



# MINICUT

PRODUKTERWEITERUNG 2026

PRODUCT EXTENSION 2026

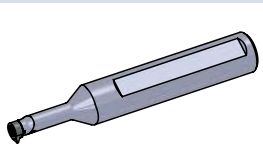
## MINICUT

Bohrungsbearbeitung

grooving, boring and profiling

## Übersicht

summary



**Klemmhalter  
Rundschaft**

**toolholder  
straight shank**

**Maße  
dimensions  
[mm]**

**Seite  
page**

**Typ 607 / 608 / 609  
611**

Klemmhalter Stahl

toolholder steel

D min. 7.0

**... 4**

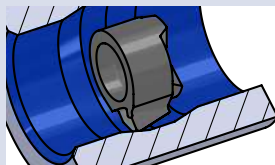
**Typ 614 / 616 / 618**

Klemmhalter Stahl

toolholder steel

D min. 14.0

**... 5**



**Schneideinsätze  
Ausdrehen und Kopieren**

**inserts  
boring and profiling**

**Maße  
dimensions  
[mm]**

**Seite  
page**

**Typ Ausdrehen und  
Kopieren**

allgemein

type boring and profiling,  
general

D min. 7 - 15.5

**... 6**

**Typ Ausdrehen und  
Kopieren**

allgemein,  
Innenfreistiche DIN 509

type boring and profiling,  
general, undercuts DIN 509

D min. 7 - 20

**... 10**

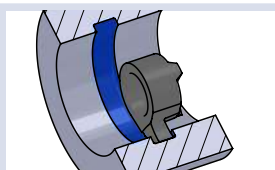
**Typ Ausdrehen und  
Kopieren**

Ausdrehen mit spezieller Spantreppe

type boring and profiling,  
boring with special chipbreaker

D min. 7.8 - 16.0

**... 13**



**Schneideinsätze  
Stechedrehen**

**inserts  
grooving**

**Maße  
dimensions  
[mm]**

**Seite  
page**

**Typ Stechedrehen**

NC-Feindrehen

type grooving,  
NC-profiling

D min. 7.8 - 20

**... 14**

**Typ Stechedrehen**

Stechedrehen und Kopieren  
Vollradius

type grooving,  
grooving and profiling,  
full radius

D min. 8 - 16  
R 0.4 - 2.0

**... 19**

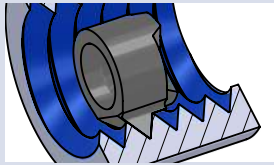
## MINICUT

Bohrungsbearbeitung

grooving, boring and profiling

## Übersicht

summary



**Schneideinsätze  
Gewindedrehen, innen**

**inserts  
threading, internal**

**Maße  
dimensions  
[mm]**

**Seite  
page**

### Typ Gewindedrehen

metrisches ISO-Gewinde,  
Vollprofil, innen

type threading, metric ISO-thread,  
full profile, internal

D min. 7 / 8  
P = 0.50 - 1.25

... 23

### Typ Gewindedrehen

metrisches ISO-Gewinde,  
Vollprofil, innen

type threading, metric ISO-thread,  
full profile, internal

D min. 9 / 11  
P = 0.5 - 3.0

... 24

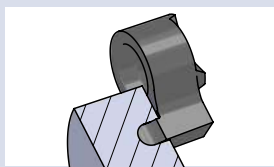
### Typ Gewindedrehen

Whitworth-Gewinde,  
Teilprofil, innen

type threading, Whitworth thread,  
partial profile, internal

D min. 7 / 9 / 11

... 25



**Schneideinsätze  
Axialstechen**

**inserts  
face grooving**

**Maße  
dimensions  
[mm]**

**Seite  
page**

### Typ Axialstechen

allgemein

type face grooving

D min. 14 / 18

... 26

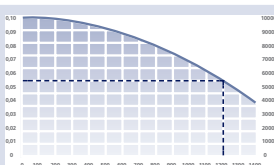
### Typ Axialstechen

am Zapfen vorbei

type face grooving,  
in pivots,

D min. 12 / 16

... 28



**Technische Hinweise**

**Technical Instructions**

**Seite  
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Schnittdatenempfehlung

speed and feed recommendation

... 30

# MINICUT

Bohrungsbearbeitung

grooving, boring and profiling

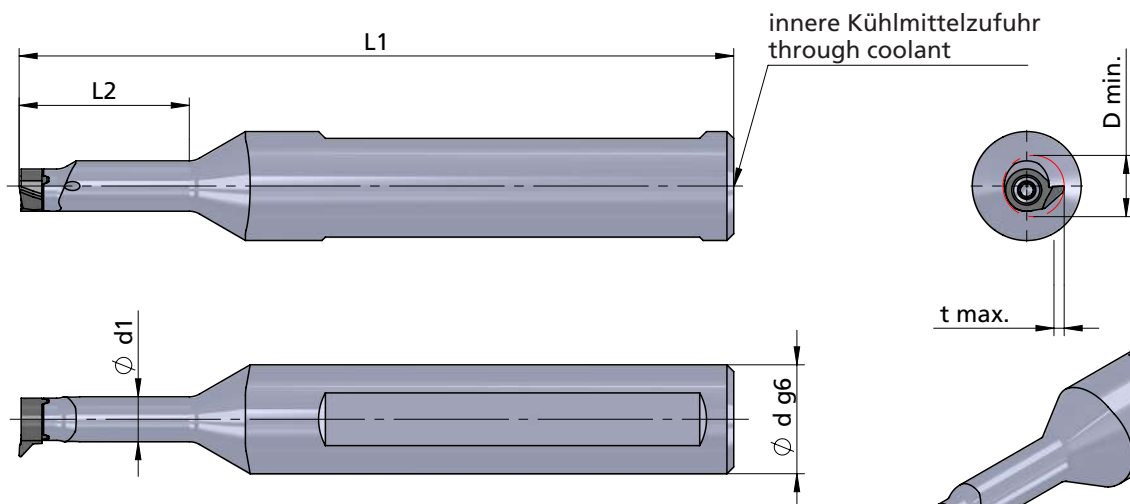
Typ 607 / 608 / 609 / 611

Klemmhalter Stahl

D min. 7.0 mm

toolholder steel

D min. 7.0 mm



Beispielzeichnung  
exemplary application

\* ... ohne IK!

Abmessungen in mm

\* ... without IK!

dimensions in mm



neu

| Bestellnummer<br>part number | Ø d g6 | Ø d (inch) | Ø d1    | L1  | L2 | Typ: t max. / D min.    | Spannschraube<br>screw | Schraubenschlüssel<br>wrench | Anzugs-<br>drehmoment<br>torque | für Schneidplatte<br>use with insert |
|------------------------------|--------|------------|---------|-----|----|-------------------------|------------------------|------------------------------|---------------------------------|--------------------------------------|
| 607.0007.1ST *               | 7.00   |            | 4.8x6   | 80  | 12 |                         |                        |                              |                                 |                                      |
| 607.0016.1ST                 | 16.00  |            | 4.8x6   | 80  | 12 | R/L S007:<br>1.0 / Ø7   | A.SPS017               | T7F-P                        | 0.8 Nm                          | R/L S07<br>R/L S007                  |
| 607.0016.1E.ST               | 16.00  |            | 4.8x6   | 85  | 21 | R/L S007:<br>2.0 / Ø7.8 |                        |                              |                                 |                                      |
| 608.0007.1ST *               | 7.00   |            | 6       | 80  | 12 |                         |                        |                              |                                 |                                      |
| 608.0158.1E.ST               | 15.87  | 5/8"       | 6x7     | 90  | 22 | R/L S008:<br>1.0 / Ø8   |                        |                              |                                 | R/L S08<br>R/L S008                  |
| 608.0016.1ST                 | 16.00  |            | 6       | 80  | 12 |                         |                        |                              |                                 |                                      |
| 608.0016.1E.ST               | 16.00  |            | 6x7     | 90  | 22 |                         | A.SPS016               | T8F-P                        | 1.2 Nm                          |                                      |
| 609.0010.1ST *               | 10.00  |            | 6.6x7.4 | 80  | 14 |                         |                        |                              |                                 |                                      |
| 609.0158.1E.ST               | 15.87  | 5/8"       | 6.6x7.4 | 105 | 25 | R/L S009:<br>1.8 / Ø9   |                        |                              |                                 | R/L S09<br>R/L S009                  |
| 609.0016.1ST                 | 16.00  |            | 6.6x7.4 | 95  | 14 |                         |                        |                              |                                 |                                      |
| 609.0016.1E.ST               | 16.00  |            | 6.6x7.4 | 105 | 25 | R/L S09: 2.8<br>/ Ø10   |                        |                              |                                 |                                      |
| 611.0010.2ST *               | 10.00  |            | 8       | 80  | 16 |                         |                        |                              |                                 |                                      |
| 611.0158.2E.ST               | 15.87  | 5/8"       | 8x9.5   | 110 | 29 | R/L S011:<br>2.3 / Ø11  |                        |                              |                                 | R/L S11<br>R/L S011                  |
| 611.0016.2ST                 | 16.00  |            | 8       | 97  | 16 |                         |                        |                              |                                 |                                      |
| 611.0016.2E.ST               | 16.00  |            | 8x9.5   | 110 | 29 |                         | A.SPS021               | T10F-P                       | 3.5 Nm                          |                                      |

# MINICUT

Bohrungsbearbeitung

grooving, boring and profiling

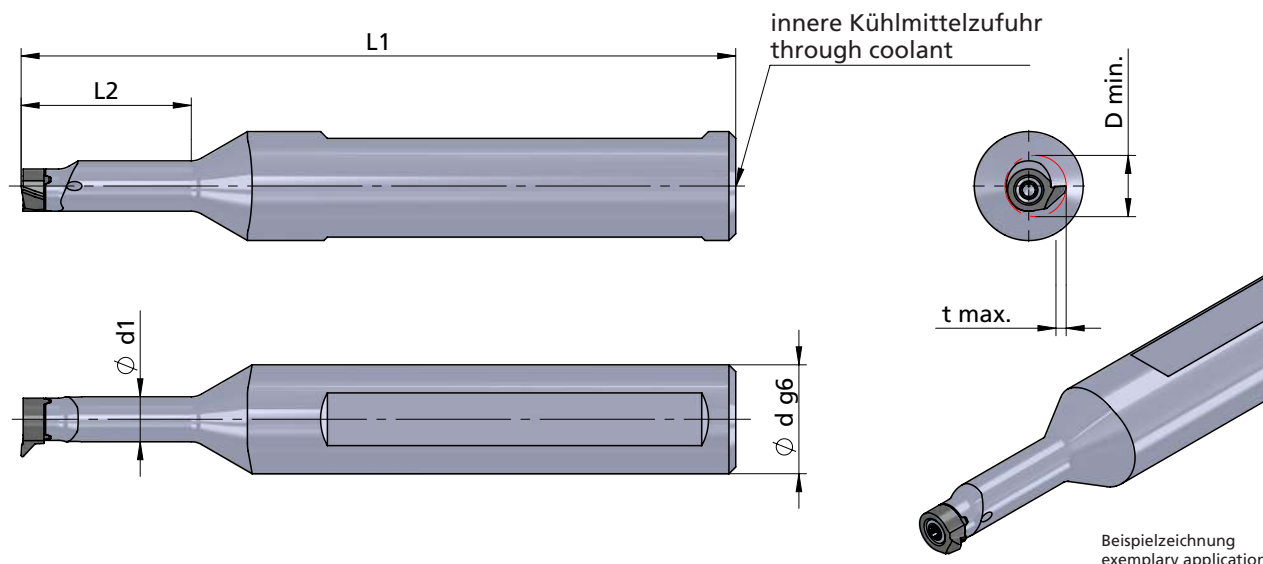
## Typ 614 / 616 / 618

Klemmhalter Stahl

toolholder steel

D min. 14 mm

D min. 14 mm



Beispielzeichnung  
exemplary application

\* ... ohne IK!

Abmessungen in mm

\* ... without IK!

dimensions in mm



neu

| Bestellnummer<br>part number | Ø d g6 | Ø d (inch) | Ø d1      | L1  | L2 | Typ: t max. / D min.   | Spannschraube<br>screw | Schraubenschlüssel<br>wrench | Anzugs-<br>drehmoment<br>torque | für Schneidplatte<br>use with insert      |
|------------------------------|--------|------------|-----------|-----|----|------------------------|------------------------|------------------------------|---------------------------------|-------------------------------------------|
| 614.0012.3ST *               | 12.00  |            | 9.5x11    | 80  | 18 |                        |                        |                              |                                 |                                           |
| 614.0127.3ST                 | 12.70  | 1/2"       | 9.5x11    | 100 | 18 | R/L S014:<br>4.0 / Ø14 |                        |                              |                                 |                                           |
| 614.0158.3E.ST               | 15.87  | 5/8"       | 9.5x11    | 120 | 38 | R/L S55:<br>5.5 / Ø16  | A.SPS026               | T15F-P                       | 4.5 Nm                          | R/L S14<br>R/L S014<br>R/L S55<br>R/L S65 |
| 614.0016.3ST                 | 16.00  |            | 9.5x11    | 100 | 18 | R/L S65:<br>6.5 / Ø17  |                        |                              |                                 |                                           |
| 614.0016.3E.ST               | 16.00  |            | 9.5x11    | 120 | 38 |                        |                        |                              |                                 |                                           |
| 616.0158.3E.ST               | 15.87  | 5/8"       | 11x13.5   | 120 | 42 | R/L S016:<br>4.3 / Ø16 |                        |                              |                                 |                                           |
| 616.0016.3ST                 | 16.00  |            | 11        | 100 | 22 |                        |                        |                              |                                 | R/L S16<br>R/L S016                       |
| 616.0016.3E.ST               | 16.00  |            | 11x13.5   | 120 | 42 |                        | A.SPS029               | T20F-P                       | 7.0 Nm                          |                                           |
| 618.0020.3ST                 | 20.00  |            | 11.5x14.2 | 95  | 25 | R/L S18:<br>6 / Ø18    |                        |                              |                                 | R/L S18<br>R/L S20                        |
| 618.0020.3E.ST               | 20.00  |            | 11.5x14.2 | 120 | 45 | R/L S20:<br>8 / Ø20    |                        |                              |                                 |                                           |

Bestellbeispiel:  
614.0012.3ST

order-example:  
614.0012.3ST

# MINICUT

Bohrungsbearbeitung

grooving, boring and profiling

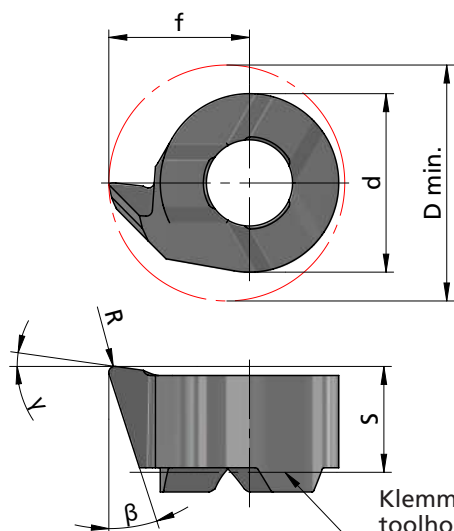
## Typ Ausdrehen und Kopieren

allgemein

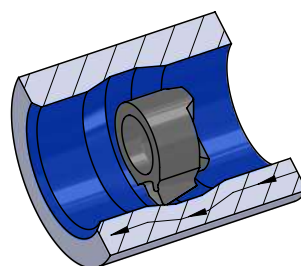
D min. 7 - 15.5 mm

type boring and profiling,  
general

D min. 7 - 15.5 mm



Klemmhalter Stirnseite  
toolholder face



Beispielzeichnung  
exemplary application

Rechts (R): wie gezeichnet  
Links (L): spiegelbildlich

righthand (R): as shown  
lefthand version (L): mirror image

Abmessungen in mm

dimensions in mm

|     | Bestellnummer<br>part number |     |     |      |      |     |     |      |        |      |       |      | Klemmhalter Typ<br>toolholder type |
|-----|------------------------------|-----|-----|------|------|-----|-----|------|--------|------|-------|------|------------------------------------|
|     |                              | β   | γ   | R    | f    | S   | d   | ap * | D min. | K10F | AL41F | P04C |                                    |
| neu | R/L S07.1841.005             | 18° | 8°  | 0.05 | 4.15 | 3.7 | 4.8 | 0.07 | 7.0    |      |       | ●    | 607...                             |
|     | R/L S07.1841.01              | 18° | 8°  | 0.10 | 4.15 | 3.7 | 4.8 | 0.13 | 7.0    | ●    |       |      |                                    |
|     | R/L S07.1841.02              | 18° | 8°  | 0.20 | 4.15 | 3.7 | 4.8 | 0.25 | 7.0    | ●    |       |      |                                    |
| neu | R/L S07.1841.04              | 18° | 8°  | 0.4  | 4.15 | 3.7 | 4.8 | 0.50 | 7.0    |      |       | ●    |                                    |
| neu | R/L S08.1846.005             | 18° | 8°  | 0.05 | 4.65 | 3.5 | 6.0 | 0.07 | 7.8    | ●    |       |      | 608...                             |
|     | R/L S08.1846.01              | 18° | 8°  | 0.10 | 4.65 | 3.5 | 6.0 | 0.13 | 7.8    |      | ●     |      |                                    |
|     | R/L S08.1846.02              | 18° | 8°  | 0.20 | 4.65 | 3.5 | 6.0 | 0.25 | 7.8    | ●    | ●     |      |                                    |
| neu | R/L S08.1846.04              | 18° | 8°  | 0.40 | 4.65 | 3.5 | 6.0 | 0.50 | 7.8    |      |       | ●    |                                    |
| neu | R/L S08.2046.005             | 20° | 20° | 0.05 | 4.65 | 3.5 | 6.0 | 0.07 | 7.8    |      |       | ●    |                                    |
| neu | R/L S08.2046.01              | 20° | 20° | 0.10 | 4.65 | 3.5 | 6.0 | 0.13 | 7.8    |      |       | ●    |                                    |
|     | R/L S08.2046.02              | 20° | 20° | 0.20 | 4.65 | 3.5 | 6.0 | 0.25 | 7.8    | ●    |       |      |                                    |
| neu | R/L S08.2046.04              | 20° | 20° | 0.40 | 4.65 | 3.5 | 6.0 | 0.50 | 7.8    |      |       | ●    |                                    |
|     | ↳ ...                        |     |     |      |      |     |     |      |        |      |       |      |                                    |

\* Schnitttiefe ap ist werkstoffabhängig.

Weitere HM Sorten können Sie in der Sorten-  
übersicht im Kapitel "Technische Hinweise" und  
der Preisliste finden.

Bestellbeispiel: für rechte Ausführung und Sorte  
RS07.1841.005/P04C

\* Depth of cut ap is depending on material.

More carbide grades you can find in the grades  
summary in the chapter "technical instructions"  
and in the price list.

order-example: righthand version and grade  
RS07.1841.005/P04C

# MINICUT

Bohrungsbearbeitung

grooving, boring and profiling

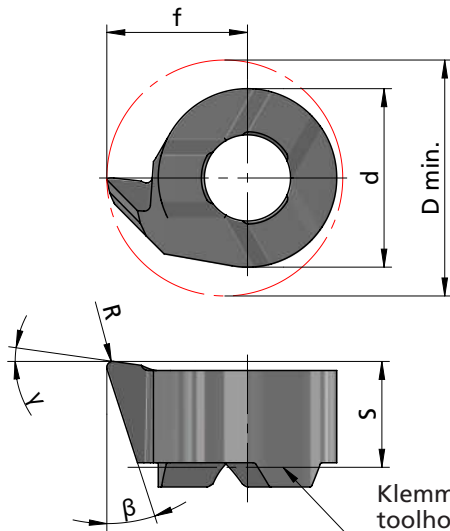
## Typ Ausdrehen und Kopieren

allgemein

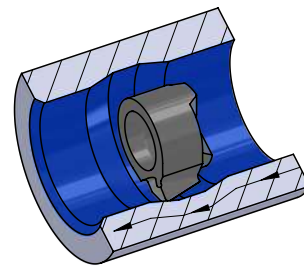
D min. 7 - 15.5 mm

type boring and profiling,  
general

D min. 7 - 15.5 mm



Klemmhalter Stirnseite  
toolholder face



Beispielzeichnung  
exemplary application

Rechts (R): wie gezeichnet  
Links (L): spiegelbildlich

righthand (R): as shown  
lefthand version (L): mirror image

Abmessungen in mm

dimensions in mm



|     | Bestellnummer<br>part number |     |     |      |      |     |     |      |        |      |       |      | Klemmhalter Typ<br>toolholder type |
|-----|------------------------------|-----|-----|------|------|-----|-----|------|--------|------|-------|------|------------------------------------|
|     |                              | β   | γ   | R    | f    | s   | d   | ap * | D min. | K10F | AL41F | P04C |                                    |
|     | ⋮ ↙                          |     |     |      |      |     |     |      |        |      |       |      |                                    |
| neu | R/L S09.1855.005             | 18° | 8°  | 0.05 | 5.50 | 3.6 | 6.2 | 0.07 | 9.0    |      |       | ●    | 609...                             |
| neu | R/L S09.1855.01              | 18° | 8°  | 0.10 | 5.50 | 3.6 | 6.2 | 0.13 | 9.0    |      |       | ●    |                                    |
|     | R/L S09.1855.02              | 18° | 8°  | 0.20 | 5.50 | 3.6 | 6.2 | 0.25 | 9.0    | ●    |       |      |                                    |
| neu | R/L S09.1855.04              | 18° | 8°  | 0.40 | 5.50 | 3.6 | 6.2 | 0.50 | 9.0    |      |       | ●    |                                    |
| neu | R/L S09.2055.005             | 20° | 20° | 0.05 | 5.50 | 3.6 | 6.2 | 0.07 | 9.0    |      |       | ●    |                                    |
| neu | R/L S09.2055.01              | 20° | 20° | 0.10 | 5.50 | 3.6 | 6.2 | 0.13 | 9.0    |      |       | ●    |                                    |
|     | R/L S09.2055.02              | 20° | 20° | 0.20 | 5.50 | 3.6 | 6.2 | 0.25 | 9.0    | ●    |       |      |                                    |
| neu | R/L S09.2055.04              | 20° | 20° | 0.40 | 5.50 | 3.6 | 6.2 | 0.50 | 9.0    |      |       | ●    |                                    |
|     | ↘ ...                        |     |     |      |      |     |     |      |        |      |       |      |                                    |

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Bestellbeispiel: für rechte Ausführung und Sorte  
RS09.1855.005/P04C

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order-example: righthand version and grade  
RS09.1855.005/P04C

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grooving, boring and profiling

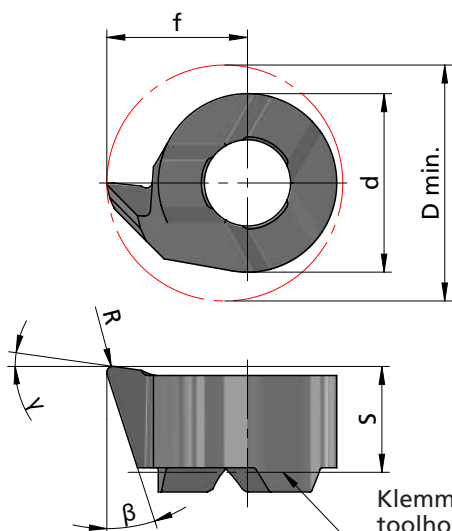
## Typ Ausdrehen und Kopieren

allgemein

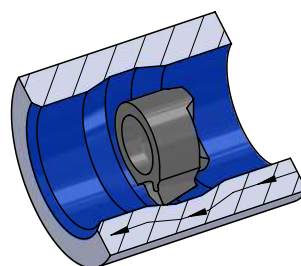
D min. 7 - 15.5 mm

type boring and profiling,  
general

D min. 7 - 15.5 mm



Klemmhalter Stirnseite  
toolholder face



Beispielzeichnung  
exemplary application

Rechts (R): wie gezeichnet  
Links (L): spiegelbildlich

righthand (R): as shown  
lefthand version (L): mirror image

Abmessungen in mm

dimensions in mm

Bestellnummer  
part number

β

γ

R

f

S

d

ap \*

D min.

K10F

AL41F

P04C

Klemmhalter Typ  
toolholder type



neu

R/L S11.1855.005

18°

8°

0.05

5.50

4.2

8.0

0.07

9.8

neu

R/L S11.1855.01

18°

8°

0.10

5.50

4.2

8.0

0.13

9.8

R/L S11.1855.02

18°

8°

0.20

5.50

4.2

8.0

0.25

9.8

neu

R/L S11.1855.04

18°

8°

0.40

5.50

4.2

8.0

0.50

9.8

neu

R/L S11.1867.005

18°

8°

0.05

6.70

4.2

8.0

0.07

11.0

neu

R/L S11.1867.01

18°

8°

0.10

6.70

4.2

8.0

0.13

11.0

R/L S11.1867.02

18°

8°

0.20

6.70

4.2

8.0

0.25

11.0

neu

R/L S11.1867.04

18°

8°

0.40

6.70

4.2

8.0

0.50

11.0

neu

R/L S11.2067.005

20°

20°

0.05

6.70

4.2

8.0

0.07

11.0

neu

R/L S11.2067.01

20°

20°

0.10

6.70

4.2

8.0

0.13

11.0

R/L S11.2067.02

20°

20°

0.20

6.70

4.2

8.0

0.25

11.0

neu

R/L S11.2067.04

20°

20°

0.40

6.70

4.2

8.0

0.50

11.0



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übersicht im Kapitel "Technische Hinweise" und  
der Preisliste finden.

Bestellbeispiel: für rechte Ausführung und Sorte  
RS11.1855.005/P04C

\* Depth of cut ap is depending on material.

More carbide grades you can find in the grades  
summary in the chapter "technical instructions"  
and in the price list.

order-example: righthand version and grade  
RS11.1855.005/P04C

# MINICUT

Bohrungsbearbeitung

grooving, boring and profiling

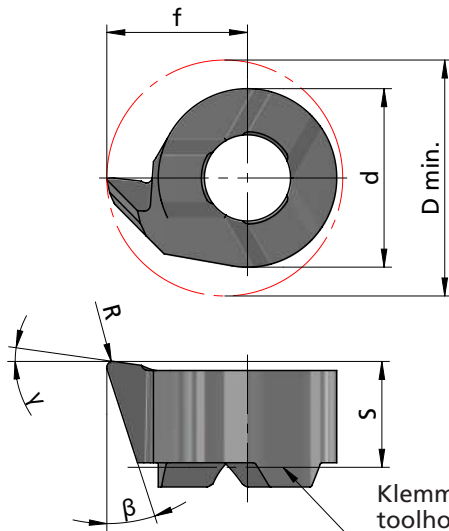
## Typ Ausdrehen und Kopieren

allgemein

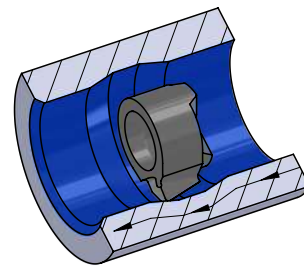
D min. 7 - 15.5 mm

type boring and profiling,  
general

D min. 7 - 15.5 mm



Klemmhalter Stirnseite  
toolholder face



Beispielzeichnung  
exemplary application

Rechts (R): wie gezeichnet  
Links (L): spiegelbildlich

righthand (R): as shown  
lefthand version (L): mirror image

Abmessungen in mm

dimensions in mm



| Bestellnummer<br>part number |     |     |      |      |     |      |      |        |  |      |       |      | Klemmhalter Typ<br>toolholder type |
|------------------------------|-----|-----|------|------|-----|------|------|--------|--|------|-------|------|------------------------------------|
|                              | β   | γ   | R    | f    | s   | d    | ap * | D min. |  | K10F | AL41F | P04C |                                    |
| ...                          |     |     |      |      |     |      |      |        |  |      |       |      |                                    |
| <b>neu</b> R/L S14.1867.005  | 18° | 8°  | 0.05 | 8.70 | 5.3 | 9.0  | 0.07 | 13.8   |  |      |       |      | 614...                             |
| <b>neu</b> R/L S14.1867.01   | 18° | 8°  | 0.10 | 8.70 | 5.3 | 9.0  | 0.13 | 13.8   |  |      |       |      |                                    |
| R/L S14.1867.02              | 18° | 8°  | 0.20 | 8.70 | 5.3 | 9.0  | 0.25 | 13.8   |  |      |       |      |                                    |
| <b>neu</b> R/L S14.1867.04   | 18° | 8°  | 0.40 | 8.70 | 5.3 | 9.0  | 0.50 | 13.8   |  |      |       |      |                                    |
| <b>neu</b> R/L S14.2087.005  | 20° | 20° | 0.05 | 8.70 | 5.3 | 9.0  | 0.07 | 13.8   |  |      |       |      |                                    |
| <b>neu</b> R/L S14.2087.01   | 20° | 20° | 0.10 | 8.70 | 5.3 | 9.0  | 0.13 | 13.8   |  |      |       |      |                                    |
| R/L S14.2087.02              | 20° | 20° | 0.20 | 8.70 | 5.3 | 9.0  | 0.25 | 13.8   |  |      |       |      |                                    |
| <b>neu</b> R/L S14.2087.04   | 20° | 20° | 0.40 | 8.70 | 5.3 | 9.0  | 0.50 | 13.8   |  |      |       |      |                                    |
| <b>neu</b> R/L S16.1897.005  | 18° | 8°  | 0.05 | 9.70 | 5.4 | 11.0 | 0.07 | 15.5   |  |      |       |      | 616...                             |
| <b>neu</b> R/L S16.1897.01   | 18° | 8°  | 0.10 | 9.70 | 5.4 | 11.0 | 0.13 | 15.5   |  |      |       |      |                                    |
| R/L S16.1897.02              | 18° | 8°  | 0.20 | 9.70 | 5.4 | 11.0 | 0.25 | 15.5   |  |      |       |      |                                    |
| <b>neu</b> R/L S16.1897.04   | 18° | 8°  | 0.40 | 9.70 | 5.4 | 11.0 | 0.50 | 15.5   |  |      |       |      |                                    |

\* Schnitttiefe ap ist werkstoffabhängig.

Weitere HM Sorten können Sie in der Sorten-  
übersicht im Kapitel "Technische Hinweise" und  
der Preisliste finden.

Bestellbeispiel: für rechte Ausführung und Sorte  
RS14.1867.005/P04C

\* Depth of cut ap is depending on material.

More carbide grades you can find in the grades  
summary in the chapter "technical instructions"  
and in the price list.

order-example: righthand version and grade  
RS14.1867.005/P04C

# MINICUT

Bohrungsbearbeitung

grooving, boring and profiling

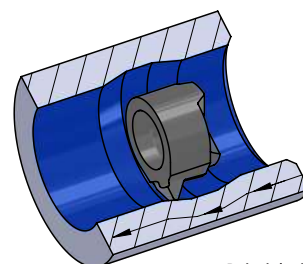
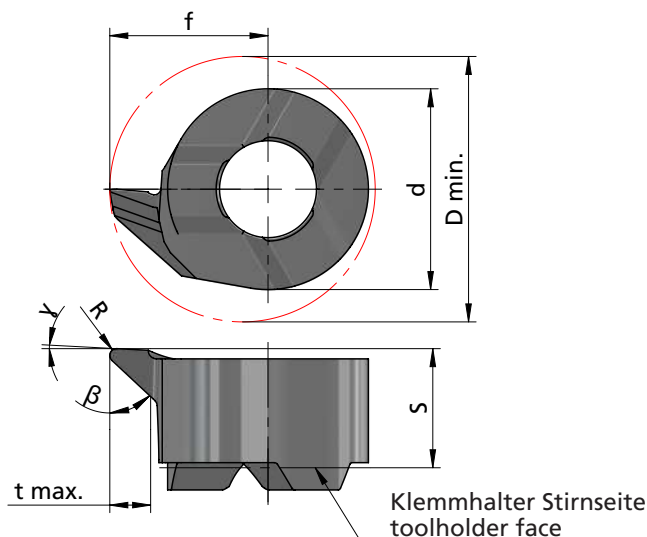
## Typ Ausdrehen und Kopieren

allgemein,  
Innenfreistriche DIN 509

D min. 7 - 20 mm

type boring and profiling,  
general, undercuts DIN 509

D min. 7 - 20 mm



Beispielzeichnung  
exemplary application

Rechts (R): wie gezeichnet  
Links (L): spiegelbildlich

righthand (R): as shown  
lefthand version (L): mirror image

Abmessungen in mm

dimensions in mm

|     | Bestellnummer<br>part number |         |          |      |      |     |     |        |        |      |       |      | Klemmhalter Typ<br>toolholder type |
|-----|------------------------------|---------|----------|------|------|-----|-----|--------|--------|------|-------|------|------------------------------------|
|     |                              | $\beta$ | $\gamma$ | R    | f    | s   | d   | t max. | D min. | K10F | AL41F | P04C |                                    |
| neu | R/L S07.4746.005             | 47°     | 3°       | 0.05 | 4.15 | 3.7 | 4.8 | 1.2    | 7.0    |      |       | ●    | 607...                             |
| neu | R/L S07.4746.01              | 47°     | 3°       | 0.10 | 4.15 | 3.7 | 4.8 | 1.2    | 7.0    |      |       | ●    |                                    |
|     | R/L S07.4746.02              | 47°     | 3°       | 0.20 | 4.15 | 3.7 | 4.8 | 1.2    | 7.0    | ●    |       |      |                                    |
| neu | R/L S07.4746.04              | 47°     | 3°       | 0.40 | 4.15 | 3.7 | 4.8 | 1.2    | 7.0    |      |       | ●    | 608...                             |
| neu | R/L S08.4746.005             | 47°     | 3°       | 0.05 | 4.65 | 3.5 | 6.0 | 1.2    | 7.8    |      |       | ●    |                                    |
|     | R/L S08.4746.01              | 47°     | 3°       | 0.10 | 4.65 | 3.5 | 6.0 | 1.2    | 7.8    | ●    |       |      |                                    |
|     | R/L S08.4746.02              | 47°     | 3°       | 0.20 | 4.65 | 3.5 | 6.0 | 1.2    | 7.8    | ●    |       |      | 609...                             |
| neu | R/L S08.4746.04              | 47°     | 3°       | 0.40 | 4.65 | 3.5 | 6.0 | 1.2    | 7.8    |      |       | ●    |                                    |
| neu | R/L S09.4755.005             | 47°     | 3°       | 0.05 | 5.50 | 3.5 | 6.2 | 1.5    | 9.0    |      |       | ●    |                                    |
| neu | R/L S09.4755.01              | 47°     | 3°       | 0.10 | 5.50 | 3.5 | 6.2 | 1.5    | 9.0    |      |       | ●    | 609...                             |
|     | R/L S09.4755.02              | 47°     | 3°       | 0.20 | 5.50 | 3.5 | 6.2 | 1.5    | 9.0    | ●    |       |      |                                    |
| neu | R/L S09.4755.04              | 47°     | 3°       | 0.40 | 5.50 | 3.5 | 6.2 | 1.5    | 9.0    |      |       | ●    |                                    |
|     | ↳ ...                        |         |          |      |      |     |     |        |        |      |       |      |                                    |

Weitere HM Sorten können Sie in der Sorten-  
übersicht im Kapitel "Technische Hinweise" und  
der Preisliste finden.

Bestellbeispiel:  
für rechte Ausführung und Sorte  
RS07.4746.005/P04C

More carbide grades you can find in the grades  
summary in the chapter "technical instructions"  
and in the price list.

order-example:  
righthand version and grade  
RS07.4746.005/P04C

## MINICUT

Bohrungsbearbeitung

grooving, boring and profiling

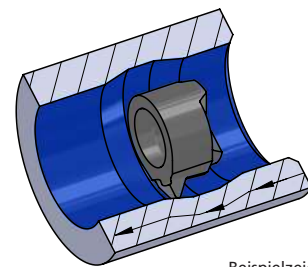
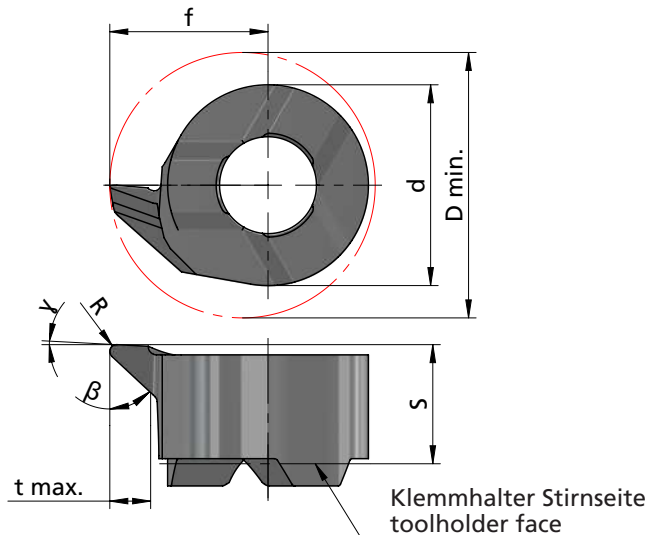
## Typ Ausdrehen und Kopieren

allgemein,  
Innenfreistriche DIN 509

D min. 7 - 20 mm

type boring and profiling,  
general, undercuts DIN 509

D min. 7 - 20 mm



Beispielzeichnung  
exemplary application

Rechts (R): wie gezeichnet  
Links (L): spiegelbildlich

righthand (R): as shown  
lefthand version (L): mirror image

Abmessungen in mm

dimensions in mm



|     | Bestellnummer<br>part number | $\beta$ | $\gamma$ | R    | f     | s   | d    | t max. | D min. |      |       |      | Klemmhalter Typ<br>toolholder type |
|-----|------------------------------|---------|----------|------|-------|-----|------|--------|--------|------|-------|------|------------------------------------|
|     |                              |         |          |      |       |     |      |        |        | K10F | AL41F | P04C |                                    |
|     | ...                          |         |          |      |       |     |      |        |        |      |       |      |                                    |
| neu | R/L S11.4767.005             | 47°     | 3°       | 0.05 | 6.70  | 4.2 | 8.0  | 2.3    | 11.0   |      |       | ●    | 611...                             |
| neu | R/L S11.4767.01              | 47°     | 3°       | 0.10 | 6.70  | 4.2 | 8.0  | 2.3    | 11.0   |      |       | ●    |                                    |
|     | R/L S11.4767.02              | 47°     | 3°       | 0.20 | 6.70  | 4.2 | 8.0  | 2.3    | 11.0   | ●    |       |      |                                    |
| neu | R/L S11.4767.04              | 47°     | 3°       | 0.40 | 6.70  | 4.2 | 8.0  | 2.3    | 11.0   |      |       | ●    | 614...                             |
| neu | R/L S14.4787.005             | 47°     | 3°       | 0.05 | 8.70  | 5.3 | 9.0  | 4.0    | 13.7   |      |       | ●    |                                    |
| neu | R/L S14.4787.01              | 47°     | 3°       | 0.10 | 8.70  | 5.3 | 9.0  | 4.0    | 13.7   |      |       | ●    |                                    |
|     | R/L S14.4787.02              | 47°     | 3°       | 0.20 | 8.70  | 5.3 | 9.0  | 4.0    | 13.7   | ●    |       |      |                                    |
|     | R/L S14.4787.04              | 47°     | 3°       | 0.40 | 8.70  | 5.3 | 9.0  | 4.0    | 13.7   | ●    |       |      | 616...                             |
| neu | R/L S16.4710.005             | 47°     | 3°       | 0.05 | 10.20 | 5.4 | 11.0 | 4.3    | 15.8   |      |       | ●    |                                    |
| neu | R/L S16.4710.01              | 47°     | 3°       | 0.10 | 10.20 | 5.4 | 11.0 | 4.3    | 15.8   |      |       | ●    |                                    |
|     | R/L S16.4710.02              | 47°     | 3°       | 0.20 | 10.20 | 5.4 | 11.0 | 4.3    | 15.8   | ●    |       |      |                                    |
| neu | R/L S16.4710.04              | 47°     | 3°       | 0.40 | 10.20 | 5.4 | 11.0 | 4.3    | 15.8   |      |       | ●    |                                    |
|     | ...                          |         |          |      |       |     |      |        |        |      |       |      |                                    |

Weitere HM Sorten können Sie in der Sorten-  
übersicht im Kapitel "Technische Hinweise" und  
der Preisliste finden.

Bestellbeispiel:  
für rechte Ausführung und Sorte  
RS11.4767.005/P04C

More carbide grades you can find in the grades  
summary in the chapter "technical instructions"  
and in the price list.

order-example:  
righthand version and grade  
RS11.4767.005/P04C

# MINICUT

Bohrungsbearbeitung

grooving, boring and profiling

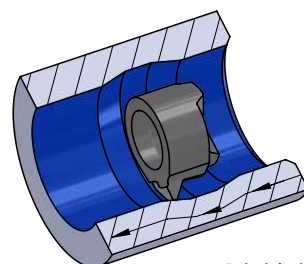
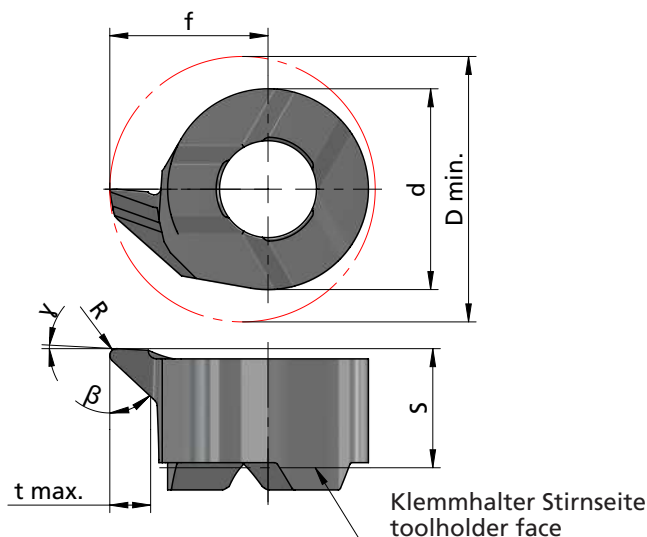
## Typ Ausdrehen und Kopieren

allgemein,  
Innenfreistriche DIN 509

D min. 7 - 20 mm

type boring and profiling,  
general, undercuts DIN 509

D min. 7 - 20 mm



Beispielzeichnung  
exemplary application

Rechts (R): wie gezeichnet  
Links (L): spiegelbildlich

righthand (R): as shown  
lefthand version (L): mirror image

Abmessungen in mm

dimensions in mm

|     | Bestellnummer<br>part number | $\beta$ | $\gamma$ | R    | f     | s   | d    | t max. | D min. |      |       |      | Klemmhalter Typ<br>toolholder type |
|-----|------------------------------|---------|----------|------|-------|-----|------|--------|--------|------|-------|------|------------------------------------|
|     |                              |         |          |      |       |     |      |        |        | K10F | AL41F | P04C |                                    |
|     | ...                          |         |          |      |       |     |      |        |        |      |       |      |                                    |
| neu | R/L S18.4712.005             | 47°     | 3°       | 0.05 | 12.00 | 5.6 | 11.0 | 6.0    | 18.0   |      |       | ●    | 618...                             |
| neu | R/L S18.4712.01              | 47°     | 3°       | 0.10 | 12.00 | 5.6 | 11.0 | 6.0    | 18.0   |      |       | ●    |                                    |
|     | R/L S18.4712.02              | 47°     | 3°       | 0.20 | 12.00 | 5.6 | 11.0 | 6.0    | 18.0   |      | ●     |      |                                    |
| neu | R/L S18.4712.04              | 47°     | 3°       | 0.40 | 12.00 | 5.6 | 11.0 | 6.0    | 18.0   |      |       | ●    |                                    |
| neu | R/L S20.4714.005             | 47°     | 3°       | 0.05 | 14.00 | 5.6 | 11.0 | 8.0    | 20.0   |      |       | ●    |                                    |
| neu | R/L S20.4714.01              | 47°     | 3°       | 0.10 | 14.00 | 5.6 | 11.0 | 8.0    | 20.0   |      |       | ●    |                                    |
|     | R/L S20.4714.02              | 47°     | 3°       | 0.20 | 14.00 | 5.6 | 11.0 | 8.0    | 20.0   |      | ●     |      |                                    |
| neu | R/L S20.4714.04              | 47°     | 3°       | 0.40 | 14.00 | 5.6 | 11.0 | 8.0    | 20.0   |      |       | ●    |                                    |
|     | R/L S08.2555.02              | 30°     | 5°       | 0.20 | 4.65  | 3.5 | 6.0  | 1.0    | 7.8    | ●    | ●     |      | 608...                             |
|     | R/L S11.2755.02              | 30°     | 5°       | 0.20 | 6.70  | 4.2 | 8.0  | 2.3    | 11.0   | ●    | ●     |      | 611...                             |
|     | R/L S14.3555.02              | 30°     | 5°       | 0.20 | 8.70  | 5.3 | 9.0  | 4.0    | 13.7   |      | ●     |      | 614...                             |
|     | R/L S16.4055.02              | 30°     | 5°       | 0.20 | 10.20 | 5.4 | 11.0 | 4.3    | 15.8   |      | ●     |      | 616...                             |

Weitere HM Sorten können Sie in der Sorten-  
übersicht im Kapitel "Technische Hinweise" und  
der Preisliste finden.

Bestellbeispiel:  
für rechte Ausführung und Sorte  
RS18.4712.005/P04C

More carbide grades you can find in the grades  
summary in the chapter "technical instructions"  
and in the price list.

order-example:  
righthand version and grade  
RS18.4712.005/P04C

## MINICUT

Bohrungsbearbeitung

grooving, boring and profiling

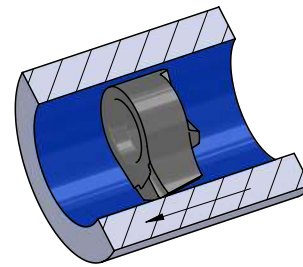
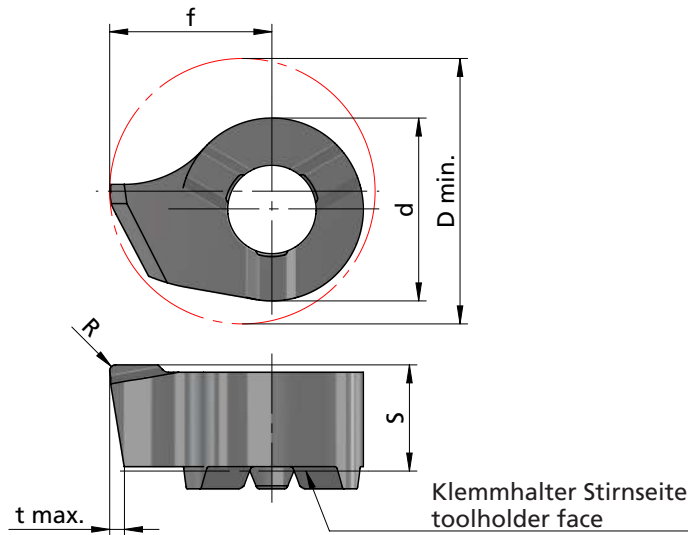
## Typ Ausdrehen und Kopieren

Ausdrehen mit spezieller  
Spantreppe

D min. 7.8 - 16.0 mm

type boring and profiling,  
boring with special chipbreaker

D min. 7.8 - 16.0 mm



Beispielzeichnung  
exemplary application

Rechts (R): wie gezeichnet  
Links (L): spiegelbildlich

righthand (R): as shown  
lefthand version (L): mirror image

Abmessungen in mm

dimensions in mm

neu  
neu

| Bestellnummer<br>part number | R   | f     | S   | d    | t max. | D min. | K10F | AL41F | P04C | Klemmhalter Typ<br>toolholder type |
|------------------------------|-----|-------|-----|------|--------|--------|------|-------|------|------------------------------------|
| R/L S08.046C.02              | 0.2 | 4.65  | 3.5 | 6.0  | 0.5    | 7.8    | ●    |       |      | 608...                             |
| R/L S09.055C.02              | 0.2 | 5.50  | 3.6 | 6.2  | 0.5    | 9.0    | ●    |       |      | 609...                             |
| R/L S11.067C.02              | 0.2 | 6.70  | 4.2 | 8.0  | 0.5    | 11.0   | ●    |       |      | 611...                             |
| R/L S14.087C.02              | 0.2 | 8.70  | 5.3 | 9.0  | 0.5    | 14.0   |      | ●     |      | 614...                             |
| R/L S16.102C.02              | 0.2 | 10.20 | 5.4 | 11.0 | 0.5    | 16.0   |      | ●     |      | 616...                             |

Weitere HM Sorten können Sie in der Sorten-  
übersicht im Kapitel "Technische Hinweise" und  
der Preisliste finden.

Bestellbeispiel:  
für rechte Ausführung und Sorte  
RS08.046C.02/AL41F

More carbide grades you can find in the grades  
summary in the chapter "technical instructions"  
and in the price list.

order-example:  
righthand version and grade  
RS08.046C.02/AL41F

# MINICUT

Bohrungsbearbeitung

grooving, boring and profiling

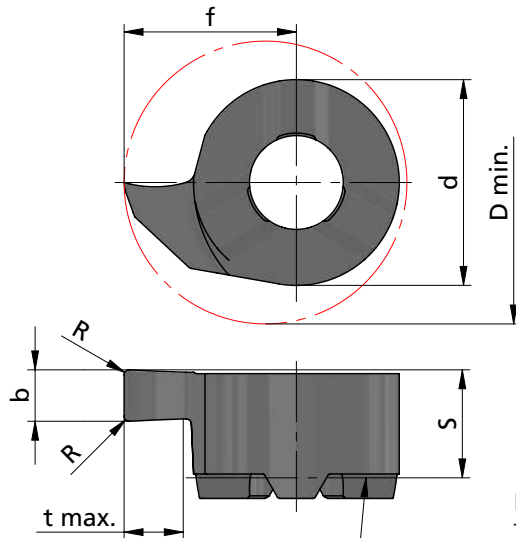
## Typ Stechdrehen

NC-Feindrehen

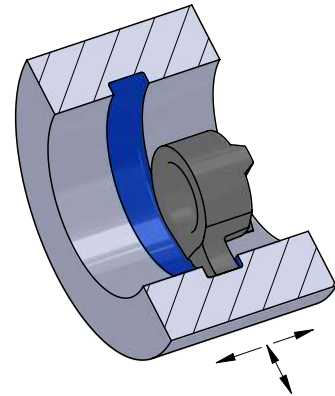
D min. 7.8 - 20 mm

type grooving,  
NC-profiling

D min. 7.8 - 20 mm



Klemmhalter Stirnseite  
toolholder face



Beispielzeichnung  
exemplary application

Rechts (R): wie gezeichnet  
Links (L): spiegelbildlich

righthand (R): as shown  
lefthand version (L): mirror image

Abmessungen in mm

dimensions in mm

|     | Bestellnummer<br>part number | b +0.03 | b (inch) | R    | f   | s   | d   | ap * | t max. | D min. | K10F | AL41F | P04C | Klemmhalter Typ<br>toolholder type |
|-----|------------------------------|---------|----------|------|-----|-----|-----|------|--------|--------|------|-------|------|------------------------------------|
|     |                              |         |          |      |     |     |     |      |        |        |      |       |      |                                    |
| neu | R/L S07.100.005.8            | 1.00    |          | 0.05 | 5.2 | 3.7 | 4.8 | 0.05 | 2.0    | 7.8    |      |       | ●    | 607...                             |
| neu | R/L S07.125.005.8            | 1.25    |          | 0.05 | 5.2 | 3.7 | 4.8 | 0.05 | 2.0    | 7.8    |      |       | ●    |                                    |
| neu | R/L S07.150.005.8            | 1.50    |          | 0.05 | 5.2 | 3.7 | 4.8 | 0.05 | 2.0    | 7.8    |      |       | ●    |                                    |
|     | R/L S07.150.02.8             | 1.50    |          | 0.20 | 5.2 | 3.7 | 4.8 | 0.20 | 2.0    | 7.8    | ●    | ●     | ●    |                                    |
| neu | R/L S07.200.005.8            | 2.00    |          | 0.05 | 5.2 | 3.7 | 4.8 | 0.05 | 2.0    | 7.8    |      |       | ●    | 608...                             |
|     | R/L S08.079.02               | 0.79    | 0.031"   | 0.20 | 4.8 | 3.3 | 6.0 | 0.20 | 1.0    | 8.0    | ●    |       | ●    |                                    |
| neu | R/L S08.100.005              | 1.00    |          | 0.05 | 4.8 | 3.3 | 6.0 | 0.05 | 1.0    | 8.0    |      |       | ●    |                                    |
|     | R/L S08.117.02               | 1.17    | 0.046"   | 0.20 | 4.8 | 3.3 | 6.0 | 0.20 | 1.0    | 8.0    | ●    |       | ●    |                                    |
| neu | R/L S08.125.005              | 1.25    |          | 0.05 | 4.8 | 3.3 | 6.0 | 0.05 | 1.0    | 8.0    |      |       | ●    |                                    |
| neu | R/L S08.150.005              | 1.50    |          | 0.05 | 4.8 | 3.3 | 6.0 | 0.05 | 1.0    | 8.0    |      |       | ●    |                                    |
|     | R/L S08.150.02               | 1.50    |          | 0.20 | 4.8 | 3.3 | 6.0 | 0.20 | 1.0    | 8.0    | ●    | ●     | ●    |                                    |
|     | R/L S08.157.02               | 1.57    | 0.062"   | 0.20 | 4.8 | 3.3 | 6.0 | 0.20 | 1.0    | 8.0    |      | ●     | ●    |                                    |
|     | R/L S08.198.02               | 1.98    | 0.078"   | 0.20 | 4.8 | 3.3 | 6.0 | 0.20 | 1.0    | 8.0    |      | ●     | ●    |                                    |
| neu | R/L S08.200.005              | 2.00    |          | 0.05 | 4.8 | 3.3 | 6.0 | 0.05 | 1.0    | 8.0    |      |       | ●    |                                    |
|     | R/L S08.200.02               | 2.00    |          | 0.20 | 4.8 | 3.3 | 6.0 | 0.20 | 1.0    | 8.0    | ●    | ●     | ●    |                                    |
|     | ↳ ...                        |         |          |      |     |     |     |      |        |        |      |       |      |                                    |

Weitere HM Sorten können Sie in der Sorten-  
übersicht im Kapitel "Technische Hinweise" und  
der Preisliste finden.

\* Schnitttiefe **ap** für das Längsdrehen ist  
werkstoffabhängig.

More carbide grades you can find in the grades  
summary in the chapter "technical instructions"  
and in the price list.

Bestellbeispiel:  
für rechte Ausführung und Sorte  
RS07.100.005.8/P04C

\* The cutting depth **ap** for turning depends on  
the material.

order-example:  
righthand version and grade  
RS07.100.005.8/P04C

## MINICUT

Bohrungsbearbeitung

grooving, boring and profiling

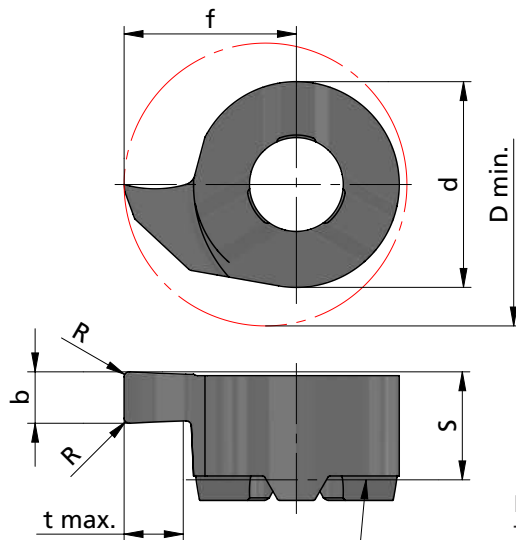
## Typ Stechdrehen

NC-Feindrehen

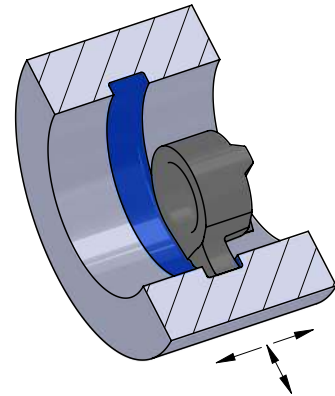
D min. 7.8 - 20 mm

type grooving,  
NC-profiling

D min. 7.8 - 20 mm



Klemhalter Stirnseite  
toolholder face



Beispielzeichnung  
exemplary application

Rechts (R): wie gezeichnet  
Links (L): spiegelbildlich

righthand (R): as shown  
lefthand version (L): mirror image

Abmessungen in mm

dimensions in mm

|     | Bestellnummer<br>part number | b +0.03 | b (inch) | R    | f   | s    | d   | ap * | t max. | D min. | K10F | AL41F | P04C | Klemhalter Typ<br>toolholder type |
|-----|------------------------------|---------|----------|------|-----|------|-----|------|--------|--------|------|-------|------|-----------------------------------|
|     | ⋮ ⌵                          |         |          |      |     |      |     |      |        |        |      |       |      |                                   |
| neu | R/L S09.100.005              | 1.00    |          | 0.05 | 5.5 | 3.6  | 6.2 | 0.05 | 1.8    | 9.0    |      |       | ●    | 609...                            |
| neu | R/L S09.125.005              | 1.25    |          | 0.05 | 5.5 | 3.6  | 6.2 | 0.05 | 1.8    | 9.0    |      |       | ●    |                                   |
| neu | R/L S09.150.005              | 1.50    |          | 0.05 | 5.5 | 3.6  | 6.2 | 0.05 | 1.8    | 9.0    |      |       | ●    |                                   |
|     | R/L S09.150.02               | 1.50    |          | 0.20 | 5.5 | 3.6  | 6.2 | 0.20 | 1.8    | 9.0    |      | ●     |      |                                   |
| neu | R/L S09.200.005              | 2.00    |          | 0.05 | 5.5 | 3.6  | 6.2 | 0.05 | 1.8    | 9.0    |      |       | ●    |                                   |
|     | R/L S09.200.02               | 2.00    |          | 0.20 | 5.5 | 3.6  | 6.2 | 0.20 | 1.8    | 9.0    |      | ●     | ●    |                                   |
| neu | R/L S09.100.005.10           | 1.00    |          | 0.05 | 6.5 | 3.55 | 6.2 | 0.05 | 2.8    | 10.0   |      |       | ●    |                                   |
| neu | R/L S09.125.005.10           | 1.25    |          | 0.05 | 6.5 | 3.55 | 6.2 | 0.05 | 2.8    | 10.0   |      |       | ●    |                                   |
| neu | R/L S09.150.005.10           | 1.50    |          | 0.05 | 6.5 | 3.6  | 6.2 | 0.05 | 2.8    | 10.0   |      |       | ●    |                                   |
| neu | R/L S09.200.005.10           | 2.00    |          | 0.05 | 6.5 | 3.6  | 6.2 | 0.05 | 2.8    | 10.0   |      |       | ●    |                                   |
|     | R/L S09.150.02.10            | 1.50    |          | 0.20 | 6.5 | 3.6  | 6.2 | 0.20 | 2.8    | 10.0   |      | ●     |      |                                   |
|     | R/L S09.200.02.10            | 2.00    |          | 0.20 | 6.5 | 3.6  | 6.2 | 0.20 | 2.8    | 10.0   |      | ●     |      |                                   |
| neu | R/L S09.250.01.10            | 2.50    |          | 0.10 | 6.5 | 3.6  | 6.2 | 0.10 | 2.8    | 10.0   |      |       | ●    |                                   |
| neu | R/L S09.300.01.10            | 3.00    |          | 0.10 | 6.5 | 3.6  | 6.2 | 0.10 | 2.8    | 10.0   |      |       | ●    |                                   |
|     | ⌵ ...                        |         |          |      |     |      |     |      |        |        |      |       |      |                                   |

Weitere HM Sorten können Sie in der Sorten-  
übersicht im Kapitel "Technische Hinweise" und  
der Preisliste finden.

Bestellbeispiel:  
für rechte Ausführung und Sorte  
RS09.100.005/P04C

\* Schnitttiefe **ap** für das Längsdrehen ist  
werkstoffabhängig.

\* The cutting depth **ap** for turning depends on  
the material.

More carbide grades you can find in the grades  
summary in the chapter "technical instructions"  
and in the price list.

order-example:  
righthand version and grade  
RS09.100.005/P04C

# MINICUT

Bohrungsbearbeitung

grooving, boring and profiling

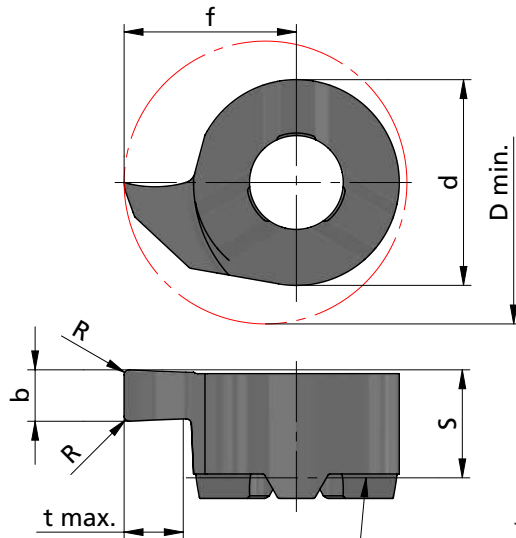
## Typ Stechdrehen

NC-Feindrehen

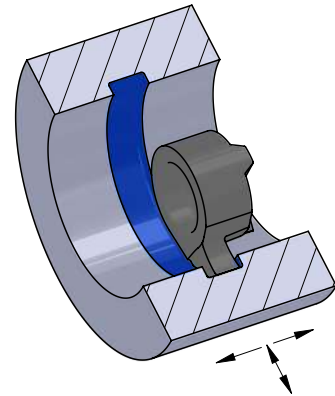
D min. 7.8 - 20 mm

type grooving,  
NC-profiling

D min. 7.8 - 20 mm



Klemhalter Stirnseite  
toolholder face



Beispielzeichnung  
exemplary application

Rechts (R): wie gezeichnet  
Links (L): spiegelbildlich

righthand (R): as shown  
lefthand version (L): mirror image

Abmessungen in mm

dimensions in mm

...

| Bestellnummer<br>part number |         |          |      |     |     |   |      |        |        |      |       |      | Klemhalter Typ<br>toolholder type |
|------------------------------|---------|----------|------|-----|-----|---|------|--------|--------|------|-------|------|-----------------------------------|
|                              | b +0.03 | b (inch) | R    | f   | s   | d | ap * | t max. | D min. | K10F | AL41F | P04C |                                   |
| R/L S11.079.02               | 0.79    | 0.031"   | 0.20 | 6.7 | 4.2 | 8 | 0.20 | 2.3    | 11     |      | ●     |      | 611...                            |
| R/L S11.100.005              | 1.00    |          | 0.05 | 6.7 | 4.2 | 8 | 0.05 | 2.3    | 11     |      |       | ●    |                                   |
| R/L S11.100.02               | 1.00    |          | 0.20 | 6.7 | 4.2 | 8 | 0.20 | 2.3    | 11     |      | ●     |      |                                   |
| R/L S11.117.02               | 1.17    | 0.046"   | 0.20 | 6.7 | 4.2 | 8 | 0.20 | 2.3    | 11     |      | ●     |      |                                   |
| R/L S11.125.005              | 1.25    |          | 0.05 | 6.7 | 4.2 | 8 | 0.05 | 2.3    | 11     |      |       | ●    |                                   |
| R/L S11.150.01               | 1.50    |          | 0.10 | 6.7 | 4.2 | 8 | 0.10 | 2.3    | 11     |      |       | ●    |                                   |
| R/L S11.150.02               | 1.50    |          | 0.20 | 6.7 | 4.2 | 8 | 0.20 | 2.3    | 11     | ●    | ●     |      |                                   |
| R/L S11.157.02               | 1.57    | 0.062"   | 0.20 | 6.7 | 4.2 | 8 | 0.20 | 2.3    | 11     |      | ●     |      |                                   |
| R/L S11.198.02               | 1.98    | 0.078"   | 0.20 | 6.7 | 4.2 | 8 | 0.20 | 2.3    | 11     |      | ●     |      |                                   |
| R/L S11.200.01               | 2.00    |          | 0.10 | 6.7 | 4.2 | 8 | 0.10 | 2.3    | 11     |      |       | ●    |                                   |
| R/L S11.200.02               | 2.00    |          | 0.20 | 6.7 | 4.2 | 8 | 0.20 | 2.3    | 11     | ●    | ●     | ●    |                                   |
| R/L S11.238.02               | 2.38    | 0.094"   | 0.20 | 6.7 | 4.2 | 8 | 0.20 | 2.3    | 11     |      | ●     |      |                                   |
| R/L S11.250.02               | 2.50    |          | 0.20 | 6.7 | 4.2 | 8 | 0.20 | 2.3    | 11     |      |       | ●    |                                   |
| R/L S11.300.02               | 3.00    |          | 0.20 | 6.7 | 4.2 | 8 | 0.20 | 2.3    | 11     |      |       | ●    |                                   |
| R/L S11.318.02               | 3.18    | 0.125"   | 0.20 | 6.7 | 4.2 | 8 | 0.20 | 2.3    | 11     |      | ●     |      |                                   |
| ↳ ...                        |         |          |      |     |     |   |      |        |        |      |       |      |                                   |

Weitere HM Sorten können Sie in der Sorten-übersicht im Kapitel "Technische Hinweise" und der Preisliste finden.

\* Schnitttiefe **ap** für das Längsdrehen ist werkstoffabhängig.

More carbide grades you can find in the grades summary in the chapter "technical instructions" and in the price list.

Bestellbeispiel:  
für rechte Ausführung und Sorte  
RS11.079.02/AL41F

\* The cutting depth **ap** for turning depends on the material.

order-example:  
righthand version and grade  
RS11.079.02/AL41F

## MINICUT

Bohrungsbearbeitung

grooving, boring and profiling

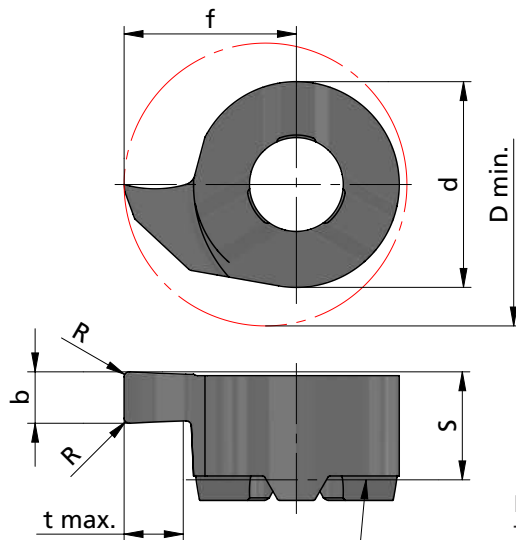
## Typ Stechdrehen

NC-Feindrehen

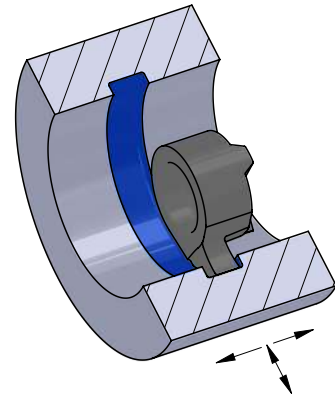
D min. 7.8 - 20 mm

type grooving,  
NC-profiling

D min. 7.8 - 20 mm



Klemhalter Stirnseite  
toolholder face



Beispielzeichnung  
exemplary application

Rechts (R): wie gezeichnet  
Links (L): spiegelbildlich

righthand (R): as shown  
lefthand version (L): mirror image

Abmessungen in mm

dimensions in mm

|     | Bestellnummer<br>part number | b +0.03 | b (inch) | R    | f   | s   | d | ap * | t max. | D min. | K10F | AL41F | P04C | Klemhalter Typ<br>toolholder type |
|-----|------------------------------|---------|----------|------|-----|-----|---|------|--------|--------|------|-------|------|-----------------------------------|
|     |                              |         |          |      |     |     |   |      |        |        |      |       |      |                                   |
| neu | R/L S14.100.005              | 1.00    |          | 0.05 | 9.0 | 5.3 | 9 | 0.05 | 4.0    | 14     |      |       | ●    | 614...                            |
| neu | R/L S14.125.005              | 1.25    |          | 0.05 | 9.0 | 5.3 | 9 | 0.05 | 4.0    | 14     |      |       | ●    |                                   |
| neu | R/L S14.150.01               | 1.50    |          | 0.10 | 9.0 | 5.3 | 9 | 0.10 | 4.0    | 14     |      |       | ●    |                                   |
|     | R/L S14.150.02               | 1.50    |          | 0.20 | 9.0 | 5.3 | 9 | 0.20 | 4.0    | 14     | ●    | ●     |      |                                   |
|     | R/L S14.157.02               | 1.57    | 0.062"   | 0.20 | 9.0 | 5.3 | 9 | 0.20 | 4.0    | 14     |      | ●     | ●    |                                   |
|     | R/L S14.157.04               | 1.57    | 0.062"   | 0.40 | 9.0 | 5.3 | 9 | 0.20 | 4.0    | 14     |      | ●     |      |                                   |
| neu | R/L S14.200.01               | 2.00    |          | 0.10 | 9.0 | 5.3 | 9 | 0.10 | 4.0    | 14     |      |       | ●    |                                   |
|     | R/L S14.200.02               | 2.00    |          | 0.20 | 9.0 | 5.3 | 9 | 0.20 | 4.0    | 14     | ●    | ●     |      |                                   |
|     | R/L S14.238.02               | 2.38    | 0.094"   | 0.20 | 9.0 | 5.3 | 9 | 0.20 | 4.0    | 14     |      | ●     |      |                                   |
|     | R/L S14.250.02               | 2.50    |          | 0.20 | 9.0 | 5.3 | 9 | 0.20 | 4.0    | 14     |      | ●     | ●    |                                   |
| neu | R/L S14.300.02               | 3.00    |          | 0.20 | 9.0 | 5.3 | 9 | 0.20 | 4.0    | 14     |      |       | ●    |                                   |
|     | R/L S14.318.02               | 3.18    | 0.125"   | 0.20 | 9.0 | 5.3 | 9 | 0.20 | 4.0    | 14     |      | ●     |      |                                   |

Weitere HM Sorten können Sie in der Sorten-  
übersicht im Kapitel "Technische Hinweise" und  
der Preisliste finden.

Bestellbeispiel:  
für rechte Ausführung und Sorte  
RS14.100.005/P04C

\* Schnitttiefe **ap** für das Längsdrehen ist  
werkstoffabhängig.

\* The cutting depth **ap** for turning depends on  
the material.

More carbide grades you can find in the grades  
summary in the chapter "technical instructions"  
and in the price list.

order-example:  
righthand version and grade  
RS14.100.005/P04C

## MINICUT

Bohrungsbearbeitung

grooving, boring and profiling

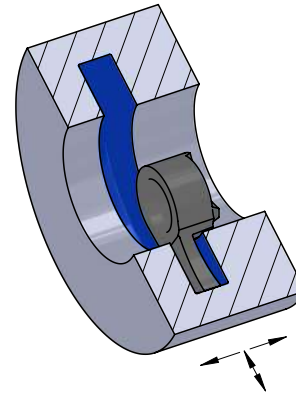
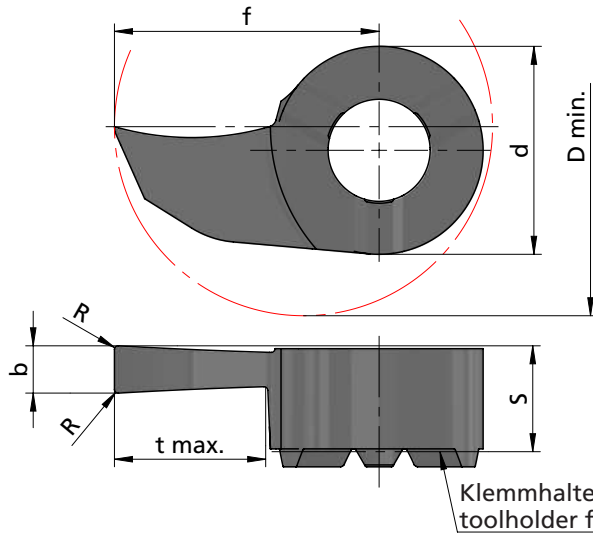
## Typ Stechdrehen

NC-Feindrehen

D min. 7.8 - 20 mm

type grooving,  
NC-profiling

D min. 7.8 - 20 mm



Beispielzeichnung  
exemplary application

Rechts (R): wie gezeichnet  
Links (L): spiegelbildlich

righthand (R): as shown  
lefthand version (L): mirror image

Abmessungen in mm

dimensions in mm

| Bestellnummer<br>part number | b +0.03 | b (inch) | R   | f    | S   | d  | ap * | t max. | D min. | K10F | AL41F | P04C | Klemhalter Typ<br>toolholder type |
|------------------------------|---------|----------|-----|------|-----|----|------|--------|--------|------|-------|------|-----------------------------------|
| ...                          |         |          |     |      |     |    |      |        |        |      |       |      |                                   |
| R/L S16.157.02               | 1.57    | 0.062"   | 0.2 | 10.2 | 5.4 | 11 | 0.2  | 4.3    | 16     | ●    |       |      |                                   |
| R/L S16.200.02               | 2.00    |          | 0.2 | 10.2 | 5.4 | 11 | 0.2  | 4.3    | 16     | ●    |       |      | 616...                            |
| R/L S16.318.02               | 3.18    | 0.125"   | 0.2 | 10.2 | 5.4 | 11 | 0.2  | 4.3    | 16     | ●    |       |      |                                   |
| R/L S18.200.02               | 2.00    |          | 0.2 | 12   | 5.6 | 11 | 0.2  | 6.0    | 18     | ●    |       |      | 618...                            |
| R/L S20.150.02               | 1.50    |          | 0.2 | 14   | 5.6 | 11 | 0.2  | 8.0    | 20     | ●    |       |      |                                   |
| R/L S20.200.02               | 2.00    |          | 0.2 | 14   | 5.6 | 11 | 0.2  | 8.0    | 20     | ●    |       |      |                                   |
| R/L S20.250.02               | 2.50    |          | 0.2 | 14   | 5.6 | 11 | 0.2  | 8.0    | 20     | ●    |       |      | 618...                            |
| R/L S20.300.02               | 3.00    |          | 0.2 | 14   | 5.6 | 11 | 0.2  | 8.0    | 20     | ●    |       |      |                                   |
| R/L S20.400.02               | 4.00    |          | 0.2 | 14   | 5.6 | 11 | 0.2  | 8.0    | 20     | ●    |       |      |                                   |

Weitere HM Sorten können Sie in der Sortenübersicht im Kapitel "Technische Hinweise" und der Preisliste finden.

\* Schnitttiefe **ap** für das Längsdrehen ist werkstoffabhängig.

More carbide grades you can find in the grades summary in the chapter "technical instructions" and in the price list.

Bestellbeispiel:  
für rechte Ausführung und Sorte  
RS16.157.02/AL41F

\* The cutting depth **ap** for turning depends on the material.

order-example:  
righthand version and grade  
RS16.157.02/AL41F

## MINICUT

Bohrungsbearbeitung

grooving, boring and profiling

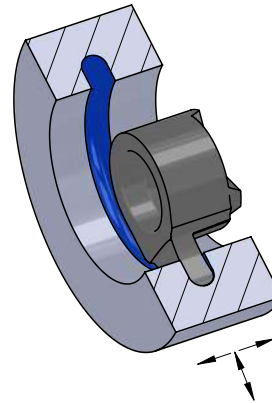
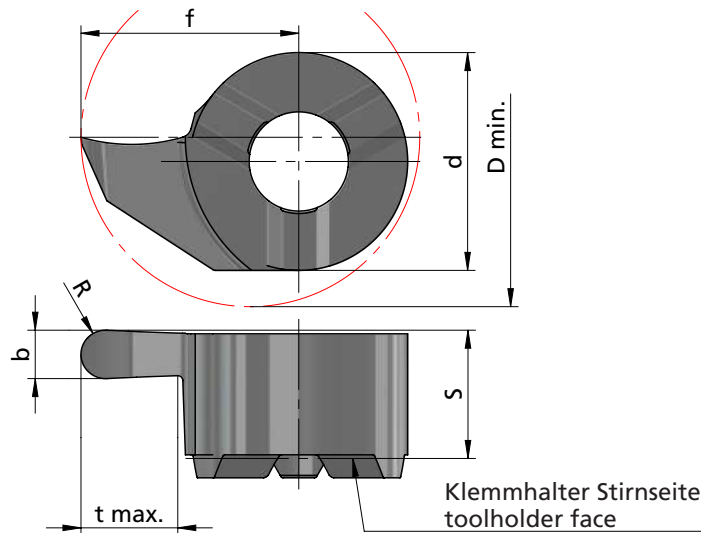
## Typ Stechdrehen

Stechdrehen und Kopieren  
Vollradius

type grooving,  
grooving and profiling  
full radius

D min. 8 - 16 mm  
Vollradius R 0.4 - 2.0

D min. 8 - 16 mm  
full radius R 0.4 - 2.0



Beispielzeichnung  
exemplary application

Rechts (R): wie gezeichnet  
Links (L): spiegelbildlich

righthand (R): as shown  
lefthand version (L): mirror image

Abmessungen in mm

dimensions in mm

neu

| Bestellnummer<br>part number | b +0.05 | b (inch) | R    | f   | s   | d   | t max. | D min. | K10F<br>AL41F<br>P04C | Klemhalter Typ<br>toolholder type |
|------------------------------|---------|----------|------|-----|-----|-----|--------|--------|-----------------------|-----------------------------------|
| R/L S08.008R04               | 0.80    |          | 0.40 | 4.8 | 3.3 | 6.0 | 1.0    | 8      | ● ● ●                 | 608...                            |
| R/L S08.010R05               | 1.00    |          | 0.50 | 4.8 | 3.3 | 6.0 | 1.0    | 8      | ● ● ●                 |                                   |
| R/L S08.012R06               | 1.20    |          | 0.60 | 4.8 | 3.3 | 6.0 | 1.0    | 8      | ● ● ●                 |                                   |
| R/L S08.U15R08               | 1.57    | 0.062"   | 0.78 | 4.8 | 3.3 | 6.0 | 1.0    | 8      | ● ● ●                 |                                   |
| R/L S08.018R09               | 1.80    |          | 0.90 | 4.8 | 3.3 | 6.0 | 1.0    | 8      | ● ● ●                 |                                   |
| R/L S08.020R10               | 2.00    |          | 1.00 | 4.8 | 3.3 | 6.0 | 1.0    | 8      | ● ● ●                 |                                   |
| R/L S09.008R04               | 0.80    |          | 0.40 | 5.5 | 3.5 | 6.2 | 1.6    | 9      | ● ● ●                 | 609...                            |
| R/L S09.010R05               | 1.00    |          | 0.50 | 5.5 | 3.5 | 6.2 | 1.6    | 9      | ● ● ●                 |                                   |
| R/L S09.012R06               | 1.20    |          | 0.60 | 5.5 | 3.5 | 6.2 | 1.6    | 9      | ● ● ●                 |                                   |
| R/L S09.018R09               | 1.80    |          | 0.90 | 5.5 | 3.5 | 6.2 | 1.6    | 9      | ● ● ●                 |                                   |
| R/L S09.020R10               | 2.00    |          | 1.00 | 5.5 | 3.5 | 6.2 | 1.6    | 9      | ● ● ●                 |                                   |
| ↳ ...                        |         |          |      |     |     |     |        |        |                       |                                   |

Weitere HM Sorten können Sie in der Sorten-  
übersicht im Kapitel "Technische Hinweise" und  
der Preisliste finden.

Bestellbeispiel:  
für rechte Ausführung und Sorte  
RS08.008R04/AL41F

More carbide grades you can find in the grades  
summary in the chapter "technical instructions"  
and in the price list.

order-example:  
righthand version and grade  
RS08.008R04/AL41F

## MINICUT

Bohrungsbearbeitung

grooving, boring and profiling

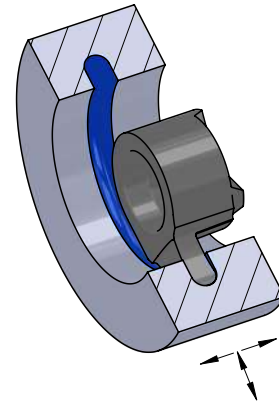
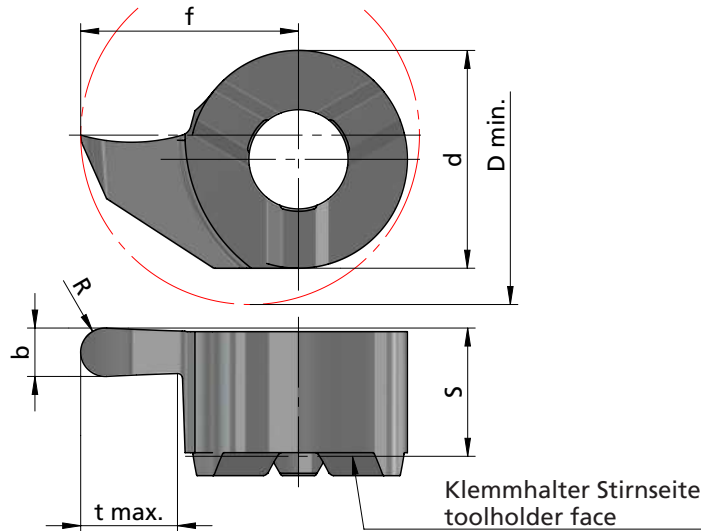
## Typ Stechdrehen

Stechdrehen und Kopieren  
Vollradius

type grooving,  
grooving and profiling  
full radius

D min. 8 - 16 mm  
Vollradius R 0.4 - 2.0

D min. 8 - 16 mm  
full radius R 0.4 - 2.0



Beispielzeichnung  
exemplary application

Rechts (R): wie gezeichnet  
Links (L): spiegelbildlich

righthand (R): as shown  
lefthand version (L): mirror image

Abmessungen in mm

dimensions in mm

neu

| Bestellnummer<br>part number | b +0.05 | b (inch) | R    | f   | s   | d | t max. | D min. | K10F | AL41F | P04C | Klemmhalter Typ<br>toolholder type |
|------------------------------|---------|----------|------|-----|-----|---|--------|--------|------|-------|------|------------------------------------|
| ⋮ ↙                          |         |          |      |     |     |   |        |        |      |       |      |                                    |
| R/L S11.008R04               | 0.80    |          | 0.40 | 6.7 | 4.2 | 8 | 2.3    | 11     | ●    | ●     | ●    | 611,...                            |
| R/L S11.010R05               | 1.00    |          | 0.50 | 6.7 | 4.2 | 8 | 2.3    | 11     |      |       | ●    |                                    |
| R/L S11.U11R05               | 1.17    | 0.046"   | 0.58 | 6.7 | 4.2 | 8 | 2.3    | 11     | ●    | ●     |      |                                    |
| R/L S11.012R06               | 1.20    |          | 0.60 | 6.7 | 4.2 | 8 | 2.3    | 11     | ●    | ●     |      |                                    |
| R/L S11.U15R08               | 1.57    | 0.062"   | 0.79 | 6.7 | 4.2 | 8 | 2.3    | 11     | ●    | ●     |      |                                    |
| R/L S11.016R08               | 1.60    |          | 0.80 | 6.7 | 4.2 | 8 | 2.3    | 11     |      | ●     |      |                                    |
| R/L S11.018R09               | 1.80    |          | 0.90 | 6.7 | 4.2 | 8 | 2.3    | 11     |      | ●     |      |                                    |
| R/L S11.020R10               | 2.00    |          | 1.00 | 6.7 | 4.2 | 8 | 2.3    | 11     | ●    | ●     | ●    |                                    |
| R/L S11.024R12               | 2.40    |          | 1.20 | 6.7 | 4.2 | 8 | 2.3    | 11     |      | ●     |      |                                    |
| R/L S11.030R15               | 3.00    |          | 1.50 | 6.7 | 4.2 | 8 | 2.3    | 11     | ●    | ●     |      |                                    |
| ↘ ...                        |         |          |      |     |     |   |        |        |      |       |      |                                    |

Weitere HM Sorten können Sie in der Sorten-  
übersicht im Kapitel "Technische Hinweise" und  
der Preisliste finden.

Bestellbeispiel:  
für rechte Ausführung und Sorte  
RS11.008R04/AL41F

More carbide grades you can find in the grades  
summary in the chapter "technical instructions"  
and in the price list.

order-example:  
righthand version and grade  
RS11.008R04/AL41F

## MINICUT

Bohrungsbearbeitung

grooving, boring and profiling

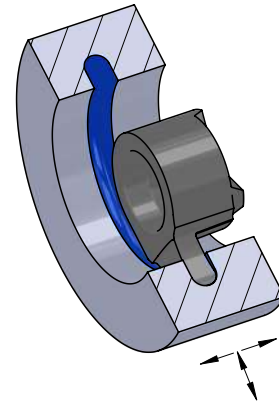
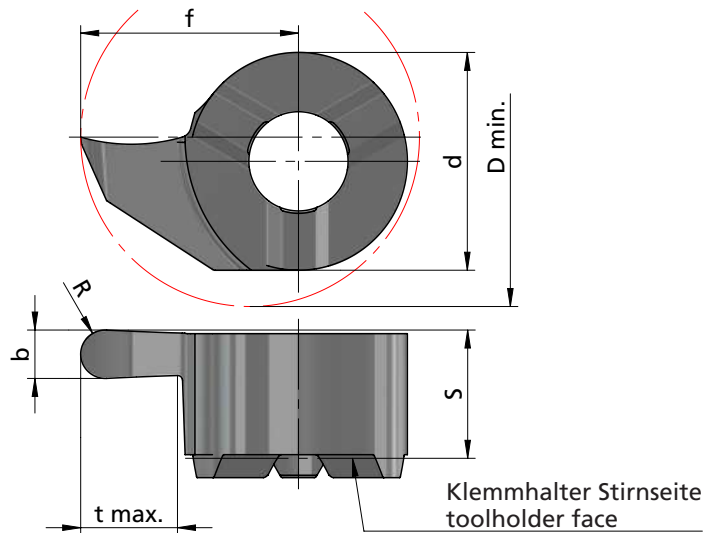
## Typ Stechdrehen

Stechdrehen und Kopieren  
Vollradius

type grooving,  
grooving and profiling  
full radius

D min. 8 - 16 mm  
Vollradius R 0.4 - 2.0

D min. 8 - 16 mm  
full radius R 0.4 - 2.0



Beispielzeichnung  
exemplary application

Rechts (R): wie gezeichnet  
Links (L): spiegelbildlich

righthand (R): as shown  
lefthand version (L): mirror image

Abmessungen in mm

dimensions in mm

| Bestellnummer<br>part number | b +0.05 | b (inch) | R    | f   | s   | d | t max. | D min. | K10F | AL41F | P04C | Klemmhalter Typ<br>toolholder type |
|------------------------------|---------|----------|------|-----|-----|---|--------|--------|------|-------|------|------------------------------------|
| ⋮ ↙                          |         |          |      |     |     |   |        |        |      |       |      |                                    |
| R/L S14.008R04               | 0.80    |          | 0.40 | 9.0 | 5.2 | 9 | 4.0    | 14     | ●    |       |      | 614...                             |
| R/L S14.010R05               | 1.00    |          | 0.50 | 9.0 | 5.3 | 9 | 4.0    | 14     | ●    |       | ●    |                                    |
| R/L S14.012R06               | 1.20    |          | 0.60 | 9.0 | 5.3 | 9 | 4.0    | 14     | ●    |       |      |                                    |
| R/L S14.U15R08               | 1.57    | 0.062"   | 0.78 | 9.0 | 5.3 | 9 | 4.0    | 14     | ●    |       |      |                                    |
| R/L S14.018R09               | 1.80    |          | 0.90 | 9.0 | 5.3 | 9 | 4.0    | 14     | ●    |       |      |                                    |
| R/L S14.020R10               | 2.00    |          | 1.00 | 9.0 | 5.3 | 9 | 4.0    | 14     | ●    |       | ●    |                                    |
| R/L S14.022R11               | 2.20    |          | 1.10 | 9.0 | 5.3 | 9 | 4.0    | 14     | ●    |       |      |                                    |
| R/L S14.030R15               | 3.00    |          | 1.50 | 9.0 | 5.3 | 9 | 4.0    | 14     | ●    | ●     | ●    |                                    |
| ↘ ...                        |         |          |      |     |     |   |        |        |      |       |      |                                    |

Weitere HM Sorten können Sie in der Sorten-  
übersicht im Kapitel "Technische Hinweise" und  
der Preisliste finden.

Bestellbeispiel:  
für rechte Ausführung und Sorte  
RS14.008R04/AL41F

More carbide grades you can find in the grades  
summary in the chapter "technical instructions"  
and in the price list.

order-example:  
righthand version and grade  
RS14.008R04/AL41F

## MINICUT

Bohrungsbearbeitung

grooving, boring and profiling

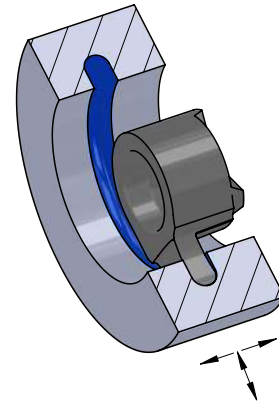
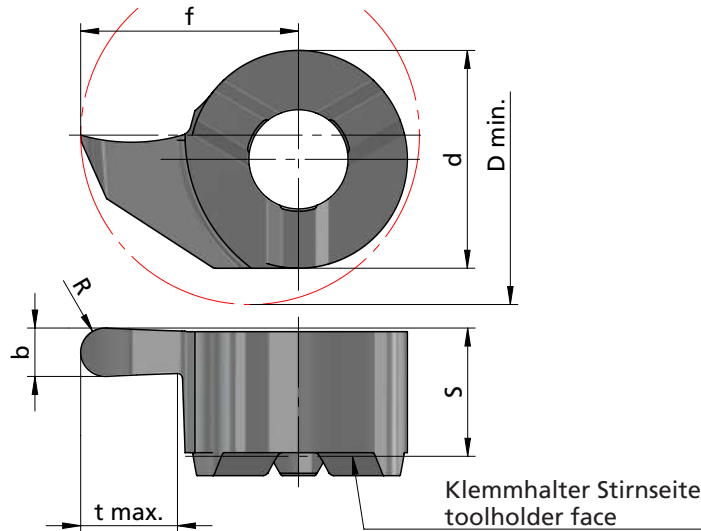
## Typ Stechdrehen

Stechdrehen und Kopieren  
Vollradius

type grooving,  
grooving and profiling  
full radius

D min. 8 - 16 mm  
Vollradius R 0.4 - 2.0

D min. 8 - 16 mm  
full radius R 0.4 - 2.0



Beispielzeichnung  
exemplary application

Rechts (R): wie gezeichnet  
Links (L): spiegelbildlich

righthand (R): as shown  
lefthand version (L): mirror image

Abmessungen in mm

dimensions in mm

| Bestellnummer<br>part number | b +0.05 | b (inch) | R    | f    | s   | d  | t max. | D min. | K10F | AL41F | P04C | Klemmhalter Typ<br>toolholder type |
|------------------------------|---------|----------|------|------|-----|----|--------|--------|------|-------|------|------------------------------------|
| ↙ ↘                          |         |          |      |      |     |    |        |        |      |       |      |                                    |
| R/L S16.016R08               | 1.60    |          | 0.80 | 10.2 | 5.4 | 11 | 4.3    | 16     | ●    |       |      | 616...                             |
| R/L S16.018R09               | 1.80    |          | 0.90 | 10.2 | 5.4 | 11 | 4.3    | 16     | ●    |       |      |                                    |
| R/L S16.U19R09               | 1.98    | 0.078"   | 0.99 | 10.2 | 5.4 | 11 | 4.3    | 16     | ●    |       |      |                                    |
| R/L S16.020R10               | 2.00    |          | 1.00 | 10.2 | 5.4 | 11 | 4.3    | 16     | ●    |       |      |                                    |
| R/L S16.022R11               | 2.20    |          | 1.10 | 10.2 | 5.4 | 11 | 4.3    | 16     | ●    |       |      |                                    |
| R/L S16.024R12               | 2.40    |          | 1.20 | 10.2 | 5.4 | 11 | 4.3    | 16     | ●    |       |      |                                    |
| R/L S16.030R15               | 3.00    |          | 1.50 | 10.2 | 5.4 | 11 | 4.3    | 16     | ●    |       |      |                                    |
| R/L S16.U31R15               | 3.18    | 0.125"   | 1.59 | 10.2 | 5.4 | 11 | 4.3    | 16     | ●    |       |      |                                    |
| R/L S16.032R16               | 3.20    |          | 1.60 | 10.2 | 5.4 | 11 | 4.3    | 16     | ●    |       |      |                                    |
| R/L S16.040R20               | 4.00    |          | 2.00 | 10.2 | 5.4 | 11 | 4.3    | 16     | ●    |       |      |                                    |

Weitere HM Sorten können Sie in der Sorten-  
übersicht im Kapitel "Technische Hinweise" und  
der Preisliste finden.

Bestellbeispiel:  
für rechte Ausführung und Sorte  
RS16.016R08/AL41F

More carbide grades you can find in the grades  
summary in the chapter "technical instructions"  
and in the price list.

order-example:  
righthand version and grade  
RS16.016R08/AL41F

## MINICUT

Bohrungsbearbeitung

grooving, boring and profiling

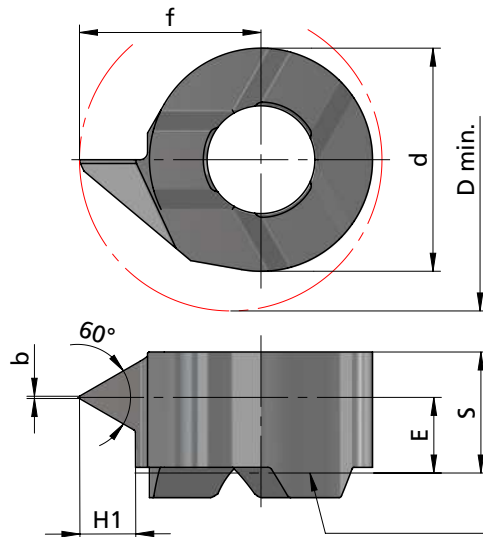
## Typ Gewindedrehen

metrisches ISO-Gewinde,  
Vollprofil, innen

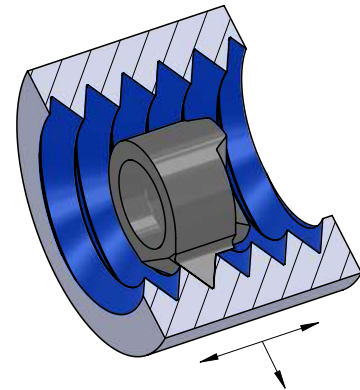
type threading,  
metric ISO-thread,  
full profile, internal

D min. 7 / 8 mm  
Steigung P = 0.50 - 1.25

D min. 7 / 8 mm  
pitch P = 0.50 - 1.25



Klemmhalter Stirnseite  
toolholder face



Beispielzeichnung  
exemplary application

Rechts (R): wie gezeichnet  
Links (L): spiegelbildlich

righthand (R): as shown  
lefthand version (L): mirror image

Abmessungen in mm

dimensions in mm

|     | Bestellnummer<br>part number | Steigung P<br>pitch P | H1   | b    | f    | S    | d   | E   | D min. | K10F<br>AL41F<br>P04C | Klemmhalter Typ<br>toolholder type |
|-----|------------------------------|-----------------------|------|------|------|------|-----|-----|--------|-----------------------|------------------------------------|
| neu | R/L S07.0205.02              | 0.50                  | 0.27 | 0.05 | 4.15 | 3.3  | 4.8 | 2.9 | 7      | ●                     | 607...                             |
| neu | R/L S07.0407.02              | 0.75                  | 0.40 | 0.08 | 4.15 | 3.3  | 4.8 | 2.7 | 7      | ●                     |                                    |
| neu | R/L S07.0510.02              | 1.00                  | 0.54 | 0.11 | 4.15 | 3.3  | 4.8 | 2.7 | 7      | ●                     |                                    |
| neu | R/L S07.0612.02              | 1.25                  | 0.67 | 0.14 | 4.15 | 3.3  | 4.8 | 2.7 | 7      | ●                     |                                    |
| neu | R/L S08.0205.02              | 0.50                  | 0.27 | 0.05 | 4.80 | 3.64 | 6.0 | 3.0 | 8      | ●                     | 608...                             |
| neu | R/L S08.0407.02              | 0.75                  | 0.40 | 0.08 | 4.80 | 3.62 | 6.0 | 2.8 | 8      | ●                     |                                    |
| neu | R/L S08.0510.02              | 1.00                  | 0.54 | 0.11 | 4.80 | 3.62 | 6.0 | 2.8 | 8      | ●                     |                                    |
| neu | R/L S08.0612.02              | 1.25                  | 0.67 | 0.14 | 4.80 | 3.62 | 6.0 | 2.8 | 8      | ●                     |                                    |

Weitere HM Sorten können Sie in der Sorten-  
übersicht im Kapitel "Technische Hinweise" und  
der Preisliste finden.

Bestellbeispiel:  
für rechte Ausführung und Sorte  
RS07.0205.02/AL41F

More carbide grades you can find in the grades  
summary in the chapter "technical instructions"  
and in the price list.

order-example:  
righthand version and grade  
RS07.0205.02/AL41F

## MINICUT

Bohrungsbearbeitung

grooving, boring and profiling

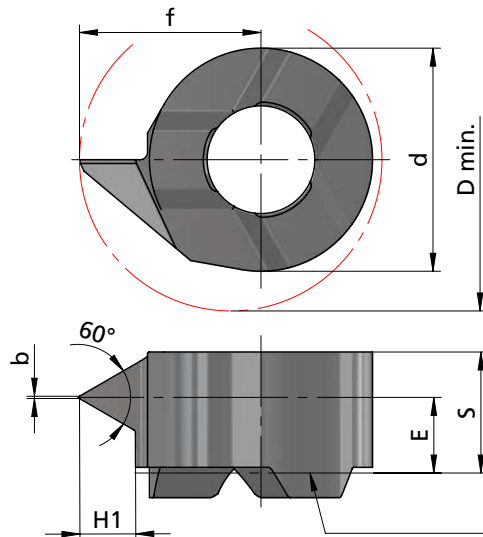
## Typ Gewindedrehen

metrisches ISO-Gewinde,  
Vollprofil, innen

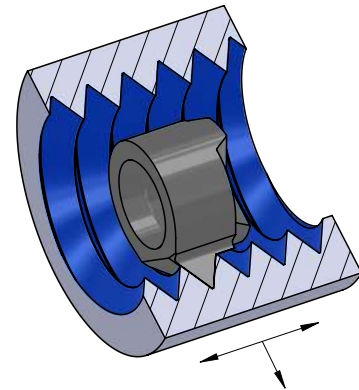
type threading,  
metric ISO-thread,  
full profile, internal

D min. 9 / 11 mm  
Steigung P = 0.5 - 3.0

D min. 9 / 11 mm  
pitch P = 0.5 - 3.0



Klemmhalter Stirnseite  
toolholder face



Beispielzeichnung  
exemplary application

Rechts (R): wie gezeichnet  
Links (L): spiegelbildlich

righthand (R): as shown  
lefthand version (L): mirror image

Abmessungen in mm

dimensions in mm

|     | Bestellnummer<br>part number | Steigung P<br>pitch P | H1   | b    | f   | S    | d   | E    | D min. |      |       |      | Klemmhalter Typ<br>toolholder type |
|-----|------------------------------|-----------------------|------|------|-----|------|-----|------|--------|------|-------|------|------------------------------------|
|     |                              |                       |      |      |     |      |     |      |        | K10F | AL41F | P04C |                                    |
| neu | R/L S09.0205.02              | 0.50                  | 0.27 | 0.06 | 5.5 | 3.65 | 6.2 | 3.25 | 9      | ●    |       |      | 609...                             |
|     | R/L S09.0407.02              | 0.75                  | 0.40 | 0.08 | 5.5 | 3.65 | 6.2 | 3.00 | 9      | ●    |       |      |                                    |
| neu | R/L S09.0510.02              | 1.00                  | 0.54 | 0.12 | 5.5 | 3.65 | 6.2 | 3.00 | 9      | ●    | ●     |      |                                    |
|     | R/L S09.0612.02              | 1.25                  | 0.67 | 0.14 | 5.5 | 3.60 | 6.2 | 2.80 | 9      | ●    |       |      |                                    |
|     | R/L S09.0815.02              | 1.50                  | 0.81 | 0.18 | 5.5 | 3.60 | 6.2 | 2.80 | 9      | ●    | ●     |      |                                    |
|     | R/L S09.0917.02              | 1.75                  | 0.95 | 0.20 | 5.5 | 3.60 | 6.2 | 2.70 | 9      | ●    | ●     |      |                                    |
|     | R/L S09.1020.02              | 2.00                  | 1.08 | 0.25 | 5.5 | 3.55 | 6.2 | 2.60 | 9      | ●    |       |      |                                    |
|     | R/L S09.1325.02              | 2.50                  | 1.35 | 0.31 | 5.5 | 3.55 | 6.2 | 2.50 | 9      | ●    |       |      |                                    |
|     | R/L S09.1630.02              | 3.00                  | 1.62 | 0.37 | 5.5 | 3.55 | 6.2 | 2.20 | 9      | ●    |       |      |                                    |
|     | R/L S11.0510.02              | 1.00                  | 0.54 | 0.12 | 6.7 | 4.30 | 8.0 | 3.60 | 11     | ●    | ●     |      | 611...                             |
|     | R/L S11.0815.02              | 1.50                  | 0.81 | 0.18 | 6.7 | 4.30 | 8.0 | 3.30 | 11     | ●    | ●     |      |                                    |
|     | R/L S11.1020.02              | 2.00                  | 1.08 | 0.25 | 6.7 | 4.30 | 8.0 | 2.90 | 11     | ●    | ●     |      |                                    |
|     | R/L S11.1325.02              | 2.50                  | 1.35 | 0.31 | 6.7 | 4.30 | 8.0 | 2.95 | 11     | ●    |       |      |                                    |
|     | R/L S11.1630.02              | 3.00                  | 1.62 | 0.37 | 6.7 | 4.30 | 8.0 | 2.90 | 11     | ●    |       |      |                                    |

Weitere HM Sorten können Sie in der Sorten-  
übersicht im Kapitel "Technische Hinweise" und  
der Preisliste finden.

Bestellbeispiel:  
für rechte Ausführung und Sorte  
RS09.0205.02/AL41F

More carbide grades you can find in the grades  
summary in the chapter "technical instructions"  
and in the price list.

order-example:  
righthand version and grade  
RS09.0205.02/AL41F

## MINICUT

Bohrungsbearbeitung

grooving, boring and profiling

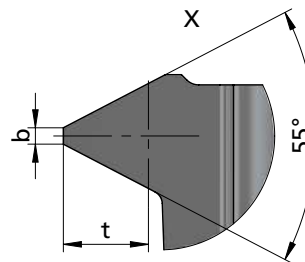
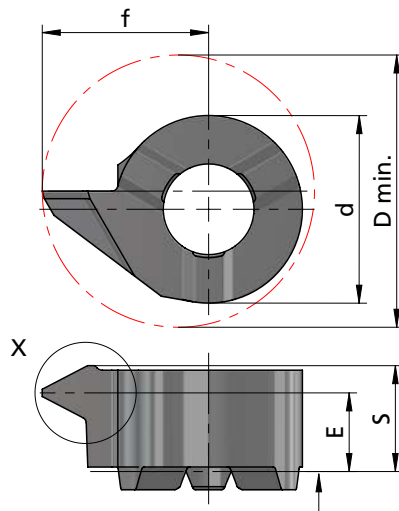
## Typ Gewindedrehen

Whitworth-Gewinde,  
Teilprofil, innen

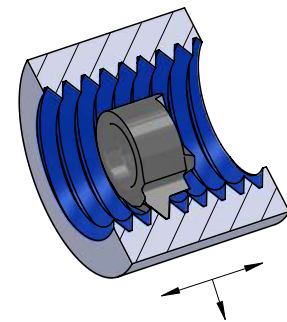
D min. 7 / 9 / 11 mm

type threading,  
Whitworth thread,  
partial profile, internal

D min. 7 / 9 / 11 mm



Klemmhalter Stirnseite  
toolholder face



Beispielzeichnung  
exemplary application

Rechts (R): wie gezeichnet  
Links (L): spiegelbildlich

righthand (R): as shown  
lefthand version (L): mirror image

Abmessungen in mm

dimensions in mm

|     | Bestellnummer<br>part number | Steigung P<br>pitch P | Gang / Zoll<br>threads / inch | t    | b    | f   | S   | d   | E    | D min. | K10F<br>AL41F | Klemmhalter Typ<br>toolholder type |
|-----|------------------------------|-----------------------|-------------------------------|------|------|-----|-----|-----|------|--------|---------------|------------------------------------|
| neu | R/L S07.TP55.18              | 1.411 - 1.814         | 14 - 18                       | 1.25 | 0.25 | 4.3 | 3.3 | 4.8 | 2.40 | 7      | ●             | 607...                             |
| neu | R/L S07.TP55.24              | 1.058 - 1.411         | 18 - 24                       | 1.00 | 0.18 | 4.3 | 3.3 | 4.8 | 2.55 | 7      | ●             |                                    |
| neu | R/L S07.TP55.32              | 0.793 - 1.058         | 24 - 32                       | 0.75 | 0.13 | 4.3 | 3.3 | 4.8 | 2.70 | 7      | ●             |                                    |
| neu | R/L S07.TP55.48              | 0.529 - 0.793         | 32 - 48                       | 0.55 | 0.09 | 4.3 | 3.3 | 4.8 | 2.85 | 7      | ●             |                                    |
| neu | R/L S09.TP55.14              | 1.814 - 2.309         | 11 - 14                       | 1.60 | 0.30 | 5.5 | 3.5 | 6.2 | 2.40 | 9      | ●             | 609...                             |
| neu | R/L S09.TP55.18              | 1.411 - 1.814         | 14 - 18                       | 1.25 | 0.24 | 5.5 | 3.5 | 6.2 | 2.60 | 9      | ●             |                                    |
| neu | R/L S09.TP55.24              | 1.058 - 1.411         | 18 - 24                       | 1.00 | 0.18 | 5.5 | 3.5 | 6.2 | 2.75 | 9      | ●             |                                    |
| neu | R/L S09.TP55.32              | 0.793 - 1.058         | 24 - 32                       | 0.75 | 0.13 | 5.5 | 3.5 | 6.2 | 2.90 | 9      | ●             |                                    |
| neu | R/L S09.TP55.48              | 0.529 - 0.793         | 32 - 48                       | 0.55 | 0.09 | 5.5 | 3.5 | 6.2 | 3.05 | 9      | ●             |                                    |
| neu | R/L S11.TP55.08              | 2.309 - 3.175         | 8 - 11                        | 2.20 | 0.38 | 6.7 | 4.2 | 8.0 | 2.75 | 11     | ●             | 611...                             |
| neu | R/L S11.TP55.14              | 1.814 - 2.309         | 11 - 14                       | 1.60 | 0.30 | 6.7 | 4.2 | 8.0 | 3.10 | 11     | ●             |                                    |
| neu | R/L S11.TP55.18              | 1.411 - 1.814         | 14 - 18                       | 1.25 | 0.24 | 6.7 | 4.2 | 8.0 | 3.30 | 11     | ●             |                                    |
| neu | R/L S11.TP55.24              | 1.058 - 1.411         | 18 - 24                       | 1.00 | 0.18 | 6.7 | 4.2 | 8.0 | 3.45 | 11     | ●             |                                    |
| neu | R/L S11.TP55.32              | 0.793 - 1.058         | 24 - 32                       | 0.75 | 0.13 | 6.7 | 4.2 | 8.0 | 3.60 | 11     | ●             |                                    |
| neu | R/L S11.TP55.48              | 0.529 - 0.793         | 32 - 48                       | 0.55 | 0.09 | 6.7 | 4.2 | 8.0 | 3.75 | 11     | ●             |                                    |

Weitere HM Sorten können Sie in der Sorten-  
übersicht im Kapitel "Technische Hinweise" und  
der Preisliste finden.

Bestellbeispiel:  
für rechte Ausführung und Sorte  
RS07.TP55.18/AL41F

More carbide grades you can find in the grades  
summary in the chapter "technical instructions"  
and in the price list.

order-example:  
righthand version and grade  
RS07.TP55.18/AL41F

## MINICUT

Bohrungsbearbeitung

grooving, boring and profiling

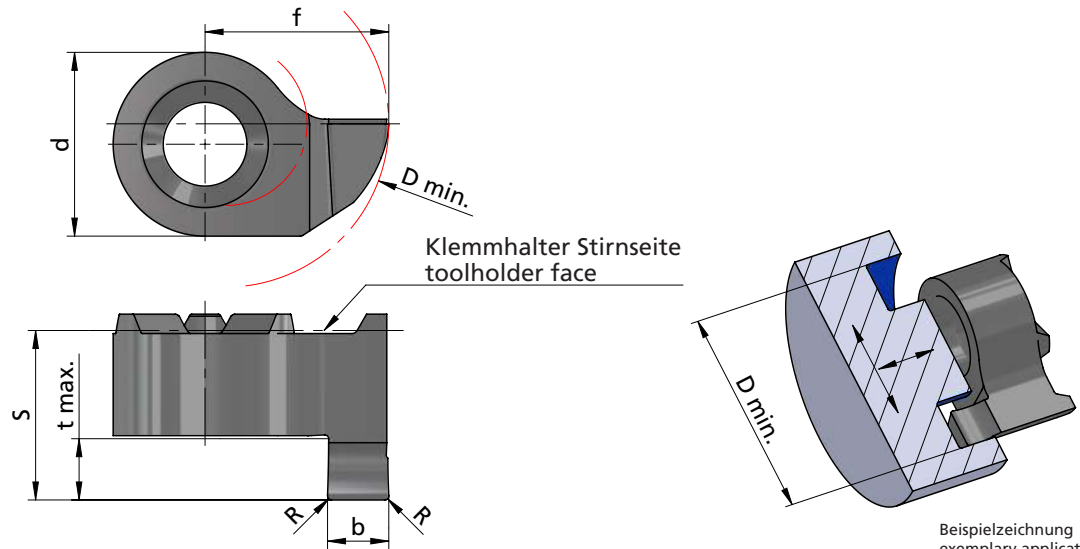
## Typ Axialstechen

allgemein

type face grooving

D min. 14 / 18 mm  
Stechtiefe t max. 6 / 10 mm  
Nutbreite bis 3.0 / 4.0 mm

D min. 14 / 18 mm  
depth of groove t max. 6 / 10 mm  
width of groove up to 3.0 / 4.0 mm



Beispielzeichnung  
exemplary application

Rechts (R): wie gezeichnet  
Links (L): spiegelbildlich

righthand (R): as shown  
lefthand version (L): mirror image

Abmessungen in mm

dimensions in mm

|     | Bestellnummer<br>part number | b+0.03 | b (inch) | f | R   | S    | d | t max. | D min. |      |       |      | Klemmhalter Typ<br>toolholder type |
|-----|------------------------------|--------|----------|---|-----|------|---|--------|--------|------|-------|------|------------------------------------|
|     |                              |        |          |   |     |      |   |        |        | K10F | AL41F | P04C |                                    |
| neu | R/L S014.1410.00             | 1.0    |          | 9 | -   | 8.3  | 9 | 1.5    | 14     |      | ●     | ●    | 614. ...<br>614.A. ...             |
|     | R/L S014.1410.01             | 1.0    |          | 9 | 0.1 | 8.3  | 9 | 1.5    | 14     |      |       | ●    |                                    |
| neu | R/L S014.U411.00             | 1.17   | 0.046"   | 9 | -   | 8.3  | 9 | 1.5    | 14     |      | ●     |      |                                    |
|     | R/L S014.1415.01             | 1.5    |          | 9 | 0.1 | 8.3  | 9 | 2.5    | 14     |      |       | ●    |                                    |
| neu | R/L S014.1415.02             | 1.5    |          | 9 | 0.2 | 8.3  | 9 | 2.5    | 14     | ●    | ●     |      |                                    |
|     | R/L S014.1420.01             | 2.0    |          | 9 | 0.1 | 8.3  | 9 | 3.0    | 14     |      |       | ●    |                                    |
| neu | R/L S014.1420.02             | 2.0    |          | 9 | 0.2 | 8.3  | 9 | 3.0    | 14     | ●    | ●     | ●    |                                    |
|     | R/L S014.1425.01             | 2.5    |          | 9 | 0.1 | 8.3  | 9 | 3.0    | 14     |      |       | ●    |                                    |
| neu | R/L S014.1425.02             | 2.5    |          | 9 | 0.2 | 8.3  | 9 | 3.0    | 14     | ●    | ●     |      |                                    |
|     | R/L S014.1430.01             | 3.0    |          | 9 | 0.1 | 8.3  | 9 | 3.0    | 14     |      |       | ●    |                                    |
| neu | R/L S014.1430.02             | 3.0    |          | 9 | 0.2 | 8.3  | 9 | 3.0    | 14     |      | ●     |      |                                    |
|     | R/L S014.1420.52             | 2.0    |          | 9 | 0.2 | 10.3 | 9 | 5.0    | 14     | ●    | ●     |      |                                    |
|     | R/L S014.1425.51             | 2.5    |          | 9 | 0.1 | 10.3 | 9 | 5.0    | 14     |      |       | ●    |                                    |
|     | R/L S014.1425.52             | 2.5    |          | 9 | 0.2 | 10.3 | 9 | 5.0    | 14     | ●    | ●     |      |                                    |
|     | ↳ ...                        |        |          |   |     |      |   |        |        |      |       |      |                                    |

Weitere HM Sorten können Sie in der Sorten-  
übersicht im Kapitel "Technische Hinweise" und  
der Preisliste finden.

Bestellbeispiel:  
für rechte Ausführung und Sorte  
RS014.1410.00/AL41F

More carbide grades you can find in the grades  
summary in the chapter "technical instructions"  
and in the price list.

order-example:  
righthand version and grade  
RS014.1410.00/AL41F

# MINICUT

Bohrungsbearbeitung

grooving, boring and profiling

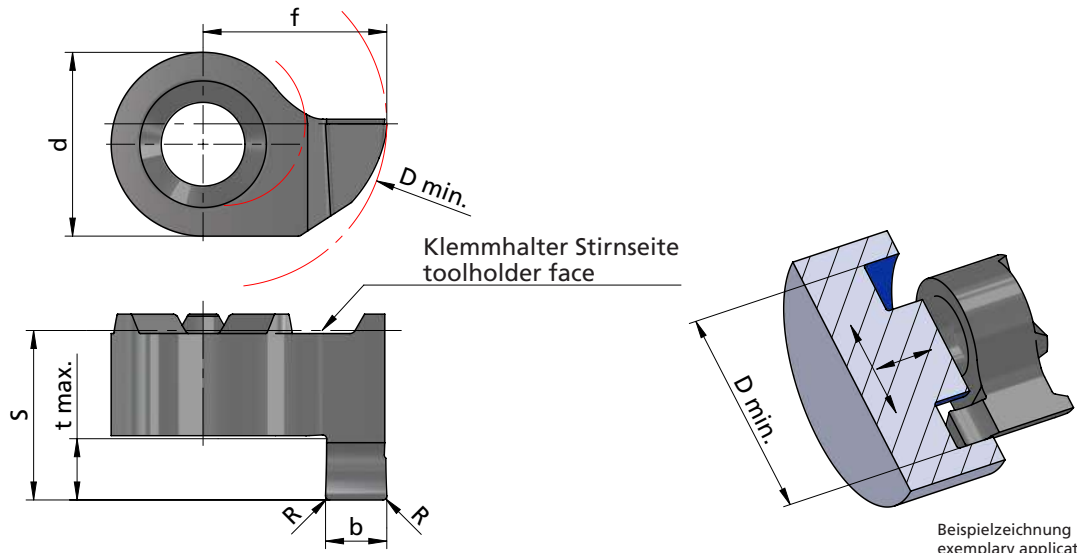
## Typ Axialstechen

allgemein

type face grooving

D min. 14 / 18 mm  
Stechtiefe t max. 6 / 10 mm  
Nutbreite bis 3.0 / 4.0 mm

D min. 14 / 18 mm  
depth of groove t max. 6 / 10 mm  
width of groove up to 3.0 / 4.0 mm



Rechts (R): wie gezeichnet  
Links (L): spiegelbildlich

righthand (R): as shown  
lefthand version (L): mirror image

Abmessungen in mm

dimensions in mm

neu

| Bestellnummer<br>part number | b+0.03 | b (inch) | f    | R   | S    | d  | t max. | D min. | K10F | AL41F | P04C | Klemmhalter Typ<br>toolholder type |
|------------------------------|--------|----------|------|-----|------|----|--------|--------|------|-------|------|------------------------------------|
| ⋮ ↙                          |        |          |      |     |      |    |        |        |      |       |      |                                    |
| R/L S014.1430.52             | 3.0    |          | 9    | 0.2 | 10.3 | 9  | 5.0    | 14     | ●    | ●     |      | 614....                            |
| R/- S014.1430.61             | 3.0    |          | 9    | 0.1 | 11.3 | 9  | 6.0    | 14     |      |       | ●    | 614.A....                          |
| R/- S014.1430.62             | 3.0    |          | 9    | 0.2 | 11.3 | 9  | 6.0    | 14     |      | ●     |      |                                    |
| R/L S018.1830.02             | 3.0    |          | 11   | 0.2 | 15.8 | 11 | 10     | 18     | ●    |       |      | 618....                            |
| R/L S018.1840.02             | 4.0    |          | 11.5 | 0.2 | 15.8 | 11 | 10     | 18     | ●    |       |      | 618.A....                          |

Weitere HM Sorten können Sie in der Sorten-  
übersicht im Kapitel "Technische Hinweise" und  
der Preisliste finden.

Bestellbeispiel:  
für rechte Ausführung und Sorte  
R/L S014.1430.52/AL41F

More carbide grades you can find in the grades  
summary in the chapter "technical instructions"  
and in the price list.

order-example:  
righthand version and grade  
R/L S014.1430.52/AL41F

# MINICUT

Bohrungsbearbeitung

grooving, boring and profiling

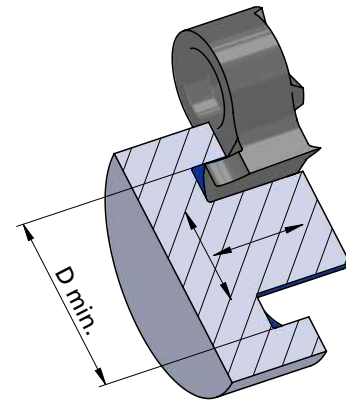
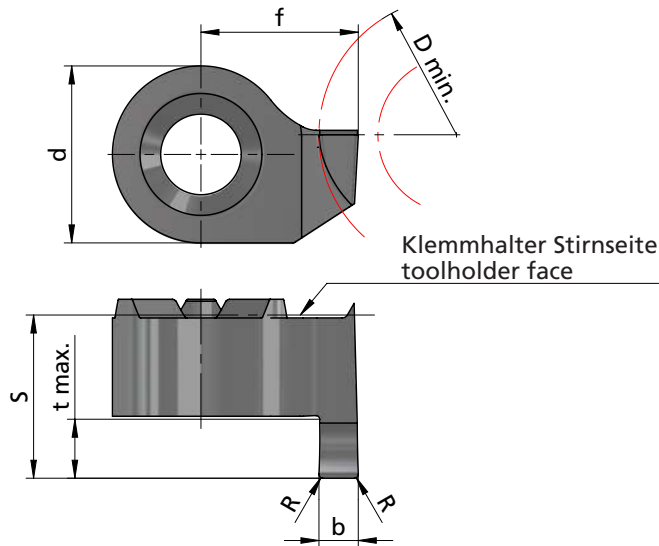
## Typ Axialstechen

am Zapfen vorbei

type face grooving,  
in pivots

D min. 12 / 16 mm  
Stechtiefe t max. 6 / 10 mm  
Nutbreite bis 3.0 / 4.0 mm

D min. 12 / 16 mm  
depth of groove t max. 6 / 10 mm  
width of groove up to 3.0 / 4.0 mm



Beispielzeichnung  
exemplary application

Rechts (R): wie gezeichnet  
Links (L): spiegelbildlich

righthand (R): as shown  
lefthand version (L): mirror image

Abmessungen in mm

dimensions in mm

| Bestellnummer<br>part number | b+0.03 | b (inch) | f    | R   | S    | d | t max. | D min. |  | K10F | AL41F | P04C | Klemmhalter Typ<br>toolholder type |
|------------------------------|--------|----------|------|-----|------|---|--------|--------|--|------|-------|------|------------------------------------|
| R/L S014.1210.00             | 1.0    |          | 7.00 | -   | 8.3  | 9 | 1.5    | 12     |  | ●    | ●     | ●    | 614.000<br>614.A.000               |
| R/L S014.1210.01             | 1.0    |          | 7.00 | 0.1 | 8.3  | 9 | 1.5    | 12     |  |      |       | ●    |                                    |
| R/L S014.1215.01             | 1.5    |          | 7.50 | 0.1 | 8.3  | 9 | 2.5    | 12     |  |      |       | ●    |                                    |
| R/L S014.1215.02             | 1.5    |          | 7.50 | 0.2 | 8.3  | 9 | 2.5    | 12     |  | ●    | ●     |      |                                    |
| R/L S014.U219.02             | 1.98   | 0.078"   | 7.98 | 0.2 | 8.3  | 9 | 3.0    | 12     |  |      | ●     |      |                                    |
| R/L S014.1220.01             | 2.0    |          | 8.00 | 0.1 | 8.3  | 9 | 3.0    | 12     |  |      |       | ●    |                                    |
| R/L S014.1220.02             | 2.0    |          | 8.00 | 0.2 | 8.3  | 9 | 3.0    | 12     |  | ●    | ●     | ●    |                                    |
| R/L S014.U223.02             | 2.39   | 0.094"   | 8.39 | 0.2 | 8.3  | 9 | 3.0    | 12     |  |      | ●     |      |                                    |
| R/L S014.1225.01             | 2.5    |          | 8.50 | 0.1 | 8.3  | 9 | 3.0    | 12     |  |      |       | ●    |                                    |
| R/L S014.1225.02             | 2.5    |          | 8.50 | 0.2 | 8.3  | 9 | 3.0    | 12     |  |      | ●     |      |                                    |
| R/L S014.1230.01             | 3.0    |          | 9.00 | 0.1 | 8.3  | 9 | 3.0    | 12     |  |      |       | ●    |                                    |
| R/L S014.1230.02             | 3.0    |          | 9.00 | 0.2 | 8.3  | 9 | 3.0    | 12     |  |      | ●     |      |                                    |
| R/L S014.U231.02             | 3.18   | 0.125"   | 9.18 | 0.2 | 8.3  | 9 | 3.0    | 12     |  |      | ●     |      |                                    |
| R/L S014.1220.52             | 2.0    |          | 8.00 | 0.2 | 10.3 | 9 | 5.0    | 12     |  | ●    | ●     |      |                                    |
| ↳ ...                        |        |          |      |     |      |   |        |        |  |      |       |      |                                    |

Weitere HM Sorten können Sie in der Sorten-  
übersicht im Kapitel "Technische Hinweise" und  
der Preisliste finden.

Bestellbeispiel:  
für rechte Ausführung und Sorte  
RS014.1210.00/AL41F

More carbide grades you can find in the grades  
summary in the chapter "technical instructions"  
and in the price list.

order-example:  
righthand version and grade  
RS014.1210.00/AL41F

## MINICUT

Bohrungsbearbeitung

grooving, boring and profiling

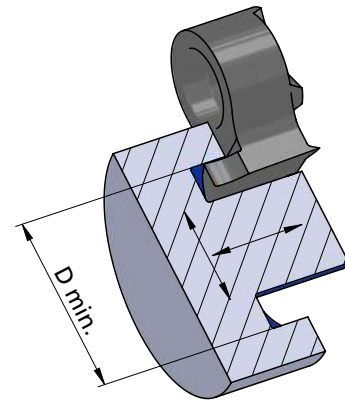
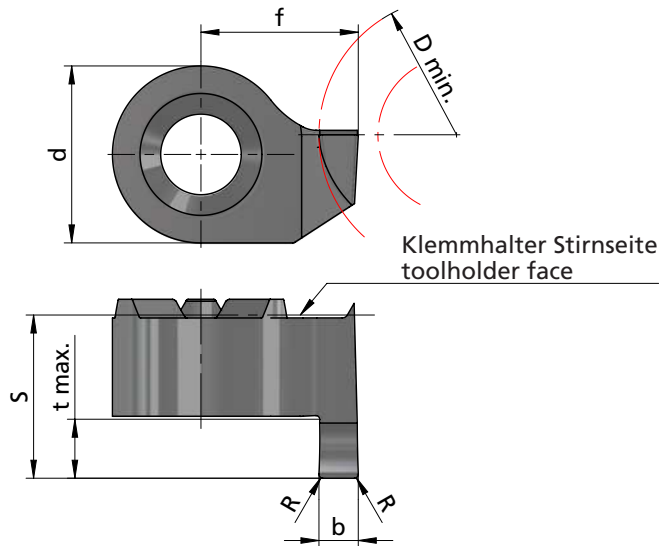
## Typ Axialstechen

am Zapfen vorbei

type face grooving,  
in pivots

D min. 12 / 16 mm  
Stechtiefe t max. 6 / 10 mm  
Nutbreite bis 3.0 / 4.0 mm

D min. 12 / 16 mm  
depth of groove t max. 6 / 10 mm  
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Beispielzeichnung  
exemplary application

Rechts (R): wie gezeichnet  
Links (L): spiegelbildlich

righthand (R): as shown  
lefthand version (L): mirror image

Abmessungen in mm

dimensions in mm



| Bestellnummer<br>part number |        |          |       |     |      |    |        |        |      |       |      | Klemmhalter Typ<br>toolholder type |
|------------------------------|--------|----------|-------|-----|------|----|--------|--------|------|-------|------|------------------------------------|
|                              | b+0.03 | b (inch) | f     | R   | S    | d  | t max. | D min. | K10F | AL41F | P04C |                                    |
| ↙ ↘                          |        |          |       |     |      |    |        |        |      |       |      |                                    |
| R/L S014.U223.52             | 2.39   | 0.094"   | 8.39  | 0.2 | 10.3 | 9  | 5.0    | 12     |      | ●     |      | 614...<br>614.A...                 |
| R/L S014.1225.51             | 2.5    |          | 8.50  | 0.1 | 10.3 | 9  | 5.0    | 12     |      |       | ●    |                                    |
| R/L S014.1225.52             | 2.5    |          | 8.50  | 0.2 | 10.3 | 9  | 5.0    | 12     |      | ●     |      |                                    |
| R/L S014.1230.52             | 3.0    |          | 9.00  | 0.2 | 10.3 | 9  | 5.0    | 12     | ●    | ●     |      |                                    |
| R/- S014.1230.61             | 3.0    |          | 9.00  | 0.1 | 11.3 | 9  | 6.0    | 12     |      |       | ●    |                                    |
| R/- S014.1230.62             | 3.0    |          | 9.00  | 0.2 | 11.3 | 9  | 6.0    | 12     |      | ●     |      |                                    |
| R/L S018.1630.02             | 3.0    |          | 11.00 | 0.2 | 15.8 | 11 | 10     | 16     |      | ●     |      | 618...<br>618.A...                 |
| R/L S018.1640.02             | 4.0    |          | 12.00 | 0.2 | 15.8 | 11 | 10     | 16     |      | ●     |      |                                    |

Weitere HM Sorten können Sie in der Sorten-  
übersicht im Kapitel "Technische Hinweise" und  
der Preisliste finden.

Bestellbeispiel:  
für rechte Ausführung und Sorte  
RS014.U223.52/AL41F

More carbide grades you can find in the grades  
summary in the chapter "technical instructions"  
and in the price list.

order-example:  
righthand version and grade  
RS014.U223.52/AL41F

# MINICUT

## Bohrungsbearbeitung

grooving, boring and profiling

## Technische Hinweise

Schnittdatenempfehlung:  
metrisch

Schnittgeschwindigkeit:  $V_c$  (m/min)  
Vorschub:  $f$  (mm/U)

Technical instructions,  
speed and feed recommendation:  
metric

cutting speed:  
feed:  $V_c$  (m/min)  
 $f$  (mm/rev)



| Werkstoffgruppe<br>material group                                                                  |                                                               | Zusammensetzung<br>composition                          |                                             | (Zug-)Festigkeit<br>tensile strength        |                                 |
|----------------------------------------------------------------------------------------------------|---------------------------------------------------------------|---------------------------------------------------------|---------------------------------------------|---------------------------------------------|---------------------------------|
| ISO                                                                                                | Beschreibung / description                                    | Gefüge / structure                                      | Wärmebehandlung / heat treatment            | Psi / N/mm² (Rm) / HB / HRC                 |                                 |
| P                                                                                                  | Unlegierter Stahl<br>unalloyed steel                          | ca.lapp. 0,15 % C                                       | geglüht / annealed                          | 61000 Psi / 420 N/mm² / 125 HB              |                                 |
|                                                                                                    |                                                               | ca.lapp. 0,45 % C                                       | geglüht / annealed                          | 93000 Psi / 640 N/mm² / 190 HB              |                                 |
|                                                                                                    |                                                               |                                                         | vergütet / tempered                         | 122000 Psi / 840 N/mm² / 250 HB             |                                 |
|                                                                                                    |                                                               | ca.lapp. 0,75 % C                                       | geglüht / annealed                          | 132000 Psi / 910 N/mm² / 270 HB             |                                 |
|                                                                                                    | Niedriglegierter Stahl<br>low alloyed steel                   |                                                         | vergütet / tempered                         | 146500 Psi / 1010 N/mm² / 300 HB            |                                 |
|                                                                                                    |                                                               |                                                         | geglüht / annealed                          | 88500 Psi / 610 N/mm² / 180 HB              |                                 |
|                                                                                                    |                                                               |                                                         | vergütet / tempered                         | 135000 Psi / 930 N/mm² / 275 HB             |                                 |
|                                                                                                    |                                                               |                                                         | vergütet / tempered                         | 146500 Psi / 1010 N/mm² / 300 HB            |                                 |
|                                                                                                    | Hochlegierter (Werkzeug)-Stahl<br>highly alloyed steel        |                                                         | vergütet / tempered                         | 174000 Psi / 1200 N/mm² / 375 HB            |                                 |
|                                                                                                    |                                                               |                                                         | geglüht / annealed                          | 99000 Psi / 680 N/mm² / 200 HB              |                                 |
|                                                                                                    |                                                               |                                                         | gehärtet & angelassen / hardened & tempered | 160000 Psi / 1100 N/mm² / 300 HB            |                                 |
|                                                                                                    |                                                               |                                                         | gehärtet & angelassen / hardened & tempered | 189000 Psi / 1300 N/mm² / 400 HB            |                                 |
| Nichtrostender Stahl<br>stainless steel                                                            | ferritisch, martensitisch / ferritic, martensitic             | geglüht / annealed                                      | 99000 Psi / 680 N/mm² / 200 HB              |                                             |                                 |
|                                                                                                    | martensitisch / martensitic                                   | vergütet / tempered                                     | 117500 Psi / 810 N/mm² / 250 HB             |                                             |                                 |
|                                                                                                    | M                                                             | Nichtrostender Stahl<br>stainless steel                 | austenitisch / austenitic                   | abgeschreckt / quenched                     | 88500 Psi / 610 N/mm² / 200 HB  |
|                                                                                                    |                                                               |                                                         | austenitisch / austenitic                   | vergütet / tempered                         | 300 HB                          |
| austenitisch, ferritisch / ferritic, martensitic (Duplex)                                          |                                                               |                                                         |                                             | 113000 Psi / 780 N/mm² / 230 HB             |                                 |
| K                                                                                                  | Grauguss<br>cast iron                                         | perlitisch, ferritisch / pearlitic, ferritic            |                                             | 51000 Psi / 350 N/mm² / 180 HB              |                                 |
|                                                                                                    |                                                               | perlitisch (martensitisch) / pearlitic (martensitic)    |                                             | 72500 Psi / 500 N/mm² / 260 HB              |                                 |
| K                                                                                                  | Gusseisen mit Kugelgraphit<br>cast iron with nodular graphite | ferritisch / ferritic                                   |                                             | 72500 Psi / 500 N/mm² / 160 HB              |                                 |
|                                                                                                    |                                                               | perlitisch / pearlitic                                  |                                             | 122500 Psi / 845 N/mm² / 250 HB             |                                 |
|                                                                                                    |                                                               | ferritisch / ferritic                                   |                                             | 63800 Psi / 440 N/mm² / 130 HB              |                                 |
| Temperguss<br>malleable iron                                                                       |                                                               | perlitisch / pearlitic                                  |                                             | 113000 Psi / 780 N/mm² / 230 HB             |                                 |
|                                                                                                    |                                                               |                                                         |                                             | 60 HB                                       |                                 |
|                                                                                                    | N                                                             | Aluminium - Knetlegierungen<br>wrought aluminum alloys  | nicht aushärtbar / uncurable                |                                             | 60 HB                           |
| aushärtbar / curable                                                                               |                                                               |                                                         | ausgehärtet / cured                         | 49000 Psi / 340 N/mm² / 100 HB              |                                 |
| Aluminium - Gusslegierungen<br>cast aluminum alloys                                                |                                                               | ≤ 12% Si, nicht aushärtbar / uncurable                  |                                             | 36250 Psi / 250 N/mm² / 75 HB               |                                 |
|                                                                                                    |                                                               | ≤ 12% Si, aushärtbar / curable                          | ausgehärtet / cured                         | 43500 Psi / 300 N/mm² / 90 HB               |                                 |
|                                                                                                    |                                                               | > 12% Si, nicht aushärtbar / uncurable                  |                                             | 63800 Psi / 440 N/mm² / 130 HB              |                                 |
| Kupfer und Kupferlegierungen<br>(Bronze / Messing)<br>copper and copper alloys<br>(bronze / brass) |                                                               | PB > 1 %, Automatenlegierungen / free cutting alloys    |                                             | 54500 Psi / 375 N/mm² / 110 HB              |                                 |
|                                                                                                    |                                                               | CuZn, CuSnZn                                            |                                             | 43500 Psi / 300 N/mm² / 90 HB               |                                 |
|                                                                                                    | CuSn, bleifrei & Elektrolytisch / lead free & electrolytic    |                                                         | 49000 Psi / 340 N/mm² / 100 HB              |                                             |                                 |
| S                                                                                                  | Magnesium &-Legierungen/Mg-alloys                             | Magnesium und -Legierungen / and -alloys                |                                             | 70 HB                                       |                                 |
|                                                                                                    |                                                               | Warmfeste Legierungen<br>heat-resistant alloys          | Fe-Basis / Fe base                          | geglüht / annealed                          | 99000 Psi / 680 N/mm² / 200 HB  |
|                                                                                                    |                                                               |                                                         |                                             | ausgehärtet / cured                         | 137750 Psi / 950 N/mm² / 280 HB |
|                                                                                                    |                                                               |                                                         | Ni- oder Co-Basis / Ni- or Co-Base          | geglüht / annealed                          | 122000 Psi / 840 N/mm² / 250 HB |
|                                                                                                    |                                                               |                                                         | ausgehärtet / cured                         | 171000 Psi / 1180 N/mm² / 350 HB            |                                 |
|                                                                                                    | Titanlegierungen<br>titanium alloys                           |                                                         | gegossen / cast                             | 156600 Psi / 1080 N/mm² / 320 HB            |                                 |
|                                                                                                    |                                                               | Reintitan / pure titanium                               |                                             | 58000 Psi / 400 N/mm²                       |                                 |
| Alpha- + Beta-Legierungen / -alloys                                                                |                                                               | ausgehärtet / cured                                     | 152250 Psi / 1050 N/mm²                     |                                             |                                 |
| H                                                                                                  |                                                               | Beta-Legierungen / -alloys                              |                                             | 203000 Psi / 1400 N/mm² / 410 HB            |                                 |
|                                                                                                    |                                                               | Gehärteter Stahl<br>hardened steel                      |                                             | gehärtet & angelassen / hardened & tempered | 46-55 HRC                       |
|                                                                                                    |                                                               |                                                         |                                             | gehärtet & angelassen / hardened & tempered | 56-60 HRC                       |
|                                                                                                    |                                                               |                                                         | gehärtet & angelassen / hardened & tempered | 61-65 HRC                                   |                                 |
|                                                                                                    |                                                               |                                                         | gehärtet & angelassen / hardened & tempered | 66-70 HRC                                   |                                 |
|                                                                                                    | Hartguss / chilled cast iron                                  |                                                         | gegossen / cast                             | 400 HB                                      |                                 |
| Gehärtetes Guss / hardened cast iron                                                               |                                                               | gehärtet & angelassen / hardened & tempered             | 55 HRC                                      |                                             |                                 |
| O                                                                                                  | Nichtmetallische Werkstoffe<br>non-metallic materials         | Kunststoffe, duroplastisch / plastics, duroplastic      |                                             | ≤ 21750 Psi / ≤ 150 N/mm²                   |                                 |
|                                                                                                    |                                                               | Kunststoffe, thermoplastisch / plastics, thermoplastic  |                                             | ≤ 14500 Psi / ≤ 100 N/mm²                   |                                 |
|                                                                                                    |                                                               | aramidfaserverstärkt / aramid fiber reinforced          |                                             | ≤ 145000 Psi / ≤ 1000 N/mm²                 |                                 |
|                                                                                                    |                                                               | glas/kohlefaserverstärkt / glas/carbon fiber reinforced |                                             | ≤ 145000 Psi / ≤ 1000 N/mm²                 |                                 |
|                                                                                                    |                                                               | Graphit / graphite                                      |                                             |                                             |                                 |

Richtige Schnittgeschwindigkeit ist in Abhängigkeit von Dimension und Anwendungssituation zu wählen.

The correct cutting speed must be selected depending on the dimension and application situation.

20 (10 - 50) bevorzugte Wahl / best choice  
20 (10 - 50) bedingt möglich / conditionally possible

20 (10 - 50)  
empfohlener Startwert  
recommended starting value  
(bevorzugter Einsatzbereich)  
(preferred application area)

Vorschub:  
feed f: [mm/U]  
[mm/rev]

Stechdrehen:  
grooving: 0.01 - 0.03 mm/U  
0.01 - 0.03 mm/rev

Ausdrehen / Kopieren:  
boring / profiling: 0.03 - 0.10 mm/U  
0.03 - 0.10 mm/rev

Axialstechen:  
face grooving: 0.02 - 0.06 mm/U  
0.02 - 0.06 mm/rev

# MINICUT

## Bohrungsbearbeitung

grooving, boring and profiling

## Technische Hinweise

Schnittdatenempfehlung:  
metrisch

Technical instructions,  
speed and feed recommendation:  
metric

Schnittgeschwindigkeit:  $V_c$  (m/min)  
Vorschub:  $f$  (mm/U)

cutting speed:  $V_c$  (m/min)  
feed:  $f$  (mm/rev)



| beispielhafte Werkstoffe<br>exemplary materials |                             |         |                              |                         | $V_c$<br>Start (min. - max.) |  |  |  |  |
|-------------------------------------------------|-----------------------------|---------|------------------------------|-------------------------|------------------------------|--|--|--|--|
| DIN                                             | DIN-Code                    | DIN     | DIN-Code                     | P04C / AL41F<br>[m/min] | CBN<br>[m/min]               |  |  |  |  |
| 1.0401                                          | C15                         | 1.1141  | Ck 15                        | 160 (100 - 260)         |                              |  |  |  |  |
| 1.1191                                          | C45E                        | 1.0718  | 9 SMnPb 28                   | 140 (80 - 230)          |                              |  |  |  |  |
| 1.1191                                          | C45E                        | 1.0535  | C 55                         | 140 (80 - 180)          |                              |  |  |  |  |
| 1.1223                                          | C60R                        | 1.0535  | C 55                         | 110 (70 - 180)          |                              |  |  |  |  |
| 1.1223                                          | C60R                        | 1.0727  | 45 S 20                      | 100 (60 - 150)          |                              |  |  |  |  |
| 1.7131                                          | 16 MnCr 5                   | 1.6587  | 17 CrNiMo6                   | 110 (70 - 180)          |                              |  |  |  |  |
| 1.7131                                          | 16 MnCr 5                   | 1.6587  | 17 CrNiMo6                   | 100 (60 - 150)          |                              |  |  |  |  |
| 1.7225                                          | 42 CrMo 4                   | 1.3505  | 100Cr6                       | 90 (50 - 140)           |                              |  |  |  |  |
| 1.7225                                          | 42 CrMo 4                   | 1.3505  | 100Cr6                       | 80 (50 - 130)           |                              |  |  |  |  |
| 1.4021                                          | X20Cr13                     | 1.4034  | X46Cr13                      | 80 (50 - 130)           |                              |  |  |  |  |
| 1.2343                                          | X 38 CrMoV 5 1              | 1.4034  | X46Cr13                      | 70 (40 - 100)           |                              |  |  |  |  |
| 1.2343                                          | X 38 CrMoV 5 1              | 1.4034  | X46Cr13                      | 50 (30 - 80)            |                              |  |  |  |  |
| 1.4016                                          | X 6 Cr 17                   | 1.2316  | X36 CrMo 16                  | 100 (60 - 160)          |                              |  |  |  |  |
| 1.4112                                          | X90CrMoV18                  | 1.2316  | X36 CrMo 16                  | 90 (50 - 140)           |                              |  |  |  |  |
| 1.4301                                          | X 5 CrNi 18 10              | 1.4571  | X2CrNiMo17-12-2              | 80 (50 - 180)           |                              |  |  |  |  |
| 1.4841                                          | X15CrNiSi25-21              | 1.4539  | X1NiCrMoCu25-20-5            | 70 (40 - 140)           |                              |  |  |  |  |
| 1.4462                                          | X2CrNiMoN22-5-3             | 1.4501  | X2CrNiMoCuWN25-7-4           | 60 (40 - 110)           |                              |  |  |  |  |
| 0.6010                                          | GG-10                       | 0.6025  | GG-25                        | 90 (50 - 230)           |                              |  |  |  |  |
| 0.6030                                          | GG-30                       | 0.6045  | GG-45                        | 100 (50 - 160)          |                              |  |  |  |  |
| 0.7040                                          | GGG-40                      | 0.7060  | GGG-60                       | 80 (50 - 150)           |                              |  |  |  |  |
| 0.7070                                          | GGG-70                      | 0.7080  | GGG-80                       | 70 (40 - 130)           |                              |  |  |  |  |
| 0.8035                                          | GTW-35-04                   | 0.8045  | GTW-45                       | 120 (70 - 230)          |                              |  |  |  |  |
| 0.8165                                          | GTS-65-02                   | 0.8170  | GTS-70-02                    | 100 (60 - 190)          |                              |  |  |  |  |
| 3.0255                                          | Al99,5                      | 3.3315  | AlMg 1                       | 290 (180 - 540)         |                              |  |  |  |  |
| 3.1355                                          | AlCuMg2                     | 3.2315  | AlMgSi1                      | 280 (170 - 510)         |                              |  |  |  |  |
| 3.2581                                          | G-AlSi12                    | 3.2163  | G-AlSi9Cu3                   | 240 (140 - 440)         |                              |  |  |  |  |
| 3.2134                                          | G-AlSi5Cu1Mg                | 3.2373  | G-AlSi9Mg                    | 200 (120 - 380)         |                              |  |  |  |  |
| -                                               | G-AlSi17Cu4Mg (Silafont-90) | -       | G-AlSi18CuNiMg (Silafont-92) | 120 (70 - 230)          |                              |  |  |  |  |
| 2.0380                                          | CuZn39Pb2 (Ms58)            | 2.0410  | CuZn44Pb2                    | 210 (130 - 390)         |                              |  |  |  |  |
| 2.0331                                          | CuZn15                      | 2.4070  | CuZn28Sn1As                  | 180 (110 - 330)         |                              |  |  |  |  |
| 2.0060                                          | E-Cu57                      | 2.0590  | CuZn40Fe                     | 130 (90 - 290)          |                              |  |  |  |  |
| 3.5612                                          | MgAl6Zn                     | 3.5312  | MgAl3Zn                      | 100 (70 - 290)          |                              |  |  |  |  |
| 1.4864                                          | X12NiCrSi 36-16             | 1.4865  | G-X40NiCrSi38-18             | 50 (30 - 100)           |                              |  |  |  |  |
| 1.4980                                          | X6NiCrTiMoVB25-15-2         | 1.4876  | X10NiCrAlTi32-20             | 30 (20 - 70)            | 30 (10 - 70)                 |  |  |  |  |
| 2.4631                                          | NiCr20TiAl (Nimonic 80A)    | 2.4856  | NiCr22Mo9Nb (Inconel 625)    | 50 (30 - 100)           | 50 (20 - 100)                |  |  |  |  |
| 2.4668                                          | NiCr19Nb5Mo3 (Inconel 718)  | 2.4955  | NiFe25Cr20NbTi               | 40 (20 - 80)            | 30 (10 - 80)                 |  |  |  |  |
| 2.4765                                          | CoCr20W15Ni                 | 1.3401  | G-X120Mn12                   | 30 (20 - 60)            | 30 (10 - 60)                 |  |  |  |  |
| 3.7025                                          | Ti99,8                      | 3.7035  | Ti99,7                       | 50 (30 - 100)           |                              |  |  |  |  |
| 3.7164                                          | TiAl6V4                     | Ti-6246 | Ti-6Al-2Sn-4Zr-6Mo           | 40 (20 - 60)            |                              |  |  |  |  |
| Ti5553                                          | Ti-5Al-5V-5Mo-3Cr           | Ti-1023 | Ti-10V-2Fe-3Al               | 30 (20 - 50)            | 20 (10 - 50)                 |  |  |  |  |
|                                                 |                             |         |                              | 50 (30 - 90)            | 40 (10 - 90)                 |  |  |  |  |
|                                                 |                             |         |                              | 40 (20 - 80)            | 30 (10 - 80)                 |  |  |  |  |
|                                                 |                             |         |                              |                         | 30 (10 - 60)                 |  |  |  |  |
|                                                 |                             |         |                              |                         |                              |  |  |  |  |
|                                                 |                             |         |                              | 40 (20 - 60)            | 30 (10 - 60)                 |  |  |  |  |
|                                                 |                             |         |                              | 150 (90 - 260)          |                              |  |  |  |  |
|                                                 |                             |         |                              | 150 (90 - 290)          |                              |  |  |  |  |
|                                                 |                             |         |                              | 130 (80 - 240)          |                              |  |  |  |  |
|                                                 |                             |         |                              | 100 (60 - 180)          |                              |  |  |  |  |
|                                                 |                             |         |                              | 150 (90 - 280)          |                              |  |  |  |  |





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