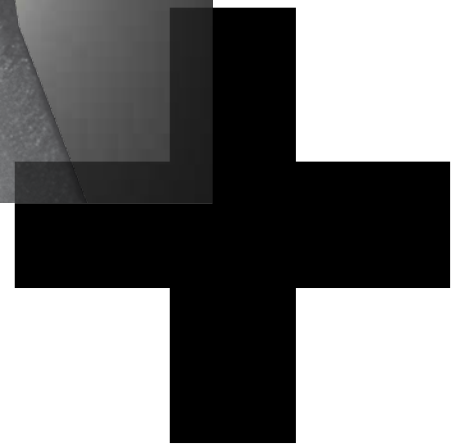


# KomPass TURNING






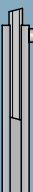

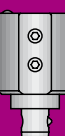
## KomPass Turning – BENEFITS for you



### **KOMET GROUP – Competence in TURNING**

Innovative solutions and tooling concepts for bore machining make the KOMET GROUP a worldwide market leader. Our developments for drilling, reaming, milling and turning make a significant contribution to our customers' success.

A pioneering spirit, a decade of experience and the constant research for innovative solutions can be clearly seen in our comprehensive programme of tools for both internal and external machining. Easy handling and the highest quality standards form the basis for optimal machining results.

	<p><b>Internal machining</b> Tools with indexable inserts</p>	8 – 22	<p>1</p> 
	<p><b>Internal machining</b> HSS and solid carbide tools UniTurn®</p>	23 – 45	<p>2</p> 
	<p><b>External machining</b> Tools with indexable inserts</p>	46 – 51	<p>3</p> 
	<p><b>External machining</b> HSS and solid carbide tools</p>	52 – 55	<p>4</p> 
	<p><b>Indexable inserts</b></p>	56 – 99	<p>5</p> 
	<p><b>Adaptors</b></p>	100 – 119	<p>6</p> 

# Programme summary indexable inserts tools

## 1 Internal machining

**Boring bar / turning tool**

W01/W29 92°		<ul style="list-style-type: none"> <li>∅ 6</li> <li>∅ 8</li> <li>∅ 10</li> </ul>	▶ 8 – 9
W01/W29 93°		<ul style="list-style-type: none"> <li>∅ 12</li> <li>∅ 16</li> <li>∅ 20</li> <li>∅ 25</li> <li>∅ 32</li> </ul>	▶ 10 – 11
W60/W79 93°		<ul style="list-style-type: none"> <li>∅ 10</li> <li>∅ 12</li> <li>∅ 16</li> <li>∅ 20</li> <li>∅ 25</li> <li>∅ 32</li> </ul>	▶ 12 – 13
W60/W79 107°30'		<ul style="list-style-type: none"> <li>∅ 10</li> <li>∅ 12</li> <li>∅ 16</li> <li>∅ 20</li> <li>∅ 25</li> <li>∅ 32</li> </ul>	▶ 14 – 15
W30/W57 92°		<ul style="list-style-type: none"> <li>∅ 8</li> <li>∅ 10</li> <li>∅ 12</li> <li>∅ 15</li> <li>∅ 16</li> <li>∅ 18</li> <li>∅ 20</li> </ul>	▶ 16 – 17
W30/W57 100°		<ul style="list-style-type: none"> <li>∅ 8</li> <li>∅ 10</li> <li>∅ 12</li> <li>∅ 16</li> <li>∅ 20</li> </ul>	▶ 18 – 19
W30/W57 90°		<ul style="list-style-type: none"> <li>∅ 8</li> <li>∅ 16</li> </ul>	▶ 20 – 21
W01/W29 91°		<ul style="list-style-type: none"> <li>∅ 16</li> <li>∅ 20</li> <li>∅ 25</li> <li>∅ 32</li> <li>∅ 40</li> </ul>	▶ 22

## 3 External machining

**Turning tool**

▶ 46 – 48	▶ 49	▶ 50	▶ 51

## 6 Adaptors with KomLoc® HSK clamping system

<p><b>Adaptor flange</b> ▶ 110</p> <p>HSK 50</p>	<p><b>Built-in flange</b> ▶ 112</p> <p>HSK 32 HSK 40 HSK 50 HSK 63</p>	<p><b>Short flange</b> ▶ 114</p> <p>HSK 50 HSK 63</p>
<p><b>VDI Adaptor DIN 69880</b> ▶ 117 – 119</p> <p>HSK 50 HSK 63</p> <p>NC 40 NC 50</p> <p>straight and angled</p>	<p><b>Round shank adaptor</b> ▶ 116</p> <p>HSK 50 HSK 63</p>	

## 6 Adaptors

**Adaptor**  
▶ 102 – 103

<ul style="list-style-type: none"> <li>∅ 8</li> <li>∅ 10</li> <li>∅ 12</li> <li>∅ 16</li> <li>∅ 20</li> <li>∅ 25</li> <li>∅ 32</li> </ul>		▶ ABS 50
<ul style="list-style-type: none"> <li>∅ 10</li> <li>∅ 12</li> <li>∅ 16</li> <li>∅ 20</li> <li>∅ 25</li> <li>∅ 32</li> </ul>		▶ HSK-A 63

**VDI Adaptor DIN 69880**  
NC..10 ▶ 105

<ul style="list-style-type: none"> <li>ABS-N 40</li> <li>ABS-N 50</li> <li>ABS-N 63</li> <li>ABS-N 80</li> <li>ABS-N 100</li> </ul>		<ul style="list-style-type: none"> <li>NC 30</li> <li>NC 40</li> <li>NC 50</li> <li>NC 60</li> </ul>
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NC..20 ▶ 106

<ul style="list-style-type: none"> <li>ABS-N 50</li> <li>ABS-N 63</li> <li>ABS-N 80</li> <li>ABS-N 100</li> </ul>		<ul style="list-style-type: none"> <li>NC 30</li> <li>NC 40</li> <li>NC 50</li> <li>NC 60</li> </ul>
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**VDI Torsional damper**  
NC..20 ▶ 107

<ul style="list-style-type: none"> <li>ABS 50</li> <li>ABS 63</li> <li>ABS 80</li> </ul>		<ul style="list-style-type: none"> <li>NC 40</li> <li>NC 50</li> </ul>
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**Adaptor**  
▶ 104

<ul style="list-style-type: none"> <li>∅ 12</li> <li>∅ 16</li> <li>∅ 20</li> <li>∅ 25</li> <li>∅ 32</li> </ul>		<ul style="list-style-type: none"> <li>ABS-N 40</li> <li>ABS-N 50</li> <li>ABS-N 63</li> <li>ABS-N 80</li> <li>ABS-N 100</li> </ul>
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**TC Adaptor**  
▶ 108

<ul style="list-style-type: none"> <li>ABS-N 50</li> <li>ABS-N 63</li> <li>ABS-N 80</li> <li>ABS-N 100</li> </ul>		<ul style="list-style-type: none"> <li>TC 40</li> <li>TC 50</li> <li>TC 60</li> <li>TC 80</li> </ul>
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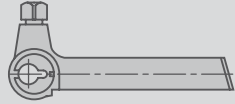


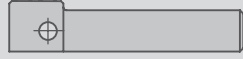








**Key**

- ▶ ABS® connection
- ▶ ABS® N connection
- ▶ cylindrical connection

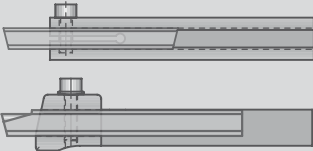
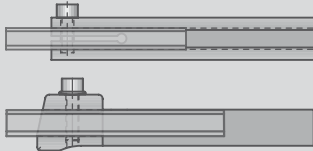
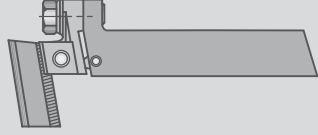
**Eccentric reducer**  
▶ 109



<ul style="list-style-type: none"> <li>ABS-N 50</li> </ul>		▶ ABS-N 80
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## 2 Internal machining

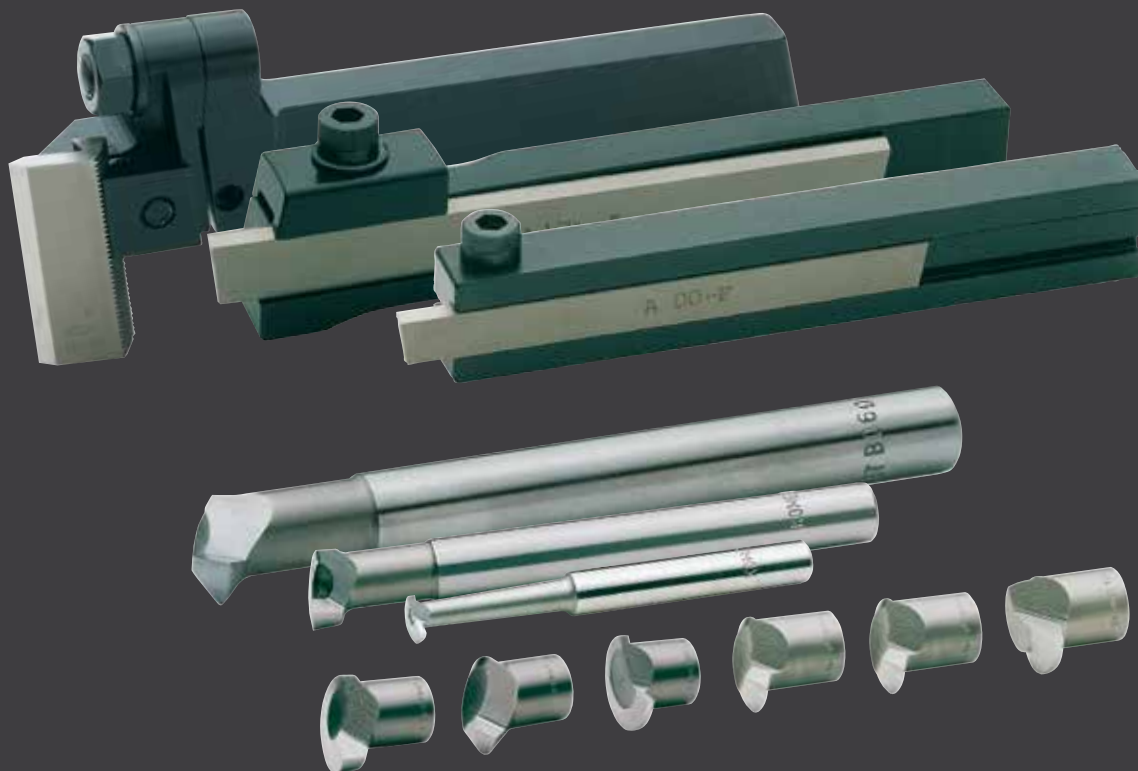
<p><b>UniTurn®</b> Clamping holder and adaptor ▶ 34</p> 					1 	
<p>Copying tool Ø 3 – 8 mm ▶ 35</p> 	<p>Recessing tool Ø 3 – 8 mm ▶ 38</p> 	<p>Threading tool Ø 5 – 8 mm ▶ 40</p> 	<p>Boring tool Ø 3 – 8 mm ▶ 36</p> 	<p>Boring tool with CBN Ø 2,7 – 7,5 mm ▶ 37</p> 		
<p>Boring tool Ø 0,5 – 2 mm ▶ 24</p> 					2 	
<p>Boring tool Form F / G Ø 2,5 – 14 mm ▶ 25 – 26</p> 	<p>Recessing tool Form H Ø 3 – 14 mm ▶ 27</p> 	<p>Threading tool 60° Ø 3 – 14 mm ▶ 28</p> 	<p>Threading tool 55° Ø 7 – 14 mm ▶ 29</p> 	<p>Boring toolholder ▶ 23</p> 		3 
						
						4 
<p>Boring tool Form F / G Ø 16 – 30 mm ▶ 30</p> 	<p>Recessing tool Form H Ø 16 – 30 mm ▶ 30</p> 	<p>Threading tool 60° / 55° Ø 16 – 30 mm ▶ 31</p> 	<p>Threading tool acme thread Ø 16 – 30 mm ▶ 31</p> 	<p>Boring toolholder and boring bar ▶ 30</p> 	5 	
						

## 4 External machining

<p><b>Parting-off</b> ▶ 52</p> 	<p><b>Grooving</b> ▶ 53</p> 	<p><b>Threading</b> ▶ 54</p> 
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		6 
		7 

## KOMET® Turning tools for external and internal machining



KOMET® turning tools are extremely versatile.

Not only can our turning tools be used for conventional lathes, turret lathes, automatic lathes and custom machines, they can also be used for boring heads and milling machines.

They are equally at home with both external and internal machining.

Their simple design, combined with ultimate precision, falls into line with KOMET®'s noted tradition of excellence – qualities which have been much sought-after for decades across the globe.

Satisfaction across generations of customers.

### KOMET UniTurn®

The main characteristic of the KOMET UniTurn® turning programme is the extremely rigid connection between the turning tool and the clamping holder. An eccentric clamping device in the holder guarantees that tool change times are extremely short and the cutting edge is very accurately positioned.

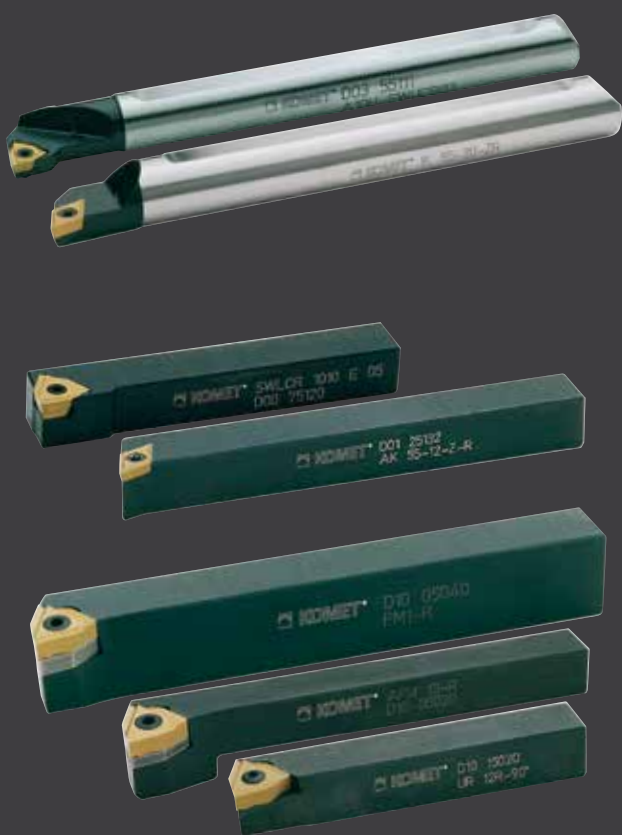
The flat insertion surface on the shaft of the turning tool ensures a correctly insert in the right position.

Two coolant slots located axially in the holder provide the best possible supply of coolant onto the cutting edge both for right-hand and left-hand boring bars. This prevents any weakening of the boring bar caused by notching.



## Indexable inserts tools

1 Internal machining	Page
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## HSS and solid carbide tools

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### KOMET SERVICE® – Chapter 7

A network of local partners that provide professional tool refurbishment, trade tools and manufacture customized solid carbide special tools | [www.komet-service.com](http://www.komet-service.com)



1



2



3



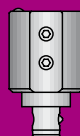
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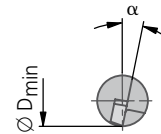
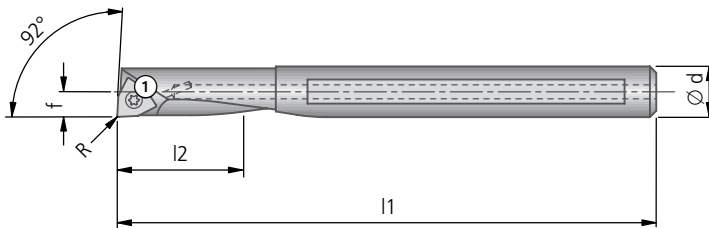
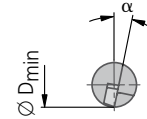
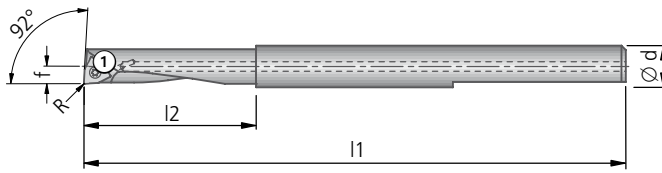


# KOMET® – Internal machining

## Boring bar $\kappa = 92^\circ$

- for insert W00, W01 / W29
- R.H. boring bar as shown with left or neutral insert
- L.H. boring bar in mirror image with right or neutral insert

B00 30280  
B00 30290



$\kappa = 92^\circ$											Insert		
D min	Order No.	Cutting form	d	l1	Working length l2	f	for R	Orientation angle $\alpha$	kg	Clamping screw ① Order No. Article	W00   W01 L.H.	W00   W01 R.H.	W29 neutral
5,6	B00 30280	R.H.	6	65	22		0,1	10°17'		N00 56011 S/M1,8x2,9-5IP 0,38 Nm	W00 04...		
6,9	B00 30290	R.H.	6	80	24		0,1	10°17'		N00 56011 S/M1,8x2,9-5IP 0,38 Nm	W00 04...		
5,6	B00 30300	L.H.	6	60	15	2,80	0,1	10°15'	0,03	N00 56011 S/M1,8x2,9-5IP 0,38 Nm		W00 04...	
	B00 35300	R.H.									W00 04...		
6,9	B00 30311	L.H.	8	70	20	3,45	0,2	15°	0,06	N00 56041 S/M2x4,3-6IP 0,62 Nm		W01 10...	W29 10...
	B00 35311	R.H.									W01 10...		
7,9	B00 30321	L.H.	8	85	25	3,95	0,2	11°30'	0,06	N00 56041 S/M2x4,3-6IP 0,62 Nm		W01 10...	W29 10...
	B00 35321	R.H.									W01 10...		
9,9	B00 30331	L.H.	10	95	30	4,95	0,2	8°	0,08	N00 56041 S/M2x4,3-6IP 0,62 Nm		W01 10...	W29 10...
	B00 35331	R.H.									W01 10...		

For further details on inserts see chapter 5.

**Supply includes:** Boring bar with clamping screw ①.

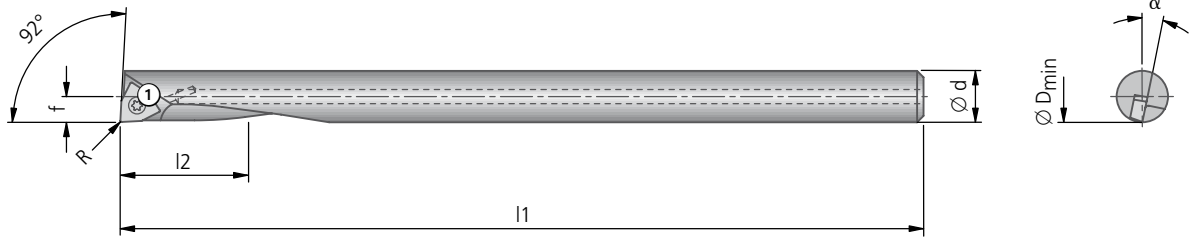
Please order insert separately. Screwdriver see chapter 7.



# KOMET® – Internal machining

## Boring bar $\alpha = 92^\circ$ for fine machining only

- carbide or heavy-duty metal (5,6 mm dia. and 6,9 mm dia.) ■
- for insert W00, W01 / W29 ■
- R.H. boring bar as shown with left or neutral insert ■
- L.H. boring bar in mirror image with right or neutral insert ■



$\alpha = 92^\circ$										Insert			
$\emptyset D$ min	Order No.	Cutting form	$\emptyset d$	$l_1$	Working length $l_2$	$f$	for R	Orientation angle $\alpha$		Clamping screw ①  Order No. Article	W00   W01 L.H.  Size▼▼	W00   W01 R.H.  Size▼▼	W29 neutral  Size▼▼
5,6	B00 35400	R.H.	6	100	50	2,80	0,1	10°15'	0,06	N00 56011 S/M1,8x2,9-5IP 0,38 Nm	W00 04...		
6,9	B00 30411	L.H.	8	125	60	3,45	0,2	15°	0,11	N00 56041		W01 10...	W29 10...
	B00 35411	R.H.								S/M2x4,3-6IP 0,62 Nm	W01 10...		
7,9	B00 30421	L.H.	8	125	-	4,30	0,2	11°30'	0,11	N00 56041		W01 10...	W29 10...
	B00 35421	R.H.								S/M2x4,3-6IP 0,62 Nm	W01 10...		
9,9	B00 30431	L.H.	10	150	-	5,30	0,2	8°	0,19	N00 56041		W01 10...	W29 10...
	B00 35431	R.H.								S/M2x4,3-6IP 0,62 Nm	W01 10...		

For further details on inserts see chapter 5.

**Supply includes:** Boring bar with clamping screw ①.

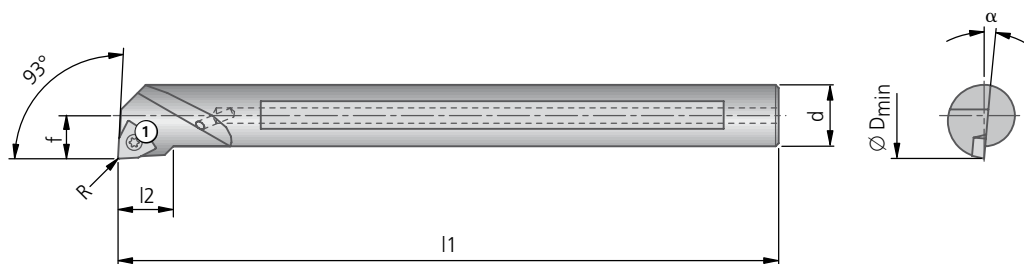
Please order insert separately. Screwdriver see chapter 7.



# KOMET® – Internal machining

## Turning tool $\alpha = 93^\circ$

- for insert W01 / W29
- R.H. turning tool as shown with left or neutral insert
- L.H. turning tool in mirror image with right or neutral insert



$\alpha = 93^\circ$										Insert		
$\varnothing D_{min}$	Order No. Article	Cutting form	$\varnothing d$	$l_1$	$l_2$	$f$	for R	Orien- tation angle $\alpha$	Clamping screw ①  Order No. Article	W01 L.H.	W01 R.H.	W01   W29 neutral
										 Size ▼▼	 Size ▼▼	 Size ▼▼
16	D03 50120 A12K-SWUCL-05	L.H.	12	125	14	9	0,4	7°	0,14 S/M2,5x7,2-8IP 1,28 Nm		W01 24...	W01 24... W29 24...
	D03 55120 A12K-SWUCR-05	R.H.								W01 24...		
20	D03 50130 A16M-SWUCL-05	L.H.	16	150	14	11	0,4	5°30'	0,25 S/M2,5x7,2-8IP 1,28 Nm		W01 24...	W01 24... W29 24...
	D03 55130 A16M-SWUCR-05	R.H.								W01 24...		
25	D03 50140 A20Q-SWUCL-06	L.H.	20	180	18	13	0,4	4°	0,46 S/M3,5x7,3-10IP 2,8 Nm		W01 34...	W01 34... W29 34...
	D03 55140 A20Q-SWUCR-06	R.H.								W01 34...		
32	D03 50150 A25R-SWUCL-06	L.H.	25	200	18	17	0,4	2°	0,76 S/M3,5x7,3-10IP 2,8 Nm		W01 34...	W01 34... W29 34...
	D03 55150 A25R-SWUCR-06	R.H.								W01 34...		
40	D03 50160 A32S-SWUCL-07	L.H.	32	250	25	22	0,4	1°30'	1,53 S/M3,5x7,3-10IP 2,8 Nm		W01 42...	W01 42... W29 42...
	D03 55160 A32S-SWUCR-07	R.H.								W01 42...		

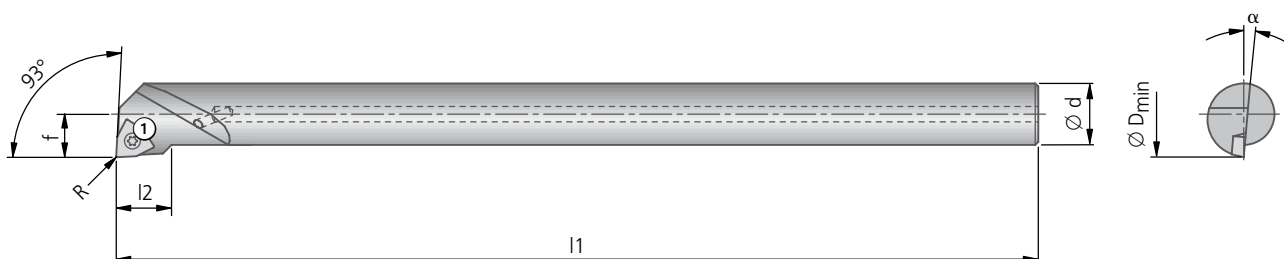
For further details on inserts see chapter 5.

**Supply includes:** Turning tool with clamping screw ①.  
Please order insert separately. Screwdriver see chapter 7.

# KOMET® – Internal machining

## Turning tool $\alpha = 93^\circ$ for fine machining only

- carbide metal ■
- for insert W01 / W29 ■
- R.H. turning tool as shown with left or neutral insert ■
- L.H. turning tool in mirror image with right or neutral insert ■



$\alpha = 93^\circ$										Insert		
$\varnothing D$ min	Order No. Article	Cutting form	$\varnothing d$	l1	l2	f	for R	Orien- tation angle $\alpha$	Clamping screw ① 	Order No. Article	W01 R.H. 	W01   W29 neutral 
											Size ▼▼	Size ▼▼
20	D03 50030 E16R-SWUCL-05	L.H.	16	200	14	11	0,4	5°30'	0,56	N00 57511 S/M2,5x7,2-8IP 1,28 Nm	W01 24...	W01 24... W29 24...

For further details on inserts see chapter 5.

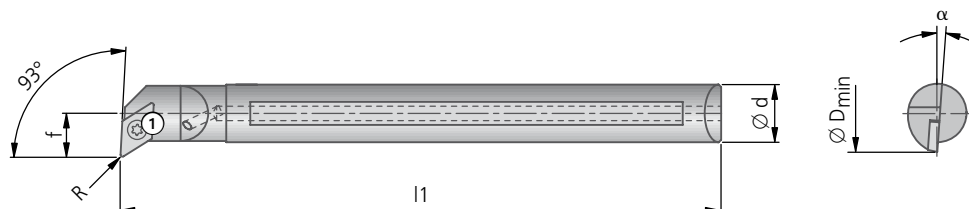
**Supply includes:** Turning tool with clamping screw ①.  
Please order insert separately. Screwdriver see chapter 7.



# KOMET® – Internal machining

## Turning tool $\kappa = 93^\circ$

- for insert W60 / W79
- R.H. turning tool as shown with left or neutral insert
- L.H. turning tool in mirror image with right or neutral insert



$\kappa = 93^\circ$									Insert			
Ø D min	Order No. Article	Cutting form	Ø d	l1	f	for R	Orientation angle $\alpha$	Clamping screw ① Order No. Article kg	W60 L.H.	W60 R.H.	W60   W79 neutral	
									Size▼	Size▼	Size▼	
13	D02 10122 IK55-10U L	L.H.	10	100	6,5	0,4	6°	0,09	N00 56651 S2560-8IP 1,28 Nm		W60 18...	W60 18... W79 18...
	D02 15122 IK55-10U R	R.H.								W60 18...		
16	D02 10133 IK55-12U L	L.H.	12	125	9	0,4	5°	0,13	N00 56651 S2560-8IP 1,28 Nm		W60 18...	W60 18... W79 18...
	D02 15133 IK55-12U R	R.H.								W60 18...		
20	D02 10143 IK55-16U L	L.H.	16	150	11	0,4	3°30'	0,25	N00 56651 S2560-8IP 1,28 Nm		W60 18...	W60 18... W79 18...
	D02 15143 IK55-16U R	R.H.								W60 18...		
25	D02 10153 IK55-20U L	L.H.	20	180	13	0,8	4°	0,49	N00 56751 S3574-10IP 2,8 Nm		W60 32...	W60 32... W79 32...
	D02 15153 IK55-20U R	R.H.								W60 32...		
32	D02 10163 IK55-25U L	L.H.	25	200	17	0,8	2°	0,78	N00 56751 S3574-10IP 2,8 Nm		W60 32...	W60 32... W79 32...
	D02 15163 IK55-25U R	R.H.								W60 32...		
40	D02 10173 IK55-32U L	L.H.	32	250	22	0,8	0°	1,51	N00 56751 S3574-10IP 2,8 Nm		W60 32...	W60 32... W79 32...
	D02 15173 IK55-32U R	R.H.								W60 32...		

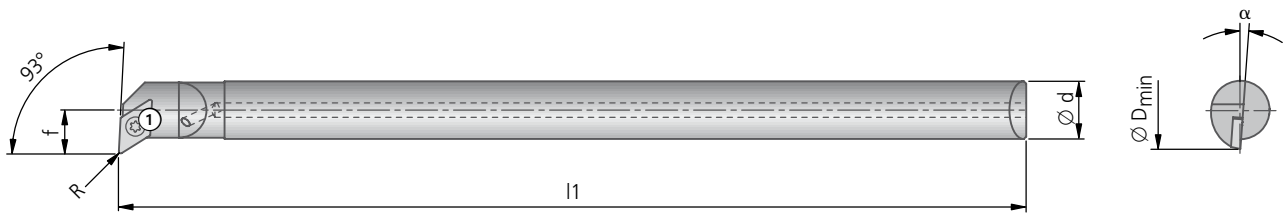
For further details on inserts see chapter 5.

**Supply includes:** Turning tool with clamping screw ①.  
Please order insert separately. Screwdriver see chapter 7.

# KOMET® – Internal machining

## Turning tool $\alpha = 93^\circ$ for fine machining only

- carbide metal ■
- for insert W60 / W79 ■
- R.H. turning tool as shown with left or neutral insert ■
- L.H. turning tool in mirror image with right or neutral insert ■



$\alpha = 93^\circ$									Insert			
Ø D min	Order No. Article	Cutting form	Ø d	l1	f	for R	Orientation angle $\alpha$	kg	Clamping screw ① Order No. Article	W60 L.H.	W60 R.H.	W60   W79 neutral
										Size ▼▼	Size ▼▼	Size ▼▼
13	D02 10571 E10M-SDUCL-07	L.H.	10	150	6,5	0,4	6°	0,19	N00 56651 S2560-8IP 1,28 Nm		W60 18...	W60 18... W79 18...
	D02 15571 E10M-SDUCR-07	R.H.								W60 18...		
16	D02 10581 E12Q-SDUCL-07	L.H.	12	180	9	0,4	5°	0,30	N00 56651 S2560-8IP 1,28 Nm		W60 18...	W60 18... W79 18...
20	D02 10591 E16R-SDUCL-07	L.H.	16	200	11	0,4	3°30'	0,55	N00 56651 S2560-8IP 1,28 Nm		W60 18...	W60 18... W79 18...
25	D02 10601 E20S-SDUCL-11	L.H.	20	250	13	0,8	4°	1,09	N00 56751 S3574-10IP 2,8 Nm		W60 32...	W60 32... W79 32...

For further details on inserts see chapter 5.

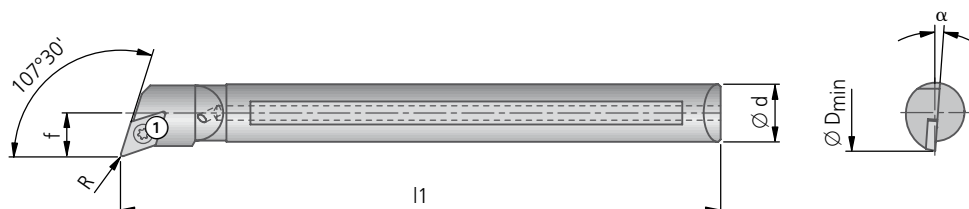
**Supply includes:** Turning tool with clamping screw ①.  
Please order insert separately. Screwdriver see chapter 7.



# KOMET® – Internal machining

## Turning tool $\alpha = 107^{\circ}30'$

- for insert W60 / W79
- R.H. turning tool as shown with left or neutral insert
- L.H. turning tool in mirror image with right or neutral insert



$\alpha = 107^{\circ}30'$									Insert			
Ø D min	Order No. Article	Cutting form	Ø d	l1	f	for R	Orien- tation angle $\alpha$	Clamping screw ① Order No. Article kg	W60 L.H.	W60 R.H.	W60   W79 neutral	
									Size▼▼	Size▼▼	Size▼▼	
13	D02 10023 IK55-10Z L	L.H.	10	100	6,5	0,4	6°	0,09	N00 56651 S2560-8IP 1,28 Nm		W60 18...	W60 18... W79 18...
	D02 15023 IK55-10Z R	R.H.								W60 18...		
16	D02 10033 IK55-12Z L	L.H.	12	125	9	0,4	5°	0,13	N00 56651 S2560-8IP 1,28 Nm		W60 18...	W60 18... W79 18...
	D02 15033 IK55-12Z R	R.H.								W60 18...		
20	D02 10043 IK55-16Z L	L.H.	16	150	11	0,4	3°30'	0,25	N00 56651 S2560-8IP 1,28 Nm		W60 18...	W60 18... W79 18...
	D02 15043 IK55-16Z R	R.H.								W60 18...		
25	D02 10053 IK55-20Z L	L.H.	20	180	13	0,8	4°	0,49	N00 56751 S3574-10IP 2,8 Nm		W60 32...	W60 32... W79 32...
	D02 15053 IK55-20Z R	R.H.								W60 32...		
32	D02 10063 IK55-25Z L	L.H.	25	200	17	0,8	2°	0,78	N00 56751 S3574-10IP 2,8 Nm		W60 32...	W60 32... W79 32...
	D02 15063 IK55-25Z R	R.H.								W60 32...		
40	D02 15073 IK55-32Z R	R.H.	32	250	22	0,8	0°	1,51	N00 56751 S3574-10IP 2,8 Nm	W60 32...		W60 32... W79 32...

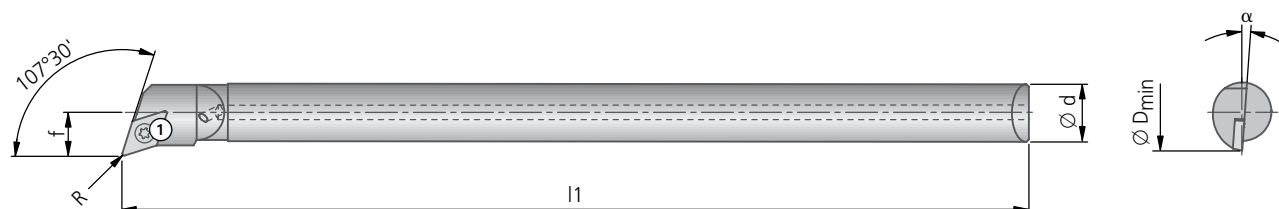
For further details on inserts see chapter 5.

**Supply includes:** Turning tool with clamping screw ①.  
Please order insert separately. Screwdriver see chapter 7.

# KOMET® – Internal machining

## Turning tool $\kappa = 107^{\circ}30'$ for fine machining only

- carbide metal ■
- for insert W60 / W79 ■
- R.H. turning tool as shown with left or neutral insert ■
- L.H. turning tool in mirror image with right or neutral insert ■



$\kappa = 107^{\circ}30'$									Insert			
$\varnothing D$ min	Order No. Article	Cutting form	$\varnothing d$	$l_1$	$f$	for R	Orien- tation angle $\alpha$	kg	Clamping screw ① Order No. Article	W60 L.H. Size ▼▼	W60 R.H. Size ▼▼	W60   W79 neutral Size ▼▼
13	D02 10671 E10M-SDQCL-07	L.H.	10	150	6,5	0,4	4°	0,19	N00 56651 S2560-8IP 1,28 Nm		W60 18...	W60 18... W79 18...
	D02 15671 E10M-SDQCR-07	R.H.								W60 18...		
16	D02 10681 E12Q-SDQCL-07	L.H.	12	180	9	0,4	5°	0,40	N00 56651 S2560-8IP 1,28 Nm		W60 18...	W60 18... W79 18...
	D02 15681 E12Q-SDQCR-07	R.H.								W60 18...		
20	D02 10691 E16R-SDQCL-07	L.H.	16	200	11	0,4	3°30'	0,80	N00 56651 S2560-8IP 1,28 Nm		W60 18...	W60 18... W79 18...
25	D02 10701 E20S-SDQCL-11	L.H.	20	250	13	0,8	4°	1,09	N00 56751 S3574-10IP 2,8 Nm		W60 32...	W60 32... W79 32...

For further details on inserts see chapter 5.

**Supply includes:** Turning tool with clamping screw ①.  
Please order insert separately. Screwdriver see chapter 7.

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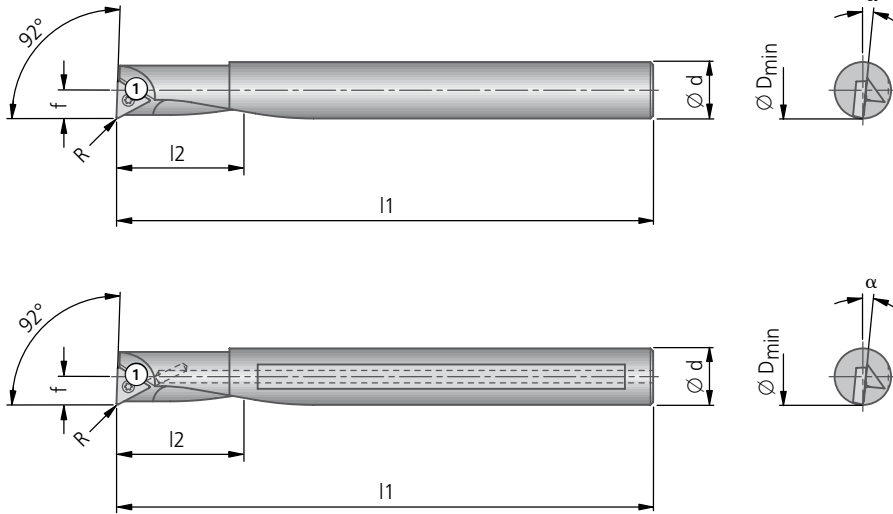
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# KOMET® – Internal machining

## Boring bar $\kappa = 92^\circ$

- for insert W30 / W57
- R.H. boring bar as shown with left or neutral insert
- L.H. boring bar in mirror image with right or neutral insert



$\kappa = 92^\circ$										Insert				
Ø D min	Order No.	Order No.	Cutting form	Ø d	l1	Working length l2	f	for R	Orientation angle $\alpha$	Clamping screw ① Order No. Article	W30 L.H.	W30 R.H.	W30   W57 neutral	
											Size ▼▼	Size ▼▼	Size ▼▼	
7,9	B00 00010	B00 00410	L.H.	8	85	15	3,95	0,2	8°30'	0,07	N00 56021 S/M2x3,8-6IP 0,62 Nm	W30 04...	W30 04...	W30 04... W57 04...
	B00 05010	B00 05410	R.H.									W30 04...		
9,9	B00 00020	B00 00420	L.H.	10	95	20	4,95	0,2	5°30'	0,08	N00 56021 S/M2x3,8-6IP 0,62 Nm	W30 04...	W30 04...	W30 04... W57 04...
	B00 05020	B00 05420	R.H.									W30 04...		
11,9	B00 00030	B00 00430	L.H.	12	110	25	5,95	0,2	7°30'	0,12	N00 56101 S/M2,6x5,2-8IP 1,28 Nm	W30 14...	W30 14...	W30 14... W57 14...
	B00 05030	B00 05430	R.H.									W30 14...		
14,9	–	B00 05440	R.H.	15	120	30	7,45	0,2	5°	0,18	N00 56101 S/M2,6x5,2-8IP 1,28 Nm	W30 14...		W30 14... W57 14...
15,9	B00 00050	B00 00450	L.H.	16	120	30	7,95	0,2	5°	0,21	N00 56101 S/M2,6x5,2-8IP 1,28 Nm	W30 14...	W30 14...	W30 14... W57 14...
	B00 05050	B00 05450	R.H.									W30 14...		
17,9	B00 05060	B00 05460	R.H.	18	150	40	8,95	0,2	5°30'	0,33	N00 56211 S/M3,5x7,3-10IP 2,8 Nm	W30 26...		W30 26... W57 26...
19,9	B00 00070	–	L.H.	20	150	40	9,95	0,2	4°30'	0,39	N00 56211 S/M3,5x7,3-10IP 2,8 Nm	W30 26...	W30 26...	W30 26... W57 26...
	B00 05070	B00 05470	R.H.									W30 26...		

For further details on inserts see chapter 5.

**Supply includes:** Boring bar with clamping screw ①.  
Please order insert separately. Screwdriver see chapter 7.



# KOMET® – Internal machining

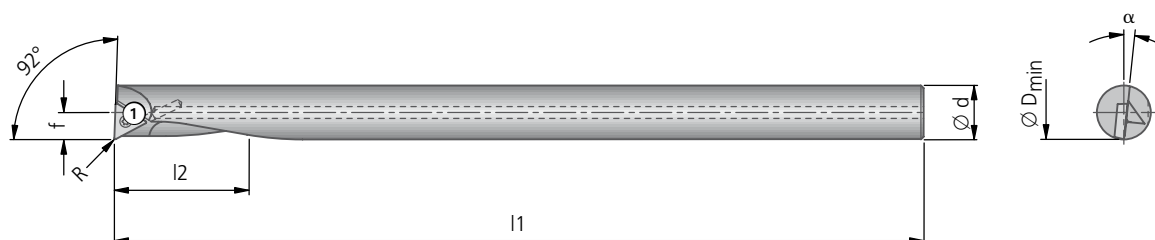
## Boring bar $\alpha = 92^\circ$ for fine machining only

carbide or heavy-duty metal (7,9 mm dia.) ■

for insert W30 / W57 ■

R.H. boring bar as shown with left or neutral insert ■

L.H. boring bar in mirror image with right or neutral insert ■



$\alpha = 92^\circ$										Insert			
Ø D min	Order No.	Cutting form	Ø d	l1	Working length l2	f	for R	Orien- tation angle $\alpha$	kg	Clamping screw ① Order No. Article	W30 L.H.	W30 R.H.	W30   W57 neutral
											Size ▼▼	Size ▼▼	Size ▼▼
7,9	B00 00600	L.H.	8	125	65	3,95	0,2	8°30'	0,11	N00 56021 S/M2x3,8-6IP 0,62 Nm	W30 04...	W30 04...	W30 04... W57 04...
	B00 05600	R.H.											
9,2	B00 00610	L.H.	8	125	-	4,60	0,2	8°12'	0,11	N00 56021 S/M2x3,8-6IP 0,62 Nm	W30 04...	W30 04...	W30 04... W57 04...
	B00 05610	R.H.											
11,2	B00 00620	L.H.	10	150	-	5,60	0,2	5°	0,19	N00 56021 S/M2x3,8-6IP 0,62 Nm	W30 04...	W30 04...	W30 04... W57 04...
	B00 05620	R.H.											
13,5	B00 00630	L.H.	12	180	-	6,75	0,2	7°30'	0,30	N00 56101 S/M2,6x5,2-8IP 1,28 Nm	W30 14...	W30 14...	W30 14... W57 14...
	B00 05630	R.H.											
16,5	B00 00640	L.H.	15	180	-	8,25	0,2	5°	0,43	N00 56101 S/M2,6x5,2-8IP 1,28 Nm	W30 14...	W30 14...	W30 14... W57 14...
	B00 05640	R.H.											
17,5	B00 00650	L.H.	16	180	-	8,75	0,2	4°	0,48	N00 56101 S/M2,6x5,2-8IP 1,28 Nm	W30 14...	W30 14...	W30 14... W57 14...
	B00 05650	R.H.											
21,7	B00 05670	R.H.	20	200	-	10,95	0,2	4°15'	0,86	N00 56211 S/M3,5x7,3-10IP 2,8 Nm	W30 26...		W30 26... W57 26...

For further details on inserts see chapter 5.

**Supply includes:** Boring bar with clamping screw ①.

Please order insert separately. Screwdriver see chapter 7.

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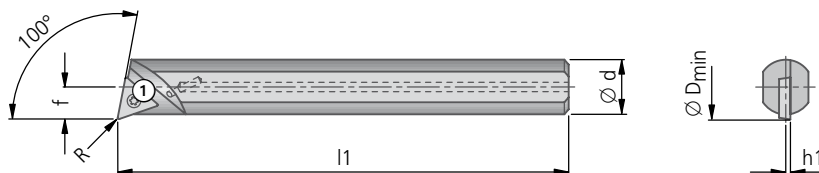
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# KOMET® – Internal machining

## Turning tool $\kappa = 100^\circ$

- for insert W30 / W57
- R.H. turning tool as shown with left or neutral insert
- L.H. turning tool in mirror image with right or neutral insert



$\kappa = 100^\circ$									Insert			
$\varnothing D_{\min}$	Order No. Article	Cutting form	$\varnothing d$	h1	l1	f	for R	Clamping screw ① Order No. Article	W30 L.H. 	W30 R.H. 	W30   W57 neutral 	
									Size▼▼	Size▼▼	Size ▼▼	
9,5	D02 20111 Z8L100U3-18	L.H.	8	0,8	100	4,70	0,3	0,06	N00 56031 S/M2x4,9-6IP 0,62 Nm		W30 04...	W30 04... W57 04...
	D02 25111 Z8R100U3-18	R.H.								W30 04...		
11,5	D02 20121 Z10L100U4-25	L.H.	10	0,8	125	5,70	0,4	0,10	N00 56101 S/M2,6x5,2-8IP 1,28 Nm		W30 14...	W30 14... W57 14...
	D02 25121 Z10R100U4-25	R.H.								W30 14...		
14,0	D02 20131 Z12L100U4-25	L.H.	12	0,8	125	6,95	0,4	0,13	N00 56101 S/M2,6x5,2-8IP 1,28 Nm		W30 14...	W30 14... W57 14...
	D02 25131 Z12R100U4-25	R.H.								W30 14...		
19,0	D02 20141 Z16L100U5-30	L.H.	16	0,8	150	9,45	0,5	0,27	N00 56201 S/M3,5x6,2-10IP 2,8 Nm		W30 26...	W30 26... W57 26...
	D02 25141 Z16R100U5-30	R.H.								W30 26...		

For further details on inserts see chapter 5.

**Supply includes:** Turning tool with clamping screw ①.  
Please order insert separately. Screwdriver see chapter 7.

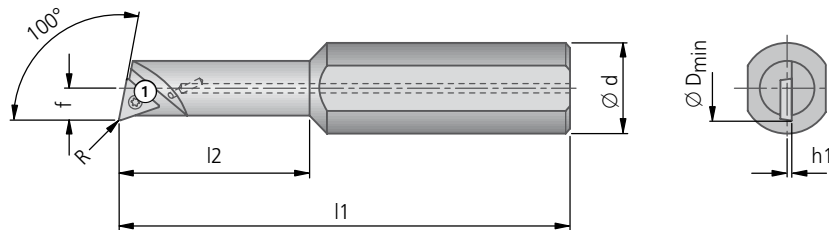
# KOMET® – Internal machining

## Turning tool $\kappa = 100^\circ$

for insert W30 / W57 ■

R.H. turning tool as shown with left or neutral insert ■

L.H. turning tool in mirror image with right or neutral insert ■



$\kappa = 100^\circ$										Insert			
Ø D min	Order No. Article	Cutting form	Ø d	h1	l1	l2	f	for R	kg	Clamping screw ① Order No. Article	W30 L.H.	W30 R.H.	W30   W57 neutral
											Size▼	Size▼	Size▼
8	D02 20001 Z20/7,5L100U3-18	L.H.	20	0,6	100	30	3,95	0,3	0,20	N00 56031 S/M2×4,9-6IP 0,62 Nm		W30 04...	W30 04...
	D02 25001 Z20/7,5R100U3-18	R.H.									W30 04...	W57 04...	
10	D02 20011 Z20/8,5L100U3-18	L.H.	20	0,8	100	35	4,95	0,3	0,20	N00 56031 S/M2×4,9-6IP 0,62 Nm		W30 04...	W30 04...
	D02 25011 Z20/8,5R100U3-18	R.H.									W30 04...	W57 04...	
12	D02 20021 Z20/10,5L100U4-25	L.H.	20	0,8	100	40	5,95	0,4	0,20	N00 56101 S/M2,6×5,2-8IP 1,28 Nm		W30 14...	W30 14...
	D02 25021 Z20/10,5R100U4-25	R.H.									W30 14...	W57 14...	
14	D02 20031 Z20/12L100U4-25	L.H.	20	0,8	105	45	6,95	0,4	0,21	N00 56101 S/M2,6×5,2-8IP 1,28 Nm		W30 14...	W30 14...
	D02 25031 Z20/12R100U4-25	R.H.									W30 14...	W57 14...	
19	D02 25041 Z20/16R100U5-30	R.H.	20	0,8	105	45	9,45	0,5	0,26	N00 56201 S/M3,5×6,2-10IP 2,8 Nm	W30 26...		W30 26... W57 26...

For further details on inserts see chapter 5.

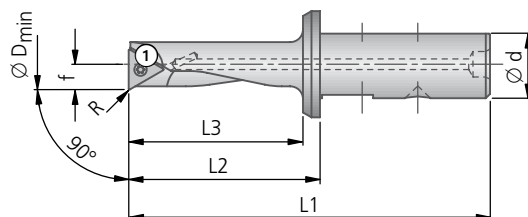
**Supply includes:** Turning tool with clamping screw ①.




Please order insert separately. Screwdriver see chapter 7.



## Boring bar $\kappa = 90^\circ$

- for insert W00, W30 / W57
- with cylindrical shank
- R.H. cutting with left or neutral insert



$\kappa = 90^\circ$									Insert			
Ø D min	Order No.	Ø d	L1	L2	L3	f	R	kg	Clamping screw ① 	W00   W30 L.H. 	W30   W57 neutral 	
									Order No. Article	Size ▼▼	Size ▼▼	
5,6	B00 37010	8	48	26	22	2,75	0,1	0,04	N00 56011 S/M1,8x2,9-5IP 0,38 Nm	W00 04...		
6,5	B00 37020	8	52	30	26	3,20	0,1	0,03				
8	B00 15510	8	57	35	28	3,95	0,2	0,02	N00 56021 S/M2x3,8-6IP 0,62 Nm	W30 04...	W30 04...	
	B00 15610	16	75	35	30	3,95	0,2	0,08			W57 04...	W57 04180.04..
10	B00 15620	16	80	40	35	4,95	0,2	0,08	N00 56101 S/M2,6x5,2-8IP 1,28 Nm	W30 14...		
11	B00 15710	16	85	45	40	5,45	0,2	0,09				
12	B00 15530	8	67	45	38	5,95	0,2	0,04				
	B00 15630	16	85	45	40	5,95	0,2	0,09				
13	B00 15720	16	90	50	45	6,45	0,2	0,10				
14	B00 15640	16	90	50	45	6,95	0,2	0,11				
15	B00 15730	16	95	55	50	7,45	0,2	0,12				
16	B00 15650	16	95	55	50	7,95	0,2	0,17				
17	B00 15741	16	100	60	55	8,45	0,2	0,13				
18	B00 15661	16	100	60	55	8,95	0,2	0,14				
19	B00 15751	16	105	65	60	9,45	0,2	0,16				
20	B00 15671	16	105	65	60	9,90	0,2	0,22				
22	B00 15681	16	105	65	60	10,9	0,2	0,19				
24	B00 15691	16	105	65	60	11,9	0,2	0,21				

For further details on inserts see chapter 5.

Further diameters on request.

**Supply includes:** Boring bar with clamping screw ①.

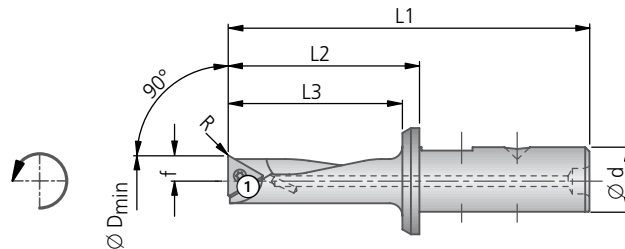
Please order insert separately. Screwdriver see chapter 7.

Ø 8 – 14 mm

# KOMET® – Internal machining

Boring bar  $\kappa = 90^\circ$

- for insert W30 / W57 ■
- with cylindrical shank ■
- L.H. cutting with right or neutral insert ■



$\kappa = 90^\circ$									Insert		
Ø D min	Order No.	Ø d	L1	L2	L3	f	R	kg	Clamping screw ①	W30 R.H.	W30   W57 neutral
									Order No. Article	Size ▼▼	Size ▼▼
8	B00 10610	16	75	35	30	3,95	0,2	0,08	N00 56021 S/M2x3,8-6IP 0,62 Nm	W30 04...	W30 04... W57 04... W57 04180.04..
10	B00 10620	16	80	40	35	4,95	0,2	0,08			
12	B00 10630	16	85	45	40	5,95	0,2	0,09	N00 56101 S/M2,6x5,2-8IP 1,28 Nm	W30 14...	W30 14... W57 14... W57 14180.04..
14	B00 10640	16	90	50	45	6,95	0,2	0,11			

For further details on inserts see chapter 5.

Further diameters on request.

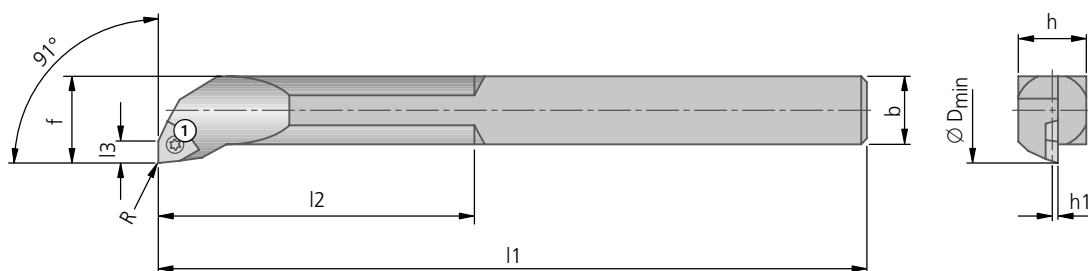
**Supply includes:** Boring bar with clamping screw ①.  
Please order insert separately. Screwdriver see chapter 7.



# KOMET® – Internal machining

## Turning tool $\kappa = 91^\circ$

- for insert W01 / W29
- R.H. turning tool as shown with left or neutral insert



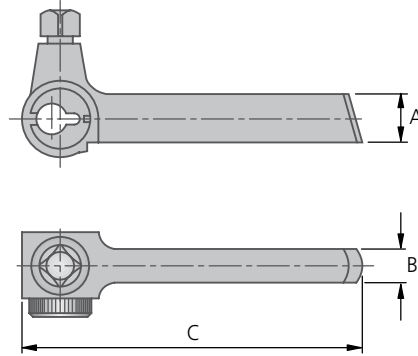
$\kappa = 91^\circ$											Insert			
$\varnothing D$ min	Order No. Article	Cutting form	b	h	h1	l1	l2	l3	f	for R	kg	Clamping screw ①  Order No. Article	W01 L.H.  Size▼▼	W01   W29 neutral  Size▼▼
25	D03 15011 UBN1-801 FR	R.H.	16	16	0,5	150	70	6,5	21	0,2	0,33	N00 57521 S/M3,5x7,3-10IP 2,8 Nm	W01 34...	W01 34... W29 34...
30	D03 15021 UBN2-810 FR	R.H.	20	20	0,5	200	100	7,5	26	0,2	0,64	N00 57531 S/M4,5x9-15IP 6,25 Nm	W01 42...	W01 42... W29 42...
40	D03 15031 UBN3-820 FR	R.H.	25	25	1,0	245	120	9,5	33	0,4	1,19	N00 57531 S/M4,5x9-15IP 6,25 Nm	W01 50...	W29 50...
50	D03 15041 UBN4-830 FR	R.H.	32	32	1,0	285	160	11,5	43	0,6	2,14	N00 57541 S/M5,5x11-20IP 6,25 Nm	W01 58...	W29 58...
65	D03 15051 UBN5-830 FR	R.H.	40	40	1,0	320	195	11,5	54	0,6	3,60	N00 57541 S/M5,5x11-20IP 6,25 Nm	W01 58...	W29 58...

For further details on inserts see chapter 5.

**Supply includes:** Turning tool with clamping screw ①.  
Please order insert separately. Screwdriver see chapter 7.

### Boring toolholder

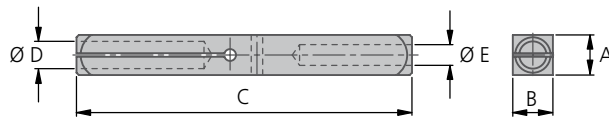
B0 – By rotating the eccentric bush, each tool can be easily brought to the required centre. The awkward and often time-consuming shimming of the toolholder is then unnecessary.



**Supply includes:** Boring toolholder B0 with eccentric bush B0 (Ø8 and Ø10)

Boring toolholder							
Article	Order No.	A	B	C	Height of cutting edge min - max	kg	
B0-8/10	H05 25010	22	12	150	7,5 - 14,5	0,72	

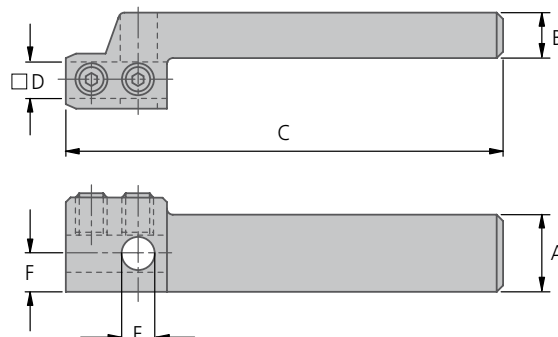
### Boring toolholder B8, B10



Boring toolholder								
Article	Order No.	A	B	C	D	E	Height of cutting edge	kg
B8-8	H05 25110	12	12	100	8	8	6,0	0,07
B10-8/10	H05 25120	15	15	125	8	10	7,5	0,16

### Boring toolholder

KD8, KD10  
for round and square tools



Boring toolholder								
Article	Order No.	A	B	C	□ D	E	F	kg
KD8-8/8	H05 65010	21	12	120	8	8	10,5	0,30
KD10-10/10	H05 65020	21	12	120	10	10	10,5	0,39

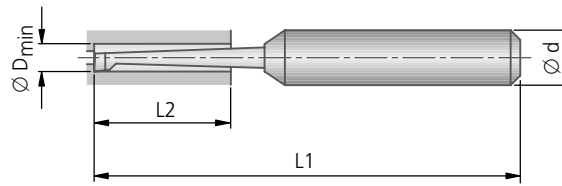


# KOMET® – Internal machining

Ø 0,5 – 2 mm

## Boring tool type K-F

Carbide grade K10



Boring tool							Basic recommendation	
Ø D min	Article	Order No.	Ø d	L1	L2	kg	Grade	for workpiece material
0,5	5K-F-K10	H15 11100.21	4	25	3	0,004	K10	● main area of application ○ suitable in some cases P M K N S H
0,8	8K-F-K10	H15 11110.21	4	25	4	0,004		● ○
1,0	10K-F-K10	H15 11120.21	4	25	4	0,004		● ○
1,2	12K-F-K10	H15 11130.21	4	25	6	0,004		● ○
1,5	15K-F-K10	H15 11140.21	4	28	7	0,004		● ○
1,7	17K-F-K10	H15 11150.21	4	28	7	0,004		● ○
2,0	20K-F-K10	H15 11160.21	4	30	9	0,005		● ○

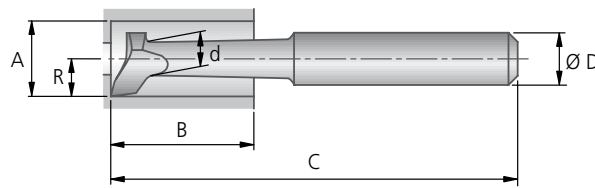


Ø 2,5 – 14 mm

KOMET® – Internal machining

Boring tool form F

HSS grade H  
Carbide grade K10 and P20



Boring tool										
for boring Ø A from	Article	Order No.	Grade	B	C	D	d	R	kg	for holder
2,5	B00F-H	H15 21100.93	H	10	50	8	1,5	1,2	0,02	B0 B8 B10 KD8
3,0	B01F-H	H15 21110.93	H	20	60	8	2,0	1,6	0,02	
	B01F-P20	H15 21110.02	P20	16						
	B01F-K10	H15 21110.21	K10	16						
5,0	B02F-H	H15 21120.93	H	24	60	8	3,0	2,8	0,02	
	B02F-P20	H15 21120.02	P20	19						
	B02F-K10	H15 21120.21	K10	19						
7,0	B03F-H	H15 21130.93	H	26	65	8	4,0	3,8	0,02	
	B03F-K10	H15 21130.21	K10							
9,0	B04F-H	H15 21140.93	H	30	75	8	5,8	5,0	0,03	
	B04F-K10	H15 21140.21	K10							
12,0	B05F-H	H15 21150.93	H	50	80	8	7,2	6,5	0,03	
	B05F-P20	H15 21150.02	P20							
	B05F-K10	H15 21150.21	K10							
14,0	B06F-H	H15 21160.93	H	60	95	10	9,2	7,6	0,06	B0 B10 KD10
	B06F-P20	H15 21160.02	P20							
	B06F-K10	H15 21160.21	K10							
strengthened design										
3,0	B01F-D10-H	H15 22110.93	H	20	60	10	2,0	1,6	0,03	B0 B10 KD8
	B01F-D10-P20	H15 22110.02	P20							
5,0	B02F-D10-K10	H15 22120.21	K10	19	60	10	3,0	2,8	0,03	
7,0	B03F-D10-H	H15 22130.93	H	26	65	10	4,0	3,8	0,03	
9,0	B04F-D10-H	H15 22140.93	H	30	75	10	5,8	5,0	0,04	
	B04F-D10-K10	H15 22140.21	K10							
12,0	B05F-D10-H	H15 22150.93	H	50	80	10	7,2	6,5	0,05	
	B05F-D10-P20	H15 22150.02	P20							
extra long design										
3,0	B01FLG-H	H15 23110.93	H	20	125	8	2,0	1,6	0,05	B0 B8 B10 KD8
	B01FLG-P20	H15 23110.02	P20	16						
	B01FLG-K10	H15 23110.21	K10	16						
5,0	B02FLG-H	H15 23120.93	H	24	125	8	3,0	2,8	0,05	
	B02FLG-P20	H15 23120.02	P20	19						
	B02FLG-K10	H15 23120.21	K10	19						
7,0	B03FLG-H	H15 23130.93	H	26	125	8	4,0	3,8	0,05	
	B03FLG-P20	H15 23130.02	P20							
	B03FLG-K10	H15 23130.21	K10							
9,0	B04FLG-H	H15 23140.93	H	30	125	8	5,8	5,0	0,05	
	B04FLG-P20	H15 23140.02	P20							
	B04FLG-K10	H15 23140.21	K10							
12,0	B05FLG-H	H15 23150.93	H	50	125	8	7,2	6,5	0,05	
	B05FLG-P20	H15 23150.02	P20							
14,0	B06FLG-H	H15 23160.93	H	60	125	10	9,2	7,6	0,08	B0 B10 KD10
	B06FLG-K10	H15 23160.21	K10							

For grinding instructions, see page 32.

L.H. corner tool available on request.

Guideline values for internal machining: page 33.

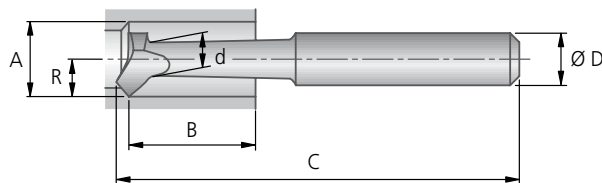


Boring tool form G

For boring through holes from Ø 2,5 mm

HSS grade H

Carbide grade K10 and P20



Boring tool

for boring Ø A from	Boring tool									kg	for holder
	Article	Order No.	Grade	B	C	D	d	R			
2,5	B00G-H	H15 21200.93	H	10	50	8	1,5	1,2	0,02	B0 B8 B10 KD8	
3,0	B01G-H	H15 21210.93	H	20	60	8	2,0	1,6	0,02		
	B01G-P20	H15 21210.02	P20	16							
	B01G-K10	H15 21210.21	K10	16							
5,0	B02G-H	H15 21220.93	H	24	60	8	3,0	2,8	0,02		
	B02G-P20	H15 21220.02	P20	19							
	B02G-K10	H15 21220.21	K10	19							
7,0	B03G-H	H15 21230.93	H	26	65	8	4,0	3,8	0,02		
	B03G-K10	H15 21230.21	K10								
9,0	B04G-H	H15 21240.93	H	30	75	8	5,8	5,0	0,03		
	B04G-P20	H15 21240.02	P20								
	B04G-K10	H15 21240.21	K10								
12,0	B05G-H	H15 21250.93	H	50	80	8	7,2	6,5	0,03		
	B05G-P20	H15 21250.02	P20								
14,0	B06G-H	H15 21260.93	H	60	95	10	9,2	7,6	0,06	B0 B10 KD10	
	B06G-P20	H15 21260.02	P20								
	B06G-K10	H15 21260.21	K10								
extra long design											
5,0	B02GLG-H	H15 23220.93	H	24	125	8	3,0	2,8	0,05	B0 B8 B10 KD8	
7,0	B03GLG-P20	H15 23230.02	P20	26	125	8	4,0	3,8	0,05		
9,0	B04GLG-H	H15 23240.93	H	30	125	8	5,8	5,0	0,05		
12,0	B05GLG-H	H15 23250.93	H	50	125	8	7,2	6,5	0,05		
	B05GLG-P20	H15 23250.02	P20								
14,0	B06GLG-H	H15 23260.93	H	60	125	10	9,2	7,6	0,08	B0 B10 KD10	
	B06GLG-P20	H15 23260.02	P20								

For grinding instructions, see page 32.

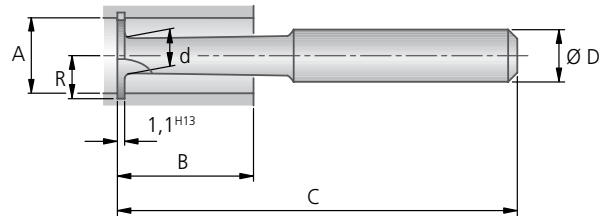
L.H. corner tool available on request.

Ø 3 – 14 mm

KOMET® – Internal machining

Recessing tool form H

HSS grade H  
Carbide grade K10 and P20



Recessing tool											
for boring Ø A from	Article	Order No.	Grade	B	C	D	d	R	kg	for holder	
3,0	B01H-H	H15 21310.93	H	20	60	8	2,0	1,6	0,02	B0 B8 B10 KD8	
5,0	B02H-H	H15 21320.93	H	24	60	8	3,0	2,8	0,02		
7,0	B03H-H	H15 21330.93	H	26	65	8	4,0	3,8	0,02		
	B03H-P20	H15 21330.02	P20								
9,0	B03H-K10	H15 21330.21	K10	30	75	8	5,8	5,0	0,03		
	B04H-H	H15 21340.93	H								
	B04H-P20	H15 21340.02	P20								
	B04H-K10	H15 21340.21	K10	50	80	8	7,2	6,5	0,03		
12,0	B05H-H	H15 21350.93	H								
	B05H-P20	H15 21350.02	P20	60	95	10	9,2	7,6	0,06		
14,0	B06H-H	H15 21360.93	H								
	B06H-P20	H15 21360.02	P20	extra long design							B0 B10 KD10
5,0	B02HLG-H	H15 23320.93	H	24	125	8	3,0	2,8	0,05		
7,0	B03HLG-H	H15 23330.93	H	26	125	8	4,0	3,8	0,05		
9,0	B04HLG-H	H15 23340.93	H	30	125	8	5,8	5,0	0,05		
12,0	B05HLG-H	H15 23350.93	H	50	125	8	7,2	6,5	0,05		
14,0	B06HLG-H	H15 23360.93	H	60	125	10	9,2	7,6	0,08		

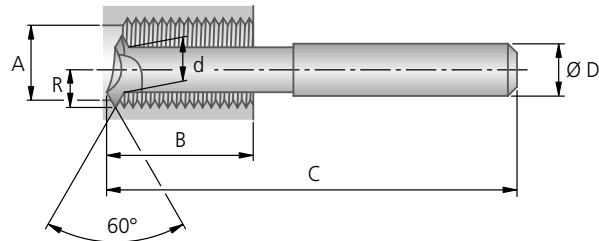
For grinding instructions, see page 32.

Special recessing widths in HSS and L.H. cutting tools on request.



## Threading tool 60°

HSS grade H  
Carbide grade K10 and P20



Threading tool



for boring Ø A from	max. pitch mm	Article	Order No.	Grade	B	C	D	d	R	kg	for holder
3,0	0,18	B01 60-H	H15 21410.93	H	15	60	8	2,0	1,6	0,02	B0 B8 B10 KD8
		B01 60-P20	H15 21410.02	P20	16						
5,0	0,8	B02 60-H	H15 21420.93	H	22	60	8	3,0	2,8	0,02	
		B02 60-P20	H15 21420.02	P20	19						
		B02 60-K10	H15 21420.21	K10	19						
7,0	1,1	B03 60-H	H15 21430.93	H	24	65	8	4,0	3,8	0,02	
		B03 60-P20	H15 21430.02	P20							
9,0	1,5	B04 60-H	H15 21440.93	H	28	75	8	5,8	5,0	0,03	
		B04 60-K10	H15 21440.21	K10							
12,0	2,8	B05 60-H	H15 21450.93	H	50	80	8	7,2	6,5	0,03	
		B05 60-K10	H15 21450.21	K10							
14,0	3,0	B06 60-H	H15 21460.93	H	60	95	10	9,2	7,6	0,06	
		B06 60-P20	H15 21460.02	P20							
		B06 60-K10	H15 21460.21	K10							
extra long design											
12,0	2,8	B05 60LG-H	H15 23450.93	H	50	125	8	7,2	6,5	0,05	B0 B8 B10 KD8

For grinding instructions, see page 32.

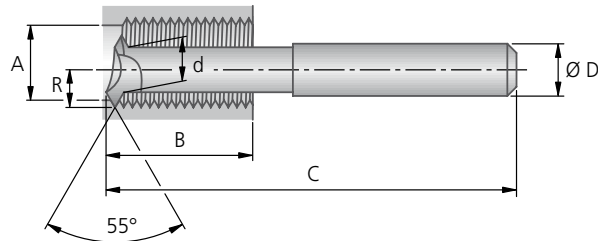
L.H. cutting internal threading tools on request.

Ø 7 – 14 mm

KOMET® – Internal machining

Threading tool 55°

HSS grade H  
Carbide grade P20



Threading tool												
for boring Ø A from	max. pitch T.P.I.	Article		Grade	B	C	D	d	R	kg	for holder	
		Order No.										
7,0	25-50	B03 55-H	H15 21530.93	H	24	65	8	4,0	3,8	0,02	B0 B8 B10 KD8	
		B03 55-P20	H15 21530.02	P20								
9,0	19-50	B04 55-H	H15 21540.93	H	28	75	8	5,8	5,0	0,03		
		B04 55-P20	H15 21540.02	P20								
12,0	11-40	B05 550-H	H15 21550.93	H	50	80	8	7,2	6,5	0,03		
14,0	10-30	B06 55-H	H15 21560.93	H	60	95	10	9,2	7,6	0,06	B0 B10 KD10	
		B06 55-P20	H15 21560.02	P20								

For grinding instructions, see page 32.

L.H. cutting internal threading tools on request.

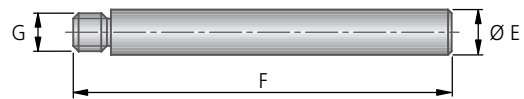
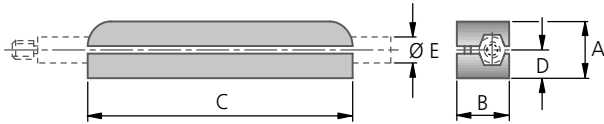


Boring head (detachable)

Holder

Boring bar

Boring bar with L.H. thread available on request.



Holder								Boring bar						
Article	Order No.	A	B	C	D	E		Article	Order No.	E	F	G		for boring head
B1	H05 25210	20	19	110	10,0	10	0,24	B1	H05 35010	10	180	M6	0,11	B1 ..
B2	H05 25220	27	23	150	14,0	13	0,56	B1A	H05 35020	13	220	M8x20 Gg/"	0,23	B1A ..
								B2	H05 35030	13	250	M10x20 Gg/"	0,27	B2 ..
B3	H05 25230	40	30	180	20,0	20	1,21	B2A	H05 35040	20	275	M12x20 Gg/"	0,67	B2A ..
								B2B	H05 35050	20	300	M14x20 Gg/"	0,74	B2B ..
								B3	H05 35060	20	325	M15x20 Gg/"	0,80	B3 ..

Boring tool (detachable)

Form F

HSS Grade F

Boring tool (detachable)

Form G

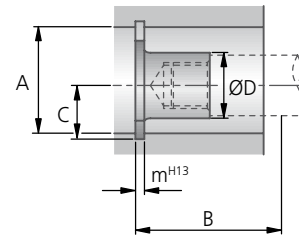
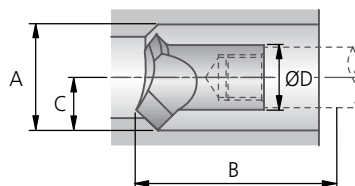
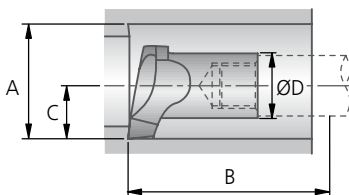
HSS Grade F

Recessing tool (detachable)

Form H

HSS Grade F

Carbide Grade P20



For grinding instructions, see page 32.

Special recessing widths in HSS on request.



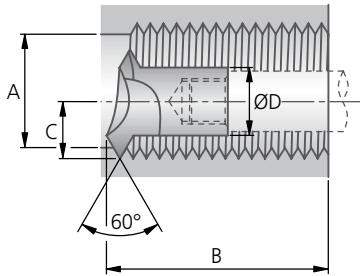
for boring-Ø A from	Boring tool Form F		Boring tool Form G		for slot width m	Recessing tool Form H		Grade	B	C	D		for boring bar
	Article	Order No.	Article	Order No.		Article	Order No.						
16	B1 F-F	H15 31010.91	B1 G-F	H15 31020.91	1,10	B1 H-F	H15 31030.91	F	80	9,0	11,5	0,02	B1
18	B1A F-F	H15 31110.91	B1A G-F	H15 31120.91	1,30	B1A H-F	H15 31130.91	F	85	10,3	12,5	0,02	B1A
21	B2 F-F	H15 31210.91	B2 G-F	H15 31220.91	1,30	B2 H-F	H15 31230.91	F	115	12,0	16,0	0,03	B2
23	–	–	–	–	1,60	B2A H-F	H15 31330.02	P20	120	13,5	18,0	0,04	B2A
24	B2A F-F	H15 31310.91	B2A G-F	H15 31320.91	1,60	B2A H-F	H15 31330.91	F	120	13,5	18,0	0,04	B2A
28	B2B F-F	H15 31410.91	–	–	1,85	B2B H-F	H15 31430.91	F	140	15,5	20,2	0,05	B2B
30	B3 F-F	H15 31510.91	B3 G-F	H15 31520.91	2,15	B3 H-F	H15 31530.91	F	165	16,8	21,5	0,07	B3

Ø 16 – 30 mm

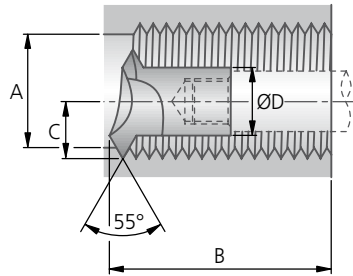
KOMET® – Internal machining

Boring head (detachable)

Threading tool (detachable)  
for 60° thread  
HSS Grade F



Threading tool (detachable)  
for 55° thread  
HSS Grade F

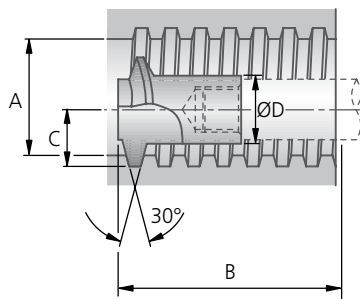


For grinding instructions, see page 32.



A for boring-Ø from	Threading tool 60°			Threading tool 55°			Grade	B	C	D	kg	for boring bar
	max. pitch mm	Article	Order No.	max. pitch T.P.I.	Article	Order No.						
16	2,9	B1 60-F	H15 31040.91	8	B1 55-F	H15 31050.91	F	80	9,0	11,5	0,02	B1
18	4,1	B1A 60-F	H15 31140.91	7	B1A 55-F	H15 31150.91	F	85	10,3	12,5	0,02	B1A
21	4,1	B2 60-F	H15 31240.91	6	B2 55-F	H15 31250.91	F	115	12,0	16,0	0,03	B2
24	4,7	B2A 60-F	H15 31340.91	5,5	B2A 55-F	H15 31350.91	F	120	13,5	18,0	0,04	B2A
28	5,9	B2B 60-F	H15 31440.91	–	–	–	F	140	15,5	20,2	0,05	B2B
30	6,4	B3 60-F	H15 31540.91	4,5	B3 55-F	H15 31550.91	F	165	16,8	21,5	0,07	B3

Threading tool (detachable)  
Acme thread  
HSS Grade F



For grinding instructions, see page 32.

Acme thread, pitch in pitch/inch, carbide tipped acme - threading tools and other thread forms (HSS and L.H. cutting tools only) on request.

A for boring-Ø from	Threading tool			Grade	B	C	D	kg	for boring bar
	Article	Order No.							
16	B1 TR-3,0-F	H15 32030.91	F	80	9,0	11,5	0,02	B1	
	B1 TR-4,0-F	H15 32040.91							
18	B1A TR-4,0-F	H15 32120.91	F	85	10,3	13,5	0,02	B1A	
	B1A TR-5,0-F	H15 32130.91							
21	B2 TR-4,0-F	H15 32220.91	F	115	12,0	15,0	0,03	B2	
	B2 TR-5,0-F	H15 32230.91							
	B2 TR-6,0-F	H15 32240.91							
24	B2A TR-6,0-F	H15 32330.91	F	120	13,5	18,0	0,04	B2A	
	B3 TR-6,0-F	H15 32530.91							
30	B3 TR-7,0-F	H15 32540.91	F	165	16,8	21,5	0,08	B3	
	B3 TR-8,0-F	H15 32550.91							

Guideline values for internal machining: page 33.

31

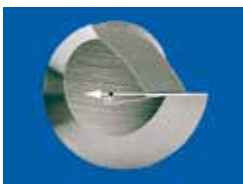


Your local KOMET SERVICE® partner will be happy to do this for you.

## Internal machining – Grinding instructions

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1

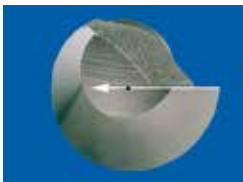


### Boring tool

The cutting edge overhang shown above runs through the centre point of the boring head. However, the top rake which is to be measured at right angles to the direction of the cutting edge (dotted line), should be ground off obliquely between 10° and 20° acc. to material.

---

2



### Internal threading tool 55° or 60°

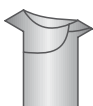
The cutting edge must always run to the centrepoint (see illustration) or the angle will be distorted. When resharpening threading tools, use front edge of chamfered grinding wheel.

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## Threading tool

KOMET® internal threading tools, HSS design in particular, are also supplied for L.H. thread cutting. Please note the details given below and state form required.

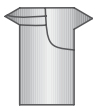
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### Threading tool form A

R.H. thread (standard), for forward running, cutting direction from tailstock to headstock.

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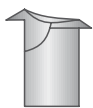
### Threading tool form D

R.H. thread, for reverse running, cutting direction from headstock to tailstock.

**Please note:** When ordering Form D, the required form must be stated.

For acme threads, round threads and buttress threads, the required pitch must also be stated, a special threading tool also being required for each pitch size.

---



### Buttress threading tool form 1

R.H. thread, cutting direction for forward running from tailstock to headstock.

When ordering buttress threading tools, please state whether thread is stressed at compression or tension. Form 1 can also be produced as L.H. threading tools with cutting direction from headstock to tailstock for forwards operation.

---



### Buttress threading tool form 2

R.H. thread, cutting direction for forward running from tailstock to headstock.

When ordering buttress threading tools, please state whether thread is stressed at compression or tension. Form 2 can also be produced as L.H. threading tools with cutting direction from headstock to tailstock for forwards operation.

---



### Form threading tool form 5: Compression



### Form threading tool form 6: Tension

A separate blade is required for each pitch for form threading tools. Round Edison threads are three different thread types. For buttress saw threading tools, please state whether the thread is stressed for compression or tension.

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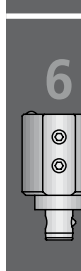
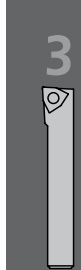
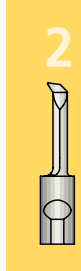


Recommended application areas

Guideline values for internal machining																
Material group	Strength Rm (N/mm <sup>2</sup> )	Hardness HB	Material	Material example, material code/DIN	Cutting speed v <sub>C</sub> (m/min)											
					Grade F			Grade H			Carbide Roughing			Carbide Finishing		
					min	opt.	max	min	opt.	max	min	opt.	max	min	opt.	max
P	1.0	≤500	non-alloy steels	1.0037 (S235JR) 1.0715 (11SMn30) 1.0044 (S2575JR)	10	25	40	15	30	45	40	70	100	50	85	120
	2.0	500-900	non-alloy / low alloy steels	1.0050 (E295) 1.0535 (C55) 1.7131 (16MnCr5)	8	22	35	8	19	30	30	60	90	40	70	100
	2.1	<500	lead alloys	1.0718 (11SMnPb30)	10	20	30	10	23	35	30	65	100	40	80	120
	3.0	>900	low alloy steels: heat resistant structural, heat treated, nitride and tools steels	1.7225 (42CrMo4) 1.1221 (C60E)	8	17	25	8	19	30	25	48	70	30	60	90
	4.0	>900	high alloy steels	1.2341 (6CrMo15-5) 1.2601 (X165Cr-MoV12)	15	20	25	16	23	30	20	40	60	20	45	65
4.1		HSS		5	8	10	6	9	12	15	28	40	15	33	50	
S	5.0	250	special alloys: Inconel, Hastelloy, Nimonic, stc.	2.4668 (NiCr-19Fe19Nb5Mo3) 2.4631 (Nimonic 80A)	5	7	8	4	7	9	10	15	20	10	18	25
	5.1	400	titanium, titanium alloys	3.7115 (TiAl5Sn2.5)	3	5	6	4	7	9	10	20	30	10	20	30
M	6.0	≤600	stainless steels	1.4306 (X2Cr-Ni19-11) 1.4401 (X5CrNi-Mo17-12-2)	10	13	15	10	13	15	20	35	50	20	35	50
	6.1	<900	stainless steels	1.4511 (X3CrNb17) 1.4571 (X10CrNiMo-Ti17-12-2)	8	12	15	8	12	15	20	35	50	20	35	50
	7.0	>900	stainless / fireproof steels	1.4713 (X10CrAlSi7) 1.4862 (X8NiCr-Si38-18)	6	8	10	6	8	10	15	28	40	15	28	40
K	8.0	180	gray cast iron	0.6025 (EN-GJL-250) 0.6035 (EN-GJL-350)	15	20	25	15	20	25	25	38	50	25	38	50
	8.1	250	alloy gray cast iron	0.6660 (GGL-NiCr20 2)	15	20	25	15	20	25	30	40	50	30	40	50
	9.0	≤600	spheroidal graphite cast iron, ferritic	0.7040 (EN-GJS-400-15)	20	25	30	20	25	30	35	48	60	35	48	60
	9.1	230	spheroidal graphite cast iron, ferritic/perlitic	0.7050 (EN-GJS-500-7) 0.7055 (GGG-55) 0.8055 (GTW-55)	20	25	30	20	25	30	35	48	60	35	48	60
	10.0	>600	spheroidal graphite cast iron, perlitic malleable iron	0.7060 (EN-GJS-600-3) 0.8165 (GTS-65)	15	20	25	15	20	25	25	38	50	25	38	50
	10.1	200	alloyed spheroidal graphite cast iron	0.7661 (EN-GJSA-XNiCr20-2)	12	16	20	12	16	20	25	38	50	25	38	50
	10.2	300	vermicular cast iron	EN-GJV Ti < 0,2 EN-GJV Ti > 0,2	10	15	20	10	15	20	25	38	50	25	38	50
N	12.0	90	copper alloy, brass, lead-alloy bronze, lead bronze: good cut	2.0375 (CuZn36Pb3) 2.1182.01 (G-CuPb15Sn)	60	80	100	60	80	100	120	150	180	120	150	180
	12.1	100	copper alloy, brass, bronze: average cut	2.0550 (CuZn40Al2) 2.0060 (E-Cu57)	30	50	70	30	50	70	120	160	200	120	160	200
	13.0	60	wrought aluminium alloys	3.3315 (AlMg1) 3.0517 (AlMnCu)	40	60	80	40	60	80	140	180	220	140	180	220
	13.1	75	cast alum. alloy: Si-content <10% magnesium alloy	3.3561 (G-AlMg5) 3.2373.61 (G-AlSi9Mg wa)	30	50	70	30	50	70	140	180	220	140	180	220
	14.0	100	cast alum.alloy: Si-content >10%	3.2381.01 (G-AlSi10Mg)	20	40	60	20	40	60	120	160	200	120	160	200
H	15.0	1400	hardened steels < 45 HRC													
	1800		hardened steels > 45 HRC													

Cutting values shown are values relating to the basic recommendations for cutting materials given.

Important: See chapter 7 for more application details and safety notes!



# KOMET UniTurn®

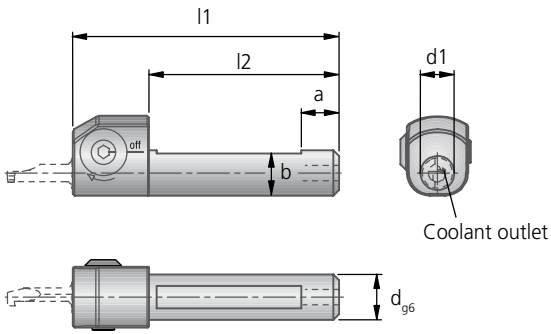
## Internal machining

1



### Clamping holder

with cylindrical connection



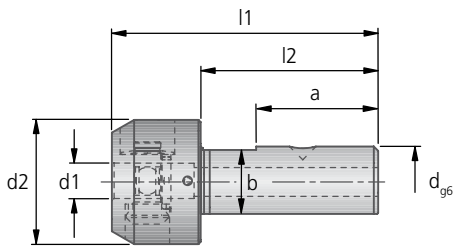
Order No.	dg6	d1	l1	l2	a	b	kg
H50 01240	12	4	70	50	10	11	0,08
H50 01281	12	8					
H50 01640	16	4	70	50	10	15	0,11
H50 01681	16	8					

2



### Adaptor

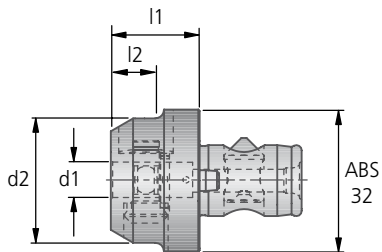
with cylindrical connection



Order No.	dg6	d1	d2	l1	l2	a	b	kg
H50 21640	16	4	28	60	40	27,5	14,4	0,15
H50 21680	16	8	28	60	40	27,5	14,4	0,13

### Adaptor

with ABS® connection

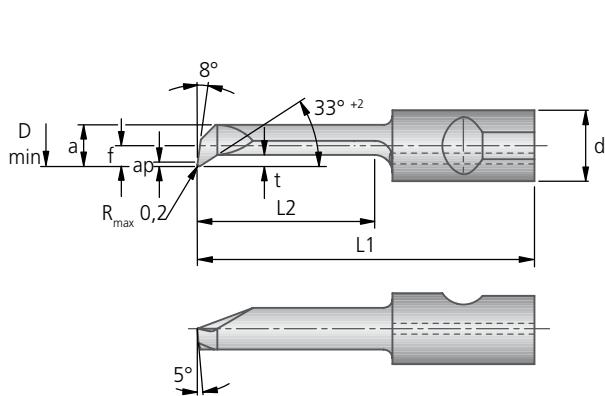


Order No.	ABS d	d1	d2	l1	l2	kg
H50 23240	32	4	28	20	12	0,15
H50 23280	32	8	28	20	12	0,12

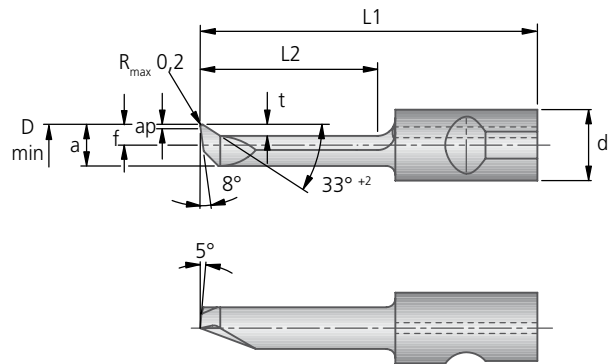
L/D	through hole	blind hole	angled	cross bore	reverse machining	HRC > 54 through hole	HRC > 54 blind hole	vibration dampening
> 3,5xD								
	●	●	○	○	✗	✗	✗	●

● very good ○ good ○ possible ✗ not possible

R.H. cutting form



L.H. cutting form



Ø D min	Cutting form										Basic recommendation						
	R.H.	L.H.	a <sub>p</sub> max	t max	f	a	d	L1	L2	kg	Quality	for workpiece material					
	Order No.	Order No.										P	M	K	N	S	H
3	H51 32100.0182	H51 31100.0182	0,2	0,7	1,25	2,7	4	28	10	0,0032	BK82	●	●	●	●		
	H51 32150.0182	H51 31150.0182	0,2	0,7	1,25	2,7	4	33	15	0,0035		●	●	●	●		
	H51 32200.0182	H51 31200.0182	0,2	0,7	1,25	2,7	4	38	20	0,0037		●	●	●	●		
4	H51 42100.0182	H51 41100.0182	0,3	0,8	1,75	3,7	4	28	10	0,0038	BK82	●	●	●	●		
	H51 42150.0182	H51 41150.0182	0,3	0,8	1,75	3,7	4	33	15	0,0043		●	●	●	●		
	H51 42200.0182	H51 41200.0182	0,3	0,8	1,75	3,7	4	38	20	0,0047		●	●	●	●		
	H51 42250.0182	H51 41250.0182	0,3	0,8	1,75	3,7	4	43	25	0,0052		●	●	●	●		
5	H51 52100.0282	H51 51100.0282	0,5	1,0	2,25	4,7	8	28	10	0,013	BK82	●	●	●	●		
	H51 52150.0282	H51 51150.0282	0,5	1,0	2,25	4,7	8	33	15	0,013		●	●	●	●		
	H51 52200.0282	H51 51200.0282	0,5	1,0	2,25	4,7	8	38	20	0,014		●	●	●	●		
	H51 52250.0282	H51 51250.0282	0,5	1,0	2,25	4,7	8	43	25	0,015		●	●	●	●		
	H51 52300.0282	H51 51300.0282	0,5	1,0	2,25	4,7	8	48	30	0,016		●	●	●	●		
6	H51 62150.0282	H51 61150.0282	0,5	1,8	2,75	5,7	8	33	15	0,014	BK82	●	●	●	●		
	H51 62200.0282	H51 61200.0282	0,5	1,8	2,75	5,7	8	38	20	0,015		●	●	●	●		
	H51 62250.0282	H51 61250.0282	0,5	1,8	2,75	5,7	8	43	25	0,016		●	●	●	●		
	H51 62300.0282	H51 61300.0282	0,5	1,8	2,75	5,7	8	48	30	0,017		●	●	●	●		
	H51 62350.0282	H51 61350.0282	0,5	1,8	2,75	5,7	8	53	35	0,018		●	●	●	●		
8	H51 82150.0282	H51 81150.0282	0,6	2,5	3,75	7,7	8	33	15	0,016	BK82	●	●	●	●		
	H51 82200.0282	H51 81200.0282	0,6	2,5	3,75	7,7	8	38	20	0,018		●	●	●	●		
	H51 82250.0282	H51 81250.0282	0,6	2,5	3,75	7,7	8	43	25	0,020		●	●	●	●		
	H51 82300.0282	H51 81300.0282	0,6	2,5	3,75	7,7	8	48	30	0,022		●	●	●	●		
	H51 82350.0282	H51 81350.0282	0,6	2,5	3,75	7,7	8	53	35	0,023		●	●	●	●		
	H51 82400.0282	H51 81400.0282	0,6	2,5	3,75	7,7	8	58	40	0,025		●	●	●	●		

Please note:

From D<sub>min.</sub> 5 mm, copying tools have internal coolant supply; for smaller diameters, coolant is passed over adaptor.



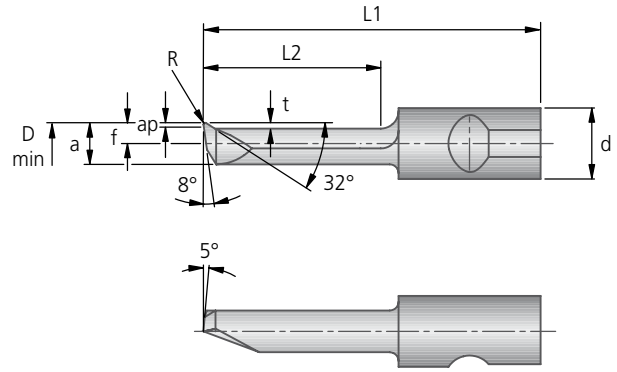
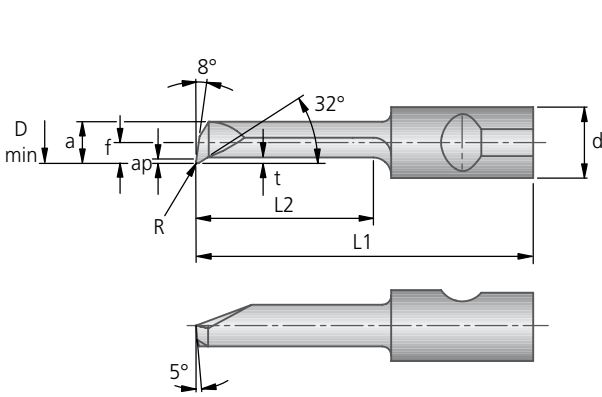
Boring tool

L / D  > 3,5xD	through hole	blind hole	angled	cross bore	reverse machining	HRC > 54 through hole	HRC > 54 blind hole	vibration dampening
●	●	●	○	●	×	×	×	●

● very good ○ good ○ possible × not possible

R.H. cutting form

L.H. cutting form



Guideline recommendation: feed  $f = 0,025-0,1$  mm



Ø D min	Cutting form										Basic recommendation		
	R.H.	L.H.	$a_p$ max	$t$ max	$f$	$a$	Ø d	L1	L2	kg	Quality	for workpiece material	
3	H55 32100.0182	H55 31100.0182	0,6	0,3	1,25	2,6	4	28	10	0,004	BK82	● ● ● ●	
	H55 32150.0182	–						33	15				
4	H55 42150.0182	–	0,8	0,3	1,75	3,6	4	33	15	0,005	BK82	● ● ● ●	
	H55 42200.0182	H55 41200.0182						38	20				0,006
5	H55 52150.0282	H55 51150.0282	1,0	0,4	1,55	4,6	8	33	15	0,016	BK82	● ● ● ●	
	–	H55 51200.0282						38	20				0,018
	H55 52250.0282	–						43	25				0,019
6	H55 62200.0282	–	1,1	0,4	1,55	5,4	8	38	20	0,020	BK82	● ● ● ●	
	H55 62300.0282	H55 61300.0282						48	30				0,023
8	–	H55 81200.0282	1,2	0,4	1,5	5,5	8	38	20	0,020	BK82	● ● ● ●	
	H55 82400.0282	–						58	40				0,027

Please note:

From  $D_{min}$ . 5 mm, boring tools have internal coolant supply; for smaller diameters, coolant is passed over adaptor.

Ø 2,7 – 7,5 mm

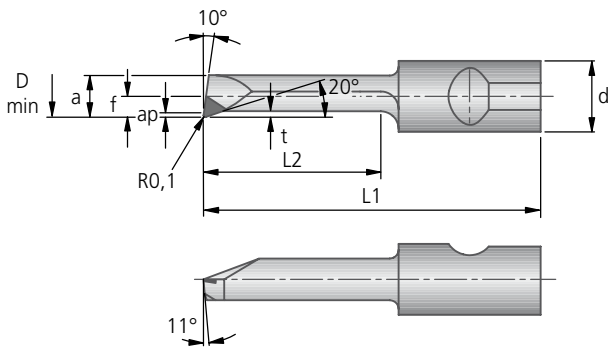
KOMET UniTurn®

Boring tool with CBN

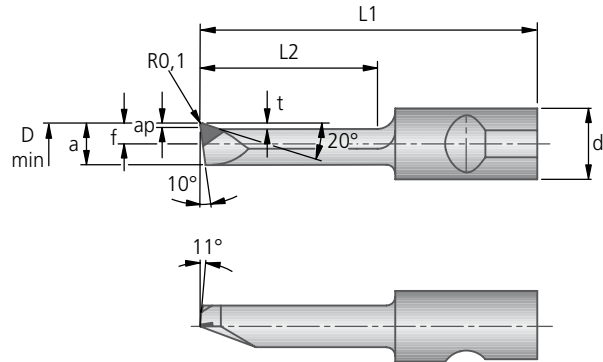
L/D	through hole	blind hole	angled	cross bore	reverse machining	HRC > 54 through hole	HRC > 54 blind hole	vibration dampening
> 3,5xD								
	●	●	○	○	×	●	●	●

● very good ○ good ○ possible × not possible

R.H. cutting form



L.H. cutting form



Guideline recommendations:  $a_p = 0,05 - 0,07$  mm;  $f = 0,01 - 0,03$  mm;  $v_c = 70 - 90$  m/min

Ø D min	Cutting form		Basic recommendation							Quality	for workpiece material ● main area of application ○ suitable in some cases
	R.H.	L.H.	t	f	a	Ø d	L1	L2	kg		
2,7	H56 32100.0140	H56 31100.0140	0,2	1,35	2,5	4	27	9	0,004	CBN40	● $\geq 52$ HRC
3,8	H56 42121.0140	H56 41121.0140	0,2	1,9	3,6	8	30	12	0,015	CBN40	● $\geq 52$ HRC
4,8	H56 52151.0140	H56 51151.0140	0,25	2,4	4,55	8	33	15	0,016	CBN40	● $\geq 52$ HRC
5,4	H56 62201.0140	H56 61201.0140	0,3	2,7	5,2	8	38	20	0,019	CBN40	● $\geq 52$ HRC
7,5	H56 82251.0140	H56 81251.0140	0,5	3,8	7,3	8	43	25	0,024	CBN40	● $\geq 52$ HRC

Please note:

Boring tools have internal coolant supply.



Recessing tool

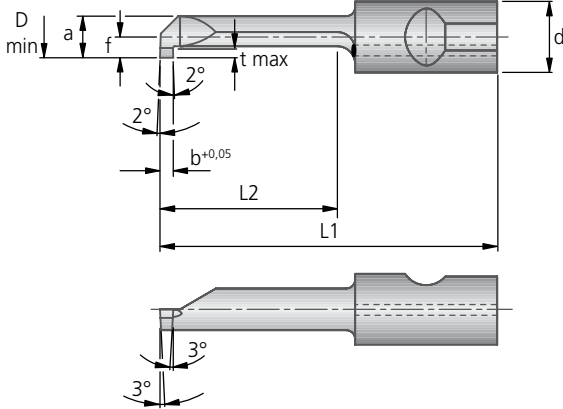
1



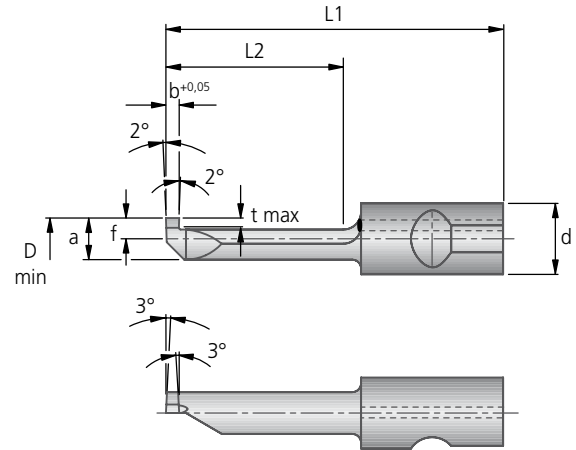
2



R.H. cutting form



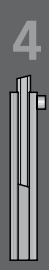
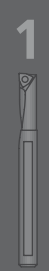
L.H. cutting form



		Cutting form									Basic recommendation						
		R.H.	L.H.								for workpiece material						
Ø D min	b	Order No.	Order No.	t max	f	a	d	L1	L2	kg	Quality	● main area of application ○ suitable in some cases					
												P	M	K	N	S	H
3	1,0	H52 32100.1082	H52 31100.1082	0,7	1,25	2,7	4	28	10	0,0032	BK82	●	●	●	●		
		H52 32150.1082	H52 31150.1082					33	15	0,0035		●	●	●	●		
4	1,0	H52 42100.1082	H52 41100.1082	0,8	1,75	3,7	4	28	10	0,0038	BK82	●	●	●	●		
		H52 42150.1082	H52 41150.1082					33	15	0,0043		●	●	●	●		
		H52 42200.1082	H52 41200.1082					38	20	0,0047		●	●	●	●		
		H52 42250.1082	–					43	25	0,0052		●	●	●	●		
5	1,0	H52 52100.1082	–	1,0	2,25	4,7	8	28	10	0,013	BK82	●	●	●	●		
	1,5	H52 52100.1582	–									●	●	●	●		
	2,0	H52 52100.2082	–									●	●	●	●		
5	1,0	H52 52150.1082	H52 51150.1082	1,0	2,25	4,7	8	33	15	0,013	BK82	●	●	●	●		
	2,0	H52 52150.2082	H52 51150.2082									●	●	●	●		
5	1,0	H52 52200.1082	H52 51200.1082	1,0	2,25	4,7	8	38	20	0,014	BK82	●	●	●	●		
	1,5	H52 52200.1582	H52 51200.1582									●	●	●	●		
	2,0	H52 52200.2082	H52 51200.2082									●	●	●	●		
5	1,0	H52 52250.1082	–	1,0	2,25	4,7	8	43	25	0,015	BK82	●	●	●	●		
	1,5	H52 52250.1582	–									●	●	●	●		
	2,0	H52 52250.2082	–									●	●	●	●		
5	1,0	H52 52300.1082	H52 51300.1082	1,0	2,25	4,7	8	48	30	0,016	BK82	●	●	●	●		
	2,0	H52 52300.2082	–									●	●	●	●		

Please note:

From D<sub>min.</sub> 5 mm, recessing tools have internal coolant supply; for smaller diameters, coolant is passed over adaptor.



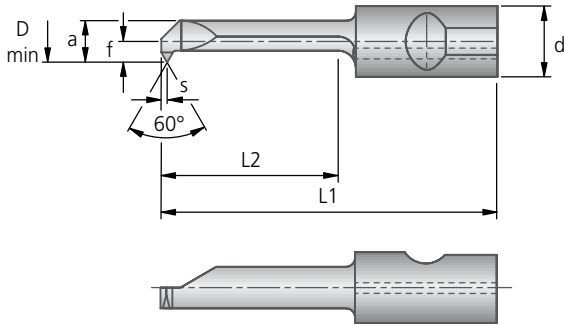
		Cutting form										Basic recommendation					
Ø D min	b	R.H.	L.H.	t max	f	a	d	L1	L2		Quality	for workpiece material					
		Order No.	Order No.									● main area of application	○ suitable in some cases				
												P	M	K	N	S	H
6	1,0	H52 62150.1082	H52 61150.1082	1,8	2,75	5,7	8	33	15	0,014	BK82	● ● ● ●					
	1,5	H52 62150.1582	H52 61150.1582														
	2,0	H52 62150.2082	H52 61150.2082														
6	1,0	H52 62200.1082	H52 61200.1082	1,8	2,75	5,7	8	38	20	0,015							
	1,5	H52 62200.1582	H52 61200.1582														
	2,0	H52 62200.2082	H52 61200.2082														
6	1,0	H52 62250.1082	–	1,8	2,75	5,7	8	43	25	0,016							
	2,0	H52 62250.2082	H52 61250.2082														
6	1,0	H52 62300.1082	H52 61300.1082	1,8	2,75	5,7	8	48	30	0,017							
	1,5	H52 62300.1582	–														
	2,0	H52 62300.2082	H52 61300.2082														
6	1,0	H52 62350.1082	H52 61350.1082	1,8	2,75	5,7	8	53	35	0,018							
	1,5	H52 62350.1582	–														
	2,0	H52 62350.2082	–														
8	1,0	H52 82150.1082	H52 81150.1082	2,5	3,75	7,7	8	33	15	0,016							
	1,5	H52 82150.1582	H52 81150.1582														
	2,0	H52 82150.2082	H52 81150.2082														
8	1,0	H52 82200.1082	H52 81200.1082	2,5	3,75	7,7	8	38	20	0,018							
	1,5	H52 82200.1582	H52 81200.1582														
	2,0	H52 82200.2082	H52 81200.2082														
8	1,0	H52 82250.1082	H52 81250.1082	2,5	3,75	7,7	8	43	25	0,020							
	1,5	H52 82250.1582	H52 81250.1582														
	2,0	H52 82250.2082	H52 81250.2082														
8	1,0	H52 82300.1082	–	2,5	3,75	7,7	8	48	30	0,022							
	1,5	H52 82300.1582	–														
	2,0	H52 82300.2082	H52 81300.2082														
8	1,0	H52 82350.1082	–	2,5	3,75	7,7	8	53	35	0,023							
	1,5	H52 82350.1582	–														
	2,0	H52 82350.2082	H52 81350.2082														
8	1,0	H52 82400.1082	–	2,5	3,75	7,7	8	58	40	0,025							
	1,5	H52 82400.1582	H52 81400.1582														
	2,0	H52 82400.2082	H52 81400.2082														

Threading tool

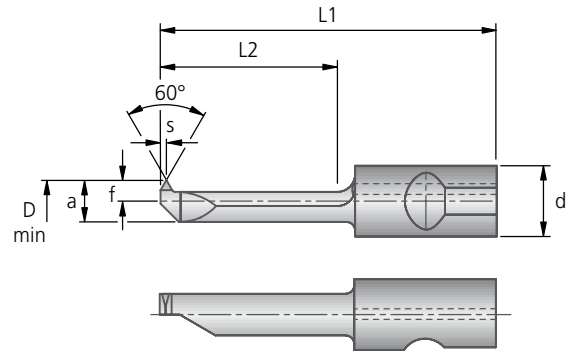
1

2

R.H. cutting form



L.H. cutting form



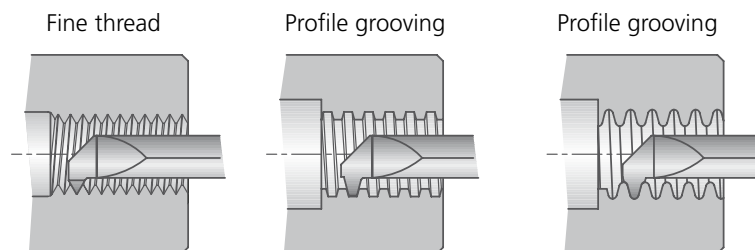
		Cutting form										Basic recommendation						
Ø D min	Control thread	Pitch P	s	R.H.		f	a	d	L1	L2	kg	Quality	for workpiece material					
				Order No.	Order No.								P	M	K	N	S	H
5	M6	1	0,55	H54 52150.1082	H54 51150.1082	2,25	4,7	8	33	15	0,014	BK82	●	●	●	●	●	●
6	M8	1,25	0,65	H54 62150.1282	–	2,75	5,7	8	33	15	0,014	BK82	●	●	●	●	●	●
8	M10	1,5	0,75	H54 82150.1582	–	3,75	7,7	8	33	15	0,017	BK82	●	●	●	●	●	●
	M12	1,75	0,85	H54 82150.1782	–								●	●	●	●	●	●

Please note:

From D<sub>min.</sub> 5 mm, threading tools have internal coolant supply; for smaller diameters, coolant is passed over adaptor.

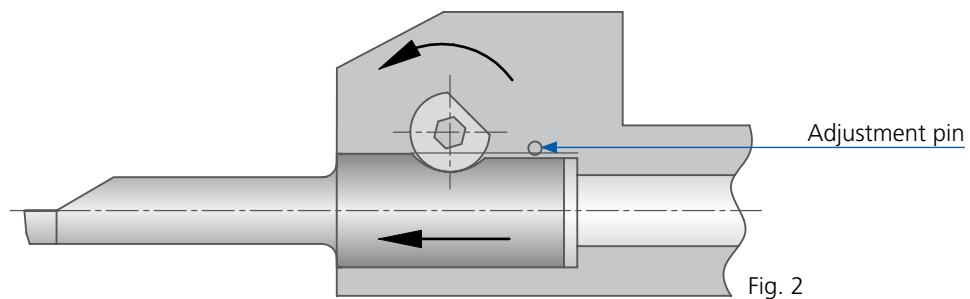
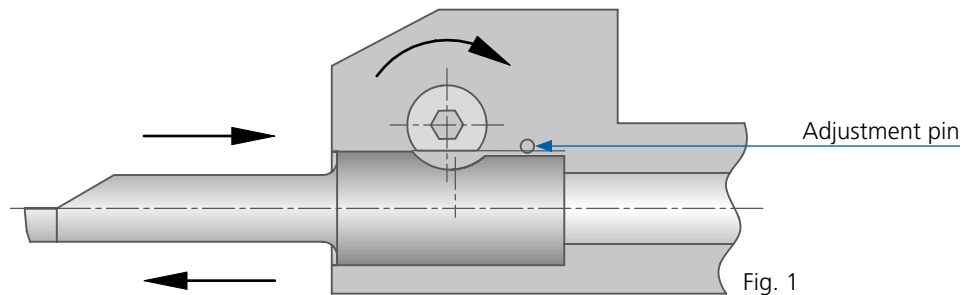
Special forms

are available on request





## Operating instructions for the clamping mechanism



Set the eccentric clamping element to the "off" position with hexagonal key (as far as the stop). The clamping mechanism is then released and the boring bar can be changed (Fig. 1). Insert the new boring bar into the clamping holder as far as the stop with the flat surface upwards.

Tighten the eccentric clamping element with the key to a maximum of 3 Nm (Fig. 2).

By turning the eccentric clamping element, the boring bar is pushed out of the holder in the axial position ( $\pm 0.01$ ) and at the same time moved into the exact centre height ( $\pm 0.01$ ).

A click will indicate that the clamping mechanism has been released.

1



2



3



4



5



6



7



## Recommended application areas

Guideline values for boring, chamfering, copying and recessing

Material group	Strength Rm (N/mm²)	Hardness HB	Material	Material example, material code/DIN	Cutting speed			until 3xD			> 3xD								
					v <sub>c</sub> (m/min)			Feed f (mm/rev)			Cutting depth a <sub>p</sub> (mm)			Feed f (mm/rev)			Cutting depth a <sub>p</sub> (mm)		
					min	opt.	max	min	opt.	max	min	opt.	max	min	opt.	max	min	opt.	max
P	1.0	≤500	non-alloy steels	1.0037 (S235JR) 1.0715 (11SMn30) 1.0044 (S2575JR)	30	100	180	0,010	0,02	0,030	0,02	0,08	0,15	0,010	0,02	0,025	0,02	0,07	0,10
	2.0	500-900	non-alloy / low alloy steels	1.0050 (E295) 1.0535 (C55) 1.7131 (16MnCr5)	30	90	130	0,010	0,02	0,030	0,02	0,08	0,15	0,010	0,02	0,025	0,02	0,07	0,10
	2.1	<500	lead alloys	1.0718 (11SMnPb30)	20	80	120	0,010	0,02	0,030	0,02	0,08	0,15	0,010	0,02	0,025	0,02	0,07	0,10
	3.0	>900	non alloy / low alloy steels: heat resistant structural, heat treated, nitride and tools steels	1.7225 (42CrMo4) 1.1221 (C60E)	20	80	120	0,005	0,01	0,025	0,02	0,07	0,10	0,005	0,01	0,020	0,02	0,07	0,10
	4.0	>900	high alloy steels	1.2341 (6CrMo15-5) 1.2601 (X165Cr- MoV12)	15	50	90	0,005	0,01	0,025	0,02	0,08	0,15	0,005	0,01	0,020	0,02	0,07	0,10
	4.1		HSS		10	30	60	0,005	0,01	0,025	0,02	0,08	0,15	0,005	0,01	0,020	0,02	0,07	0,10
S	5.0	250	special alloys: Inconel, Hastelloy, Nimonic, stc.	2.4668 (NiuCr- 19Fe19Nb5Mo3) 2.4631 (Nimonic 80A)	5	20	30	0,005	0,01	0,025	0,02	0,05	0,08	0,005	0,01	0,020	0,02	0,06	0,10
	5.1	400	titanium, titanium alloys	3.7115 (TiAl5Sn2.5)	5	30	50	0,005	0,01	0,025	0,02	0,05	0,08	0,005	0,01	0,020	0,02	0,06	0,10
M	6.0	≤600	stainless steels	1.4306 (X2Cr- Ni19-11) 1.4401 (X5CrNi- Mo17-12-2)	10	50	80	0,005	0,01	0,025	0,02	0,07	0,10	0,005	0,01	0,020	0,02	0,07	0,10
	6.1	<900	stainless steels	1.4511 (X3CrNb17) 1.4571 (X10CrNiMo- Ti17-12-2)	10	50	80	0,005	0,01	0,025	0,02	0,07	0,10	0,005	0,01	0,020	0,02	0,07	0,10
	7.0	>900	stainless / fireproof steels	1.4713 (X10CrAlSi7) 1.4862 (X8NiCr- Si38-18)	8	30	60	0,005	0,01	0,025	0,02	0,07	0,10	0,005	0,01	0,020	0,02	0,07	0,10
K	8.0	180	gray cast iron	0.6025 (EN-GJL-250) 0.6035 (EN-GJL-350)	15	55	90	0,010	0,02	0,035	0,05	0,10	0,25	0,010	0,02	0,030	0,03	0,10	0,20
	8.1	250	alloy gray cast iron	0.6660 (GGL- NiCr20 2)	15	55	90	0,010	0,02	0,035	0,05	0,10	0,25	0,010	0,02	0,030	0,03	0,10	0,20
	9.0	≤600	spheroidal graphite cast iron, ferritic	0.7040 (EN- GJS-400-15)	15	55	90	0,010	0,02	0,035	0,05	0,10	0,25	0,010	0,02	0,030	0,03	0,10	0,20
	9.1	230	spheroidal graphite cast iron, ferritic / perlite	0.7050 (EN-GJS-500-7) 0.7055 (GGG-55) 0.8055 (GTW-55)	15	55	90	0,010	0,02	0,035	0,05	0,10	0,25	0,010	0,02	0,030	0,03	0,10	0,20
	10.0	>600	spheroidal graphite cast iron, perlite malleable iron	0.7060 (EN- GJS-600-3) 0.8165 (GTS-65)	15	55	90	0,010	0,02	0,035	0,05	0,10	0,25	0,010	0,02	0,030	0,03	0,10	0,20
	10.1	200	alloyed spheroidal graphite cast iron	0.7661 (EN-GJSA-XNiCr20-2)	15	55	90	0,010	0,02	0,035	0,05	0,10	0,25	0,010	0,02	0,030	0,03	0,10	0,20
	10.2	300	vermicular cast iron	EN-GJV Ti < 0,2 EN-GJV Ti > 0,2	15	55	90	0,010	0,02	0,035	0,05	0,10	0,25	0,010	0,02	0,030	0,03	0,10	0,20
N	12.0	90	copper alloy, brass, lead-alloy bronze, lead bronze: good cut	2.0375 (CuZn36Pb3) 2.1182.01 (G- CuPb15Sn)	30	120	200	0,010	0,02	0,040	0,02	0,40	0,50	0,010	0,02	0,040	0,03	0,15	0,30
	12.1	100	copper alloy, brass, bronze: average cut	2.0550 (CuZn40Al2) 2.0060 (E-Cu57)	30	150	250	0,010	0,02	0,040	0,02	0,40	0,50	0,010	0,02	0,040	0,03	0,15	0,30
	13.0	60	wrought aluminium alloys	3.3315 (AlMg1) 3.0517 (AlMnCu)	30	180	300	0,010	0,02	0,040	0,02	0,40	0,50	0,010	0,02	0,040	0,03	0,15	0,30
	13.1	75	cast alum. alloy: Si-content <10% magnesium alloy	3.3561 (G-AllMg5) 3.2373.61 (G- AlSi9Mg wa)	30	150	250	0,010	0,02	0,040	0,02	0,40	0,50	0,010	0,02	0,040	0,03	0,15	0,30
	14.0	100	cast alum.alloy: Si-content >10%	3.2381.01 (G- AlSi10Mg)	30	120	200	0,010	0,02	0,040	0,02	0,40	0,50	0,010	0,02	0,040	0,03	0,15	0,30
H	15.0	1400	hardened steels > 52 HRC		20	50	80	0,005	0,01	0,020	0,02	0,07	0,12	-	-	-	-	-	-
	16.0	1800	hardened steels > 62 HRC		15	40	65	0,005	0,01	0,020	0,02	0,07	0,12	-	-	-	-	-	-

Cutting values shown are relating to the basic recommendations for cutting materials given.

Patent applied for inside and outside Germany

Recommended application areas

Guideline values for internal thread cutting													
Material group	Strength Rm (N/mm²)	Hardness HB	Material	Material example, material code/DIN	Cutting speed v <sub>c</sub> (m/min)			No. of cuts					
					min	opt.	max	Pitch (mm)					
								0,50	0,75	1,00	1,25	1,50	1,75
P	1.0	≤500	non-alloy steels	1.0037 (S235JR) 1.0715 (11SMn30) 1.0044 (S2575JR)	30	100	180	4-6	4-7	4-8	5-9	6-10	7-12
	2.0	500-900	non-alloy / low alloy steels	1.0050 (E295) 1.0535 (C55) 1.7131 (16MnCr5)	30	90	130						
	2.1	<500	lead alloys	1.0718 (11SMnPb30)	20	80	120						
	3.0	>900	non alloy / low alloy steels: heat resistant structural, heat treated, nitride and tools steels	1.7225 (42CrMo4) 1.1221 (C60E)	20	80	120						
	4.0	>900	high alloy steels	1.2341 (6CrMo15-5) 1.2601 (X165CrMoV12)	15	50	90						
4.1		HSS		10	30	60							
S	5.0	250	special alloys: Inconel, Hastelloy, Nimonic, etc.	2.4668 (NiuCr19Fe19Nb5Mo3) 2.4631 (Nimonic 80A)	5	20	30	4-6	4-7	4-8	5-9	6-10	7-12
	5.1	400	titanium, titanium alloys	3.7115 (TiAl5Sn2.5)	5	30	50						
M	6.0	≤600	stainless steels	1.4306 (X2CrNi19-11) 1.4401 (X5CrNiMo17-12-2)	10	50	80	4-6	4-7	4-8	5-9	6-10	7-12
	6.1	<900	stainless steels	1.4511 (X3CrNb17) 1.4571 (X10CrNiMoTi17-12-2)	10	50	80						
	7.0	>900	stainless / fireproof steels	1.4713 (X10CrAlSi7) 1.4862 (X8NiCrSi38-18)	8	30	60						
K	8.0	180	gray cast iron	0.6025 (EN-GJL-250) 0.6035 (EN-GJL-350)	15	55	90	4-6	4-7	4-8	5-9	6-10	7-12
	8.1	250	alloy gray cast iron	0.6660 (GGL-NiCr20 2)	15	55	90						
	9.0	≤600	spheroidal graphite cast iron, ferritic	0.7040 (EN-GJS-400-15)	15	55	90						
	9.1	230	spheroidal graphite cast iron, ferritic /perlitic	0.7050 (EN-GJS-500-7) 0.7055 (GGG-55) 0.8055 (GTW-55)	15	55	90						
	10.0	>600	spheroidal graphite cast iron, perlitic malleable iron	0.7060 (EN-GJS-600-3) 0.8165 (GTS-65)	15	55	90						
	10.1	200	alloyed spheroidal graphite cast iron	0.7661 (EN-GJSA-XNiCr20-2)	15	55	90						
10.2	300	vermicular cast iron	EN-GJV Ti < 0,2 EN-GJV Ti > 0,2	15	55	90							
N	12.0	90	copper alloy, brass, lead-alloy bronze, lead bronze: good cut	2.0375 (CuZn36Pb3) 2.1182.01 (G-CuPb15Sn)	30	120	200	4-6	4-7	4-8	5-9	6-10	7-12
	12.1	100	copper alloy, brass, bronze: average cut	2.0550 (CuZn40Al2) 2.0060 (E-Cu57)	30	150	250						
	13.0	60	wrought aluminium alloys	3.3315 (AlMg1) 3.0517 (AlMnCu)	30	180	300						
	13.1	75	cast alum. alloy: Si-content <10% magnesium alloy	3.3561 (G-AllMg5) 3.2373.61 (G-AllSi9Mg wa)	30	150	250						
	14.0	100	cast alum.alloy:Si-content >10%	3.2381.01 (G-AllSi10Mg)	30	120	200						
H	15.0	1400	hardened steels > 52 HRC										
	1800	1400	hardened steels > 62 HRC										

Cutting values shown are relating to the basic recommendations for cutting materials given.

Important: See chapter 7 for more application details and safety notes!



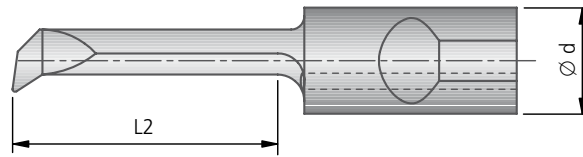
# KOMET UniTurn® Easy Special

## Design your own tool!

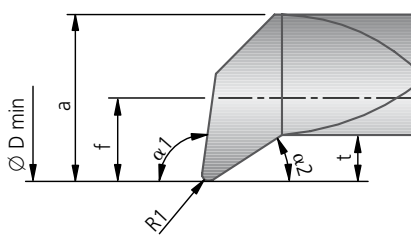
We check your specifications for technical feasibility and you receive a prompt reply.

### BENEFITS for you:

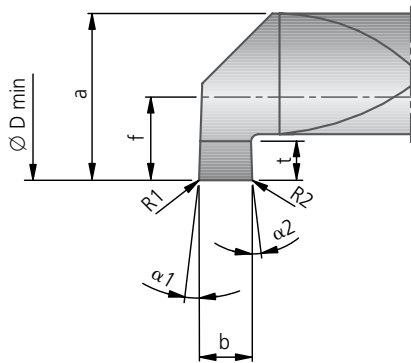
- Only 3-4 weeks delivery from order being placed (for quantities of up to 50 off/per item for coated tools)
- Only 2 weeks delivery from order being placed (for quantities of up to 50 off/per item for uncoated tools)
- Fixed price subject to quantity and working length
- Easy processing



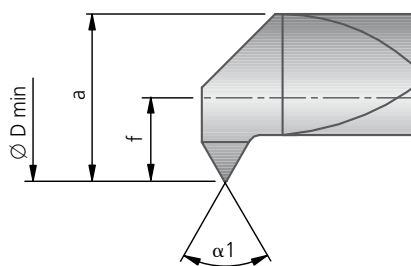
### Copying



### Grooving



### Thread turning



- for ISO and fine thread (M6-M12)
- in L.H. and R.H. versions

Parameter table

Ø D min	b max	t max	a	f	Working length L2						
					10	15	20	25	30	35	
3	1,3	0,7	2,7	1,25	10	15	20	-	-	-	-
4	1,3	0,8	3,7	1,75	10	15	20	25	-	-	-
5	2,3	1,0	4,7	2,25	10	15	20	25	30	-	-
6	2,3	1,8	5,7	2,75	-	15	20	25	30	35	-
8	2,3	2,5	7,7	3,75	-	15	20	25	30	35	40

Parameter table

Ø D min	b max	t max	a	f	Working length L2						
					10	15	20	25	30	35	
5	2,3	1,0	4,7	2,25	10	15	20	25	30	-	-
6	2,3	1,8	5,7	2,75	-	15	20	25	30	35	-
8	2,3	2,5	7,7	3,75	-	15	20	25	30	35	40

Note: Variations in sizes (L2-, a-, f-dimension) will have to be separately checked individually.

Order No./Order date	Please state Customer No.	Signature	KOMET internal
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Company:  
Address:

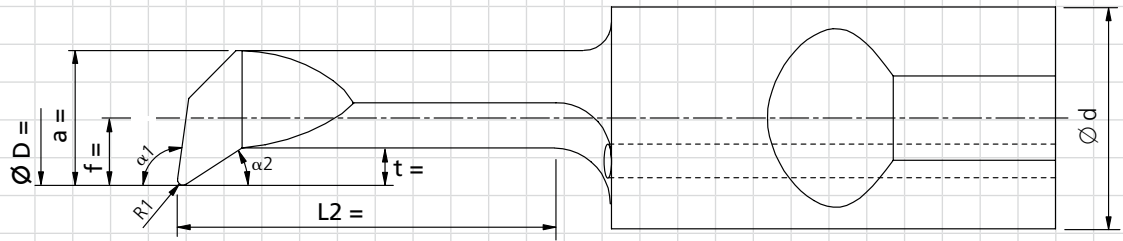
Contact:  
Department:  
Telephone:  
Fax:  
E-Mail:

Order     Enquiry

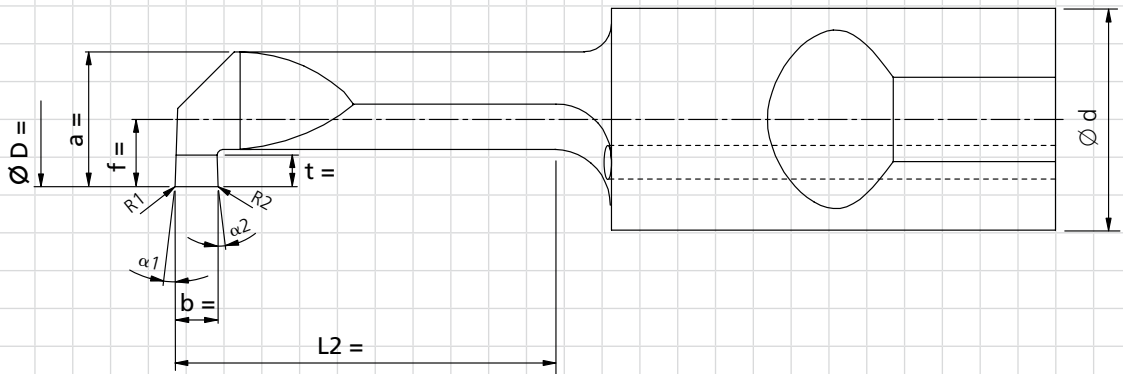
Quantity:  
(minimum order 5 off)

Coating     yes     no

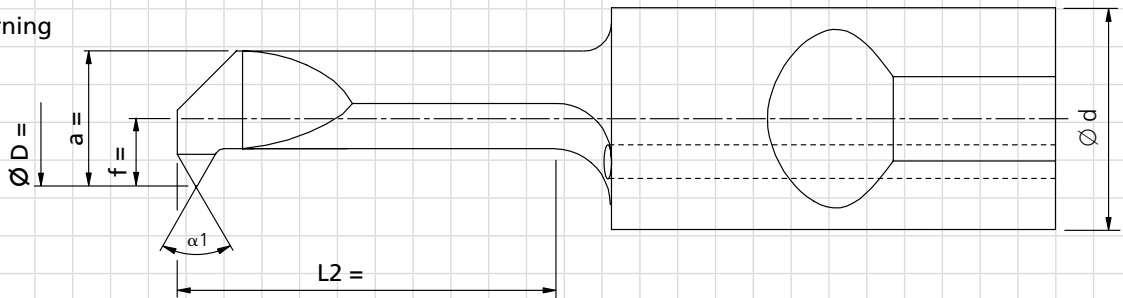
Copying



Grooving



Thread turning



Please provide workpiece sketch!

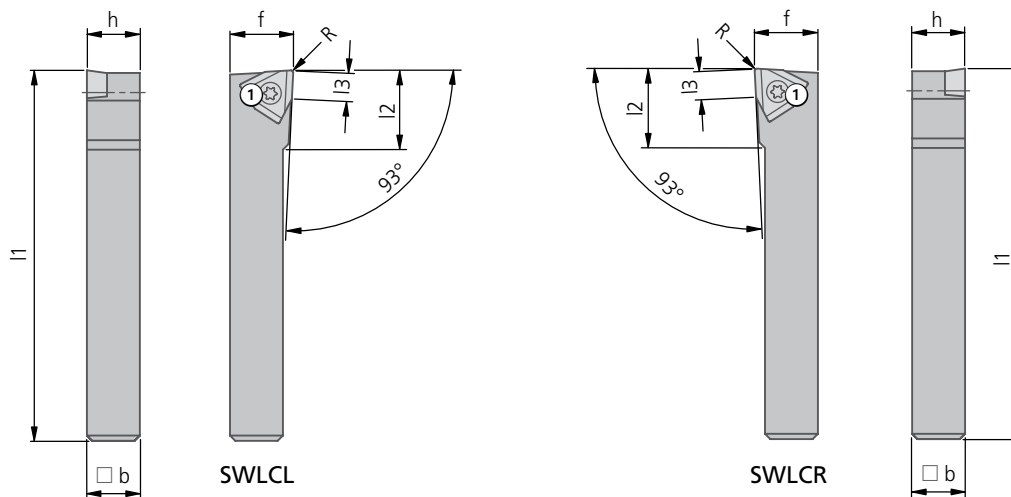
Blank grid area for providing a workpiece sketch.



# KOMET® – External machining

## Turning tool $\kappa = 93^\circ$

- for insert W01 / W29
- L.H. turning tool SWLCL with left or neutral insert
- R.H. turning tool SWLCR with right or neutral insert



$\kappa = 93^\circ$										Insert			
Order No. Article	Cutting form	h	□ b	l1	l2	l3	f	for R	kg	Clamping screw ① Order No. Article	W01 L.H.  Size ▼	W01 R.H.  Size ▼	W01   W29 neutral  Size ▼
D00 75120 SWLCR-1010-E05	R.H.	10	10	70	15	5,3	12	0,2	0,09	N00 57511 S/M2,5x7,2-8IP 1,28 Nm		W01 24...	W01 24... W29 24...
D00 70130 SWLCL-1212-F05	L.H.	12	12	80	18	5,3	16	0,2	0,13	N00 57511 S/M2,5x7,2-8IP 1,28 Nm	W01 24...		W01 24... W29 24...
D00 75130 SWLCR-1212-F05	R.H.											W01 24...	
D00 70140 SWLCL-1616-H06	L.H.	16	16	100	20	6,6	20	0,2	0,27	N00 57521 S/M3,5x7,3-10IP 2,8 Nm	W01 34...		W01 34... W29 34...
D00 75140 SWLCR-1616-H06	R.H.											W01 34...	
D00 70150 SWLCL-2020-K07	L.H.	20	20	125	24	7,9	25	0,2	0,50	N00 57531 S/M4,5x9-15IP 6,25 Nm	W01 42...		W01 42... W29 42...
D00 75150 SWLCR-2020-K07	R.H.											W01 42...	
D00 70160 SWLCL-2525-M09	L.H.	25	25	150	30	9,9	32	0,4	0,84	N00 57531 S/M4,5x9-15IP 6,25 Nm	W01 50...		W29 50...
D00 75160 SWLCR-2525-M09	R.H.											W01 50...	

For further details on inserts see chapter 5.

**Supply includes:** Turning tool with clamping screw ①.  
Please order insert separately. Screwdriver see chapter 7.

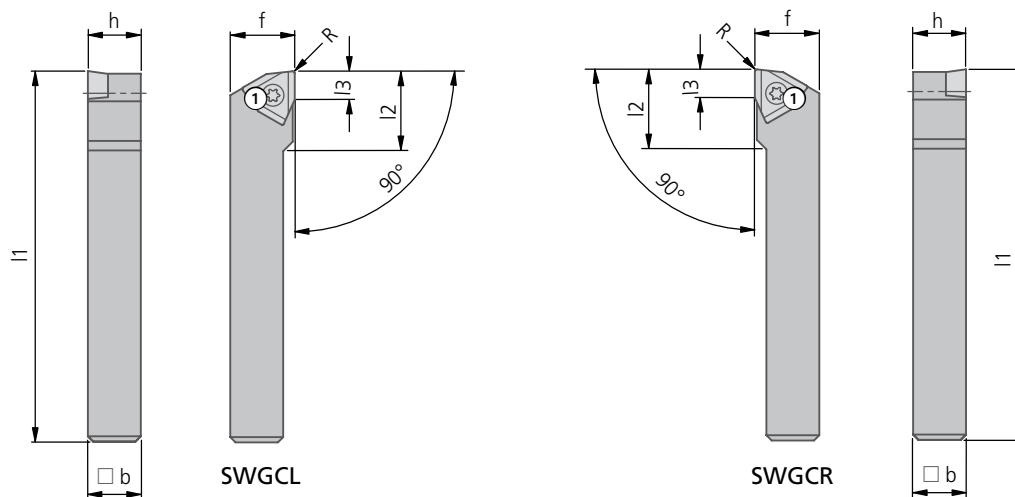
# KOMET® – External machining

## Turning tool $\alpha = 90^\circ$

for insert W01 / W29 ■

L.H. turning tool SWGCL with left or neutral insert ■

R.H. turning tool SWGCR with right or neutral insert ■



$\alpha = 90^\circ$										Insert			
Order No. Article	Cutting form	h	□ b	l1	l2	l3	f	for R	kg	Clamping screw ① Order No. Article	W01 L.H. Size ▼▼	W01 R.H. Size ▼▼	W01   W29 neutral Size ▼▼
D00 75010 SWGCR-0808-D05	R.H.	8	8	60	16	5,3	11	0,2	0,06	N00 57511 S/M2,5x7,2-8IP 1,28 Nm		W01 24...	W01 24... W29 24... W29 24160.04..
D00 70020 SWGCL-1010-E05	L.H.	10	10	70	16	5,3	12	0,2	0,09	N00 57511 S/M2,5x7,2-8IP 1,28 Nm	W01 24...	W01 24...	W01 24... W29 24... W29 24160.04..
D00 75020 SWGCR-1010-E05	R.H.				15								
D00 70030 SWGCL-1212-F05	L.H.	12	12	80	20	5,3	16	0,2	0,13	N00 57511 S/M2,5x7,2-8IP 1,28 Nm	W01 24...	W01 24...	W01 24... W29 24... W29 24160.04..
D00 75030 SWGCR-1212-F05	R.H.				19								
D00 70040 SWGCL-1616-H06	L.H.	16	16	100	22	6,6	20	0,2	0,27	N00 57521 S/M3,5x7,3-10IP 2,8 Nm	W01 34...	W01 34...	W01 34... W29 34... W29 34160.04..
D00 75040 SWGCR-1616-H06	R.H.				20								
D00 70050 SWGCL-2020-K07	L.H.	20	20	125	26	7,9	25	0,2	0,50	N00 57531 S/M4,5x9-15IP 6,25 Nm	W01 42...	W01 42...	W01 42... W29 42... W29 42160.04..
D00 75050 SWGCR-2020-K07	R.H.												
D00 70060 SWGCL-2525-M09	L.H.	25	25	150	33	9,9	32	0,4	0,84	N00 57531 S/M4,5x9-15IP 6,25 Nm	W01 50...	W01 50...	W29 50...
D00 75060 SWGCR-2525-M09	R.H.												
D00 70070 SWGCL-3232-P09	L.H.	32	32	170	34	9,9	40	0,4	1,45	N00 57531 S/M4,5x9-15IP 6,25 Nm	W01 50...	W01 50...	W29 50...
D00 75070 SWGCR-3232-P09	R.H.				33								

For further details on inserts see chapter 5.

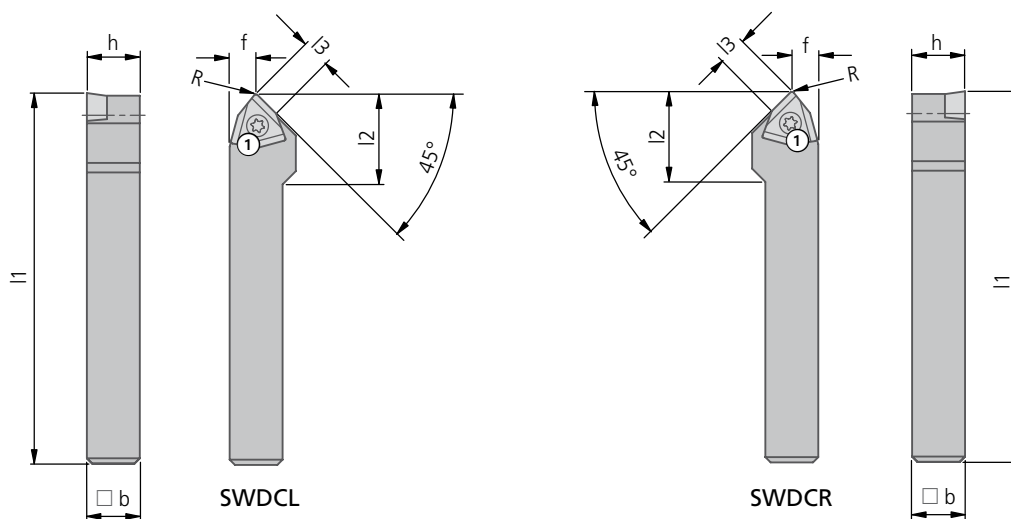
**Supply includes:** Turning tool with clamping screw ①.  
Please order insert separately. Screwdriver see chapter 7.



# KOMET® – External machining

## Turning tool $\kappa = 45^\circ$

- for insert W01 / W29
- L.H. turning tool SWDCL with left or neutral insert
- R.H. turning tool SWDCR with right or neutral insert



$\kappa = 45^\circ$										Insert			
Order No. Article	Cutting form	h	□ b	l1	l2	l3	f	for R	kg	Clamping screw ① Order No. Article	W01 L.H.  Size ▼	W01 R.H.  Size ▼	W01   W29 neutral  Size ▼
D00 75410 SWDCR-0808-D05	R.H.	8	8	60	18	5,3	5	0,2	0,06	N00 57511 S/M2,5x7,2-8IP 1,28 Nm		W01 24...	W01 24... W29 24...
D00 75420 SWDCR-1010-E05	R.H.	10	10	70	17	5,3	5	0,2	0,09	N00 57511 S/M2,5x7,2-8IP 1,28 Nm		W01 24...	W01 24... W29 24...
D00 75430 SWDCR-1212-F05	R.H.	12	12	80	18	5,3	6	0,2	0,13	N00 57511 S/M2,5x7,2-8IP 1,28 Nm		W01 24...	W01 24... W29 24...
D00 70440 SWDCL-1616-H06	L.H.	16	16	100	23	6,6	8	0,2	0,27	N00 57521 S/M3,5x7,3-10IP 2,8 Nm	W01 34...		W01 34... W29 34...
D00 75440 SWDCR-1616-H06	R.H.											W01 34...	
D00 70450 SWDCL-2020-K07	L.H.	20	20	125	10	7,9	10	0,2	0,50	N00 57531 S/M4,5x9-15IP 6,25 Nm	W01 42...		W01 42... W29 42...
D00 75450 SWDCR-2020-K07	R.H.											W01 42...	
D00 70460 SWDCL-2525-M09	L.H.	25	25	150	12,5	9,9	12,5	0,4	0,84	N00 57531 S/M4,5x9-15IP 6,25 Nm	W01 50...		W29 50...
D00 75460 SWDCR-2525-M09	R.H.											W01 50...	

For further details on inserts see chapter 5.

**Supply includes:** Turning tool with clamping screw ①.  
Please order insert separately. Screwdriver see chapter 7.



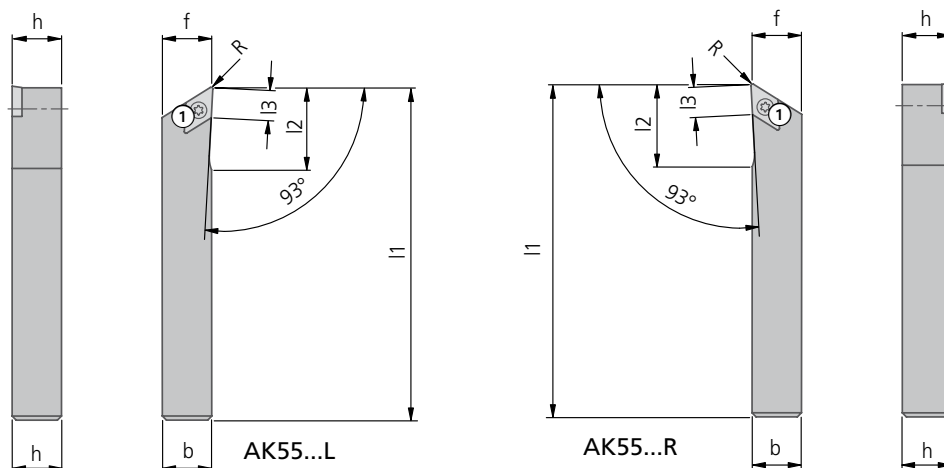
# KOMET® – External machining

## Turning tool $\kappa = 93^\circ$

for insert W60 / W79 ■

L.H. turning tool AK55...L with left or neutral insert ■

R.H. turning tool AK55...R with right or neutral insert ■



$\kappa = 93^\circ$										Insert			
Order No. Article	Cutting form	h	b	l1	l2	l3	f	for R		Clamping screw ①  Order No. Article	W60 L.H.  Size ▼	W60 R.H.  Size ▼	W60   W79 neutral  Size ▼
D01 25012 AK55-8J R	R.H.	8	8	80	20	7	10,3	0,4	0,08	N00 56651 S2560-8IP 1,28 Nm		W60 18...	W60 18... W79 18...
D01 25022 AK55-10J R	R.H.	10	10	90	20	7	10,3	0,4	0,10	N00 56651 S2560-8IP 1,28 Nm		W60 18...	W60 18... W79 18...
D01 25032 AK55-12J R	R.H.	12	12	100	20	7	12,3	0,4	0,14	N00 56651 S2560-8IP 1,28 Nm		W60 18...	W60 18... W79 18...
D01 20042 AK55-16J L	L.H.	16	16	110	20	7	20	0,4	0,25	N00 56651 S2560-8IP 1,28 Nm	W60 18...		W60 18... W79 18...
D01 25042 AK55-16J R	R.H.				24						W60 18...		
D01 20052 AK55-20J L	L.H.	20	20	120	30	11	25	0,8	0,46	N00 56751 S3574-10IP 2,8 Nm	W60 32...		W60 32... W79 32...
D01 25052 AK55-20J R	R.H.										W60 32...		
D01 20062 AK55-25J L	L.H.	25	25	150	30	11	32	0,8	0,82	N00 56751 S3574-10IP 2,8 Nm	W60 32...		W60 32... W79 32...
D01 25062 AK55-25J R	R.H.										W60 32...		

For further details on inserts see chapter 5.

**Supply includes:** Turning tool with clamping screw ①.

Please order insert separately. Screwdriver see chapter 7.

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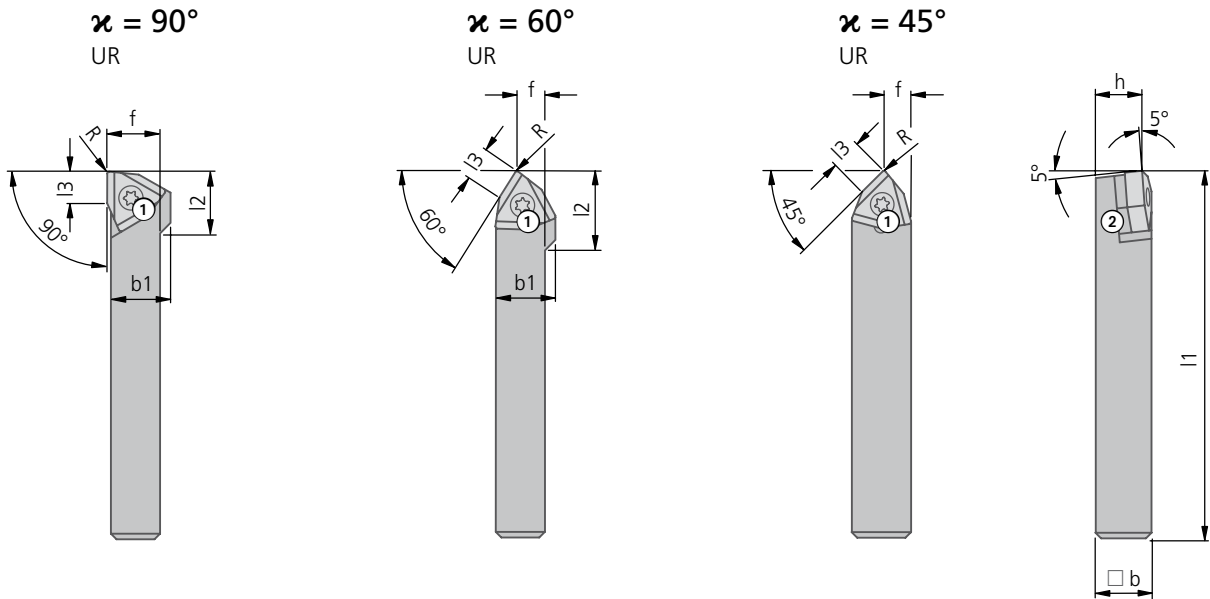
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# KOMET® – External machining

## Turning tool $\kappa = 90^\circ, 60^\circ$ and $45^\circ$

- for insert W04
- R.H. turning tool as shown with right insert



UR												Insert		
Order No. Article	Cutting form	□ b	b1	h	l1	l2	l3	f	for R	$\kappa$	kg	Clamping screw ①  Order No. Article $\varnothing$ WAF	Shim plate ② Order No. Size	W04 R.H. 
D10 15010 UR10 R 90°	R.H.	10	12,7	8,3	50	12	6,5	10,7	0,2	90°	0,04	N00 55060 M3,5×9,4/60° $\varnothing$ 1,5 2,8 Nm	–	W04 34480.02..
D10 15110 UR10 R 60°	R.H.	10	12,7	8,3	50	15	6,5	6,0	0,2	60°	0,04	N00 55060 M3,5×9,4/60° $\varnothing$ 1,5 2,8 Nm	–	W04 34480.02..
D10 15240 UR20 R 45°	R.H.	20	–	17,6	120	–	9,5	9,1	0,4	45°	0,35	N00 55120 M4,5×16,4 $\varnothing$ 2,5 4,5 Nm	L02 11110 2K	W04 50480.04..

For further details on inserts see chapter 5.

**Supply includes:** Turning tool with clamping screw ① and shim plate ②.  
Please order insert separately. Hexagonal key see chapter 7.

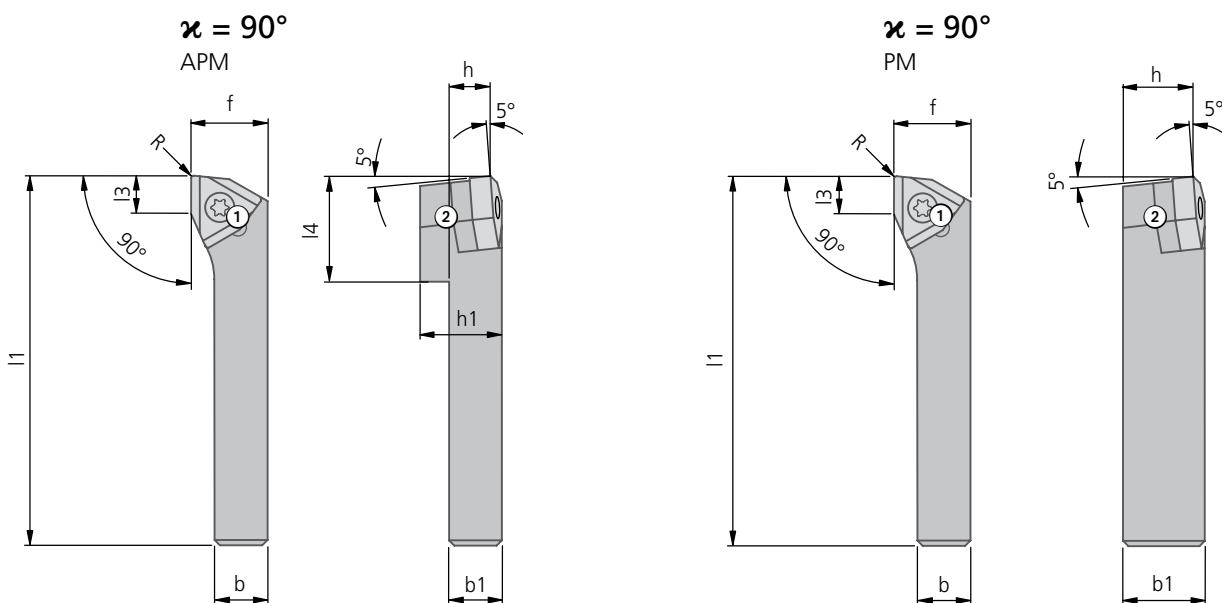
# KOMET® – External machining

## Turning tool $\kappa = 90^\circ$

for insert W04 ■

R.H. turning tool as shown with right insert ■

L.H. turning tool in mirror image with left insert ■



APM												Insert		
Order No. Article	Cutting form	b	b1	h	h1	l1	l2	l3	f	for R	kg	Clamping screw ①  Order No. Article $\varnothing$ WAF	Shim plate ②  Order No. Size	W04 R.H. 
D10 05010 APM10R	R.H.	10	10	8	17,7	115	22,5	7,5	16,8	0,2	0,12	N00 55110 M4,5×14,5 $\varnothing$ 2,5 4,5 Nm	L02 11040 16	W04 42480.02..
D10 05020 APM12R	R.H.	12	12	10	17,7	115	22,5	7,5	16,8	0,2	0,12	N00 55110 M4,5×14,5 $\varnothing$ 2,5 4,5 Nm	L02 11040 16	W04 42480.02..

PM												Insert	
Order No. Article	Cutting form	b	b1	h	l1	l3	f	for R	kg	Clamping screw ①  Order No. Article $\varnothing$ WAF	Shim plate ②  Order No. Size	W04 L.H. 	W04 R.H. 
D10 00030 PM1/16L	L.H.	16	17,7	15,7	140	7,5	19,8	0,2	0,31	N00 55110 M4,5×14,5 $\varnothing$ 2,5 4,5 Nm	L02 11040 16	W04 42180.02..	
D10 05030 PM1/16R	R.H.												W04 42480.02..
D10 00040 PM1L	L.H.	16	21,7	19,7	140	7,5	19,8	0,2	0,39	N00 55130 M4,5×18,7 $\varnothing$ 2,5 4,5 Nm	L02 11000 1	W04 42180.02..	
D10 05040 PM1R	R.H.												W04 42480.02..
D10 00050 PM2L	L.H.	20	26,1	23,7	165	9,5	24,0	0,4	0,67	N00 55140 M4,5×22,5 $\varnothing$ 2,5 4,5 Nm	L02 11010 2	W04 50180.04..	
D10 05050 PM2R	R.H.												W04 50480.04..

For further details on inserts see chapter 5.

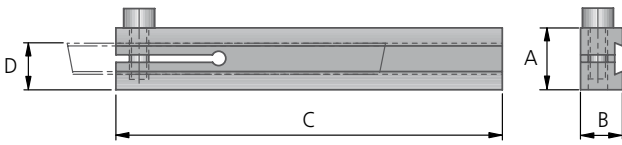
**Supply includes:** Turning tool with clamping screw ① and shim plate ②.

Please order insert separately. Hexagonal key see chapter 7.

# KOMET® – External machining

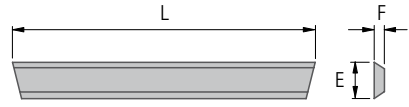
## Parting-off

**Holder**  
A00, A0

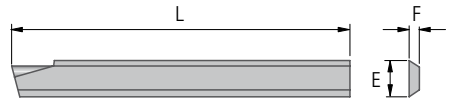


For this design, blades are clamped by pulling the slotted front section of the holder together.

**Blade**  
A00, A0



- HSS grade F
- for L.H. and R.H. use

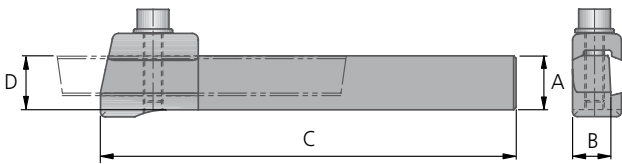


- carbide grade P20
- for R.H. use only
- blade with carbide insert



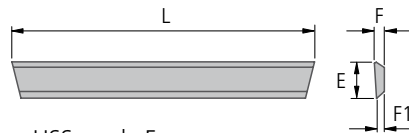
Holder							Blade						
Article	Order No.	A	B	C	D	kg	Article	Order No.	Grade	E	F	L	kg
A00	H01 15010	16	11	100	12	0,15	A00-F	H10 15010.91	F	8	2,2	75	0,010
A0	H01 15020	18	11	125	14	0,23	A0-F	H10 15020.91	F	10	2,7	100	0,019
							A0-R-P20	H10 15020.02	P20				

**Holder**  
A1/2A, A3A

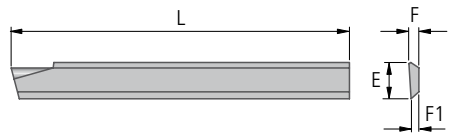


Also available for L.H. use.

**Blade**  
A1/2A, A3A



- HSS grade F
- for L.H. and R.H. use



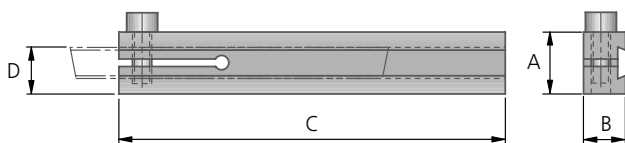
- carbide grade P20
- for R.H. use only
- blade with carbide insert



Holder							Blade							
Article	Order No.	A	B	C	D	kg	Article	Order No.	Grade	E	F	F1	L	kg
A1/2A	H01 15110	22	14,5	170	20	0,55	A1/2A-F	H10 15110.91	F	16	4	3	150	0,065
							A1/2A-R-P20	H10 15110.02	P20				100	0,044
A3A	H01 15130	27	18,0	210	25	1,00	A3A-F	H10 15130.91	F	18,5	5	4	150	0,095
							A3A-R-P20	H10 15130.02	P20				100	0,062

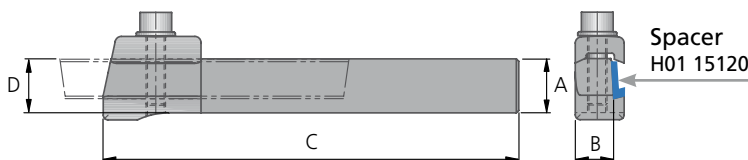
### Holder for grooving width 0,8 - 2,0 mm

AE



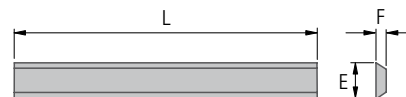
### Holder for grooving width 0,8 - 2,0 mm

A1/2A



### Blade

A0,9 - A2,15



- HSS grade F
- for L.H. and R.H. use

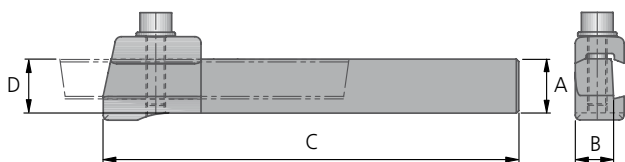


Holder						
Article	Order No.	A	B	C	D	kg
AE	H01 15030	18	11	125	14	0,23
A1/2A	H01 15110	22	14,5	170	20	0,55

Blade							
Article	Order No.	Grade	for grooving width	E	F	L	kg
A0,9-R-F	H10 15210.91	F	0,8	11	0,9	80	0,006
A1,1-R-F	H10 15220.91	F	1,0	11	1,1	80	0,007
A1,3-R-F	H10 15230.91	F	1,2	11	1,3	80	0,009
A1,6-R-F	H10 15240.91	F	1,5	11	1,6	80	0,010
A1,85-R-F	H10 15250.91	F	1,75	11	1,85	80	0,012
A2,15-R-F	H10 15260.91	F	2,0	11	2,15	80	0,014

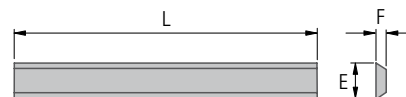
### Holder for grooving width 2,5 - 5,0 mm

A1/2A



### Blade

A2,65 - A5,15



- HSS grade F
- for L.H. and R.H. use



Holder						
Article	Order No.	A	B	C	D	kg
A1/2A	H01 15110	22	14,5	170	20	0,55

Blade							
Article	Order No.	Grade	for grooving width	E	F	L	kg
A2,65-R-F	H10 15270.91	F	2,5	16	2,65	150	0,038
A3,15-R-F	H10 15280.91	F	3,0	16	3,15	150	0,047
A4,15-R-F	H10 15290.91	F	4,0	16	4,15	150	0,066
A5,15-R-F	H10 15300.91	F	5,0	16	5,15	150	0,082

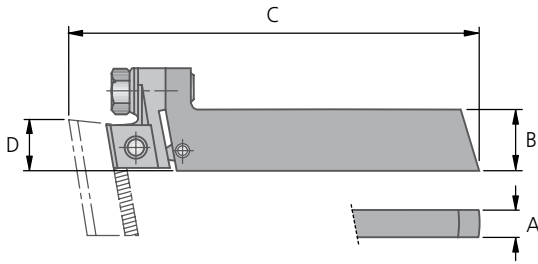


# KOMET® – External machining

## Threading

### Holder

Type FG, external, spring-loaded and adjustable



### External threading tool

- HSS grade F
- FG1 for 55° and 60° thread
- FG2 for 55°, 60° and acme thread



Holder						
Article	Order No.	A	B	C	D	kg
FG1	H04 15010	10	22	145	15	0,35
FG2	H04 15020	13	29	175	20	0,70

Grinding gauge  
H09 15500

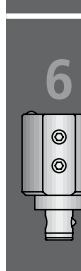
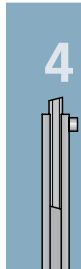
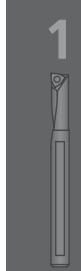
External threading tool					
Article	Order No.	Grade	for pitch	for holder	kg
FG1-55-F	H11 11000.91	F	up to 3 mm/rev or 8 T.P.I.	FG1	0,02
FG1-60-F	H11 12000.91				
FG2-55-F	H11 21000.91	F	up to 4 mm/rev or 6,5 T.P.I.	FG2	0,05
FG2-60-F	H11 22000.91				
FG2TR-4,0-F	H11 23040.91	F	4 mm		
FG2TR-5,0-F	H11 23050.91	F	5 mm		

Recommended application areas

Guideline values for external machining																
Material group	Strength Rm (N/mm <sup>2</sup> )	Hardness HB	Material	Material example, material code/DIN	Cutting speed v <sub>C</sub> (m/min)											
					Grade F			Grade H			Carbide Roughing			Carbide Finishing		
					min	opt.	max	min	opt.	max	min	opt.	max	min	opt.	max
P	1.0	≤500	non-alloy steels	1.0037 (S235JR) 1.0715 (11SMn30) 1.0044 (S2575JR)	10	25	40	15	30	45	40	70	100	50	85	120
	2.0	500-900	non-alloy / low alloy steels	1.0050 (E295) 1.0535 (C55) 1.7131 (16MnCr5)	8	22	35	8	19	30	30	60	90	40	70	100
	2.1	<500	lead alloys	1.0718 (11SMnPb30)	10	20	30	10	23	35	30	65	100	40	80	120
	3.0	>900	low alloy steels: heat resistant structural, heat treated, nitride and tools steels	1.7225 (42CrMo4) 1.1221 (C60E)	8	17	25	8	19	30	25	48	70	30	60	90
	4.0	>900	high alloy steels	1.2341 (6CrMo15-5) 1.2601 (X165Cr-MoV12)	15	20	25	16	23	30	20	40	60	20	45	65
4.1		HSS		5	8	10	6	9	12	15	28	40	15	33	50	
S	5.0	250	special alloys: Inconel, Hastelloy, Nimonic, stc.	2.4668 (NiCr-19Fe19Nb5Mo3) 2.4631 (Nimonic 80A)	5	7	8	4	7	9	10	15	20	10	18	25
	5.1	400	titanium, titanium alloys	3.7115 (TiAl5Sn2.5)	3	5	6	4	7	9	10	20	30	10	20	30
M	6.0	≤600	stainless steels	1.4306 (X2Cr-Ni19-11) 1.4401 (X5CrNi-Mo17-12-2)	10	13	15	10	13	15	20	35	50	20	35	50
	6.1	<900	stainless steels	1.4511 (X3CrNb17) 1.4571 (X10CrNiMo-Ti17-12-2)	8	12	15	8	12	15	20	35	50	20	35	50
	7.0	>900	stainless / fireproof steels	1.4713 (X10CrAlSi7) 1.4862 (X8NiCr-Si38-18)	6	8	10	6	8	10	15	28	40	15	28	40
K	8.0	180	gray cast iron	0.6025 (EN-GJL-250) 0.6035 (EN-GJL-350)	15	20	25	15	20	25	25	38	50	25	38	50
	8.1	250	alloy gray cast iron	0.6660 (GGL-NiCr20 2)	15	20	25	15	20	25	30	40	50	30	40	50
	9.0	≤600	spheroidal graphite cast iron, ferritic	0.7040 (EN-GJS-400-15)	20	25	30	20	25	30	35	48	60	35	48	60
	9.1	230	spheroidal graphite cast iron, ferritic/perlitic	0.7050 (EN-GJS-500-7) 0.7055 (GGG-55) 0.8055 (GTW-55)	20	25	30	20	25	30	35	48	60	35	48	60
	10.0	>600	spheroidal graphite cast iron, perlitic malleable iron	0.7060 (EN-GJS-600-3) 0.8165 (GTS-65)	15	20	25	15	20	25	25	38	50	25	38	50
	10.1	200	alloyed spheroidal graphite cast iron	0.7661 (EN-GJSA-XNiCr20-2)	12	16	20	12	16	20	25	38	50	25	38	50
	10.2	300	vermicular cast iron	EN-GJV Ti < 0,2 EN-GJV Ti > 0,2	10	15	20	10	15	20	25	38	50	25	38	50
N	12.0	90	copper alloy, brass, lead-alloy bronze, lead bronze: good cut	2.0375 (CuZn36Pb3) 2.1182.01 (G-CuPb15Sn)	60	80	100	60	80	100	120	150	180	120	150	180
	12.1	100	copper alloy, brass, bronze: average cut	2.0550 (CuZn40Al2) 2.0060 (E-Cu57)	30	50	70	30	50	70	120	160	200	120	160	200
	13.0	60	wrought aluminium alloys	3.3315 (AlMg1) 3.0517 (AlMnCu)	40	60	80	40	60	80	140	180	220	140	180	220
	13.1	75	cast alum. alloy: Si-content <10% magnesium alloy	3.3561 (G-AlMg5) 3.2373.61 (G-AlSi9Mg wa)	30	50	70	30	50	70	140	180	220	140	180	220
	14.0	100	cast alum.alloy: Si-content >10%	3.2381.01 (G-AlSi10Mg)	20	40	60	20	40	60	120	160	200	120	160	200
H	15.0	1400	hardened steels < 45 HRC													
	1800		hardened steels > 45 HRC													

Cutting values shown are values relating to the basic recommendations for cutting materials given.

Important: See chapter 7 for more application details and safety notes!



# KOMET®

## Cutting elements

KOMET® inserts and the appropriate tools provide the user with an efficient system for machining any materials.

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4



5





KOMET® Cutting elements

Page

Cutting tool materials

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Unisix® W00 – WOHX



W00..12 ▶ 64  
L.H. cutting form



W00..42 ▶ 64  
R.H. cutting form

Unisix® W01 – WOHX | WOGX



W01..65 ▶ 65  
L.H. cutting form



W01..66 ▶ 66  
R.H. cutting form



W01..60 ▶ 67  
neutral cutting form



W01..94 ▶ 68  
PCD / CBN

Unisix® W04 – WNHX



W04..18 ▶ 69  
L.H. cutting form



W04..48 ▶ 70  
R.H. cutting form

Unisix® W29 – WOEX | WOGX



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W30 – TOHX | TOGX



W30.. L.H. ▶ 80



W30.. R.H. ▶ 81



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W30..82 ▶ 83  
L.H. cutting form



W30..83 ▶ 84  
R.H. cutting form



W30..94 ▶ 85  
PCD / CBN



W30..98 ▶ 86  
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W57 – TOGX



W57..12 ▶ 88



W57..14 ▶ 89



W57..18 ▶ 90

W60 – DOHT | DOHW | DOGT | DOGW



W60.. ▶ 91  
L.H. cutting form



W60.. ▶ 92  
R.H. cutting form



W60..60 ▶ 93  
neutral cutting form



W60..98 ▶ 94  
W60..99 ▶ 95

W79 – DOHT



W79..06 ▶ 96

Numerical coding

97 – 99

1



2



3



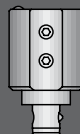
4



5



6



7



# Summary and list of codes

## Guidelines for selecting inserts

All dimensions shown are subject to tolerance in accordance with the relevant requirement.

Workpiece material	
Mild steel/tool steel	<b>P</b>
Stainless and acid-resistant steel	<b>M</b>
Grey cast iron, spheroidal cast iron	<b>K</b>
Non-ferrous metals	<b>N</b>
Heat-resistant steels	<b>S</b>
Hardened tool steel	<b>H</b>

## Key Abbreviations used

- d1 mm Incircle diameter
- s mm Indexable insert thickness
- l mm Theoretical usable length of cutting edge
- $\gamma$  ° Rake angle
- f mm Construction auxiliary dimension
- R mm Corner radius
- d2 mm Hole diameter

New 4-digit cutting material code e.g.

BK6115	Toughness grade (05...50)
	Coating type (e.g. CVD Al <sub>2</sub> O <sub>3</sub> )
	Cutting material designation: carbide + coating

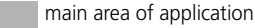
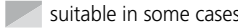
## Selecting the top rake

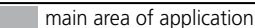
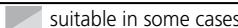
Recommendations for using inserts with ground chip grooves

(W00, W01, W04, W30, W32, W34, W37, W60)

	rounded	sharp-edged	chamfered
	<b>P</b>	<b>P</b>	<b>P</b>
	<b>M</b>	<b>M</b>	<b>M</b>
	<b>K</b>	<b>K</b>	<b>K</b>
	<b>N</b>	<b>N</b> PKD55 PKD5520	<b>N</b>
	<b>S</b>	<b>S</b>	<b>S</b>
<b>H</b>	<b>H</b>	<b>H</b>	
	<b>P</b>	<b>P</b>	<b>P</b>
	<b>M</b>	<b>M</b>	<b>M</b>
	<b>K</b>	<b>K</b>	<b>K</b>
	<b>N</b>	<b>N</b>	<b>N</b>
	<b>S</b>	<b>S</b>	<b>S</b>
<b>H</b>	<b>H</b>	<b>H</b>	
	<b>P</b>	<b>P</b>	<b>P</b>
	<b>M</b>	<b>M</b>	<b>M</b>
	<b>K</b>	<b>K</b>	<b>K</b>
	<b>N</b>	<b>N</b>	<b>N</b>
	<b>S</b>	<b>S</b>	<b>S</b>
<b>H</b>	<b>H</b>	<b>H</b>	
	<b>P</b>	<b>P</b>	<b>P</b>
	<b>M</b>	<b>M</b>	<b>M</b>
	<b>K</b>	<b>K</b>	<b>K</b>
	<b>N</b>	<b>N</b>	<b>N</b>
	<b>S</b>	<b>S</b>	<b>S</b>
<b>H</b>	<b>H</b>	<b>H</b>	

# Summary and list of codes



uncoated																		
Cutting material designation	Code	Norm code	Application range											Properties	Cutting element			
			Wear resistance						Toughness factor									
			01	05	10	15	20	25	30	35	40	45	50					
P25	12	HW-P25	P													uncoated: • with excellent wear resistance and good toughness factor • suitable for medium to high cutting speeds for roughing and finishing • for non-alloy steel, malleable cast iron, stainless steel and cast iron	W04..	
			M															
			K															
			N															
			S															
P25M	03	HW-P25	P													uncoated: • with excellent wear resistance and good toughness factor • suitable for medium to high cutting speeds for roughing and finishing, also for interrupted cut • for non-alloy steel, malleable cast iron, stainless steel and cast steel	W01 Q09 W27 Q36 W29 W30 W34 W59 W60 W79	
			M															
			K															
			N															
			S															
P40	04	HW-P40	P													uncoated: • with medium wear resistance at optimum toughness factor • low to medium cutting speeds for roughing and with heavily interrupted cut • also for unstable working conditions • for non-alloy steel, die steel and stainless steels	W00.. W04.. W27..01 W29..01 W29..13 W30..	
			M															
			K															
			N															
			S															
K10	21	HW-K10	P													uncoated: • chamfered and neutral cutter geometry suitable for all grades of cast iron • positively sintered (PD) and ground geometry is used for aluminium e.g.: 12° and 20° top rake, ground sharply and not rounded	W00 W37 W01 W59 W04 W60 W24 W79 W27 W83 W29 W85 W30 Q36 W32 W34	
			M															
			K															
			N															
			S															
			01	05	10	15	20	25	30	35	40	45	50	 main area of application  suitable in some cases				

CVD coated																		
Cutting material designation	Code	Norm code	Application range											Properties	Cutting element			
			Wear resistance						Toughness factor									
			01	05	10	15	20	25	30	35	40	45	50					
BK50	50	HC-K10	P													diamond coating: • crystalline diamond coating • for cutting aluminium alloys, abrasive materials, graphite, plastics and bonded materials at high cutting speeds	W24..11 W29..11 W32.. W85..	
			M															
			K															
			N															
			S															
BK60	60	HC-M10	P													CVD-TiC-TiCN-TiN: • multiple coating on P25M carbide base • high tool life, even in the higher cutting speed range	W29..15 W29..16 W57..14	
			M															
			K															
			N															
			S															
BK6110	6110	HC-P10	P													CVD-TiCN-TiN-Al <sub>2</sub> O <sub>3</sub> : • for final machining bores in cast iron and steel materials • excellent dimensional stability due to combination of wear resistant substrate and ceramic, surface treated coating	W30.. W59.. H80.. Q36..	
			M															
		HC-K10	K															
			N															
			S															
			01	05	10	15	20	25	30	35	40	45	50	 main area of application  suitable in some cases				







# Summary and list of codes

PVD coated																	
Cutting material designation	Code	Norm code	Application range											Properties	Cutting element		
			Wear resistance Toughness factor														
			01	05	10	15	20	25	30	35	40	45	50				
BK2710	2710	HC-K10	P													PVD-TiAlN: • extremely wear resistant carbide • for bore end machining stainless steels, structural and tool steels and cast materials • excellent dimensional stability due to combination of hard substrate and TiAlN coating with high aluminium content	W00.. W30.. W60.. W79.. H80..
BK2730	2730	HC-M25	P													PVD-TiAlN: • extremely fine grades • extremely good edge stability and maximum wear resistance at medium and high speed ranges	W29..20 W82..21 Q80..
BK77	77	HC-K10	P													PVD-TiN: • wear-resistant PVD-coated grade • for cutting aluminium alloys and plastics at medium cutting speeds • sufficient properties of toughness and a high level of resistance against the formation of build-up on the cutting edges	W24..11 W29..11 W30.. W85..
BK7710	7710	HC-K10	P													PVD-TiB <sub>2</sub> : • coating on extremely high wear resistance K10 carbide • for finish and rough machining aluminium up to approx. 10% Si content and titanium alloys • optimum coating properties to prevent build-up on cutting edges	W29..11 W32.. W57..12 W58..12 W80..01 W82..21 W83..21 H62..
BK79	79	HC-M35	P													PVD-TiAlN: • coated carbide on P40 base substrate with very high reserves of toughness • low to medium cutting speed for roughing and finishing and with interrupted cut • for non-alloy steel, cast steel, die steels and rust-proof and stainless steels	W24..13 W27..01 W27..10 W29..01 W29..13 W59..
BK7930	7930	HC-M25	P													PVD-TiAlN: • extremely efficient combination of extremely fine grade carbide • for use on solid drills for stainless and acid resistant steels	W29..01 H72..
BK8425	8425	HC-P25	P													PVD-TiAlN/TiN: • grade for universal application with increased wear resistance due to innovative PVD coating in multi-layer Ausführung	W01 H70 W29 Q09 W30 Q12 W59 Q15 W80 Q36 W83
BK8430	8430	HC-P30	P													PVD-TiAlN/TiN: • extremely fine grades • extremely good edge stability and maximum wear resistance at medium and high speed ranges	W29..15 W29..16 W29..20 W57..14 W57..18 W80..03 W83..03 W83..21
BK8440	8440	HC-P35	P													PVD-TiCN/TiN: • coating on extremely tough substrate • for medium cutting speeds and also suitable for interrupted cut	W00.. H60.. Q15..
				01	05	10	15	20	25	30	35	40	45	50	 main area of application  suitable in some cases		



# Summary and list of codes

Cermets uncoated															
Cutting material designation	Code	Norm code	Application range										Properties	Cutting element	
			Wear resistance					Toughness factor							
			01	05	10	15	20	25	30	35	40	45	50		
CK30	30	HT-P15	P	[Main area of application: 01-15]										uncoated: • for fine and finish turning • high toughness factor, low wear and comparatively high cutting speeds produce longer tool life and high surface quality	W30..
			M	[Main area of application: 05-20]											
			K	[Main area of application: 10-25]											
			N	[Main area of application: 15-30]											
			S	[Main area of application: 20-35]											
		H	[Main area of application: 25-40]												
CK32	32	HT-P15	P	[Main area of application: 01-15]										uncoated: • for fine and finish turning • low wear and higher cutting speed producing longer tool life and good surface finish • cutting material for high productivity in the upper cutting speed range	W30.. W57..18 W79..
			M	[Main area of application: 05-20]											
			K	[Main area of application: 10-25]											
			N	[Main area of application: 15-30]											
			S	[Main area of application: 20-35]											
		H	[Main area of application: 25-40]												
CK3210	3210	HT-P10	P	[Main area of application: 01-15]										uncoated: • for fine and finish turning • low wear and higher cutting speed producing longer tool life and good surface finish • cutting material for high productivity in the upper cutting speed range	W57..14
			M	[Main area of application: 05-20]											
			K	[Main area of application: 10-25]											
			N	[Main area of application: 15-30]											
			S	[Main area of application: 20-35]											
		H	[Main area of application: 25-40]												
CK3230	3230	HT-P20	P	[Main area of application: 01-15]										uncoated: • extremely tough behaviour and good wear resistance • also suitable for use in interrupted cut	W57..14
			M	[Main area of application: 05-20]											
			K	[Main area of application: 10-25]											
			N	[Main area of application: 15-30]											
			S	[Main area of application: 20-35]											
		H	[Main area of application: 25-40]												
CK37	37	HT-P20	P	[Main area of application: 01-15]										uncoated: • good balance of wear resistance and toughness • allows interrupted cuts and light roughing operations	W29..00 W30.. W79.. Q09..
			M	[Main area of application: 05-20]											
			K	[Main area of application: 10-25]											
			N	[Main area of application: 15-30]											
			S	[Main area of application: 20-35]											
		H	[Main area of application: 25-40]												

Cermets coated															
Cutting material designation	Code	Norm code	Application range										Properties	Cutting element	
			Wear resistance					Toughness factor							
			01	05	10	15	20	25	30	35	40	45	50		
CK38	38	HC-P10	P	[Main area of application: 01-15]										PVD-TiCN/TiN: • high toughness factor and extremely good wear resistance • this cutting material has a wide range of applications in non-alloy and alloy steel, die steel, rust-resistant and stainless steels and cast irons	W30..
			M	[Main area of application: 05-20]											
			K	[Main area of application: 10-25]											
			N	[Main area of application: 15-30]											
			S	[Main area of application: 20-35]											
		H	[Main area of application: 25-40]												
			01	05	10	15	20	25	30	35	40	45	50	 main area of application	 suitable in some cases

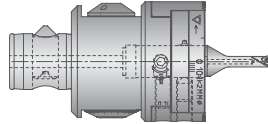


Inserts



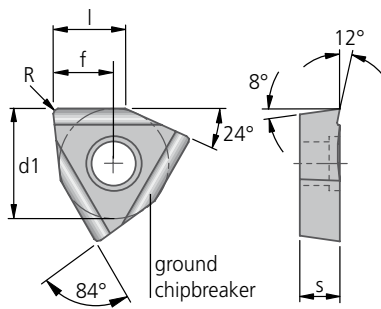
Application range:

- MicroKom *BluFlex*® and MicroKom® *hi.flex* Ø 6-8 mm
- External and internal turning
- Special tools
- positive cutter geometry produces efficient cutting results
- particularly suitable for low output machines and unstable workpieces
- good, controllable chip formation in materials with low tensile strength



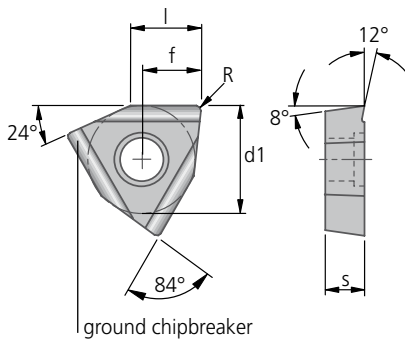
Cutter geometry:

L.H. cutting form „L“



Substrate		Carbide										
Coating type		-	-	PVD	PVD	CVD						
Cutting material designation		P40	K10	BK2710	BK8440	BK6440						
Cutting edge design		E	F	E	E	E						
ISO Code	Order No.						d1	s	l	γ	f	R
Cutting edge design E = rounded F = sharp		Enter code		04	21	2710	8440	6440				
WOHX 02T001..L-G12	W00 04120.01..	▲	▲	▲	▲	▲	4,0	1,2	2,6	12°	2,20	0,1
WOHX 02T002..L-G12	W00 04120.02..			▲	▲						2,19	0,2
Mild steel/tool steel	P	●	●	●	●	●	Order example: ISO Code WOHX 02T001 FL-G12 Cutting material K10 Order No. W00 04120.0121					
Stainless and acid-resistant steel	M	●	●	●	●	●						
Grey cast iron, spheroidal cast iron	K	●	●	●	●	●						
Non-ferrous metals	N	●	●	●	●	●						
Heat-resistant steels	S	●	●	●	●	●						
Hardened tool steel	H	●	●	●	●	●						

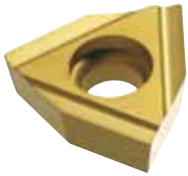
R.H. cutting form „R“



Substrate		Carbide										
Coating type		-	PVD	PVD	CVD							
Cutting material designation		P40	BK2710	BK8440	BK6440							
Cutting edge design		E	E	E	E							
ISO Code	Order No.					d1	s	l	γ	f	R	
Cutting edge design E = rounded		Enter code		04	2710	8440	6440					
WOHX 02T001..R-G12	W00 04420.01..	▲	▲	▲	▲	4,0	1,2	2,6	12°	2,20	0,1	
WOHX 02T002..R-G12	W00 04420.02..		▲	▲						2,19	0,2	
Mild steel/tool steel	P	●	●	●	●	●	Order example: ISO Code WOHX 02T001 ER-G12 Cutting material BK2710 Order No. W00 04420.012710					
Stainless and acid-resistant steel	M	●	●	●	●	●						
Grey cast iron, spheroidal cast iron	K	●	●	●	●	●						
Non-ferrous metals	N	●	●	●	●	●						
Heat-resistant steels	S	●	●	●	●	●						
Hardened tool steel	H	●	●	●	●	●						

● Main area of application ● Suitable in some cases  
▲ Availability: for delivery see current price and stock list

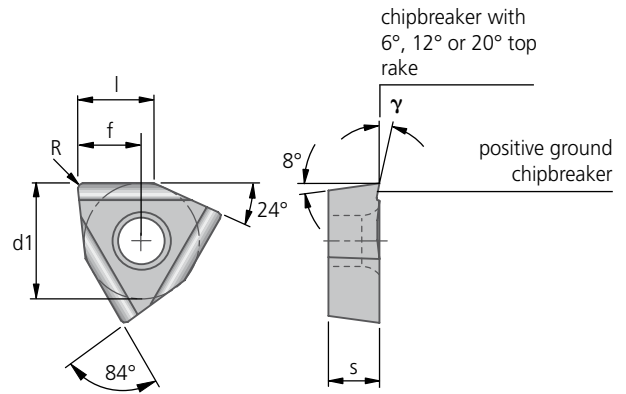




Application range:

- External and internal turning
- TwinKom® Double Insert Tools
- Special tools
- Kometric® mounted seatings
- positive cutter geometry produces efficient cutting results
- particularly suitable for low output machines and unstable workpieces
- good, controllable chip formation in materials with low tensile strength

Cutter geometry:



Substrate		Carbide											
Coating type		-	-	-	CVD	CVD	PVD						
Cutting material designation		P25M	K10	K10	BK6425	BK6115	BK8425						
Cutting edge design		E	E	F	E	E	E						
ISO Code	Order No.							d1	s	l	γ	f	R
Cutting edge design E = rounded F = sharp		03	21	21	6425	6115	8425						
Enter code													
WOHX 030204..L-G06	W01 10060.04..						▲	5,0	2,3	3,2	6°	2,73	0,4
WOHX 030204..L-G12	W01 10120.04..	▲		▲			▲				12°	2,72	0,4
WOHX 040304..L-G12	W01 18120.04..			▲	▲		▲	6,35	3,18	4,1	12°	3,47	0,4
WOHX 05T302..L-G06	W01 24060.02..	▲	▲		▲		▲	8,0	3,8	5,3	6°	4,42	0,2
WOHX 05T304..L-G06	W01 24060.04..					▲						4,40	0,4
WOHX 05T302..L-G12	W01 24120.02..	▲			▲		▲	8,0	3,8	5,3	12°	4,42	0,2
WOHX 05T304..L-G12	W01 24120.04..	▲		▲	▲		▲					4,40	0,4
WOHX 06T302..L-G06	W01 34060.02..	▲	▲		▲		▲	10,0	3,8	6,6	6°	5,53	0,2
WOHX 06T304..L-G06	W01 34060.04..					▲	▲					5,51	0,4
WOHX 06T302..L-G12	W01 34120.02..	▲					▲					5,53	0,2
WOHX 06T304..L-G12	W01 34120.04..	▲		▲	▲		▲	10,0	3,8	6,6	12°	5,51	0,4
WOHX 080402..L-G06	W01 42060.02..	▲			▲		▲	12,0	4,8	7,9	6°	6,64	0,2
WOHX 080404..L-G06	W01 42060.04..		▲			▲						6,62	0,4
WOHX 080402..L-G12	W01 42120.02..				▲		▲	12,0	4,8	7,9	12°	6,64	0,2
WOHX 080404..L-G12	W01 42120.04..	▲		▲	▲		▲					6,62	0,4
WOHX 100504..L-G06	W01 50060.04..	▲	▲		▲		▲	15,0	5,3	9,9	6°	8,29	0,4
WOHX 100504..L-G12	W01 50120.04..			▲			▲					8,29	0,4
WOHX 120606..L-G06	W01 58060.06..						▲	17,6	6,0	11,6	6°	9,71	0,6
WOHX 120606..L-G12	W01 58120.06..						▲				12°	9,71	0,6
Mild steel/tool steel	P	●	●	●	●	●	●	Order example: ISO Code WOHX 030204 EL-G06 Cutting material BK8425 Order No. W01 10060.048425					
Stainless and acid-resistant steel	M	●	●	●	●	●	●						
Grey cast iron, spheroidal cast iron	K		●	●		●							
Non-ferrous metals	N		●	●									
Heat-resistant steels	S		●	●									
Hardened tool steel	H												

● Main area of application ● Suitable in some cases

Important: See chapter 7 for more application details and safety notes!



## Inserts

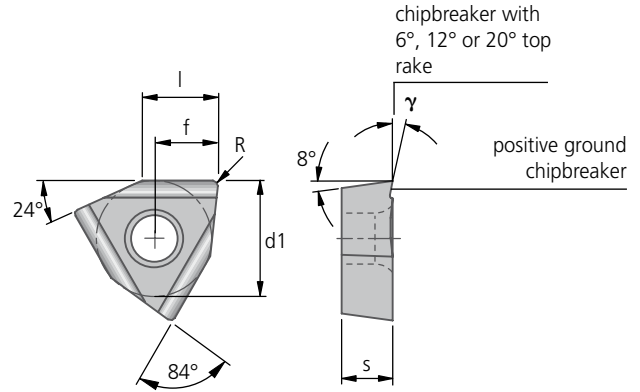
R.H. cutting form „R“



### Application range:

- External and internal turning
- TwinKom® Double Insert Tools
- Special tools
- Kometric® mounted seatings
- positive cutter geometry produces efficient cutting results
- particularly suitable for low output machines and unstable workpieces
- good, controllable chip formation in materials with low tensile strength

### Cutter geometry:



Substrate		Carbide										
Coating type		-	-	CVD	CVD	PVD						
Cutting material designation		P25M	K10	BK6425	BK6115	BK8425						
Cutting edge design		E	F	E	E	E						
ISO Code	Order No.						d1	s	l	γ	f	R
Cutting edge design E = rounded F = sharp	Enter code	03	21	6425	6115	8425						
WOHX 030204..R-G06	W01 10360.04..					▲	5,0	2,3	3,2	6°	2,73	0,4
WOHX 030204..R-G12	W01 10420.04..					▲				12°	2,72	0,4
WOHX 040304..R-G06	W01 18360.04..			▲		▲	6,35	3,18	4,1	6°	3,48	0,4
WOHX 040304..R-G12	W01 18420.04..					▲				12°	3,47	0,4
WOHX 05T304..R-G06	W01 24360.04..				▲		8,0	3,8	5,3	6°	4,40	0,4
WOHX 05T302..R-G12	W01 24420.02..	▲	▲	▲		▲				12°	4,42	0,2
WOHX 06T302..R-G06	W01 34360.02..	▲					10,0	3,8	6,6	6°	5,53	0,2
WOHX 06T304..R-G06	W01 34360.04..				▲						5,51	0,4
WOHX 06T302..R-G12	W01 34420.02..	▲		▲		▲	10,0	3,8	6,6	12°	5,53	0,2
WOHX 080402..R-G06	W01 42360.02..	▲					12,0	4,8	7,9	6°	6,64	0,2
WOHX 080404..R-G06	W01 42360.04..			▲	▲						6,62	0,4
WOHX 080402..R-G12	W01 42420.02..	▲	▲	▲		▲					6,64	0,2
WOHX 080404..R-G12	W01 42420.04..					▲	12,0	4,8	7,9	12°	6,62	0,4
WOHX 100504..R-G06	W01 50360.04..	▲					15,0	5,3	9,9	6°	8,29	0,4
WOHX 100504..R-G12	W01 50420.04..	▲				▲				12°	8,29	0,4
Mild steel/tool steel	P	●	●	●	●	●	Order example: ISO Code WOHX 030204 ER-G12 Cutting material BK8425 Order No. W01 10420.048425					
Stainless and acid-resistant steel	M	●	●	●	●	●						
Grey cast iron, spheroidal cast iron	K		●		●							
Non-ferrous metals	N		●									
Heat-resistant steels	S		●									
Hardened tool steel	H					●						

● Main area of application ○ Suitable in some cases

▲ Availability: for delivery see current price and stock list

# WOHX

# KOMET Unisix® W01..60



## Inserts

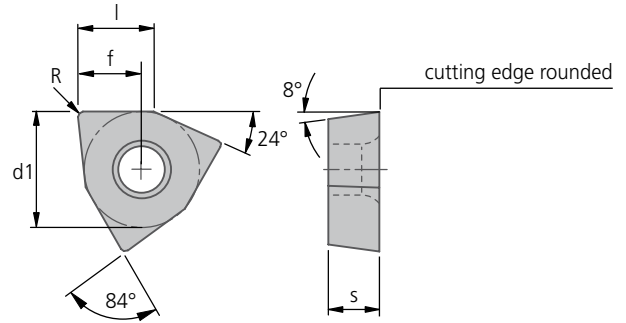
neutral cutting form „N“

### Application range:

Rough boring and turning operations on grey cast iron and SG cast iron materials

- roughing and standard machining under difficult operating conditions (interrupted cut or variations in machining allowances)
- grey cast iron and SG cast iron materials
- can be used on G01 twin cutting tools and on special tools
- extremely efficient because of high cutting speeds

### Cutter geometry:



Substrate		Carbide						
Coating type		-		CVD				
Cutting material designation		K10		BK7615				
Cutting edge design		E		E				
ISO Code	Order No.			d1	s	l	f	R
Cutting edge design E = rounded	Enter code	21	7615					
WOHX 040304 EN	W01 18600.04..	▲	▲	6,35	3,18	4,1	3,48	0,4
WOHX 05T304 EN	W01 24600.04..	▲	▲	8,0	3,8	5,3	4,40	0,4
WOHX 05T308 EN	W01 24600.08..						4,35	0,8
WOHX 06T304 EN	W01 34600.04..	▲	▲	10,0	3,8	6,6	5,51	0,4
WOHX 06T308 EN	W01 34600.08..						5,47	0,8
WOHX 080404 EN	W01 42600.04..		▲	12,0	4,8	7,9	6,62	0,4
WOHX 080408 EN	W01 42600.08..		▲				6,58	0,8
Mild steel/tool steel	P	●		Order example: ISO Code WOHX 030204 EN Cutting material BK7615 Order No. W01 10600.047615				
Stainless and acid-resistant steel	M							
Grey cast iron, spheroidal cast iron	K	●	●					
Non-ferrous metals	N	●						
Heat-resistant steels	S	●						
Hardened tool steel	H		● <52HRC					

● Main area of application ● Suitable in some cases

Important: See chapter 7 for more application details and safety notes!



# KOMET Unisix® W01..94

WOGX

## Inserts

neutral cutting form „N“



### Application range:

#### PCD application range

Machining non-ferrous metals, plastics, composites, rubber, graphite, etc.

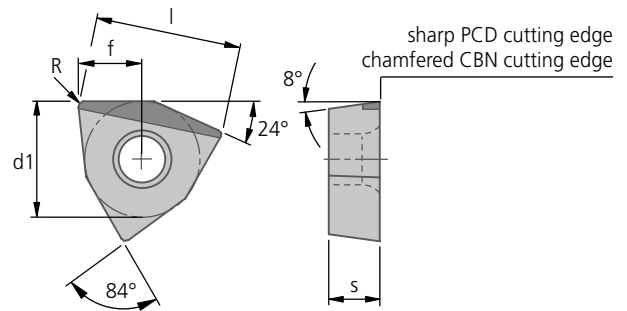
#### CBN application range (CBN57)

Machining cast iron materials etc.

Inserts with PCD and CBN cutting edges have the following advantages:

- high cutting speeds
- high dimensional consistency
- enormously long tool life
- above-average surface finish

### Cutter geometry:



Substrate		PCD	CBN					
Coating type		–	–					
Cutting material designation		PKD55	CBN57					
Cutting edge design		F	S					
ISO Code	Order No.			d1	s	l	f	R
Cutting edge design S = chamfered+rounded F = sharp		55	57					
Enter code		▲	▲					
WOGX 05T304 ..	W01 24940.04..	▲	▲	8,0	3,8	10,1	4,40	0,4
WOGX 06T304 ..	W01 34940.04..	▲	▲	10,0	3,8	12,7	5,51	0,4
WOGX 080404 ..	W01 42940.04..	▲		12,0	4,8	15,3	6,62	0,4
Mild steel/tool steel	<b>P</b>			Order example: ISO Code WOGX 05T304 S Cutting material CBN57 Order No. W01 24940.0457				
Stainless and acid-resistant steel	<b>M</b>							
Grey cast iron, spheroidal cast iron	<b>K</b>							
Non-ferrous metals	<b>N</b>	●	●					
Heat-resistant steels	<b>S</b>		●					
Hardened tool steel	<b>H</b>		●					

- Main area of application
- Suitable in some cases
- ▲ Availability: for delivery see current price and stock list

# WNHX

# KOMET Unisix® W04..18



## Inserts

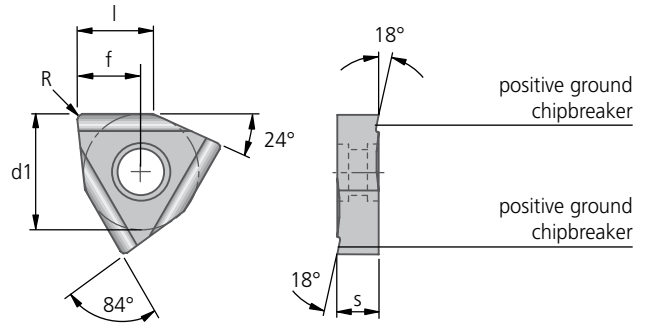
positive ground chipbreaker  
L.H. cutting form „L“  
P6 cutting edges

### Application range:

#### Internal and external turning

The Unisix® insert with 6 cutting edges is an efficient and economic insert. The six cutting edges can be used because of the negative insert seating. The positively ground chipbreakers guarantee a good chip form and a soft cut.

### Cutter geometry:



Substrate		Carbide								
Coating type		-	-	-	CVD					
Cutting material designation		P25	P40	K10	BK6425					
Cutting edge design		E	E	F	E					
ISO Code	Order No.					d1	s	l	f	R
Cutting edge design E = rounded F = sharp	Enter code	12	04	21	6425					
WNHX 060302..L-G18	W04 34180.02..	▲				10,0	3,5	6,5	5,53	0,2
WNHX 08T302..L-G18	W04 42180.02..	▲	▲	▲	▲	12,0	4,5	7,5	6,64	0,2
WNHX 100404..L-G18	W04 50180.04..	▲	▲			15,0	5,0	9,5	8,29	0,4
Mild steel/tool steel	P	●	●	◐	●	Order example: ISO Code WNHX 060302 EL-G18 Cutting material P25 Order No. W04 34180.0212				
Stainless and acid-resistant steel	M	●	●		●					
Grey cast iron, spheroidal cast iron	K			●						
Non-ferrous metals	N			●						
Heat-resistant steels	S			●						
Hardened tool steel	H									

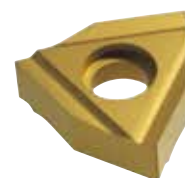
● Main area of application ◐ Suitable in some cases

Important: See chapter 7 for more application details and safety notes!



Inserts

positive ground chipbreaker  
 R.H. cutting form „R”  
 P6 cutting edges

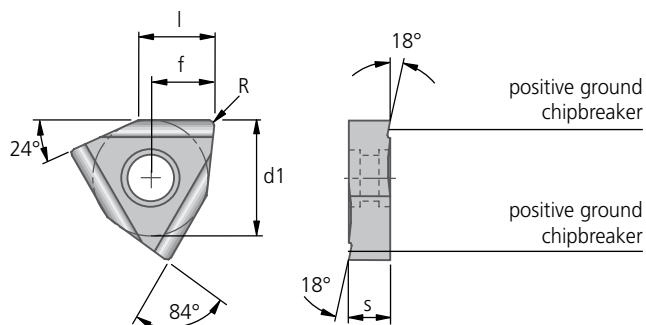


Application range:

Internal and external turning

The Unisix® insert with 6 cutting edges is an efficient and economic insert. The six cutting edges can be used because of the negative insert seating. The positively ground chipbreakers guarantee a good chip form and a soft cut.

Cutter geometry:



Substrate		Carbide								
Coating type		-	-	-	CVD					
Cutting material designation		P25	P40	K10	BK6425					
Cutting edge design		E	E	F	E					
ISO Code	Order No.					d1	s	l	f	R
WNHX 060302..R-G18	W04 34480.02..	▲				10,0	3,5	6,5	5,53	0,2
WNHX 08T302..R-G18	W04 42480.02..	▲	▲	▲	▲	12,0	4,5	7,5	6,64	0,2
WNHX 08T304..R-G18	W04 42480.04..	▲							6,62	0,4
WNHX 100404..R-G18	W04 50480.04..	▲	▲	▲	▲	15,0	5,0	9,5	8,29	0,4
WNHX 120606..R-G18	W04 58480.06..	▲				17,6	6,0	11,5	9,71	0,6
Mild steel/tool steel	P	●	●	●	●	Order example: ISO Code WNHX 060302ER-G18 Cutting material P25 Order No. W04 34480.0212				
Stainless and acid-resistant steel	M	●	●		●					
Grey cast iron, spheroidal cast iron	K			●						
Non-ferrous metals	N			●						
Heat-resistant steels	S			●						
Hardened tool steel	H									

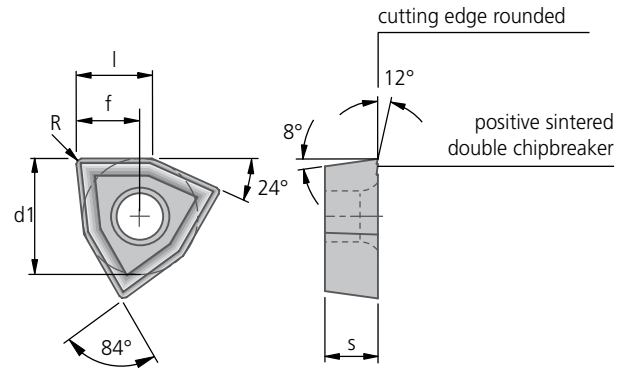
● Main area of application ● Suitable in some cases  
 ▲ Availability: for delivery see current price and stock list



Application range:

- External and internal turning
- TwinKom® Double Insert Tools
- Special tools
- Kometric® mounted seatings
- as outer cutter with KUB® solid drill bit
- positive cutter geometry produces efficient cutting results
- particularly suitable for low output machines and unstable workpieces
- good, controllable chip formation in materials with low tensile strength

Cutter geometry:



Substrate		Carbide											
Coating type		-	-	CVD	CVD	CVD	CVD	PVD					
Cutting material designation		P25M	K10	BK6425	BK7615	BK6115	BK6440	BK8425					
ISO Code	Order No.								d1	s	l	f	R
	Enter code ▼	03	21	6425	7615	6115	6440	8425					
WOEX 05T304-00	W29 24000.04..	▲	▲	▲	▲	▲	▲	▲	8,0	3,8	5,3	4,40	0,4
WOEX 06T304-00	W29 34000.04..	▲	▲	▲	▲	▲	▲	▲	10,0	3,8	6,6	5,51	0,4
WOEX 080404-00	W29 42000.04..	▲	▲	▲	▲	▲	▲	▲	12,0	4,8	7,9	6,62	0,4
WOEX 100504-00	W29 50000.04..	▲	▲	▲		▲	▲	▲	15,0	5,3	9,9	8,29	0,4
WOEX 100508-00	W29 50000.08..					▲	▲						
WOEX 120608-00	W29 58000.08..		▲	▲		▲	▲	▲	17,6	6,0	11,6	9,69	0,8
Mild steel/tool steel	P	●	●	●		●	●	●	Order example: ISO Code WOEX 05T304-00 Cutting material P25M Order No. W29 24000.0403				
Stainless and acid-resistant steel	M	●	●	●		●	●	●					
Grey cast iron, spheroidal cast iron	K		●		●								
Non-ferrous metals	N		●										
Heat-resistant steels	S		●										
Hardened tool steel	H				●								
External cutting edge		✓	✓	✓	✓	✓	✓	✓					
Internal cutting edge Recommendation		W29..01 – BK8425											

● Main area of application ● Suitable in some cases



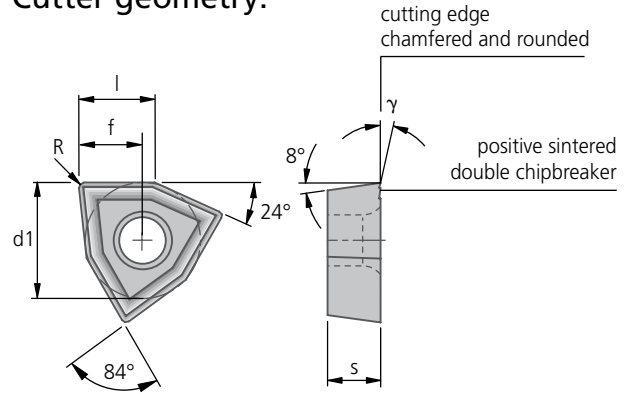
## Inserts



### Application range:

- External and internal turning
- KUB Centron®, KUB Trigon®, KUB® drill
- TwinKom® Double Insert Tools
- Special tools
- Kometric® mounted seatings
- positive cutter geometry produces efficient cutting results
- particularly suitable for low output machines and unstable workpieces
- good, controllable chip formation in materials with low tensile strength

### Cutter geometry:



Substrate		Carbide																		
Coating type		-	-	-	CVD	CVD	CVD	CVD	CVD	CVD	PVD	PVD	PVD							
Cutting material designation		P25M	P40	K10	BK 6425	BK 7615	BK 6115	BK 62	BK 6440	BK 6420	BK 72	BK 79	BK 7930	BK 8425						
ISO Code	Order No.														d1	s	l	γ	f	R
Enter code ▼		03	04	21	6425	7615	6115	62	6440	6420	72	79	7930	8425						
WOEX 020102-01	W29 04010.02..											▲		▲	4,0	1,6	2,6	12°	2,19	0,2
WOEX 030204-01	W29 10010.04..		▲	▲		▲	▲	▲				▲		▲	5,0	2,3	3,2	8°	2,73	0,4
WOEX 040304-01	W29 18010.04..		▲	▲		▲	▲	▲				▲		▲	6,35	3,18	4,1	8°	3,48	0,4
WOEX 05T304-01	W29 24010.04..	▲	▲	▲	▲	▲	▲	▲	▲	▲	▲		▲	▲	8,0	3,8	5,3	12°	4,40	0,4
WOEX 05T308-01	W29 24010.08..	▲	▲	▲	▲	▲	▲	▲	▲	▲		▲		▲					4,35	0,8
WOEX 06T304-01	W29 34010.04..	▲	▲	▲	▲	▲	▲	▲	▲	▲	▲		▲	▲	10,0	3,8	6,6	12°	5,51	0,4
WOEX 06T308-01	W29 34010.08..			▲	▲	▲	▲	▲	▲	▲	▲	▲		▲					5,47	0,8
WOEX 080404-01	W29 42010.04..	▲	▲	▲	▲	▲	▲	▲	▲	▲	▲		▲	▲	12,0	4,8	7,9	12°	6,62	0,4
WOEX 080408-01	W29 42010.08..	▲	▲	▲	▲	▲	▲	▲	▲	▲		▲		▲					6,58	0,8
WOEX 100504-01	W29 50010.04..	▲	▲	▲	▲	▲	▲	▲	▲	▲	▲		▲	▲	15,0	5,3	9,9	12°	8,29	0,4
WOEX 100508-01	W29 50010.08..	▲	▲	▲	▲	▲	▲	▲	▲	▲	▲	▲		▲					8,24	0,8
WOEX 120608-01	W29 58010.08..	▲	▲	▲	▲	▲	▲	▲	▲	▲	▲		▲	▲	17,6	6,0	11,6	12°	9,69	0,8
Mild steel/tool steel	P	●	●	●	●		●		●	●	●	●	●	●	Order example: ISO Code WOEX 05T304-01 Cutting material P25M Order No. W29 24010.0403					
Stainless and acid-resistant steel	M	●	●		●		●		●	●	●	●	●	●						
Grey cast iron, spheroidal cast iron	K			●			●		●	●	●		●	●						
Non-ferrous metals	N			●																
Heat-resistant steels	S			●																
Hardened tool steel	H						⊙		⊙											
External cutting edge		✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓						
Internal cutting edge Recommendation		✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓						

● Main area of application ○ Suitable in some cases

▲ Availability: for delivery see current price and stock list

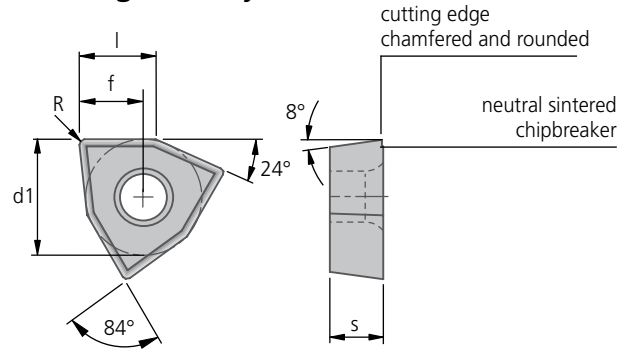




Application range:

- TwinKom® Double Insert Tools
- Special tools
- as outer cutter with KUB® solid drill bit
- excellent for interrupted cut because of stable cutting angle (82°) (top rake 0°) and chamfered cutting edge. A first class chipbreaker also produces good chip formation even from difficult materials.
- cutting edge chamfered and rounded.
- for cutting depths of < 1.5 mm

Cutter geometry:



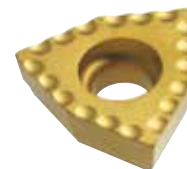
Substrate		Carbide						
Coating type		CVD	CVD					
Cutting material designation		BK6425	BK6440					
ISO Code	Order No.			d1	s	l	f	R
	Enter code ▼	6425	6440					
WOEX 05T304-02	W29 24020.04..	▲	▲	8,0	3,8	5,3	4,40	0,4
WOEX 05T308-02	W29 24020.08..		▲				4,35	0,8
WOEX 06T304-02	W29 34020.04..	▲	▲	10,0	3,8	6,6	5,51	0,4
WOEX 06T308-02	W29 34020.08..		▲				5,47	0,8
WOEX 080404-02	W29 42020.04..		▲	12,0	4,8	7,9	6,62	0,4
WOEX 080408-02	W29 42020.08..		▲				6,58	0,8
WOEX 100504-02	W29 50020.04..		▲	15,0	5,3	9,9	8,29	0,4
WOEX 100508-02	W29 50020.08..		▲				8,24	0,8
WOEX 120608-02	W29 58020.08..		▲	17,6	6,0	11,6	9,69	0,8
Mild steel/tool steel	P	●	●	Order example: ISO Code WOEX 05T304-02 Cutting material BK6440 Order No. W29 24020.046440				
Stainless and acid-resistant steel	M	●	●					
Grey cast iron, spheroidal cast iron	K							
Non-ferrous metals	N							
Heat-resistant steels	S							
Hardened tool steel	H							
External cutting edge		✓	✓					
Internal cutting edge Recommendation		W29..01 – BK8425						

● Main area of application ○ Suitable in some cases

Important: See chapter 7 for more application details and safety notes!



Inserts



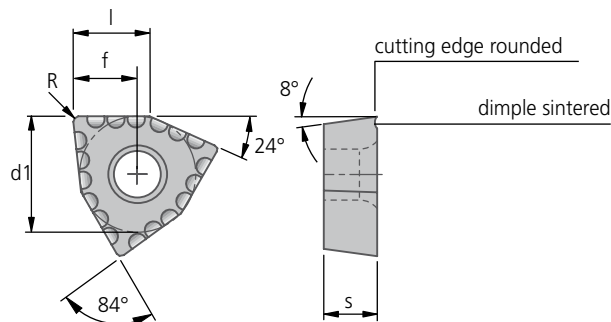
Application range:

- KUB Centron®, KUB Trigon®, KUB® drill
- TwinKom® double insert tools
- Special tools
- Internal and external machining

The dimple shaped chipbreaker causes a different chip flow action.

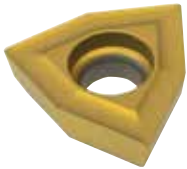
The chip is compressed in cross section and tends to break more rapidly.

Cutter geometry:



Substrate		Carbide							
Coating type		-	CVD	PVD					
Cutting material designation		P25M	BK6425	BK8425					
ISO Code	Order No.				d1	s	l	f	R
Enter code ▼		03	6425	8425					
WOEX 030204-03	W29 10030.04..		▲	▲	5,0	2,3	3,2	2,73	0,4
WOEX 040304-03	W29 18030.04..		▲	▲	6,35	3,18	4,1	3,48	0,4
WOEX 05T304-03	W29 24030.04..		▲	▲	8,0	3,8	5,3	4,40	0,4
WOEX 05T308-03	W29 24030.08..		▲	▲				4,35	0,8
WOEX 06T304-03	W29 34030.04..	▲	▲	▲	10,0	3,8	6,6	5,51	0,4
WOEX 06T308-03	W29 34030.08..		▲	▲				5,47	0,8
WOEX 080404-03	W29 42030.04..	▲	▲	▲	12,0	4,8	7,9	6,62	0,4
WOEX 080408-03	W29 42030.08..		▲	▲				6,58	0,8
WOEX 100504-03	W29 50030.04..	▲	▲	▲	15,0	5,3	9,9	8,29	0,4
WOEX 100508-03	W29 50030.08..		▲	▲				8,24	0,8
WOEX 120608-03	W29 58030.08..		▲	▲	17,6	6,0	11,6	9,69	0,8
Mild steel/tool steel	P	●	●	●	Order example: ISO Code WOEX 030201-03 Cutting material BK6425 Order No. W29 10030.046425				
Stainless and acid-resistant steel	M	●	●	●					
Grey cast iron, spheroidal cast iron	K			●					
Non-ferrous metals	N								
Heat-resistant steels	S								
Hardened tool steel	H								
External cutting edge		✓	✓	✓					
Internal cutting edge Recommendation		W29..01 – BK8425							

● Main area of application ● Suitable in some cases  
▲ Availability: for delivery see current price and stock list

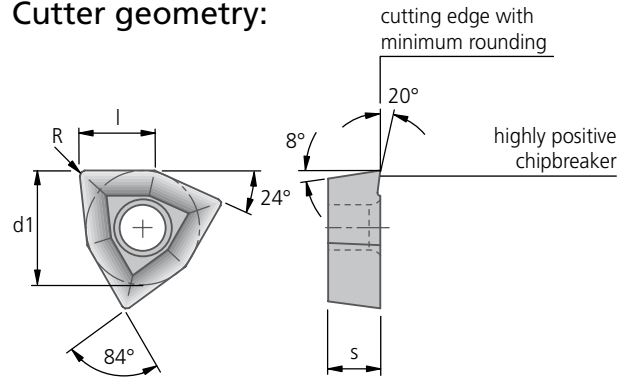


Application range:

- KUB Centron®, KUB Trigon®, KUB® drill
- TwinKom® double insert tools
- Special tools
- Internal and external machining

The highly positive chip groove with minimal chamfer for soft cutting operations, mainly on aluminium

Cutter geometry:



Substrate		Carbide							
Coating type		-	◆	PVD	PVD				
Cutting material designation		K10	BK50	BK77	BK7710				
ISO Code	Order No.					d1	s	l	R
Enter code ▼		21	50	77	7710				
WOEX 030204-11	W29 10110.04..	▲	▲	▲	▲	5,0	2,3	3,2	0,4
WOEX 040304-11	W29 18110.04..	▲	▲	▲	▲	6,35	3,18	4,1	0,4
WOEX 05T304-11	W29 24110.04..	▲	▲	▲	▲	8,0	3,8	5,3	0,4
WOEX 06T304-11	W29 34110.04..	▲	▲	▲	▲	10,0	3,8	6,6	0,4
WOEX 080404-11	W29 42110.04..	▲	▲	▲	▲	12,0	4,8	7,9	0,4
WOEX 100504-11	W29 50110.04..	▲	▲	▲	▲	15,0	5,3	9,9	0,4
Mild steel/tool steel	P	●				Order example: ISO Code WOEX 030204-11 Cutting material K10 Order No. W29 10110.0421			
Stainless and acid-resistant steel	M								
Grey cast iron, spheroidal cast iron	K	●							
Non-ferrous metals	N	●	●	●	●				
Heat-resistant steels	S	●		●					
Hardened tool steel	H								

● Main area of application ● Suitable in some cases



Inserts



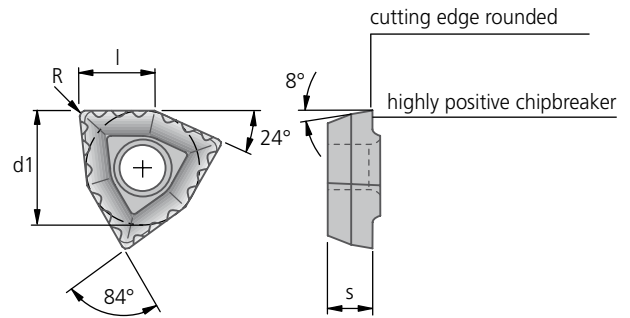
Application range:

- KUB Centron®, KUB Trigon®, KUB® drill
- TwinKom® double insert tools
- Special tools
- Internal and external machining

The dimple shaped chipbreaker causes a different chip flow action.

The chip is compressed in cross section and tends to break more rapidly.

Cutter geometry:



Substrate		Carbide							
Coating type		-	CVD	PVD	PVD				
Cutting material designation		P40	BK7325	BK79	BK8425				
ISO Code	Order No.					d1	s	l	R
Enter code ▼		04	7325	79	8425				
WOEX 030204-13	W29 10130.04..	▲	▲	▲	▲	5,0	2,3	3,2	0,4
WOEX 040304-13	W29 18130.04..	▲	▲	▲	▲	6,35	3,18	4,1	0,4
WOEX 05T304-13	W29 24130.04..	▲	▲	▲	▲	8,0	3,8	5,3	0,4
WOEX 06T304-13	W29 34130.04..		▲	▲	▲	10,0	3,8	6,6	0,4
WOEX 080404-13	W29 42130.04..	▲	▲	▲	▲	12,0	4,8	7,9	0,4
WOEX 100504-13	W29 50130.04..		▲	▲	▲	15,0	5,3	9,9	0,4
WOEX 120608-13	W29 58130.08..	▲	▲	▲	▲	17,6	6,0	11,6	0,8
Mild steel/tool steel	P	●	●	●	●	Order example: ISO Code WOEX 030204-13 Cutting material P40 Order No. W29 10130.0404			
Stainless and acid-resistant steel	M	●	●	●	●				
Grey cast iron, spheroidal cast iron	K				●				
Non-ferrous metals	N								
Heat-resistant steels	S			●					
Hardened tool steel	H								

EP 0 792 201 and other patents (geometry)

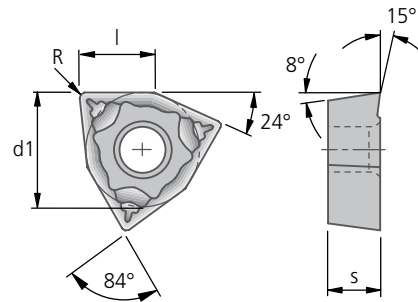


Application range:

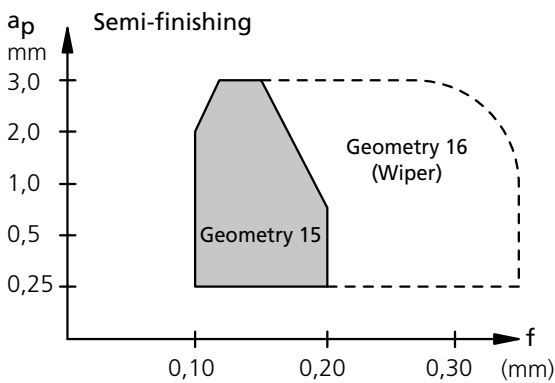
- TwinKom® double insert tools
- Special tools
- Internal and external machining

Optimum chip formation for cutting depths from 0.25 mm.

Cutter geometry:



Substrate		Carbide						
Coating type		CVD	CVD	PVD				
Cutting material designation		BK60	BK73	BK8430				
ISO Code	Order No.				d1	s	l	R
Enter code ▼		60	73	8430				
WOGX 030204-15	W29 10150.04..			▲	5,0	2,3	3,2	0,4
WOGX 040304-15	W29 18150.04..	▲		▲	6,35	3,18	4,1	0,4
WOGX 05T304-15	W29 24150.04..	▲	▲	▲	8,0	3,8	5,3	0,4
WOGX 06T304-15	W29 34150.04..	▲		▲	10,0	3,8	6,6	0,4
WOGX 080404-15	W29 42150.04..	▲	▲	▲	12,0	4,8	7,9	0,4
Mild steel/tool steel	P	●	●	●	Order example: ISO Code WOGX 030204-15 Cutting material BK60 Order No. W29 10150.0460			
Stainless and acid-resistant steel	M		●	●				
Grey cast iron, spheroidal cast iron	K	●		●				
Non-ferrous metals	N							
Heat-resistant steels	S							
Hardened tool steel	H							



● Main area of application ○ Suitable in some cases

Important: See chapter 7 for more application details and safety notes!



Inserts

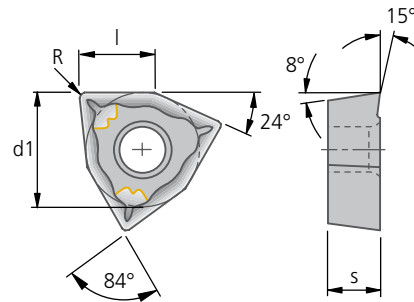


Application range:

- TwinKom® double insert tools
- Special tools
- Internal and external machining

Optimum chip formation for cutting depths from 0.25 mm.

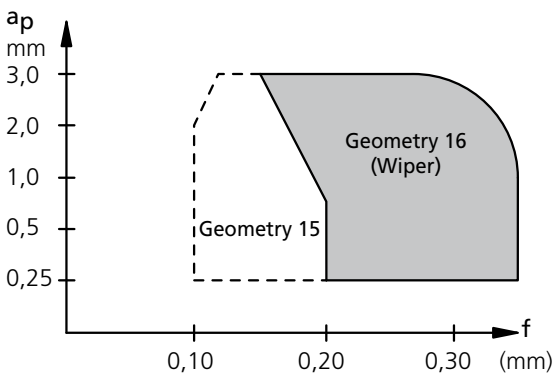
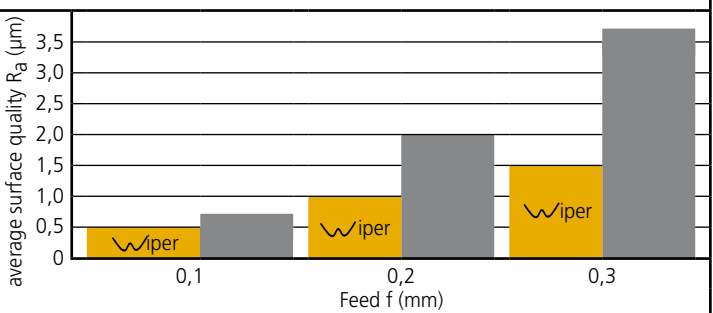
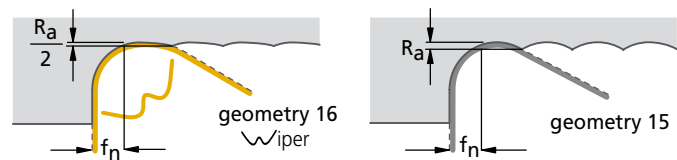
Cutter geometry:



Substrate		Carbide						
Coating type		CVD	CVD	PVD				
Cutting material designation		BK60	BK73	BK8430				
ISO Code	Order No.				d1	s	l	R
	Enter code ▼	60	73	8430				
WOGX 030204-16	W29 10160.04..	▲		▲	5,0	2,3	3,2	0,4
WOGX 040304-16	W29 18160.04..		▲	▲	6,35	3,18	4,1	0,4
WOGX 05T304-16	W29 24160.04..	▲		▲	8,0	3,8	5,3	0,4
WOGX 06T304-16	W29 34160.04..	▲	▲	▲	10,0	3,8	6,6	0,4
WOGX 080404-16	W29 42160.04..	▲		▲	12,0	4,8	7,9	0,4
Mild steel/tool steel	P	●	●	●	Order example: ISO Code WOGX 030204-16 Cutting material BK60 Order No. W29 10160.0460			
Stainless and acid-resistant steel	M		●	●				
Grey cast iron, spheroidal cast iron	K	●		●				
Non-ferrous metals	N							
Heat-resistant steels	S							
Hardened tool steel	H							

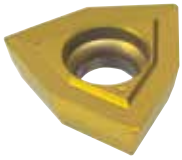
Surface quality results:

Comparison of surface quality results for "Wiper" – R04 for  $\alpha = 90^\circ$  in X40Cr13 / 1.4034



● Main area of application ● Suitable in some cases

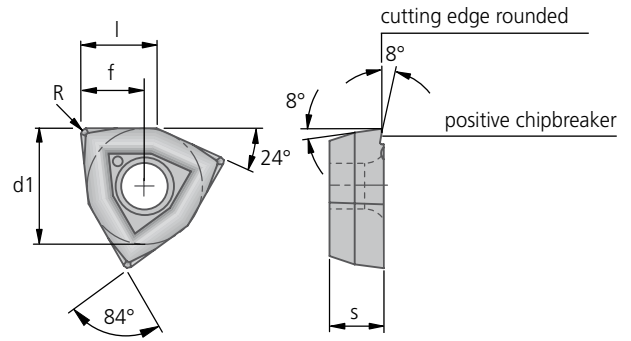
▲ Availability: for delivery see current price and stock list





Application range:

- External and internal turning
- KUB® solid drill
- TwinKom® double insert tools
- Kometric® mounted seatings

Cutter geometry:



Substrate		Carbide					
Coating type		PVD	PVD				
Cutting material designation		BK2730	BK8430				
ISO Code	Order No.			d1	s	l	R
Enter code ▼		2730	8430				
WOEX 030204-20	W29 10200.04..	▲	▲	5,0	2,3	3,2	0,4
WOEX 040304-20	W29 18200.04..	▲	▲	6,35	3,18	4,1	0,4
WOEX 05T304-20	W29 24200.04..	▲	▲	8,0	3,8	5,3	0,4
WOEX 06T304-20	W29 34200.04..	▲	▲	10,0	3,8	6,6	0,4
WOEX 080404-20	W29 42200.04..	▲	▲	12,0	4,8	7,9	0,4
WOEX 100504-20	W29 50200.04..	▲	▲	15,0	5,3	9,9	0,4
Mild steel/tool steel	P	●	●	Order example: ISO Code WOEX 030204-20 Cutting material BK2730 Order No. W29 10200.042730			
Stainless and acid-resistant steel	M	●	●				
Grey cast iron, spheroidal cast iron	K	●	●				
Non-ferrous metals	N	●	●				
Heat-resistant steels	S	●	●				
Hardened tool steel	H	●	●				

● Main area of application ○ Suitable in some cases



Inserts

L.H. cutting form „L“

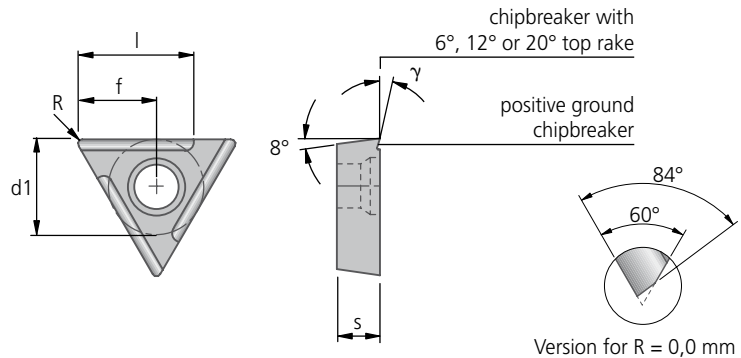


Application range:

- Internal and external turning
- Small boring bars
- Fine machining, internal and external
- Countersink tools, end mill cutters

Peripheral ground triangular insert. Can be turned over with high changeover accuracy because of precision 2-sided contact. Large selection of ground chipbreakers and carbides suitable for almost any materials.

Cutter geometry:



Version for R = 0,0 mm

Important note! The cutting edge on Cermet inserts is rounded.

Substrate		Carbide								Cermet									
Coating type		-	-	CVD	CVD	CVD	CVD	PVD	PVD	-	-	-	PVD						
Cutting material designation		P25M	K10	BK 6425	BK 7615	BK 6110	BK 6440	BK 2710	BK 8425	CK 30	CK 32	CK 37	CK 38						
Cutting edge design		E	E F	E	E	E	E	E	E	E	E	E	E						
ISO Code	Order No.	Enter code												d1	s	l	γ	f	R
Cutting edge design E = rounded F = sharp		03	21	6425	7615	6110	6440	2710	8425	30	32	37	38						
TOHX 06T100EL-G06	W30 04060.30..		▲	▲					▲					4,0	1,8	1	6°	3,25	0,0
TOHX 06T102..L-G06	W30 04060.02..	▲	▲	▲	▲	▲	▲	▲	▲					4,0	1,8	1	6°	3,32	0,2
TOHX 06T103..L-G06	W30 04060.03..	▲	▲	▲	▲	▲	▲	▲	▲									3,25	0,3
TOHX 06T104..L-G06	W30 04060.04..	▲	▲	▲			▲											3,17	0,4
TOHX 06T100EL-G12	W30 04120.30..			▲					▲					4,0	1,8	1	12°	3,25	0,0
TOHX 06T102..L-G12	W30 04120.02..	▲	▲	▲			▲		▲	▲	▲	▲	▲	4,0	1,8	1	12°	3,32	0,2
TOHX 06T103..L-G12	W30 04120.03..	▲	▲	▲			▲		▲		▲	▲						3,25	0,3
TOHX 06T104..L-G12	W30 04120.04..	▲	▲	▲			▲		▲	▲			▲					3,17	0,4
TOHX 06T102..L-G20	W30 04200.02..		▲	▲					▲					4,0	1,8	1	20°	3,32	0,2
TOHX 06T103..L-G20	W30 04200.03..		▲	▲														3,25	0,3
TOHX 090200EL-G06	W30 14060.30..		▲	▲					▲					5,6	2,5	2,5	6°	4,55	0,0
TOHX 090202EL-G06	W30 14060.02..	▲	▲	▲	▲	▲	▲	▲	▲					5,6	2,5	2,5	6°	4,70	0,2
TOHX 090204EL-G06	W30 14060.04..	▲	▲	▲	▲	▲	▲	▲	▲									4,56	0,4
TOHX 090208EL-G06	W30 14060.08..	▲	▲	▲	▲	▲	▲	▲	▲									4,26	0,8
TOHX 090200EL-G12	W30 14120.30..		▲	▲					▲					5,6	2,5	2,5	12°	4,55	0,0
TOHX 090202..L-G12	W30 14120.02..	▲	▲	▲			▲		▲	▲	▲	▲	▲	5,6	2,5	2,5	12°	4,70	0,2
TOHX 090204EL-G12	W30 14120.04..	▲	▲	▲			▲		▲	▲	▲	▲	▲					4,56	0,4
TOHX 090208..L-G12	W30 14120.08..		▲	▲					▲									4,26	0,8
TOHX 090202..L-G20	W30 14200.02..	▲	▲	▲					▲					5,6	2,5	2,5	20°	4,70	0,2
TOHX 090204..L-G20	W30 14200.04..		▲	▲														4,56	0,4
TOHX 140302EL-G06	W30 26060.02..	▲	▲	▲	▲	▲		▲	▲					8,2	3,0	4,5	6°	6,96	0,2
TOHX 140304EL-G06	W30 26060.04..	▲	▲	▲	▲	▲	▲	▲	▲									6,81	0,4
TOHX 140305EL-G06	W30 26060.05..	▲	▲	▲	▲	▲	▲	▲	▲									6,74	0,5
TOHX 140308EL-G06	W30 26060.08..			▲	▲	▲		▲	▲									6,52	0,8
TOHX 140300EL-G12	W30 26120.30..			▲										8,2	3,0	4,5	12°	6,28	0,0
TOHX 140302..L-G12	W30 26120.02..	▲	▲	▲			▲		▲		▲	▲	▲					6,96	0,2
TOHX 140304..L-G12	W30 26120.04..	▲	▲	▲				▲	▲	▲			▲	8,2	3,0	4,5	12°	6,81	0,4
TOHX 140305..L-G12	W30 26120.05..	▲	▲	▲			▲		▲		▲	▲						6,74	0,5
TOHX 140308EL-G12	W30 26120.08..			▲					▲									6,52	0,8
TOHX 140302FL-G20	W30 26200.02..		▲											8,2	3,0	4,5	20°	6,96	0,2
TOHX 140304FL-G20	W30 26200.04..		▲															6,81	0,4
TOHX 140305FL-G20	W30 26200.05..		▲															6,74	0,5
TOHX 22T308EL-G06	W30 44060.08..								▲					12,7	4,3	10,5	6°	10,41	0,8
Mild steel/tool steel	P	●	●	●		●	●	●	●	●	●	●	●	Order example: ISO Code TOHX 06T100 EL-G06 Cutting material BK6425 Order No. W30 04060.306425					
Stainless and acid-resistant steel	M	●		●			●	●	●	●	●	●	●						
Grey cast iron, spheroidal cast iron	K		●		●	●		●	●	●	●	●	●						
Non-ferrous metals	N		●							●	●								
Heat-resistant steels	S		●																
Hardened tool steel	H				●	●		●											

● Main area of application ○ Suitable in some cases

▲ Availability: for delivery see current price and stock list





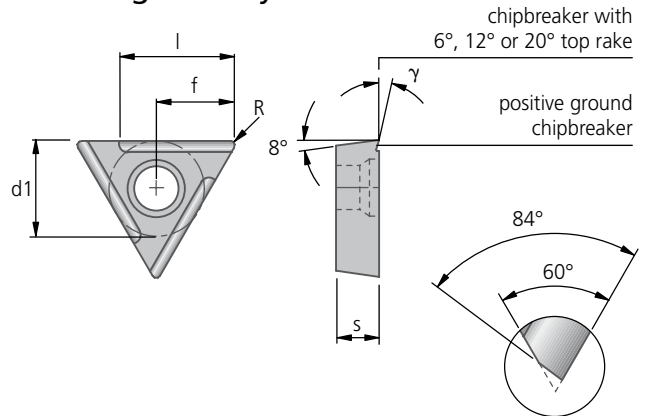
Application range:

- Internal and external turning
- Small boring bars
- Fine machining, internal and external
- Countersink tools, end mill cutters

Peripheral ground triangular insert. Can be turned over with high changeover accuracy because of precision 2-sided contact. Large selection of ground chipbreakers and carbides suitable for almost any materials.

Important note! The cutting edge on Cermet inserts is rounded.

Cutter geometry:



Version for R = 0,0 mm

Substrate		Carbide						Cermet									
Coating type		-	-	CVD	CVD	CVD	PVD	-	-	-	PVD						
Cutting material designation		P25M	K10	BK6425	BK7615	BK6440	BK8425	CK30	CK32	CK37	CK38						
Cutting edge design		E	E F	E	E	E	E	E	E	E	E						
ISO Code	Order No.											d1	s	l	γ	f	R
Cutting edge design E = rounded F = sharp	Enter code	03	21	6425	7615	6440	8425	30	32	37	38						
TOHX 06T102ER-G06	W30 04360.02..	▲	▲	▲			▲									3,32	0,2
TOHX 06T103ER-G06	W30 04360.03..	▲	▲	▲			▲					4,0	1,8	1	6°	3,25	0,3
TOHX 06T104ER-G06	W30 04360.04..			▲			▲									3,17	0,4
TOHX 06T102..R-G12	W30 04420.02..	▲	▲	▲			▲	▲	▲	▲	▲					3,32	0,2
TOHX 06T103..R-G12	W30 04420.03..	▲	▲	▲			▲				▲	4,0	1,8	1	12°	3,25	0,3
TOHX 06T104ER-G12	W30 04420.04..			▲			▲	▲			▲					3,17	0,4
TOHX 06T102..R-G20	W30 04500.02..		▲													3,32	0,2
TOHX 06T103..R-G20	W30 04500.03..		▲									4,0	1,8	1	20°	3,25	0,3
TOHX 090200ER-G06	W30 14360.30..	▲														4,55	0,0
TOHX 090202ER-G06	W30 14360.02..	▲	▲	▲			▲					5,6	2,5	2,5	6°	4,70	0,2
TOHX 090204ER-G06	W30 14360.04..	▲	▲	▲	▲	▲	▲									4,56	0,4
TOHX 090202..R-G12	W30 14420.30..		▲													4,55	0,0
TOHX 090202..R-G12	W30 14420.02..	▲	▲	▲			▲		▲	▲	▲	5,6	2,5	2,5	12°	4,70	0,2
TOHX 090204..R-G12	W30 14420.04..	▲	▲	▲	▲	▲	▲	▲	▲	▲	▲					4,56	0,4
TOHX 090202..R-G20	W30 14500.02..		▲									5,6	2,5	2,5	20°	4,70	0,2
TOHX 090204..R-G20	W30 14500.04..		▲	▲								5,6	2,5	2,5	20°	4,56	0,4
TOHX 140302ER-G06	W30 26360.02..		▲													6,96	0,2
TOHX 140304ER-G06	W30 26360.04..			▲								8,2	3,0	4,5	6°	6,81	0,4
TOHX 140305ER-G06	W30 26360.05..	▲	▲	▲			▲	▲								6,74	0,5
TOHX 140302..R-G12	W30 26420.02..		▲	▲												6,96	0,2
TOHX 140304ER-G12	W30 26420.04..										▲	8,2	3,0	4,5	12°	6,81	0,4
TOHX 140305..R-G12	W30 26420.05..	▲	▲	▲			▲			▲						6,74	0,5
TOHX 140305ER-G20	W30 26500.05..						▲					8,2	3,0	4,5	20°	6,74	0,5
TOHX 22T308ER-G06	W30 44360.08..	▲					▲					12,7	4,3	10,5	6°	10,41	0,8
TOHX 22T308ER-G12	W30 44420.08..						▲					12,7	4,3	10,5	12°	10,41	0,8
Mild steel/tool steel	P	●	●	●			●	●	●	●	●	Order example: ISO Code TOHX 06T102 ER-G06 Cutting material P25M Order No. W30 04360.0203					
Stainless and acid-resistant steel	M	●		●			●	●	●	●	●						
Grey cast iron, spheroidal cast iron	K		●		●			●	●	●	●						
Non-ferrous metals	N		●						●	●							
Heat-resistant steels	S		●														
Hardened tool steel	H				●												

● Main area of application ● Suitable in some cases

Important: See chapter 7 for more application details and safety notes!



Inserts

neutral cutting form „N“

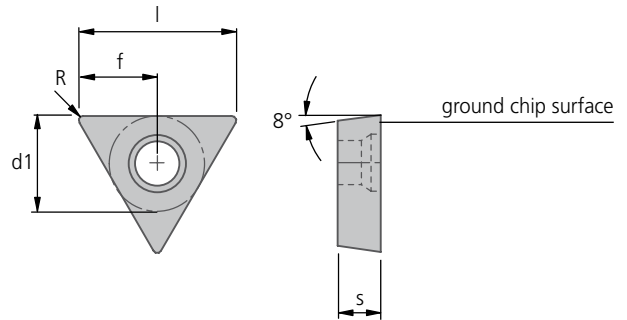


Application range:

- Internal and external turning
- Small boring bars
- Fine machining, internal and external
- Countersink tools, end mill cutters

Peripheral ground triangular insert. Can be turned over with high changeover accuracy because of precision 2-sided contact.

Cutter geometry:



Substrate		Carbide										
Coating type		-	-	CVD	CVD	CVD	PVD					
Cutting material designation		P25M	K10	BK6425	BK7615	BK62	BK8425					
Cutting edge design		E	E	E	E	E	E					
ISO Code	Order No.							d1	s	l	f	R
Cutting edge design E = rounded	Enter code	03	21	6425	7615	62	8425					
TOHX 06T102 EN	W30 04600.02..		▲					4,0	1,8	6,5	3,32	0,2
TOHX 06T103 EN	W30 04600.03..	▲	▲	▲	▲		▲			6,5	3,25	0,3
TOHX 090202 EN	W30 14600.02..		▲							9,4	4,70	0,2
TOHX 090204 EN	W30 14600.04..	▲	▲	▲	▲	▲	▲	5,6	2,5	9,1	4,56	0,4
TOHX 090208 EN	W30 14600.08..				▲					8,5	4,26	0,8
TOHX 140304 EN	W30 26600.04..				▲					13,6	6,81	0,4
TOHX 140305 EN	W30 26600.05..	▲	▲		▲		▲	8,2	3,0	13,5	6,74	0,5
TOHX 140308 EN	W30 26600.08..		▲	▲	▲					13,0	6,52	0,8
TOHX 22T308 EN	W30 44600.08..		▲		▲			12,7	4,3	20,8	10,41	0,8
Mild steel/tool steel	P	●	●	●			●	Order example: ISO Code TOHX 06T103 EN Cutting material K10 Order No. W30 04600.0321				
Stainless and acid-resistant steel	M	●	●	●			●					
Grey cast iron, spheroidal cast iron	K		●		●	●	●					
Non-ferrous metals	N		●									
Heat-resistant steels	S		●									
Hardened tool steel	H				●	●	●					

● Main area of application ○ Suitable in some cases

▲ Availability: for delivery see current price and stock list

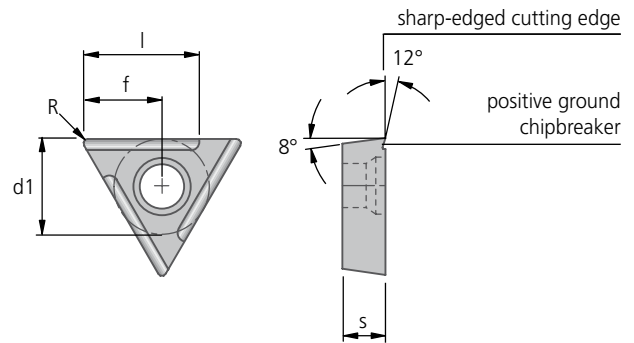


**Application range:**

- Internal and external turning
- Small boring bars
- Fine machining, internal and external
- Countersink tools, end mill cutters

Peripheral ground triangular insert. Can be turned over with high changeover accuracy because of precision 2-sided contact. Large selection of ground chipbreakers and carbides suitable for almost any materials.

**Cutter geometry:**



Substrate		Cermet							
Coating type		-	-	PVD					
Cutting material designation		CK30	CK32	CK38					
Cutting edge design		F	F	F					
ISO Code	Order No.				d1	s	l	f	R
Cutting edge design F = sharp	Enter code	30	32	38					
TOHX 06T102 FL-G12	W30 04820.02..	▲	▲	▲				3,32	0,2
TOHX 06T103 FL-G12	W30 04820.03..		▲		4,0	1,8	1	3,25	0,3
TOHX 06T104 FL-G12	W30 04820.04..	▲		▲				3,17	0,4
TOHX 090202 FL-G12	W30 14820.02..	▲	▲	▲				4,70	0,2
TOHX 090204 FL-G12	W30 14820.04..	▲	▲	▲	5,6	2,5	2,5	4,56	0,4
TOHX 140302 FL-G12	W30 26820.02..		▲	▲				6,96	0,2
TOHX 140304 FL-G12	W30 26820.04..			▲	8,2	3,0	4,5	6,81	0,4
TOHX 140305 FL-G12	W30 26820.05..		▲					6,74	0,5
Mild steel/tool steel	P	●	●	●	Order example: ISO Code TOHX 06T102 FL-G12 Cutting material CK30 Order No. W30 04820.0230				
Stainless and acid-resistant steel	M	●	●	●					
Grey cast iron, spheroidal cast iron	K	●	●	●					
Non-ferrous metals	N								
Heat-resistant steels	S								
Hardened tool steel	H								

● Main area of application ○ Suitable in some cases

Important: See chapter 7 for more application details and safety notes!



# KOMET® W30..83

TOHX

## Inserts

R.H. cutting form „R“

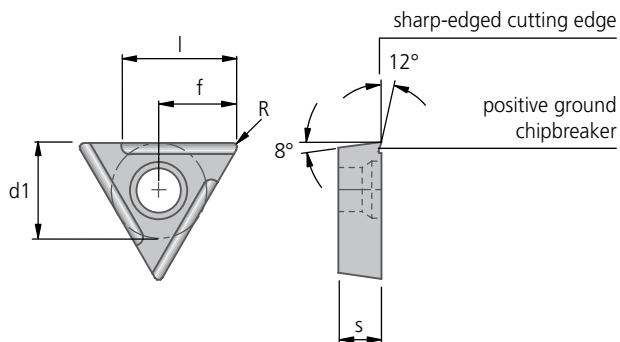



### Application range:

- Internal and external turning
- Small boring bars
- Fine machining, internal and external
- Countersink tools, end mill cutters

Peripheral ground triangular insert. Can be turned over with high changeover accuracy because of precision 2-sided contact. Large selection of ground chipbreakers and carbides suitable for almost any materials.

### Cutter geometry:



Substrate		Cermet					
Coating type		-					
Cutting material designation		CK32					
Cutting edge design		F					
ISO Code	Order No.		d1	s	l	f	R
Cutting edge design F = sharp	Enter code	32					
TOHX 06T102 FR-G12	W30 04830.02..	▲	4,0	1,8	1	3,32	0,2
TOHX 090202 FR-G12	W30 14830.02..	▲	5,6	2,5	2,5	4,70	0,2
Mild steel/tool steel	P	●	Order example: ISO Code TOHX 06T102 FR-G12 Cutting material CK32 Order No. W30 04830.0232				
Stainless and acid-resistant steel	M	●					
Grey cast iron, spheroidal cast iron	K	●					
Non-ferrous metals	N	●					
Heat-resistant steels	S	●					
Hardened tool steel	H	●					

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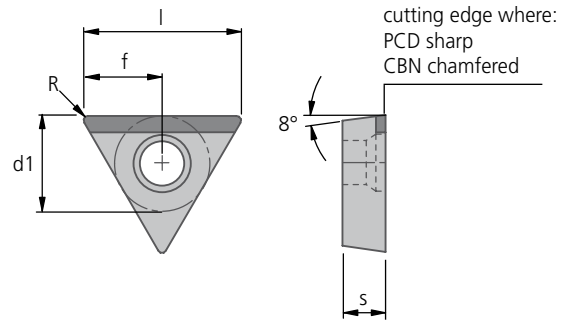
Application range:

**PCD:** Internal and external machining, fine turning of non-ferrous metals, plastics, composites, rubber, graphites, etc. High cutting speeds, good dimensional accuracy, above-average surface finish and extremely good tool life are all features of these PCD tipped inserts.

**CBN:** Internal and external machining, fine turning. Inserts with cutting edges have the following advantages: high cutting speeds, high dimensional consistency, extremely long tool life and above-average surface finish.

**CBN 57:** Preferably for cast materials and alloys on a nickel cobalt base.

Cutter geometry:



Substrate		PCD	CBN					
Coating type		–	–					
Cutting material designation		PKD55	CBN57					
Cutting edge design		F	T					
ISO Code	Order No.			d1	s	l	f	R
Cutting edge design F = sharp T = chamfered	Enter code	55	57					
TOGX 090204 ..	W30 14940.04..	▲	▲	5,6	2,5	9,12	4,56	0,4
TOGX 140305 ..	W30 26940.05..	▲	▲	8,2	3,0	13,5	6,74	0,5
Mild steel/tool steel	P			Order example: ISO Code TOGX 090204 T Cutting material CBN57 Order No. W30 14940.0457				
Stainless and acid-resistant steel	M							
Grey cast iron, spheroidal cast iron	K		●					
Non-ferrous metals	N	●						
Heat-resistant steels	S		●					
Hardened tool steel	H		○ < 52 HRC					

● Main area of application ○ Suitable in some cases

Important: See chapter 7 for more application details and safety notes!

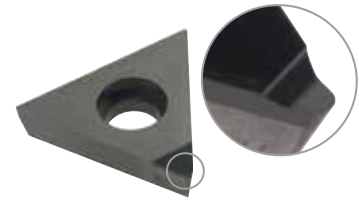


# KOMET® W30..98

TOGX

## Inserts

PCD chip topography

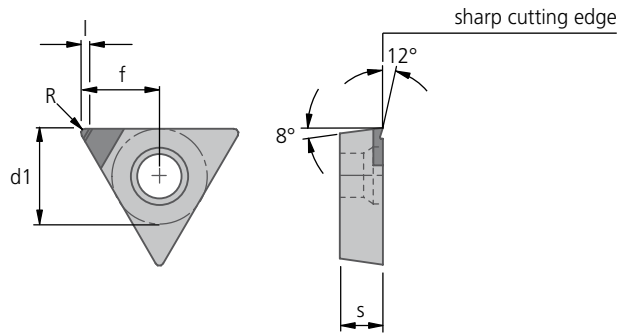



### Application range:

Version with chip breaker for optimum chip control. Particularly well-suited for long-chipping non-ferrous metals, mainly aluminium, wrought alloys and die casting alloys.

**PCD:** Internal and external machining, fine turning of non-ferrous metals, plastics, composites, rubber, graphites, etc. High cutting speeds, good dimensional accuracy, above-average surface finish and extremely good tool life are all features of these PCD tipped inserts.

### Cutter geometry:



Substrate		PCD					
Coating type		-					
Cutting material designation		PKD55					
Cutting edge design		F					
ISO Code	Order No.		d1	s	l	f	R
Cutting edge design F = sharp	Enter code	55					
TOGX 06T103 FN-G12	W30 04980.03..	▲	4,0	1,8	0,6	3,25	0,3
TOGX 090204 FN-G12	W30 14980.04..	▲	5,6	2,5	0,6	4,56	0,4
TOGX 140305 FN-G12	W30 26980.05..	▲	8,2	3,0	0,6	6,74	0,5
Mild steel/tool steel	P	●	Order example: ISO Code TOGX 06T103 FN Cutting material PKD55 Order No. W30 04980.0355				
Stainless and acid-resistant steel	M	●					
Grey cast iron, spheroidal cast iron	K	●					
Non-ferrous metals	N	●					
Heat-resistant steels	S	●					
Hardened tool steel	H	●					



**Application range:**

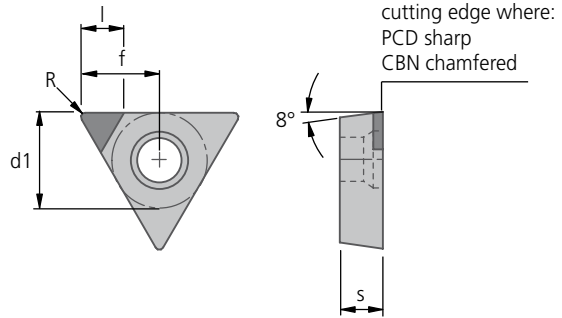
**PCD:** Internal and external machining, fine turning of non-ferrous metals, plastics, composites, rubber, graphites, etc. High cutting speeds, good dimensional accuracy, above-average surface finish and extremely good tool life are all features of these PCD tipped inserts.

**CBN:** Internal and external machining, fine turning. Inserts with cutting edges have the following advantages: high cutting speeds, high dimensional consistency, extremely long tool life and above-average surface finish.

**CBN 57:** Preferably for cast materials and alloys on a nickel cobalt base.

**CBN 40:** For machining hardened steels (harder than 45 HRC)

**Cutter geometry:**



Substrate		PCD	CBN						
Coating type		-	-	-					
Cutting material designation		PKD55	CBN57	CBN40					
Cutting edge design		F	T	T					
ISO Code	Order No.				d1	s	l	f	R
Cutting edge design F = sharp T = chamfered		55	57	40					
Enter code									
TOGX 06T102 ..N	W30 04990.02..	▲	▲	▲				3,32	0,2
TOGX 06T103 ..N	W30 04990.03..	▲	▲		4,0	1,8	1,8	3,25	0,3
TOGX 06T104 ..N	W30 04990.04..	▲						3,17	0,4
TOGX 090202 ..N	W30 14990.02..	▲	▲	▲				4,70	0,2
TOGX 090204 ..N	W30 14990.04..	▲	▲	▲	5,6	2,5	2,7	4,56	0,4
TOGX 090208 ..N	W30 14990.08..	▲	▲					4,26	0,8
TOGX 140302 ..N	W30 26990.02..	▲	▲					6,96	0,2
TOGX 140304 ..N	W30 26990.04..	▲	▲	▲	8,2	3,0	2,7	6,81	0,4
TOGX 140305 ..N	W30 26990.05..	▲	▲					6,74	0,5
Mild steel/tool steel	P				Order example: ISO Code TOGX 06T102 TN Cutting material CBN57 Order No. W30 04990.0257				
Stainless and acid-resistant steel	M								
Grey cast iron, spheroidal cast iron	K								
Non-ferrous metals	N	●	●						
Heat-resistant steels	S		●	●					
Hardened tool steel	H			●					

● Main area of application ● Suitable in some cases

**Important:** See chapter 7 for more application details and safety notes!



# KOMET® W57..12

TOGX

## Inserts

for machining aluminium

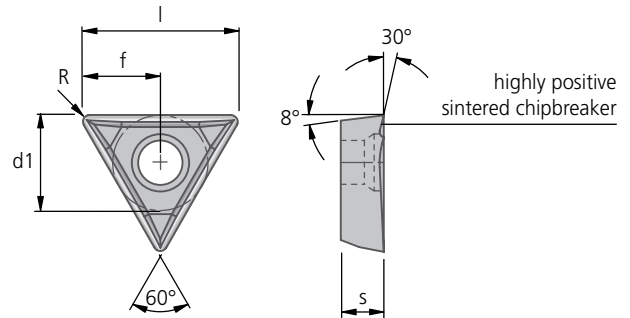


### Application range:

- Internal and external turning
- Fine finish turning for aluminium machining
- Aluminium materials, in particular soft wrought alloys

The highly positive cutting edge geometry and the peripheral ground clearance faces guarantee controlled chip formation and the best surface quality with low cutting forces.

### Cutter geometry:



Substrate		Carbide						
Coating type		-		PVD				
Cutting material designation		K10		BK7710				
Cutting edge design		F		F				
ISO Code	Order No.							
Cutting edge design F = sharp	Enter code	23	7710	d1	s	l	f	R
TOGX 06T102 FN-12	W57 04120.02..	▲	▲	4,00	1,80	6,64	3,32	0,2
TOGX 090204 FN-12	W57 14120.04..	▲	▲	5,60	2,50	9,12	4,56	0,4
TOGX 140304 FN-12	W57 26120.04..	▲	▲	8,20	3,00	13,62	6,81	0,4
Mild steel/tool steel	P			Order example: ISO Code TOGX 06T102 FN-12 Cutting material K10 Order No. W57 04120.0223				
Stainless and acid-resistant steel	M	●						
Grey cast iron, spheroidal cast iron	K							
Non-ferrous metals	N	●	●					
Heat-resistant steels	S	●						
Hardened tool steel	H							

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● Main area of application ● Suitable in some cases

▲ Availability: for delivery see current price and stock list





Application range:

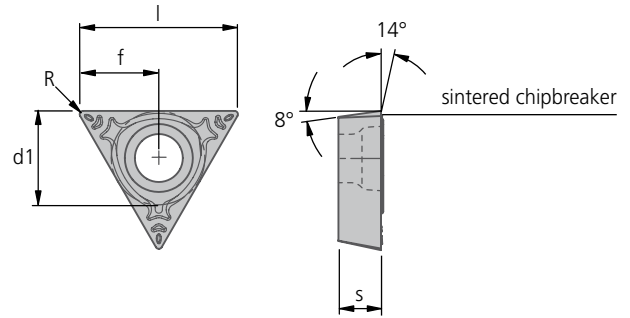
- Internal and external machining
- Special tools
- Fine boring

Controlled chip formation for fine and high precision machining. Wear resistant grades: CVD and PVD coated and uncoated Cermet.

CK3210: Extremely high resistance to wear

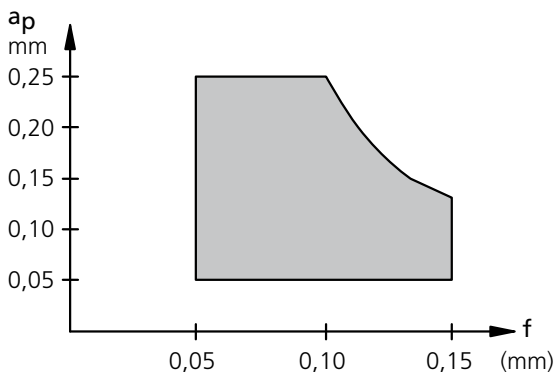
CK3230: Optimum toughness, suitable for interrupted cutting

Cutter geometry:



Substrate		Carbide		Cermet						
Coating type		CVD	PVD	-	-					
Cutting material designation		BK60	BK8430	CK3210	CK3230					
Cutting edge design		E	E	E	E					
ISO Code	Order No.					d1	s	l	f	R
Cutting edge design E = rounded	Enter code	60	8430	3210	3230					
TOGX 06T102 EN-14	W57 04140.02..	▲	▲	▲	▲	4,0	1,8	6,64	3,32	0,2
TOGX 06T104 EN-14	W57 04140.04..	▲	▲	▲	▲			6,35	3,17	0,4
TOGX 090202 EN-14	W57 14140.02..	▲	▲	▲	▲	5,6	2,5	9,41	4,70	0,2
TOGX 090204 EN-14	W57 14140.04..	▲	▲	▲	▲			9,12	4,56	0,4
TOGX 140302 EN-14	W57 26140.02..	▲	▲	▲	▲	8,2	3,0	13,91	6,96	0,2
TOGX 140304 EN-14	W57 26140.04..	▲	▲	▲	▲			13,62	6,81	0,4
Mild steel/tool steel	P	●	●	●	●	Order example: ISO Code TOGX 06T102 EN-14 Cutting material BK60 Order No. W57 04140.0260				
Stainless and acid-resistant steel	M	●	●	●	●					
Grey cast iron, spheroidal cast iron	K	●	●	●	●					
Non-ferrous metals	N	●	●	●	●					
Heat-resistant steels	S	●	●	●	●					
Hardened tool steel	H									

Application area

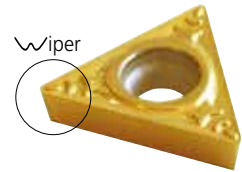


- Main area of application
- ◐ Suitable in some cases

Important: See chapter 7 for more application details and safety notes!



Inserts



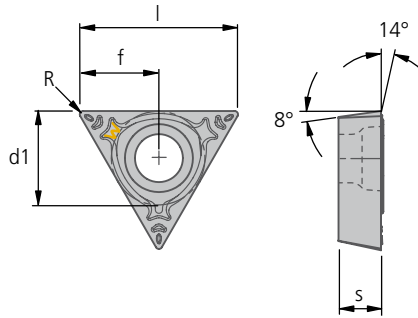
Application range:

- Internal and external machining
- Special tools
- Fine boring

Controlled chip formation for fine and high precision machining with optimised feed:surface ratio for best surface finish.

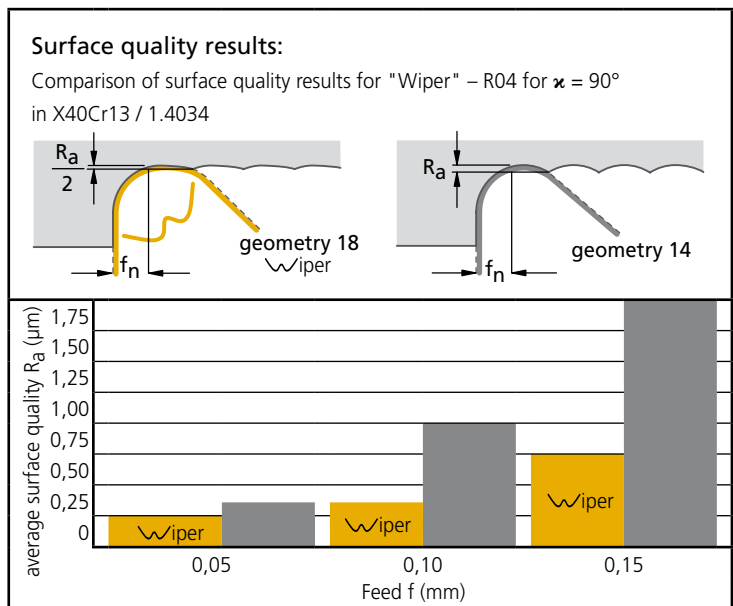
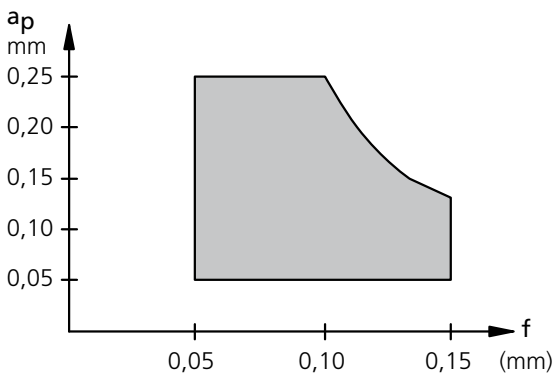
Wear resistant grades: Finest grade carbide + PVD coating and uncoated Cermet.

Cutter geometry:



Substrate		Carbide	Cermet					
Coating type		PVD	-					
Cutting material designation		BK8430	CK32					
Cutting edge design		E	E					
ISO Code	Order No.			d1	s	l	f	R
Cutting edge design E = rounded	Enter code	8430	32					
TOGX 060104 EN-18	W57 04180.04..	▲	▲	4,0	1,8	6,3	3,17	0,4
TOGX 090204 EN-18	W57 14180.04..	▲	▲	5,6	2,5	9,1	4,56	0,4
TOGX 140304 EN-18	W57 26180.04..	▲	▲	8,2	3,0	13,6	6,81	0,4
Mild steel/tool steel	P	●	●	Order example: ISO Code TOGX 060104 EN-18 Cutting material BK8430 Order No. W57 04180.048430				
Stainless and acid-resistant steel	M	●	●					
Grey cast iron, spheroidal cast iron	K	●	●					
Non-ferrous metals	N	●	●					
Heat-resistant steels	S	●	●					
Hardened tool steel	H	●	●					

Application area



- Main area of application
- Suitable in some cases
- ▲ Availability: for delivery see current price and stock list

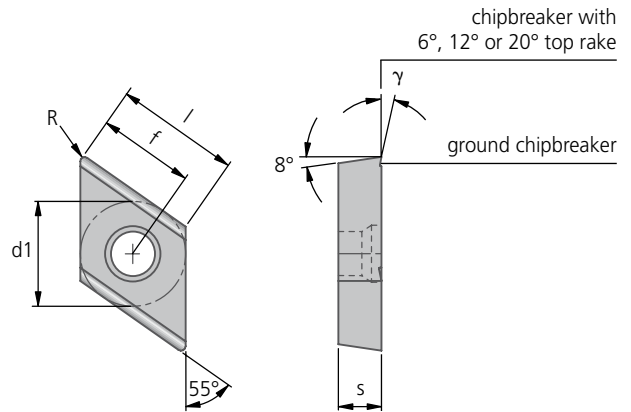


Application range:

- External and internal copy turning

Because of the positive cutting edge geometry, cutting is very efficient. Particularly suitable for long overhang and for thin-walled materials. The large selection of ground chipbreakers and carbides will suit almost any materials.

Cutter geometry:



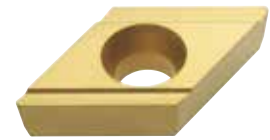
Substrate		Carbide									
Coating type		-	-	CVD	PVD						
Cutting material designation		P25M	K10	BK6425	BK2710						
Cutting edge design		E	F	E	E						
ISO Code	Order No.					d1	s	l	γ	f	R
Cutting edge design E = rounded F = sharp	Enter code	03	21	6425	2710						
DOHT 070202..L-G06	W60 18060.02..	▲				6,35	2,4	7,4	6°	5,92	0,2
DOHT 070204..L-G06	W60 18060.04..			▲						5,73	0,4
DOHT 070202..L-G12	W60 18120.02..	▲	▲	▲	▲	6,35	2,4	7,4	12°	5,92	0,2
DOHT 070204..L-G12	W60 18120.04..	▲	▲	▲	▲					5,73	0,4
DOHT 070202..L-G20	W60 18200.02..		▲			6,35	2,4	7,4	20°	5,92	0,2
DOHT 11T302..L-G12	W60 32120.02..	▲	▲	▲						8,96	0,2
DOHT 11T304..L-G12	W60 32120.04..	▲	▲	▲	▲	9,52	4,0	11,2	12°	8,78	0,4
DOHT 11T308..L-G12	W60 32120.08..			▲	▲					8,41	0,8
Mild steel/tool steel	P	●	◐	●	◐	Order example: ISO Code DOHT 070202 EL-G06 Cutting material P25M Order No. W60 18060.0203					
Stainless and acid-resistant steel	M	●		●	◐						
Grey cast iron, spheroidal cast iron	K		●		●						
Non-ferrous metals	N		●		●						
Heat-resistant steels	S		●		●						
Hardened tool steel	H				●						

● Main area of application ◐ Suitable in some cases



Inserts

R.H. cutting form „R“

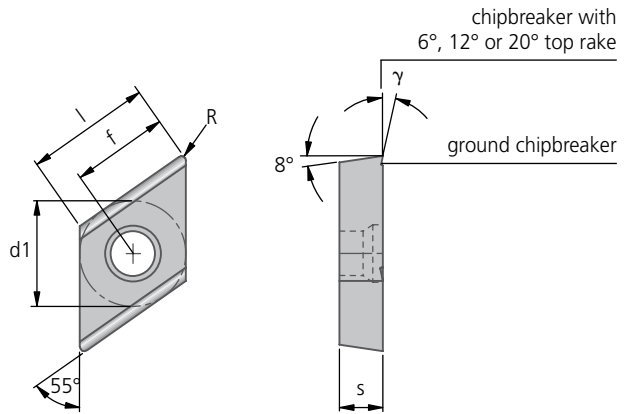


Application range:

- External and internal copy turning

Because of the positive cutting edge geometry, cutting is very efficient. Particularly suitable for long overhang and for thin-walled materials. The large selection of ground chipbreakers and carbides will suit almost any materials.

Cutter geometry:



Substrate		Carbide								
Coating type		-	-	CVD						
Cutting material designation		P25M	K10	BK6425						
Cutting edge design		E	F	E						
ISO Code	Order No.				d1	s	l	γ	f	R
DOHT 070202..R-G06	W60 18360.02..	▲		▲	6,35	2,4	7,4	6°	5,92	0,2
DOHT 070204..R-G06	W60 18360.04..			▲					5,73	0,4
DOHT 070202..R-G12	W60 18420.02..	▲	▲	▲	6,35	2,4	7,4	12°	5,92	0,2
DOHT 070204..R-G12	W60 18420.04..	▲	▲	▲					5,73	0,4
DOHT 070202..R-G20	W60 18500.02..		▲		6,35	2,4	7,4	20°	5,92	0,2
DOHT 070204..R-G20	W60 18500.04..		▲						5,73	0,4
DOHT 11T308..R-G06	W60 32360.08..			▲	9,52	4,0	11,2	6°	8,41	0,8
DOHT 11T302..R-G12	W60 32420.02..	▲	▲	▲					8,96	0,2
DOHT 11T304..R-G12	W60 32420.04..	▲	▲	▲	9,52	4,0	11,2	12°	8,78	0,4
DOHT 11T308..R-G12	W60 32420.08..			▲					8,41	0,8
Mild steel/tool steel	P	●	●	●	Order example: ISO Code DOHT 070202 ER-G06 Cutting material P25M Order No. W60 18360.0203					
Stainless and acid-resistant steel	M	●		●						
Grey cast iron, spheroidal cast iron	K		●							
Non-ferrous metals	N		●							
Heat-resistant steels	S		●							
Hardened tool steel	H			●						

● Main area of application ● Suitable in some cases  
▲ Availability: for delivery see current price and stock list

# DOHW

KOMET® W60..60

Inserts

neutral cutting form „N“

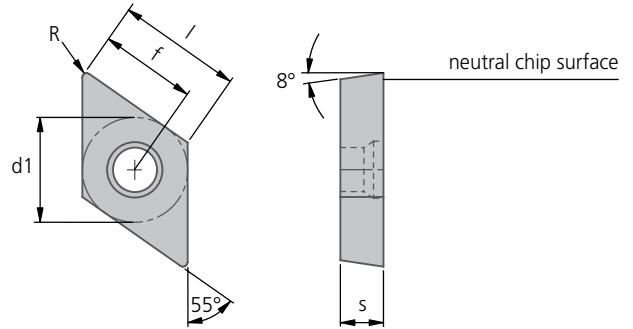


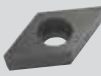
## Application range:

- External and internal copy turning

Because of the positive cutting edge geometry, cutting is very efficient. Particularly suitable for long overhang and for thin-walled materials.

## Cutter geometry:



Substrate		Carbide					
Coating type		-					
Cutting material designation		K10					
Cutting edge design		E					
ISO Code	Order No.		d1	s	l	f	R
Cutting edge design E = rounded	Enter code	21					
DOHW 070202 EN	W60 18600.02..	▲	6,35	2,4	7,4	5,20	0,2
DOHW 070204 EN	W60 18600.04..	▲				5,73	0,4
DOHW 11T304 EN	W60 32600.04..	▲	9,52	4,0	11,2	8,78	0,4
Mild steel/tool steel	<b>P</b>	●	Order example: ISO Code DOHW 070202 EN Cutting material K10 Order No. W60 18600.0221				
Stainless and acid-resistant steel	<b>M</b>	●					
Grey cast iron, spheroidal cast iron	<b>K</b>	●					
Non-ferrous metals	<b>N</b>	●					
Heat-resistant steels	<b>S</b>	●					
Hardened tool steel	<b>H</b>	●					

● Main area of application ○ Suitable in some cases

Important: See chapter 7 for more application details and safety notes!

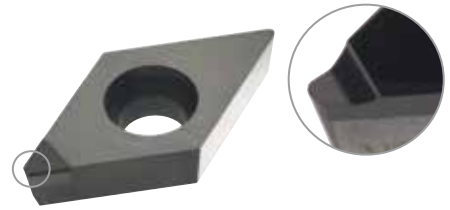


# KOMET® W60..98

DOGT

## Inserts

PCD chip topography

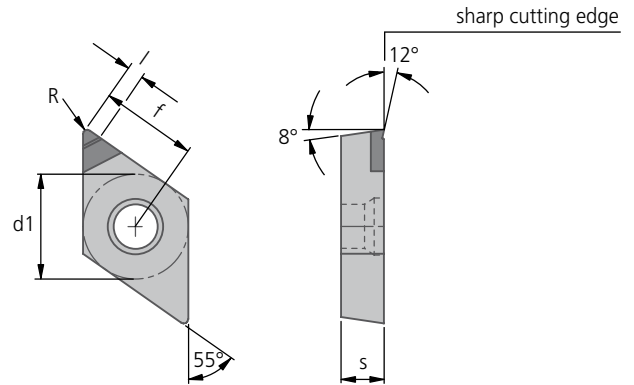


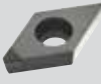
### Application range:

Version with chip breaker for optimum chip control. Particularly well-suited for long-chipping non-ferrous metals, mainly aluminium, wrought alloys and die casting alloys.

**PCD:** Internal and external machining, fine turning of non-ferrous metals, plastics, composites, rubber, graphites, etc. High cutting speeds, good dimensional accuracy, above-average surface finish and extremely good tool life are all features of these PCD tipped inserts.

### Cutter geometry:



Substrate		PCD					
Coating type		-					
Cutting material designation		PKD55					
Cutting edge design		F					
ISO Code	Order No.		d1	s	l	f	R
Cutting edge design F = sharp	Enter code	55					
DOGT 070204 FN-G12	W60 18980.04..	▲	6,35	2,4	0,6	5,73	0,4
DOGT 11T304 FN-G10	W60 32980.04..	▲	9,52	4,0	0,6	8,78	0,4
Mild steel/tool steel	P		Order example: ISO Code DOGW 070204 FN Cutting material PKD55 Order No. W60 18980.0455				
Stainless and acid-resistant steel	M						
Grey cast iron, spheroidal cast iron	K						
Non-ferrous metals	N	●					
Heat-resistant steels	S						
Hardened tool steel	H						

# DOGW



# KOMET® W60..99

## Inserts

PCD or CBN cutting edge

### Application range:

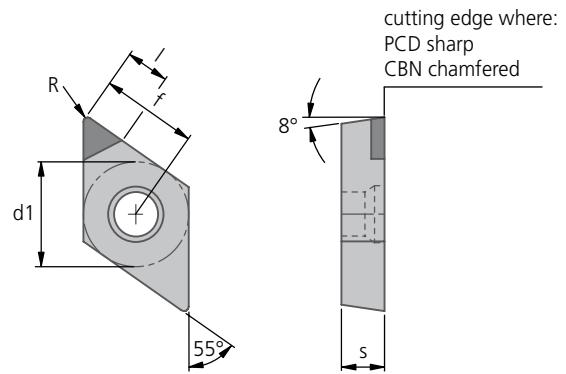
**PCD:** Internal and external machining, fine turning of non-ferrous metals, plastics, composites, rubber, graphites, etc. High cutting speeds, good dimensional accuracy, above-average surface finish and extremely good tool life are all features of these PCD tipped inserts.

**CBN:** Internal and external machining, fine turning. Inserts with cutting edges have the following advantages: high cutting speeds, high dimensional consistency, extremely long tool life and above-average surface finish.

**CBN 57:** Preferably for cast materials and alloys on a nickel cobalt base.

**CBN 40:** For machining hardened steels (over 52 HRC).

### Cutter geometry:



Substrate		PCD	CBN						
Coating type		–	–	–					
Cutting material designation		PKD55	CBN57	CBN40					
Cutting edge design		F	T	T					
ISO Code	Order No.				d1	s	l	f	R
Cutting edge design F = sharp T = chamfered		55	57	40					
Enter code									
DOGW 070202 ..N	W60 18990.02..	▲		▲	6,35	2,4	3,0	5,92	0,2
DOGW 070204 ..N	W60 18990.04..	▲	▲	▲				5,73	0,4
DOGW 11T302 ..N	W60 32990.02..	▲		▲	9,52	4,0	3,0	8,96	0,2
DOGW 11T304 ..N	W60 32990.04..	▲	▲	▲				8,78	0,4
Mild steel/tool steel	P				Order example: ISO Code DOGW 070202 FN Cutting material PKD55 Order No. W60 18990.0255				
Stainless and acid-resistant steel	M								
Grey cast iron, spheroidal cast iron	K		●						
Non-ferrous metals	N	●							
Heat-resistant steels	S		●						
Hardened tool steel	H			●	○ ≥ 52 HRC				

● Main area of application ○ Suitable in some cases

**Important:** See chapter 7 for more application details and safety notes!



Inserts

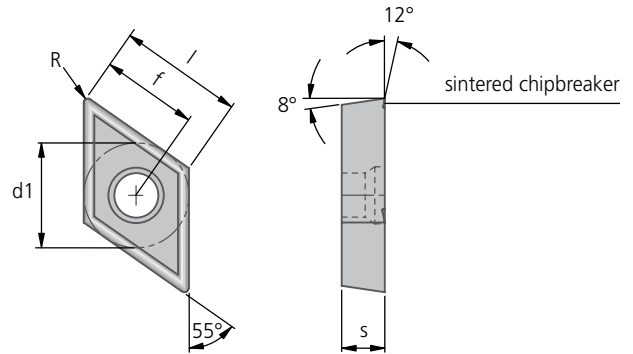


Application range:

- External and internal copy turning

The sintered chipbreaker allows universal use. The positive cutter geometry and peripheral ground clearance faces produce low cutting forces with high changeover accuracy.

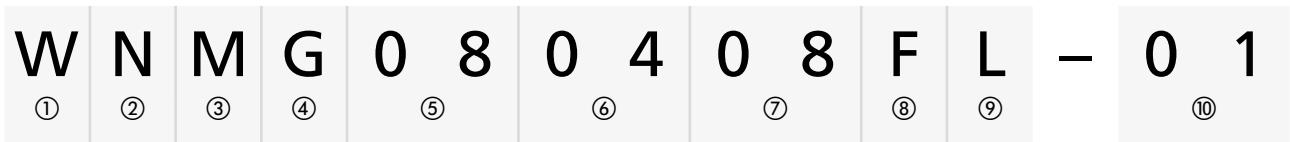
Cutter geometry:



Substrate		Carbide										
Coating type		–	–	CVD	CVD	CVD	PVD					
Cutting material designation		P25M	K10	BK6425	BK7615	BK6440	BK2710					
ISO Code	Order No.							d1	s	l	f	R
	Enter code ▼	03	21	6425	7615	6440	2710					
DOHT 070202-06	W79 18060.02..	▲	▲	▲		▲	▲				5,92	0,2
DOHT 070204-06	W79 18060.04..	▲	▲	▲	▲	▲	▲	6,35	2,4	7,4	5,73	0,4
DOHT 070208-06	W79 18060.08..			▲		▲					5,36	0,8
DOHT 11T302-06	W79 32060.02..		▲	▲							8,96	0,2
DOHT 11T304-06	W79 32060.04..	▲	▲	▲		▲	▲	9,52	4,0	11,2	8,78	0,4
DOHT 11T308-06	W79 32060.08..		▲	▲		▲	▲				8,41	0,8
Mild steel/tool steel	P	●	●	●		●	●	Order example: ISO Code DOHT 070202-06 Cutting material P25M Order No. W79 18060.0203				
Stainless and acid-resistant steel	M	●	●	●		●	●					
Grey cast iron, spheroidal cast iron	K		●		●		●					
Non-ferrous metals	N		●				●					
Heat-resistant steels	S		●				●					
Hardened tool steel	H				●		●					

● Main area of application ● Suitable in some cases  
▲ Availability: for delivery see current price and stock list





①	Form
Code	
	R
	S 90°
	L 90°
	A 85°
	T 60°
	C 80° / 100°
	E 75°
	D 55°
	V 35°
	W 80°

②	Clearance angle
Code	
	N 0°
	B 5°
	C 7°
	O according to manufacturer specification (with KOMET 8°)
	P 11°
	E 20°

③	Tolerance		
Code			
	<i>m</i>		
	<i>s</i>		
	<i>d</i>		
A	±0,005	±0,025	±0,025
E	±0,025	±0,025	±0,025
G	±0,025	±0,13	±0,025
H	±0,013	±0,025	±0,013
K	±0,013	±0,025	±0,05...±0,15
M	±0,08...±0,18 <sup>1)</sup>	±0,13	±0,05...±0,13 <sup>1)</sup>
U	±0,13...±0,38 <sup>1)</sup>	±0,13	±0,08...±0,25 <sup>1)</sup>
Tolerance in mm			
Ø d1	at <i>m</i>	at <i>m</i>	at <i>d1</i>
IC	Class M	Class U	Class M
6,35	±0,08	±0,13	d±0,05
9,52	±0,08	±0,13	d±0,05
12,70	±0,13	±0,20	±0,08
15,87	±0,15	±0,27	±0,10
19,05	±0,15	±0,27	±0,10
25,40	±0,18	±0,38	±0,13

④	Type
Code	
	A no chipformer, with hole
	M chipformer on one side, with hole
	G chipformer both sides, with hole
	R chipformer on one side, no hole
	W no chipformer, countersunk hole 40-60°
	B no chipformer, countersunk hole 70-90°
	T chipformer on one side, countersunk hole 40-60°
	H chipformer on one side, countersunk hole 70-90°
	P neg/pos. one or two sides, with hole
	U chipformer both sides, with countersunk hole
	X special design, drawing required

⑤	Cutting edge length <i>l</i>
Code	
d1	at code
mm	A C D L R S T V W
3,97	
4,80	04
5,56	05
6,35	10 06 07
7,94	08
8,00	12
9,52	09 11 12
10,00	
10,90	16
12,00	
12,70	12 15
15,00	
15,88	
16,00	
17,60	
19,05	19
20,00	
25,00	
25,40	

⑥	Thickness <i>s</i>
Code	
T0	1,20 mm
	01 1,59 mm
T1	1,80 mm
	02 2,38 mm
T2	2,97 mm
	03 3,18 mm
T3	3,97 mm
	04 4,76 mm
	05 5,30 mm
	06 6,35 mm
	07 7,94 mm

⑦	Corner radius <i>R</i>
Code	
00	0,0 mm
01	0,1 mm
02	0,2 mm
03	0,3 mm
04	0,4 mm
05	0,5 mm
	06 0,6 mm
08	0,8 mm
12	1,2 mm
16	1,6 mm
20	2,0 mm
24	2,4 mm
ZZ	Face cutting edge

⑧	Cutting edge design
Code	
	F sharp
	E rounded
	T chamfered (negative)
	S chamfered + rounded

⑨	Cutting direction of insert
Code	
	R R.H.
	L L.H.
	N R.H. and L.H.

⑩	Chipformer
Code	
-01	medium
-05	Cast iron
-11	Aluminium
-13	
-14	finishing
-15	semi-finishing
-21	
-32	
-33	



# Numerical Coding for Inserts C.. / W..

C	8	5	1	8	0	1	0	.	0	4	7	5	2	5
W	6	0	3	2	0	6	0	.	0	8	6	0		
W	2	9	2	4	0	1	0	.	0	4	8	4	2	5
①	②		③		④		⑤		⑥		⑦			

## ① Main group for standard inserts Code

## ② Secondary group number insert geometry

Code	Form	Version	peripheral	Chip groove	Clearance angle, other
00	Unisix®	standard	ground	ground	
01	Unisix®	strengthened	ground	ground	
04	Unisix®	6 edged	ground	ground	
05	Unisix®	6 edged	ground	ground	0°, wide flute
24	Unisix®	95° strengthened	sintered	sintered	
25	Unisix®	standard	sintered	sintered	
27	Unisix®	95° strengthened	ground	sintered	
28	Unisix®	standard	ground	sintered	
29	Unisix®	strengthened		sintered	
30	triangular		ground	ground	8°
32	triangular		ground	ground	11°
34	triangular	strengthened	ground	ground	
36	triangular	6 edged	ground	ground	0°
37	triangular		ground	ground	20°
57	triangular		ground	sintered	11°
58	triangular		ground	sintered	IC tolerance ±0,025
59	triangular	strengthened	ground	sintered	
60	rhomboid		ground	ground	
78	rhomboid		ground	sintered	
79	rhomboid		ground	sintered	
80	square		sintered	sintered	
82	square		ground	sintered	
83	square		sintered	sintered	

## ③ Inscribed circle d1

Code	d1
03	3,97 mm
04	4,0 mm
10	4,8 / 5,0 mm
12	5,5 mm
13	5,56 mm
14	5,6 mm
17	6,0 mm
18	6,2 / 6,35 mm
20	7,0 / 7,1 mm
22	7,7 mm
23	7,94 mm
24	8,0 mm
26	8,2 mm
28	8,9 mm
32	9,52 / 9,8 mm
34	10,0 mm
38	10,9 / 11,1 mm
42	12,0 mm
44	12,7 mm
46	13,2 mm
50	15,0 mm
53	15,88 mm
58	17,6 mm

## ⑤ Modification code

1 ... 9 Code

## ⑥ Geometry of cutting edge

Code	Description
01	R 0,1 mm
02	R 0,2 mm
03	R 0,3 mm
04	R 0,4 mm
05	R 0,5 mm
06	R 0,6 mm
08	R 0,8 mm
12	R 1,2 mm
30	U8.00 R 0
31	UF
32	US
33	U8.77 15° clearance angle additional cutt. edge form for Unisix® mill. cutter inserts
34	F / KUF 90°
35	F / KUF 75°
36	F / KUF 60°
39	R 0,05 mm
40	45° corner for chamfering cartridge
75	Support chamfer 75° L.H.
90	Support chamfer 90° L.H.

## ④ Type of chip groove / chip surface

Code ground	Code sintered		
00	L.H. cutting, neutral	00	Double chip groove (PD), cutting edge rounded
06	L.H. cutting, 6°	01	Double chip groove (K), cutting edge chamfered and rounded
12	L.H. cutting, 12°	02	Step geometry (KS), cutting edge chamfered and rounded
15	L.H. cutting, 15°	03	Dimple geometry (KX), cutting edge rounded
18	L.H. cutting, 18°	04	Finished geometry
20	L.H. cutting, 20°	05	10° chip groove (T), cutting edge rounded
30	R.H. cutting, neutral	06	12° chip groove (C), cutting edge rounded
36	R.H. cutting, 6°	07	Finished geometry
42	R.H. cutting, 12°	10	Shank geometry, cutting edge chamfered and rounded
45	R.H. cutting, 15°	11	20° chip groove, cutting edge rounded
48	R.H. cutting, 18°	12	Al / finished geometry
50	R.H. cutting, 20°	13	Shank geometry, cutting edge rounded
60	neutral	14	Finishing-Topographie
66	3x ground, 6°	15	Semi-finishing Topographie
70	3x ground, 10°	16	Semi-finishing Topographie with "Wiper" corner
72	3x ground, 12°	17	22° Topographie / tangential insert
80	3x ground, 20°	18	Finishing-Topographie with "Wiper" corner
82	L.H. cutting, 12° sharp-edged	20	Universal topography 8° top rake
83	R.H. cutting, 12° sharp-edged	21	20° Highly positive "Technology 21"
94	neutral, bright complete, L.H. and R.H. cutting	32	peripheral ground with minimal burring
98	bright with flute on corner, L.H. and R.H. cutting	33	peripheral sintered with minimal burring
99	neutral, bright on corner, L.H. and R.H. cutting		

## ⑦ Material grade

Code	Material grade	Code	Material grade
03	P25M	2715	BK2715
04	P40	2730	BK2730
22	K20	6115	BK6115
60	BK60	...	...

# Numerical Coding for Inserts W..

Programme ISO

W 8 5 1 8 0 0 0 . 0 8 8 4 2 5

① ② ③ ④ ⑤ ⑥ ⑦

① Main group for standard inserts  
Code

②	Secondary group number insert geometry
Code	ISO basic forms
83	S... square 90°
84	T... triangular 60°
85	C... rhomboid 80°
86	D... rhomboid 55°
89	V... rhomboid 35°
90	W... hexagonal 80°
95	R... round
97	threaded

③	Inscribed circle $d_1$
Code	
13	5,56 mm
18	6,35 mm
24	8,0 mm
32	9,52 mm
38	11,1 mm
44	12,7 mm
53	15,88 mm
62	19,05 mm

④	Serial number
Code	
00 ... 99	Code

⑤	Modification code
Code	
1 ... 9	Code

⑥	Serial number
Code	
01 ... 99	Code

⑦	Material grade
Code	
03	P25M
04	P40
22	K20
2715	BK2715
2730	BK2730
6115	BK6115
...	

# Numerical Coding for Inserts Q..

Q 2 1 4 4 0 0 0 . 0 1 2 7 3 0

Q 8 0 3 2 0 0 0 . 0 1 6 1 1 5

① ② ③ ④ ⑤ ⑥ ⑦

① Main group for standard inserts  
Code

②	Secondary group number insert geometry
Code	ISO basic forms
09	S... square 90°
12	T... triangular 60°
15	C... rhomboid 80°
21	E... rhomboid 75°
36	A... rhomboid form
80	L... square 90°

③	Inscribed circle $d_1$
Code	
13	5,56 mm
18	6,35 mm
24	8,0 mm
32	9,52 mm
38	11,1 mm
44	12,7 mm
53	15,88 mm

④	Serial number
Code	
00 ... 99	Code

⑤	Modification code
Code	
1 ... 9	Code

⑥	Serial number
Code	
01 ... 99	Code

⑦	Material grade
Code	
03	P25M
04	P40
22	K20
2715	BK2715
2730	BK2730
6115	BK6115
...	

# KOMET® Adaptors

Perfecting the connection

1



With our comprehension programme of tool adaptors we have the right answer for every requirement. Adaptors with connections specified by manufacturers available on request.

2



BENEFITS for you:

- Maximum tool change accuracy
- Perfect static rigidity
- High radial rigidity
- Short tool change times
- Ideal dimensions
- Low weight

3



4



5



6





## KOMET® Adaptor

Page

### HSK-A Adaptor ISO 12164-1

Boring bar holder 102

### ABS® Adaptor

Boring bar holder 103

Adaptor for turning tool 104

Eccentric reducer ABS® N 109

### VDI Adaptor

Adaptor NC..10 105

Adaptor NC..20 106

Torsional dampener NC..20 107

### Cylindrical adaptor

Adaptor ABS® N 108

## KOMET KomLoc® HSK clamping system

on request

Adaptor flange HSK-SVF 110

Built-in flange HSK-SEF 112

Short flange 114

Round shank adaptor 116

NC adaptor to DIN 69880 117 – 119

### Symbols



Machine adaptor  
Connection on machine side



Balancing note (chapter 7)  
Balance as despatched



Coolant supply



Concentricity



Lightweight



Vibration dampening  
torsion damping | bending vibration



adjustable  
radially | axially



Tool holder  
Connection on tool side

1



2



3



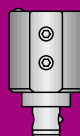
4



5



6

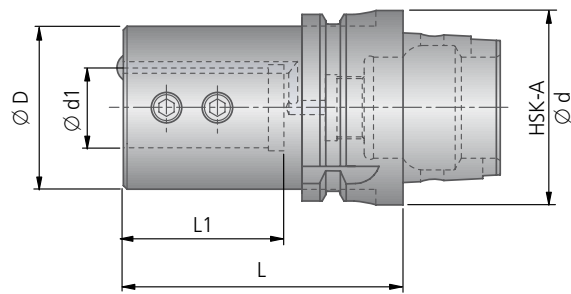


7



# KOMET® ISO 12164-1

## HSK-A Boring bar holder



HSK-A DIN 69893 T1 BA							
Article	Order No.	HSK-A Ø d	Ø d1	Ø D	L	L1	kg
HSK-A63-BA10	A06 34610	63	10	38	51	22	0,84
HSK-A63-BA12	A06 34620	63	12	40	56	27	0,90
HSK-A63-BA16	A06 34630	63	16	44	64	35	1,03
HSK-A63-BA20	A06 34640	63	20	53	71	41	1,30
HSK-A63-BA25	A06 34650	63	25	57	81	50	1,48
HSK-A63-BA32	A06 34660	63	32	70	96	66	2,10

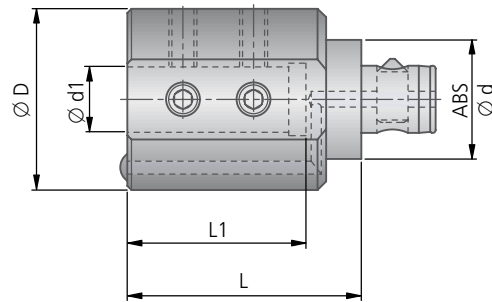
### Supply includes:

Boring bar holder mounted complete. Please order coolant supply connection and key separately (chapter 7).

ABS® Boring bar holder



on request



ABS® BA							
Article	Order No.	ABS Ø d	Ø d1	Ø D	L	L1	kg
ABS50-BA 8-L1	A35 04210	50	8	36	35	18	0,58
ABS50-BA10-L1	A35 04220	50	10	38	40	22	0,62
ABS50-BA12-L1	A35 04230	50	12	40	45	27	0,68
ABS50-BA16-L1	A35 04240	50	16	44	50	33	0,77
ABS50-BA20-L1	A35 04260	50	20	48	60	41	0,94
ABS50-BA25-L1	A35 04280	50	25	53	70	49	1,15
ABS50-BA32-L1	A35 04290	50	32	68	85	62,5	1,85

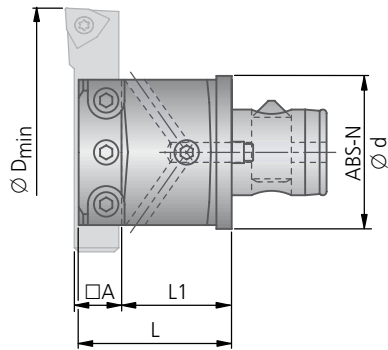
Supply includes:

Boring bar holder mounted complete.



# KOMET ABS® N

## Adaptor with ABS® N connection



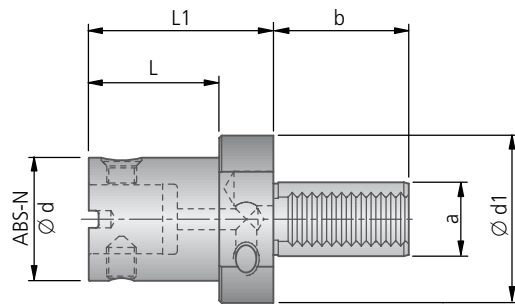
ABS® N								
Order No.	ABS-N Ø d	Ø D min.	L	L1	□ A		Threaded pin DIN 915	
							Article	Order No.
A36 33050	40	60	40	29	12		M6x12	55053 06012
A36 34050	50	75	50	36	16		M8x20	55053 08020
A36 35050	63	95	63	45	20		M10x20	55053 10020
A36 36050	80	120	80	58	25		M12x25	55053 12025
A36 37050	100	150	100	72	32		M16x30	55053 16030

Supply includes: Adaptor fitted complete, inclusive threaded pin.

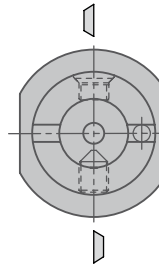


# KOMET ABS® N NC..10

## VDI Adaptor with ABS® N connection



Cutter position for all L. H. cutting tools



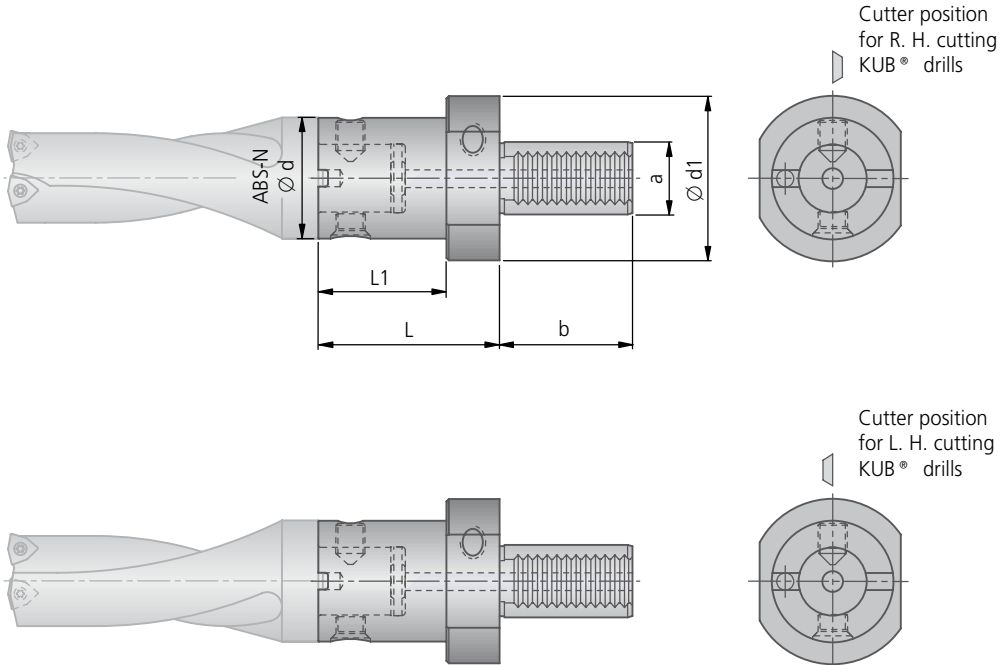
Cutter position for L. H. cutting KUB® Drills

ABS® N NC..10								
Article	Order No.	ABS-N Ø d	L	L1	a	b	Ø d1	kg
ABS50N-NC3010	A01 10151	50	60	38	30	55	68	1,33
ABS40N-NC4010	A01 10241	40	50	25	40	63	83	1,67
ABS50N-NC4010	A01 10251	50	60	38	40	63	83	1,90
ABS63N-NC4010	A01 10261	63	70	48	40	63	83	2,40
ABS80N-NC4010	A01 10271	80	75	53	40	63	83	2,98
ABS50N-NC5010	A01 10351	50	65	35	50	78	98	3,06
ABS63N-NC5010	A01 10361	63	75	45	50	78	98	3,06
ABS80N-NC5010	A01 10371	80	75	45	50	78	98	3,87
ABS50N-NC6010	A01 10451	50	65	35	60	94	123	4,80
ABS63N-NC6010	A01 10461	63	75	45	60	94	123	5,24
ABS80N-NC6010	A01 10471	80	75	45	60	94	123	5,63



# KOMET ABS® N NC..20

## VDI Adaptor with ABS® N connection

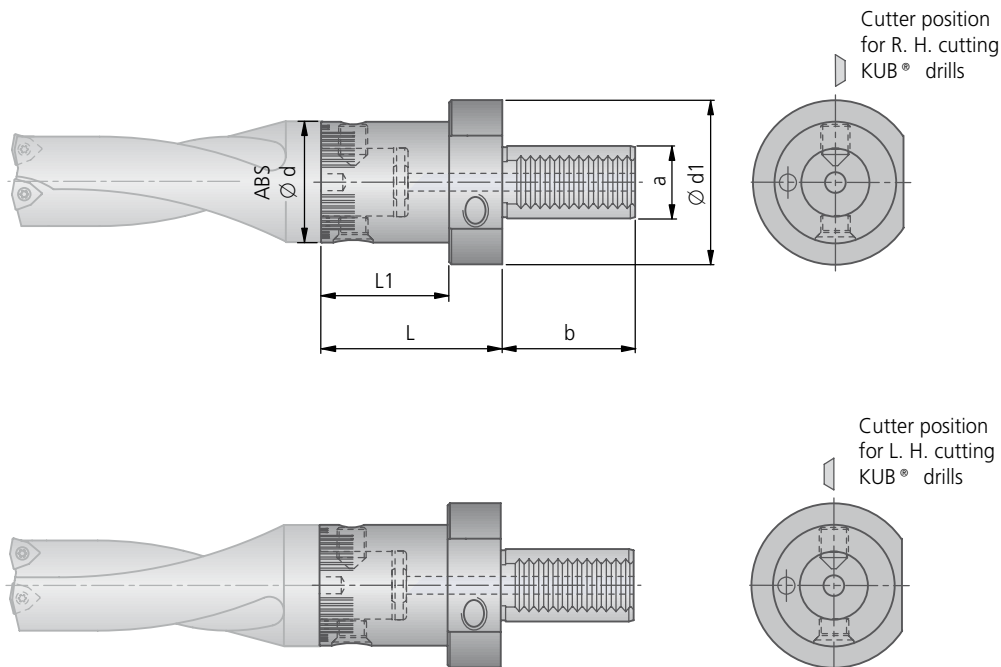
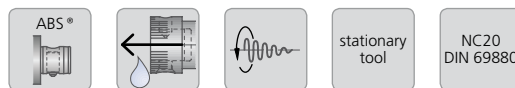


NC..20 ABS® N								
Article	Order No.	ABS-N Ø d	L	L1	a	b	Ø d1	kg
ABS50N-NC3020	A01 11152	50	60	38	30	55	68	1,33
ABS50N-NC4020	A01 11252	50	60	38	40	63	83	1,89
ABS63N-NC4020	A01 11262	63	70	48	40	63	83	2,35
ABS80N-NC4020	A01 11271	80	75	53	40	63	83	2,97
ABS50N-NC5020	A01 11352	50	65	35	50	78	98	3,06
ABS63N-NC5020	A01 11362	63	75	45	50	78	98	3,51
ABS80N-NC5020	A01 11372	80	75	45	50	78	98	3,86
ABS50N-NC6020	A01 11452	50	65	35	60	94	123	4,82
ABS63N-NC6020	A01 11462	63	75	45	60	94	123	5,24
ABS80N-NC6020	A01 11472	80	75	45	60	94	123	5,61
ABS100N-NC6020	A01 11482	100	90	60	60	94	123	7,00

**Note:**  
When adjusting the KUB® drill in + X direction, use this adaptor.

# KOMET ABS® NC..20 TSD

## VDI Torsional dampener with ABS® connection



NC..20 ABS® TSD								
Article	Order No.	ABS Ø d	L	L1	a	b	Ø d1	kg
NC4020 ABS50-TSD	A01 14251	50	60	38	40	63	83	1,89
NC4020 ABS63-TSD	A01 14261	63	70	48	40	63	83	2,35
NC5020 ABS50-TSD	A01 14351	50	65	35	50	78	98	3,06
NC5020 ABS63-TSD	A01 14361	63	75	45	50	78	98	3,51
NC5020 ABS80-TSD	A01 14370	80	75	45	50	78	98	3,86

The torsional dampeners are designed for solid drills in line with the torque which is produced.

Recommended use:

...-ABS50-TSD for drill Ø 14 - 44 mm

...-ABS63-TSD for drill Ø 45 - 54 mm

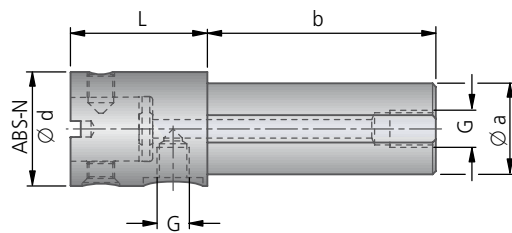
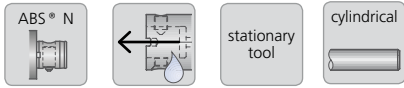
...-ABS80-TSD for drill Ø 55 - 81 mm

For drill heads V464 with larger diameters we recommend the use of appropriate reducers (available on request).



# KOMET ABS® N TC

## Adaptor with ABS® N connection

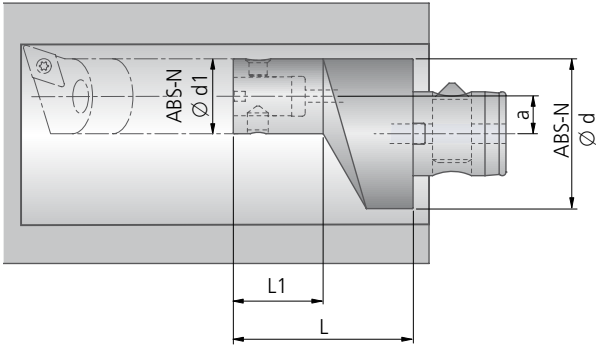
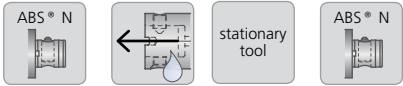



ABS® N TC							
Article	Order No.	ABS-N Ø d	L	Ø a	b	G	kg
ABS50N-TC40	A01 15450	50	60	40	100	G3/8"	1,67
ABS63N-TC40	A01 15460	63	65	40	100	G3/8"	2,25
ABS50N-TC50	A01 15550	50	60	50	120	G3/8"	2,50
ABS63N-TC50	A01 15560	63	65	50	120	G3/8"	3,10
ABS80N-TC50	A01 15570	80	70	50	120	G3/8"	3,94
ABS50N-TC60	A01 15650	50	60	60	120	G3/8"	3,35
ABS63N-TC60	A01 15660	63	65	60	120	G3/8"	3,87
ABS80N-TC60	A01 15670	80	70	60	120	G3/8"	4,84
ABS50N-TC80	A01 15750	50	60	80	160	G3/8"	6,87
ABS63N-TC80	A01 15760	63	65	80	160	G3/8"	7,41
ABS80N-TC80	A01 15770	80	70	80	160	G3/8"	8,25
ABS100N-TC80	A01 15780	100	90	80	160	G3/8"	10,38

We supply other shank versions on request.

# KOMET ABS® N

## Eccentric reducer with ABS® N connection



ABS® N							
Article	Order No.	ABS-N Ø d	ABS-N Ø d1	L	L1	a	
ABS80N-R50	A20 13080	80	50	60	35	15,0	

Supply includes: Reducer mounted complete.



# KOMET KomLoc® HSK clamping system

## Adaptor flange HSK-SVF on request

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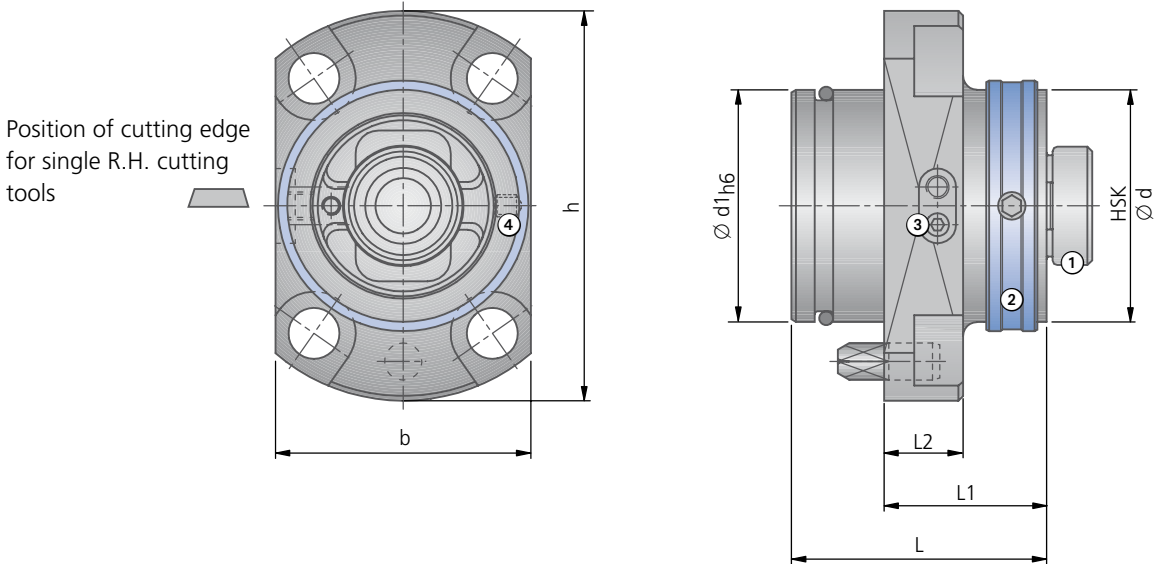
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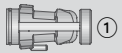





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KomLoc® HSK-SVF											Cylindrical screw DIN 912		
Order No. Article	HSK Ø d	Ø d1	L	L1	L2	b	h	kg	Clamping device KomLoc®  ① Order No.	Sealing ring, turning  ② Order No.	Spring screw ③  ③ Order No.	Ball pressure screw ④  ④ Order No.	Order No. Article
A08 61040 HSK-50 SVFL	50	50	55	35	17	55	84		L07 01050	L07 01750	L07 01550	N10 30739	55011 06020 M6×20

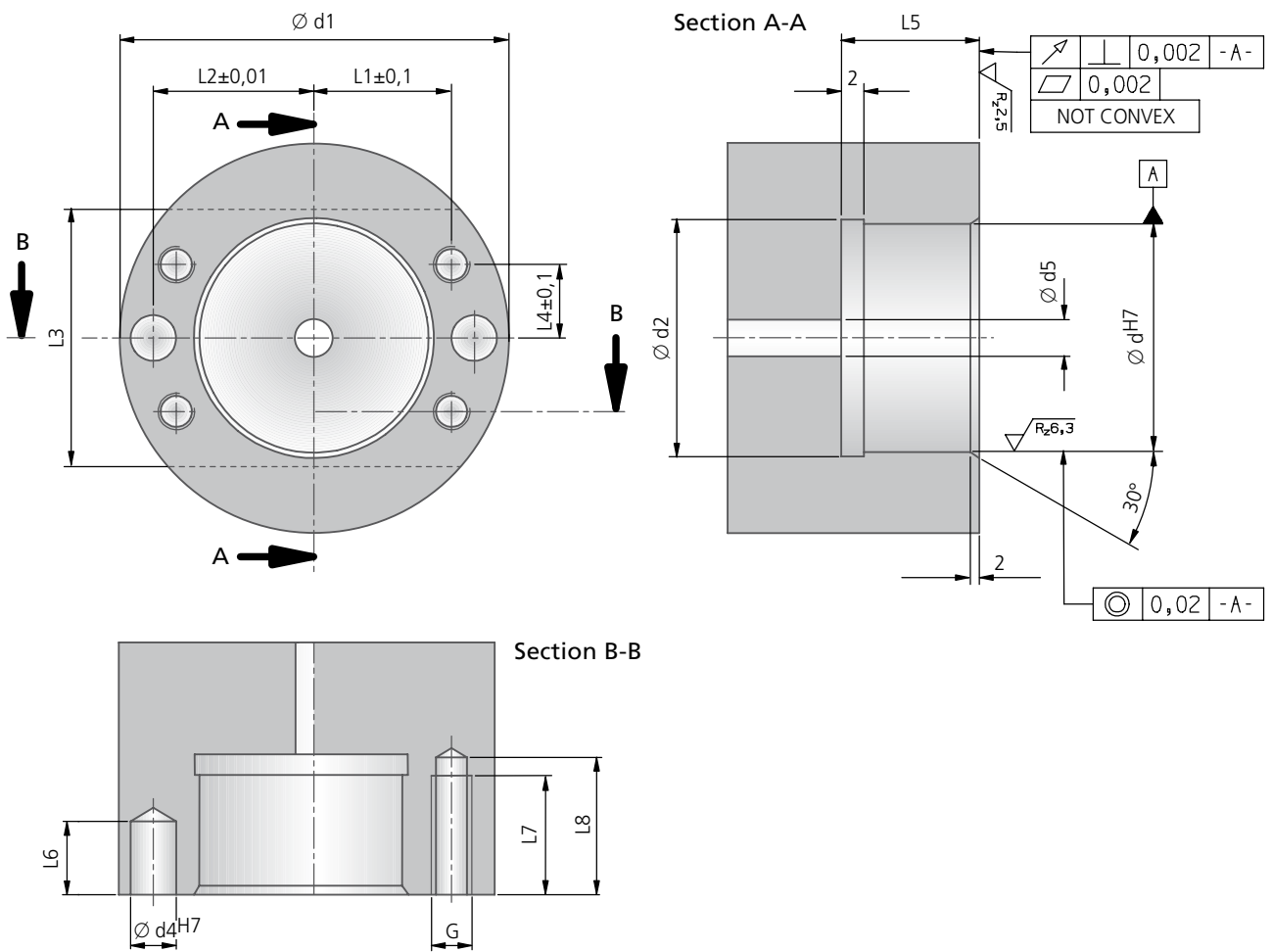
### Supply includes:

Adaptor flange with clamping device KomLoc® ①, sealing ring ②, spring screw ③, ball pressure screw ④ and Allen key.  
Please order cylindrical screws for mounting separately.

**Note:** Please use the wiper to clean the taper and the contact face (chapter 7)

# KOMET KomLoc® HSK clamping system

## Connection dimensions for adaptor flange HSK-SVF



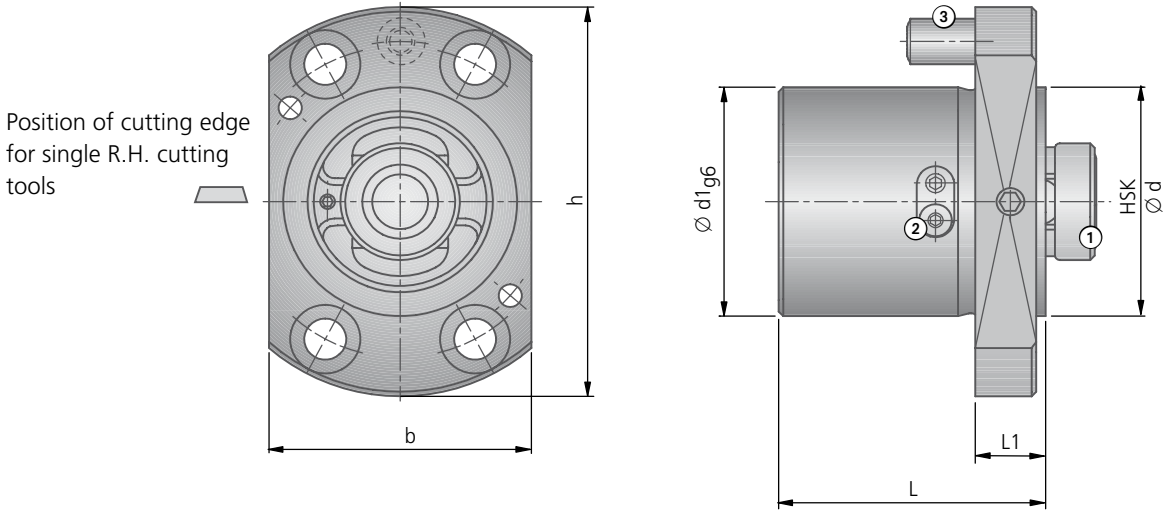
KomLoc® HSK-SVF														
for adaptor flange	$\varnothing d$	$\varnothing d1$	$\varnothing d2$	$\varnothing d4$	$\varnothing d5$	G	L1	L2	L3	L4	L5	L6	L7	L8
A08 61040	50	84	52	8	10	M10	27,44	33,5	55	19,22	21	15	20	25



# KOMET KomLoc® HSK clamping system

## Built-in flange HSK-SEF on request

shown in SEFR flange version



KomLoc® HSK-SEF										Cylindrical screw DIN 912	
Order No. Article	HSK Ø d	Ø d1	L	L1	b	h	kg	Clamping device KomLoc® Order No.	Spring screw ② Order No.	Cylindrical pin ③ Order No.	Order No. Article
A08 41010 HSK-32 SEFL	32	32	37	10	36	55	0,24	L07 01030	-	55321 06016	55011 05012 M5×12
A08 41070 HSK-32 SEFR											
A08 51010 HSK-40 SEFL	40	40	45	12	45	68	0,45	L07 01040	-	55321 08020	55011 06016 M6×16
A08 61010 HSK-50 SEFL											
A08 61070 HSK-50 SEFR	50	50	57	15	56	85	0,87	L07 01050	L07 01550	55321 10028	55011 08018 M8×18
A08 71010 HSK-63 SEFL											
A08 71070 HSK-63 SEFR	63	63	70	15	70	106	1,64	L07 01060	L07 01560	55321 12036	55011 08018 M8×18

### Supply includes:

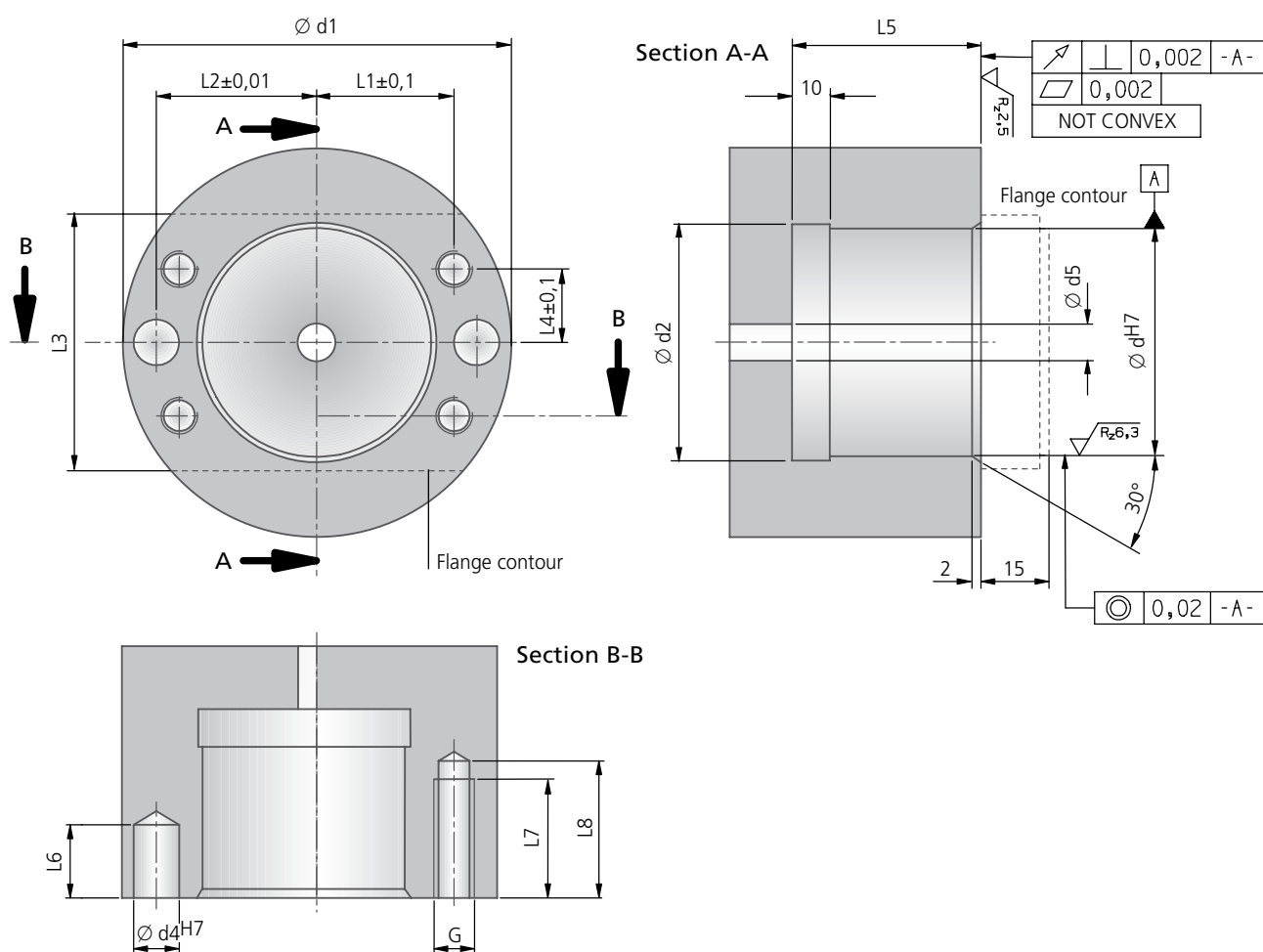
Built-in flange with clamping device KomLoc® ①, spring screw ② and cylindrical pin ③.  
Please order cylindrical screws for mounting separately.

**Note:** Please use the wiper to clean the taper and the contact face (chapter 7)



# KOMET KomLoc® HSK clamping system

## Connection dimensions for built-in flange HSK-SEF



KomLoc® HSK-SEF														
for built-in flange	$\varnothing d$	$\varnothing d1$	$\varnothing d2$	$\varnothing d4$	$\varnothing d5$	G	L1	L2	L3	L4	L5	L6	L7	L8
A08 41010	32	55	34	6	8	M5	19,2	22	36	10,5	28	10	12	16
A08 41070														
A08 51010	40	68	42	8	8	M6	23	27	45	13,5	34	12	14	18
A08 61010	50	85	52	10	8	M8	30	35	56	16	43	15	16	20
A08 61070														
A08 71010	63	106	65	12	8	M8	37	44	70	20,5	56	24	16	20
A08 71070														

# KOMET KomLoc® HSK clamping system

Short flange HSK  
on request

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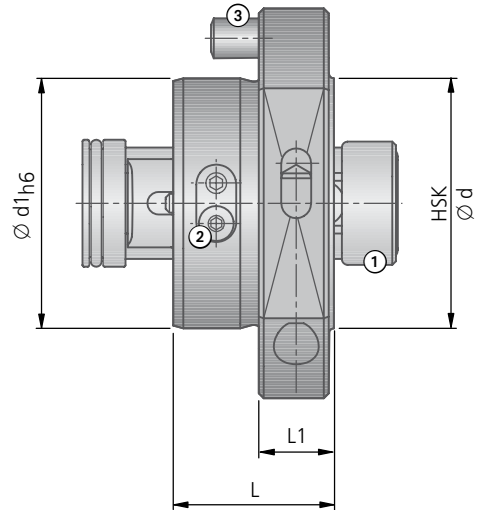
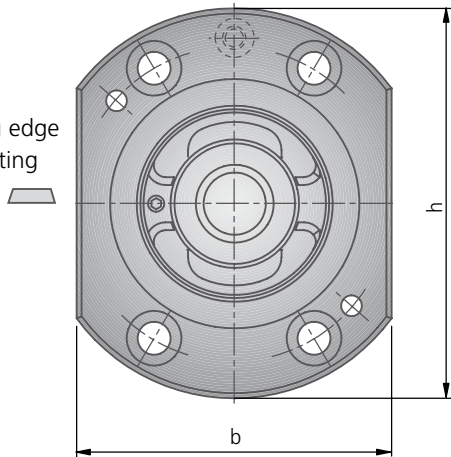
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Position of cutting edge  
for single R.H. cutting  
tools



KomLoc® HSK											
Order No. Article	HSK Ø d	Ø d1	L	L1	b	h	kg	Clamping device KomLoc® ① Order No.	Spring screw ② Order No.	Cylindrical pin ③ Order No.	Cylindrical screw DIN 912 Order No. Article
A08 61021 HSK-50KL	50	50	32,10	15	63	78	0,63	L07 01050	L07 01550	55321 08024	55011 06016 M6×16
A08 61081 HSK-50KR											
A08 71021 HSK-63KL	63	63	40,05	15	78	97	1,13	L07 01060	L07 01560	55321 10028	55011 08020 M8×20
A08 71081 HSK-63KR											

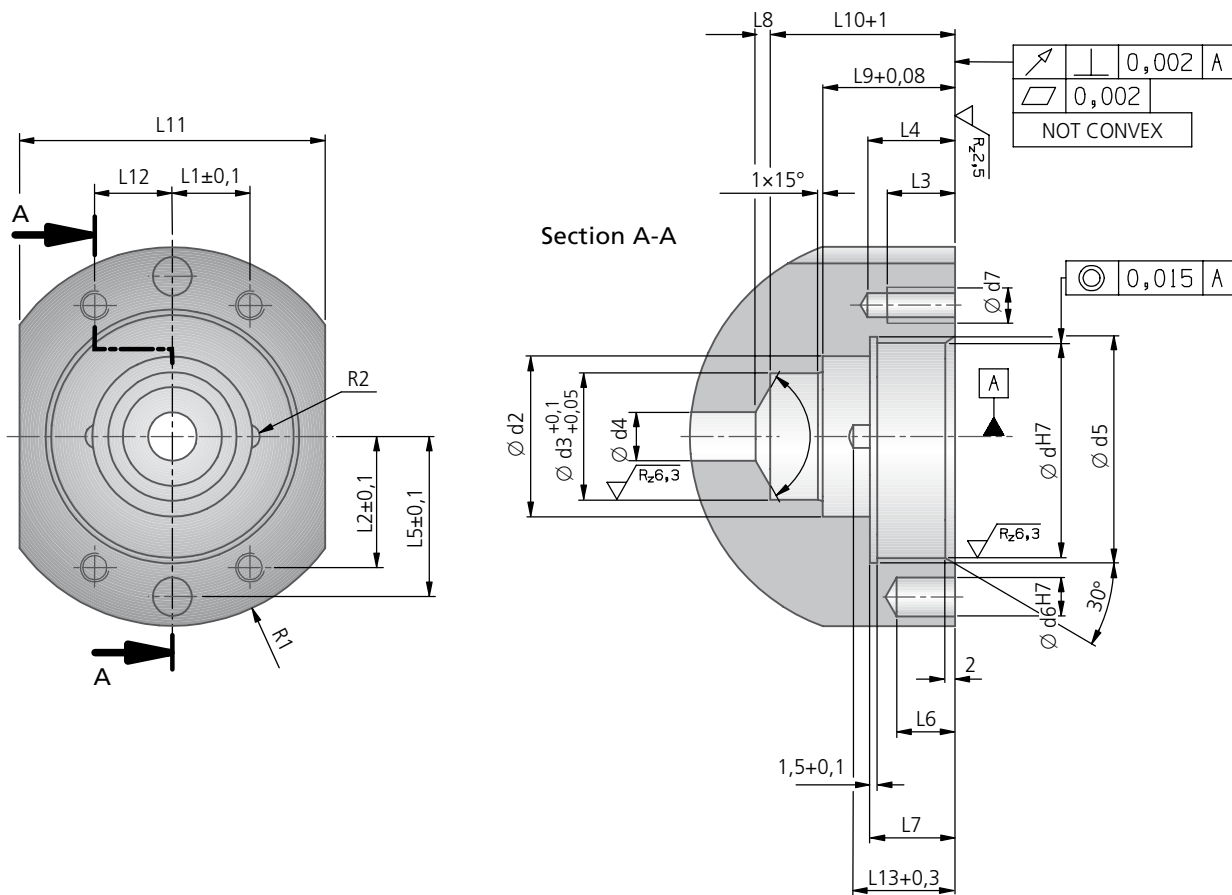
**Supply includes:**

Short flange with clamping device KomLoc® ①, spring screw ② and cylindrical pin ③.  
Please order cylindrical screws for mounting separately.

**Note:** Please use the wiper to clean the taper and the contact face (chapter 7)

# KOMET KomLoc® HSK clamping system

## Connection dimensions for short flange HSK



KomLoc® HSK																						
for short flange	$\phi d$	$\phi d2$	$\phi d3$	$\phi d4$	$\phi d5$	$\phi d6$	$\phi d7$	L1	L2	L3	L4	L5	L6	L7	L8	L9	L10	L11	L12	L13	R1	R2
A08 61021	50	33	26	10	52	8	M6	16	27	14	18	33	12	17,5	3	27,2	38	63	15,5	21	39	2,5
A08 61081																						
A08 71021	63	42,5	34	16	65	10	M8	20	34	16	20	40	16	25,5	3,5	37,8	50	78	20	31,5	48,5	3
A08 71081																						

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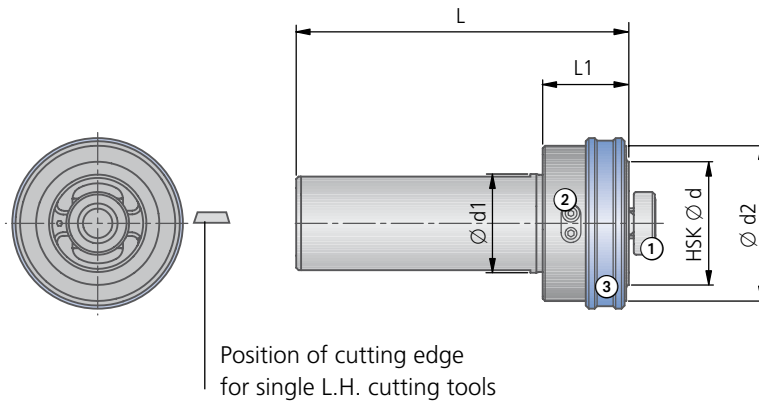
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



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# KOMET KomLoc® HSK clamping system

Round shank adaptor HSK  
on request



KomLoc® HSK										
Article	Order No.	HSK Ø d	Ø d1	Ø d2	L	L1	 kg	Clamping device KomLoc®  ① Order No.	Spring screw ②  Order No.	Sealing ring, shifting  ③ Order No.
HSK-50 K D40R	A08 61360	50	40	63	135	35	1,56	L07 01050	L07 01550	L07 01450
HSK-50 K D40L	A08 61370									
HSK-63 K D50R	A08 71360	63	50	80	160	40	2,89	L07 01060	L07 01560	L07 01460
HSK-63 K D50L	A08 71370									

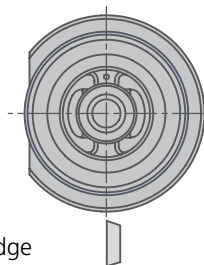
### Supply includes:

Adaptor with clamping device KomLoc® ①, spring screw ②, sealing ring ③ and Allen key.  
Please order coolant supply connection and key separately (chapter 7).

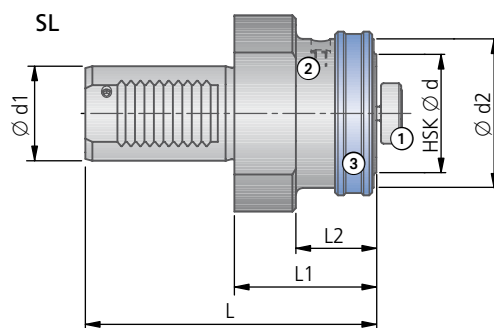
**Note:** Please use the wiper to clean the taper and the contact face (chapter 7).

# KOMET KomLoc® HSK clamping system

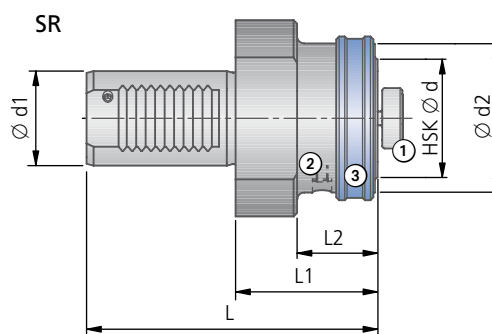
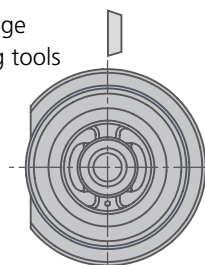
NC adaptor to DIN 69880, straight  
on request



Position of cutting edge  
for single L.H. cutting tools



Position of cutting edge  
for single R.H. cutting tools



KomLoc® HSK											
Article	Order No.	HSK $\varnothing d$	$\varnothing d1$	$\varnothing d2$	L	L1	L2	kg	Clamping device KomLoc® Order No. ①	Spring screw ② Order No.	Sealing ring, shifting Order No. ③
HSK-50K NC40 SR	A08 61500	50	40	63	123	60	34	2,2	L07 01050	L07 01550	L07 01450
HSK-50K NC40 SL	A08 61510										
HSK-63K NC50 SR	A08 71500	63	50	80	148	70	44	4,0	L07 01060	L07 01560	L07 01460
HSK-63K NC50 SL	A08 71510										

### Supply includes:

Adaptor with clamping device KomLoc® ①, spring screw ②, sealing ring ③ and Allen key.  
Please order coolant supply connection and key separately (chapter 7).

**Note:** Please use the wiper to clean the taper and the contact face (chapter 7).

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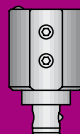
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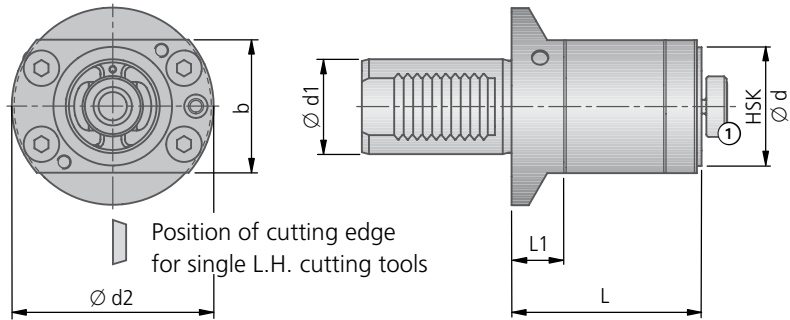


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# KOMET KomLoc® HSK clamping system

NC adaptor to DIN 69880, straight  
on request



KomLoc® HSK										
Article	Order No.	HSK Ø d	Ø d1	Ø d2	b	L	L1	kg	Clamping device KomLoc®	Built-in flange
									Order No. ①	Order No.
HSK-63 K NC40SL II	A08 71580	63	40	97	78	80	22	4,0	L07 01060	A08 71021
HSK-63 K NC50SL II	A08 71590	63	50	97	78	95	30	5,6	L07 01060	A08 71021

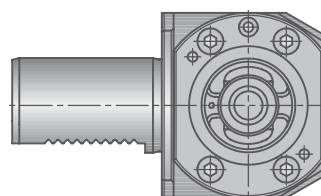
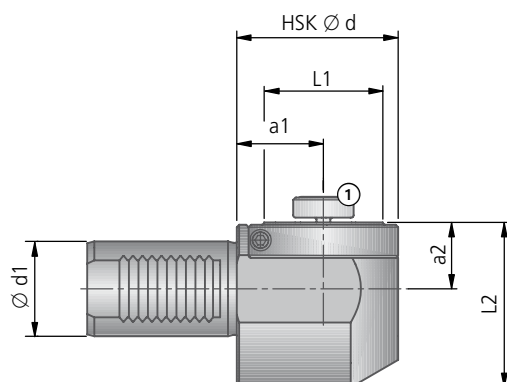
**Supply includes:**

Adaptor with clamping device KomLoc® ① and Allen key.  
Please order coolant supply connection and key separately (chapter 7).

**Note:** Please use the wiper to clean the taper and the contact face (chapter 7).

# KOMET KomLoc® HSK clamping system

NC adaptor to DIN 69880, angled  
on request



Position of cutting edge  
for single L.H. cutting tools

KomLoc® HSK										
Article	Order No.	HSK Ø d	Ø d1	L1	L2	a1	a2	kg	Clamping device KomLoc®	Built-in flange
									Order No. ①	Order No.
HSK-50 K NC40 AL	A08 61530	50	40	68	69,5	36,5	28	2,7	L07 01050	A08 61021
HSK-63 K NC50 AL	A08 71530	63	50	83	78	44	29	4,5	L07 01060	A08 71021

## Supply includes:

Adaptor with clamping device KomLoc® ① and Allen key.

Please order coolant supply connection and key separately (chapter 7).

**Note:** Please use the wiper to clean the taper and the contact face (chapter 7).

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## The ideas factory

The IDEEN-FABRIK reflects the evolution of the KOMET GROUP from a tool manufacturer into a creative expert for solutions covering all aspects of boring, reaming, thread milling and mechatronic tools.

The central objective is to offer our customers and employees scope for creative working and learning.

On a total area of 2,500 m<sup>2</sup>, we have created a modern, multi-storey factory environment. The IDEEN-FABRIK was deliberately not constructed as a separate, detached training building, but integrated directly above a manufacturing business.

While the metal swarf flies down below, ideas are exchanged above. By this, we aim to demonstrate that the work here is always associated with new ideas and creative ambition.

With the IDEEN-FABRIK and the comprehensive seminar programme for customers and employee qualification, we aim to offer you a measurable and permanent competitive advantage in your markets.

Ask for our no-obligation specialist seminar brochure.

7







## TOOLS+IDEAS®

The KOMET GROUP is the worldwide technology leader for innovative tool concepts and complete solutions for drilling machining.

Our customers know us as a manufacturer of premium tools, and know the ideas behind our solutions. The further creativity is still unused, and remains to be discovered. We have set ourselves the objective of exploiting the added value thus created for the benefit of our customers.

We call this TOOLS+IDEAS. A new and different way of being able to offer our customers long-term, sustainable advantages through a plus in support and services.

Our IDEEN-FABRIK in Besigheim is the first step in this direction.

## Informations

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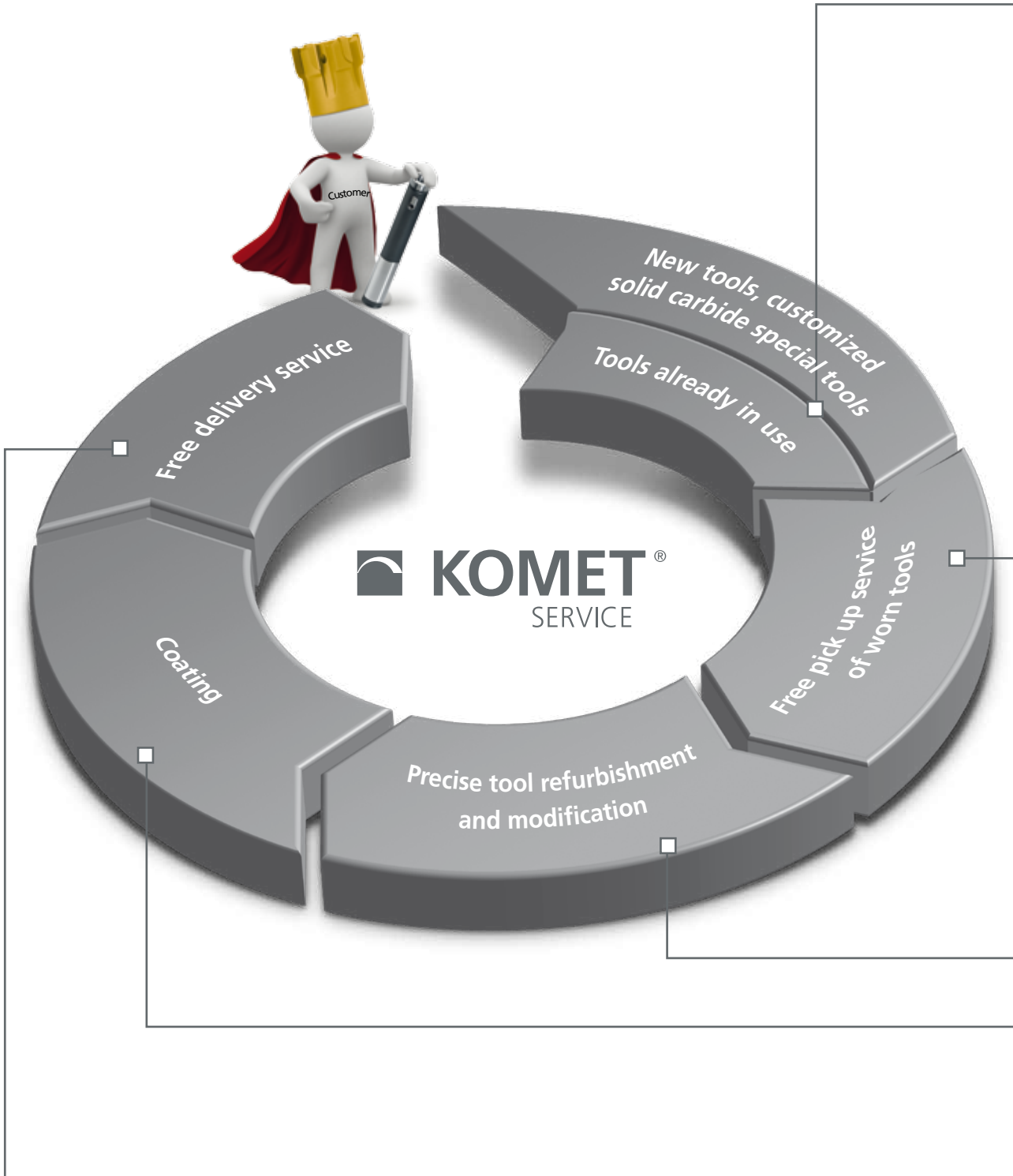
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# KOMET SERVICE®

the service brand name of the KOMET GROUP

A network of local partners that provide professional tool refurbishment, trade tools and manufacture customized solid carbide special tools. Everything from a single source. Fast, flexible and always close to you.





### From stock or individually manufactured

Get your solid carbide *TOOLlife* tools directly from your KOMET SERVICE® partner or have your own customized solid carbide special tools manufactured.

Your KOMET SERVICE® partner will happily refurbish these tools along with all tools from other brands.



### One call does it all

Get on a regular pick-up schedule or arrange a one-time pick-up of your tools needing refurbishment by your KOMET SERVICE® partner. It's fast and it's free.



### Tools refurbished to original quality

Our refurbishing experts fairly assess the current state of your tools (irrespective of the manufacturer) in order to recommend refurbishment or replacement.

KOMET GROUP tools are refurbished according to strict criteria to restore the original geometry or original tipping. By request you receive a measurement report. Our partners will also professionally modify tools for you, quickly and flexibly.



### Coating – fully customized

KOMET GROUP tools are of course given the original coatings once more. We customize our service to your needs, even with other standard coatings, all within a few days.



### Just-in-time delivery

Your KOMET SERVICE® partner will return your KOMET GROUP tools refurbished to their original quality within 5 or 10 days (without or with coating) – safely stored in the KOMET SERVICE® *TOOLlife* box.

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**1** Castelar Tool & Grinding Inc.  
2775 Slough St.  
L4T 1G2, Mississauga, Ontario, Canada  
Tel. +1 9056773090  
Fax +1 9056773091  
castelar@kometservice.com

**2** NTM, Inc.  
140 NE Liberty Street  
Minneapolis, MN 55432, USA  
Tel. +1 763 780 1420  
Fax +1 763 780 8921  
Toll Free +1 800 274 4686  
ntm@kometservice.com

**3** Integrity Saw & Tool  
507 West Rolling Meadows Drive  
Fond du Lac, WI 54937, USA  
Tel. +1 920 923 4474  
Fax +1 920 923 4407  
integrity@kometservice.com

**4** Ekstrom Carlson  
5248 27th Avenue  
Rockford, IL 61109, USA  
Tel. +1 815 394 1744  
Fax +1 815 316 8120  
ekstrom@kometservice.com

**5** Countyline Tool, Inc.  
3303 N. Main Street  
East Peoria, IL 61611, USA  
Tel. +1 309 694 2400  
Fax +1 309 694 2445  
countyline@kometservice.com

**6** Tri-State Tool Grinding  
5311-A Robert Ave  
Cincinnati, OH 45248, USA  
Tel. +1 513 347 0100  
Fax +1 513 347 3728  
tristate@kometservice.com

**7** Brecker's ABC Tool Company  
15919 East 12 Mile Road  
Roseville, MI 48066, USA  
Tel. +1 5867791122  
Fax +1 5867790157  
breckers@kometservice.com

**8** Razor Tool, Inc.  
41 Elm Street  
Stoneham, MA 02180, USA  
Tel. +1 7816541582  
razortool@kometservice.com

**9** Cutting Tool Engineers, Inc.  
208 Commerce Parkway  
Pelham, AL 35124, USA  
Tel. +1 2057330100  
Fax +1 2057330191  
CTE@kometservice.com

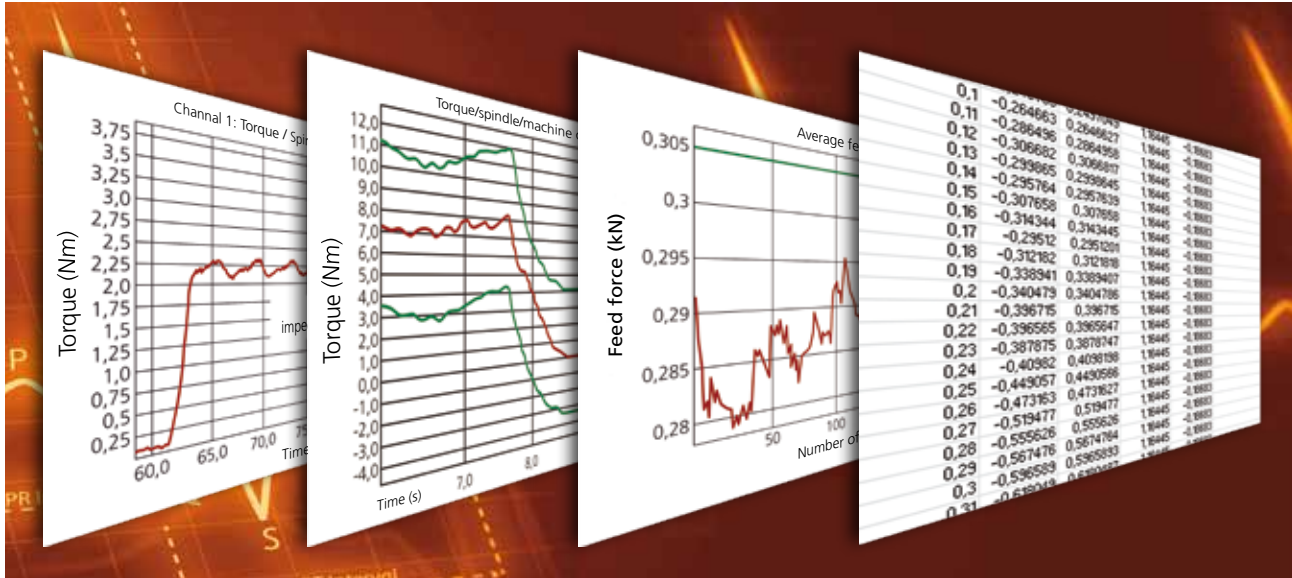
**10** Grinding Technology, LLC  
220 Barren Springs Drive  
Houston, TX 77090, USA  
Tel. +1 7139107719  
Fax +1 7139107554  
GT@kometservice.com





# KOMET® BRINKHAUS ToolScope

## Process monitoring – the benefit for your production



Visualisation

Monitoring

Optimisation

Documentation

### Next generation process monitoring

Growing automation in the machining industry increases the demand for more process and machine tool monitoring, which can help minimize machine down time and reduce scrap rates, detect and manage wear in mass series production, thereby improving the delivery times to your customers.

Based on the latest technology of process and machine tool monitoring, the ToolScope System from KOMET® BRINKHAUS relies on a unique, patented method for statistical process monitoring which not only detects breakage but also recognizes considerably smaller process deviations. In addition to the usual procedures of process control, the ToolScope System provides a procedure for monitoring quality while a process is running.



### KOMET® BRINKHAUS ToolScope adds considerable value to your production

KOMET® BRINKHAUS ToolScope has an advantage over other systems not only because it features the latest technology, but also because of its modularity and user-friendliness. Above that, many additional modules like Adaptive Feed Control, Condition Monitoring or Energy Monitoring underline the multiplicity of the system. Finally we offer with our wide network of application tools and process specialist service up to the complete management of system and production process.

### BENEFITS for you:

- Wide network of KOMET® tool and process experts, which can support the operation of the system
- Automatic documentation of the process data as a PDF, PNG or Excel file
- Online visualization of the process (oscilloscope function) to support the set-up procedure, e.g. in order to promptly detect the jamming of chips
- Monitoring for tool wear and missing tool
- Six Sigma Strategy: statistical process verification and process quality monitoring
- Monitoring of any and all possible sensor signals
- Dynamic Monitoring Module: Process monitoring for small batch runs which alleviates the need for a learning period
- Evaluating analogue sensor signals with up to 10 kHz
- Adaptive Control (AC) Module: Optimization of the essential operating time through process acceleration for tools that are underused, and speed reduction for tools that are overused
- Monitoring of the vibration behavior of bearings, axles, spindles and tools
- Measuring without (additional) sensors: The sensor data is read directly from the CNC via Profibus or TCP/IP
- Operation via the machine control system HMI or using a touch screen
- Modular program structure enables the optimal adjustment to customer needs
- Many additional modules like chatter recognition and control, Condition Monitoring, Energy Monitoring etc.

Dimensions (WxDxH)	Data – mm (inch)	Note
IPC version	215x272x114 (8.465x10.708x4.488)	
DIN Rail Module	200x140x110 (7.874x5.512x4.331)	
Touch Panel PC version	410x320x90 (16.142x12.598x3.543)	15" Display

Interfaces	Sampling frequency	Note
Profibus with synchronous actions / PLC-Transfere	Sampling frequency approx. 20 - 30 Hz	
Profibus with compile cycle	Sampling frequency approx. 100 - 500 Hz	see below
TCP/IP	yes	HMI-visualization over TCP/IP
Analog input channels	up to 10 kHz	16 inputs, during monitoring perhaps lower sample rate
Digital input/output channels		16 input/output channels each

**Supported control systems**  
Siemens 840D SL, 840D PL, Heidenhain >iTNC530, Fanuc >3xi, Bosch Rexroth, Beckhoff. From year of manufacture 2005 applies for all control systems, other types and years of manufacture possible on request.

Profibus connection (Siemens)	
Requirements for compile cycle Sample rate approx. 100 Hz	<p><b>Drive hardware:</b> SIMODRIVE® 611D based drive system, digital drive, delivers digital current/torque information</p> <p><b>Control hardware:</b> SINUMERIK® 840D, • NCU: 572.3 or 573.2 or higher (572.2 only SW4.4), • storage: min. 32 MB, • PROFIBUS interface</p> <p><b>Control software:</b> SINUMERIK® 840D technology board, version 05.03.06 (NCU_05.03.18) or 04.04.11 (NCU_04.04.37) or higher</p>
Requirements for compile cycle Sample rate approx. 100 - 500 Hz	<p><b>In addition to the above mentioned requirements, the following must apply:</b></p> <p><b>Control software:</b> SINUMERIK® 840D, NC-Software ≥ 06.03</p>

Visualization on HMI (only Siemens)	
Requirements	Windows® 95 and later, network card

**Start monitoring with the KOMET® BRINKHAUS ToolScope system**  
Monitoring can automatically be started by changing from G0 to G1. Furthermore the processes can automatically be stored in reference to the tool number, workpiece number, program name, etc.

Functionality	
Visualization	Each process can easily and continuously be visualized (oscilloscope function).
Data logging	Each process is automatically stored on the hard disk (logbook).
Filtering	The system offers a variety of filters such as average value, effective value, RMS, variance, etc. as standard for the filtering of the input signals.
Monitoring tool breakage	The basic system contains a self learning algorithm to recognize tool breakage. The tolerance bands are simply and automatically identified.
Monitoring tool wear	The system offers tracing and monitoring of tool wear. By setting warning thresholds, the operator can be forewarned of worn tools.
Six Sigma Strategy (optional) Online statistical process control	With this monitoring algorithm, minimal process deviations such as wear, larger cavities, changes in material can be recognized during constant serial production processes. This is equivalent to conducting real-time quality control while a process is running.
Adaptive Control (AC) Module (optional)	With adaptive control, the feed is optimized so that the effective power of the tool remains as constant as possible. Therefore, the essential operation time can significantly be reduced, e.g. during roughing. Moreover, the feed can be reduced if an effective power limit is exceeded, thus protecting the tool.
Dynamic Monitoring Module (optional)	With this monitoring strategy, the process and the tool can be monitored from as early as lot size 1. Here the system is also fully self-learning.

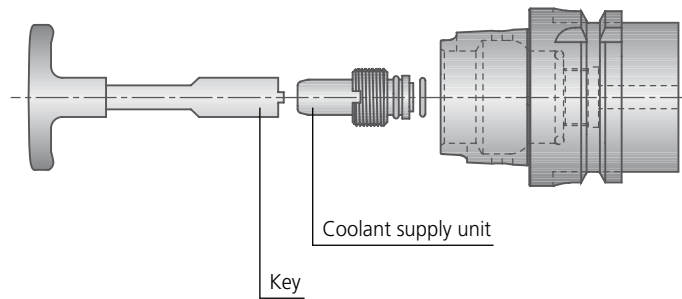
KOMET® BRINKHAUS ToolScope Basic system including installation / commissioning: Order No. E65 01010		
Enhanced with:	Dynamic Monitoring Module Order No. E65 21020	Adaptive Control (AC) Module Order No. E65 21030



# KOMET® HSK-A

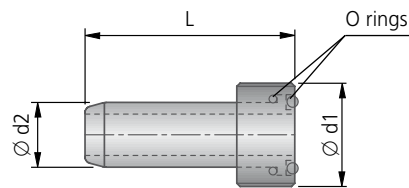
## Accessories HSK-A

### Mounting of the coolant supply unit



**Note:**

The coolant supply unit should be fitted in the tool with the key, to ensure a seal is produced. A coolant supply unit specifically for the machine can also be fitted, if required, using the thread in the tool.



HSK-A size	Key	Coolant supply unit						
	Order No.	Order No.	Ø d1	Ø d2	L	O ring face side and over tube		Order No.
32	18021 01032	51391 00032	M10×1,0	6	26	5×1,2	2×	52914 00512
40	18021 01040	51391 00040	M12×1,0	8	29,1	7,5×1,5	2×	52914 00751
50	18021 01050	51391 00050	M16×1,0	10	32,7	9×2	2×	52914 00920
63	18021 01063	51391 00063	M18×1,0	12	36,2	10×2,5 10×2	1× 1×	52914 01025 52914 01020
80	18021 01080	51391 00080	M20×1,5	14	39,7	13×2	2×	52914 01320
100	18021 01100	51391 00100	M24×1,5	16	43,6	14×3	2×	52914 01430

**Supply coolant supply unit includes:**  
Coolant tube, locking collar and two O rings.

**Note re. supply:**

The coolant supply connection for the tool adaptors must be ordered separately.

Only use the keys listed for assembly.

This will prevent coolant flowing back into the machine spindle/clamping system.

A specific coolant hose for the machine can also be fitted on all HSK adaptors.



The application details given depend on the environmental and application conditions (e.g. machine, ambient temperature, lubricant/coolant used and machining result required): they are based on the correct application conditions, correct use and compliance with the spindle speed limits given for the tools.

All measurement specifications stated in the catalogue apply to the metric unit system, unless they are expressly identified using another unit of measurement.

**Hazard warning:**

If using tungsten carbide-based hard metal products together with cobalt as a binder metal, please read our safety data sheets, which are available for you to download from our website.

(<http://www.kometgroup.com/navigation-top/download/service/datenblaetter.html>)

**Balancing note:**

Tool holders or adaptors are only balanced as supplied, i.e. no allowance has been made for items which can alter this, such as boring tools, milling cutters, inserts, etc. When used at high speeds, we recommend precision balancing be carried out when the tool is fitted ready for use.

1



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## Screwdriver | Key

To ensure the correct starting torque on screws, the torque key from the TORX PLUS® system has. Complies with the following requirements: EN ISO 6789, BS EN 26789, ASME B107.14M (with certificate).

1



**Torque wrench TorqueFix®**  
with fixed preset torque  
accuracy: ± 6% release torque: + 30%

TorqueFix®			appropriate replaceable blade
Size	Torque	Order No.	Order No.
5IP	0,38 Nm	L05 00901	L05 00700
6IP	0,62 Nm	L05 00911	L05 00710
6IP	1,01 Nm	L05 03301	
7IP	0,90 Nm	L05 00921	L05 00720
8IP	1,28 Nm	L05 00931	L05 00730
8IP	2,25 Nm	L05 03311	
9IP	2,50 Nm	L05 00941	L05 00740
10IP	2,80 Nm	L05 00951	L05 00750
15IP	4,30 Nm	L05 00961	L05 00760
20IP	6,25 Nm	L05 00971	L05 00770

Supply includes: Torque wrench without replaceable blade.

2



**Torque wrench easyTorque**  
with fixed preset torque  
accuracy: ± 10% release torque: unbounded

easyTorque			appropriate replaceable blade
Size	Torque	Order No.	Order No.
5IP	0,38 Nm	L05 00902	L05 00700
6IP	0,62 Nm	L05 00912	L05 00710
6IP	1,01 Nm	L05 00922	
8IP	1,28 Nm	L05 00932	L05 00730
8IP	1,8 Nm	L05 03320	
8IP	2,25 Nm	L05 00942	
9IP	2,50 Nm	L05 00952	L05 00740
10IP	2,80 Nm	L05 00962	L05 00750
15IP	4,30 Nm	L05 00972	L05 00760

Supply includes: Torque wrench without replaceable blade.

3



**Torque wrench TorqueVario®**  
adjustable with scale

TorqueVario®				
Size	Torque	Order No.	Adjusting key	Replaceable blades
5IP – 7IP	0,38 - 1,01 Nm	L05 00781	L05 00990	L05 00700
				L05 00710
				L05 00720
				L05 00740
9IP – 20IP	2,25 - 6,25 Nm	L05 00791	L05 00990	L05 00750
				L05 00760
				L05 00770
				L05 00770

### Changing the torque

- Remove blade
- Insert adjusting key in variable torque key handle and turn to set the required torque. The appropriate IP size can be read from the graduated scale.
- Push blade in again



Supply includes: Torque wrench with adjusting key and replaceable blades.

4



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7



TORX PLUS®			
Size	Order No.	Size	Order No.
5IP	L05 00800	9IP	L05 00840
6IP	L05 00810	10IP	L05 00850
7IP	L05 00820	15IP	L05 00860
8IP	L05 00830	20IP	L05 00870

The old Torx keys do fit the new TORX PLUS® shape but we recommend only TORX PLUS® keys be used for tightening screws.

Allen key	
Width across flats WAF	Order No.
1,5	18591 10015
2,5	18591 10025
3	18591 10030
4	18591 10040
5	18591 10050
6	18591 10060
10	18591 10100

Key	
Size	Order No.
16	18701 80016
22	18701 80022
27	18701 80027
32	18701 80032
40	18701 80040
50	18701 80050

on request

## A PLUS for our customers and the environment

### The company targets

The KOMET GROUP pursues a consistent policy of investments and achieves long-term and profitable growth via continuous improvement of products and processes as well as via consistent qualification of employees. This increases the value of the company. The KOMET GROUP consistently increases its innovation quota via research and development, offering the market new products every year. The KOMET GROUP is a premium quality manufacturer and motivates employee qualification and customers in their IDEAS FACTORY. The training quota of vocational beginners is exemplary for the entire field of business.

### The products and services

KOMET GROUP products and services offer the customer incomparable added value. The KOMET GROUP develops, manufactures and sells the comprehensive, modular portfolio on bore machining as full-range suppliers. The KOMET GROUP offers the innovative technologies, thereby taking the high economic viability, best quality and most attractive designs into account. The KOMET GROUP sees itself not purely as a tool manufacturer, but rather as suppliers of innovative solutions and ideas for the benefit of the customer: **TOOLS+IDEAS®**.

### The customer

The KOMET GROUP places value on long-term, binding customer relations, seeing itself as a partner of the customer in a balance of benefit supplies and benefit harvests.

The KOMET GROUP records customers' demands and then produces the most effective ideas and tool solutions for their machining tasks. The KOMET GROUP offers the customer information and collaboration via their worldwide presence in local Service Centres. The IDEAS FACTORY supports vocation-related training and further qualifications for customers.

### The environment / surroundings

The KOMET GROUP feels itself obliged to avoid any wastage, and therefore commits itself to responsible usage of raw materials and careful utilisation of remaining materials.

The KOMET GROUP management is well aware of its responsibilities towards society, and creates the foundations for modern working environments and working conditions. The specifications on ergonomics and work safety are taken into account. Beholden to the founder, Robert Breuning, the KOMET GROUP supports the site at Besigheim, maintaining direct contact to schools and social facilities in the region.

With these claims in mind, the KOMET GROUP has introduced a modern, integrated management system, known as KMS (KOMET Management System), which is certified in accordance with ISO 9001:2008, ISO 14001:2009 and the German „Akkreditierungs-und Zulassungsverordnung Arbeitsförderung – AZAV“.

### Certification

<http://www.kometgroup.com/navigation-top/download/service/zertifikate.html>

### Energy efficiency and resource conservation

The KOMET GROUP is now also focussing on the issue of „energy efficiency“. The reason is that metal machining companies need intelligent products, processes and systems in this regard as well, in order to successfully meet the challenges that the future holds.

Bluecompetence is the sustainability initiative launched by the VDMA (German Engineering Association) with which the KOMET GROUP has also associated itself. By combining the resources, expertise and strengths of all members of the VDMA, the intention is to consolidate and enhance the joint global position as the technology leader in sustainable production and products.



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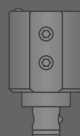
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# KOMET® APP

Products  
Product menu with a short, descriptive text to the portfolio



Cutting data  
Cutting data: speed, feed, processing time, power and torque can be calculated.



Calculator screen  
Here you can enter the diameter and the cutting speed, is automatically calculated.





Material classification  
International translation table for material classification.



Technical dictionary  
German/English with full-text search. Many common words from the machining and tool world.



Videos  
Links to the KOMET GROUP product videos on YouTube®



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KomPass – Turning

Customer No. – please specify	Order No.	Order date	Supplier No.
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Delivery address (if different)

Company \_\_\_\_\_

Contact person (surname) \_\_\_\_\_ Name \_\_\_\_\_

Branch \_\_\_\_\_ Department/site \_\_\_\_\_

Street \_\_\_\_\_

Town/city, postcode \_\_\_\_\_

Tel. \_\_\_\_\_ Fax \_\_\_\_\_

Date \_\_\_\_\_ Signature \_\_\_\_\_

Company \_\_\_\_\_

Contact person (surname) \_\_\_\_\_ Name \_\_\_\_\_

Branch \_\_\_\_\_ Department/site \_\_\_\_\_

Street \_\_\_\_\_

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Order quantity	Order No.	Tool name / Item Article	Customer material number	Additional information





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