

FLAT FORM TOOLS

Solid carbide tools and tooling solutions





FLAT FORM TOOLS

As a pioneer of flat form tools, Leistriz offers solid carbide contour grooving inserts for a wide range of demanding applications. These are clearly superior to the classic indexable inserts for contour turning and contour grooving in productivity, quality and economy, as can be shown by a simple example.

The idea of manufacturing so-called flat form tools (= product name for the Leistriz profile grooving program) customer-specifically is as simple as it is ingenious. A wide-ranging stock program of plate blanks and various holder versions ensures that contour grooving tools can be delivered within a very short time as required.

Special-purpose holders and specific solutions for all machines (even special inserts if required) are a matter of course for us.

FLAT FORM TOOLS FOR:

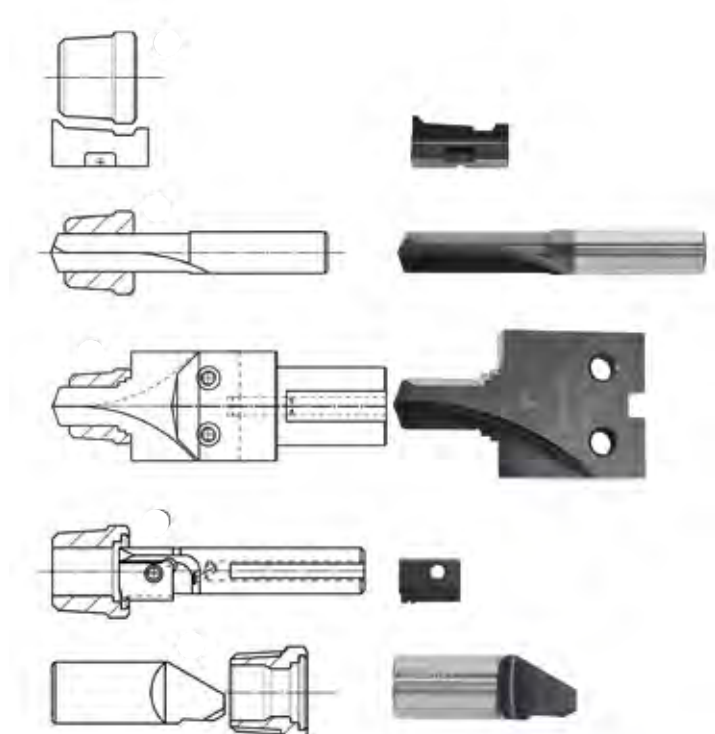
- Multi-spindle lathes
- Single-spindle lathes
- Sliding headstock lathes
- Fixed headstock lathes

FOR ALL COMMON:

- Automatic rotary indexing machines
- CNC lathes*

* Profile grooving replaces copy-turning and reduces machine running times

»Complete workpiece processing
from a single source!«

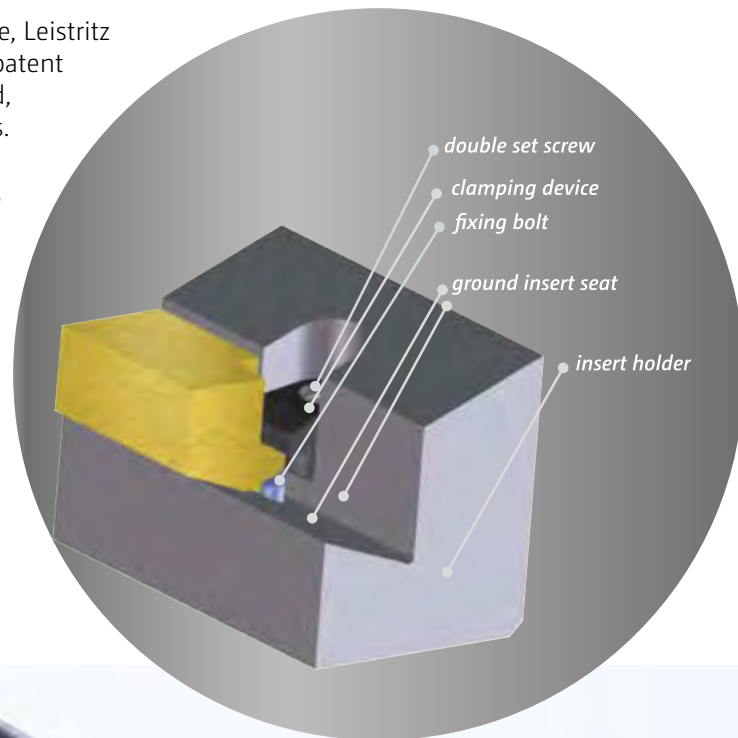


Profiled flat form insert for outer contour, Solid carbide drill for pre-drilling
Plate drills large, for complex inner contour, Inner contour with profiled
indexable insert, Solid carbide graver for inside turning

THE BOLT MAKES THE DIFFERENCE

With the invention and patenting of the changeable profile plate, Leistritz set a landmark in the history of profile turning tools. Since the patent application, the range of tools has been continuously developed, expanded and supplemented according to market requirements.

The Leistritz flat form tool with its characteristic and stable plate shape distinguishes itself by its ground insert seat in combination with a fixing bolt. This allows the cutting plate holder to remain clamped in the machine during plate change. Thereby the accuracy of the plate change is higher than for presetting. In order to enable the plate change in difficult or confined space conditions in the machine, the clamping claw can be loosened from the top and bottom in the holder by the double set screw.



BENEFITS

- By using the most modern grinding centers, the inserts are profile-ground and the contour is aligned with the center of the bolt.
- The fixing bolt in the holder in conjunction with the fixing groove precisely ground at the insert guarantees the high repeatability of the plate change.
- The holder can remain in the machine for plate change.
- A simple clamping system allows **quick, clean, and exact** plate changes.
- A compact insert seat guarantees high process reliability.
- No losable parts.
- Wear-free, by introducing the high cutting pressures across the entire holder width.
- A wide stock range of changeable plates of different heights guarantees the most economical solution between cheap disposable blanks and blanks that can be re-sharpened.





PROFILE CENTER

Due to the possibility of a suitable machine selection, we are able to economically manufacture and offer even small and smallest batch sizes.

For the dimensioning of the cutting edge geometries, we rely on the extensive experience of our application technicians and engineers, as well as on a sound basic knowledge from decades of practical experience in the metal cutting sector.

Our data storage enables us even after years to grind reproducible inserts, which can be clamped by the customer directly on the machine without a holder correction.

Quality, precision and optimum grinding of the inserts are our highest priority when profiling.

Complex contours of rotary parts require powerful profile-grooving tools for the economical production of these rotary parts. In the Leistriz Profile Center we will gladly take care of:

- Profile design
- Cut distribution

YOUR WORKPIECE



OUR SUITABLE TOOL



Or we grind/profile according to your specifications. For this purpose, the most modern profile grinding centers are available from our extensive machine park in order to profile with a high-precision cutting edge geometry:

- Contour grooving inserts
- Contour drills solid carbide or changeable system
- Contour milling cutters etc.



Project planning, programming and production takes place via the most modern CAD-CAM systems.



Along the production process, we make use of precise measuring machines with state-of-the-art optical measuring technology.

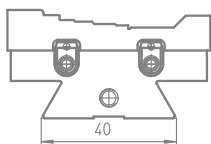
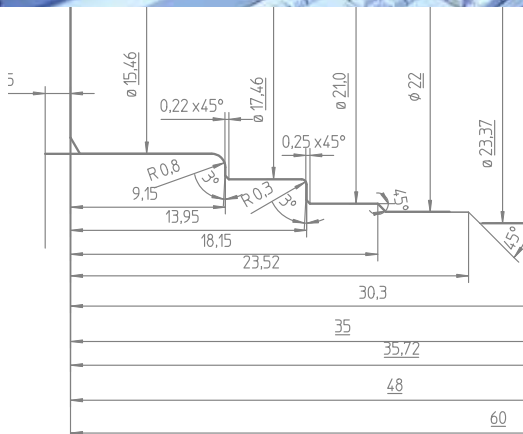


Additionally, a permanent visual inspection is carried out on optimum grinding, surface quality and the detection of possible micro break-outs.

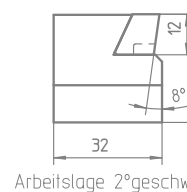
PROFILE MEASUREMENT



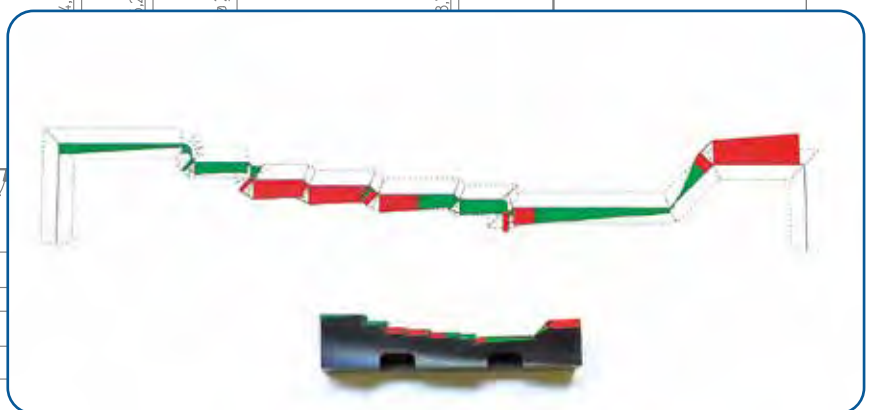
When measuring the profile, the visual display is carried out using a tolerance band of ± 0.005 mm above the ground contour. Tolerance deviation within the band is shown in green, exceedance in red. Thus, position and deviation of more than 5μ are immediately recognizable. These measurement protocols can also be used for documentation if required.



rohrling			
nummer			
imnummer			
winkel	Grad	L	R
winkel	6°		
anfreiwinkel	2°		
anfreiwinkel	0		
techseite			
ranz	+/-0.01		



Arbeitslage 2°geschw



Intermediate checking: still tolerance deviations



Ready-to-use "getting the green light"

FLAT FORM **INSERTS AND PLATES**

Blanks for profiling, for contour grooves

Program	Version		Rake face		With fixing groove		Image	Form	Width /IC in mm	Insert heights in mm	Page
	screwed	clamped	raw sintered	0° ground	yes	no					
W 30xx-0xxx 0xxx N*		X	X		X			A	6-10	3	8
W 30xx-0xxx 0xxx N*		X	X		X			B	10-32	3, 7, 8	8
W 30xx-0xxx 0xxx N*		X	X		X			C	>32-60	3, 7, 8	8
FW 30xx-0xxx 0xxx N*		X		X	X			A	6-10	3	9
FW 30xx-0xxx 0xxx N*		X		X	X			B	10-32	3, 7, 8	9
FW 30xx-0xxx 0xxx N*		X		X	X			C	>32-60	3, 7, 8	9
W 31xx-0200 0000 N for larger profile depths as disposable insert	X		X		X				10, 12, 14	2	19
W 33xx-0200 0000 N for fixed headstock automatic lathes and sliding headstock automatic lathes	X		X		X				8, 10, 12, 14	3	19
SK 5338 for boring bar SK5293 for workpiece inside - Ø ≥ 14 mm	X		X			X			14-25	3	18
SK 5401 3 cutting edges /	X					X			9.53, 10.8, 16, 27	4.76, 6, 8	20

* for low re-grinding frequency 3mm, for larger re-grinding frequency 7, 8mm

FLAT FORM **SHANK HOLDERS**

Blanks for profiling, for contour grooves

Program	Version				Fixing bolt		Image	Form	Width/IC in mm	Insert heights in mm	Page
	screwed	clamped			yes	no					
H30xx-xxxx 0xxx N for insert height 3 mm		X			X			A	6-10	3	10
H30xx-xxxx 0xxx N for insert heights 3, 7 and 8 mm		X			X			B	10-32	3, 7, 8	10 11
H30xx-xxxx 0xxx N for insert heights 3, 7 and 8 mm		X			X			C	>32-60	3, 7, 8	10 11
H30xx-0300 xxxx N for insert height 3 mm without inconvenient projection		X			X			B	12-25	3	12
H 30xx-0xxx xxxx R/L offset version					X			B	14, 20	3	12
H311x-xxx 0002 N "Extra flat" for larger profile depths	X				X				10, 12, 14	2	19
H33xx-xxx 0002 N "Super flat" holder heights 8 mm for fixed headstock automatic lathes and sliding headstock automatic lathes	X				X				8, 10, 12, 14	3	19
SK 5400-xxxx R/L "Economy" upright standing insert with 3 cutting edges	X								9.53, 10.8, 16, 27	4.76, 6, 8	20
SK 5775	X								14		18
SK 5293 R boring bar with internal coolant supply	X								14	3	18

FLAT FORM **HOLDERS FOR AUTOMATIC MACHINES**

Blanks for profiling, for contour grooves

Program	Version			Fixing bolt with highest repeat- ing accuracy		Image	Form	Width in mm	Insert heights in mm	Page
	N = neutral	R = right	L = left	yes	no					

Gildemeister and Schütte automatic lathes

H30XX-0xxx Axx Nxx	X			X			B	14-32	3, 7, 8	13
H30XX-0xxx Axx Nxx	X			X			C	>32-60	7, 8	14
H30XX-0xxx Axx R/Lxx		X	X	X			B	14-32	7, 8	15
H30XX-0xxx Axx R/Lxx		X	X	X			C	>32-60	7, 60	15

Tornos automatic lathes

H30XX-0xxx Axx Nxx	X			X			B	14-32	8	16
H30XX-0xxx Axx R/Lxx		X	X	X			B	14-32	8	16

Index and Traub automatic lathes

H30XX-0xxx 01xx N Sizes B25 and B42	X			X			B	14-32	3, 7, 8	17
H30XX-0xxx 01xx N Sizes B25 and B42	X			X			C	>32-60	3, 7, 8	17

FLAT FORM **BORING BARS**

Blanks for profiling, for contour grooves, bearing tools

Program	Version		Safety insert seat with lower handle		Form	Shank ø in mm	Image	Width in mm	Insert heights in mm	Page
	screwed	clamped	yes	no						

H30xx-xxxx xxxx R for internal machining		X		X	B	18/25		16/25	3	21
H30xx-03xx xxxx for facing operation		X		X	B	16		14	3	21
H30xx-03xx xxxx for roundness machining		X		X	B	19		14	3	21

Contour drilling with changeable plates

SK 5820-xx-XX/Plate	X		X					10, 12, 14, 16	S=3	22
SK 5816-xx-XX/Holder	X		X			10,12,14,16				22
SK 5397-xx-XX/Plate Lengths 30-100	X			X				35-60	S=8	22
SK 5816-xx-XX/Holder with Plate SK 5397	X			X		25				22

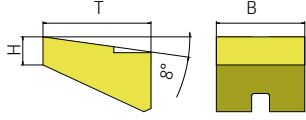
Other

Application examples contour drilling with SK 5820 and SK 5397										23
Tube-chamfering inserts										24
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Questionnaire, inquiry: profiled inserts										26/27
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"Re-grinding and eroding device" for automatic profiling										29
Cutting value table										30/31

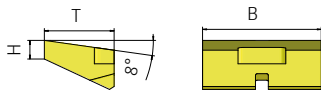
PROGRAM W 30.. - **RAKE FACES RAW-SINTERED**

Clamped version

Version A
(width: B 6 - 10 mm)



Version B
(width: B 10 - 32 mm)



Version C
(width: B > 32 - 60 mm)

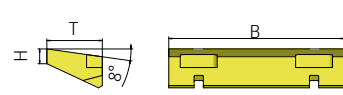
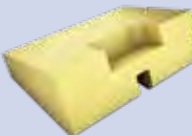
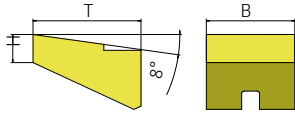


Image	Order number	Dimensions mm			Version	K10F	Item No.:	P20- 30	Item No.:
		B	H	T					
	W 3006-0300 0000 N	6	3	12	A	●	07304264		
	W 3008-0300 0000 N	8	3	12	A	●	00060922		07307664
	W 3010-0300 0000 N	10	3	12	A	●	00060923		07307271
	W 3010-0715 0000 N	10	7	15	B	●	07202091		
	W 3010-0800 0000 N	10	8	12	B	●	07202907		
	W 3012-0300 0000 N	12	3	12	B	●	00066767	●	00066859
	W 3012-0715 0000 N	12	7	15	B	●	07202519		
	W 3012-0800 0000 N	12	8	12	B	●	07202482		
	W 3014-0300 0000 N	14	3	12	B	●	00066768	●	00066860
	W 3014-0715 0000 N	14	7	15	B	●	07202092		
	W 3014-0800 0000 N	14	8	12	B	●	00066769	●	00066771
	W 3016-0300 0000 N	16	3	12	B	●	00060709		
	W 3016-0715 0000 N	16	7	15	B	●	07202093		
	W 3016-0800 0000 N	16	8	12	B	●	00060570	●	07305500
	W 3018-0300 0000 N	18	3	12	B	●	07202434		
	W 3018-0800 0000 N	18	8	12	B	●	07310372		
	W 3020-0300 0000 N	20	3	12	B	●	00060527	●	00060525
	W 3020-0327 0000 N	20	3	27	B	●	07209012		
	W 3020-0715 0000 N	20	7	15	B	●	07202094		
	W 3020-0800 0000 N	20	8	12	B	●	00060532	●	00060530
	W 3022-0800 0000 N	22	8	12	B	●	07202446		
	W 3025-0300 0000 N	25	3	12	B	●	00066773		00066864
	W 3025-0715 0000 N	25	7	15	B	●	07202095		
	W 3025-0800 0000 N	25	8	12	B	●	00066774	●	00066776
	W 3028-0300 0000 N	28	3	12	B	●	07202436		
	W 3028-0715 0000 N	28	7	15	B	●	07205529		
	W 3028-0800 0000 N	28	8	12	B	●	07202347		
	W 3030-0300 0000 N	30	3	12	B		07208016		
	W 3032-0300 0000 N	32	3	12	B	●	07304955		07312109
	W 3032-0715 0000 N	32	7	15	B	●	07202115		
	W 3032-0800 0000 N	32	8	12	B	●	00060692		00060638
	W 3038-0300 0000 N	38	3	12	C	●	07311082		
	W 3038-0715 0000 N	38	7	15	C	●	07202096		
	W 3038-0800 0000 N	38	8	12	C	●	07311896		
	W 3045-0300 0000 N	45	3	12	C	●	00060534		
	W 3045-0715 0000 N	45	7	15	C	●	07202097		
	W 3045-0800 0000 N	45	8	12	C	●	00066988		07302963
	W 3052-0715 0000 N	52	7	15	C	●	07202803		
	W 3060-0215 0000 N	60	2	15	C	●	07203790		
	W 3060-0715 0000 N	60	7	15	C	●	07202098		

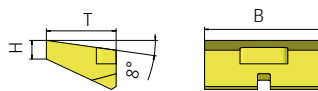
PROGRAM FW 30.. - **RAKE FACES 0° GROUND**

Clamped version

Version A
(width: B 6 - 10 mm)



Version B
(width: B 10 - 32 mm)



Version C
(width: B > 32 - 60 mm)

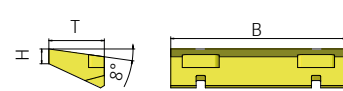
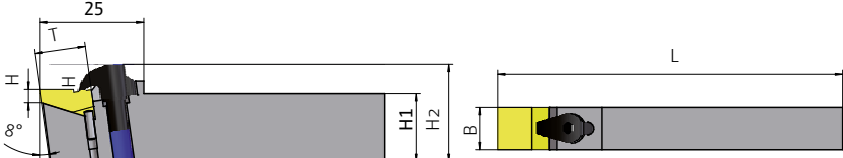
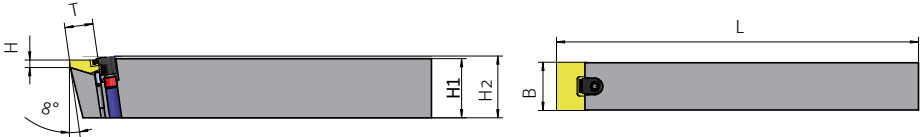
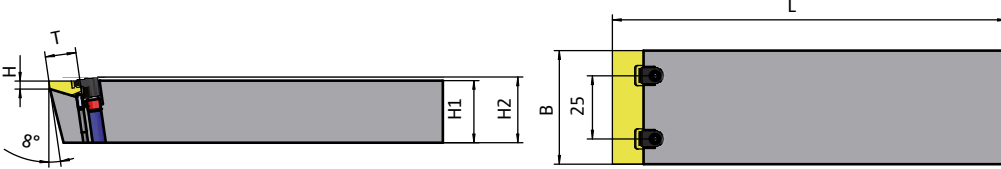


Image	Order number	Dimensions mm			Version	K10F	Item No.:
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	FW 3008-0300 0000 N	8	3	12	A	●	07201334
	FW 3010-0300 0000 N	10	3	12	A		
	FW 3010-0715 0000 N	10	7	15	B		
	FW 3010-0800 0000 N	10	8	12	B		
	FW 3012-0300 0000 N	12	3	12	B	●	07208917
	FW 3012-0715 0000 N	12	7	15	B		
	FW 3012-0800 0000 N	12	8	12	B		
	FW 3014-0300 0000 N	14	3	12	B	●	07208918
	FW 3014-0715 0000 N	14	7	15	B		
	FW 3014-0800 0000 N	14	8	12	B	●	07203659
	FW 3016-0300 0000 N	16	3	12	B	●	07208919
	FW 3016-0715 0000 N	16	7	15	B	●	07201447
	FW 3016-0800 0000 N	16	8	12	B	●	07208932
	FW 3018-0300 0000 N	18	3	12	B	●	07208925
	FW 3018-0800 0000 N	18	8	12	B	●	07201337
	FW 3020-0300 0000 N	20	3	12	B	●	07208920
	FW 3020-0327 0000 N	20	3	27	B		
	FW 3020-0715 0000 N	20	7	15	B	●	07208931
	FW 3020-0800 0000 N	20	8	12	B	●	07208928
	FW 3022-0800 0000 N	22	8	12	B		
	FW 3025-0300 0000 N	25	3	12	B	●	07208921
	FW 3025-0715 0000 N	25	7	15	B	●	07205125
	FW 3025-0800 0000 N	25	8	12	B	●	07201431
	FW 3028-0300 0000 N	28	3	12	B	●	07208926
	FW 3028-0715 0000 N	28	7	15	B		
	FW 3028-0800 0000 N	28	8	12	B	●	07203660
	FW 3030-0300 0000 N	30	3	12	B		
	FW 3032-0300 0000 N	32	3	12	B	●	07208922
	FW 3032-0715 0000 N	32	7	15	B	●	07203221
	FW 3032-0800 0000 N	32	8	12	B	●	07208927
	FW 3038-0300 0000 N	38	3	12	C	●	07208923
	FW 3038-0715 0000 N	38	7	15	C	●	07203231
	FW 3038-0800 0000 N	38	8	12	C		
	FW 3045-0300 0000 N	45	3	12	C	●	07208924
	FW 3045-0715 0000 N	45	7	15	C	●	07203228
	FW 3045-0800 0000 N	45	8	12	C		
	FW 3052-0715 0000 N	52	7	15	C		
	FW 3060-0215 0000 N	60	2	15	C		
	FW 3060-0715 0000 N	60	7	15	C		

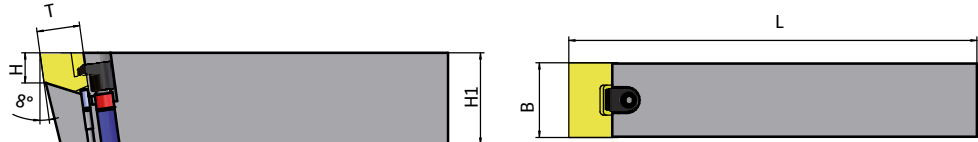
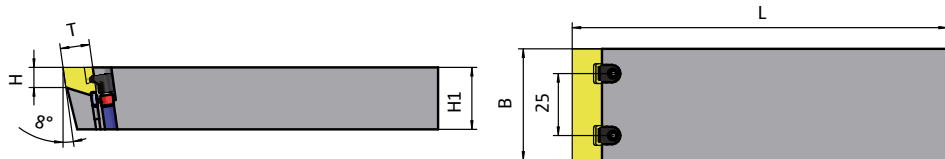
SHANK HOLDERS FOR FLAT FORM INSERTS

Clamped version

Version A with 1 set of clamping fingers width 6 - 10 mm	Order number	Dimensions in mm						Version	In stock	Item No.:	Spare parts			
		B	H	T	H1	H2	L				S	D	Z	G
														
	H 3006-1606 0003 N	6	3	12	16	21	125	A	●	07101259	1	-	6	1.5
	H 3008-1608 0003 N	8	3	12	16	23	125	A	●	07101260	2	-	6	2.5
	H 3010-1610 0003 N	10	3	12	16	23	125	A	●	07101261	2	-	6	2.5
Version B 1 clamping device width 12 - 32 mm														
	H 3012-1212 0003 N	12	3	12	12	14	150	B	●	00066823	3	6	6	2.5
	H 3012-1612 0003 N	12	3	12	16	16	150	B	●	07100197	3	1	8	2.5
	H 3012-2012 0003 N	12	3	12	20	22	150	B	●	07102823	3	1	12	2.5
	H 3012-2512 0003 N	12	3	12	25	27	150	B	●	07102741	3	1	12	2.5
	H 3014-1214 0003 N	14	3	12	12	14	150	B	●	07109700	3	6	6	2.5
	H 3014-1614 0003 N	14	3	12	16	16	150	B	●	00066766	3	1	8	2.5
	H 3014-2014 0003 N	14	3	12	20	22	150	B	●	00060547	3	1	12	2.5
	H 3014-2514 0003 N	14	3	12	25	27	150	B	●	07100167	3	1	12	2.5
	H 3016-1616 0003 N	16	3	12	16	16	150	B	●	07100389	3	1	8	2.5
	H 3016-2016 0003 N	16	3	12	20	22	150	B	●	07102742	3	1	12	2.5
	H 3016-2516 0003 N	16	3	12	25	27	150	B	●	07100168	3	1	12	2.5
	H 3020-1620 0003 N	20	3	12	16	16	150	B	●	07104362	3	1	8	2.5
	H 3020-2020 0003 N	20	3	12	20	22	150	B	●	07100390	3	1	12	2.5
	H 3020-2520 0003 N	20	3	12	25	27	150	B	●	00060520	3	1	12	2.5
	H 3025-1625 0003 N	25	3	12	16	16	150	B	●	07104363	3	1	8	2.5
	H 3025-2025 0003 N	25	3	12	20	22	150	B	●	07106190	3	1	12	2.5
	H 3025-2525 0003 N	25	3	12	25	27	150	B	●	00066824	3	1	12	2.5
	H 3028-2028 0003 N	28	3	12	20	22	150	B	●	07100005	3	1	12	2.5
	H 3032-2032 0003 N	32	3	12	20	22	150	B	●	07103813	3	1	12	2.5
	Version C 2 clamping devices width > 32 - 60 mm													
	H 3038-2038 0003 N	38	3	12	20	22	150	C	●	07100009	3	1	12	2.5
	H 3045-2045 0003 N	45	3	12	20	22	150	C	●	07106149	3	1	12	2.5
	H 3045-2545 0003 N	45	3	12	25	27	150	C	●	07100169	3	1	12	2.5

SHANK HOLDERS FOR FLAT FORM INSERTS

Clamped version

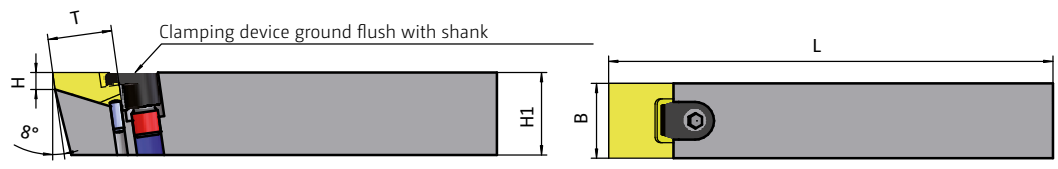
Version B with 1 clamping device width 12 - 32 mm	Order number	Dimensions in mm					Version	In stock	Item No.:	Spare parts			
		B	H	T	H1	L				S	D	Z	G
													
	H 3020-2520 0327 N	20	3	27	25	150	B	●	07100345	3	1	8	2.5
	H 3014-2014 0715 N	14	7	15	20	150	B	●	07104703	3	1	8	2.5
	H 3014-2514 0715 N	14	7	15	25	150	B	●	07104101	3	1	8	2.5
	H 3016-2016 0715 N	16	7	15	20	150	B	●	07103802	3	1	8	2.5
	H 3020-2020 0715 N	20	7	15	20	150	B	●	07103803	3	1	8	2.5
	H 3025-2025 0715 N	25	7	15	20	150	B	●	07103804	3	1	8	2.5
	H 3025-2525 0715 N	25	7	15	25	150	B	●	10012190	3	1	8	2.5
	H 3032-2032 0715 N	32	7	15	20	150	B		07105817	3	1	8	2.5
	H 3032-2532 0715 N	32	7	15	25	150	B	●	07104126	3	1	8	2.5
	H 3032-3232 0715 N	32	7	15	32	150	B	●	07102309	3	1	8	2.5
	H 3012-2012 0008 N	12	8	12	20	150	B		10000397	3	6	8	2.5
	H 3014-2014 0008 N	14	8	12	20	150	B	●	00066825	3	6	8	2.5
	H 3014-2514 0008 N	14	8	12	25	150	B	●	00066764	3	1	12	2.5
	H 3016-2016 0008 N	16	8	12	20	150	B	●	00060746	3	6	8	2.5
	H 3016-2516 0008 N	16	8	12	25	150	B	●	07100166	3	1	12	2.5
	H 3020-2020 0008 N	20	8	12	20	150	B	●	00060544	3	6	8	2.5
	H 3020-2520 0008 N	20	8	12	25	150	B	●	00060521	3	1	12	2.5
	H 3025-2025 0008 N	25	8	12	20	150	B	●	07102743	3	6	8	2.5
	H 3025-2525 0008 N	25	8	12	25	150	B	●	00066826	3	1	12	2.5
	H 3025-3225 0008 N	25	8	12	32	150	B	●	07102744	3	1	12	2.5
	H 3032-2032 0008 N	32	8	12	20	150	B	●	07102745	3	6	8	2.5
	H 3032-2532 0008 N	32	8	12	25	150	B	●	07100812	3	1	12	2.5
	H 3032-3232 0008 N	32	8	12	32	150	B	●	07102746	3	1	12	2.5
Version C 2 clamping devices width > 32 - 60 mm													
	H 3045-2045 0715 N	45	7	15	20	150	C	●	07104271	3	1	8	2.5
	H 3060-2560 0715 N	60	7	15	25	150	C	●	07104190	3	1	8	2.5
	H 3045-2545 0008 N	45	8	12	25	150	C	●	07100196	3	1	12	2.5

SHANK HOLDERS *FOR FLAT FORM INSERTS*

Clamped version

without cant for short clamping holder length only 90 mm	Order number	Dimensions in mm							Ver- sion	In stock	Item No.:	Spare parts			
		B	H	T	H1	H2	T1	L				S	D	Z	G

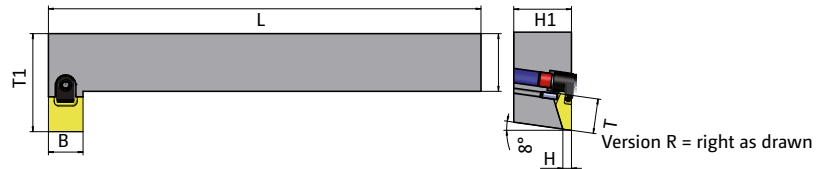




H3012-0300 3103 N	12	3	12	16				90	B	●	07104651	4	1	8	2.5
H3012-0300 3132 N	12	3	12	12				90	B	●	07106515	4	6	6	2.5
H3014-0300 3048 N	14	3	12	16				90	B	●	07105616	4	1	12	2.5
H3016-0300 3022 N	16	3	12	16				90	B	●	07108059	4	1	12	2.5
H3020-0300 3024 N	20	3	12	16				90	B	●	07105293	4	1	12	2.5
H3020-0300 3032 N	20	3	12	20				90	B	●	07105626	4	1	12	2.5
H3025-0300 3035 N	25	3	12	20				90	B	●	07108013	4	1	12	2.5

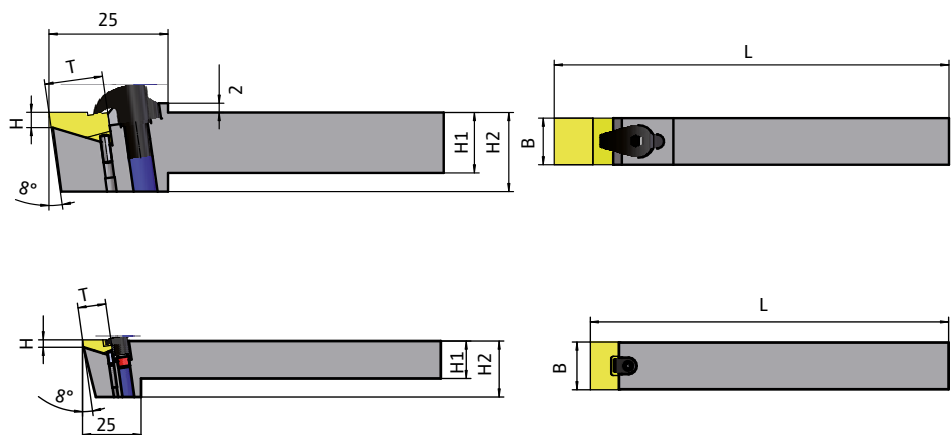
offset version for:
axial grooving / internal
grooving





H 3012-0300 3131 R	12	3	12	20	20	34	150	B	●	07106414	3	1	12	2.5
H 3012-0300 3131 L	12	3	12	20	20	34	150	B	●	07100388	3	1	12	2.5
H3020-0715 4109 R	20	7	15	20	12	30	85	B	●	07102481	3	1	8	2.5

stepped version for low
shank heights H2 or
shortened, reworked
from sizes above

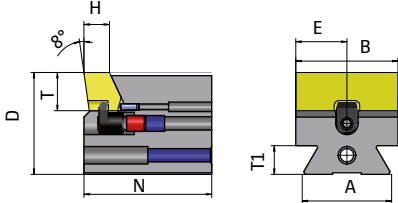


GILDEMEISTER AND SCHÜTTE AUTOMATIC LATHES

Basic holder N (neutral) for flat form inserts

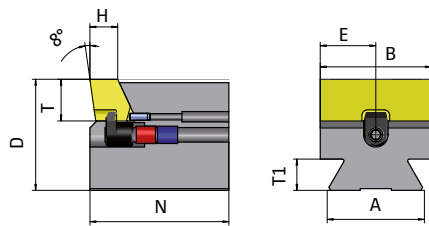
Version B 1 clamping device width 12 to 32 mm	Order number	Dimensions in mm								Ver- sion	In stock	Item No.:	Spare parts				
		A	B	H	T	T ₁	D	E	N				S	D	Z	G	M

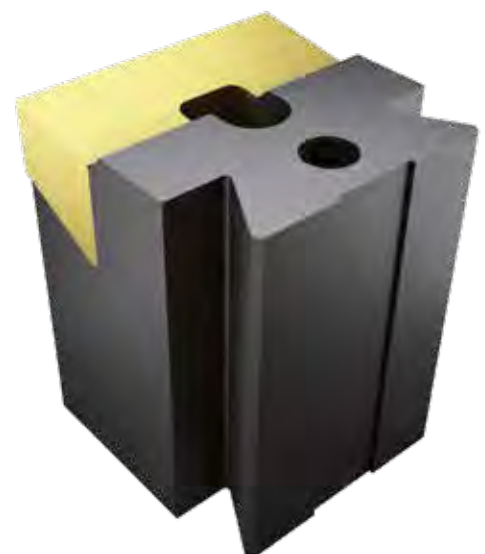


																	
H 3020-0312 A20 N30	A20	20	3	12	7	32	10	30	B			07109750	3	1	6	2.5	30
H 3025-0715 A28 N40	A28	25	7	15	9	32	12.5	40	B	●		07103810	3	1	6	2.5	30
H 3032-0715 A28 N40		32	7	15	9	32	16	40	B	●		07103811	3	1	12	2.5	30
H 3032-0715 A28 N50		32	7	15	9	32	16	50	B	●		07104249	3	1	12	2.5	30
H 3032-0715 A40 N40	A40	32	7	15	11	32	16	40	B			10014595	3	1	12	2.5	30
H 3032-0715 A40 N50		32	7	15	11	32	16	50	B	●		07104895	3	1	12	2.5	30
H 3020-0812 A20 N30	A20	20	8	12	7	32	10	30	B			07108019	3	1	6	2.5	30
H 3025-0812 A20 N50		25	8	12	7	32	12.5	50	B	●		00060703	3	1	12	2.5	30
H 3032-0812 A20 N40		32	8	12	7	32	12.5	40	B	●		07104379	3	1	12	2.5	30
H 3014-0812 A28 N40	A28	14	8	12	9	32	7	40	B	●		07103824	3	1	12	2.5	30
H 3016-0812 A28 N40		16	8	12	9	32	8	40	B	●		07103825	3	1	12	2.5	30
H 3020-0812 A28 N40		20	8	12	9	32	10	40	B	●		07103826	3	1	12	2.5	30
H 3025-0812 A28 N40		25	8	12	9	32	12.5	40	B	●		07103827	3	1	12	2.5	30
H 3025-0812 A28 N50		25	8	12	9	32	12.5	50	B	●		00060705	3	1	12	2.5	30
H 3032-0812 A28 N40		32	8	12	9	32	16	40	B	●		07103828	3	1	12	2.5	30
H 3032-0812 A28 N50		32	8	12	9	32	16	50	B	●		07103491	3	1	12	2.5	30
H 3032-0812 A40 N40	A40	32	8	12	11	40	16	40	B	●		07103832	3	1	12	2.5	30

Version B
 1 clamping device
 without jacking screw

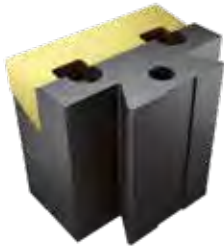
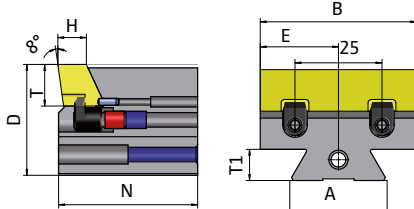
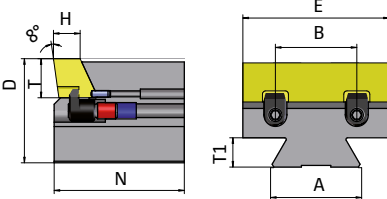


																	
H 3020-0800 3032 N	A20	20	8	12	7	22	10	20	B	●		07106997	3	1	6	2.5	-



GILDEMEISTER AND SCHÜTTE AUTOMATIC LATHES

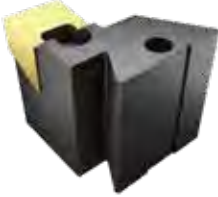
Basic holder N (neutral) for flat form inserts

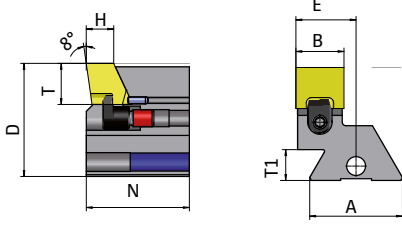
Version C 2 clamping devices width > 32 - 60 mm	Order number	Dimensions in mm								Ver- sion	In stock	Item No.:	Spare parts				
		A	B	H	T	T ₁	D	E	N				S	D	Z	G	M
																	
	H 3045-0715 A28 N40	A28	45	7	15	9	32	22.5	40	C	●	07103812	3	1	12	2.5	30
	H 3060-0715 A28 N50		60	7	15	9	32	22.5	50	C	●	10030048	3	1	12	2.5	30
	H 3045-0715 A40 N50	A40	45	7	15	11	40	22.5	50	C	●	07105168	3	1	12	2.5	30
	H 3045-0812 A20 N40	A20	45	8	12	7	32	22.5	40	C		07100034	3	1	12	2.5	30
	H 3038-0812 A28 N40	A28	38	8	12	9	32	19	40	C	●	07103829	3	1	12	2.5	30
	H 3045-0812 A28 N40		45	8	12	9	32	22.5	40	C	●	07103830	3	1	12	2.5	30
	H 3045-0812 A28 N50		45	8	12	9	32	22.5	50	C	●	07100198	3	1	12	2.5	30
	H 3045-0812 A40 N50	A40	45	8	12	11	40	22.5	50	C	●	07100187	3	1	12	2.5	30
	H 3052-0812 A40 N50		52	8	12	11	40	22.5	50	C		10015354	3	1	12	2.5	30
Version C 2 clamping devices without jacking screw																	
	H 3045-0800 0228 N	A28	45	8	12	9	32	22.5	40	C	●	07100176	3	1	12	2.5	-

GILDEMEISTER AND SCHÜTTE AUTOMATIC LATHES

Basic holder R (right) for flat form inserts

Version B 1 clamping device width 12 to 32 mm	Order number	Dimensions in mm								Ver- sion	In stock	Item No.:	Spare parts				
		A	B	H	T	T ₁	D	E	N				S	D	Z	G	M





H 3020-0715 A28 R40	A28	20	7	15	9	35	18	40	B	●	07105355	3	1	12	2.5	30
H 3014-0812 A20 R30	A20	14	8	12	7	32	12.5	30	B		07104730	3	1	12	2.5	30
H 3014-0812 A20 R40		14	8	12	7	32	12.5	40	B		07104084	3	1	12	2.5	30
H 3014-0812 A20 R50		14	8	12	7	32	12.5	50	B	●	00060702	3	1	12	2.5	30
H 3014-0812 A28 R30		14	8	12	9	32	18	30	B		07103794	3	1	12	2.5	30
H 3014-0812 A28 R40		14	8	12	9	32	18	40	B	●	07104059	3	1	12	2.5	30
H 3016-0812 A28 R40		16	8	12	9	32	18	40	B	●	07104165	3	1	12	2.5	30
H 3020-0812 A28 R40		20	8	12	9	32	18	40	B	●	07104166	3	1	12	2.5	30
H 3025-0812 A28 R40		25	8	12	9	32	18	40	B	●	07103831	3	1	12	2.5	30
H 3032-0812 A28 R40		32	8	12	9	32	18	40	B		10004022	3	1	12	2.5	30
H 3014-0812 A28 R50		14	8	12	9	32	18	50	B		00060704	3	1	12	2.5	30
H 3025-0812 A28 R50		25	8	12	9	32	18	50	B	●	00060706	3	1	12	2.5	30
H 3032-0812 A28 R50		32	8	12	9	32	18	50	B	●	07102827	3	1	12	2.5	30
H 3014-0812 A40 R50		14	8	12	11	35	22.5	50	B		00060707	3	1	12	2.5	30
H 3025-0812 A40 R50		25	8	12	11	35	22.5	50	B		00060708	3	1	12	2.5	30

Basic holder L (left) for flat form inserts

	H 3025-0812 A20 L50	A20	25	8	12	7	32	18	50	B		07100182	3	1	12	2.5	30
	H 3014-0812 A28 L50	A28	14	8	12	9	32	18	50	B		07100183	3	1	12	2.5	30
	H 3025-0812 A28 L50		25	8	12	9	32	18	50	B		07104505	3	1	12	2.5	30
	H 3025-0812 A40 L50	A40	25	8	12	11	40	22.5	50	B		07100186	3	1	12	2.5	30

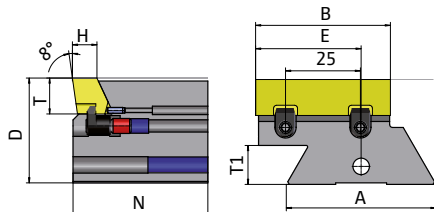
Basic holder R (right) for flat form inserts

Version C

2 clamping devices

width > 32 - 60 mm





H 3038-0812 A28 R40	A28	38	8	12	9	32	18	40	C		07105354	3	1	12	2.5	30
H 3045-0715 A40 R50	A40	45	7	15	11	40	30	50	C		07104996	3	1	12	2.5	30
H 3045-0812 A50 R45	A50	45	8	12	13	40	34.5	45	C		07103833	3	1	12	2.5	30

Basic holder L (left) for flat form inserts

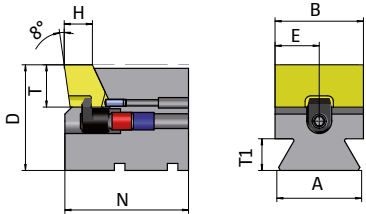
																	
	H 3045-0715 A40 L50	A40	45	7	15	11	40	30	50	C		07104997	3	1	12	2.5	30

TORNOSAUTOMATIC LATHES

Basic holder N (neutral) for flat form inserts

Version B 1 clamping device width 12 - 32 mm	Order number	Dimensions in mm								Ver- sion	In stock	Item No.:	Spare parts			
		A	B	H	T	T ₁	D	E	N				S	D	Z	G



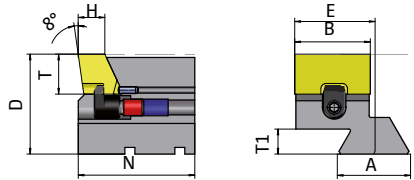


H 3014-0800 0422 N	A22	14	8	12	7.5	30	7	35	B			00060711	3	1	12	2.5
H 3016-0800 0422 N	A22	16	8	12	7.5	30	8	35	B			07102469	3	1	12	2.5
H 3020-0800 0422 N	A22	20	8	12	7.5	30	10	35	B			07100193	3	1	12	2.5
H 3025-0800 0422 N	A22	25	8	12	7.5	30	12.5	35	B		●	00060720	3	1	12	2.5

Basic holder R (right) for flat form inserts

Version B 1 clamping device width 12 - 32 mm	Order number	Dimensions in mm								Ver- sion	In stock	Item No.:	Spare parts			
		A	B	H	T	T ₁	D	E	N				S	D	Z	G





H 3014-0800 0422 R	A22	14	8	12	7.5	30	22	35	B			00060723	3	1	12	2.5
H 3016-0800 0422 R	A22	16	8	12	7.5	30	23	35	B			07100391	3	1	12	2.5
H 3018-0800 0422 R	A22	18	8	12	7.5	30	23	35	B			07106496	3	1	12	2.5
H 3020-0800 0422 R	A22	20	8	12	7.5	30	22	35	B		●	07100194	3	1	12	2.5
H 3025-0800 0422 R	A22	25	8	12	7.5	30	22	35	B			00060721	3	1	12	2.5

Basic holder L (left) for flat form inserts

Version B 1 clamping device width 12 - 32 mm	Order number	Dimensions in mm								Ver- sion	In stock	Item No.:	Spare parts			
		A	B	H	T	T ₁	D	E	N				S	D	Z	G

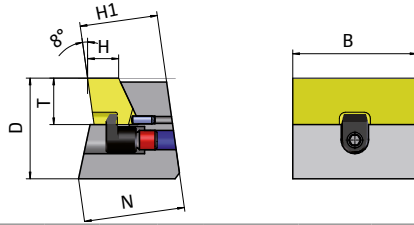
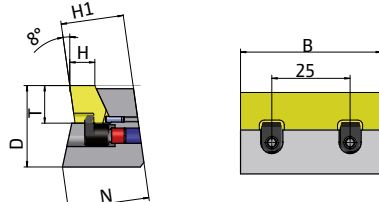


H 3014-0800 0422 L	A22	14	8	12	7.5	30	22	35	B		●	00060724	3	1	12	2.5
H 3016-0800 0422 L	A22	16	8	12	7.5	30	23	35	B			07106811	3	1	12	2.5
H 3018-0800 0422 L	A22	18	8	12	7.5	30	23	35	B			07104539	3	1	12	2.5
H 3020-0800 0422 L	A22	20	8	12	7.5	30	22	35	B			07100195	3	1	12	2.5
H 3025-0800 0422 L	A22	25	8	12	7.5	30	22	35	B			00060722	3	1	12	2.5



INDEX - TRAUB AUTOMATIC LATHES

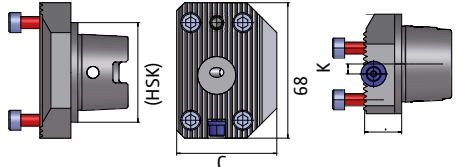
Basic holder N (neutral) for flat form inserts

Version B 1 clamping device width 12 to 32 mm	Order number							Ver- sion	In stock	Item No.:	Spare parts			
		B	H	T	D	H ₁	L				S	D	Z	G
														
	Size B 25													
	H 3016-0300 0125 N	16	3	12	20	20	24	B		07101943	3	1	8	2.5
	H 3032-0300 0125 N	32	3	12	20	20	24	B	●	07101946	3	1	8	2.5
	H 3014-0800 0125 N	14	8	12	20	20	24	B	●	00066760	3	1	8	2.5
	H 3016-0800 0125 N	16	8	12	20	20	24	B		07100170	3	1	8	2.5
	H 3020-0800 0125 N	20	8	12	20	20	24	B	●	00060586	3	1	8	2.5
	H 3025-0800 0125 N	25	8	12	20	20	24	B	●	00066762	3	1	8	2.5
	H 3032-0800 0125 N	32	8	12	20	20	24	B	●	07104001	3	1	8	2.5
	Size B 42													
	H 3016-0300 0142 N	16	3	12	26	20	26	B	●	07104160	3	1	8	2.5
	H 3020-0300 0142 N	20	3	12	26	20	26	B	●	07100397	3	1	12	2.5
	H 3025-0300 0142 N	25	3	12	26	20	26	B	●	07100396	3	1	8	2.5
	H 3032-0300 0142 N	32	3	12	26	20	26	B	●	07105821	3	1	8	2.5
	H 3016-0715 0142 N	16	7	15	29	20	26	B	●	07103805	3	1	8	2.5
	H 3020-0715 0142 N	20	7	15	29	20	26	B	●	07103806	3	1	8	2.5
	H 3025-0715 0142 N	25	7	15	29	20	26	B	●	07103807	3	1	8	2.5
	H 3032-0715 0142 N	32	7	15	29	20	26	B	●	07103808	3	1	8	2.5
	H 3012-0800 0142 N	12	8	12	26	20	26	B	●	07104923	3	1	8	2.5
	H 3014-0800 0142 N	14	8	12	26	20	26	B	●	00066761	3	1	8	2.5
	H 3016-0800 0142 N	16	8	12	26	20	26	B	●	07105398	3	1	8	2.5
	H 3020-0800 0142 N	20	8	12	26	20	26	B	●	07100171	3	1	8	2.5
	H 3025-0800 0142 N	25	8	12	26	20	26	B	●	00066763	3	1	8	2.5
	H 3032-0800 0142 N	32	8	12	26	20	26	B	●	07100529	3	1	8	2.5
Version C 2 clamping devices width > 32 - 60 mm														
	Size B 25													
	H 3038-0800 0125 N	38	8	12	20	20	24	C		07103949	3	1	8	2.5
	H 3045-0800 0125 N	45	8	12	20	20	24	C		00060522	3	1	8	2.5
	Size B 42													
	H 3045-0300 0142 N	45	3	12	26	20	26	C	●	07108966	3	1	8	2.5
	H 3038-0715 0142 N	38	7	15	29	20	26	C	●	07103753	3	1	8	2.5
	H 3045-0715 0142 N	45	7	15	29	20	26	C	●	07103809	3	1	8	2.5
	H 3060-0715 0142 N	60	7	15	29	20	26	C	●	07104607	3	1	8	2.5
	H 3038-0800 0142 N	38	8	12	26	20	26	C	●	07105537	3	1	8	2.5
	H 3045-0800 0142 N	45	8	12	26	20	26	C	●	00060523	3	1	8	2.5

HOLDERS FOR AUTOMATIC MACHINES WITH **HOLLOW SHANK TAPER (HSK)**

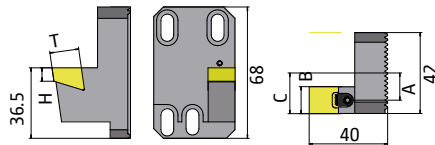
Internal coolant supply, adjustable tip height

Basic holder - Adapter

	Order number		Dimensions in mm			Item no.:
			(HSK) ø	C	K	
						
	EZF VZ 69893-C-40	40	40	0		
EZF VZ 69893-C-50	50	50	5	18.5		

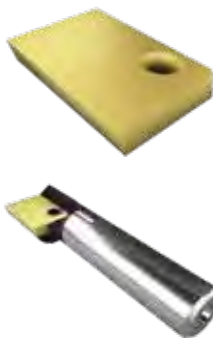
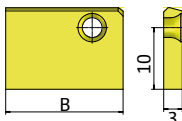
Holder for flat form inserts:



Order number	Dimensions in mm				Version	In stock	Item No.:	Spare parts				
	B	H	T	A				S	D	Z	G	M
												
H 3010-0715-VZ22 R	10	7	15	17.0	B		07107225	3	1	8	2.5	5
H 3014-0715-VZ22 R	14	7	15	15.0	B	●	07107224	3	1	8	2.5	5
H 3020-0715-VZ22 R	20	7	15	12.0	B		07107223	3	1	8	2.5	5
H 3025-0715-VZ22 R	25	7	15	9.5	B	●	07107222	3	1	8	2.5	5
H 3032-0715-VZ22 R	32	7	15	6.0	B		07107221	3	1	8	2.5	5
H 3038-0715-VZ22 R	38	7	15	15.5	C	●	07107220	3	1	8	2.5	5

PROFILE PLATE FROM INNER $\phi 14$ MM

Screwed version

	Order number	Dimensions in mm								K10F	In stock	Item no.:	Spare parts	
		B	B1	B2	H1	H2	L	L1	D				S	G
													Version R = right as drawn	
	SK 5338 - 25 x 13.24 R	25										07208154		
	SK 5338 - 20 x 13.24 R	20												
	SK 5338 - 20 x 13.24 L	20										07204192		
	SK 5338 - 14 x 13.24 R	14										07204000		

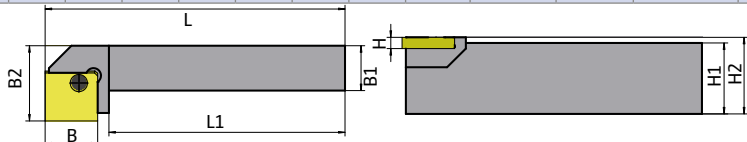
Boring bar

internal coolant supply
safety insert seat - lower handle

														
SK 5293 R	14	16.8				64		ø12		●	07101696	7	T9	

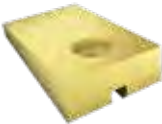
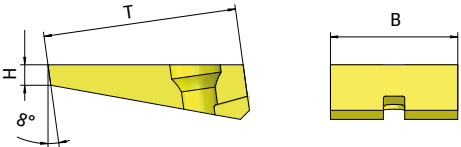
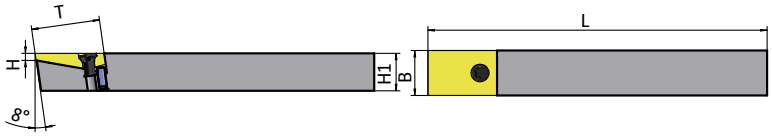
Shank holders

with safety insert seat - lower handle

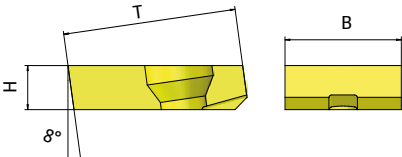
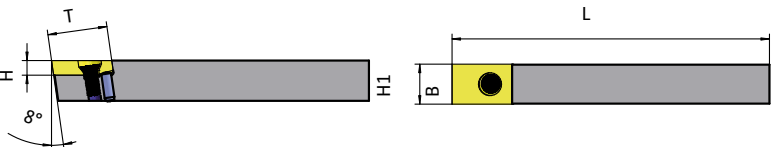
														
SK 5775	14	12	20	20	20.5	100	83				●	07102512	7	T9

SHANK HOLDERS AND FLAT FORM INSERTS PROGRAM 31

Screwed version

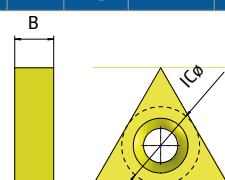
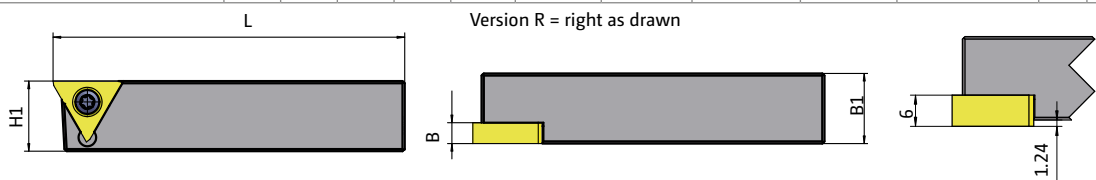
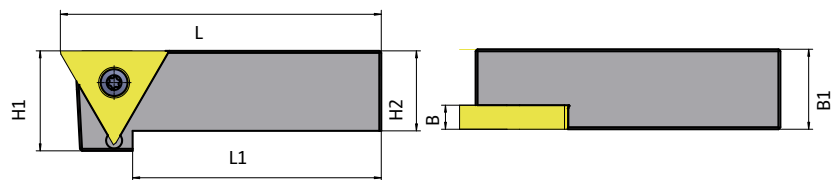
Flat form inserts inserts for larger profile depths	Order number	Dimensions in mm					K10F	In stock	Item No.:	Spare parts		
		B	H	T	H ₁	L				S	Z	G
												
	W 3110-0200 0000 N	10	2	18			●	●	07205010			
	W 3112-0200 0000 N	12	2	18			●	●	07205012			
	W 3114-0200 0000 N	14	2	18			●	●	07205014			
Flat form shank holder												
	H 3110-1010 0002 N	10	2		10	150		●	07115210	7	6	T9
	H 3110-1610 0002 N	10	2		16	150		●	07115211	7	8	T9
	H 3110-2010 0002 N	10	2		20	150		●	07115215	7	8	T9
	H 3112-1012 0002 N	12	2		10	150		●	07115212	7	6	T9
	H 3112-2012 0002 N	12	2		20	150		●	07115216	7	8	T9
	H 3114-1014 0002 N	14	2		10	150		●	07115214	7	6	T9

SHANK HOLDERS AND FLAT FORM INSERTS PROGRAM 33

Flat form inserts holder height 8 mm for fixed and sliding headstock automatic lathes	Order number	Dimensions in mm					K10F	In stock	Item No.:	Spare parts		
		B	H	T	H ₁	L				S	Z	G
												
	W 3308-0300 0000 N	8	3	12			●	●				
	W 3310-0300 0000 N	10	3	12			●	●	10029903			
	W 3312-0300 0000 N	12	3	12			●	●	10029904			
	W 3314-0300 0000 N	14	3	12			●	●	10029905			
Flat form shank holder												
	H 3308-0808 0003 N	8	3		8	125		●	10029907	7	4	T9
	H 3310-0810 0003 N	10	3		8	125		●	10029908	7	4	T9
	H 3312-0812 0003 N	12	3		8	125		●	10029909	7	4	T9
	H 3314-0814 0003 N	14	3		8	125		●		7	4	T9

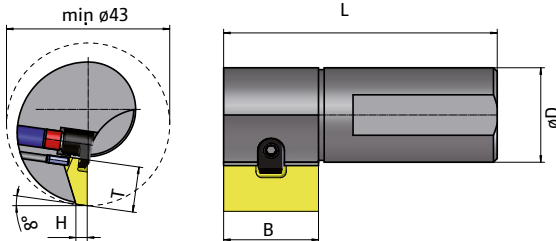
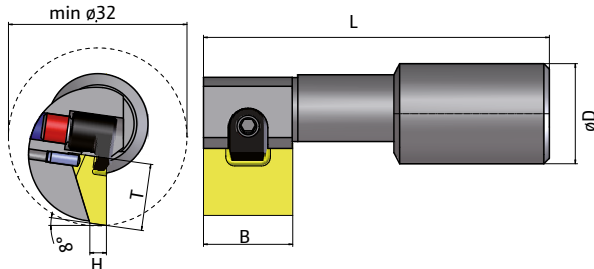
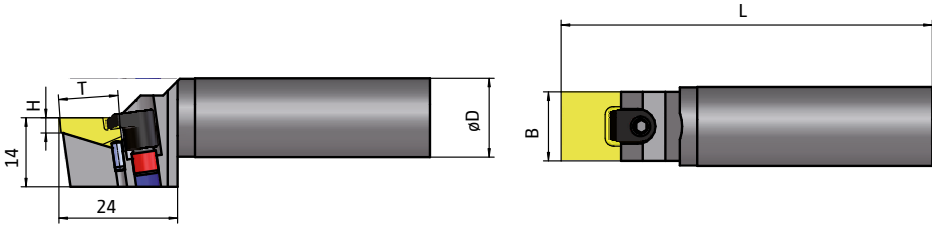
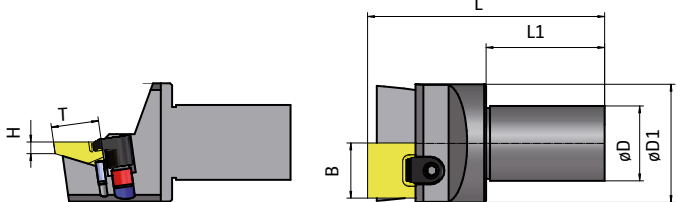
SHANK HOLDER AND INSERT WITH 3 CUTTING EDGES *ECONOMY*

Program 54

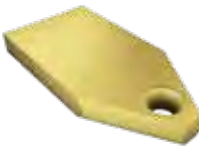
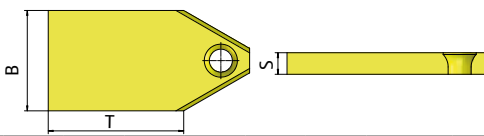
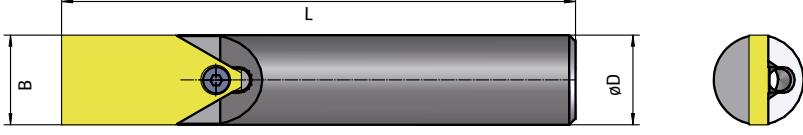
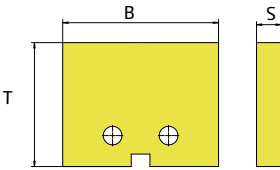
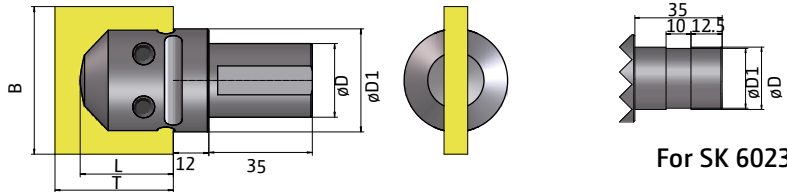
Grooving insert 3 cutting edges	Order number	Dimensions in mm					K10F	In stock	Item No.:	P 20-30	Item No.:	Spare parts	
		B	B1	H1	L	IC						S	G
													
	SK 5401 - 16-4.76 N	4.76				9.52	●		07200024	●	07204275		
	SK 5401 - 16-6.00 N	6				9.52	●		10016391				
	SK 5401 - 16-8.00 N	8				9.52	●		10026297				
	SK 5401 - 27-6.00 N	6				18.88	●		07204530				
Grooving holder R (right version) L (left version)													
	SK 5400-1604-1616 R	4.76	16	16	125				07100260			11	T15
	SK 5400-1604-2016 R	4.76	16	20	125			●	07100024			11	T15
	SK 5400-1604-2520 R	4.76	20	25	125			●	07101902			11	T15
	SK 5400-1604-2520 L	4.76	20	25	125			●	07109659			11	T15
	SK 5400-1608-2016 R	8.00	16	20	125			●	10026286			11	T15
	SK 5400-2706-2520 R	6	20	25	125			●	07107213			20	T20
	SK 5400-2706-2520 L	6	20	25	125			●	07107214			20	T20
stepped version for low shank heights H2 or shortened, reworked from sizes above													
	SK5400-1604-1216 R	4.76	16	16	125			●	07109263			11	T15

BORING BARS FOR CLAMPED FLAT FORM INSERTS

W30xx-03xx xxxx N

Internal machining	Order number	Dimensions in mm						Version	In stock	Item No.:	Spare parts			
		from inner ø	B	H	T	Dh7	L				S	D	Z	G
														
	H3025-0300 3033 R	43	25	3	12	25	72	B	●	07105504	3	6	6	2.5
														
	H 3016-0300 3015 R	32	16	3	12	18	62	B	●	07104168	3	6	6	2.5
for face grooving														
														
	H 3014-0312 4154		14	3	12	16	125	B	●	07109369	3	6	6	2.5
for automatic rotary indexing machines														
														
	H 3014-0312 4012		14	3	12	19	60	B	●	07100777	3	6	6	2.5

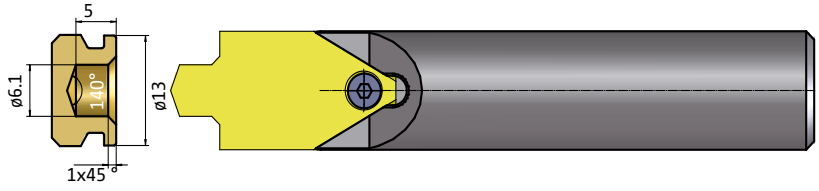
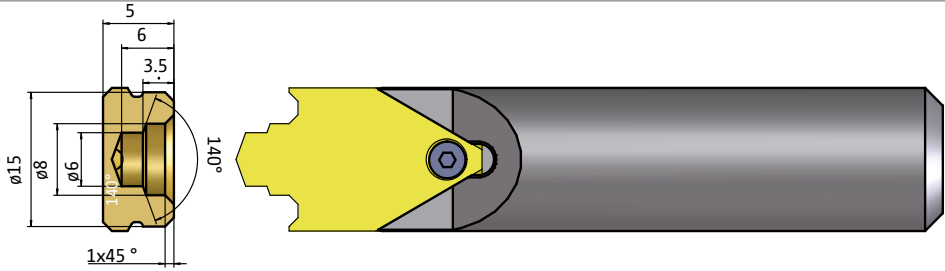
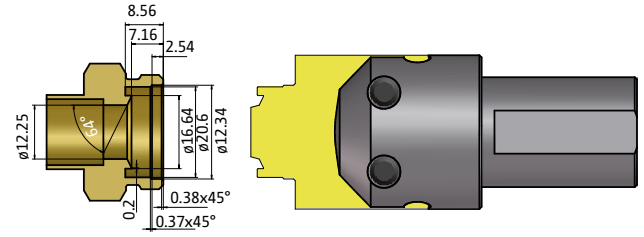
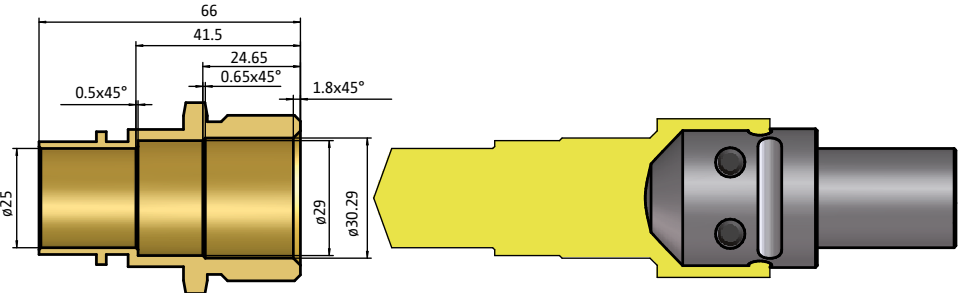
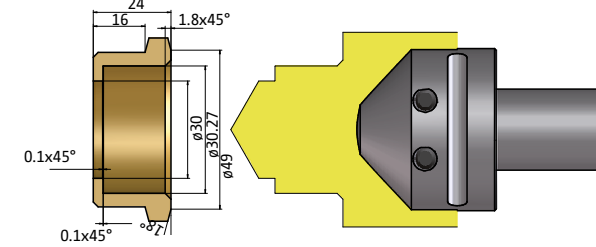
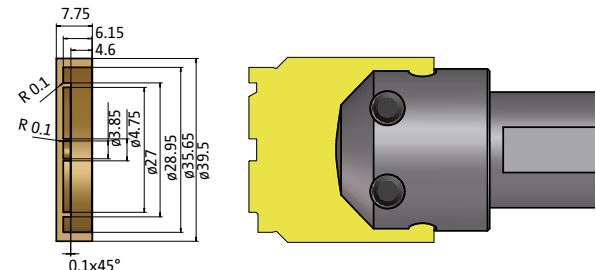
CONTOUR DRILLING WITH CHANGEABLE PLATES

Changeable plate small	Order number	Dimensions in mm						K30F	In stock	Item No.:	Spare parts	
		B	T	S	L	Dh6	D1				S	G
												
	SK 5820-10-16	10	9.2	3				●	●	07282200		
	SK 5820-12-16	12	7.5	3				●	●	07282201		
	SK 5820-14-28	14	17.8	3				●	●	07282202		
	SK 5820-16-28	16	16.0	3				●	●	07282203		
Holder for changeable plates, small, safety insert seat - lower handle												
	SK5816-10	10	9.2		60	10		●	●	07107253	7	T9
	SK5816-12	12	7.5		60	12		●	●	07107254	7	T9
	SK5816-14	14	17.8		80	14		●	●	07107255	7	T9
	SK5816-16	16	16.0		80	16		●	●	07107256	7	T9
Changeable plate large												
	SK 5397-35-30	35	30	8				●	●	07200406		
	SK 5397-35-40	35	40	8				●	●	07204166		
	SK 5397-35-60	35	60	8				●	●	07204161		
	SK 5397-40-60	40	60	8				●	●	07204272		
	SK 5397-40-100	40	100	8				●	●	07204224		
	SK 5397-50-40	50	40	8				●	●	07204147		
	SK 5397-50-100	50	100	8				●	●	07204471		
	SK 5397-60-80	60	80	8				●	●	07204559		
Holder for changeable plates, large												
												



CONTOUR DRILLING WITH CHANGEABLE PLATES

Practical examples of use

SK 5820-14-28 SK 5816-14	
SK 5820-16-28 SK 5816-16	
SK 5397-35-60 SK 5800-22.5 HB	
SK 5397-40-100 SK 5899-31.5 HA	
SK 5397-60-80 SK 5936 HA	
SK 5397-40-60 SK 5800-22.5 HB	

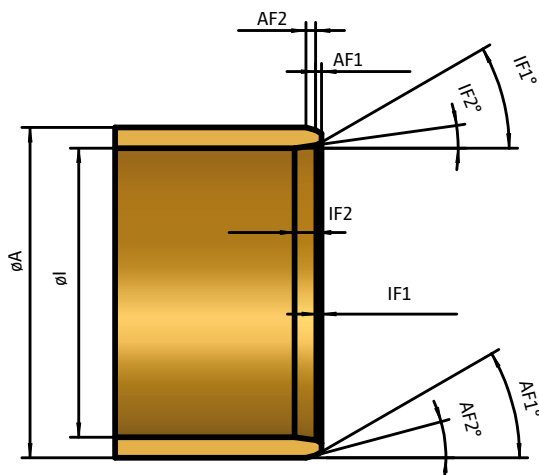


TUBE END FINISHING WITH TUBE-CHAMFERING INSERTS



We profile your tube-chamfering insert for you

➤ from inner tube-Ø 4 mm ➤ wall thickness 0.8 - 2 mm ➤ radii and other shapes possible

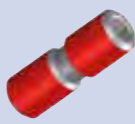
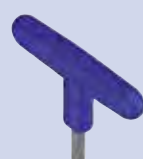


Ø - A in mm	
Ø - I in mm	
AF1 - in °	
AF1 - in mm	
AF2 - in °	
AF2 - in mm	
IF1 - in °	
IF1 - in mm	
IF2 - in °	
IF2 - in mm	

Further versions:

Tube-chamfering head with cylindrical holding fixture:	
Hollow shank taper, steep taper or suitable for your machine's holding fixture	
Holders for end finishing, specifically designed to match your existing tool	

FLAT FORM SPARE PARTS

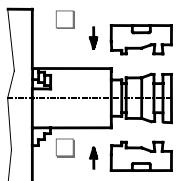
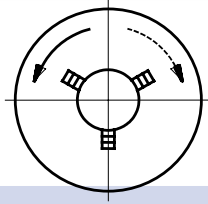
Image	Group		Label	Size	Length L in mm	DIN	In stock	Order number	Item No.:
	Letter	Number							
Clamping claws and clamping screws									
	S	1	Clamping finger set					172.9-825.1	07900426
	S	2	Clamping finger set				●	174.9-830.2	07900385
	S	3	Clamping claw				●	Y 2162	00066504
	S	4	Special clamping claw				●	Y 11467	07104654
	S	7	Torx screw				●	M 3x7	07762157
	S	11	Torx screw				●	M 3.5x11	07764038
	S	20	Torx screw				●	M 5x20	07761230
Double set screw									
	D	6	Double set screw		12.5		●	Y 2106	00061912
	D	1	Double set screw		15		●	Y 2101	00060185
	D	3	Double set screw		19		●	Y 2103	00060186
	D	4	Double set screw		24		●	Y 2104	00060186
Fixing bolts									
	Z	6	Fixing bolt		4 mm		●	2 m 6 x 4	??
	Z	1	Fixing bolt		6 mm		●	2 m 6 x 6	07763091
	Z	3	Fixing bolt		8 mm		●	2 m 6 x 8	07761466
	Z	4	Fixing bolt		12 mm		●	2 m 6 x 12	07761904
Jacking and adjusting screws									
	M	5	Adjusting screw			--	●	M6 x 5	07761195
	M	30	Jacking screw / Set screw			DIN 913	●	M5 x 30	00091465
Wrenches									
	G	1.5	Allen wrench	SW 1.5					
	G	2	Allen wrench	SW 2					
	G	2.5	Key with handle	SW 2.5			●	Y 2119	07104678
	G	3	Key with handle	SW 3			●	Y 9287	07104679
	G	4	Key with handle	SW 4			●	Y 7111	07104680
	G	T9	Torx wrench w. large flag				●	T9	07762160
	G	T15	Torx wrench w. large flag				●	T15	07762161
	G	T20	Torx wrench w. large flag				●	T20	07762985

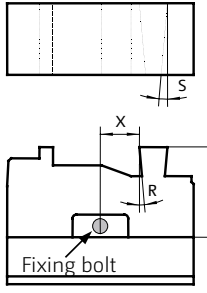
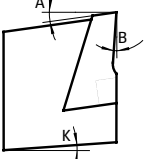
DATA SHEET FOR PROFILED FLAT FORM TOOLS

Customer details		Date:
Company:		Contact person:
Street:		Email:
Zip Code:		Town:
Phone:		Fax:

Tool information:	
Flat form holder: H 30 _____ number of pieces: _____	
☐ Shank holder ☐ INDEX holder ☐ SCHÜTTE holder ☐ TORNOS holder	
Flat form insert: W 30 _____ number of pieces: _____	
☐ height 3 mm ☐ height 7 mm ☐ height 8 mm ☐ height 2 mm	
Tolerance class for tolerated dimensions: ☐ ± 0.01 ☐ ± 0.03 ☐ $\pm$ _____	
Grade of carbide ☐ K 10 F ☐ _____ Coating: ☐ yes ☐ no	
Other:	

Machine manufacturer: _____	Rough machining: ☐
Machine type: _____	Finishing: ☐
Spindle position: ☐ 1 ☐ 2 ☐ 3 ☐ 4 ☐ 5 ☐ 6 ☐ _____	Direction of grooving: ☐ radial
Spindle speed: _____ rpm	☐ axial
Feed: _____ mm per rev.	☐ Internal grooving

Direction of rotation ☐ Right ☐ Left	Position of tool 
	
☐ Tool holder reversed	

	
Fixing bolt	

Drawing number: _____
Please mark the desired machining in the drawing!
Parting-off side: _____
Please mark with "XXX" in the workpiece drawing!
Width for parting off: _____ mm
Material: _____
A = Front relief angle: _____ °
B = Rake angle: _____ °
S = Side clearance angle: _____ °
R = Radial relief angle: _____ °
K = Tilt angle (of tool holder in the machine): _____ °
X = Lateral position to the bolt: _____ mm
Y = Maximum length of insert: _____ mm

Please be sure to enclose your workpiece drawing. Thank you!

See page 27 



Re-grinding service

LEISTRITZ **RE-GRINDING SERVICE**

Delivered inserts will be:

- assessed whether they are yet economically suitable for re-grinding
- re-sharpened across the chip breakers, corresponding to the wear mark
- Re-coating*
- Labeling with insert height
- Lasering of the chip breaker true to contour*
* if necessary



worn edge



re-sharpened
and re-coated



We bunch inserts of the same profiles, group them according to the height of the wear mark, and re-sharpen to the same point height. You benefit from low changeover costs. Another advantage of this service: The holder must be adjusted to height in the machine only once.

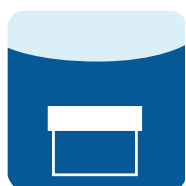
Lasering of chip breakers true to contour for new tools as well as re-sharpening



Coating service

At Leistriz, re-sharpened tools can of course be re-coated with their original coating. The use of our service guarantees that the original cutting edge geometries, for example relief and rake angles, cutting edge preparation etc., as well as the specified coating are maintained. For our customers this means: consistent quality and tool life!

Shipping service:



Defective tools into the Leistriz re-grinding box



Shipping to Leistriz



Testing, re-grinding and re-coating of the tools



Re-worked tools into the Leistriz re-grinding box



Shipping to the customer



Tools are available to the customer again

GRINDING AND ERODING DEVICES can be loaded on 2 sides



Practical examples:

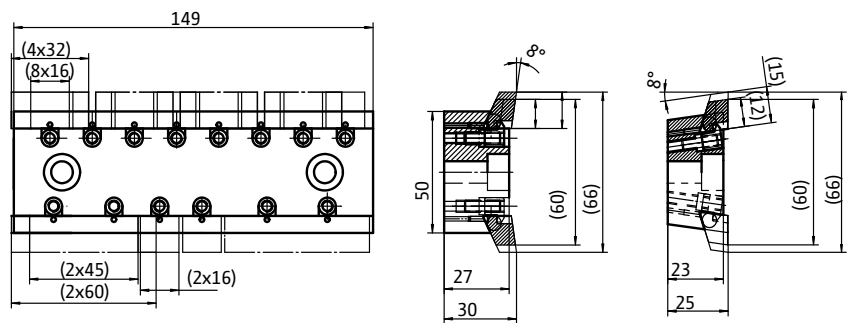
We manufacture the devices individually for your needs

Side A with:

- 4 inserts widths 18 - 32 mm
- 8 inserts widths < 16 mm

Side B with:

- 2 inserts widths 60 mm
- 2 inserts widths 38 - 45 mm
- 6 inserts ≤ 16 mm



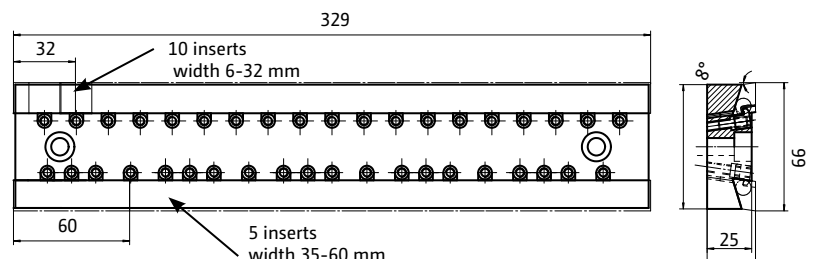
Order number	Angles for clamped inserts		Availability	Item No.:
	Relief angle	Rake angle		
SK 5538	0°	8°	●	07101632
SK 5539	8°	0°	●	07101633

Side A with:

- 10 inserts widths 18 - 32 mm
- 19 inserts widths 6 - 16 mm

Side B with:

- 5 inserts widths 38 - 60 mm
- 8 inserts widths 28 - 32 mm
- 10 inserts widths 14 - 25 mm
- 20 inserts widths 6 - 12 mm



Order number	Angles for clamped inserts		Availability	Item No.:
	Relief angle	Rake angle		
SK 5426	8°	0°		

CUTTING VALUE TABLE FOR PROFILE GROOVING WITH FLAT FORM INSERTS

Standard values for: Cutting speed and feed

Material			"VC = cutting speed in m/min"		f = feed in mm per rev. on condition		
	Label	No.:	K10F	WA10/WK10	optimal	normal	minimal
Table for steel and gray cast iron							
Structural steels DIN 1652, DIN 17100	St 37	10.120	130	170	0.04	0.03	0.02
	St 37-2	10.161	130	170	0.04	0.03	0.02
	St 42	10.140	130	170	0.04	0.03	0.02
	St 42-2	10.181	130	170	0.04	0.03	0.02
	St 50	10.531	120	150	0.04	0.03	0.02
	St 50-2	10.533	120	150	0.04	0.03	0.02
	St 60-2	10.543	120	150	0.035	0.025	0.02
	St 70-2	10.633	100	130	0.035	0.025	0.02
High-grade and quality case-hardening steels; non-alloy DIN 17210	C 10	10.301	130	170	0.04	0.03	0.02
	C k 10	11.121	130	170	0.04	0.03	0.02
	C 15	10.401	130	170	0.04	0.03	0.02
	C k 15	11.141	130	170	0.04	0.03	0.02
High-grade and quality quenched and tempered steels non-alloy DIN 1652, DIN 17210	C 35	10.501	120	150	0.04	0.03	0.02
	C k 35	11.191	120	150	0.04	0.03	0.02
	C 45	10.503	120	150	0.04	0.03	0.02
	C k 45	11.191	120	150	0.04	0.03	0.02
	C 60	10.601	100	130	0.035	0.025	0.02
	C k 60	11.221	100	130	0.035	0.025	0.02
	C 100	10.601	100	130	0.035	0.025	0.02
Stainless steels DIN 17440	X 20 Cr 13	14.021	100	130	0.03	0.025	0.015
	X 40 Cr 13	14.034	100	130	0.03	0.025	0.015
	X 12 Cr Mo S 17	14.104	100	130	0.03	0.025	0.015
	X 8 Cr 17	14.016	100	130	0.03	0.025	0.015
	X 12 Cr Ni S 1808	14.305	110	140	0.03	0.025	0.015
	X 5 Cr Ni Mo 1810	14.401	90	120	0.03	0.025	0.015
	X 10 Cr Ni Mo Ti 1810	14.571	60	80	0.03	0.025	0.015
	X 20 Cr Ni Mo 1810	14.571	60	80	0.03	0.025	0.015
Rolling bearing steel	100 Cr 6 (W3)	1.3505	100	130	0.025	0.02	0.015
Gray cast iron DIN 1691	GG- 10	0.6010	80	100	0.05	0.03	0.02
	GG- 20	0.6020	80	100	0.05	0.03	0.02
	GG- 30	0.6030	70	90	0.05	0.03	0.02
	GG- 40	0.6040	70	90	0.05	0.03	0.02
	GGG- 40	0.7040	120	160	0.05	0.03	0.02
Cast iron DIN 1693	GGG- 50	0.7050	80	100	0.05	0.03	0.02
	GGG- 60	0.7060	80	100	0.05	0.03	0.02
	GGG- 70	0.7070	60	80	0.05	0.03	0.02
	GGG- 80	0.7080	60	80	0.05	0.03	0.02
Free-cutting steels DIN 1651	9 S 20	10.711	130	170	0.05	0.04	0.02
	9 S Mn 28	10.715	120	150	0.05	0.04	0.02
	9 S Mn Pb 28	10.718	170	200	0.05	0.04	0.02
	9 S Mn Pb 28 Te		170	200	0.05	0.04	0.02
	9 S Mn 36	10.736	160	190	0.05	0.04	0.02
	9 S Mn Pb 36	10.737	160	200	0.05	0.04	0.02
	10 S 20	10.721	140	180	0.04	0.03	0.02
	10 S Pb 20	10.722	140	180	0.04	0.03	0.02
	35 S 20	10.726	120	150	0.04	0.03	0.02
	45 S 20	10.727	100	130	0.04	0.03	0.02
	60 S 20	10.728	100	130	0.04	0.03	0.02

All information is meant to be a rough guideline and very much depends on the other underlying conditions. Values which are 30-35% above or below these figures are quite practical. The values should be adjusted to the condition of the processing machine.

CUTTING VALUE TABLE FOR PROFILE GROOVING WITH FLAT FORM INSERTS

Standard values for: Cutting speed and feed

Material			"VC = cutting speed in m/min"	f = feed in mm per rev. on condition		
	Label	No.:	K10F	optimal	normal	minimal
Table for non-ferrous metals						
Aluminum, wrought and cast alloys DIN 1725	Al Mg Si Pb	3.0615	500	0.08	0.04	0.02
	Al Cu Mg Pb	3.1645	500	0.08	0.04	0.02
	Al Cu Bi Pb	3.1655	500	0.08	0.04	0.02
	Al Mg 5	3.3555	700	0.08	0.04	0.02
	G - Al Si 12	3.2581.01	200	0.08	0.04	0.02
High-grade zinc casting alloy DIN 1743	G - Zn Al4 Cu3	2.2143.01	350	0.08	0.04	0.02
Copper-zinc alloys / brass DIN 17660	"Cu Zn 40 Pb 3 (MS58)"	2.0405	400	0.08	0.04	0.02
	"Cu Zn 36 (MS63)"	2.0335	350	0.08	0.04	0.02
	"Cu Zn 36 Pb 3 (MS63Pb)"	2.0375	400	0.08	0.04	0.02
	"Cu Zn 40 Mn Pb (So Ms 58 Pb)"	2.0580	400	0.08	0.04	0.02
Copper alloys DIN 17666	Cu SP	2.1498	350	0.08	0.04	0.02
	Cu Te P (SF cu Te)	2.1546	350	0.08	0.04	0.02
Cast tin bronze, DIN 1705	G - Sn Bz 14	2.1056.01	350	0.05	0.03	0.02
	G - Sn Bz 12	2.1052.01	350	0.05	0.03	0.02
	G - Sn Bz 10	2.1050.01	350	0.05	0.03	0.02

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