

Efficient parting & grooving

Discover the accurate solution from
ZCC Cutting Tools Europe



– EN –



ZCC Cutting Tools Europe GmbH

your Partner | your Value

Modular grooving system zFlex

Maintain flexibility in your production operations

Chip breaker	Application	P	M	K	N	S	H	Feed	Cutting edge design
ZT****-MM	Parting & grooving ✓	✓	✓	✓	✓	✓	✓		
	Turning ✓								
ZT****-MU	Parting & grooving ✓	✓	✓	✓	✓	✓	✓		
	Turning ✓								
ZP****-MG	Parting & grooving ✓	✓	✓	✓	✓	✓	✓		
	Turning -								
ZT****-MG	Parting & grooving ✓	✓	✓	✓	✓	✓	✓		
	Turning ✓								
ZR****-MG	Parting & grooving ✓	✓	✓	✓	✓	✓	✓		
	Turning ✓								
ZR****-EG	Parting & grooving ✓	✓	✓	✓	✓	✓	✓		
	Turning ✓								

✓ Very suitable ✓ Suitable

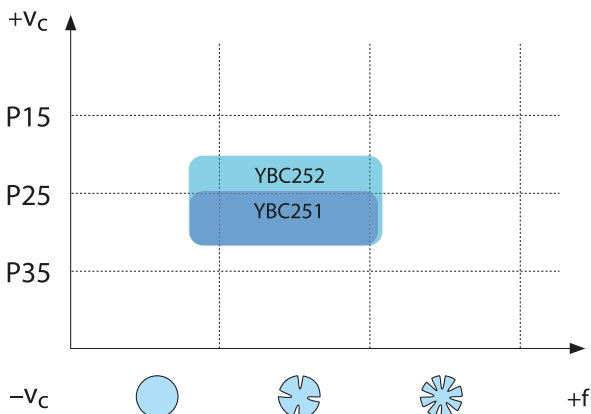
■ Parting & grooving
■ Turning

A Turning
B Milling
C Drilling
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A

Turning

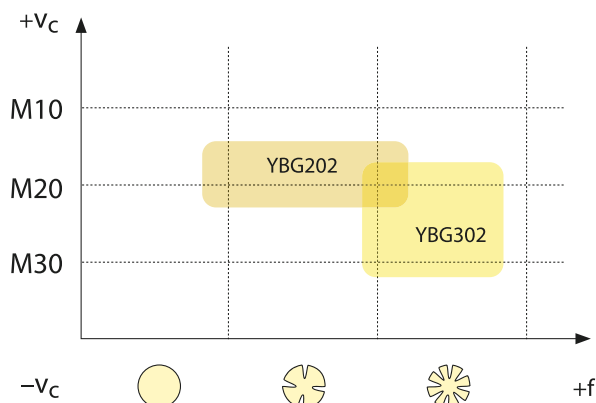
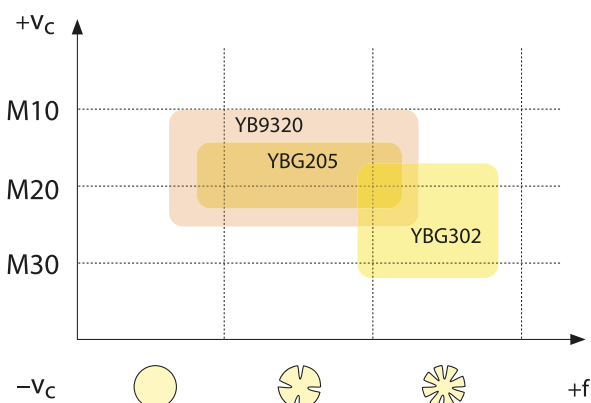
CVD coated carbide grades for steel



B

Milling

PVD coated carbide grades for stainless steel



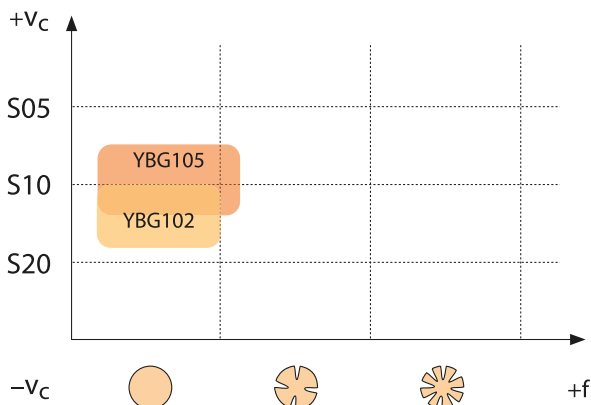
C

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D

Technical Information

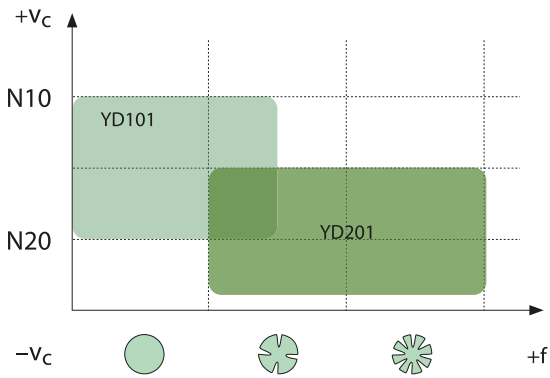
PVD coated carbide grades for superalloys



E

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Carbide grades for non-ferrous metals



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Application	
Code	Description
ZP	Parting
ZT	Grooving & turning
ZR	Form turning


1

Insert seat size [mm]	
Groove width	
Code	Description
B	2,0
E	2,5
F	3,0
G	4,0
H	5,0
K	6,0
L	8,0

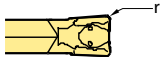
2

No. of cutting edges	
Code	Description
S	Single
D	Double

3

Insert thickness S [mm]	
	
Code	S
02	2,0
025	2,5
03	3,0
04	4,0
05	5,0
06	6,0
08	8,0

4

Nose radius r [mm]	
	
Code	r
02	0,2
03	0,3
04	0,4
08	0,8




5

Tolerance class [mm]	
Code	Description
M	±0,13
E	±0,025

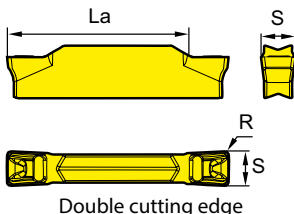

















6

Chip breaker	
Code	Description
G	General chip breaker
F	Special chip breaker
M	Straight edge
U	Universal chip breaker

7

-  Ideal machining conditions
-  Normal machining conditions
-  Unfavourable machining conditions



Parting inserts

Parting & grooving insert (double sided)					HC ¹ (CVD)		HC ¹ (PVD)				HW	
 <p>Double cutting edge</p>	P											
	M											
	K											
	N											
	S											
H												
ISO	R \pm 0.1	La max	S	f	YBC252 YBC251		YBG105 YBG102	YB9320 YBG205	YBG202 YBG302		YD101 YD201	
 ZTBD02002-MM	0.2	13	2	0,02-0,07				● ● ○				
ZTED02503-MM	0.3	17	2.5	0,03-0,1			●					
ZTFD0303-MM	0.3	17	3	0,04-0,13			●					
ZTGD0404-MM	0.4	22	4	0,06-0,18			●					
ZTHD0504-MM	0.4	22	5	0,08-0,23			●					
ZTKD0608-MM	0.8	22	6	0,12-0,27			●					
ZTLD0808-MM	0.8	28	8	0,13-0,29	○		● ○					

● Ex stock ○ On demand

HC¹ Coated carbide
HW Uncoated carbide

Tool holders

QE*D*R/L	QE*D*R/L-DGC	QE*D*R/L-DGSC	QE*D*R/L-SC
			
A17	A19	A21	A22






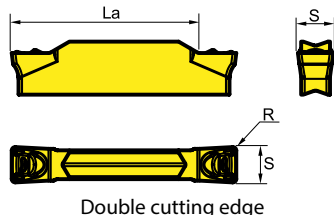





Do you already know our innovative modular grooving system zFlex?

A

Turning


Parting inserts

-  Ideal machining conditions
-  Normal machining conditions
-  Unfavourable machining conditions

Parting & grooving insert (double sided)		HC ¹ (CVD)	HC ¹ (PVD)	HW
	P			
	M			
	K			
	N			
	S			
	H			

B

Milling


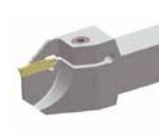
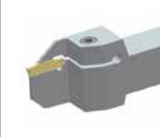
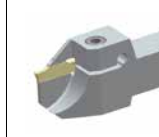
ISO	R±0.1	La max	S±0.10	f	YBC252 YBC251	YBG105 YBG102 YBG320 YBG205 YBG202 YBG302	YD101 YD201
 ZTFD0302-MU	0,2	17	3	0,06-0,18		●	
ZTFD0303-MU	0,3	17	3	0,06-0,18		●	
ZTGD0402-MU	0,2	22	4	0,08-0,20		●	
ZTGD0404-MU	0,4	22	4	0,08-0,20		●	
ZTHD0504-MU	0,4	22	5	0,09-0,25		●	
ZTHD0508-MU	0,8	22	5	0,09-0,25		●	
ZTKD0604-MU	0,4	22	6	0,15-0,30		○	
ZTKD0608-MU	0,8	22	6	0,15-0,30		○	

● Ex stock ○ On demand

HC¹ Coated carbide
HW Uncoated carbide

C

Drilling

Tool holders			
QE*D*R/L	QE*D*R/L-DGC	QE*D*R/L-DGSC	QE*D*R/L-SC
			
A17	A19	A21	A22

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Do you already know our innovative modular grooving system **zFlex**?

- Ideal machining conditions
- Normal machining conditions
- Unfavourable machining conditions

Parting inserts

Parting & grooving insert (double sided)						HC ¹ (CVD)		HC ¹ (PVD)				HW					
<p>Double cutting edge</p>						P	● ●					● ● ● ● ● ●					
						M						● ● ● ● ● ●					
						K											
						N										● ●	
						S								● ● ● ● ● ●			
H																	
ISO	R±0.1	La max	S±0.10	f	YBC252	YBC251	YBG105	YBG102	YB9320	YBG205	YBG202	YBG302	YD101	YD201			
	ZPED02502-MG	0.2	17	2.5	0,03-0,1	●			●	○	●						
	ZPFD0302-MG	0.2	17	3	0,04-0,13	● ●			●	○	●						
	ZPGD0402-MG	0.2	22	4	0,07-0,18	●			●		●		○				
	ZPHD0503-MG	0.3	22	5	0,1-0,24						○	●					
	ZPKD0604-MG	0.4	22	6	0,12-0,29	○					○	●					

● Ex stock ○ On demand

HC¹ Coated carbide
HW Uncoated carbide

Tool holders			
QE*D*R/L	QE*D*R/L-DGC	QE*D*R/L-DGSC	QE*D*R/L-SC
A17	A19	A21	A22



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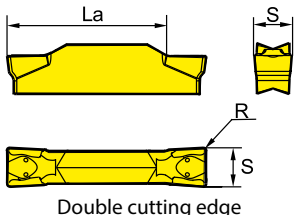















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Turning

Parting inserts

-  Ideal machining conditions
-  Normal machining conditions
-  Unfavourable machining conditions

Parting & grooving insert (double sided)					HC ¹ (CVD)		HC ¹ (PVD)			HW	
	P										
	M										
	K										
	N										
	S										
H											

B

Milling




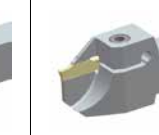
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ZTED02503-MG		17	2,5	0,03-0,11										
ZTFD0303-MG		17	3	0,04-0,14										
ZTGD0402-MG		22	4	0,07-0,2										
ZTGD0404-MG		22	4	0,07-0,2										
ZTHD0504-MG		22	5	0,10-0,25										
ZTKD0604-MG		22	6	0,13-0,30										
ZTKD0608-MG		22	6	0,13-0,30										

● Ex stock ○ On demand

HC¹ Coated carbide
HW Uncoated carbide

C

Drilling

Tool holders			
QE*D*R/L	QE*D*R/L-DGC	QE*D*R/L-DGSC	QE*D*R/L-SC
			
A17	A19	A21	A22

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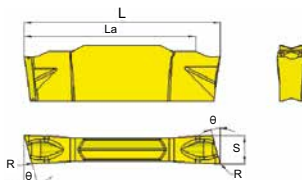

















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Do you already know our innovative modular grooving system **zFlex**?


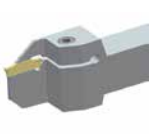

Parting inserts

-  Ideal machining conditions
-  Normal machining conditions
-  Unfavourable machining conditions

Parting & grooving insert (double sided)								HC ¹ (CVD)		HC ¹ (PVD)			HW	
 <p>Right hand style</p>	P													
	M													
	K													
	N													
	S													
H														
ISO	La max	L	S	θ	R	f	YBC252 YBC251		YBG105 YBG102 YB9320 YBG205 YBG202 YBG302			YD101 YD201		
	ZPED02502-MG-6L	17	20	2.35	6°	0.2	0,03-0,08					●		
	ZPED02502-MG-6R	17	20	2.35	6°	0.2	0,03-0,08			●	●			
	ZPED02502-MG-15L	17	20	2.35	15°	0.2	0,03-0,05					○		
	ZPED02502-MG-15R	17	20	2.35	15°	0.2	0,03-0,05					○	○	
	ZPFD0302-MG-6L	17	20	2.85	6°	0.2	0,04-0,1			●	○	●		
	ZPFD0302-MG-6R	17	20	2.85	6°	0.2	0,04-0,1			●	○	○		
	ZPFD0302-MG-15L	17	20	2.85	15°	0.2	0,04-0,08					○	○	
	ZPFD0302-MG-15R	17	20	2.85	15°	0.3	0,04-0,08			●	○			

● Ex stock ○ On demand

HC¹ Coated carbide
HW Uncoated carbide

Tools holders			
QE*D*R/L	QE*D*R/L-DGC	QE*D*R/L-DGSC	QE*D*R/L-SC
			
A17	A19	A21	A22



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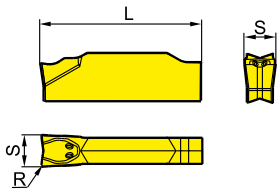
















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A

Turning


Parting inserts

-  Ideal machining conditions
-  Normal machining conditions
-  Unfavourable machining conditions

Parting & grooving insert (single sided)		HC ¹ (CVD)	HC ¹ (PVD)	HW
 <p>Single cutting edge</p>	P	 	   	
	M		   	
	K			
	N			 
	S		   	
	H			

B

Milling

ISO	R±0.1	S±0.10	f	YBC252	YBC251	YBG105	YBG102	YB9320	YBG205	YBG202	YBG302	YD101	YD201
	ZPES02502-MG	0.2	2.5	0,03-0,1				○		○	●		
	ZPFS0302-MG	0.2	3	0,04-0,13	●			●		●			
	ZPGS0402-MG-25	0.2	4	0,07-0,18				●					
	ZPHS0503-MG-25	0.3	5	0,1-0,24				●					
	ZPKS0604-MG-25	0.4	6	0,12-0,29				●					



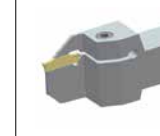
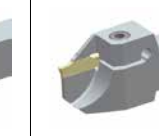
● Ex stock ○ On demand

Single sided inserts only for parting blades

HC¹ Coated carbide
HW Uncoated carbide

C

Drilling

Tool holders			
QE*D*R/L	QE*D*R/L-DGC	QE*D*R/L-DGSC	QE*D*R/L-SC
			
A17	A19	A21	A22

D




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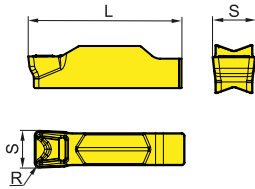

















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Do you already know our innovative modular grooving system **zFlex**?


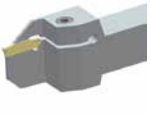
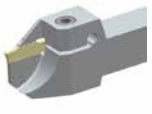
-  Ideal machining conditions
-  Normal machining conditions
-  Unfavourable machining conditions

Parting inserts

Parting & grooving insert (single sided)						HC ¹ (CVD)		HC ¹ (PVD)			HW					
 <p>Single cutting edge</p>	P															
	M															
	K															
	N															
	S															
	H															
	ISO	R±0.1	L	S±0.10	f	YBC252	YBC251		YBG105	YBG102	YB9320	YBG205	YBG202	YBG302	YD101	YD201
	ZTES02503-MM	0.3	19.9	2.5	0,03-0,1						●					
	ZTFS0303-MM	0.3	19.9	3	0,04-0,13						●					
	ZTGS0404-MM-25	0.4	24.6	4	0,06-0,18						●					
	ZTHS0504-MM-25	0.4	24.6	5	0,08-0,23						●					
	ZTKS0608-MM-25	0.8	24.6	6	0,12-0,27						●					

● Ex stock ○ On demand

HC¹ Coated carbide
HW Uncoated carbide

Tool holders			
QE*D*R/L	QE*D*R/L-DGC	QE*D*R/L-DGSC	QE*D*R/L-SC
			
A17	A19	A21	A22






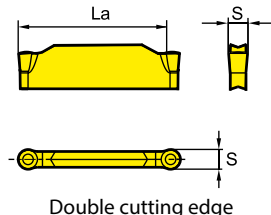















Do you already know our innovative modular grooving system zFlex?

A

Turning




Parting inserts

-  Ideal machining conditions
-  Normal machining conditions
-  Unfavourable machining conditions

Parting & grooving insert (double sided)				HC ¹ (CVD)		HC ¹ (PVD)					HW	
 <p>Double cutting edge</p>	P											
	M											
	K											
	N											
	S											
H												

B

Milling



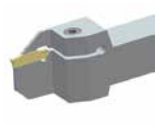

ISO	La max	S±0.10	f	YBC252		YBC251		YBG105					YD101	
				YBC252	YBC251	YBG102	YBG102	YBG320	YBG205	YBG202	YBG302	YD101	YD201	
 ZRED025-MG	17.5	2.5	0,03-0,11											
ZRFD03-MG	17	3	0,04-0,14											
ZRGD04-MG	21	4	0,07-0,2											
ZRHD05-MG	20	5	0,1-0,24											
ZRKD06-MG	19	6	0,12-0,29											

● Ex stock ○ On demand

HC¹ Coated carbide
HW Uncoated carbide

C

Drilling

Tool holders			
QE*D*R/L	QE*D*R/L-DGC	QE*D*R/L-DGSC	QE*D*R/L-SC
			
A17	A19	A21	A22

D




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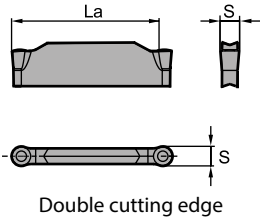

















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Do you already know our innovative modular grooving system **zFlex**?

-  Ideal machining conditions
-  Normal machining conditions
-  Unfavourable machining conditions


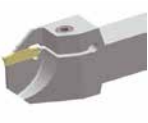

Parting inserts

Parting & grooving insert (double sided)					HC ¹ (CVD)		HC ¹ (PVD)			HW		
 <p>Double cutting edge</p>	P	 					   					
	M						   					
	K											
	N									 		
	S							   				
H												
ISO	La max	S±0.025	f	YBC252 YBC251			YBG105 YBG102 YB9320 YBG205 YBG202 YBG302		YD101 YD201			
	ZRFD03-EG	17	3	0,04-0,14				●	○			
	ZRGD04-EG	21	4	0,07-0,2				●				
	ZRHD05-EG	20	5	0,1-0,24				●	○			
	ZRKD06-EG	19	6	0,12-0,29				○				

● Ex stock ○ On demand

HC¹ Coated carbide
HW Uncoated carbide

Tool holders

QE*D*R/L	QE*D*R/L-DGC	QE*D*R/L-DGSC	QE*D*R/L-SC
			
A17	A19	A21	A22



Do you already know our innovative modular grooving system **zFlex**?

External tool holders

Q F G D 2525 R 22 (S) C – (130) (H)

1 2 3 4 5 6 7 8 9 10 11

Holder for parting & grooving

1

Application	
Code	Description
E	External machining
F	Axial machining

2

Insert seat size [mm]	
Holder/cutting width	
Code	Description
A	1,5
B	2,0
E	2,5
F	3,0
G	4,0
H	5,0
K	6,0
L	8,0

3

No. of cutting edges	
Code	Description
S	Single
D	Double

4

Cross section of holder [mm] x [mm]

5

Type	
Code	Description
R	Right
L	Left
N	Right and left

6

Max. cutting depth [mm]

7

Serie	
Code	Description
S	Swiss turning holder
DG	Cut-off holder for greater grooving depths with reinforcement
DGS	Cut-off holder for greater grooving depths without reinforcement

8

With internal cooling

9

Min. diameter of work piece for first axial grooving [mm]

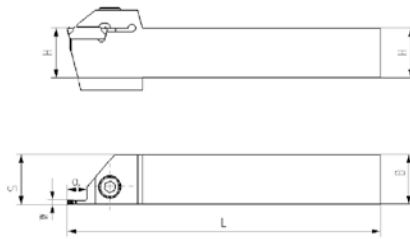
10

Cutting head	
Code	Description
H	0°
L	90°

11

Parting & grooving tool holder (external)

QE**R/L



Article	*	Stock		Dimensions [mm]					Inserts
		R	L	HxB	L	S	W	ar _{max}	
QEED1616R/L10	●	●	16x16	125	15	2.5	10	Z*ED**	
QEED1616R/L17	●	●	16x16	125	15	2.5	17	Z*ED**	
QEED2020R/L17	●	●	20x20	125	19	2.5	17	Z*ED**	
QEED2020R/L10	●	●	20x20	150	10	2.5	10	Z*ED**	
QEED2525R/L10	●	●	25x25	150	19	2.5	10	Z*ED**	
QEED2525R/L17	●	●	25x25	150	19	2.5	17	Z*ED**	
QEGD2020R/L13	●	●	20x20	140	18.5	4	13	Z*GD**	
QEGD2020R/L22	●	●	20x20	140	18.5	4	22	Z*GD**	
QEGD2525R/L13	●	●	25x25	150	23.5	4	13	Z*GD**	
QEGD2525R/L22	●	●	25x25	150	23.5	4	22	Z*GD**	
QEGD3232R/L13	●	●	32x32	170	30.5	4	13	Z*GD**	
QEGD3232R/L22	●	●	32x32	170	30.5	4	22	Z*GD**	
QEHD2525R/L13	●	●	25x25	150	23	5	13	Z*HD**	
QEHD2525R/L22	●	●	25x25	150	23	5	22	Z*HD**	
QEHD3232R/L13	●	●	32x32	170	30	5	13	Z*HD**	
QEHD3232R/L22	●	●	32x32	170	30	5	22	Z*HD**	
QEKD2525R/L13	●	●	25x25	150	22.6	6	13	Z*KD**	
QEKD2525R/L22	●	●	25x25	150	22.6	6	22	Z*KD**	
QEKD3232R/L13	●	●	32x32	170	29.6	6	13	Z*KD**	
QEKD3232R/L22	●	●	32x32	170	29.6	6	22	Z*KD**	

● Ex stock ○ On demand

* With internal cooling





You can find our **axial grooving tools** in our Main Catalogue from page A434 to A442. Simply scan the QR code.

A










Turning

Parting & grooving tool holder (external)

Spare parts									
	Insert	Z*BD**	Z*ED**	Z*ED**	Z*FD**	Z*FD**	Z*GD**	Z*HD**	Z*KD**
	H	16-20	16	20-32	16	20-32	20-32	20-32	20-32
	Screw	GB70-85-M5×16 (4.0 Nm)	GB70-85-M5×20 (4.0 Nm)	GB70-85-M6×20 (7.0 Nm)	GB70-85-M5×20 (4.0 Nm)	GB70-85-M6×20 (7.0 Nm)	GB70-85-M6×20 (7.0 Nm)	GB70-85-M6×20 (7.0 Nm)	GB70-85-M6×20 (7.0 Nm)
	Wrench	WH40L	WH40L	WH50L	WH40L	WH50L	WH50L	WH50L	WH50L

B

Milling

Insert					
					
A7	A8	A9	A10	A11	A12
					
A13	A14	A15			

C

Drilling

D

Technical Information

E

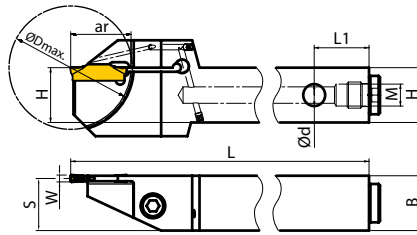
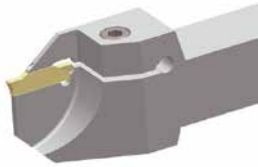
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Parting & grooving tool holder (external)

QE**R/L-DGC



Article	*	Stock		Dimensions [mm]										Inserts
		R	L	HxB	ød	L	S	L ₁	W	ar _{max}	ØD _{max}	M		
QEED1616R/L20-DGC	*	○	○	16x16	G1/8	96	15	20	2	20	40	G1/8	Z*BD**	
QEED1616R/L30-DGC	*	●	●	16x16	G1/8	105	15	20	2	30	60	G1/8	Z*BD**	
QEED2020R/L20-DGC	*	○	○	20x20	G1/8	111	19	20	2	20	40	G1/8	Z*BD**	
QEED2020R/L30-DGC	*	●	●	20x20	G1/8	120	19	20	2	30	60	G1/8	Z*BD**	
QEED2525R/L20-DGC	*	○	○	25x25	G1/8	126	24	20	2	20	40	G1/8	Z*BD**	
QEED2525R/L30-DGC	*	●	●	25x25	G1/8	135	24	20	2	30	60	G1/8	Z*BD**	
QEED1616R/L20-DGC	*	○	○	16x16	G1/8	96	14.75	20	2.5	20	40	G1/8	Z*ED**	
QEED1616R/L30-DGC	*	●	●	16x16	G1/8	105	14.75	20	2.5	30	60	G1/8	Z*ED**	
QEED2020R/L20-DGC	*	○	○	20x20	G1/8	111	18.75	20	2.5	20	40	G1/8	Z*ED**	
QEED2020R/L30-DGC	*	●	○	20x20	G1/8	120	18.75	20	2.5	30	60	G1/8	Z*ED**	
QEED2525R/L20-DGC	*	○	○	25x25	G1/8	126	23.75	20	2.5	20	40	G1/8	Z*ED**	
QEED2525R/L30-DGC	*	○	○	25x25	G1/8	135	23.75	20	2.5	30	60	G1/8	Z*ED**	
QEFD1616R/L20-DGC	*	○	○	16x16	G1/8	96	14.5	20	3	20	40	G1/8	Z*FD**	
QEFD1616R/L30-DGC	*	●	●	16x16	G1/8	105	14.5	20	3	30	60	G1/8	Z*FD**	
QEFD2020R/L20-DGC	*	○	○	20x20	G1/8	111	18.5	20	3	20	40	G1/8	Z*FD**	
QEFD2020R/L30-DGC	*	●	●	20x20	G1/8	120	18.5	20	3	30	60	G1/8	Z*FD**	
QEFD2525R/L20-DGC	*	○	○	25x25	G1/8	126	23.5	20	3	20	40	G1/8	Z*FD**	
QEFD2525R/L30-DGC	*	○	○	25x25	G1/8	135	23.5	20	3	30	60	G1/8	Z*FD**	
QEGD1616R/L20-DGC	*	○	○	16x16	G1/8	96	14	20	4	20	40	G1/8	Z*GD**	
QEGD1616R/L30-DGC	*	●	●	16x16	G1/8	105	14	20	4	30	60	G1/8	Z*GD**	
QEGD2020R/L20-DGC	*	○	○	20x20	G1/8	111	18	20	4	20	40	G1/8	Z*GD**	
QEGD2020R/L30-DGC	*	○	○	20x20	G1/8	120	18	20	4	30	60	G1/8	Z*GD**	
QEGD2525R/L20-DGC	*	○	○	25x25	G1/8	126	23	20	4	20	40	G1/8	Z*GD**	
QEGD2525R/L30-DGC	*	○	○	25x25	G1/8	135	23	20	4	30	60	G1/8	Z*GD**	

● Ex stock ○ On demand

* With internal cooling










Spare parts

	Insert	Z*BD**	Z*ED**	Z*FD**	Z*GD**
		H	16-25	16-25	16-25
	Grub screw	PT1/8x4	PT1/8x4	PT1/8x4	PT1/8x4
	Screw	GB70-85-M5x20 (4.0 Nm)	GB70-85-M5x20 (4.0 Nm)	GB70-85-M5x20 (4.0 Nm)	GB70-85-M5x20 (4.0 Nm)
	Wrench	WH40L	WH40L	WH40L	WH40L
	Wrench	WH50L	WH50L	WH50L	WH50L

A

Turning

Parting & grooving tool holder (external)

Insert					
					
A7	A8	A9	A10	A11	A12
					
A13	A14	A15			

B

Milling

C

Drilling

D

Technical Information

E

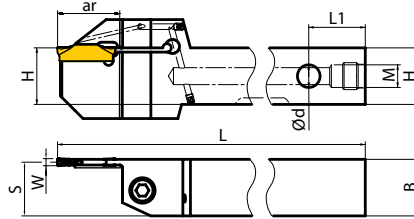
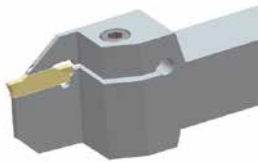
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You can find our **axial grooving tools** in our Main Catalogue from page A434 to A442. Simply scan the QR code.

Parting & grooving tool holder (external)

QE**R/L-DGSC



Article	*	Stock		Dimensions [mm]								Inserts
		R	L	HxB	ød	L	S	L ₁	W	ar _{max}	M	
QEED1616R/L30-DGSC	*	●	●	16x16	G1/8	105	14.75	20	2.5	30	G1/8	Z*ED**
QEED2020R/L30-DGSC	*	●	○	20x20	G1/8	120	18.75	20	2.5	30	G1/8	Z*ED**
QEED2525R/L30-DGSC	*	○	○	25x25	G1/8	135	23.75	20	2.5	30	G1/8	Z*ED**
Qefd1616R/L30-DGSC	*	●	●	16x16	G1/8	105	14.5	20	3	30	G1/8	Z*FD**
Qefd2020R/L30-DGSC	*	○	○	20x20	G1/8	120	18.5	20	3	30	G1/8	Z*FD**
Qefd2525R/L30-DGSC	*	○	○	25x25	G1/8	135	23.5	20	3	30	G1/8	Z*FD**
QEGD1616R/L30-DGSC	*	○	○	16x16	G1/8	105	14	20	4	30	G1/8	Z*GD**
QEGD2020R/L30-DGSC	*	○	○	20x20	G1/8	120	18	20	4	30	G1/8	Z*GD**
QEGD2525R/L30-DGSC	*	○	○	25x25	G1/8	135	23	20	4	30	G1/8	Z*GD**
QeHD2525R/L30-DGSC	*	○	○	25x25	G1/8	135	22.5	20	5	30	G1/8	Z*HD**
QEKD2525R/L30-DGSC	*	○	○	25x25	G1/8	135	22	20	6	30	G1/8	Z*KD**

● Ex stock ○ On demand

* With internal cooling

Spare parts

	Insert H	Z*ED** 16-25	Z*FD** 16-25	Z*GD** 20-25	Z*HD** 20-25	Z*KD** 20-25
	Grub screw	PT1/8x4	PT1/8x4	PT1/8x4	PT1/8x4	PT1/8x4
	Screw	GB70-85-M5x20 (4.0 Nm)	GB70-85-M5x20 (4.0 Nm)	GB70-85-M5x20 (4.0 Nm)	GB70-85-M6x20 (7.0 Nm)	GB70-85-M6x20 (7.0 Nm)
	Wrench	WH40L	WH40L	WH40L	WH50L	WH50L
	Wrench	WH50L	WH50L	WH50L	WH50L	WH50L

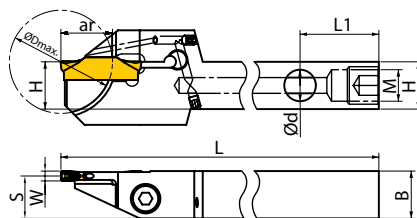
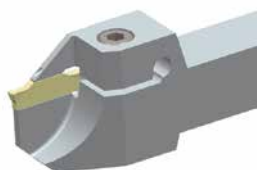
Insert

A7	A8	A9	A10	A11	A12

A13	A14	A15

Parting & grooving tool holder (external)

QE**R/L-SC



Article	*	Stock		Dimensions [mm]									Inserts
		R	L	HxB	Ød	L	S	L ₁	W	ar _{max}	ØD _{max}	M	
QEAD1010R/L10-SC	*	○	○	10x10	G1/16	125	9	20	1.5	10	20	G1/16	Z*AD**
QEAD1212R/L13-SC	*	○	○	12x12	G1/8	125	12	20	1.5	13	26	G1/8	Z*AD**
QEAD1616R/L13-SC	*	○	○	16x16	G1/8	125	15	20	1.5	13	26	G1/8	Z*AD**
QEAD2020R/L13-SC	*	○	○	20x20	G1/8	125	19	20	1.5	13	26	G1/8	Z*AD**
QEBD1010R/L10-SC	*	○	○	10x10	G1/16	110	9	20	2	10	20	G1/16	Z*BD**
QEBD1212R/L13-SC	*	●	●	12x12	G1/8	110	11	20	2	13	26	G1/8	Z*BD**
QEBD1616R/L13-SC	*	●	●	16x16	G1/8	110	15	20	2	13	26	G1/8	Z*BD**
QEBD2020R/L13-SC	*	○	○	20x20	G1/8	110	19	20	2	13	26	G1/8	Z*BD**
QEED1010R/L10-SC	*	○	○	10x10	G1/16	110	8.75	20	2.5	10	20	G1/16	Z*ED**
QEED1212R/L13-SC	*	●	●	12x12	G1/8	110	10.75	20	2.5	13	26	G1/8	Z*ED**
QEED1616R/L17-SC	*	●	●	16x16	G1/8	110	14.75	20	2.5	17	34	G1/8	Z*ED**
QEED2020R/L17-SC	*	●	●	20x20	G1/8	110	18.75	20	2.5	17	34	G1/8	Z*ED**
Qefd1212R/L13-SC	*	●	●	12x12	G1/8	110	10.5	20	3	13	26	G1/8	Z*FD**
Qefd1616R/L17-SC	*	●	●	16x16	G1/8	110	14.5	20	3	17	34	G1/8	Z*FD**
Qefd2020R/L22-SC	*	●	●	20x20	G1/8	110	18.5	20	3	22	44	G1/8	Z*FD**










● Ex stock ○ On demand

* With internal cooling

Spare parts

Insert	H	Z*AD**	Z*AD**	Z*AD**	Z*AD**	Z*BD**	Z*BD**	Z*BD**	Z*ED**	Z*ED**	Z*ED**	Z*FD**	Z*FD**
		10	12	16	20	10	12	16-20	10	12	16-20	12	16-20
	Grub screw	PT1/16x6	PT1/8x4	PT1/8x4	PT1/8x4	PT1/16x6	PT1/8x4	PT1/8x4	PT1/16x6	PT1/8x4	PT1/8x4	PT1/8x4	PT1/8x4
	Screw	GB70-85-M4x12 (2.6 Nm)	GB70-85-M4x12 (2.6 Nm)	GB70-85-M4x14	GB70-85-M4x18	GB70-85-M4x12 (2.6 Nm)	GB70-85-M4x12 (2.6 Nm)	GB70-85-M6x20 (7.0 Nm)	GB70-85-M4x12 (2.6 Nm)	GB70-85-M4x12 (2.6 Nm)	GB70-85-M6x20 (7.0 Nm)	GB70-85-M4x12 (2.6 Nm)	GB70-85-M5x20 (4.0 Nm)
	Wrench	WH30L	WH30L	WH30L	WH30L	WH30L	WH30L	WH40L	WH30L	WH30L	WH40L	WH30L	WH40L
	Wrench	WH40L	WH50L	WH50L	WH50L	WH40L	WH50L	WH50L	WH40L	WH50L	WH50L	WH50L	WH50L

Parting & grooving tool holder (external)

Insert					
					
A7	A8	A9	A10	A11	A12
					
A13	A14	A15			

A

Turning

B

Milling

C

Drilling

D

Technical
Information

E

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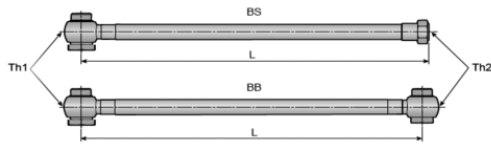


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A

Accessoires

Coolant hose



Turning

B

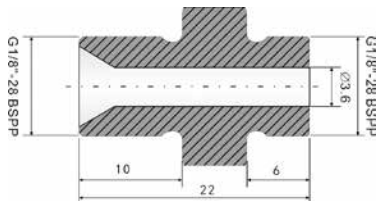
Article	Dimensions [mm]			Stock
	L	Th1	Th2	
HOSE G1/8-7/16/200BS	200	G1/8"-28 BSPP	G1/8"-28 BSPP	○
HOSE G1/8-7/16/300BS	300	G1/8"-28 BSPP	G1/8"-28 BSPP	○
HOSE G1/8-7/16/200BB	200	G1/8"-28 BSPP	G1/8"-28 BSPP	○
HOSE G1/8-7/16/300BB	300	G1/8"-28 BSPP	G1/8"-28 BSPP	○

Milling

● Ex stock ○ On demand

C

Coolant connection



Drilling

D

Article	Stock
NIPPLE G1/8- G1/8	○

● Ex stock ○ On demand

Technical Information

F

Index

Chip breaker MU

Universal tool that delivers optimum chip control

Parting & grooving inserts

Material group	Composition / structure / heat treatment		Brinell hardness HB	Machining group	Starting values for cutting speed vc [m/min]			
					HC (CVD)		HC (PVD)	
					YBC252	YBG102	YBG105	
P Unalloyed steel Low-alloyed steel High-alloyed steel and high-alloyed tool steel	approx. 0,15 % C	annealed	125	1	190			
		annealed	190	2	175			
		approx. 0,45 % C	tempered	250	3	145		
		annealed	270	4	140			
		tempered	300	5	135			
		annealed	180	6	170			
		tempered	275	7	125			
		tempered	300	8	115			
		tempered	350	9	105			
		annealed	200	10	125			
		hardened and tempered	325	11	95			
M Stainless steel	ferritic/martensitic	annealed	200	12	165	165	170	
	martensitic	tempered	240	13	135	135	140	
	austenitic	quench hardened	180	14	155	155	160	
	austenitic-ferritic		230	15	135	135	140	
K Grey cast iron Cast iron with spheroidal graphite Malleable cast iron	perlitic/ferritic		180	16	240			
		perlitic (martensitic)	260	17	185			
	ferritic		160	18	220			
		perlitic	250	19	165			
	ferritic		130	20	175			
		perlitic	230	21	165			
N Aluminium wrought alloys Cast aluminium alloys Copper and copper alloys (bronze/brass)	cannot be hardened		60	22				
	hardenable		100	23				
	≤ 12% Si, cannot be hardened		75	24				
		≤ 12% Si, hardenable	hardened	90	25			
		> 12% Si, cannot be hardened		130	26			
	machining steel, PB> 1%		110	27				
		CuZn, CuSnZn	90	28				
		CuSn, Pb-free copper, electrolytic copper	100	29				
S Heat-resistant alloys Titanium alloys	Fe-based alloys	annealed	200	30		95	100	
		hardened	280	31		50	50	
	Ni or Co bass	annealed	250	32		80	80	
		hardened	350	33		70	70	
		cast	320	34		70	70	
pure titanium		R _m 400	35		145	150		
	α and β alloys	hardened	R _m 1050	36		50	50	
H Hardened steel Hard cast iron Hardened cast iron		hardened and tempered	55 HRC	37				
		hardened and tempered	60 HRC	38				
		cast	400	39				
X Non-metallic materials		hardened and tempered	55 HRC	40				
	Thermoplasts			41				
	Thermosetting plastics			42				
	Plastic, glass-fibre reinforced GFRP			43				
	Plastic, carbon fibre reinforced CFRP			44				
	Graphite			45				
	Wood			46				

Note: The given cutting values are guide values, which were determined under ideal conditions.
The values have to be adapted in individual cases.
For examples of material for cutting tool groups view page D11.

A

Turning

B

Milling

C

Drilling

D

Technical Information

E

Index

Starting values for cutting speed vc [m/min]							
	HC (PVD)				HW		
	YB9320	YBG202	YBG205	YBG302	YD101	YD201	
	190	190	190	185			
	175	175	175	170			
	145	145	145	140			
	140	140	140	135			
	135	135	135	130			
	170	170	170	165			
	125	125	125	125			
	115	115	115	115			
	105	105	105	105			
	125	125	125	125			
	95	95	95	95			
	165	165	165	160			
	135	135	135	130			
	155	155	155	150			
	135	135	135	130			
	240	240	240	235			
	185	185	185	180			
	220	220	220	215			
	165	165	165	160			
	175	175	175	170			
	165	165	165	160			
					800	760	
					600	570	
					320	305	
					240	230	
					160	155	
					160	155	
					600	570	
					200	190	
	95	95	95	95	70	65	
	50	50	50	50	35	35	
	80	80	80	75	60	60	
	70	70	70	65	50	50	
	70	70	70	65	50	50	
	145	145	145	140	105	100	
	50	50	50	50	35	35	

HC Coated carbide
 HW Uncoated carbide, main component (WC)

A

Turning

B

Milling

C

Drilling

D

Technical Information

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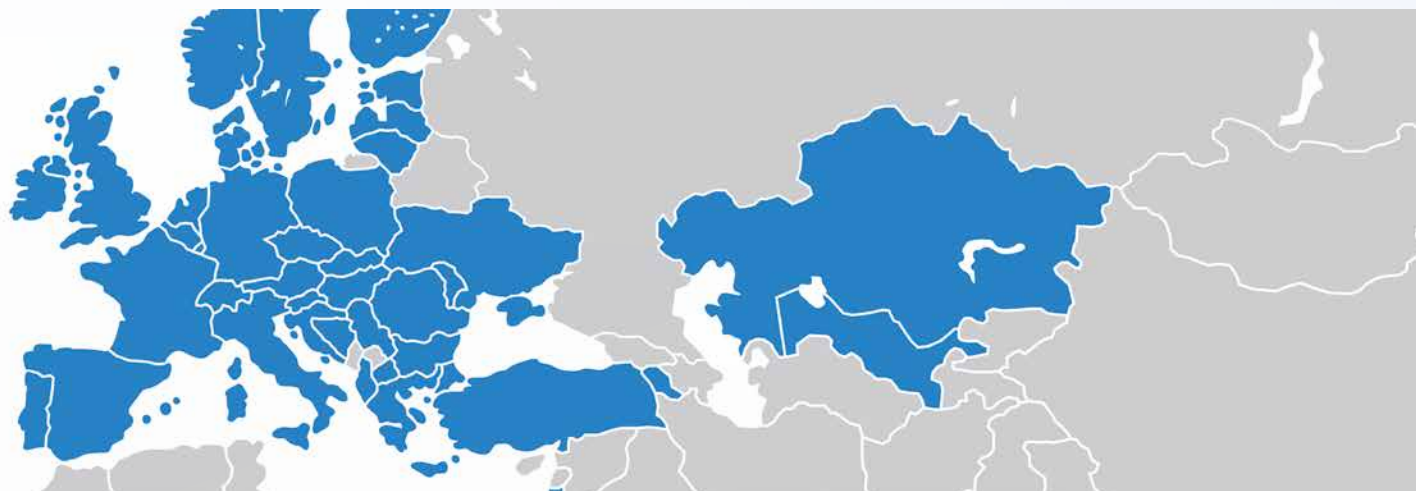




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