



D - GROOVING & PARTING OFF

D - 654 | Inserts overview

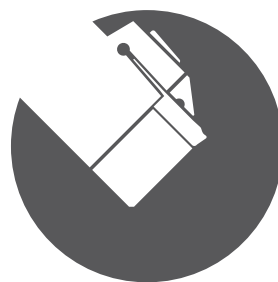
D - 656 | GROOVING PLUS

D - 656 | Inserts code key

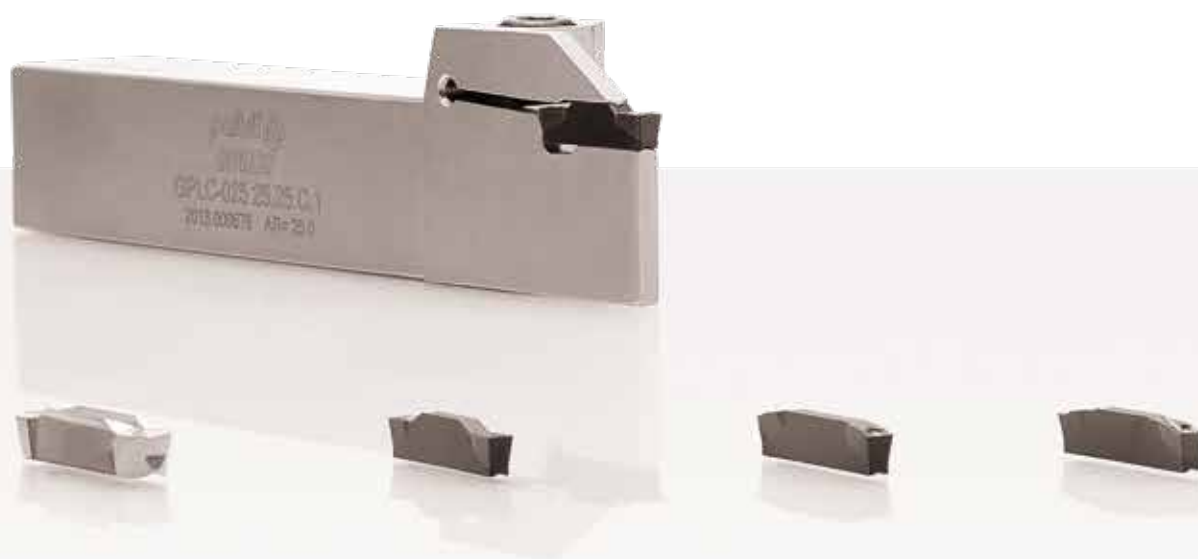
D - 657 | GP Inserts

D - 660 | Blades & Toolholders code key

D - 661 | Blades & Toolholders



GROOVING & PARTING OFF



D - 664 | GROOVING

D - 664 | Inserts code key & Overview

D - 665 | Inserts

D - 670 | Blades code key

D - 671 | Blades & Toolholders

D - 673 | Trigon Inserts

D - 676 | Trigon Toolholders

D - 680 | SAL (Swiss Automatic Lathes)

D - 682 | Inserts & toolholders code key

D - 684 | Toolholders

D - 685 | Inserts

D - 688 | Technical data

D - 690 | SPARE PARTS

D - 691 TECHNICAL DATA

GENERAL INSERTS OVERVIEW



GROOVING & PARTING OFF

Grooving Plus & Parting Off

Grooving & Parting Off

SAL - Swiss Automatic Lathes

Technical Data

Operation Insert Type + Chipbreaker		Parting Off	General Grooving	Turning	Profiling
	GP...-N01-MC GP...-R01-MC GP...-L01-MC				
	GP...-N02-MC GP...-R02-MC GP...-L02-MC				
	GP...-N02-MG				
	GP...-N02-MM				
	GP...-N02-MP				
	GP...-N02-NP				
	GCMX-...				
	SANCAR-...				

First choice | Primeira opção | Primera opción

Alternative | Alternativa

Toolholder Insert Size	GPNC	GPLC	GPRC	BLST	BLS
					
GP02...	✓	✓	✓		
GP03...	✓	✓	✓		
GP04...	✓	✓	✓		
GP05...		✓	✓		
GP06...		✓	✓		
GCMX-...				✓	
SANCAR-...					✓

GP INSERTS CODE KEY

Chave de codificação para pastilhas GP | Llave de codificación para plaquitas GP

For R or L Insert type

GP	0300	B	020	-	050	R	02	-	MC
1	2	3	4		5	6	7		8

For N Insert type

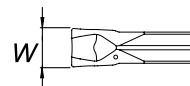
GP	0300	B	020	-	N	02	-	MC
1	2	3	4		6	7		8

1 - Product Line

GP - Grooving Plus

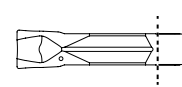
2 - Cutting Width

0200 - 2,00mm | 0300 - 3,00mm | 0400 - 4,00mm | 0500 - 5,00mm | 0600 - 6,00mm



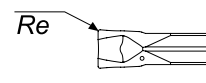
3 - Seat Size

A - 1,60mm | B - 2,30mm | C - 3,30mm | D - 4,30mm | E - 4,90mm | F - 6,60mm

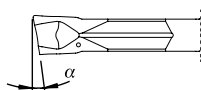


4 - Cutting Radius

020 - 0,20mm | 025 - 0,25mm | 040 - 0,40mm | 600 - 6,00mm

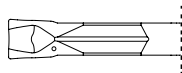


5 - Relief Angle

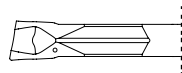


6 - Insert Type

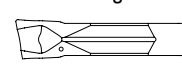
N - Neutral



L - Left

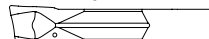


R - Right

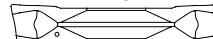


7 - N° of Cutting Edges

01



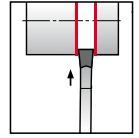
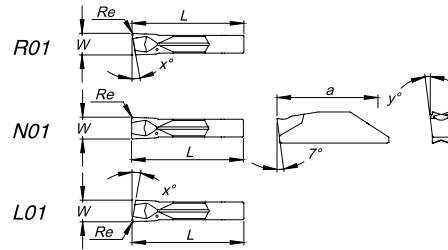
02



8 - Chipbreaker

MC - Medium Cut Off | MG - Medium Grooving | MM - Medium Multi Function | MP - Medium Profiling | NP - Non-Ferrous Profiling

GP...01-MC | Medium Cut Off



		P			M			K				N	S	Dimensions (mm)							Cutting Conditions		
		CVD-MT		PVD	CVD-MT		PVD	UNC	CVD-MT		UNC	PVD											
		L8	N2	G4	L8	N2	G4	25	L5	L6	N2	10	G4										
(1) Geometry code	ISO/ANSI Reference	PH5125	PH5135	PH7920	PH5125	PH5135	PH7920	PH0705	PH5705	PH5320	PH5135	PH0910	PH7920	W	Re	L	x°	a ¹	y°	Seat ² Size	f _n (mm/r)	Min	Max
1130422	GP0200A020-N01-MC													2,0	0,2	20,2	-	-	6,0	A	0,06	0,05	0,10
1130423	GP0300B020-N01-MC													3,0	0,2	20,1	-	-	8,0	B	0,08	0,05	0,15
1130424	GP0400C020-N01-MC													4,0	0,2	20,5	-	-	7,0	C	0,13	0,05	0,25
1130425	GP0200A020-050R01-MC													2,0	0,2	20,2	5,0	-	6,0	A	0,05	0,04	0,08
1130426	GP0300B020-050R01-MC													3,0	0,2	20,1	5,0	-	8,0	B	0,07	0,04	0,12
1130427	GP0400C020-050R01-MC													4,0	0,2	20,5	5,0	-	7,0	C	0,10	0,04	0,20
1130428	GP0200A020-050L01-MC													2,0	0,2	20,2	5,0	-	6,0	A	0,05	0,04	0,08
1130429	GP0300B020-050L01-MC													3,0	0,2	20,1	5,0	-	8,0	B	0,07	0,04	0,12
1130430	GP0400C020-050L01-MC													4,0	0,2	20,5	5,0	-	7,0	C	0,10	0,04	0,20

First choice | Primeira opção | 1ª opción

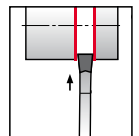
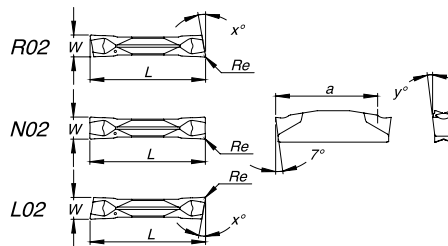
Stock item | Produto de stock | Itens de stock

Available under request | Disponível sobre consulta
Disponible bajo consulta

Insert order code = (1) Geometry Code + (2) Grade Code

1 - When using inserts with 1 Cutting edge, the "a" measure is given by the Toolholder | 2 - Correspond to a Specific Holder

GP...02-MC | Medium Cut Off



		P			M			K				N	S	Dimensions (mm)							Cutting Conditions		
		CVD-MT		PVD	CVD-MT		PVD	UNC	CVD-MT		UNC	PVD											
		L8	N2	G4	L8	N2	G4	25	L5	L6	N2	10	G4										
(1) Geometry code	ISO/ANSI Reference	PH5125	PH5135	PH7920	PH5125	PH5135	PH7920	PH0705	PH5705	PH5320	PH5135	PH0910	PH7920	W	Re	L	x°	a	y°	Seat ² Size	fn (mm/r)	Min	Max
1130383	GP0200A020-N02-MC													2,0	0,2	20,5	-	18,5	6,0	A	0,06	0,05	0,10
1130384	GP0300B020-N02-MC													3,0	0,2	20,4	-	18,5	8,0	B	0,08	0,05	0,15
1130397	GP0400C020-N02-MC													4,0	0,2	21,0	-	18,5	7,0	C	0,13	0,05	0,25
1130416	GP0200A020-050R02-MC													2,0	0,2	20,5	5,0	18,5	6,0	A	0,05	0,04	0,08
1130417	GP0300B020-050R02-MC													3,0	0,2	20,4	5,0	18,5	8,0	B	0,07	0,04	0,12
1130418	GP0400C020-050R02-MC													4,0	0,2	21,0	5,0	18,5	7,0	C	0,10	0,04	0,20
1130419	GP0200A020-050L02-MC													2,0	0,2	20,5	5,0	18,5	6,0	A	0,05	0,04	0,08
1130420	GP0300B020-050L02-MC													3,0	0,2	20,4	5,0	18,5	8,0	B	0,07	0,04	0,12
1130421	GP0400C020-050L02-MC													4,0	0,2	21,0	5,0	18,5	7,0	C	0,10	0,04	0,20

First choice | Primeira opção | 1ª opción

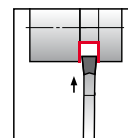
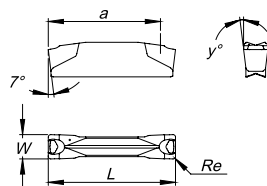
Stock item | Produto de stock | Itens de stock

Available under request | Disponível sobre consulta
Disponible bajo consulta

Insert order code = (1) Geometry Code + (2) Grade Code

2 - Correspond to a Specific Holder

GP...02-MG | Medium Grooving



		P			M			K				N	S	Dimensions (mm)							Cutting Conditions		
		CVD-MT		PVD	CVD-MT		PVD	UNC	CVD-MT		UNC	PVD											
		L8	N2	G4	L8	N2	G4	25	L5	L6	N2	10	G4										
(1) Geometry code	ISO/ANSI Reference	PH5125	PH5135	PH7920	PH5125	PH5135	PH7920	PH0705	PH5705	PH5320	PH5135	PH0910	PH7920	W	Re	L	x°	a	y°	Seat² Size	f _n (mm/r)	Min	Max
1130398	GP0300B020-N02-MG													3,0	0,2	21,0	-	18,5	6,5	B	0,06	0,05	0,10
1130399	GP0400C040-N02-MG													4,0	0,4	21,0	-	18,5	6,5	C	0,08	0,05	0,15
1130400	GP0500D040-N02-MG													5,0	0,4	21,0	-	18,5	6,0	D	0,13	0,05	0,25

Ⓢ First choice | Primeira opção | 1ª opción

Ⓢ Stock item | Produto de stock | Itens de stock

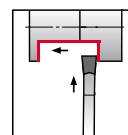
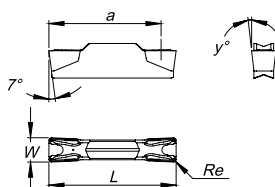
○ Available under request | Disponível sobre consulta
Disponível bajo consulta

Insert order code = (1) Geometry Code + (2) Grade Code

In some positions new grade PH7920, will be available when PH7325 stock ends.

2 - Correspond to a Specific Holder

GP...02-MM | Medium Multi Function



		P			M			K				N	S	Dimensions (mm)								Cutting Conditions					
		CVD-MT		PVD	CVD-MT		PVD	UNC	CVD-MT			UNC	PVD														
		L8	N2	G4	L8	N2	G4	25	L5	L6	N2	10	G4														
⁽¹⁾ Geometry code	ISO/ANSI Reference	PH5125	PH5135	PH7920	PH5125	PH5135	PH7920	PH0705	PH5705	PH5320	PH5135	PH0910	PH7920	W	Re	L	α°	a ¹	γ°	Seat ² Size	Ap (mm)	Min	Max	f _n (mm/r)	Min	Max	
1130401	GP0300B040-N02-MM													3,0	0,4	21,0	-	18,5	6,0	B	0,8	0,4	1,5	0,09	0,05	0,12	
1130402	GP0400C040-N02-MM													4,0	0,4	21,0	-	18,5	6,0	C	1,1	0,6	2,0	0,12	0,07	0,15	
1130403	GP0500D040-N02-MM													5,0	0,4	21,0	-	18,5	5,5	D	1,5	0,8	2,5	0,14	0,10	0,18	

Ⓢ First choice | Primeira opção | 1ª opción

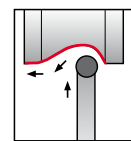
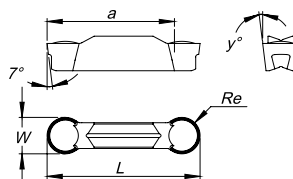
Ⓢ Stock item | Produto de stock | Itens de stock

○ Available under request | Disponível sobre consulta
Disponível bajo consulta

Insert order code = (1) Geometry Code + (2) Grade Code

1 - When using inserts with 1 Cutting edge, the "a" measure is given by the Toolholder | 2 - Correspond to a Specific Holder

GP...02-MP | Medium Profiling



		P			M			K			N	S	Dimensions (mm)							Cutting Conditions						
		CVD-MT		PVD	CVD-MT		PVD	UNC	CVD-MT		UNC	PVD														
		L8	N2	G4	L8	N2	G4	25	L5	L6	N2	10													G4	
⁽¹⁾																										
Geometry code	ISO/ANSI Reference	PH5125	PH5135	PH7920	PH5125	PH5135	PH7920	PH0705	PH5705	PH5320	PH5135	PH0910	PH7920	W	Re	L	x°	a	y°	Seat ² Size	Ap (mm)	Min	Max	fn (mm/r)	Min	Max
1130404	GP0600E300-N02-MP													6,0	3,0	25,2	-	21,0	7,0	E	1,50	0,04	2,20	0,18	0,15	0,22

Ⓢ First choice | Primeira opção | 1ª opción

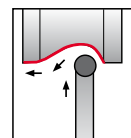
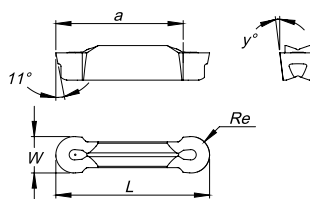
Ⓢ Stock item | Produto de stock | Itens de stock

○ Available under request | Disponível sobre consulta
Disponibile bajo consulta

Insert order code = (1) Geometry Code + (2) Grade Code

2 - Correspond to a Specific Holder

GP...02-NP | Non-Ferrous Profiling



		P			M			K			N	S	Dimensions (mm)							Cutting Conditions						
		CVD-MT		PVD	CVD-MT		PVD	UNC	CVD-MT		UNC	PVD														
		⁽²⁾ Grade code		L8	N2	G4	L8	N2	G4	25	L5	L6	N2	10	G4											
⁽¹⁾ Geometry code	ISO/ANSI Reference	PH5125	PH5135	PH7920	PH5125	PH5135	PH7920	PH0705	PH5705	PH5320	PH5135	PH0910	PH7920	W	Re	L	x°	a	y°	Seat ² Size	Ap (mm)	Min	Max	fn (mm/r)	Min	Max
1130405	GP0600E300-N02-NP													6,0	3,0	25,4	-	18,5	7,0	E	1,30	0,50	2,50	0,20	0,15	0,25

Ⓢ First choice | Primeira opção | 1ª opción

Ⓢ Stock item | Produto de stock | Itens de stock

○ Available under request | Disponível sobre consulta
Disponibile bajo consulta

Insert order code = (1) Geometry Code + (2) Grade Code

2 - Correspond to a Specific Holder

BLADES & TOOLHOLDERS CODE KEY

Chave de codificação para lâminas | Llave de codificación de lamas

For Blades

GP	N	C	-	080	25	.A	.0
1	2	3		5	6	7	8

For Toolholders

GP	R	C	-	100	010	25.25	.A	.1
1	2	3		4	5	6	7	8

1 - Product Line

GP - Grooving Plus

2 - Work Side

R - Right



N - Neutral



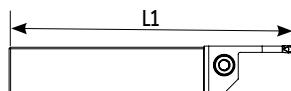
L - Left



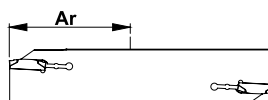
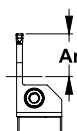
3 - Tool Type

C - Frontal

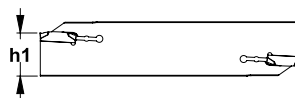
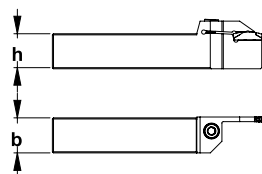
4 - Total toolholder length



5 - Maximum Depth of Cut

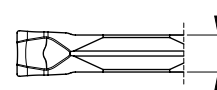


6 - Shaft | Cutting Unit Dimension



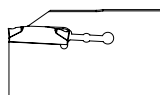
7 - Seat Size

A - 1,60mm | B - 2,30mm | C - 3,30mm | D - 4,30mm | E - 4,00mm | F - 6,60mm

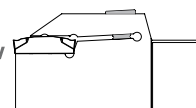


8 - Clamping System

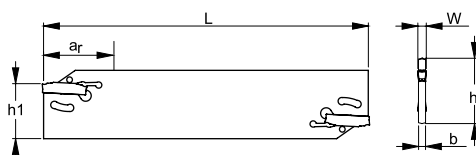
0 - Spring



1 - Screw



GPNC



Order separately

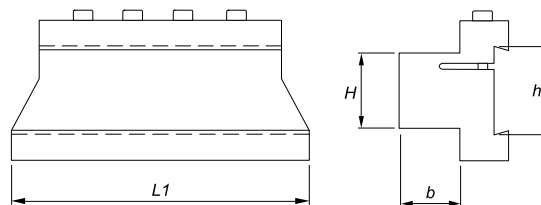
Order code Código	Reference Referência Referencia	Dimensions Dimensões Dimensiones (mm)							Insert	Toolholder		Wrench*	Stock
		ar	L1	h	h1	b	W	Seat Size		CPTS	DPTS		
213010000	GPNC-020 25.A.0	20	150	32	25,0	1,5	2	A	GP02...	CPTS 32...	DPTS 32...	LE25-30	⊗
213009900	GPNC-055 25.B.0	55	150	32	25,0	2,3	3	B	GP03...	CPTS 32...	DPTS 32...	LE25-30	⊗
213009700	GPNC-055 25.C.0	55	150	32	25,0	2,3	4	C	GP04...	CPTS 32...	DPTS 32...	LE25-30	⊗

⊗ Stock item | Produto de stock | Itens de stock ○ Available under request | Disponível sobre consulta | Disponible bajo consulta

*Note: Wrench must be ordered separately

Note: For inserts with 2 cutting edges, the ar is defined by the insert

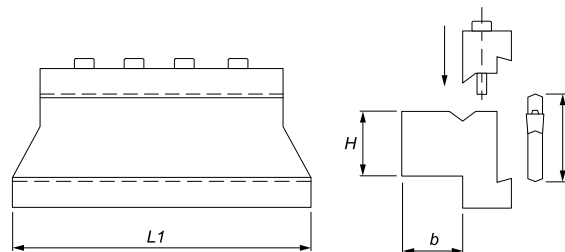
CPTS



Order code Código	Reference Referência Referencia	Dimensions Dimensões Dimensiones (mm)				Kg	Screw	Wrench	Stock
		h	L1	H	b				
290006200	CPTS 3220	32	100	20	20	0,700	D0603600	SS50	⊗
290005000	CPTS 3225	32	110	25	25	0,950	D0603600	SS50	⊗
290006300	CPTS 3232	32	120	32	32	1,400	D0603600	SS50	⊗

⊗ Stock item | Produto de stock | Itens de stock ○ Available under request | Disponível sobre consulta | Disponible bajo consulta

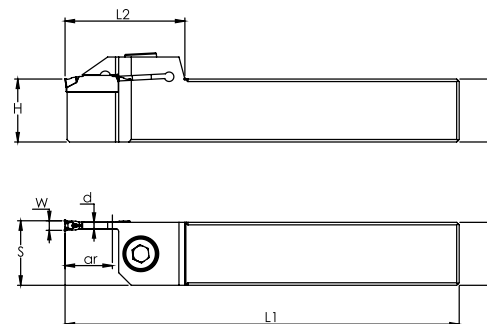
DPTS



Order code Código	Reference Referência Referencia	Dimensions Dimensões Dimensiones (mm)				Kg	Screw	Wrench	Stock
		h	L1	H	b				
290073600	DPTS 3220	32	100	20	20	0,750	D0603600	SS50	⊗
290073700	DPTS 3225	32	110	25	25	1,00	D0603600	SS50	⊗
290073800	DPTS 3232	32	120	32	32	1,450	D0603600	SS50	⊗

⊗ Stock item | Produto de stock | Itens de stock ○ Available under request | Disponível sobre consulta | Disponible bajo consulta

GPLC



Order code Código	Reference Referência Referencia	Dimensions Dimensões Dimensiones (mm)									Seat Size	Insert	Screw	Wrench	Stock
		ar	L1	h	b	H	L2	S	d	W					
213020800	GPLC-100 010 16.16.A.1	10	100	16	16	16	30	16,25	1,5	2	A	GP02...	D0602200	SS50	○
213020900	GPLC-100 015 16.16.A.1	15	100	16	16	16	38	16,25	1,5	2		GP02...	D0602200	SS50	⊗
213021000	GPLC-125 010 20.20.A.1	10	125	20	20	20	32	20,25	1,5	2		GP02...	D0602200	SS50	○
213021100	GPLC-125 015 20.20.A.1	15	125	20	20	20	38	20,25	1,5	2		GP02...	D0602200	SS50	⊗
213021200	GPLC-150 010 25.25.A.1	10	150	25	25	25	34	25,25	1,5	2		GP02...	D0602200	SS50	⊗
213021300	GPLC-150 020 25.25.A.1	20	150	25	25	25	42	25,25	1,5	2		GP02...	D0602200	SS50	⊗
213021400	GPLC-100 010 16.16.B.1	10	100	16	16	16	30	16,5	2	3	B	GP03...	D0602200	SS50	○
213021500	GPLC-100 015 16.16.B.1	15	100	16	16	16	38	16,5	2	3		GP03...	D0602200	SS50	⊗
213021600	GPLC-125 010 20.20.B.1	10	125	20	20	20	32	20,5	2	3		GP03...	D0602200	SS50	○
213021700	GPLC-125 015 20.20.B.1	15	125	20	20	20	38	20,5	2	3		GP03...	D0602200	SS50	⊗
213021800	GPLC-150 010 25.25.B.1	10	150	25	25	25	34	25,5	2	3		GP03...	D0602200	SS50	⊗
213021900	GPLC-150 020 25.25.B.1	20	150	25	25	25	42	25,5	2	3		GP03...	D0602200	SS50	⊗
213022000	GPLC-125 013 20.20.C.1	13	125	20	20	20	32	20,5	3	4	C	GP04...	D0602200	SS50	○
213022100	GPLC-125 019 20.20.C.1	19	125	20	20	20	38	20,5	3	4		GP04...	D0602200	SS50	⊗
213022200	GPLC-150 013 25.25.C.1	13	150	25	25	25	34	25,5	3	4		GP04...	D0602200	SS50	⊗
213022300	GPLC-150 023 25.25.C.1	23	150	25	25	25	42	25,5	3	4		GP04...	D0602200	SS50	⊗
213022400	GPLC-125 013 20.20.D.1	13	125	20	20	20	32	20,5	4	5	D	GP05...	D0602200	SS50	○
213022500	GPLC-125 019 20.20.D.1	19	125	20	20	20	38	20,5	4	5		GP05...	D0602200	SS50	⊗
213022600	GPLC-150 013 25.25.D.1	13	150	25	25	25	34	25,5	4	5		GP05...	D0602200	SS50	⊗
213022700	GPLC-150 023 25.25.D.1	23	150	25	25	25	42	25,5	4	5		GP05...	D0602200	SS50	⊗
213022800	GPLC-150 015 25.25.E.1	15	150	25	25	25	34	26	4	6	E	GP06...	D0602200	SS50	⊗
213022900	GPLC-150 023 25.25.E.1	23	150	25	25	25	42	26	4	6		GP06...	D0602200	SS50	⊗

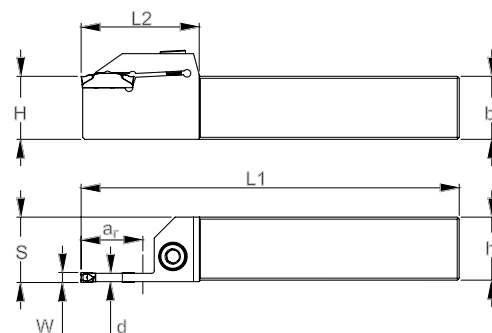
⊗ Stock item | Produto de stock | Itens de stock

○ Available under request | Disponível sobre consulta | Disponible bajo consulta

Note: For inserts with 2 cutting edges, the ar is defined by the insert

GP02... GP03... GP04... GP05...				GP06...	
					
MC				MP	NP
Seat Size A, B, C, D				Seat Size E	

GPRC



Order code Código	Reference Referência Referencia	Dimensions Dimensões Dimensiones (mm)									Seat Size	Insert	Screw	Wrench	Stock
		ar	L1	h	b	H	L2	S	d	W					
213018400	GPRC-100 010 16.16.A.1	10	100	16	16	16	30	16,25	1,5	2	A	GP02...	D0602200	SS50	○
213018500	GPRC-100 015 16.16.A.1	15	100	16	16	16	38	16,25	1,5	2		GP02...	D0602200	SS50	⊗
213018600	GPRC-125 010 20.20.A.1	10	125	20	20	20	32	20,25	1,5	2		GP02...	D0602200	SS50	○
213018700	GPRC-125 015 20.20.A.1	15	125	20	20	20	38	20,25	1,5	2		GP02...	D0602200	SS50	⊗
213018800	GPRC-150 010 25.25.A.1	10	150	25	25	25	34	25,25	1,5	2		GP02...	D0602200	SS50	⊗
213018900	GPRC-150 020 25.25.A.1	20	150	25	25	25	42	25,25	1,5	2		GP02...	D0602200	SS50	⊗
213019000	GPRC-100 010 16.16.B.1	10	100	16	16	16	30	16,50	2,0	3	B	GP03...	D0602200	SS50	○
213019100	GPRC-100 015 16.16.B.1	15	100	16	16	16	38	16,50	2,0	3		GP03...	D0602200	SS50	⊗
213019200	GPRC-125 010 20.20.B.1	10	125	20	20	20	32	20,50	2,0	3		GP03...	D0602200	SS50	○
213019300	GPRC-125 015 20.20.B.1	15	125	20	20	20	38	20,50	2,0	3		GP03...	D0602200	SS50	⊗
213019400	GPRC-150 010 25.25.B.1	10	150	25	25	25	34	25,50	2,0	3		GP03...	D0602200	SS50	⊗
213019500	GPRC-150 020 25.25.B.1	20	150	25	25	25	42	25,50	2,0	3		GP03...	D0602200	SS50	⊗
213019600	GPRC-125 013 20.20.C.1	13	125	20	20	20	32	20,50	3,0	4	C	GP04...	D0602200	SS50	○
213019700	GPRC-125 019 20.20.C.1	19	125	20	20	20	38	20,50	3,0	4		GP04...	D0602200	SS50	⊗
213019800	GPRC-150 013 25.25.C.1	13	150	25	25	25	34	25,50	3,0	4		GP04...	D0602200	SS50	⊗
213019900	GPRC-150 023 25.25.C.1	23	150	25	25	25	42	25,50	3,0	4		GP04...	D0602200	SS50	⊗
213020000	GPRC-125 013 20.20.D.1	13	125	20	20	20	32	20,50	4,0	5	D	GP05...	D0602200	SS50	○
213020100	GPRC-125 019 20.20.D.1	19	125	20	20	20	38	20,50	4,0	5		GP05...	D0602200	SS50	⊗
213020200	GPRC-150 013 25.25.D.1	13	150	25	25	25	34	25,50	4,0	5		GP05...	D0602200	SS50	⊗
213020300	GPRC-150 023 25.25.D.1	23	150	25	25	25	42	25,50	4,0	5		GP05...	D0602200	SS50	⊗
213020400	GPRC-150 015 25.25.E.1	15	150	25	25	25	34	26,00	4,0	6	E	GP06...	D0602200	SS50	⊗
213020500	GPRC-150 023 25.25.E.1	23	150	25	25	25	42	26,00	4,0	6		GP06...	D0602200	SS50	⊗

⊗ Stock item | Produto de stock | Itens de stock ○ Available under request | Disponível sobre consulta | Disponible bajo consulta

Note: For inserts with 2 cutting edges, the ar is defined by the insert

GP02... GP03... GP04... GP05...				GP06...	
					
MC				MP	NP
Seat Size A, B, C, D				Seat Size E	

GCMX & SANCAR INSERTS CODE KEY

Chave de codificação para pastilhas | Llave de codificación para plaquitas

For GCMX Inserts

GCMX
1

-

3
2

R
3

15
4

For SANCAR Inserts

SANCAR
1

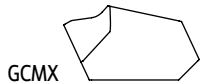
-

3
2

R
3

5
4

1 - Product Line



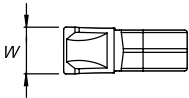
GCMX



SANCAR

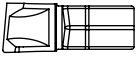
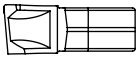
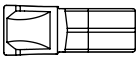
2 - Cutting Width

2mm | 2,4mm | 3mm | 4mm | 4,8mm | 5mm | 6mm



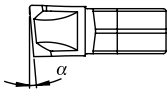
3 - Inserts Type

N - Neutral | R - Right | L - Left



4 - Relief Angle

4 - 4° | 5 - 5° | 8 - 8° | 15 - 15°



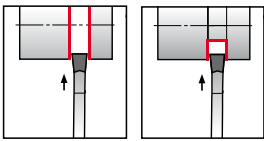
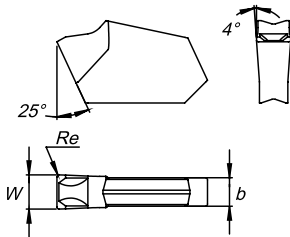
INSERTS OVERVIEW | Visão geral | Visión general

Operation Insert Type + Chipbreaker		Parting Off	General Grooving	Turning	Profiling
	GCMX-...				
	SANCAR-...				

First choice | Primeira opção | Primera opción

Alternative | Alternativa

GCMX-N

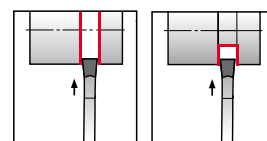
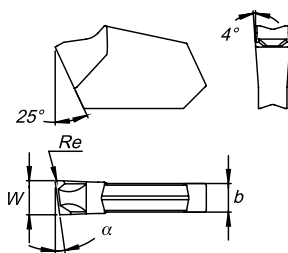


			P		M		K		Dimensions (mm)				Cutting Conditions		
			CVD-MT		CVD-MT		CVD-MT								
	⁽²⁾ Grade code		L7	N2	L7	N2	L6	N2							
⁽¹⁾ Geometry code	ISO Reference	ANSI Reference	PH5115	PH5135	PH5115	PH5135	PH5320	PH5135	W	b	Re	α	f _n (mm/r)	Min	Max
1130165	GCMX-2N	GTN-2N							2,2	1,8	0,16	-	0,08	0,05	0,16
1130228	GCMX-2.4N	GTN-2.4N							2,4	2,0	0,16	-	0,10	0,06	0,18
1130169	GCMX-3N	GTN-3N							3,1	2,6	0,20	-	0,15	0,10	0,25
1130174	GCMX-4N	GTN-4N							4,1	3,5	0,25	-	0,18	0,10	0,30
1130229	GCMX-4.8N	GTN-4.8N							4,8	4,2	0,28	-	0,20	0,12	0,35
1130175	GCMX-5N	GTN-5N							5,1	4,5	0,28	-	0,20	0,12	0,35
1130176	GCMX-6N	GTN-6N							6,4	5,5	0,35	-	0,25	0,15	0,40
1130449	GCMX-8N	GTN-8N							8,0	7,1	0,40	-	0,28	0,17	0,45

Ⓢ First choice | Primeira opção | 1ª opción
Ⓢ Stock item | Produto de stock | Ítems de stock
○ Available under request | Disponível sobre consulta
Disponible bajo consulta
Insert order code = (1) Geometry Code + (2) Grade Code

INSERTS

GCMX-R



			P		M		K		Dimensions (mm)				Cutting Conditions		
			CVD-MT		CVD-MT		CVD-MT								
	⁽²⁾ Grade code		L7	N2	L7	N2	L6	N2							
⁽¹⁾ Geometry code	ISO Reference	ANSI Reference	PH5115	PH5135	PH5115	PH5135	PH5320	PH5135	W	b	Re	α	f _n (mm/r)	Min	Max
1130166	GCMX-2R 4	GTN-2R 4	○	○	○	○	○	○	2,2	1,8	0,16	4	0,07	0,04	0,13
1130167	GCMX-2R 8	GTN-2R 8	○	○	○	○	○	○	2,2	1,8	0,16	8	0,06	0,04	0,11
1130255	GCMX-2R 15	GTN-2R 15	○	○	○	○	○	○	2,2	1,8	0,16	15	0,06	0,04	0,09
1130257	GCMX-2.4R 4	GTN-2.4R 4	○	○	○	○	○	○	2,4	2,0	0,16	4	0,08	0,04	0,14
1130233	GCMX-2.4R 8	GTN-2.4R 8	○	○	○	○	○	○	2,4	2,0	0,16	8	0,07	0,04	0,12
1130258	GCMX-2.4R 15	GTN-2.4R 15	○	○	○	○	○	○	2,4	2,0	0,16	15	0,06	0,04	0,10
1130170	GCMX-3R 4	GTN-3R 4	○	○	○	○	○	○	3,1	2,6	0,20	4	0,08	0,05	0,15
1130171	GCMX-3R 8	GTN-3R 8	○	○	○	○	○	○	3,1	2,6	0,20	8	0,07	0,05	0,12
1130253	GCMX-3R 15	GTN-3R 15	○	○	○	○	○	○	3,1	2,6	0,20	15	0,06	0,05	0,10
1130261	GCMX-4R 4	GTN-4R 4	○	○	○	○	○	○	4,1	3,5	0,25	4	0,12	0,08	0,20
1130222	GCMX-4R 8	GTN-4R 8	○	○	○	○	○	○	4,1	3,5	0,25	8	0,10	0,08	0,12
1130262	GCMX-4R 15	GTN-4R 15	○	○	○	○	○	○	4,1	3,5	0,25	15	0,10	0,08	0,12
1130264	GCMX-4.8R 4	GTN-4.8R 4	○	○	○	○	○	○	4,8	4,2	0,28	4	0,18	0,10	0,25
1130230	GCMX-4.8R 8	GTN-4.8R 8	○	○	○	○	○	○	4,8	4,2	0,28	8	0,13	0,10	0,18
1130265	GCMX-4.8R 15	GTN-4.8R 15	○	○	○	○	○	○	4,8	4,2	0,28	15	0,12	0,09	0,15
1130268	GCMX-5R 4	GTN-5R 4	○	○	○	○	○	○	5,1	4,5	0,28	4	0,18	0,10	0,25
1130224	GCMX-5R 8	GTN-5R 8	○	○	○	○	○	○	5,1	4,5	0,28	8	0,13	0,10	0,18
1130269	GCMX-5R 15	GTN-5R 15	○	○	○	○	○	○	5,1	4,5	0,28	15	0,12	0,09	0,15
1130272	GCMX-6R 4	GTN-6R 4	○	○	○	○	○	○	6,4	5,5	0,35	4	0,20	0,10	0,30
1130227	GCMX-6R 8	GTN-6R 8	○	○	○	○	○	○	6,4	5,5	0,35	8	0,17	0,12	0,20
1130276	GCMX-6R 15	GTN-6R 15	○	○	○	○	○	○	6,4	5,5	0,35	15	0,14	0,10	0,18

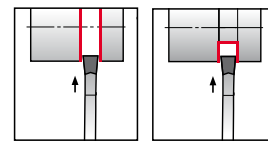
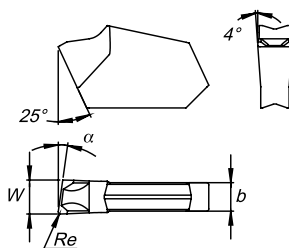
First choice | Primeira opção | 1ª opción

Stock item | Produto de stock | Itens de stock

Available under request | Disponível sobre consulta
Disponible bajo consulta

Insert order code = (1) Geometry Code + (2) Grade Code

GCMX-L



			P		M		K		Dimensions (mm)				Cutting Conditions		
			CVD-MT		CVD-MT		CVD-MT								
	⁽²⁾ Grade code		L7	N2	L7	N2	L6	N2							
⁽¹⁾ Geometry code	ISO Reference	ANSI Reference	PH5115	PH5135	PH5115	PH5135	PH5320	PH5135	W	b	Re	α	f _n (mm/r)	Min	Max
1130164	GCMX-2L 4	GTN-2L 4	○	○	○	○	○	○	2,2	1,8	0,16	4	0,07	0,04	0,13
1130220	GCMX-2L 8	GTN-2L 8	○	○	○	○	○	○	2,2	1,8	0,16	8	0,06	0,04	0,11
1130256	GCMX-2L 15	GTN-2L 15	○	○	○	○	○	○	2,2	1,8	0,16	15	0,06	0,04	0,09
1130259	GCMX-2.4L 4	GTN-2.4L 4	○	○	○	○	○	○	2,4	2,0	0,16	4	0,08	0,04	0,14
1130232	GCMX-2.4L 8	GTN-2.4L 8	○	○	○	○	○	○	2,4	2,0	0,16	8	0,07	0,04	0,12
1130260	GCMX-2.4L 15	GTN-2.4L 15	○	○	○	○	○	○	2,4	2,0	0,16	15	0,06	0,04	0,10
1130221	GCMX-3L 4	GTN-3L 4	○	○	○	○	○	○	3,1	2,6	0,20	4	0,08	0,05	0,15
1130168	GCMX-3L 8	GTN-3L 8	○	○	○	○	○	○	3,1	2,6	0,20	8	0,07	0,05	0,12
1130254	GCMX-3L 15	GTN-3L 15	○	○	○	○	○	○	3,1	2,6	0,20	15	0,06	0,05	0,10
1130173	GCMX-4L 4	GTN-4L 4	○	○	○	○	○	○	4,1	3,5	0,25	4	0,12	0,08	0,20
1130223	GCMX-4L 8	GTN-4L 8	○	○	○	○	○	○	4,1	3,5	0,25	8	0,10	0,08	0,12
1130263	GCMX-4L 15	GTN-4L 15	○	○	○	○	○	○	4,1	3,5	0,25	15	0,10	0,08	0,12
1130266	GCMX-4.8L 4	GTN-4.8L 4	○	○	○	○	○	○	4,8	4,2	0,28	4	0,18	0,10	0,25
1130231	GCMX-4.8L 8	GTN-4.8L 8	○	○	○	○	○	○	4,8	4,2	0,28	8	0,13	0,10	0,18
1130267	GCMX-4.8L 15	GTN-4.8L 15	○	○	○	○	○	○	4,8	4,2	0,28	15	0,12	0,09	0,15
1130270	GCMX-5L 4	GTN-5L 4	○	○	○	○	○	○	5,1	4,5	0,28	4	0,18	0,10	0,25
1130225	GCMX-5L 8	GTN-5L 8	○	○	○	○	○	○	5,1	4,5	0,28	8	0,13	0,10	0,18
1130271	GCMX-5L 15	GTN-5L 15	○	○	○	○	○	○	5,1	4,5	0,28	15	0,12	0,09	0,15
1130274	GCMX-6L 4	GTN-6L 4	○	○	○	○	○	○	6,4	5,5	0,35	4	0,20	0,10	0,30
1130226	GCMX-6L 8	GTN-6L 8	○	○	○	○	○	○	6,4	5,5	0,35	8	0,17	0,12	0,20
1130275	GCMX-6L 15	GTN-6L 15	○	○	○	○	○	○	6,4	5,5	0,35	15	0,14	0,10	0,18

First choice | Primeira opção | 1ª opción

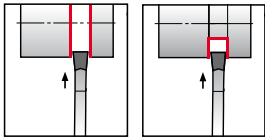
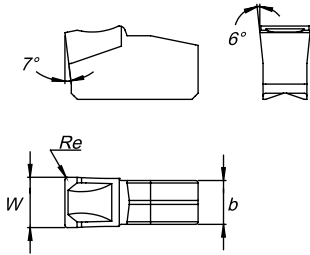
Stock item | Produto de stock | Itens de stock

Available under request | Disponível sobre consulta
Disponible bajo consulta

Insert order code = (1) Geometry Code + (2) Grade Code

INSERTS

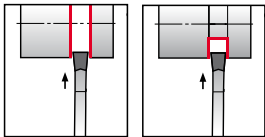
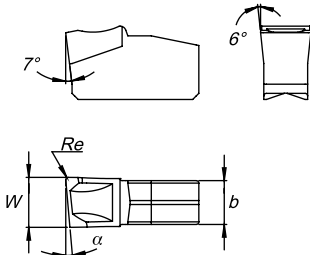
SANCAR-N



			P		M		K		Dimensions (mm)				Cutting Conditions		
			CVD-MT		CVD-MT		CVD-MT								
			L7	N2	L7	N2	L6	N2							
⁽¹⁾ Geometry code	ISO Reference	ANSI Reference	PH5115	PH5135	PH5115	PH5135	PH5320	PH5135	W	b	Re	α	f _n (mm/r)	Min	Max
1130186	SANCAR-3N	SANCAR-3N							3,0	2,5	0,25	-	0,13	0,05	0,25
1130187	SANCAR-4N	SANCAR-4N							4,0	3,3	0,25	-	0,18	0,10	0,30
1130189	SANCAR-5N	SANCAR-5N							5,0	4,3	0,25	-	0,22	0,10	0,35

Ⓢ First choice | Primeira opção | 1ª opción Ⓢ Stock item | Produto de stock | Itens de stock ○ Available under request | Disponível sobre consulta / Disponible bajo consulta Insert order code = (1) Geometry Code + (2) Grade Code

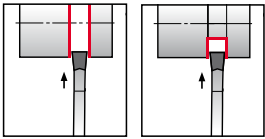
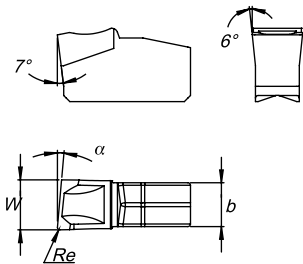
SANCAR-R



			P		M		K		Dimensions (mm)				Cutting Conditions		
			CVD-MT		CVD-MT		CVD-MT								
			L7	N2	L7	N2	L6	N2							
⁽¹⁾ Geometry code	ISO Reference	ANSI Reference	PH5115	PH5135	PH5115	PH5135	PH5320	PH5135	W	b	Re	α	f _n (mm/r)	Min	Max
1130288	SANCAR-3R 5	SANCAR-3R 5	○	○	○	○	○	○	3,0	2,5	0,25	5	0,10	0,05	0,15
1130188	SANCAR-4R 5	SANCAR-4R 5	○	○	○	○	○	○	4,0	3,3	0,25	5	0,12	0,08	0,20
1130388	SANCAR-5R 5	SANCAR-5R 5	○	○	○	○	○	○	5,0	4,3	0,25	5	0,15	0,08	0,25

Ⓢ First choice | Primeira opção | 1ª opción Ⓢ Stock item | Produto de stock | Itens de stock ○ Available under request | Disponível sobre consulta / Disponible bajo consulta Insert order code = (1) Geometry Code + (2) Grade Code

SANCAR-L



			P		M		K		Dimensions (mm)				Cutting Conditions		
			CVD-MT		CVD-MT		CVD-MT								
	⁽²⁾ Grade code		L7	N2	L7	N2	L6	N2							
⁽¹⁾ Geometry code	ISO Reference	ANSI Reference	PH5115	PH5135	PH5115	PH5135	PH5320	PH5135	W	b	Re	α	f _n (mm/r)	Min	Max
1130185	SANCAR-3L 5	SANCAR-3L 5	○	○	○	○	○	○	3,0	2,5	0,25	5	0,10	0,05	0,15
1130390	SANCAR-4L 5	SANCAR-4L 5	○	○	○	○	○	○	4,0	3,3	0,25	5	0,12	0,08	0,20
1130389	SANCAR-5L 5	SANCAL-5L 5	○	○	○	○	○	○	5,0	4,3	0,25	5	0,15	0,08	0,25

First choice | Primeira opção | 1ª opción

Stock item | Produto de stock | Itens de stock

Available under request | Disponível sobre consulta
Disponibile bajo consulta

Insert order code = (1) Geometry Code + (2) Grade Code

BLADES CODE KEY | Chave de codificação para laminas | Llave de codificación de lamas

D

GROOVING & PARTING OFF

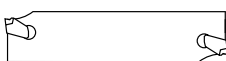


1 - Product Line

BL - Blade

2 - Blade Type

ST - Standard
Blade

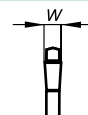


S - SANCAR
Blade



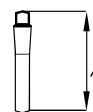
3 - Cutting Width

2mm | 3mm | 4mm | 5mm | 6mm



4 - Maximum Depth of Cut

19 - 19mm | 26 - 26mm | 32 - 32mm



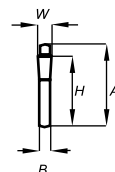
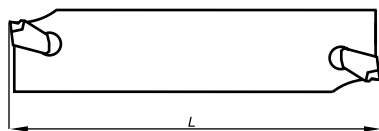
Grooving Plus & Parting Off

Grooving & Parting Off

SAL - Swiss Automatic Lathes

Technical Data

BLST (GCMX)



GCMX...



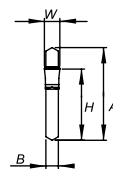
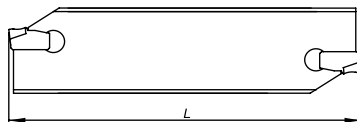
Hand Type
N, R, L

Order code Código	Reference Referência Referencia	Dimensions Dimensões Dimensiones (mm)					Inserts	Toolholder		Wrench	Stock
		A	W	H	B	L		CPTS	DPTS		
213008000	BLST 2-19	19	2	16	1,6	85	GCMX-2...	CPTS 19...	DPTS 19...	LE05	⊗
213008100	BLST 2-26	26	2	21,4	1,6	110	GCMX-2...	CPTS 26...	DPTS 26...	LE05	⊗
213008200	BLST 3-26	26	3	21,4	2,4	110	GCMX-3...	CPTS 26...	DPTS 26...	LE05	⊗
213008300	BLST 4-26	26	4	21,4	3,2	110	GCMX-4...	CPTS 26...	DPTS 26...	LE05	⊗
213008400	BLST 5-26	26	5	21,4	4	110	GCMX-5...	CPTS 26...	DPTS 26...	LE05	⊗
213008500	BLST 6-26	26	6	21,4	5,2	110	GCMX-6...	CPTS 26...	DPTS 26...	LE05	⊗
213008600	BLST 2-32	32	2	25	1,6	150	GCMX-2...	CPTS 32...	DPTS 32...	LE05	⊗
213008700	BLST 3-32	32	3	25	2,4	150	GCMX-3...	CPTS 32...	DPTS 32...	LE05	⊗
213008800	BLST 4-32	32	4	25	3,2	150	GCMX-4...	CPTS 32...	DPTS 32...	LE05	⊗
213008900	BLST 5-32	32	5	25	4	150	GCMX-5...	CPTS 32...	DPTS 32...	LE05	⊗
213009000	BLST 6-32	32	6	25	5,2	150	GCMX-6...	CPTS 32...	DPTS 32...	LE05	⊗

⊗ Stock item | Produto de stock | Itens de stock

○ Available under request | Disponível sobre consulta | Disponible bajo consulta

BLS (SANCAR)



SANCAR...



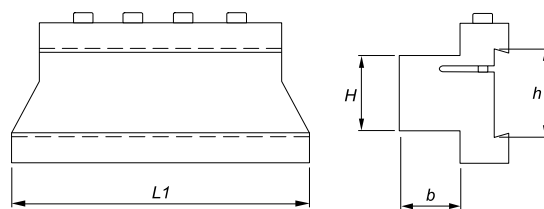
Hand Type
N, R, L

Order code Código	Reference Referência Referencia	Dimensions Dimensões Dimensiones (mm)					Inserts	Toolholder		Wrench	Stock
		A	W	H	B	L		CPTS	DPTS		
213004600	BLS 3-32	32	3	25	2,4	150	SANCAR 3...	CPTS 32...	DPTS 32...	LE05	⊗
213004700	BLS 4-32	32	4	25	3,2	150	SANCAR 4...	CPTS 32...	DPTS 32...	LE05	⊗
213005500	BLS 5-32	32	5	25	4	150	SANCAR 5...	CPTS 32...	DPTS 32...	LE05	⊗

⊗ Stock item | Produto de stock | Itens de stock

○ Available under request | Disponível sobre consulta | Disponible bajo consulta

CPTS

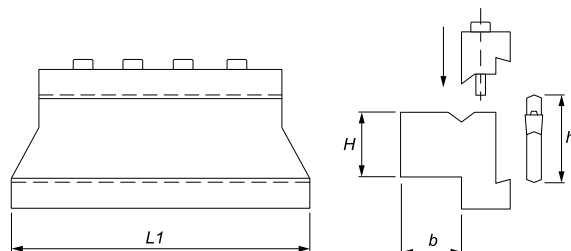


Order code Código	Reference Referência Referencia	Dimensions Dimensões Dimensiones (mm)				Kg	Screw	Wrench	Stock
		h	L1	H	b				
290009300	CPTS 1916	19	76	16	16	0,300	D0503000	SS40	⊗
290008200	CPTS 2616	26	76	16	16	0,450	D0603600	SS50	⊗
290006000	CPTS 2620	26	87	20	20	0,500	D0603600	SS50	⊗
290006100	CPTS 2625	26	87	25	25	0,650	D0603600	SS50	⊗
290006200	CPTS 3220	32	100	20	20	0,700	D0603600	SS50	⊗
290005000	CPTS 3225	32	110	25	25	0,950	D0603600	SS50	⊗
290006300	CPTS 3232	32	120	32	32	1,400	D0603600	SS50	⊗

⊗ Stock item | Produto de stock | Itens de stock

○ Available under request | Disponível sobre consulta | Disponible bajo consulta

DPTS



Order code Código	Reference Referência Referencia	Dimensions Dimensões Dimensiones (mm)				Kg	Screw	Wrench	Stock
		h	L1	H	b				
290045400	DPTS 1916	19	76	16	16	0,250	D0503000	SS40	⊗
290045500	DPTS 2620	26	87	20	20	0,550	D0603600	SS50	⊗
290046600	DPTS 2625	26	87	25	25	0,700	D0603600	SS50	⊗
290073600	DPTS 3220	32	100	20	20	0,750	D0603600	SS50	⊗
290073700	DPTS 3225	32	110	25	25	1,00	D0603600	SS50	⊗
290073800	DPTS 3232	32	120	32	32	1,450	D0603600	SS50	⊗

⊗ Stock item | Produto de stock | Itens de stock

○ Available under request | Disponível sobre consulta | Disponible bajo consulta

TRIGON INSERTS CODE KEY

Chave de codificação para pastilhas | Llave de codificación para plaquitas

For Trigon 60° Inserts

16

-

ER

-

W

-

1.00

1

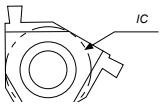
2

3

4

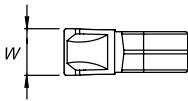
1 - Inscribed Circle

16 - 9,525mm



2 - Insert Type

ER - External Right | IR - Internal Right

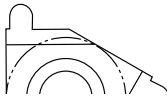


3 - Cutting Edge Type

W - Rectangular

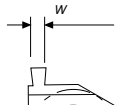


R - Rounded



4 - Cutting Edge Length

0,50 - 0,5mm | 2,25 - 2,25mm



D

GROOVING & PARTING OFF

Grooving Plus & Parting Off

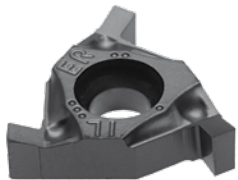
Grooving & Parting Off

SAL - Swiss Automatic Lathes

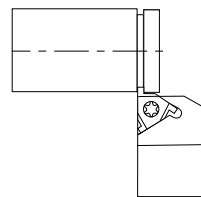
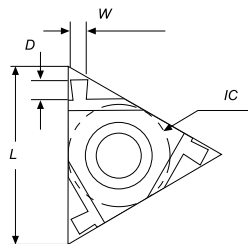
Technical Data

TRIGON INSERTS

FLAT GROOVING



External



Inserts ER = IL

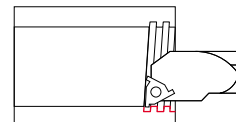
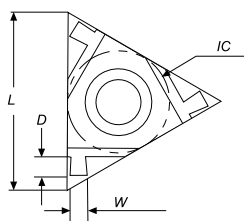
Order code Código	Reference Referência Referencia	Anvil	Dimensions Dimensões Dimensiones (mm)				Stock - Grade Code (2)	
			IC	L	W	D	(68) PH6920	(D0) PH8920
1883721	11 ER W 0.50	-	6,35	11,00	0,50	1,40	○	○
1883722	11 ER W 0.60	-	6,35	11,00	0,60	1,40	○	○
1883723	11 ER W 0.70	-	6,35	11,00	0,70	1,40	○	○
1883724	11 ER W 0.80	-	6,35	11,00	0,80	1,40	○	○
1883725	11 ER W 1.00	-	6,35	11,00	1,00	1,30	○	○
1883726	16 ER W 0.50	EA 16	9,525	16,00	0,50	1,40	○	○
1881125	16 ER W 1.00	EA 16	9,525	16,00	1,00	1,40	⊗	○
1883707	16 ER W 1.20	EA 16	9,525	16,00	1,20	1,60	⊗	○
1883720	16 ER W 1.40	EA 16	9,525	16,00	1,40	1,80	⊗	○
1881129	16 ER W 1.70	EA 16	9,525	16,00	1,70	2,00	⊗	⊗
1883711	16 ER W 1.95	EA 16	9,525	16,00	1,95	2,00	⊗	⊗
1883714	16 ER W 2.25	EA 16	9,525	16,00	2,25	2,25	⊗	⊗

⊗ Stock item | Produto de stock | Itens de stock ○ Available under request | Disponível sobre consulta | Disponible bajo consulta

Note: Select the toolholder "SXAN"



Internal



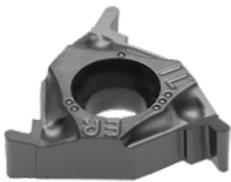
Inserts IR = EL

Order code Código	Reference Referência Referencia	Anvil	Dimensions Dimensões Dimensiones (mm)				Stock - Grade Code (2)	
			IC	L	W	D	(68) PH6920	(D0) PH8920
1881142	11 IR W 0.50	-	6,35	11,00	0,50	1,40	⊗	○
1883727	11 IR W 0.60	-	6,35	11,00	0,60	1,40	○	○
1883728	11 IR W 0.70	-	6,35	11,00	0,70	1,40	○	○
1883729	11 IR W 0.80	-	6,35	11,00	0,80	1,40	○	○
1881144	11 IR W 1.00	-	6,35	11,00	1,00	1,30	⊗	○
1883730	16 IR W 0.50	EA 16	9,525	16,00	0,50	1,40	○	○
1881134	16 IR W 1.00	EA 16	9,525	16,00	1,00	1,40	⊗	○
1883731	16 IR W 1.20	EA 16	9,525	16,00	1,20	1,60	⊗	○
1883712	16 IR W 1.40	EA 16	9,525	16,00	1,40	1,80	⊗	○
1881138	16 IR W 1.70	EA 16	9,525	16,00	1,70	2,00	⊗	○
1883710	16 IR W 1.95	EA 16	9,525	16,00	1,95	2,00	⊗	○
1883713	16 IR W 2.25	EA 16	9,525	16,00	2,25	2,25	⊗	○

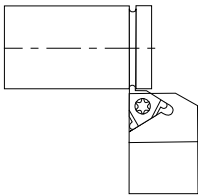
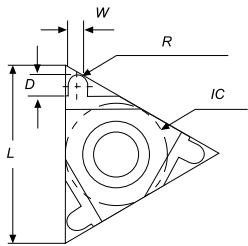
⊗ Stock item | Produto de stock | Itens de stock ○ Available under request | Disponível sobre consulta | Disponible bajo consulta

Note: Select the toolholder "SXFN"

FULL RADIUS GROOVING



External



Inserts ER = IL

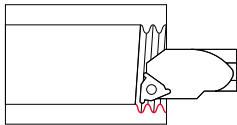
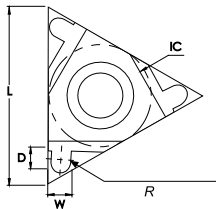
Order code Código	Reference Referência Referencia	Anvil	Dimensions Dimensões Dimensiones (mm)					Stock - Grade Code (2)	
			IC	L	W	R	D	(68) PH6920	(D0) PH8920
1881149	16 ER R 0.50	EA 16	9,525	16	1,00	0,50	1,40	☉	○
1883732	16 ER R 0.60	EA 16	9,525	16	1,20	0,60	1,60	○	○
1883733	16 ER R 0.90	EA 16	9,525	16	1,80	0,90	2,00	○	○
1881151	16 ER R 1.00	EA 16	9,525	16	2,00	1,00	2,00	○	○
1883734	16 ER R 1.10	EA 16	9,525	16	2,20	1,10	2,15	○	○
1883735	16 ER R 1.20	EA 16	9,525	16	2,40	1,20	2,15	○	○

☉ Stock item | Produto de stock | Itens de stock ○ Available under request | Disponível sobre consulta | Disponible bajo consulta

Note: Select the toolholder "SXAN"



Internal



Inserts IR = EL

Order code Código	Reference Referência Referencia	Anvil	Dimensions Dimensões Dimensiones (mm)					Stock - Grade Code (2)	
			IC	L	W	R	D	(68) PH6920	(D0) PH8920
1881145	16 IR R 0.50	EA 16	9,525	16	1,00	0,50	1,40	○	○
1883736	16 IR R 0.60	EA 16	9,525	16	2,00	1,00	1,40	○	○
1883737	16 IR R 0.90	EA 16	9,525	16	2,40	1,20	1,60	○	○
1881147	16 IR R 1.00	EA 16	9,525	16	2,80	1,40	1,80	○	○
1883738	16 IR R 1.10	EA 16	9,525	16	3,40	1,70	2,00	○	○
1883739	16 IR R 1.20	EA 16	9,525	16	3,90	1,95	2,00	○	○

☉ Stock item | Produto de stock | Itens de stock ○ Available under request | Disponível sobre consulta | Disponible bajo consulta

Note: Select the toolholder "SXFN"

EXTERNAL TOOLHOLDERS CODE KEY

Chave de codificação para suporte externos | Llave de codificación para herramienta exterior

S	X	A	N	R	25	25	M	16
1	2	3	4	5	6	7	8	9

1 - Inserts Clamping System				
C	D	M	P	S

2 - Insert Shape			
C	D	E	K
R	S	T	V
X	W		

4 - Inserts Clearance Angle			
B	C	N	P

5 - Tool Hand		
R	L	N

3 - Toolholder Leading Angle		
A	B	C
D	E	F
G	H	J
K	L	M
N	Q	R
S	T	V
X	Z	

6 - Height of Shank (mm)

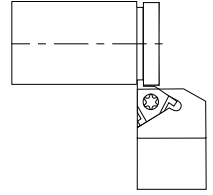
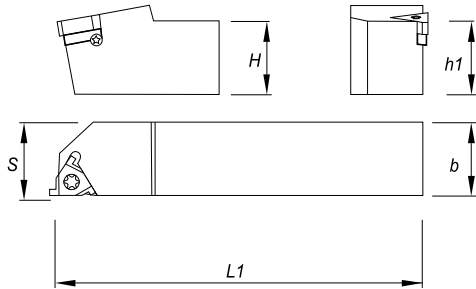
7 - Width of Shank (mm)

8 - Length of Holder (mm)				
	D	60	P	170
	E	70	R	200
	F	80	S	250
	H	100	T	300
	K	125	U	350
	L	140	V	400
	M	150	X	Special

9 - Length of Inserts Cutting Edge (mm)	

EXTERNAL TOOLHOLDER

SXAN



External Left

Order Code Código	Reference Referência Referencia	Insert Geometry	Dimensions Dimensões Dimensiones (mm)				Anvil	Anvil Screw	Insert Screw	Torx Key	Stock
			H=h1	b	S	L					
212244300	SXAN L 0808 H11	11 EL	8	8	11	100	-	-	P0260700	XT08	○
212244400	SXAN L 1010 H11	11 EL	10	10	11	100	-	-	P0260700	XT08	⊗
212384500	SXAN L 1212 K11	11 EL	12	12	12	125	-	-	P0260700	XT08	○
212384600	SXAN L 1212 F16	16 EL	12	12	16	80	IA16	P5000790	P5401390	XT10	○
212123400	SXAN L 1616 H16	16 EL	16	16	16	100	IA16	P5000790	P5401390	XT10	○
212123500	SXAN L 2020 K16	16 EL	20	20	20	125	IA16	P5000790	P5401390	XT10	⊗
212123800	SXAN L 2525 M16	16 EL	25	25	25	150	IA16	P5000790	P5401390	XT10	⊗
212124400	SXAN L 3232 P16	16 EL	32	32	32	170	IA16	P5000790	P5401390	XT10	○

⊗ Stock item | Produto de stock | Itens de stock

○ Available under request | Disponível sobre consulta | Disponible bajo consulta

External Right

Order Code Código	Reference Referência Referencia	Insert Geometry	Dimensions Dimensões Dimensiones (mm)				Anvil	Anvil Screw	Insert Screw	Torx Key	Stock
			H=h1	b	S	L					
212244700	SXAN R 0808 H11	11 ER	8	8	10	100	-	-	P0260700	XT08	○
212244800	SXAN R 1010 H11	11 ER	10	10	10	100	-	-	P0260700	XT08	⊗
212384900	SXAN R 1212 K11	11 ER	12	12	12	125	-	-	P0260700	XT08	○
212383800	SXAN R 1212 F16	16 ER	12	12	16	80	EA16	P5000790	P5401390	XT10	⊗
212053800	SXAN R 1616 H16	16 ER	16	16	16	100	EA16	P5000790	P5401390	XT10	⊗
212053100	SXAN R 2020 K16	16 ER	20	20	20	125	EA16	P5000790	P5401390	XT10	⊗
212053200	SXAN R 2525 M16	16 ER	25	25	25	150	EA16	P5000790	P5401390	XT10	⊗
212124300	SXAN R 3232 P16	16 ER	32	32	32	170	EA16	P5000790	P5401390	XT10	⊗

⊗ Stock item | Produto de stock | Itens de stock

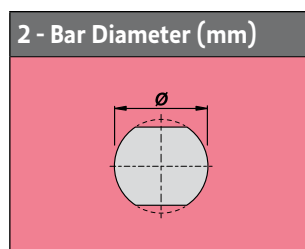
○ Available under request | Disponível sobre consulta | Disponible bajo consulta

INTERNAL TOOLHOLDERS CODE KEY

Chave de codificação para suporte internos | Llave de codificación para herramienta interior

S	32	S	S	X	F	N	R	16
1	2	3	4	5	6	7	8	9

1 - Bar Type	
S	Steel shank



3 - Bar Length (mm)			
	H	100	T 300
	J	110	U 350
	K	125	V 400
	L	140	W 450
	M	150	Y 500
	Q	180	X Special
	R	200	
	S	250	

4 - Inserts Clamping System			
C	M	P	S

5 - Insert Shape			
80° 	55° 	75° 	55°
C	D	E	K
90° 	60° 	35° 	80°
S	T	V	W
60° 			
X			

6 - Bar Leading Angle		
90° 	75° 	95°
F	K	L
107°30' 	93° 	93°
Q	U	U-BT
90° 		
G		

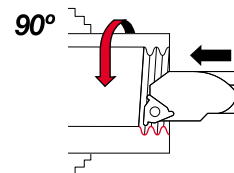
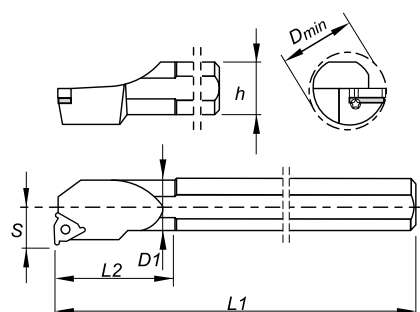
7 - Inserts Clearance Angle			
5° 	7° 	0° 	11°
B	C	N	P

8 - Bar Hand		
L	R	N

9 - Length of Inserts Cutting Edge (mm)				
C,D,E,V	K	S	T	W

INTERNAL TOOLHOLDER

SXFN



Internal Left

Order Code Código	Reference Referência Referencia	Insert Type	Dimensions Dimensões Dimensiones (mm)						Anvil	Anvil Screw	Insert Screw	Torx Key	Stock
			h	D1	Dmin	L1	L2	S					
212137600	S10H SXFN L 11	11 IL	10	10	12	100	-	7,4	-	-	P0260700	XT08	☼
212137800	S10K SXFN L 11	11 IL	16	10	12	125	25	7,4	-	-	P0260700	XT08	○
212385300	S13L SXFN L 11	11 IL	16	13	15	140	32	8,9	-	-	P0260700	XT08	○
212138000	S13M SXFN L 16	16 IL	16	13	16	150	32	10,2	-	-	P5401391	XT10	○
212127400	S16P SXFN L 16	16 IL	20	16	19	170	40	11,7	-	-	P5401391	XT10	☼
212138200	S20P SXFN L 16	16 IL	20	20	24	170	-	13,7	EA16	P5000790	P5401390	XT10	☼
212125500	S25R SXFN L 16	16 IL	25	25	29	200	-	16,2	EA16	P5000790	P5401390	XT10	☼
212125700	S32S SXFN L 16	16 IL	32	32	36	250	-	19,7	EA16	P5000790	P5401390	XT10	○
212125900	S40T SXFN L 16	16 IL	40	40	44	300	-	23,7	EA16	P5000790	P5401390	XT10	○

☼ Stock item | Produto de stock
Itens de stock

○ Available under request | Disponível sobre consulta
Disponível bajo consulta

Note: All the toolholders SXFN are made with 1,5° helix angle. | Todos os ferros de torno são fornecidos com um ângulo de hélice de 1,5° | Todos los soportes se hacen con un ángulo de hélice de 1,5°.

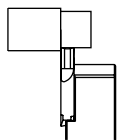
Internal Right

Order Code Código	Reference Referência Referencia	Insert Type	Dimensions Dimensões Dimensiones (mm)						Anvil	Anvil Screw	Insert Screw	Torx Key	Stock
			h	D1	Dmin	L1	L2	S					
212137700	S10H SXFN R 11	11 IR	10	10	12,5	100	-	7,3	-	-	P0260700	XT08	☼
212137900	S10K SXFN R 11	11 IR	16	10	12,5	125	25	7,3	-	-	P0260700	XT08	○
212385400	S10L SXFN R 11	11 IR	16	13	15	140	32	8,9	-	-	P0260700	XT08	○
212138100	S13M SXFN R 16	16 IR	16	13	16,5	150	32	10,4	-	-	P5401391	XT10	○
212127300	S16P SXFN R 16	16 IR	20	16	19,5	170	40	11,6	-	-	P5401391	XT10	☼
212138400	S20P SXFN R 16	16 IR	20	20	23,5	170	-	13,6	IA16	P5000790	P5401390	XT10	☼
212125400	S25R SXFN R 16	16 IR	25	25	28,5	200	-	16,3	IA16	P5000790	P5401390	XT10	☼
212125600	S32S SXFN R 16	16 IR	32	32	35,5	250	-	19,6	IA16	P5000790	P5401390	XT10	○
212125800	S40T SXFN R 16	16 IR	40	40	43,5	300	-	23,6	IA16	P5000790	P5401390	XT10	○

☼ Stock item | Produto de stock
Itens de stock

○ Available under request | Disponível sobre consulta
Disponível bajo consulta

Note: All the toolholders SXFN are made with 1,5° helix angle. | Todos os ferros de torno são fornecidos com um ângulo de hélice de 1,5° | Todos los soportes se hacen con un ángulo de hélice de 1,5°.



Turning

INSERTS

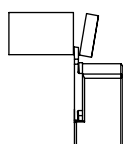
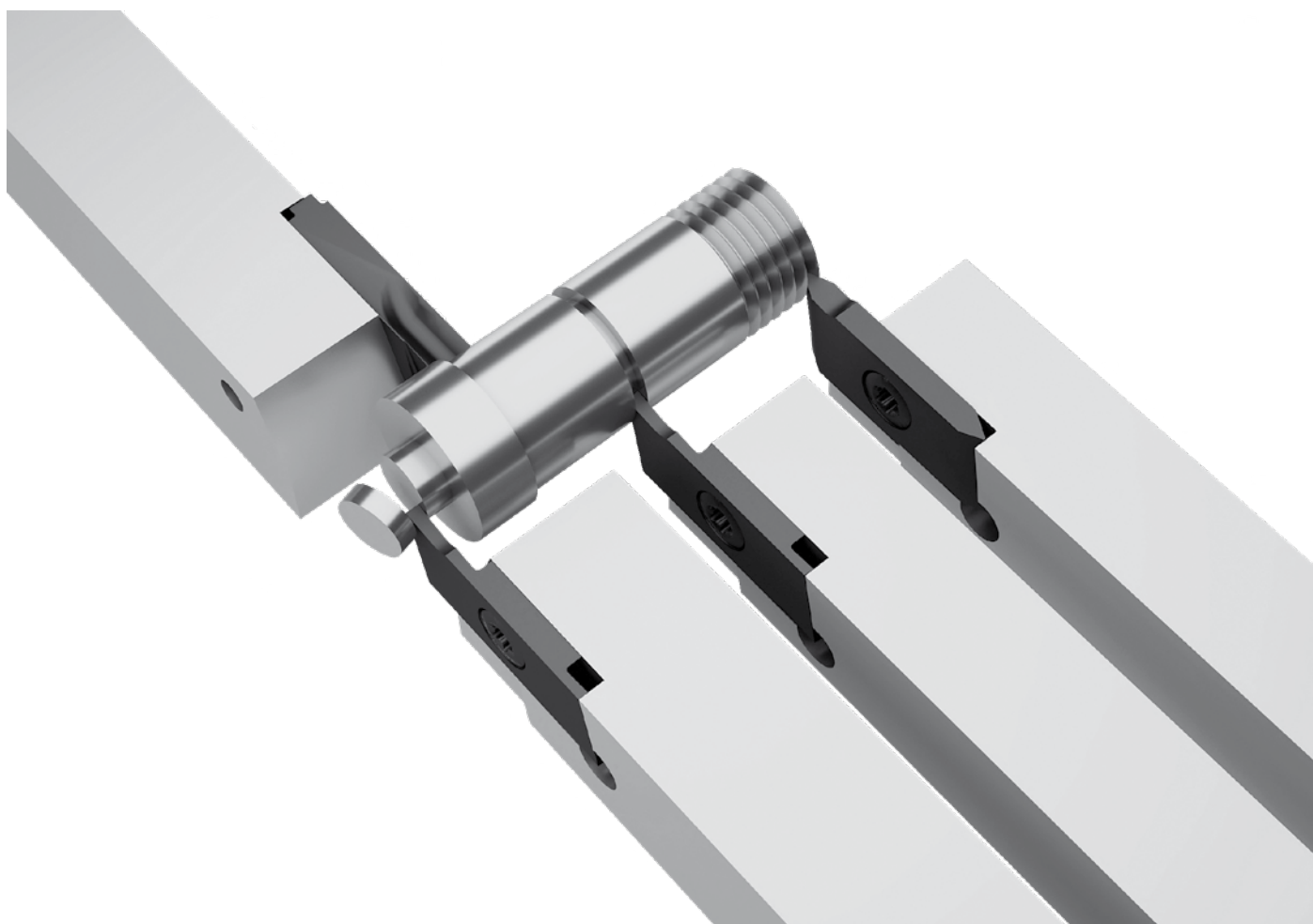
4 Different operations:

- Turning
- Parting off
- Grooving
- Threading

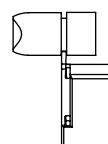
TOOLHOLDERS

Dimensions:

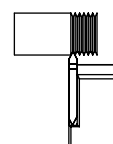
- 08x08mm
- 10x10mm
- 12x12mm
- 16x16mm



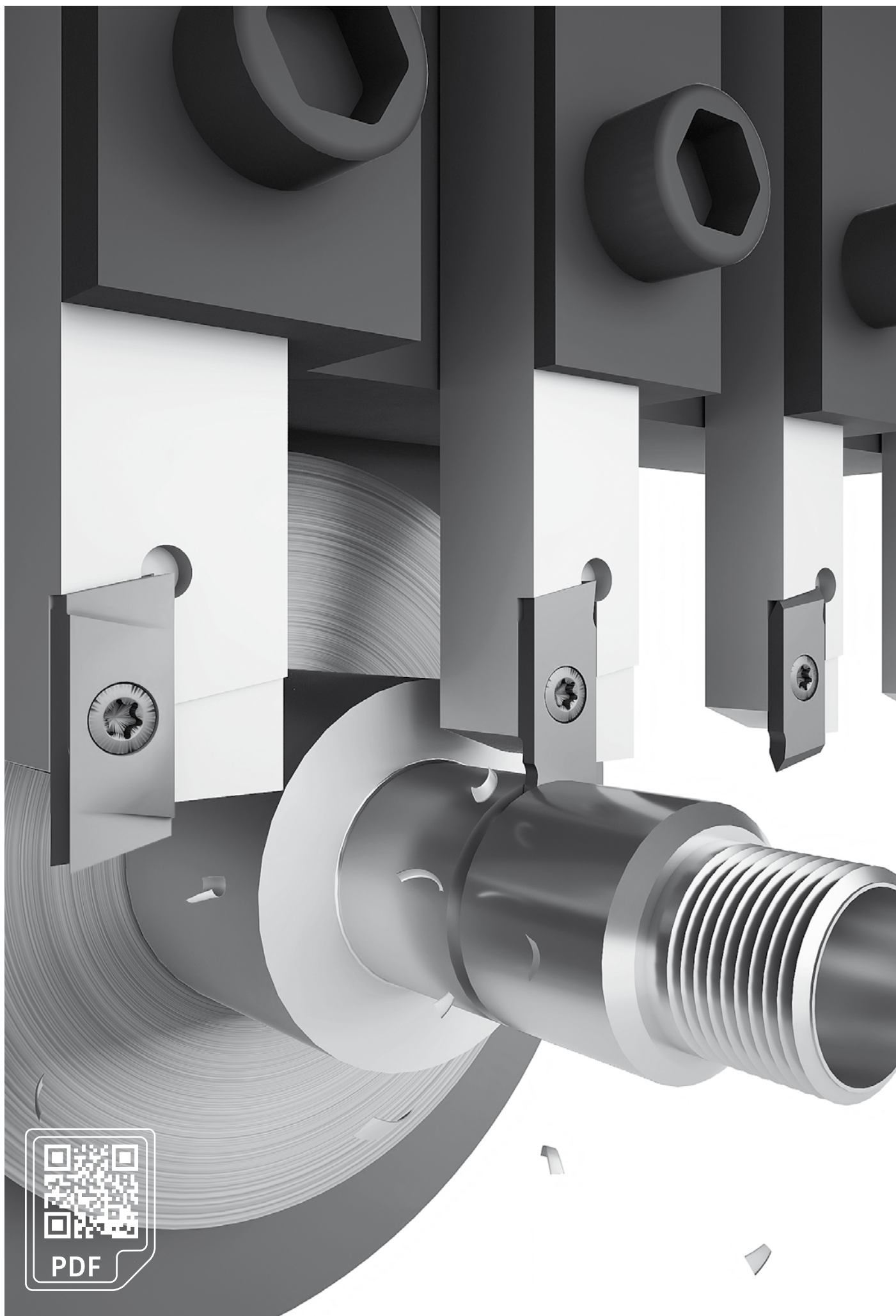
Parting off



Grooving



Threading



PDF

SAL - SWISS AUTOMATIC LATHES

INSERTS CODE KEY - Chave de codificação para pastilhas | Llave de codificación de plaquitas

Grooving Inserts

SAL	25	G	050	R		GS
1	2	5	6	8	-	11

Parting Off Inserts

SAL	11	P	100	R	N	P07
1	3	5	6	8	9	11

Threading Inserts

SAL	100	H	010	R	60	PT
1	4	5	7	8	10	11

Turning Inserts

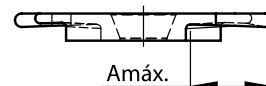
SAL	60	T	300	R		TP
1	2	5	6	8	-	11

1 - Product line

SAL - Swiss Automatic Lathes Line

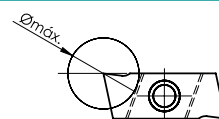
2 - Maximum depth of cut (Turning and Grooving inserts)

25 - 2,5mm | 60 - 6,0mm



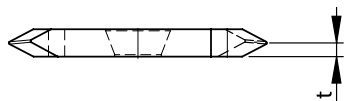
3 - Maximum Cutting Diameter (Parting Off Inserts)

11 - 11,0mm | 13 - 13,0mm



4 - Center distance (Threading Inserts)

050 - 0,5mm | 100 - 1,00mm



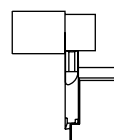
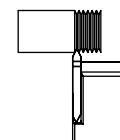
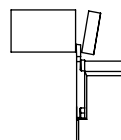
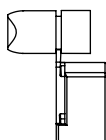
5 - Operations type

G - Grooving

P - Parting off

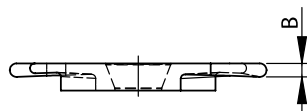
H - Threading

T - Turning



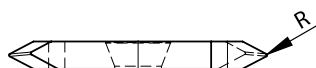
6 - Cut thickness (Grooving, Parting Off and Turning Inserts)

050 - 0,50mm | 070 - 0,70mm | 080 - 0,80mm
090 - 0,90mm | 100 - 1,00mm | 110 - 1,10mm
130 - 1,30mm | 150 - 1,50mm | 160 - 1,60mm
185 - 1,85mm | 200 - 2,00 mm | 300 - 3,00 mm



7 - Corner radius (Threading Inserts)

005 - 0,05mm | 010 - 0,10mm
012 - 0,12mm



8 - Insert / toolholder side

L - Left hand

R - Right hand

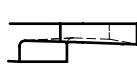


9 - Front angle (Parting off)

N - Neutral

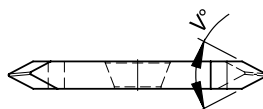
R - Right

L - Left



10 - Angle (Threading Inserts)

55 - 55° | 60 - 60°



11 - Chip Breaker (Turning, Grooving, Parting Off and Threading Inserts)

Turning TP - Turning steel

Grooving GS - Square Grooving
GR - Round Grooving

Parting Off P00 - Front angle 0°
P07 - Front angle 7°

Threading PT - Partial Profile

TOOLHOLDERS CODE KEY - Chave de codificação para suportes | Llave de codificación de herramienta

SAL	H	E	R		08	08		M	07
1	2	3	4	-	5	6	-	7	8

1 - Product line

SAL - Swiss Automatic Lathes Line

2 - Tool type

H - Holder

3 - Internal or External

E - External

4 - Insert / toolholder side

L - Left hand

R - Right hand

5 - Shank height

08 - 8 mm

10 - 10 mm

12 - 12 mm

16 - 16 mm

6 - Shank width

08 - 8 mm

10 - 10 mm

12 - 12 mm

16 - 16 mm

7 - Shank height

L - 140 mm

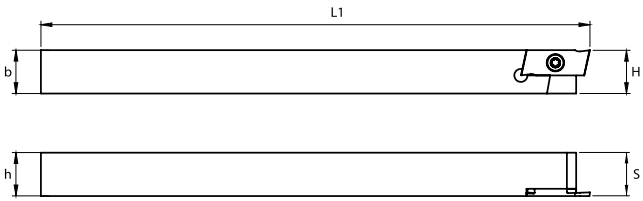
M - 150 mm

8 - Insert cutting edge lenght (mm)

07 - 7,0 mm



Left hand style show



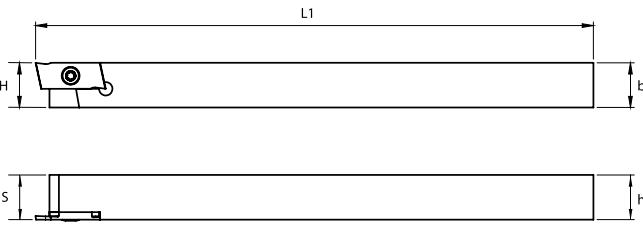
Order code Código	Reference Referência Referencia	Dimensions Dimensões Dimensiones (mm)					* Insert	Screw	Wrench	Stock
		h	b	H	L1	S				
213023600	SALHEL 0808 M07	8,00	8,00	8,00	150,00	8,00	SAL...L	P0300900	XT 08	
213023700	SALHEL 1010 M07	10,00	10,00	10,00	150,00	10,00	SAL...L	P0300900	XT 08	
213023800	SALHEL 1212 M07	12,00	12,00	12,00	150,00	12,00	SAL...L	P0300900	XT 08	
213023900	SALHEL 1616 M07	16,00	16,00	16,00	150,00	16,00	SAL...L	P0300900	XT 08	

Stock item | Produto de stock | Itens de stock Available under request | Disponível sobre consulta | Disponible bajo consulta

* Left insert only fits on left toolholder



Right hand style show



Order code Código	Reference Referência Referencia	Dimensions Dimensões Dimensiones (mm)					* Insert	Screw	Wrench	Stock
		h	b	H	L1	S				
213023200	SALHER 0808 M07	8,00	8,00	8,00	150,00	8,00	SAL...R	P0300900	XT 08	
213023300	SALHER 1010 M07	10,00	10,00	10,00	150,00	10,00	SAL...R	P0300900	XT 08	
213023400	SALHER 1212 M07	12,00	12,00	12,00	150,00	12,00	SAL...R	P0300900	XT 08	
213023500	SALHER 1616 M07	16,00	16,00	16,00	150,00	16,00	SAL...R	P0300900	XT 08	

Stock item | Produto de stock | Itens de stock Available under request | Disponível sobre consulta | Disponible bajo consulta

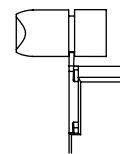
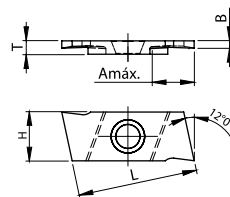
* Right insert only fits on right toolholder

GS SERIES | Inserts | Pastilhas | Plaquetas



Right hand style show

For square grooving
Para grooving quadrado
Para ranurado quadrado



Grooving

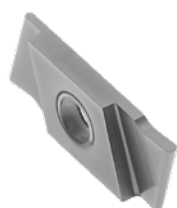
					P		M		K		S		Dimensions (mm) Dimensões (mm) Dimensiones (mm)						Cutting conditions Condições de corte Condiciones de corte		
	(2) Grade code		PVD																		
	(1)	ISO	ANSI	G1	G4	G4	P8	G4	P8	G4	P8	B	L	T	H	Amáx.	V°	Ømáx.	fn (mm/r)	Min.	Max.
Geometry code	Reference	Reference	PH7910	PH7920	PH7920	PH7135	PH7920	PH7135	PH7920	PH7135											
1130441	SAL25G050R-GS	SAL25G050R-GS	○	⊗	⊗	○	⊗	○	⊗	○	0,50	17,00	2,00	7,00	2,50	-	-	0,04	0,02	0,06	
1130475	SAL25G070R-GS	SAL25G070R-GS	○	⊗	⊗	○	⊗	○	⊗	○	0,70	17,00	2,00	7,00	2,50	-	-	0,05	0,02	0,08	
1130477	SAL25G080R-GS	SAL25G080R-GS	○	⊗	⊗	○	⊗	○	⊗	○	0,80	17,00	2,00	7,00	2,50	-	-	0,05	0,02	0,09	
1130479	SAL25G090R-GS	SAL25G090R-GS	○	⊗	⊗	○	⊗	○	⊗	○	0,90	17,00	2,00	7,00	2,50	-	-	0,06	0,02	0,10	
1130488	SAL60G110R-GS	SAL60G110R-GS	○	⊗	⊗	○	⊗	○	⊗	○	1,10	17,00	2,00	7,00	6,00	-	-	0,06	0,02	0,11	
1130490	SAL60G130R-GS	SAL60G130R-GS	○	⊗	⊗	○	⊗	○	⊗	○	1,30	17,00	2,00	7,00	6,00	-	-	0,07	0,02	0,12	
1130442	SAL60G160R-GS	SAL60G160R-GS	○	⊗	⊗	○	⊗	○	⊗	○	1,60	17,00	2,00	7,00	6,00	-	-	0,07	0,02	0,13	
1130495	SAL60G185R-GS	SAL60G185R-GS	○	⊗	⊗	○	⊗	○	⊗	○	1,85	17,00	2,00	7,00	6,00	-	-	0,08	0,02	0,14	
1130473	SAL25G050L-GS	SAL25G050L-GS	○	⊗	⊗	○	⊗	○	⊗	○	0,50	17,00	2,00	7,00	2,50	-	-	0,04	0,02	0,06	
1130474	SAL25G070L-GS	SAL25G070L-GS	○	⊗	⊗	○	⊗	○	⊗	○	0,70	17,00	2,00	7,00	2,50	-	-	0,05	0,02	0,08	
1130476	SAL25G080L-GS	SAL25G080L-GS	○	⊗	⊗	○	⊗	○	⊗	○	0,80	17,00	2,00	7,00	2,50	-	-	0,05	0,02	0,09	
1130478	SAL25G090L-GS	SAL25G090L-GS	○	⊗	⊗	○	⊗	○	⊗	○	0,90	17,00	2,00	7,00	2,50	-	-	0,06	0,02	0,10	
1130487	SAL60G110L-GS	SAL60G110L-GS	○	⊗	⊗	○	⊗	○	⊗	○	1,10	17,00	2,00	7,00	6,00	-	-	0,06	0,02	0,11	
1130489	SAL60G130L-GS	SAL60G130L-GS	○	⊗	⊗	○	⊗	○	⊗	○	1,30	17,00	2,00	7,00	6,00	-	-	0,07	0,02	0,12	
1130493	SAL60G160L-GS	SAL60G160L-GS	○	⊗	⊗	○	⊗	○	⊗	○	1,60	17,00	2,00	7,00	6,00	-	-	0,07	0,02	0,13	
1130494	SAL60G185L-GS	SAL60G185L-GS	○	⊗	⊗	○	⊗	○	⊗	○	1,85	17,00	2,00	7,00	6,00	-	-	0,08	0,02	0,14	

⊗ Stock item | Produto de stock | Itens de stock

○ Available under request with delivery time 4 weeks
Disponível sobre consulta com prazo de entrega de 4 semanas
Disponible bajo consulta, con fecha de entrega en 4 semanas

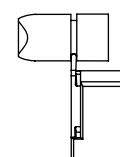
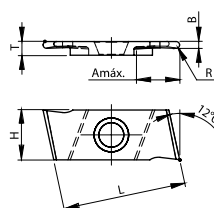
Order code = (1) Geometry code + (2) Grade code

GR SERIES | Inserts | Pastilhas | Plaquetas



Right hand style show

For round grooving
Para grooving redondo
Para ranurado redondo



Grooving

			P		M		K		S		Dimensions (mm) Dimensões (mm) Dimensiones (mm)						Cutting conditions Condições de corte Condiciones de corte			
	⁽²⁾ Grade code		PVD																	
				G1	G4	G4	P8	G4	P8	G4	P8									
⁽¹⁾	ISO	ANSI	PH7910	PH7920	PH7920	PH7135	PH7920	PH7135	PH7920	PH7135										
Geometry code	Reference	Reference									B	L	T	H	Amáx.	V°	Ømáx.	fn (mm/r)	Min.	Max.
1130443	SAL60G100R-GR	SAL60G100R-GR	○	⊗	⊗	○	⊗	○	⊗	○	1,00	17,00	2,00	7,00	6,00	-	-	0,06	0,02	0,10
1130492	SAL60G150R-GR	SAL60G150R-GR	○	⊗	⊗	○	⊗	○	⊗	○	1,50	17,00	2,00	7,00	6,00	-	-	0,08	0,02	0,12
1130497	SAL60G200R-GR	SAL60G200R-GR	○	⊗	⊗	○	⊗	○	⊗	○	2,00	17,00	2,00	7,00	6,00	-	-	0,08	0,03	0,14
1130486	SAL60G100L-GR	SAL60G100L-GR	○	⊗	⊗	○	⊗	○	⊗	○	1,00	17,00	2,00	7,00	6,00	-	-	0,06	0,02	0,10
1130491	SAL60G150L-GR	SAL60G150L-GR	○	⊗	⊗	○	⊗	○	⊗	○	1,50	17,00	2,00	7,00	6,00	-	-	0,08	0,02	0,12
1130496	SAL60G200L-GR	SAL60G200L-GR	○	⊗	⊗	○	⊗	○	⊗	○	2,00	17,00	2,00	7,00	6,00	-	-	0,08	0,03	0,14

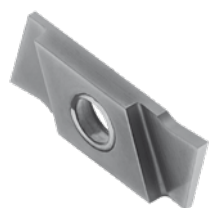
⊗ Stock item | Produto de stock | Itens de stock

○ Available under request with delivery time 4 weeks
Disponível sobre consulta com prazo de entrega de 4 semanas
Disponible bajo consulta, con fecha de entrega en 4 semanas

Order code = (1) Geometry code + (2) Grade code

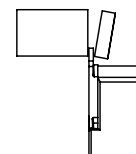
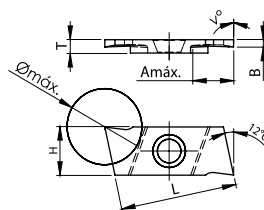
SAL - SWISS AUTOMATIC LATHES

P(P00) SERIES | Inserts | Pastilhas | Plaquetas



Right hand style show

Without front angle
Sem ângulo frontal
Sin ángulo frontal



Parting off

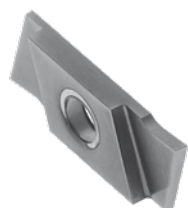
	(2) Grade code		P		M		K		S		Dimensions (mm) Dimensões (mm) Dimensiones (mm)						Cutting conditions Condições de corte Condiciones de corte			
			PVD																	
(1)	ISO Reference	ANSI Reference	G1	G4	G4	P8	G4	P8	G4	P8	B	L	T	H	Amáx.	V°	Ømáx.	fn (mm/r)	Min.	Max.
Geometry code			PH7910	PH7920	PH7920	PH7135	PH7920	PH7135	PH7920	PH7135										
1130444	SAL11P100RN-P00	SAL11P100RN-P00	○	⊗	⊗	○	⊗	○	⊗	○	1,00	17,00	2,00	7,00	6,00	0	11,00	0,06	0,02	0,10
1130462	SAL11P150RN-P00	SAL11P150RN-P00	○	⊗	⊗	○	⊗	○	⊗	○	1,50	17,00	2,00	7,00	6,00	0	11,00	0,08	0,02	0,12
1130468	SAL13P200RN-P00	SAL13P200RN-P00	○	⊗	⊗	○	⊗	○	⊗	○	2,00	17,00	2,00	7,00	6,00	0	7,00	0,08	0,03	0,14
1130456	SAL11P100LN-P00	SAL11P100LN-P00	○	⊗	⊗	○	⊗	○	⊗	○	1,00	17,00	2,00	7,00	6,00	0	11,00	0,06	0,02	0,10
1130459	SAL11P150LN-P00	SAL11P150LN-P00	○	⊗	⊗	○	⊗	○	⊗	○	1,50	17,00	2,00	7,00	6,00	0	11,00	0,08	0,02	0,12
1130465	SAL13P200LN-P00	SAL13P200LN-P00	○	⊗	⊗	○	⊗	○	⊗	○	2,00	17,00	2,00	7,00	6,00	0	7,00	0,08	0,03	0,14

⊗ Stock item | Produto de stock | Itens de stock

○ Available under request with delivery time 4 weeks
Disponível sobre consulta com prazo de entrega de 4 semanas
Disponible bajo consulta, con fecha de entrega en 4 semanas

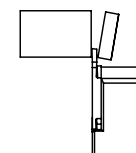
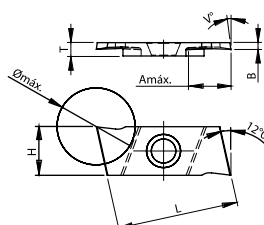
Order code = (1) Geometry code + (2) Grade code

P(P07) SERIES | Inserts | Pastilhas | Plaquetas



Right hand style show

Front angle 7°
Ângulo frontal de 7°
Ángulo frontal de 7°



Parting off

Right hand style show			PVD								Dimensions (mm) Dimensões (mm) Dimensiones (mm)							Cutting conditions Condições de corte Condiciones de corte		
	(2) Grade code																			
			G1	G4	G4	P8	G4	P8	G4	P8										
(1) Geometry code	ISO Reference	ANSI Reference	PH7910	PH7920	PH7920	PH7135	PH7920	PH7135	PH7920	PH7135	B	L	T	H	Amáx.	V°	Ømáx.	fn (mm/r)	Min.	Max.
1130445	SAL11P100RR-P07	SAL11P100RR-P07	○	⊗	⊗	○	⊗	○	⊗	○	1,00	17,00	2,00	7,00	6,00	7	11,00	0,05	0,02	0,08
1130446	SAL11P100RL-P07	SAL11P100RL-P07	○	⊗	⊗	○	⊗	○	⊗	○	1,00	17,00	2,00	7,00	6,00	7	11,00	0,05	0,02	0,08
1130463	SAL11P150RR-P07	SAL11P150RR-P07	○	⊗	⊗	○	⊗	○	⊗	○	1,50	17,00	2,00	7,00	6,00	7	11,00	0,06	0,02	0,10
1130461	SAL11P150RL-P07	SAL11P150RL-P07	○	⊗	⊗	○	⊗	○	⊗	○	1,50	17,00	2,00	7,00	6,00	7	11,00	0,06	0,02	0,10
1130469	SAL13P200RR-P07	SAL13P200RR-P07	○	⊗	⊗	○	⊗	○	⊗	○	2,00	17,00	2,00	7,00	6,00	7	7,00	0,06	0,03	0,12
1130467	SAL13P200RL-P07	SAL13P200RL-P07	○	⊗	⊗	○	⊗	○	⊗	○	2,00	17,00	2,00	7,00	6,00	7	7,00	0,06	0,03	0,12
1130457	SAL11P100LR-P07	SAL11P100LR-P07	○	⊗	⊗	○	⊗	○	⊗	○	1,00	17,00	2,00	7,00	6,00	7	11,00	0,05	0,02	0,08
1130455	SAL11P100LL-P07	SAL11P100LL-P07	○	⊗	⊗	○	⊗	○	⊗	○	1,00	17,00	2,00	7,00	6,00	7	11,00	0,05	0,02	0,08
1130460	SAL11P150LR-P07	SAL11P150LR-P07	○	⊗	⊗	○	⊗	○	⊗	○	1,50	17,00	2,00	7,00	6,00	7	11,00	0,06	0,02	0,10
1130458	SAL11P150LL-P07	SAL11P150LL-P07	○	⊗	⊗	○	⊗	○	⊗	○	1,50	17,00	2,00	7,00	6,00	7	11,00	0,06	0,02	0,10
1130466	SAL13P200LR-P07	SAL13P200LR-P07	○	⊗	⊗	○	⊗	○	⊗	○	2,00	17,00	2,00	7,00	6,00	7	7,00	0,06	0,03	0,12
1130464	SAL13P200LL-P07	SAL13P200LL-P07	○	⊗	⊗	○	⊗	○	⊗	○	2,00	17,00	2,00	7,00	6,00	7	7,00	0,06	0,03	0,12

⊗ Stock item | Produto de stock | Itens de stock

○ Available under request with delivery time 4 weeks
Disponível sobre consulta com prazo de entrega de 4 semanas
Disponible bajo consulta, con fecha de entrega en 4 semanas

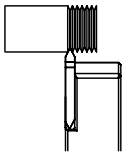
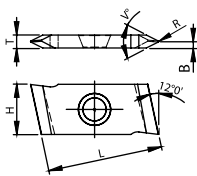
Order code = (1) Geometry code + (2) Grade code

PT SERIES | Inserts | Pastilhas | Plaquetas



Right hand style show

For partial profile threading
Para perfil parcial de roscagem
Para perfil parcial de roscado

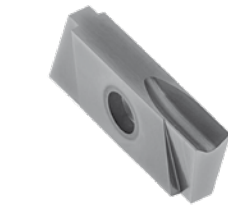


Threading

			P		M		K		S		Dimensions (mm) Dimensões (mm) Dimensiones (mm)							Cutting conditions Condições de corte Condiciones de corte		
			(2) Grade code																	
			PVD																	
			G1	G4	G4	P8	G4	P8	G4	P8										
(1)	ISO	ANSI	PH7910	PH7920	PH7920	PH7135	PH7920	PH7135	PH7920	PH7135	B	L	T	H	Amáx.	V°	Ømáx.	fn (mm/r)	Min.	Max.
Geometry code	Reference	Reference																		
1130472	SAL100H012R55-PT	SAL100H012R55-PT	○	⊗	⊗	○	⊗	○	⊗	○	1,09	1700	2,00	7,00	0,12	55	-	0,80	0,20	2,00
1130447	SAL100H012R60-PT	SAL100H012R60-PT	○	⊗	⊗	○	⊗	○	⊗	○	1,09	1700	2,00	7,00	0,12	60	-	0,80	0,20	2,00
1130470	SAL100H012L55-PT	SAL100H012L55-PT	○	⊗	⊗	○	⊗	○	⊗	○	1,09	1700	2,00	7,00	0,12	55	-	0,80	0,20	2,00
1130471	SAL100H012L60-PT	SAL100H012L60-PT	○	⊗	⊗	○	⊗	○	⊗	○	1,09	1700	2,00	7,00	0,12	60	-	0,80	0,20	2,00

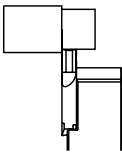
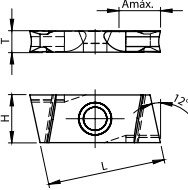
⊗ Stock item | Produto de stock | Itens de stock ○ Available under request with delivery time 4 weeks
Disponível sobre consulta com prazo de entrega de 4 semanas Order code = (1) Geometry code + (2) Grade code
Disponible bajo consulta, con fecha de entrega en 4 semanas

TP SERIES | Inserts | Pastilhas | Plaquetas



Right hand style show

For turning
Para torneamento
Para torneado

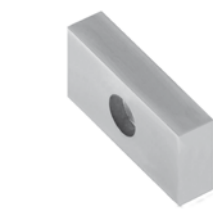


Turning

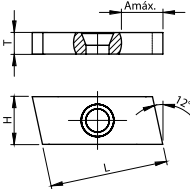
			P		M		K		S		Dimensions (mm) Dimensões (mm) Dimensiones (mm)							Cutting conditions Condições de corte Condiciones de corte		
	(2) Grade code		PVD																	
			G1	G4	G4	P8	G4	P8	G4	P8										
(1)	ISO Reference	ANSI Reference	PH7910	PH7920	PH7920	PH7135	PH7920	PH7135	PH7920	PH7135	B	L	T	H	Amáx.	V°	Ømáx.	fn (mm/r)	Min.	Max.
Geometry code																				
1130501	SAL60T300R-TP	SAL60T300R-TP	○	⊗	⊗	○	⊗	○	⊗	○	-	1700	3,17	7,00	6,00	-	-	0,08	0,02	0,12
1130499	SAL60T300L-TP	SAL60T300L-TP	○	⊗	⊗	○	⊗	○	⊗	○	-	1700	3,17	7,00	6,00	-	-	0,08	0,02	0,12

⊗ Stock item | Produto de stock | Itens de stock ○ Available under request with delivery time 4 weeks
Disponível sobre consulta com prazo de entrega de 4 semanas Order code = (1) Geometry code + (2) Grade code
Disponible bajo consulta, con fecha de entrega en 4 semanas

BLANKS FOR GRINDING | Blanks para personalizar | Blanks para personalizar



Right hand style show



Inserts blanks “do it yourself” grinding are available allowing modifications of the insert for any machining operation.

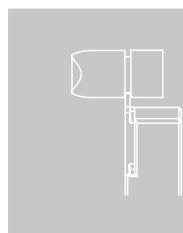
As pastilhas de blank “faça você mesmo” permitem a personalização da pastilha para qualquer operação de maquinação.

Las plaquetas de blank “haga usted mismo” permiten la personalización de la plaqueta para cualquiera operación de maquinación.

(1) Geometry code	(2) Grade code		Uncoated			Dimensions (mm) Dimensões (mm) Dimensiones (mm)						
			10	12	14	B	L	T	H	Amáx.	V°	Ømáx.
	PH0910	PH0920	PH0135									
1130440	BLANK SALR 17x7x2	BLANK SALR 17x7x2	⊗	⊗	⊗	-	17,50	2,00	7,50	-	-	-
1130504	BLANK SALR 17x7x3,17	BLANK SALR 17x7x3,17	⊗	⊗	⊗	-	17,50	3,17	7,50	-	-	-
1130453	BLANK SALL 17x7x2	BLANK SALL 17x7x2	⊗	⊗	⊗	-	17,50	2,00	7,50	-	-	-
1130505	BLANK SALL 17x7x3,17	BLANK SALL 17x7x3,17	⊗	⊗	⊗	-	17,50	3,17	7,50	-	-	-

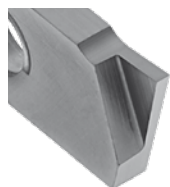
⊗ Stock item | Produto de stock | Itens de stock ○ Available under request | Disponível sobre consulta | Disponible bajo consulta
Order code = (1) Geometry code + (2) Grade code

GROOVING | Canais | Ranurado



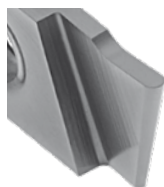
- High precision
- Close tolerances
- Wide variety of insert widths

GS



Square grooving

GR



Round grooving

Recommended cutting conditions

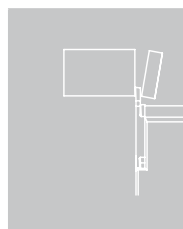
P	M	K	S
60-200	60-180	60-150	20-50

Recommended grade PH7920, (Vc) m/min.

Grade PH7910 and PH7135

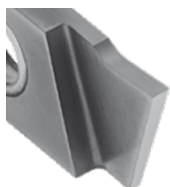
Available under request (4 weeks delivery time)

PARTING OFF | Corte | Tronzado



- When parting off with a sub-spindle, it is more productive to use a straight cutting edge. This is a more stable parting method and will generate the best surface finish.
- When parting off without a sub-spindle, we recommend you use an insert with a maximum 7° front angle to minimize the risk of burr and pips on the component.
- When parting off with 7° front angled inserts, we recommend reducing the feed rate by approximately 30%.

P00



0° Relief angle

P07



7° Relief angle

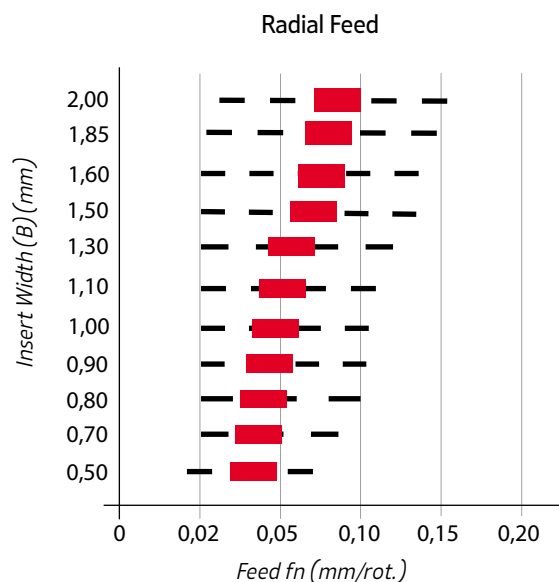
Recommended cutting conditions

P	M	K	S
60-200	60-180	60-150	20-50

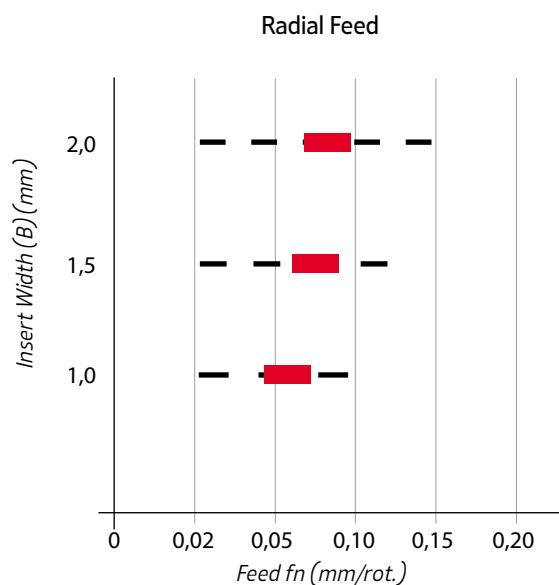
Recommended grade PH7920, (Vc) m/min.

Grade PH7910 and PH7135

Available under request (4 weeks delivery time)

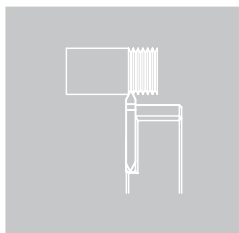


recommended starting value



recommended starting value

THREADING | Roscagem | Roscado



Two types of threading:

- Partial profile 55°
- Partial profile 60°

Pitch from 12 - 94 TPI / 0,25 - 2,0 mm

PT



Partial profile

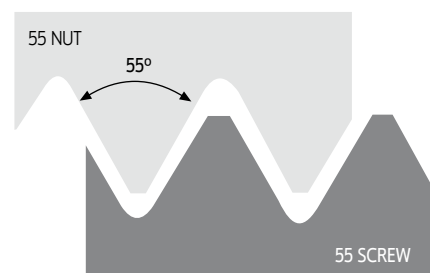
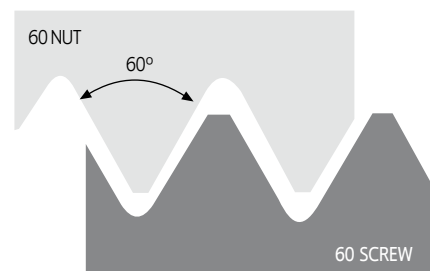
Recommended cutting conditions

P	M	K	S
60-200	60-180	60-150	20-50

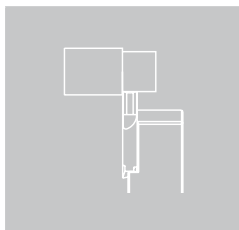
Recommended grade PH7920, (Vc) m/min.

Grade PH7910 and PH7135

Available under request (4 weeks delivery time)



TURNING | Torneamento | Torneado

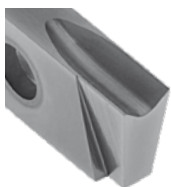


- Insert for turning

- Maximum deep of cut is 2,50 mm

- Too low cutting speed will result in inadequate tool life and it is advisable to follow cutting speed recommendations.

TP



Turning steel

Recommended cutting conditions

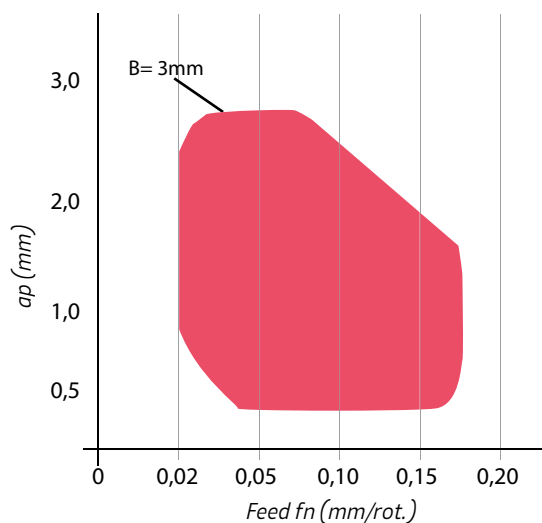
P	M	K	S
60-200	60-180	60-150	20-50

Recommended grade PH7920, (Vc) m/min.

Grade PH7910 and PH7135

Available under request (4 weeks delivery time)

Radial Feed



Machining field

SCREWS & KEYS



Screws

Order code Código	Reference Referência Referencia	Stock
290074100	D0503000	
290020700	D0603600	
290062900	D0602200	
290044800	P0260700	
290044600	P5401390	
290044900	P5401391	

- Stock item | Produto de stock | Itens de stock
- Available under request | Disponível sobre consulta | Disponible bajo consulta

Keys

Order Code Código	Reference Referência Referencia	Stock
290011700	XT08	
290013100	XT10	

WRENCHES



Order code Código	Reference Referência Referencia	Stock
290021200	SS40	
290021300	SS50	

Order code Código	Reference Referência Referencia	Stock
290074400	LE05	

Order code Código	Reference Referência Referencia	Stock
290079600	LE25-30	

- Stock item | Produto de stock | Itens de stock
- Available under request | Disponível sobre consulta | Disponible bajo consulta

GROOVING & PARTING OFF GRADES

ISO	Uncoated grades	Coated Grades		
		CVD	PVD	
P	05			- Wear resistance - Resistência ao desgaste - Resistencia al desgaste
	10			
	15			
	20			
	25			
	30			
	35			
	40			
	45			
	50			
STEEL	05			- Toughness - Tenacidade - Tenacidad
	10			
	15			
	20			
	25			
	30			
	35			
	40			
	45			
	50			
M	05			- Wear resistance - Resistência ao desgaste - Resistencia al desgaste
	10			
	15			
	20			
	25			
	30			
	35			
	40			
	45			
	50			
STAINLESS STEEL	05			- Toughness - Tenacidade - Tenacidad
	10			
	15			
	20			
	25			
	30			
	35			
	40			
	45			
	50			
K	05			- Wear resistance - Resistência ao desgaste - Resistencia al desgaste
	10			
	15			
	20			
	25			
	30			
	35			
	40			
	45			
	50			
CAST IRON	05			- Toughness - Tenacidade - Tenacidad
	10			
	15			
	20			
	25			
	30			
	35			
	40			
	45			
	50			
Z	05			- Wear resistance - Resistência ao desgaste - Resistencia al desgaste
	10			
	15			
	20			
	25			
	30			
	35			
	40			
	45			
	50			
ALUMINIUM & NON FERROUS	05			- Toughness - Tenacidade - Tenacidad
	10			
	15			
	20			
	25			
	30			
	35			
	40			
	45			
	50			
S	05			- Wear resistance - Resistência ao desgaste - Resistencia al desgaste
	10			
	15			
	20			
	25			
	30			
	35			
	40			
	45			
	50			
HEAT RESISTENT / TITANIUM ALLOYS	05			- Toughness - Tenacidade - Tenacidad
	10			
	15			
	20			
	25			
	30			
	35			
	40			
	45			
	50			

The position and the form of the grade symbols indicate the suitable field of application.

Centre of the field of application.

Recommended fields of application

To be replaced by new grades

GROOVING & PARTING OFF GRADES DESCRIPTION



GROOVING & PARTING OFF

Grooving Plus & Parting Off

Grooving & Parting Off

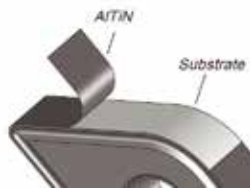
SAL - Swiss Automatic Lathes

Technical Data

PVD GRADES

PH7920

P10-P35
M10-M25
S10-S30

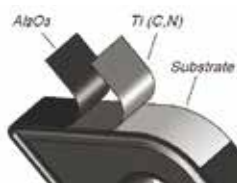


A micro grain size combined with the AlTiN PVD coating make it suitable for Roughing to Finishing operations under good cutting conditions to light interrupted cuts at medium cutting speeds. Suitable for steels, stainless steel, HRSA.

CVD GRADES

PH5115

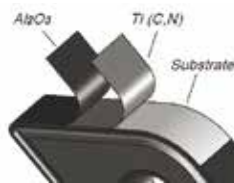
P01-P30
M01-M25



Medium temperature CVD coating with α -Al₂O₃. Carbide grade with a gradient layer close to the surface. Suitable for high to medium cutting speeds on steels & cast steels.

PH5125

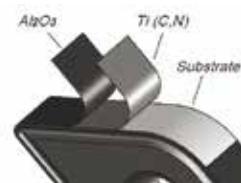
P10-P35
M05-M30



Carbide grade suitable for medium machining of steels & cast steels at medium cutting speeds. The substrate is suitable for the adhesion of the Alumina coating (α -Al₂O₃) medium temperature - CVD, improving the tool life.

PH5135

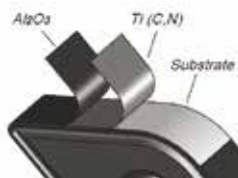
P20-P40
M15-M35
K15-K30



Substrate grade binary (Wc & Co) with medium grain size combined with the medium temperature CVD coating. Suitable for heavy roughing to roughing operations with interrupted cuts at medium to low cutting speeds.

PH5320

K01-K25



Medium temperature CVD coating (α -Al₂O₃) combined with a hard substrate make it capable of withstanding interrupted conditions. Recommended as general choice for roughing of all cast irons at low to medium cutting speeds. Can also be a solution for high alloy steels.

UNCOATED CARBIDE GRADE

PH0910

N01-N20



Uncoated carbide micrograin grade combining a good abrasive wear resistance and toughness. Suitable for rough to finish turning of HRSA, Titanium alloys, cast irons and Aluminium alloys.

CUTTING SPEED (m/min)

ISO	Material	Grade fn (mm/r) HB (brinell)	CVD Coating			PVD Coating
			← Wear Resistance →			Toughness →
			PH5115	PH5125	PH5135	PH7920
			0.04 -0.5	0.04 -0.5	0.04 -0.5	0.04 -0.5
P	Unalloyed steel	125-170	85-165	70-150	70-140	45-120
	Low-alloy steel	180-350	60-140	55-130	55-125	50-115
	High-alloy stel	200-325	50-130	45-115	45-115	50-110

ISO	Material	Grade fn (mm/r) HB (brinell)	CVD Coating			PVD Coating
			← Wear Resistance →			Toughness →
			PH5115	PH5125	PH5135	PH7920
			0.04 -0.5	0.04 -0.5	0.04 -0.5	0.04 -0.5
M	SS - Ferritic / Martensitic	200-330	65-175	55-165	45-155	45-140
	SS - Austenitic / Duplex	180-330	65-150	55-140	50-130	50-125
	SS - Ferritic / Duplex	230-260	65-140	55-130	50-125	50-120

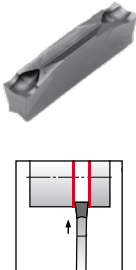
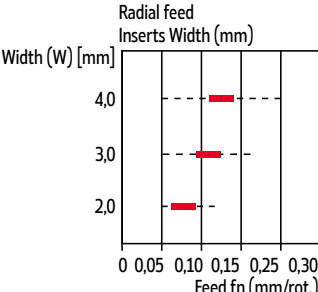
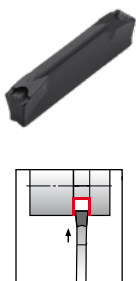
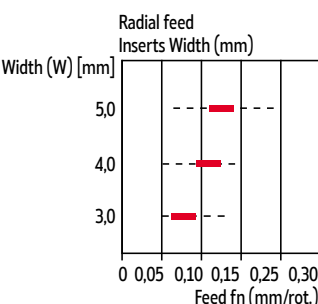
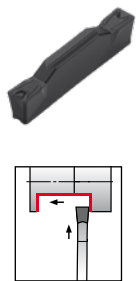
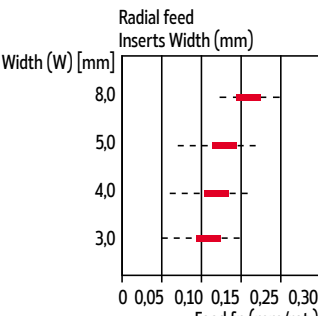
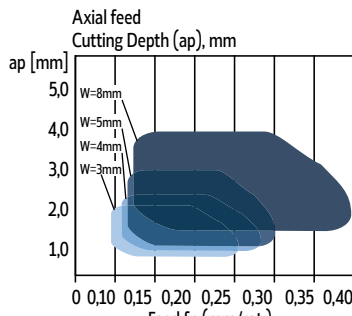
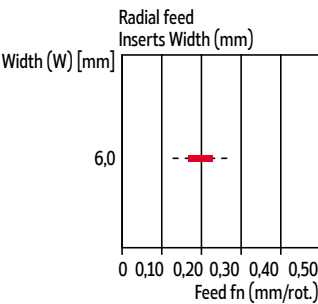
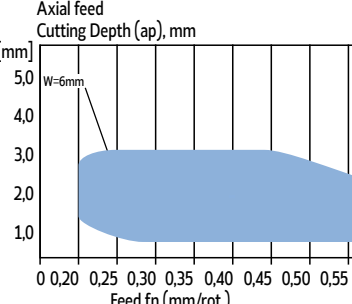
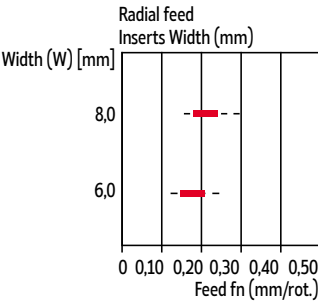
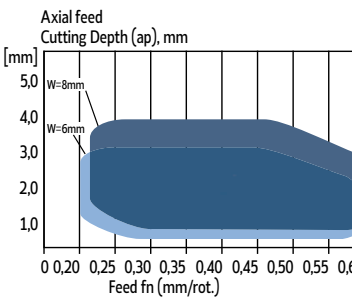
ISO	Material	Grade fn (mm/r) HB (brinell)	CVD Coating		
			← Wear Resistance →		
			PH5705	PH5320	PH5135
			0.04 -0.5	0.04 -0.5	0.04 -0.5
K	Marble cast iron	130-230	95-180	75-160	75-155
	Grey cast iron	180-220	90-175	70-155	70-140
	Nodular cast iron	160-380	55-150	45-135	45-125

ISO	Material	Grade fn (mm/r) HB (brinell)	Uncoated
			PH0910
			0.04 -0.35
N	Aluminium alloys	60-130	190-1800
	Cooper and cooper alloys	90-110	40-420

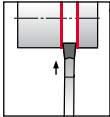
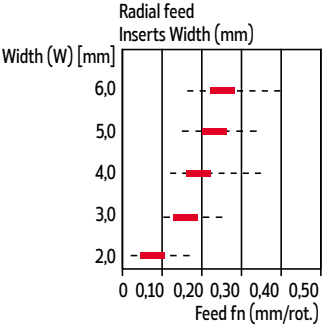
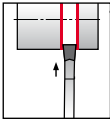
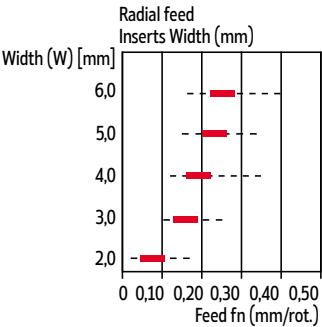
ISO	Material	Grade fn (mm/r) HB (brinell)	PVD Coating
			PH7920
			0.04 -0.30
S	Heat resistant super alloys (Iron base)	200-280	35-90
	Heat resistant super alloys (Nickel base)	250-320	22-60
	Heat resistant super alloys (Cobalt base)	200-320	27-80
	Titanium alloys (400<or<1050[MPa])	-	85-175

TECHNICAL DATA

CUTTING PARAMETERS || Parâmetros de corte | Parámetros de corte

Feed recommendations and geometry descriptions		Grooving & Parting Off
GP...02-MC 		Medium Parting Off Recommended for parting off, thin walled tubes and small diameter components in all materials. The positive geometry eliminates the risk of built-up edge. Low cutting forces resulting in reduced vibration.
GP...02-MG 		Medium Grooving Outstanding chip control. Reduces chip width giving good surfaces. For all materials.
GP...02-MM 		 Medium Multi Function (Grooving & Turning) For grooving and turning in all materials. Good chip control.
GP...02-MP 		 Medium Profiling For profiling all materials. Outstanding chip control even at low feeds and small depths of cut. Good surface finish.
GP...02-NP 		 Medium Aluminium profiling First choice for profiling in non-ferrous materials. Good chip flow provides a better surface finishing. Sharp cutting edge.

CUTTING PARAMETERS || Parâmetros de corte | Parámetros de corte

Feed recommendations and geometry descriptions		Grooving & Parting Off
GCMX-... 	Radial feed Inserts Width (mm) 	Medium Parting Off Most efficient on stainless steel and most types of steel at moderate feed rates. Superior straightness of cut
SANCAR-... 	Radial feed Inserts Width (mm) 	Medium Parting Off Optimizer to minimize pips and burrs on components. Recommended for steel, stainless steel and cast iron.

Recommended starting value.
For cutting speed recommendations, see page D-693