

Plastic Machining Tools

*Kunststoff-Bearbeitungswerkzeuge
Outils d'usinage de plastique*



Top Solutions for Plastic Processing

Our tool systems master the challenges posed by the machining of plastics (polymers).

- Extremely sharp cutting edges
- Very good chip control
- Custom-made blade and cutting geometries

Our highly qualified staff, whom we proudly consider family, have developed process-safe systems. Driven by the Swabian urge to make things even more precise, effective, and efficient, we continuously optimize supposedly the best solutions or rethink them entirely.



Management: Stefan Dieterle, Petra Dieterle-Müller, Michael Dieterle

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Legend

-  Rotation direction
- #** Number of cutting edges
- t_{max}** Maximum cutting depth
- R** Radius
- α** Clearance angle
- β** Wedge angle
- γ** Top rake angle



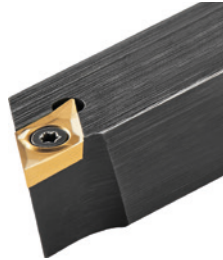


Product Range External Machining

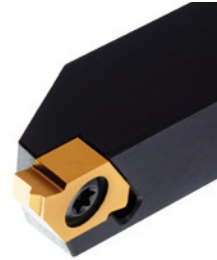
Standard Tools



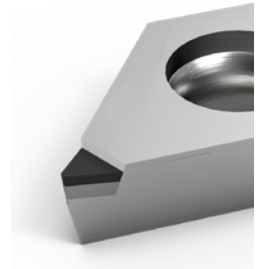
Parting off Systems



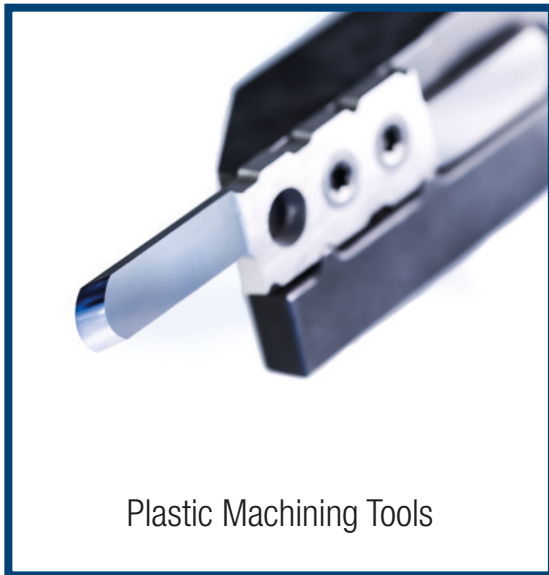
Turning Tools



Threading Tools



Ultra-hard Cutting Materials



Plastic Machining Tools



Turning Tools for Swiss type machines



Polygon Cutters

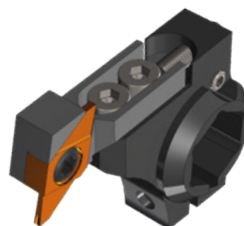


Knurling Tools

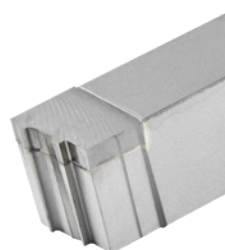
Special Tools



Form grooving systems shank holders



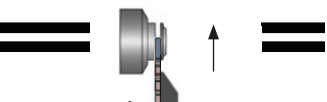
Form grooving systems machine related interfaces



Form grooving tools out of tool holder bits



Thread whirling tools

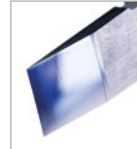
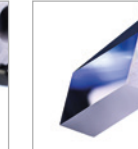
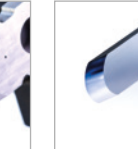


Tool Finder Plastic

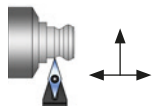
Grooving and Cutting off



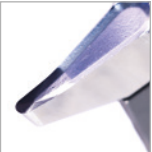
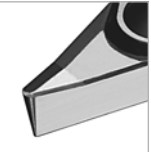
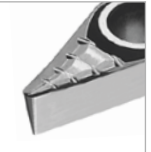
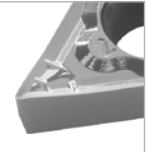
cutting								
Material	-45°-	-45°-R01-	-225-	-S1-	-S1-SP-	-S2-SP2-	-S1-PKD	-PKD-
PUR					++	++		
PTFE (Teflon)	++	++	++	++	++	++		
POM	++	++	++	++	++	++		
PA	++	++	++	++	++	++		
PVC	+	+	+	+	++	++		
PP	++	++	++	++	++	++		
PE-HD					++	++		
PEEK	++	++	++	++	++	++		
Vulkollan					++	++		
PMMA (Plexiglass)	++	++	++	++	++	++		
With fillers							++	++
PC	++	++	++	++	++	++		
PET	+	+	+	+	++	++		
PVDF	++	++	++	++	++	++		
PEI					++	++		
PPS	++	++	++	++	++	++		

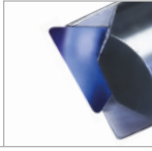
chipless-cutting				
Material	-RX-	-VG-	-12°-	-R3-
PUR	++	++	++	++
PTFE (Teflon)				
POM	++	++	++	++
PA				
PVC	++	++	++	++
PP	++	++	++	++
PE-HD	++	++	++	++
PEEK	++	++	++	++
Vulkollan	++	++	++	++
PMMA (Plexiglass)				
With fillers				
PC				
PET	++	++	++	++
PVDF				
PEI	++	++	++	++
PPS				





Tool Finder Plastic Copy Turning

copying						
Material	KP-VC GT-11	KP-VC GT-16 KP-VC GT-22	ALU-FA	ASF	ACB	AWI
PUR	++	+	+	+		+
PTFE (Teflon)	++	+	+	+	+	+
POM	+	+	+	+	+	+
PA	+	+	+	+	++	+
PVC	+	+			+	
PP	+	+		+	+	+
PE-HD		+			++	
PEEK	+	+	+		+	
Vulkollan	+					
PMMA (Plexiglass)	+	+	+	++	+	++
With fillers						
PC	+	+	+	+	+	+
PET	+	+	+	+	++	+
PVDF	+	+	+	+	+	+
PEI	+		+	+	+	
PPS	+	+	+	+	+	+

copying			
Material	_CGT-PKD	_CGW-PKD	KP-...TOFX-PKD
PUR			
PTFE (Teflon)			
POM			
PA			
PVC			
PP			
PE-HD			
PEEK			
Vulkollan			
PMMA (Plexiglass)			
With fillers	+	+	+
PC			
PET			
PVDF			
PEI			
PPS			



Parting off systems Tool Holder KH

KH base holders in sizes 2-7 and 2-9 accept all Dieterle plastic punch and cutting tools.

KH 2-9

Screws: S-3080-30-KP
Item no. 138657

Key: T8
Item no. 103603

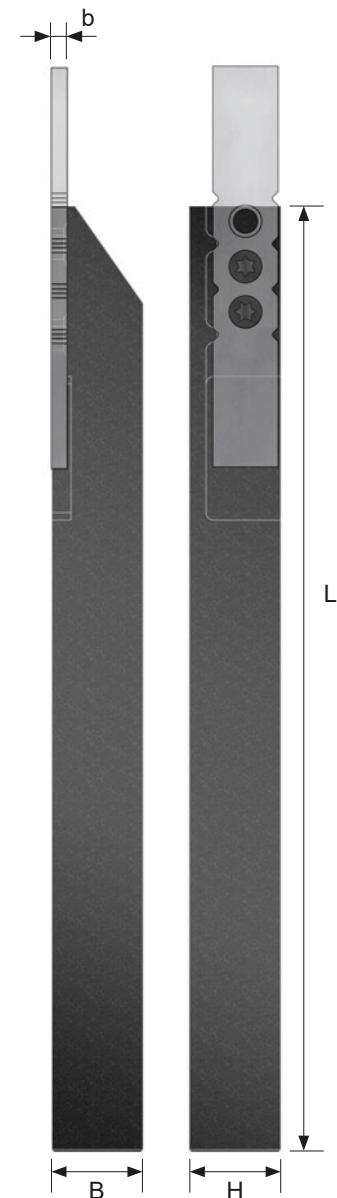
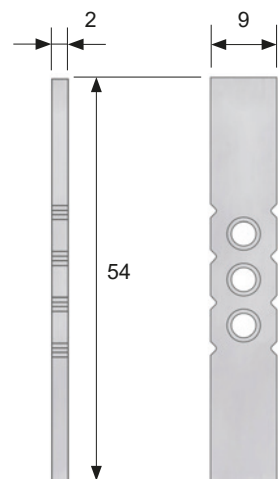
Item no.	Designation		H	B	L
137674	KH-2-9-1010-R	R	10	10	140
137677	KH-2-9-1010-L	L	10	10	140
128453	KH-2-9-1212-R	R	12	12	140
128468	KH-2-9-1212-L	L	12	12	140
128454	KH-2-9-1616-R	R	16	16	125
128867	KH-2-9-1616-L	L	16	16	125
130238	KH-2-9-2020-R	R	20	20	125
130240	KH-2-9-2020-L	L	20	20	125
160096	KH-2-9-2525-R	R	25	25	125
160095	KH-2-9-2525-L	L	25	25	125

KH 2-7

Screws: S-3080-30-KP
Item no. 138657

Key: T8
Item no. 103603

Item no.	Designation		H	B	L
135260	KH-2-7-0808-R	R	8	8	140
135259	KH-2-7-0808-L	L	8	8	140
128455	KH-2-7-1010-R	R	10	10	140
128868	KH-2-7-1010-L	L	10	10	140
128881	KH-2-7-1212-R	R	12	12	140
128880	KH-2-7-1212-L	L	12	12	140
128883	KH-2-7-1616-R	R	16	16	125
128882	KH-2-7-1616-L	L	16	16	125
160098	KH-2-7-2020-R	R	20	20	125
160097	KH-2-7-2020-L	L	20	20	125
160100	KH-2-7-2525-R	R	25	25	125
160099	KH-2-7-2525-L	L	25	25	125



Right-hand version shown
(internal coolant supply on demand)



Parting off systems

Parting-off cutting tool

45°

The Dieterle 45° has been proven for years in Machining/finishing of numerous plastics. The unique tooth geometry provides extreme sharpness and a guided chip.

Holder system 2-9 (Holder on page 6)

Item no.	Designation		b	t _{max}	R	a
138681	KP-2-9-10-12-45°-S-R-UFK2	R	1,0	12	0	0,5
180131	KP-2-9-10-12-45°-S-L-UFK2	L	1,0	12	0	0,5
180129	KP-2-9-15-18-45°-S-R-UFK2	R	1,5	18	0	0,5
180132	KP-2-9-15-18-45°-S-L-UFK2	L	1,5	18	0	0,5
180130	KP-2-9-20-18-45°-S-R-UFK2	R	2,0	18	0	0,5
180133	KP-2-9-20-18-45°-S-L-UFK2	L	2,0	18	0	0,5

Holder system 2-7 (Holder on page 6)

Item no.	Designation		b	t _{max}	R	a
180126	KP-2-7-10-10-45°-S-R-UFK2	R	1,0	10	0	0,25
140210	KP-2-7-10-10-45°-S-L-UFK2	L	1,0	10	0	0,25
180127	KP-2-7-15-10-45°-S-R-UFK2	R	1,5	10	0	0,25
180128	KP-2-7-15-10-45°-S-L-UFK2	L	1,5	10	0	0,25

45°-R01

Holder system 2-9 (Holder on page 6)

Item no.	Designation		b	t _{max}	R	a
140830	KP-2-9-10-12-45°-S-01-R-UFK2	R	1,0	12	0,1	0,5
157840	KP-2-9-10-12-45°-S-01-L-UFK2	L	1,0	12	0,1	0,5
143843	KP-2-9-15-18-45°-S-01-R-UFK2	R	1,5	18	0,1	0,5
141393	KP-2-9-15-18-45°-S-01-L-UFK2	L	1,5	18	0,1	0,5
144140	KP-2-9-20-18-45°-S-01-R-UFK2	R	2,0	18	0,1	0,5
144139	KP-2-9-20-18-45°-S-01-L-UFK2	L	2,0	18	0,1	0,5

Holder system 2-7 (Holder on page 6)

Item no.	Designation		b	t _{max}	R	a
142345	KP-2-7-10-10-45°-S-01-R-UFK2	R	1,0	10	0,1	0,25
142871	KP-2-7-10-10-45°-S-01-L-UFK2	L	1,0	10	0,1	0,25
143735	KP-2-7-15-10-45°-S-01-R-UFK2	R	1,5	10	0,1	0,25
144023	KP-2-7-15-10-45°-S-01-L-UFK2	L	1,5	10	0,1	0,25

Right-hand version shown

PTFE
POM
PA
PVC
PP
PEEK
PMMA
PC
PPS

PTFE
POM
PA
PVC
PP
PEEK
PMMA
PC
PPS

Parting off systems Machining Inserts

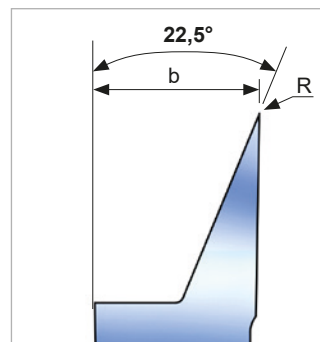
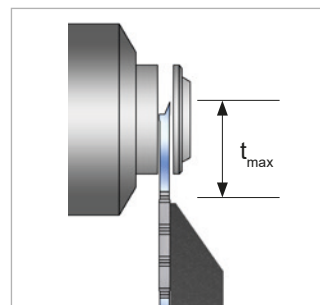
New Geometry

225

Holder system 2-9 (Holder on page 6)

PTFE
POM
PA
PVC
PP
PEEK
PMMA
PC
PPS

Item no.	Designation		b	t _{max}	R
198671	KP-2-9-10-12-225-R-UFK2	R	1,0	12	0
198670	KP-2-9-15-18-225-R-UFK2	R	1,5	18	0
198669	KP-2-9-20-18-225-R-UFK2	R	2,0	18	0



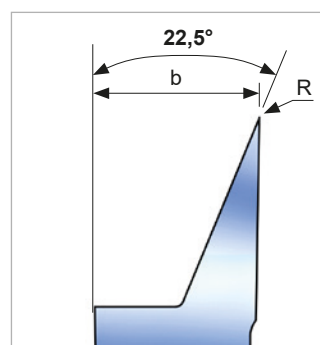
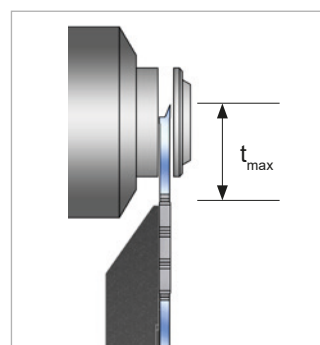
Right-hand Insert
Alignment right

225-S5

Holder system 2-7 (Holder on page 6)

PTFE
POM
PA
PVC
PP
PEEK
PMMA
PC
PPS

Item no.	Designation		b	t _{max}	R
198674	KP-2-9-10-12-225-S5-L-UFK2	R	1,0	12	0
198673	KP-2-9-15-18-225-S5-L-UFK2	R	1,5	18	0
198672	KP-2-9-20-18-225-S5-L-UFK2	R	2,0	18	0



Left-hand Insert
Alignment right (S5)



Parting off systems Machining Inserts

S1

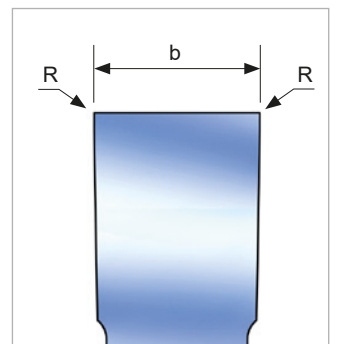
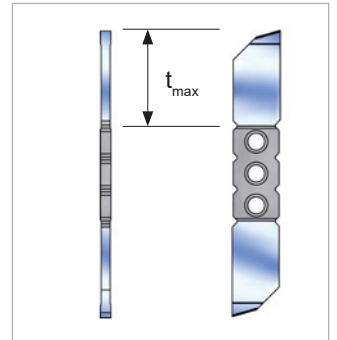
PTFE
POM
PA
PVC
PP
PEEK
PMMA
PC
PPS

Holder system 2-9 (Holder on page 6)

Item no.	Designation		b	t _{max}	R
133300	KP-2-9-08-12-S1-R-UFK2	R	0,8	12	0
134214	KP-2-9-08-12-S1-L-UFK2	L	0,8	12	0
133299	KP-2-9-10-12-S1-R-UFK2	R	1,0	12	0
134213	KP-2-9-10-12-S1-L-UFK2	L	1,0	12	0
133295	KP-2-9-15-18-S1-R-UFK2	R	1,5	18	0
140414	KP-2-9-15-18-S1-L-UFK2	L	1,5	18	0
133294	KP-2-9-20-18-S1-R-UFK2	R	2,0	18	0
134624	KP-2-9-20-18-S1-L-UFK2	L	2,0	18	0

Holder system 2-7 (Holder on page 6)

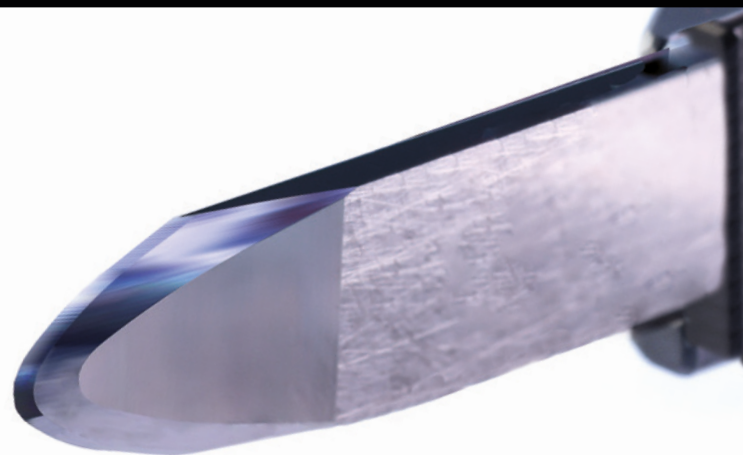
Item no.	Designation		b	t _{max}	R
180111	KP-2-7-05-06-S1-R-UFK2	R	0,5	6	0
180112	KP-2-7-05-06-S1-L-UFK2	L	0,5	6	0
131081	KP-2-7-08-10-S1-R-UFK2	R	0,8	10	0
135278	KP-2-7-08-10-S1-L-UFK2	L	0,8	10	0
131973	KP-2-7-10-10-S1-R-UFK2	R	1,0	10	0
134430	KP-2-7-10-10-S1-L-UFK2	L	1,0	10	0



Right-hand version shown

Still deeper parting?

- Insertion depths (t_{max}) up to 25 mm with KBS-2-9-L25
- Insertion width (b) up to 3 mm with KBS-3-9
- Insertion depths (t_{max}) up to 45 mm and above are feasible



www.dieterle-tools.de/easy-request/



Parting off systems Machining Inserts

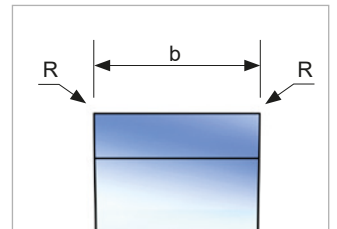
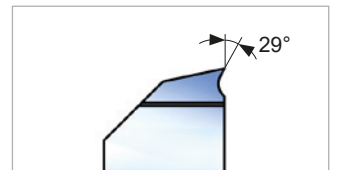
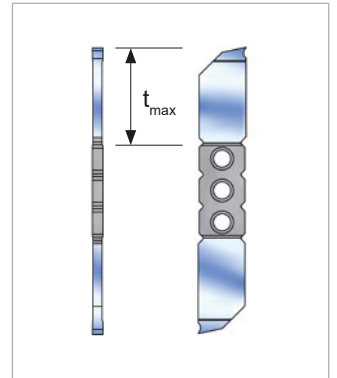
S1-SP with large positive top rake angle

Holder system 2-9 (Holder on page 6)

Item no.	Designation		b	t _{max}	R
133293	KP-2-9-08-12-S1-SP-R-UFK2	R	0,8	12	0
160317	KP-2-9-08-12-S1-SP-L-UFK2	L	0,8	12	0
133288	KP-2-9-10-16-S1-SP-R-UFK2	R	1,0	16	0
149189	KP-2-9-10-16-S1-SP-L-UFK2	L	1,0	16	0
133285	KP-2-9-15-18-S1-SP-R-UFK2	R	1,5	18	0
134907	KP-2-9-15-18-S1-SP-L-UFK2	L	1,5	18	0
133284	KP-2-9-20-18-S1-SP-R-UFK2	R	2,0	18	0
134625	KP-2-9-20-18-S1-SP-L-UFK2	L	2,0	18	0

Holder system 2-7 (Holder on page 6)

Item no.	Designation		b	t _{max}	R
180116	KP-2-7-05-06-S1-SP-R-UFK2	R	0,5	6	0
180115	KP-2-7-05-06-S1-SP-L-UFK2	L	0,5	6	0
133359	KP-2-7-08-10-S1-SP-R-UFK2	R	0,8	10	0
134839	KP-2-7-08-10-S1-SP-L-UFK2	L	0,8	10	0
133358	KP-2-7-10-10-S1-SP-R-UFK2	R	1,0	10	0
134431	KP-2-7-10-10-S1-SP-L-UFK2	L	1,0	10	0



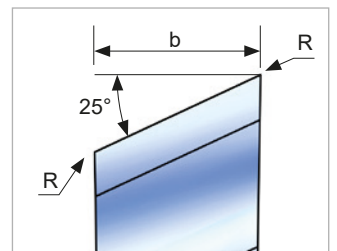
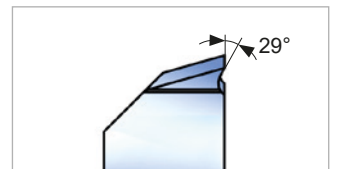
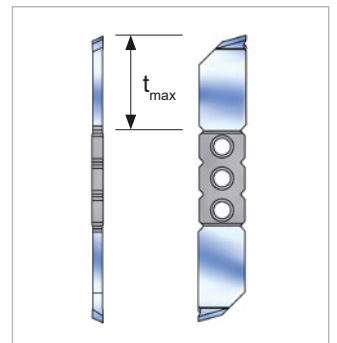
S2-SP2 with top rake angle and 25° cutting-off direction

Holder system 2-9 (Holder on page 6)

Item no.	Designation		b	t _{max}	R
180124	KP-2-9-08-10-S2-SP2-R-UFK2	R	0,8	10	0
180125	KP-2-9-08-10-S2-SP2-L-UFK2	L	0,8	10	0
153401	KP-2-9-10-16-S2-SP2-R-UFK2	R	1,0	16	0
180123	KP-2-9-10-16-S2-SP2-L-UFK2	L	1,0	16	0
180121	KP-2-9-15-18-S2-SP2-R-UFK2	R	1,5	18	0
180122	KP-2-9-15-18-S2-SP2-L-UFK2	L	1,5	18	0
144774	KP-2-9-20-18-S2-SP2-R-UFK2	R	2,0	18	0
145957	KP-2-9-20-18-S2-SP2-L-UFK2	L	2,0	18	0

Holder system 2-7 (Holder on page 6)

Item no.	Designation		b	t _{max}	R
180117	KP-2-7-05-06-S2-SP2-R-UFK2	R	0,5	6	0
180118	KP-2-7-05-06-S2-SP2-L-UFK2	L	0,5	6	0
178991	KP-2-7-10-10-S2-SP2-R-UFK2	R	1,0	10	0
178992	KP-2-7-10-10-S2-SP2-L-UFK2	L	1,0	10	0
180120	KP-2-7-15-10-S2-SP2-R-UFK2	R	1,5	10	0
180119	KP-2-7-15-10-S2-SP2-L-UFK2	L	1,5	10	0



Right-hand version shown



Parting off systems Machining Inserts

S1-PCD

Plastics
with
fillers
GFK
CFK

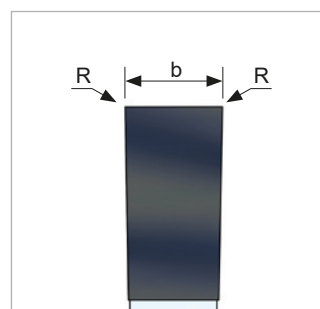
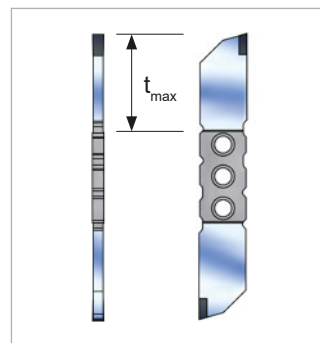
Holder system 2-9 (Holder on page 6)

Item no.	Designation		b	t _{max}	R
180138	KP-2-9-10-18-S1-R-PKD	R	1,0	18	0
182500	KP-2-9-10-18-S1-L-PKD	L	1,0	18	0
180137	KP-2-9-15-18-S1-R-PKD	R	1,5	18	0
178005	KP-2-9-15-18-S1-L-PKD	L	1,5	18	0
174540	KP-2-9-20-18-S1-R-PKD	R	2,0	18	0
182501	KP-2-9-20-18-S1-L-PKD	L	2,0	18	0

Holder system 2-7 (Holder on page 6)

Item no.	Designation		b	t _{max}	R
181154	KP-2-7-08-10-S1-R-PKD	R	0,8	10	0
182496	KP-2-7-08-10-S1-L-PKD	L	0,8	10	0
181155	KP-2-7-10-10-S1-R-PKD	R	1,0	10	0
182497	KP-2-7-10-10-S1-L-PKD	L	1,0	10	0

supply on demand



PCD with 15° cutting-off direction

Plastics
with
fillers
GFK
CFK

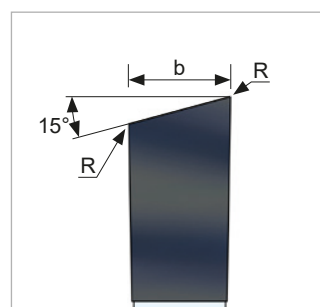
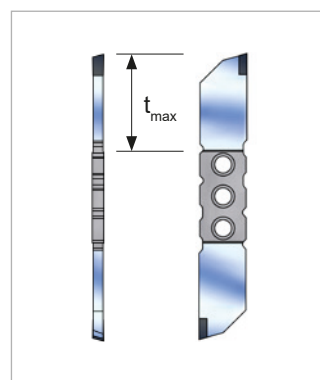
Holder system 2-9 (Holder on page 6)

Item no.	Designation		b	t _{max}	R
160043	KP-2-9-08-18-R-PKD	R	0,8	18	0
182502	KP-2-9-08-18-L-PKD	L	0,8	18	0
160053	KP-2-9-10-18-R-PKD	R	1,0	18	0
182503	KP-2-9-10-18-L-PKD	L	1,0	18	0
160054	KP-2-9-15-18-R-PKD	R	1,5	18	0
182504	KP-2-9-15-18-L-PKD	L	1,5	18	0
180135	KP-2-9-20-18-R-PKD	R	2,0	18	0
182505	KP-2-9-20-18-L-PKD	L	2,0	18	0

Holder system 2-7 (Holder on page 6)

Item no.	Designation		b	t _{max}	R
180136	KP-2-7-08-10-R-PKD	R	0,8	10	0
182498	KP-2-7-08-10-L-PKD	L	0,8	10	0
172872	KP-2-7-10-10-R-PKD	R	1,0	10	0
182499	KP-2-7-10-10-L-PKD	L	1,0	10	0

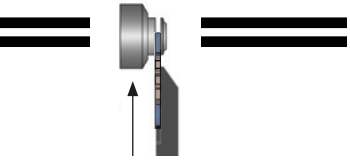
supply on demand



Right-hand version shown

Parting off systems

Tool Holder KH-H

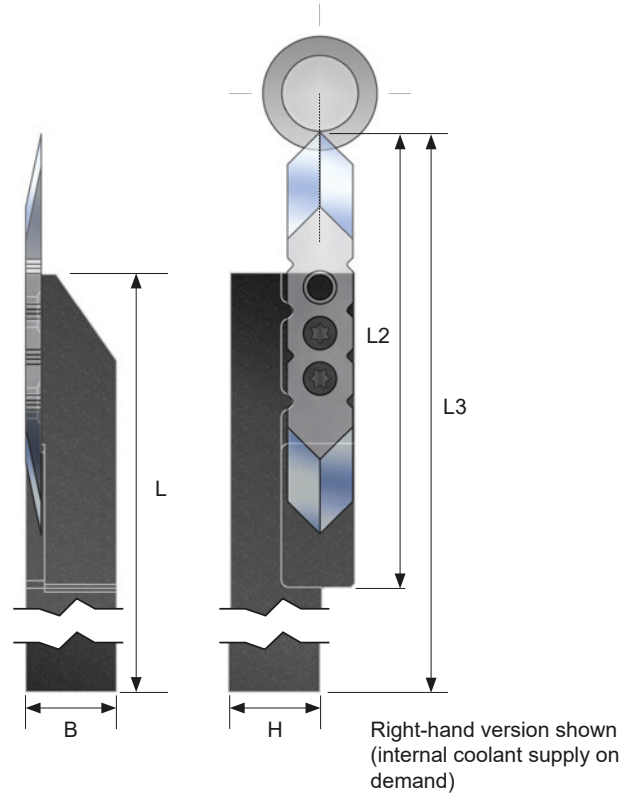


Holder KH-H for conventional automatic lathes

These Dieterle holders account for the tip height on conventional lathes. The elevated plate seat of the „KH-H“ holder compensates for the non-adjustable Y-axis. Thus they are ideal for lathes with a fixed tool holder.

Screws: S-3080-30-KP
Item no. 138657

Key: T8
Item no. 103603



Holder system 2-9

Item no.	Designation		H	B	L	L2	L3
148535	KH-2-9-1010-H-R	R	10	10	110	54,5 - 60,5	123 - 129
148529	KH-2-9-1010-H-L	L	10	10	110	54,5 - 60,5	123 - 129
148537	KH-2-9-1212-H-R	R	12	12	110	54,5 - 60,5	123 - 129
148536	KH-2-9-1212-H-L	L	12	12	110	54,5 - 60,5	123 - 129
148540	KH-2-9-1616-H-R	R	16	16	110	54,5 - 60,5	123 - 129
148539	KH-2-9-1616-H-L	L	16	16	110	54,5 - 60,5	123 - 129
148542	KH-2-9-2020-H-R	R	20	20	110	54,5 - 60,5	123 - 129
148541	KH-2-9-2020-H-L	L	20	20	110	54,5 - 60,5	123 - 129

Holder system 2-7

Item no.	Designation		H	B	L	L2	L3
148544	KH-2-7-0808-H-R	R	8	8	110	38,5 - 44,5	117 - 123
148543	KH-2-7-0808-H-L	L	8	8	110	38,5 - 44,5	117 - 123
148547	KH-2-7-1010-H-R	R	10	10	110	38,5 - 44,5	117 - 123
148545	KH-2-7-1010-H-L	L	10	10	110	38,5 - 44,5	117 - 123
148551	KH-2-7-1212-H-R	R	12	12	110	38,5 - 44,5	117 - 123
148549	KH-2-7-1212-H-L	L	12	12	110	38,5 - 44,5	117 - 123
148553	KH-2-7-1616-H-R	R	16	16	110	38,5 - 44,5	117 - 123
148552	KH-2-7-1616-H-L	L	16	16	110	38,5 - 44,5	117 - 123
165722	KH-2-7-2020-H-R	R	20	20	110	38,5 - 44,5	117 - 123
165721	KH-2-7-2020-H-L	L	20	20	110	38,5 - 44,5	117 - 123

Parting off systems Chipless-Cutting

Dieterle tools for scoring and trimming work particularly well on soft plastics such as elastomers. The knife-like cutting geometries

enable nearly burr-free separation of the work-pieces from the stock with a fine blade.

RX

Holder system 2-9 (Holder on page 12)

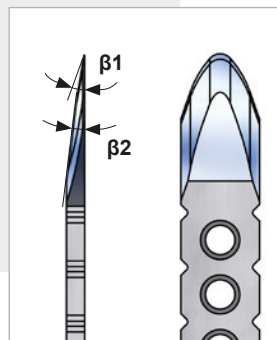
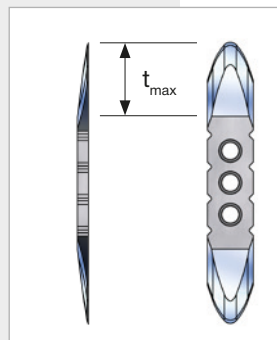
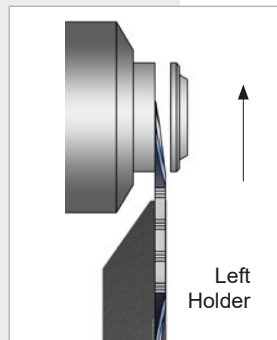
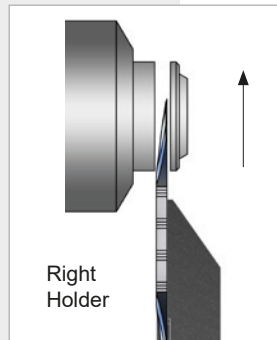
Item no.	Designation		t _{max}	β ₁	β ₂
143100	KP-2-9-RX-A-UFK2	A	18	20°	7°
138679	KP-2-9-RX-B-UFK2	B	18	20°	7°

Holder system 2-7 (Holder on page 12)

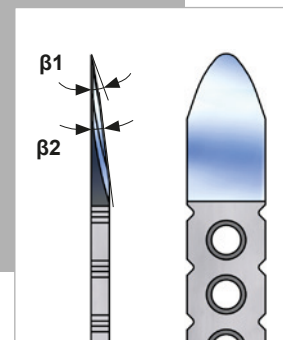
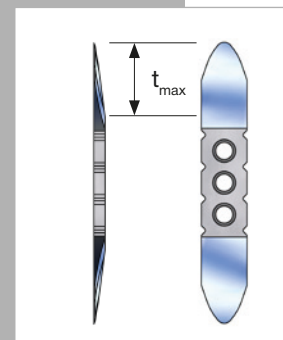
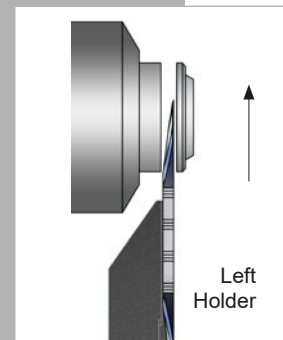
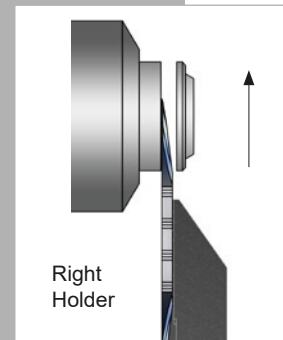
Item no.	Designation		t _{max}	β ₁	β ₂
143446	KP-2-7-RX-A-UFK2	A	10	20°	7°
143447	KP-2-7-RX-B-UFK2	B	10	20°	7°

PUR
POM
PVC
PP
PE-HD
PEEK
Vulkollan
PET
PEI

Version A



Version B



Parting off systems Chipless-Cutting

VG

Holder system 2-9 (Holder on page 12)

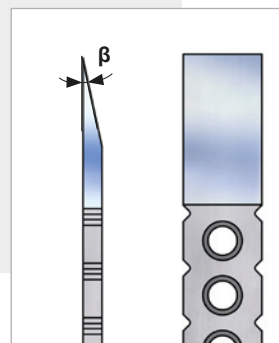
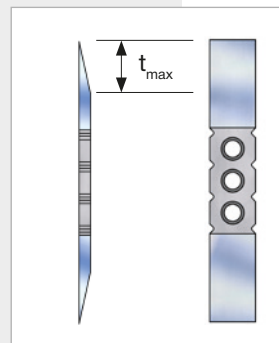
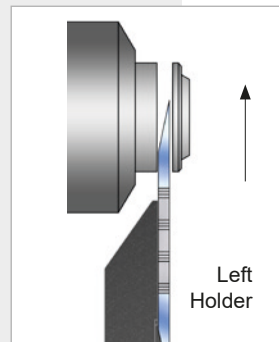
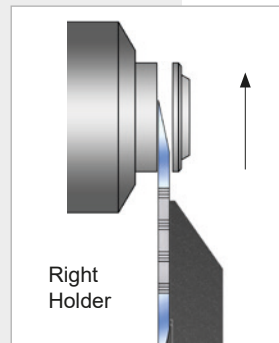
Item no.	Designation		t _{max}	β
133099	KP-2-9-12°-VG-12-18-A-UFK2	A	18	12°
133548	KP-2-9-12°-VG-12-18-B-UFK2	B	18	12°

Holder system 2-7 (Holder on page 12)

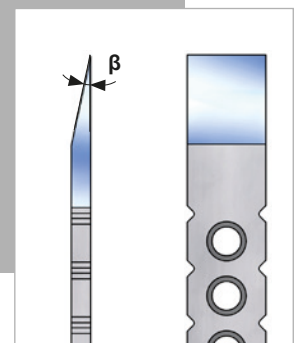
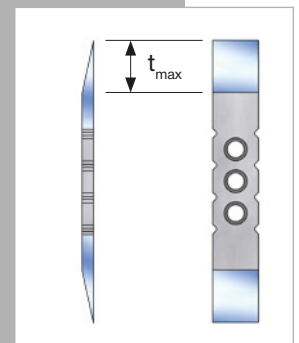
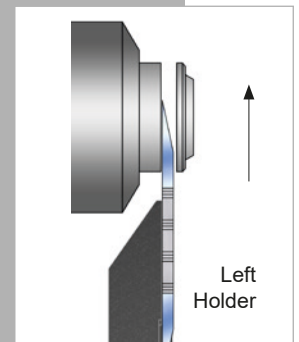
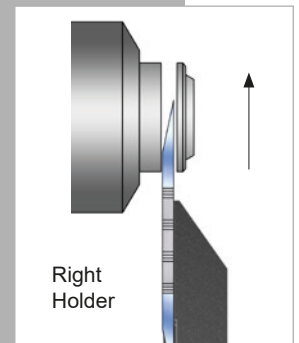
Item no.	Designation		t _{max}	β
161353	KP-2-7-12°-VG-10-A-UFK2	A	10	12°
137125	KP-2-7-12°-VG-10-B-UFK2	B	10	12°

PUR
POM
PVC
PP
PE-HD
PEEK
Vulkollan
PET
PEI

Version A



Version B



Parting off systems Chipless-Cutting

12°

Holder system 2-9 (Holder on page 12)

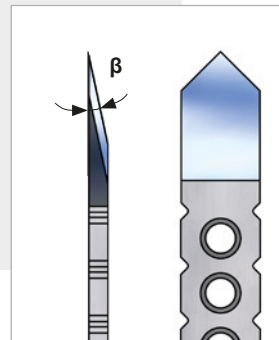
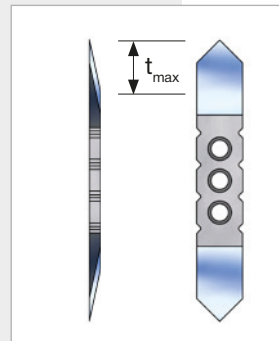
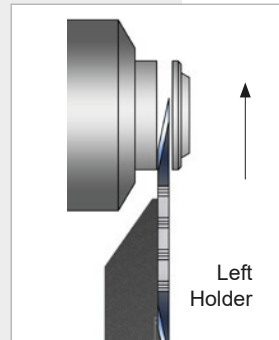
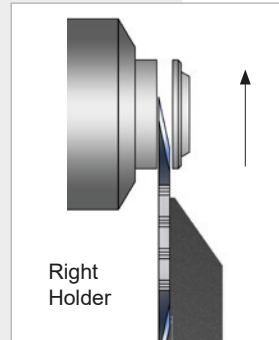
Item no.	Designation		t _{max}	β
133100	KP-2-9-12°-12-18-A-UFK2	A	18	12°
133546	KP-2-9-12°-12-18-B-UFK2	B	18	12°

Holder system 2-7 (Holder on page 12)

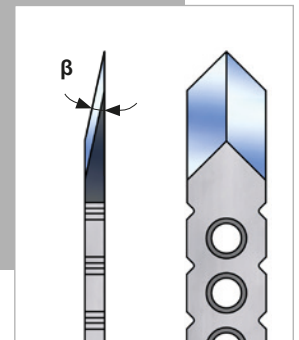
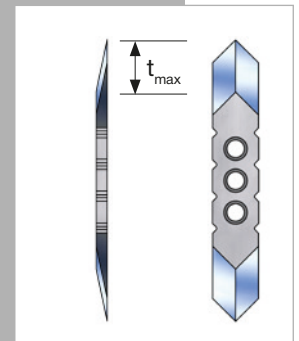
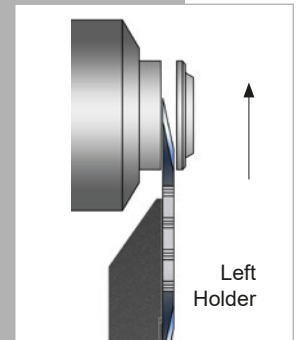
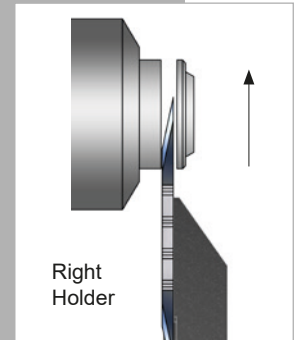
Item no.	Designation		t _{max}	β
145471	KP-2-7-12°-12-A-UFK2	A	10	12°
145472	KP-2-7-12°-12-B-UFK2	B	10	12°

PUR
POM
PVC
PP
PE-HD
PEEK
Vulkollan
PET
PEI

Version A



Version B



Parting off systems Chipless-Cutting

R3

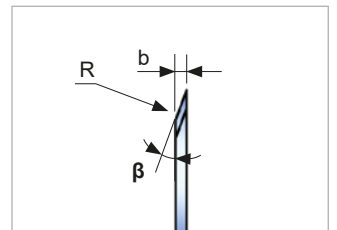
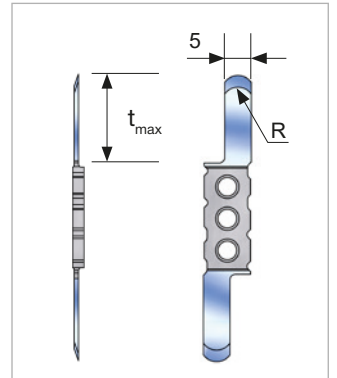
PUR
POM
PVC
PP
PE-HD
PEEK
Vulkollan
PET
PEI

Holder system 2-9

Item no.	Designation		b	t _{max}	R	β
131971	KP-2-9-08-R3-12-R-UFK2	R	0,8	12	3	20°
133544	KP-2-9-08-R3-12-L-UFK2	L	0,8	12	3	20°
131972	KP-2-9-08-R3-16-R-UFK2	R	0,8	16	3	20°
133545	KP-2-9-08-R3-16-L-UFK2	L	0,8	16	3	20°

Holder system 2-7

Item no.	Designation		b	t _{max}	R	β
131970	KP-2-7-08-R3-8-R-UFK2	R	0,8	8	3	20°
134840	KP-2-7-08-R3-8-L-UFK2	L	0,8	8	3	20°

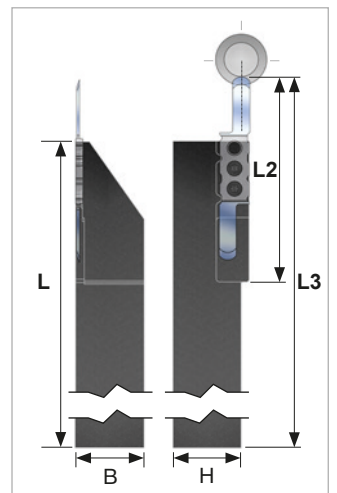


Holder KH-H1 for conventional automatic lathes

These Dieterle holders account for the tip height on conventional lathes. The elevated plate seat of the „KH-H1“ holder compensates for the non-adjustable Y-axis.

Screws: S-3080-30-KP
Item no. 138657

Key: T8
Item no. 103603



Right-hand version shown
(internal coolant supply on demand)

Holder system 2-9 (for chipless-cutting insert R3)

Item no.	Designation		H	B	L	L2	L3
165829	KH-2-9-2020-H1-R	R	20	20	110	54,5 - 60,5	123 - 129
165828	KH-2-9-2020-H1-L	L	20	20	110	54,5 - 60,5	123 - 129

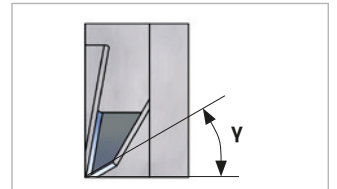
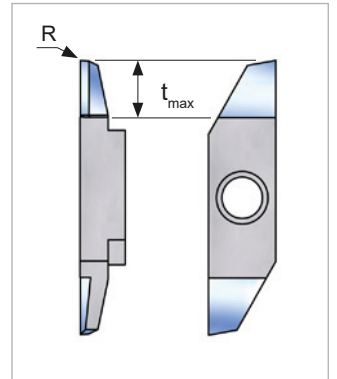
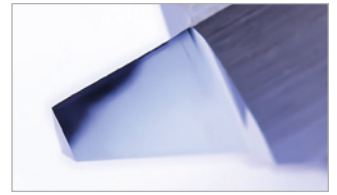
Holder system 2-7 (for chipless-cutting insert R3)

Item no.	Designation		H	B	L	L2	L3
165831	KH-2-7-2020-H1-R	R	20	20	125	38,5 - 44,5	117 - 123
165830	KH-2-7-2020-H1-L	L	20	20	125	38,5 - 44,5	117 - 123



Holder system SSXA-T06 (Holder below)

Item no.	Designation		#	t _{max}	Y	R
178219	SALP-T06-KP-05-R-G1A-FK	R	2	5	60°	0
179304	SALP-T06-KP-05-L-G1A-FK	L	2	5	60°	0
196590	SALP-T06-KP-3SP-R0-R-FK	R	2	5	30°	0
197210	SALP-T06-KP-3SP-R003-R-FK	R	2	5	30°	0,03
198881	SALP-T06-KP-3SP-R01-R-FK	R	2	5	30°	0,1
192254	SALP-T06-KP-3SP-R02-R-FK	R	2	5	30°	0,2

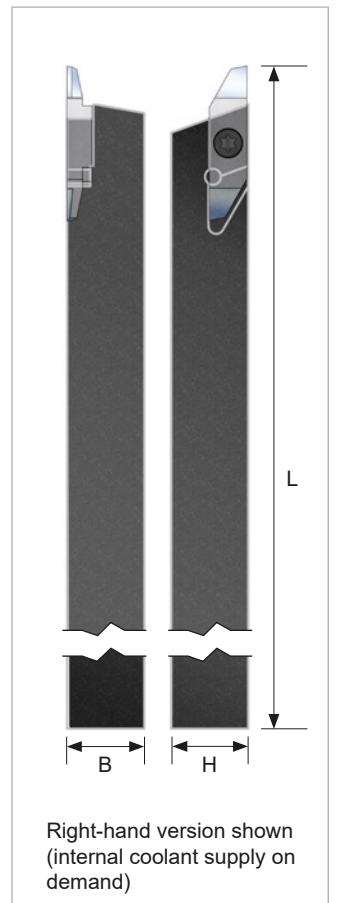


SSXA-T06.. Holder

Screws: S-3080-30°
Item no. 102612

Key: T8
Item no. 103603

Item no.	Designation		H	B	L
103510	SSXA-T06-0808-R	R	8	8	140
103509	SSXA-T06-0808-L	L	8	8	140
103512	SSXA-T06-1010-R	R	10	10	140
103511	SSXA-T06-1010-L	L	10	10	140
103514	SSXA-T06-1212-R	R	12	12	140
103513	SSXA-T06-1212-L	L	12	12	140



Right-hand version shown
(internal coolant supply on demand)

PUR
POM
PVC
PP
PE-HD
PEEK
Vulkollan
PET
PEI

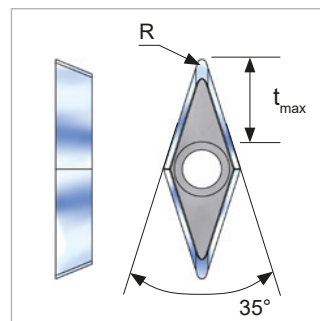


Copy Turning KP-VCGT-11

New! Corner Radius R0.2

KP-VCGT-11 (Holder below)

Item no.	Designation		#	t _{max}	R
198711	KP-VCGT-11-S-02-K10	N	2	7	0,2
140952	KP-VCGT-11-S-04-K10	N	2	7	0,4

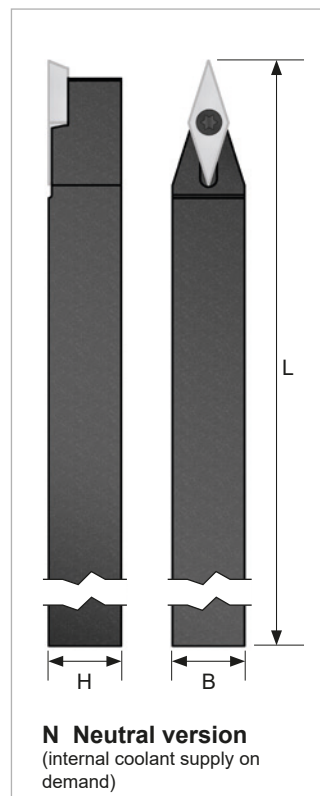
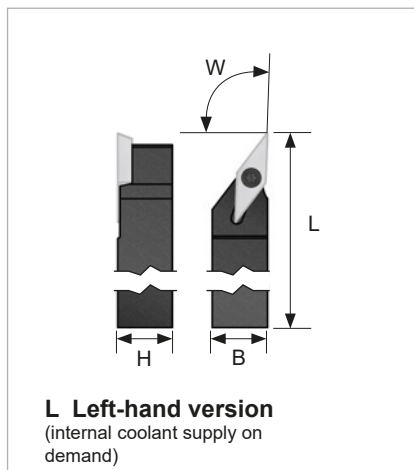
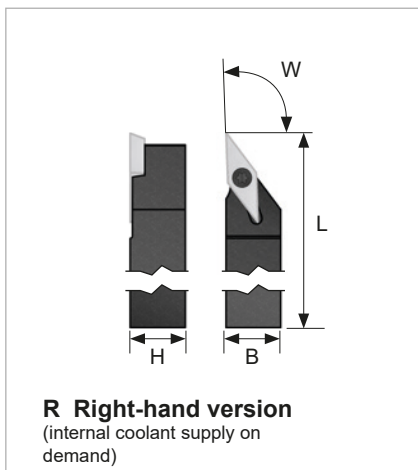


SDAC-KP-11 Holder

Screws: M2,5 x 7
Item no. 102206

Key: T7
Item no. 103602

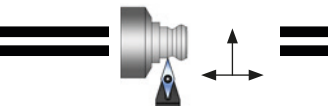
Item no.	Designation		H	B	L	W
103290	SDAC-1135-0808-N	N	8	8	140	-
103210	SDAC-1135-0808-R	R	8	8	140	92°
103209	SDAC-1135-0808-L	L	8	8	140	92°
103291	SDAC-1135-1010-N	N	10	10	140	-
103212	SDAC-1135-1010-R	R	10	10	140	92°
103211	SDAC-1135-1010-L	L	10	10	140	92°
103246	SDAC-1135-1212-N	N	12	12	140	-
103214	SDAC-1135-1212-R	R	12	12	140	92°
103213	SDAC-1135-1212-L	L	12	12	140	92°
103292	SDAC-1135-1616-N	N	16	16	125	-
103218	SDAC-1135-1616-R	R	16	16	125	92°
103217	SDAC-1135-1616-L	L	16	16	125	92°



PUR
PTFE
POM
PA
PVC
PP
PEEK
Vulkollan
PMMA
PC
PVDF
PET
PEI
PPS



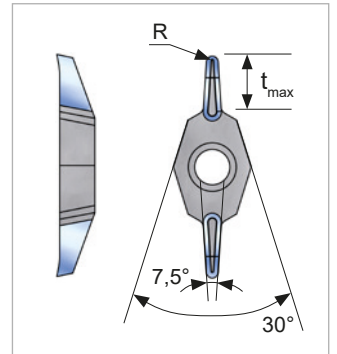
Copy Turning KP-VCGT-16



KP-VCGT-16 (Holder below)

Item no.	Designation		#	t _{max}	R
140953	KP-VCGT-16-S-K10	N	2	6,2	0,78

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PTFE
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PA
PVC
PP
PEEK
PMMA
PC
PVDF
PET
PPS

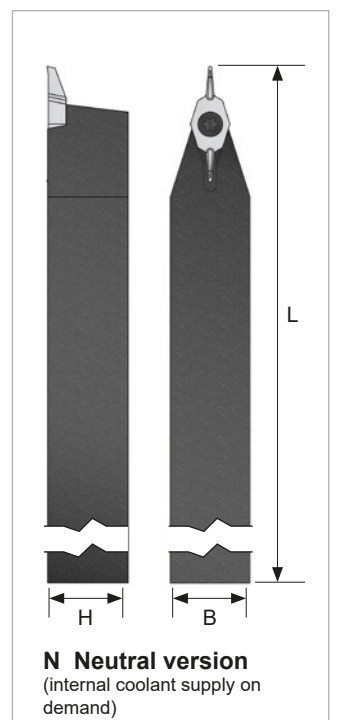
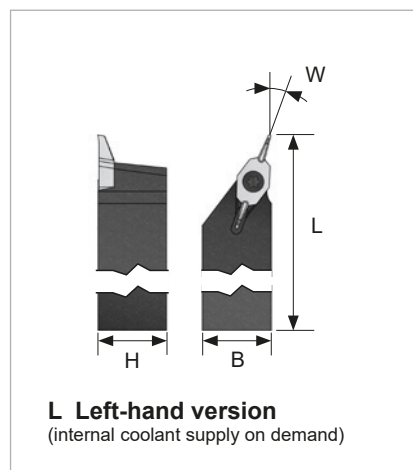
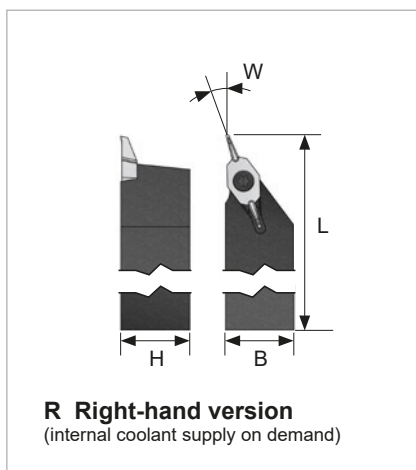


SDAC-KP-16 Holder

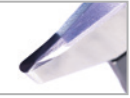
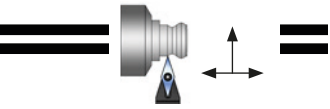
Screws: M4 x 9,5
Item no. 102217

Key: T15
Item no. 107482

Item no.	Designation		H	B	L	W
169030	SDAC-KP-1635-1212-N	N	12	12	100	-
169022	SDAC-KP-1635-1616-N	N	16	16	100	-
169020	SDAC-KP-1635-1616-R	R	16	16	100	20°
169021	SDAC-KP-1635-1616-L	L	16	16	100	20°
169024	SDAC-KP-1635-2020-N	N	20	20	100	-
169025	SDAC-KP-1635-2020-R	R	20	20	100	20°
169031	SDAC-KP-1635-2020-L	L	20	20	100	20°



Copy Turning KP-VCGT-22



KP-VCGT-22 (Holder below)

Item no.	Designation		#	t _{max}	R
170085	KP-VCGT-22-S-K10	N	2	10,5	0,7

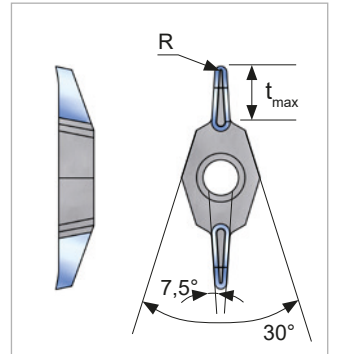


PUR
PTFE
POM
PA
PVC
PP
PEEK
PMMA
PC
PVDF
PET
PPS

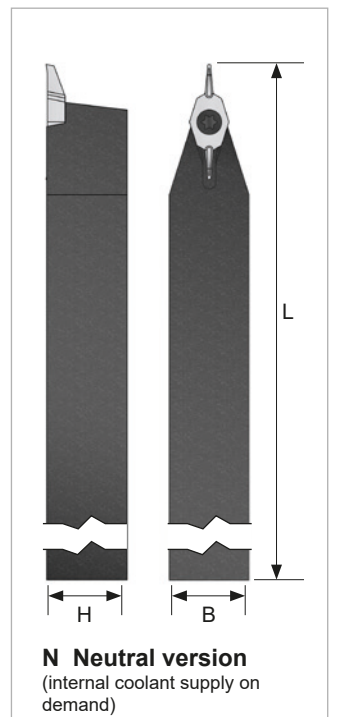
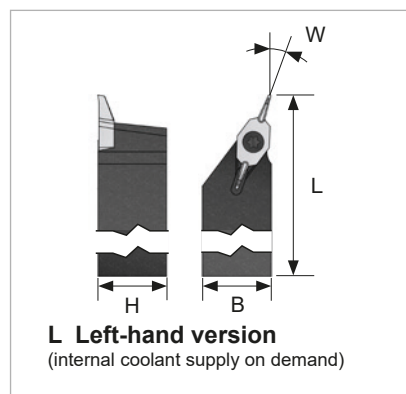
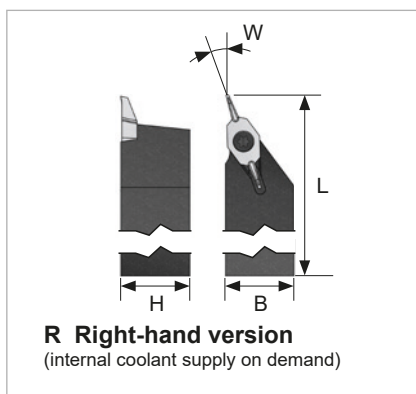
SDAC-KP-22 Holder

Screws: M5 x 13
Item no. 102219

Key: T25
Item no. 103599

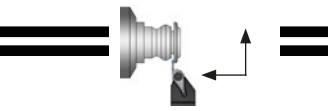


Item no.	Designation		H	B	L	W
170420	SDAC-KP-2235-1616-N	N	16	16	100	-
171093	SDAC-KP-20-2235-1616-R	R	16	16	100	20°
171092	SDAC-KP-20-2235-1616-L	L	16	16	100	20°
171095	SDAC-KP-45-2235-1616-R	R	16	16	100	45°
171094	SDAC-KP-45-2235-1616-L	L	16	16	100	45°
170419	SDAC-KP-2235-2020-N	N	20	20	100	-
170421	SDAC-KP-20-2235-2020-R	R	20	20	100	20°
171090	SDAC-KP-20-2235-2020-L	L	20	20	100	20°
171098	SDAC-KP-45-2235-2020-R	R	20	20	100	45°
171096	SDAC-KP-45-2235-2020-L	L	20	20	100	45°
170423	SDAC-KP-2235-2525-N	N	25	25	100	-
170422	SDAC-KP-20-2235-2525-R	R	25	25	100	20°
171091	SDAC-KP-20-2235-2525-L	L	25	25	100	20°
171100	SDAC-KP-45-2235-2525-R	R	25	25	100	45°
171099	SDAC-KP-45-2235-2525-L	L	25	25	100	45°
171097	SDAC-KP-2235-3232-N	N	32	32	100	-
171104	SDAC-KP-20-2235-3232-R	R	32	32	100	20°
171103	SDAC-KP-20-2235-3232-L	L	32	32	100	20°
171102	SDAC-KP-45-2235-3232-R	R	32	32	100	45°
171101	SDAC-KP-45-2235-3232-L	L	32	32	100	45°



Grooving - Turning - Copy Turning

KP-VCGT-07.. / KP-VCGT-13..



PUR
PTFE
POM
PA
PVC
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PEEK
PMMA
PC
PVDF
PET
PPS

KP-VCGT-07.. (Holder below)

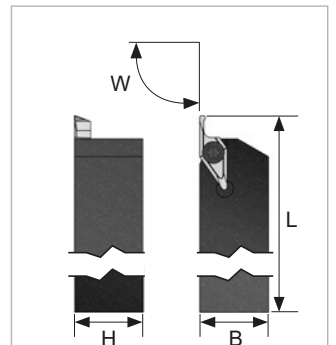
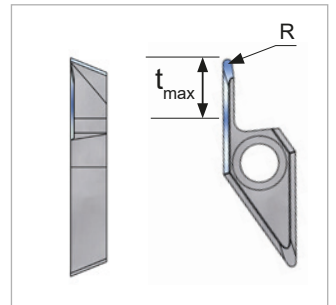
Item no.	Designation		#	t _{max}	R
180051	KP-VCGT-070202-S02-R	R	1	2,8	0,2
180052	KP-VCGT-070204-S02-R	R	1	2,8	0,4

SDAC-KP-07 Holder

Screws: M2050
Item no. 102238

Key: T6
Item no. 103601

Item no.	Designation		H	B	L	W
180183	SDAC-KP-90-0735-0808-R	R	8	8	140	90°
180184	SDAC-KP-90-0735-1010-R	R	10	10	140	90°



R Right-hand version
(internal coolant supply on demand)

KP-VCGT-13.. (Holder below)

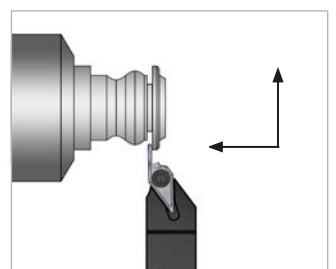
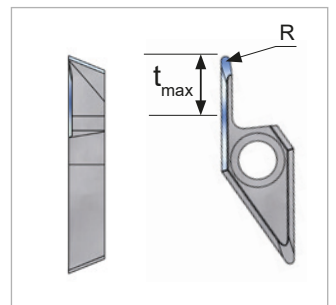
Item no.	Designation		#	t _{max}	R
179913	KP-VCGT-130302-S02-R	R	1	5,5	0,2
179914	KP-VCGT-130304-S02-R	R	1	5,5	0,4

SDAC-KP-13 Holder

Screws: M2050
Item no. 102238

Key: T6
Item no. 103601

Item no.	Designation		H	B	L	W
180181	SDAC-KP-90-1335-1616-R	R	16	16	125	90°
180182	SDAC-KP-90-1335-2020-R	R	20	20	125	90°





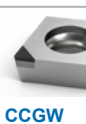
ISO indexable inserts Plastic-processing holder

CC..-06..

Screws: M2,5 x 7
Item no. 102206

Key: T7
Item no. 103602

Item no.	Designation		H	B	L	W
103326	SLHC-06-0808-R	R	8	8	140	92°
103325	SLHC-06-0808-L	L	8	8	140	92°
103328	SLHC-06-1010-R	R	10	10	140	92°
103327	SLHC-06-1010-L	L	10	10	140	92°
103330	SLHC-06-1212-R	R	12	12	140	92°
103329	SLHC-06-1212-L	L	12	12	140	92°
103332	SLHC-06-1616-R	R	16	16	125	92°
103331	SLHC-06-1616-L	L	16	16	125	92°



DC..-07..

Screws: M2,5 x 7
Item no. 102206

Key: T7
Item no. 103602

Item no.	Designation		H	B	L	W
103288	SDAC-0755-0808-N	N	8	8	140	-
103204	SDAC-0755-0808-R	R	8	8	140	92°
103203	SDAC-0755-0808-L	L	8	8	140	92°
103289	SDAC-0755-1010-N	N	10	10	140	-
103206	SDAC-0755-1010-R	R	10	10	140	92°
103205	SDAC-0755-1010-L	L	10	10	140	92°
103245	SDAC-0755-1212-N	N	12	12	140	-
103208	SDAC-0755-1212-R	R	12	12	140	92°
103207	SDAC-0755-1212-L	L	12	12	140	92°

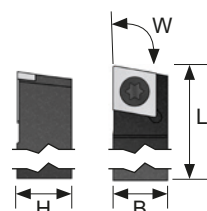
DC..-11T3..

Screws: M4 x 9,5
Item no. 102217

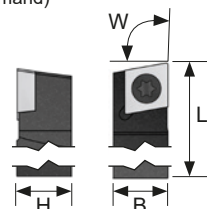
Key: T15
Item no. 107482

Item no.	Designation		H	B	L	W
103294	SDAC-1155-1010-N	N	10	10	140	-
103295	SDAC-1155-1212-N	N	12	12	140	-
103248	SDAC-1155-1212-R	R	12	12	140	92°
103247	SDAC-1155-1212-L	L	12	12	140	92°
103297	SDAC-1155-1616-N	N	16	16	125	-
103224	SDAC-1155-1616-R	R	16	16	125	92°
103223	SDAC-1155-1616-L	L	16	16	125	92°
103250	SDAC-1155-2020-N	N	20	20	125	-
103251	SDAC-1155-2020-R	R	20	20	125	92°
103249	SDAC-1155-2020-L	L	20	20	125	92°

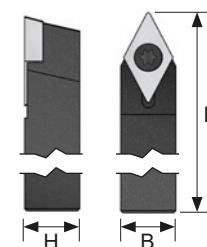
Directions of rotation



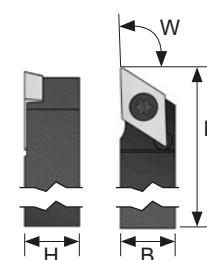
R Right-hand version
(internal coolant supply on demand)



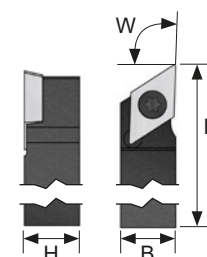
L Left-hand version
(internal coolant supply on demand)



N Neutral version
(internal coolant supply on demand)



R Right-hand version
(internal coolant supply on demand)



L Left-hand version
(internal coolant supply on demand)





ISO indexable inserts Plastic-processing holder

VC..-07..

Screws: M2050
Item no. 102238

Key: T6
Item no. 103601

Item no.	Designation		H	B	L	W
108894	SDAC-0735-1010-N	N	10	10	140	-
108896	SDAC-0735-1010-R	R	10	10	140	92°
108899	SDAC-0735-1010-L	L	10	10	140	92°
108897	SDAC-0735-1212-R	R	12	12	140	92°
108900	SDAC-0735-1212-L	L	12	12	140	92°

VC..-13..

Screws: M3x7,2
Item no. 102210

Key: T9
Item no. 103604

Item no.	Designation		H	B	L	W
103252	SDAC-1335-1010-N	N	10	10	140	-
103299	SDAC-1335-1212-N	N	12	12	140	-
103226	SDAC-1335-1212-R	R	12	12	140	92°
103225	SDAC-1335-1212-L	L	12	12	140	92°
103301	SDAC-1335-1616-N	N	16	16	125	-
103232	SDAC-1335-1616-R	R	16	16	125	92°
103231	SDAC-1335-1616-L	L	16	16	125	92°
103254	SDAC-1335-2020-N	N	20	20	125	-
103255	SDAC-1335-2020-R	R	20	20	125	92°
103253	SDAC-1335-2020-L	L	20	20	125	92°

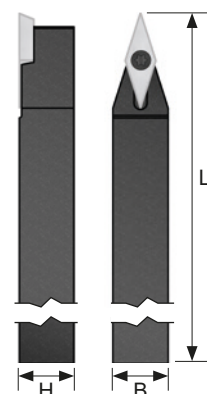
VC..-16..

Screws: M4 x 9,5
Item no. 102217

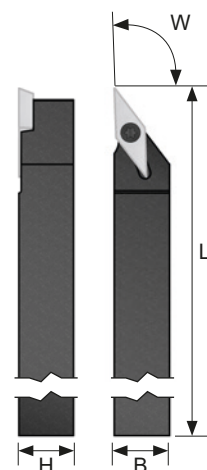
Key: T15
Item no. 107482

Item no.	Designation		H	B	L	W
103256	SDAC-1635-1212-N	N	12	12	140	-
103306	SDAC-1635-1616-N	N	16	16	125	-
103242	SDAC-1635-1616-R	R	16	16	125	92°
103241	SDAC-1635-1616-L	L	16	16	125	92°
103307	SDAC-1635-2020-N	N	20	20	125	-
103244	SDAC-1635-2020-R	R	20	20	125	92°
103243	SDAC-1635-2020-L	L	20	20	125	92°

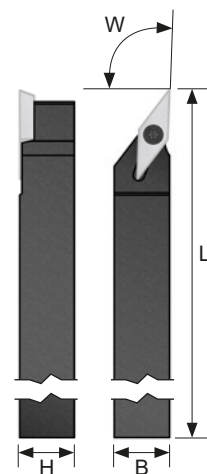
Directions of rotation



N Neutral version
(internal coolant supply on demand)

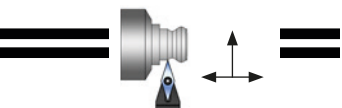


R Right-hand version
(internal coolant supply on demand)

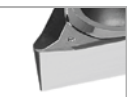


L Left-hand version
(internal coolant supply on demand)





Copy Turning ISO-Indexable Inserts



Plastic processing with CCGT I DCGT

When machining plastics, one thing is particularly important: extreme sharpness. For the most common ISO geometries, we offer

indexable inserts in our plastic program that deliver the best results in plastics.

CCGT - ALU (Holder on page 22)

Item no.	Designation	#	R	α
100836	CCGT-060202-N-ALU-FA-G7B-K10	2	0,20	7°
100839	CCGT-060204-N-ALU-FA-G7B-K10	2	0,40	7°

CCGT - AWI (Holder on page 22)

Item no.	Designation	#	R	α
115738	CCGT-060204-N-AWI-FA-G7B-K10	2	0,40	7°

DCGT - ALU (Holder on page 22)

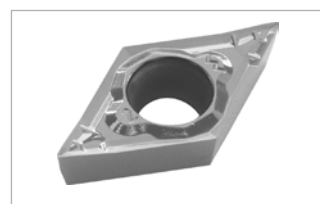
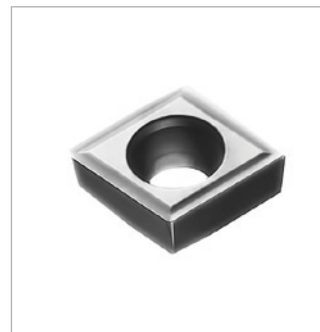
Item no.	Designation	#	R	α
177138	DCGT-0702005-N-ALU-FA-G7B-K10	2	0,05	7°
101060	DCGT-070202-N-ALU-FA-G7B-K10	2	0,20	7°
101063	DCGT-070204-N-ALU-FA-G7B-K10	2	0,40	7°
138632	DCGT-11T301-N-ALU-FA-G7B-K10	2	0,10	7°
101066	DCGT-11T302-N-ALU-FA-G7B-K10	2	0,20	7°
101069	DCGT-11T304-N-ALU-FA-G7B-K10	2	0,40	7°
101072	DCGT-11T308-N-ALU-FA-G7B-K10	2	0,80	7°

DCGT - ASF (Holder on page 22)

Item no.	Designation	#	R	α
150650	DCGT-0702005-N-ASF-G7B-K10	2	0,05	7°
120824	DCGT-070202-N-ASF-G7B-K10	2	0,20	7°
120123	DCGT-070204-N-ASF-G7B-K10	2	0,40	7°
149184	DCGT-11T3005-N-ASF-G7B-K10	2	0,05	7°
135104	DCGT-11T301-N-ASF-G7B-K10	2	0,10	7°
119857	DCGT-11T302-N-ASF-G7B-K10	2	0,20	7°
128259	DCGT-11T304-N-ASF-G7B-K10	2	0,40	7°
128260	DCGT-11T308-N-ASF-G7B-K10	2	0,80	7°

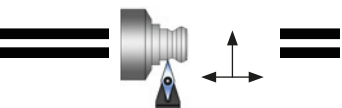
DCGT - AWI (Holder on page 22)

Item no.	Designation	#	R	α
121238	DCGT-070202-N-AWI-FA-G7B-K10	2	0,20	7°
120449	DCGT-070204-N-AWI-FA-G7B-K10	2	0,40	7°
158972	DCGT-11T302-N-AWI-FA-G7B-K10	2	0,20	7°
118554	DCGT-11T304-N-AWI-FA-G7B-K10	2	0,40	7°



PUR
PTFE
POM
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PVC
PP
PE-HD
PEEK
Vulkollan
PMMA
PC
PET
PVDF
PEI
PPS





Copy Turning ISO-Indexable Inserts



Plastic processing with VCGT

VCGT - ALU - FA (Holder on page 23 - Holder for 11... on Page 18)

Item no.	Designation	#	R	α
125101	VCGT-0702005-N-ALU-FA-G7B-K10	2	0,05	7°
167409	VCGT-070201-N-ALU-FA-G7B-K10	2	0,10	7°
170054	VCGT-070202-N-ALU-FA-G7B-K10	2	0,20	7°
142564	VCGT-1103005-N-ALU-FA-G7B-K10	2	0,05	7°
108310	VCGT-110301-N-ALU-FA-G7B-K10	2	0,10	7°
103833	VCGT-110302-N-ALU-FA-G7B-K10	2	0,20	7°
103836	VCGT-110304-N-ALU-FA-G7B-K10	2	0,40	7°
103839	VCGT-110308-N-ALU-FA-G7B-K10	2	0,80	7°
108311	VCGT-130301-N-ALU-FA-G7B-K10	2	0,10	7°
103841	VCGT-130302-N-ALU-FA-G7B-K10	2	0,20	7°
103844	VCGT-130304-N-ALU-FA-G7B-K10	2	0,40	7°
132892	VCGT-130308-N-ALU-FA-G7B-K10	2	0,80	7°
180143	VCGT-160402-N-ALU-FA-G7B-K10	2	0,20	7°
103849	VCGT-160404-N-ALU-FA-G7B-K10	2	0,40	7°
103852	VCGT-160408-N-ALU-FA-G7B-K10	2	0,80	7°

VCGT - ALU - FS (Holder on page 23)

Item no.	Designation	#	R	α
103818	VCGT-130302-N-ALU-FS-G7B-K10	2	0,20	7°
103823	VCGT-130304-N-ALU-FS-G7B-K10	2	0,40	7°
103828	VCGT-130308-N-ALU-FS-G7B-K10	2	0,80	7°

VCGT - ASF (Holder on page 23 - Holder for 11... on Page 18)

Item no.	Designation	#	R	α
144281	VCGT-0702005-N-ASF-G7B-K10	2	0,05	7°
125096	VCGT-070204-N-ASF-G7B-K10	2	0,40	7°
149183	VCGT-1103005-N-ASF-G7B-K10	2	0,05	7°
119925	VCGT-110302-N-ASF-G7B-K10	2	0,20	7°
120732	VCGT-110304-N-ASF-G7B-K10	2	0,40	7°
142482	VCGT-130301-N-ASF-G7B-K10	2	0,10	7°
123728	VCGT-130302-N-ASF-G7B-K10	2	0,20	7°
121324	VCGT-130304-N-ASF-G7B-K10	2	0,40	7°
147912	VCGT-160401-N-ASF-G7B-K10	2	0,10	7°
181630	VCGT-160402-N-ASF-G7B-K10	2	0,20	7°
138627	VCGT-160404-N-ASF-G7B-K10	2	0,40	7°
140076	VCGT-160408-N-ASF-G7B-K10	2	0,80	7°

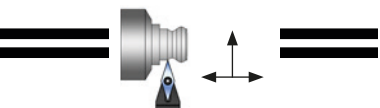
VCGT - ACB (Holder on page 23)

Item no.	Designation	#	R	α
180144	VCGT-160404-N-ACB-FA-G7B-K10	2	0,40	7°
180145	VCGT-160408-N-ACB-FA-G7B-K10	2	0,80	7°
180146	VCGT-160412-N-ACB-FA-G7B-K10	2	1,20	7°



PUR
PTFE
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PVC
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PE-HD
PEEK
Vulkollan
PMMA
PC
PET
PVDF
PEI
PPS





Copy Turning ISO-Indexable Inserts

Program expanded



PCD - Inserts

Depending on the application areas, plastics are reinforced with glass or carbon fibers (GFR/ CFR) to improve mechanical

properties. For the machining of these plastics, we recommend our indexable inserts with PCD tooling.

CCGT (Holder on page 22)

Item no.	Designation	#	R	l1	γ	α
198740	CCGT-060201FN-PKD	1	0,1	2,5	10°	7°
159096	CCGT-060202FN-PKD	1	0,2	2,5	10°	7°
159097	CCGT-060204FN-PKD	1	0,4	2,5	10°	7°
198741	CCGT-09T301FN-PKD	1	0,1	2,5	10°	7°
159098	CCGT-09T302FN-PKD	1	0,2	2,5	10°	7°
159099	CCGT-09T304FN-PKD	1	0,4	2,5	10°	7°
198742	CCGT-09T308FN-PKD	1	0,8	2,5	10°	7°

CCGW (Holder on page 22 - 09T3... supply on demand)

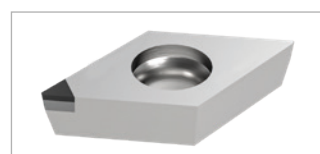
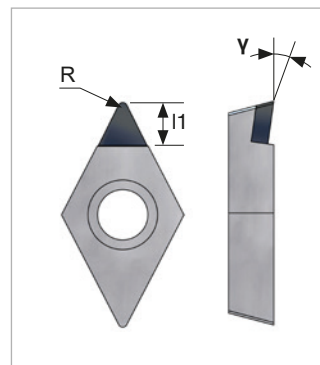
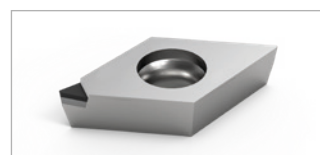
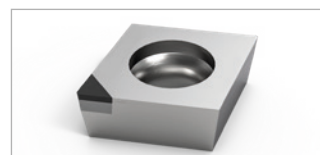
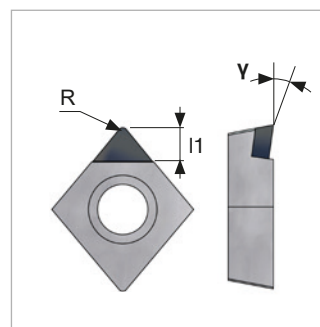
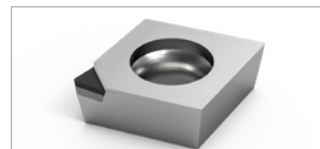
Item no.	Designation	#	R	l1	γ	α
198743	CCGW-060201FN-PKD	1	0,1	2,5	0°	7°
159104	CCGW-060202FN-PKD	1	0,2	2,5	0°	7°
159105	CCGW-060204FN-PKD	1	0,4	2,5	0°	7°
198744	CCGW-060208FN-PKD	1	0,8	2,5	0°	7°
198745	CCGW-09T301FN-PKD	1	0,1	2,5	0°	7°
159106	CCGW-09T302FN-PKD	1	0,2	2,5	0°	7°
159107	CCGW-09T304FN-PKD	1	0,4	2,5	0°	7°
198746	CCGW-09T308FN-PKD	1	0,8	2,5	0°	7°

DCGT (Holder on page 22)

Item no.	Designation	#	R	l1	γ	α
137567	DCGT-070201FN-PKD	1	0,1	2,5	10°	7°
137566	DCGT-070202FN-PKD	1	0,2	2,5	10°	7°
121521	DCGT-070204FN-PKD	1	0,4	2,5	10°	7°
198747	DCGT-11T301FN-PKD	1	0,1	2,5	10°	7°
135013	DCGT-11T302FN-PKD	1	0,2	2,5	10°	7°
121522	DCGT-11T304FN-PKD	1	0,4	2,5	10°	7°
198748	DCGT-11T308FN-PKD	1	0,8	2,5	10°	7°

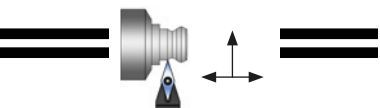
DCGW (Holder on page 22)

Item no.	Designation	#	R	l1	γ	α
198749	DCGW-070201FN-PKD	1	0,1	2,5	0°	7°
198750	DCGW-070202FN-PKD	1	0,2	2,5	0°	7°
198751	DCGW-070204FN-PKD	1	0,4	2,5	0°	7°
198752	DCGW-11T301FN-PKD	1	0,1	2,5	0°	7°
121536	DCGW-11T302FN-PKD	1	0,2	2,5	0°	7°
108630	DCGW-11T304FN-PKD	1	0,4	2,5	0°	7°



Plastics
with
fillers
GFR
CFK





Copy Turning ISO-Indexable Inserts

Program expanded



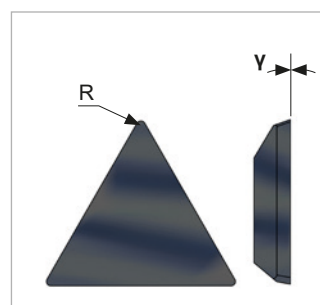
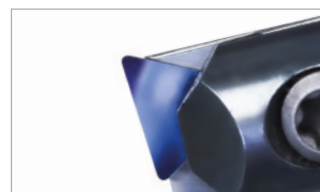
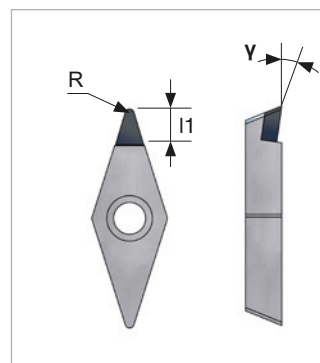
PCD - Inserts

VCGT (Holder on page 23 - Holder for 11... on Page 18)

Item no.	Designation	#	R	l1	γ	α
157346	VCGT-070201FN-PKD	1	0,1	2,5	10°	7°
121524	VCGT-070202FN-PKD	1	0,2	2,5	10°	7°
159131	VCGT-070204FN-PKD	1	0,4	2,5	10°	7°
198754	VCGT-110301FN-PKD	1	0,1	2,5	10°	7°
135015	VCGT-110302FN-PKD	1	0,2	2,5	10°	7°
121525	VCGT-110304FN-PKD	1	0,4	2,5	10°	7°
198755	VCGT-130301FN-PKD	1	0,1	2,5	10°	7°
121322	VCGT-130302FN-PKD	1	0,2	2,5	10°	7°
137247	VCGT-130304FN-PKD	1	0,4	2,5	10°	7°
198757	VCGT-160401FN-PKD	1	0,1	2,5	10°	7°
159145	VCGT-160402FN-PKD	1	0,2	2,5	10°	7°
159146	VCGT-160404FN-PKD	1	0,4	2,5	10°	7°
198758	VCGT-160408FN-PKD	1	0,8	2,5	10°	7°

VCGW (Holder on page 23 - Holder for 11... on Page 18)

Item no.	Designation	#	R	l1	γ	α
159147	VCGW-070201FN-PKD	1	0,1	2,5	0°	7°
121527	VCGW-070202FN-PKD	1	0,2	2,5	0°	7°
148298	VCGW-110301FN-PKD	1	0,1	2,5	0°	7°
109005	VCGW-110302FN-PKD	1	0,2	2,5	0°	7°
121528	VCGW-110304FN-PKD	1	0,4	2,5	0°	7°
198759	VCGW-130301FN-PKD	1	0,1	2,5	0°	7°
108446	VCGW-130302FN-PKD	1	0,2	2,5	0°	7°
121529	VCGW-130304FN-PKD	1	0,4	2,5	0°	7°
198760	VCGW-160401FN-PKD	1	0,1	4,4	0°	7°
159148	VCGW-160402FN-PKD	1	0,2	4,4	0°	7°
159149	VCGW-160404FN-PKD	1	0,4	4,4	0°	7°
198761	VCGW-160408FN-PKD	1	0,8	4,4	0°	7°



Plastics
with
fillers
GFK
CFK

TOFX

TOFX is the 3-edge full-PCD insert for our MINIFIX system.

Specifically designed for the finest internal and external machining of abrasive plastics with fillers.

MINIFIX holder system: www.dieterle-tools.de/MINIFIX

Item no.	Designation	#	R	γ
103743	TOFX-230801-PKD	3	0,1	0°
103751	TOFX-230802-PKD	3	0,2	0°

Plastics
with
fillers
GFK
CFK

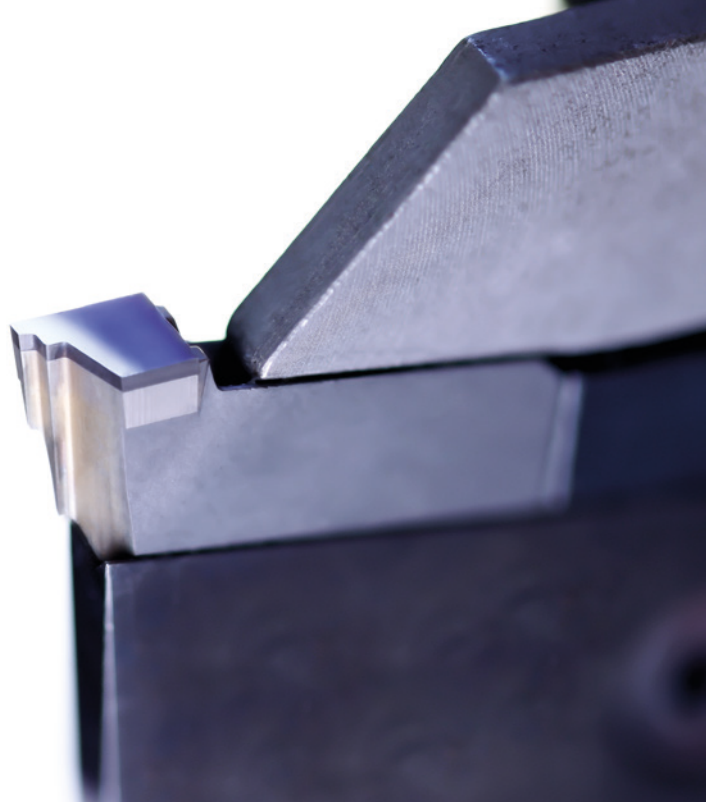


Available for all Dieterle systems:

PCD Form Grooving Tools

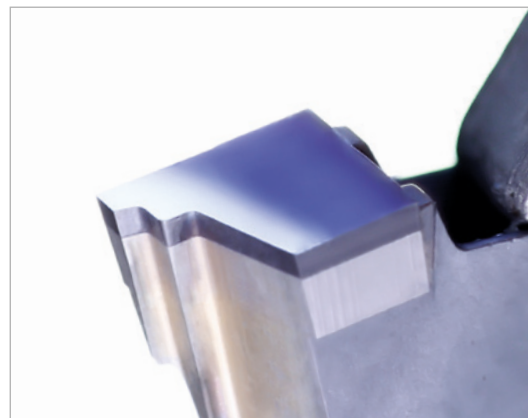
The use of glass or carbon fibers in plastics improves mechanical properties. The workpieces become more stable but also more abrasive, which makes machining more difficult. The solution is the use of PCD-equipped tooling. This extends tool life while maintaining the same precision.

We implement PCD-form tools on all systems. Turning, deburring, and form turning according to your requirements with our quality mindset. As examples, see our DAK- and FHGU-ES systems.



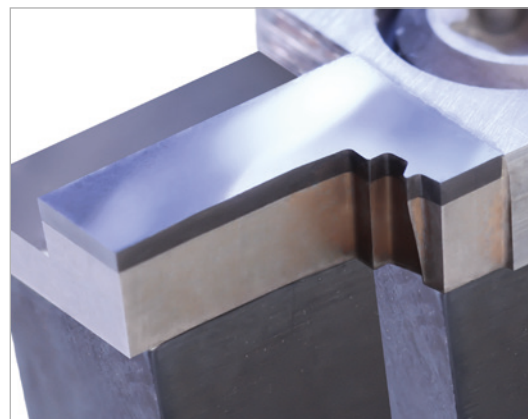
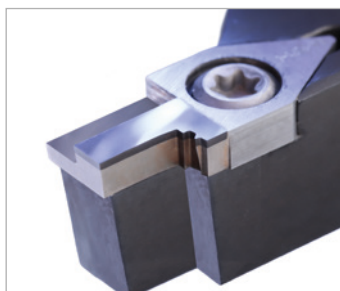
PCD - Form Grooving Tool - DAK

- For use with reinforced plastics
- Cutting off
- Form grooving
- Long tool life
- Full-face PCD



PCD - Form Grooving Tool - FHGU-ES

- Fine contours
- Flat PCD-equipped
- Large insert depth
- Long tool life when used with reinforced plastics



www.dieterle-tools.de/easy-request/





Product Range Internal Machining

Standard Tools



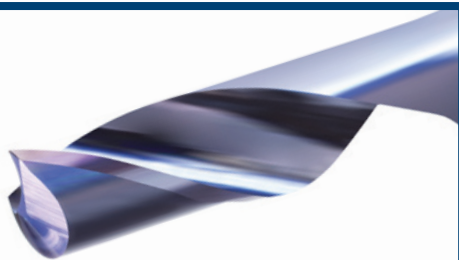
Drills and Mills



Turning Tools



Thread Whirling Tools



Plastic Machining Tools



Profile Broaches



MINIFIX System

Special Tools



Drills and Mills



Whirl Thread Milling
Cutters Micro

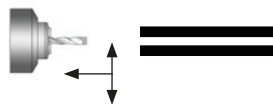


Internal grooving and face
grooving tools



Profile Broaches

Tool Finder Plastic Drills and Mills

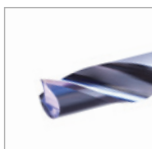


drilling



Material	T303
PUR	+
PTFE (Teflon)	++
POM	++
PA	++
PVC	+
PP	++
PE-HD	++
PEEK	++
Vulkollan	+
PMMA (Plexiglass)	++
With fillers	+
PC	++
PET	++
PVDF	++
PEI	++
PPS	++

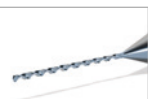
milling



Material	M823	M966	M640	M639
PUR	+++	++		
PTFE (Teflon)	+++	++		
POM	+++	++		
PA	+++	++		
PVC	+++	++		
PP	+++	++		
PE-HD	+++	++		
PEEK	+++	++		
Vulkollan	+++	++		
PMMA (Plexiglass)	+++	++		
With fillers	+	+	++	++
PC	+++	++		
PET	+++	++		
PVDF	+++	++		
PEI	+++	++		
PPS	+++	++		

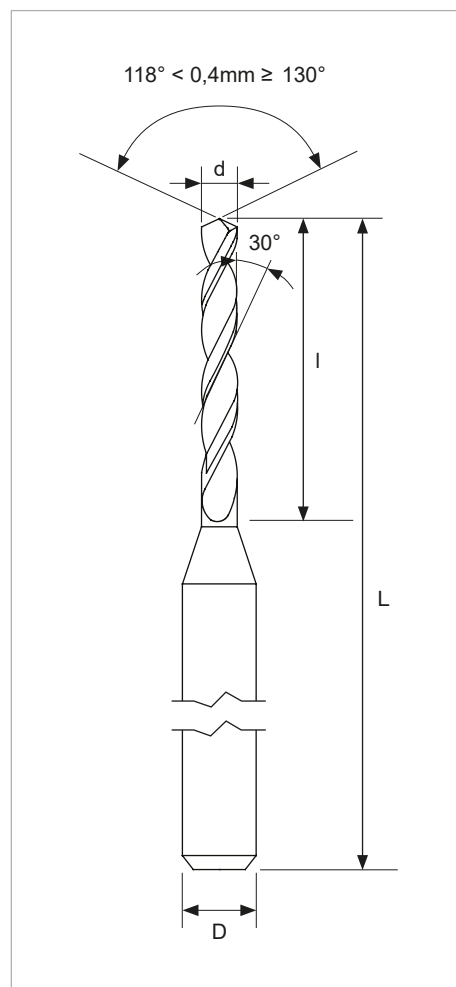
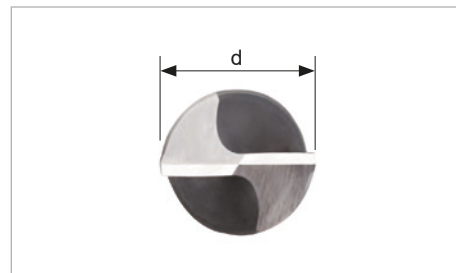
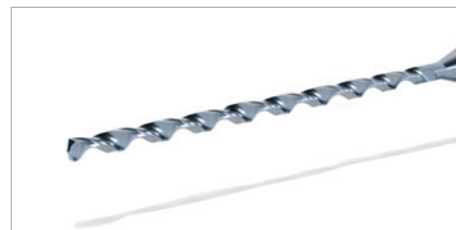


Internal Machining Drills



T303

- Specified polymer geometry
- Excellent cutting performance
- Stabilized cutting edges
- High rotational accuracy
- Improved positioning accuracy and hole quality

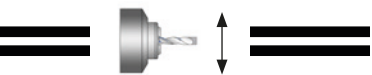


PUR
PTFE
POM
PA
PVC
PP
PE-HD
PEEK
Vulkollan
PMMA
PC
PET
PVDF
PEI
PPS

Item no.	Designation	Ø d	l	L	Ø D
154523	T303-0300-050	0,3	5	38	3
154534	T303-0400-060	0,4	6	38	3
154536	T303-0500-060	0,5	6	38	3
154539	T303-0600-080	0,6	8	38	3
154541	T303-0700-080	0,7	8	38	3
154544	T303-0800-080	0,8	8	38	3
154546	T303-0900-080	0,9	8	38	3
154548	T303-1000-100	1	10	38	3
198328	T303-1100-120	1,1	12	38	3
198329	T303-1200-120	1,2	12	38	3
198330	T303-1300-140	1,3	14	45	3
198331	T303-1400-140	1,4	14	45	3
198332	T303-1500-160	1,5	16	45	3
198333	T303-1600-160	1,6	16	45	3
198334	T303-1700-180	1,7	18	45	3
198335	T303-1800-180	1,8	18	45	3
198336	T303-1900-180	1,9	18	45	3
198337	T303-2000-180	2	18	45	3
198338	T303-2100-200	2,1	20	50	3
198339	T303-2200-200	2,2	20	50	3
198340	T303-2300-220	2,3	22	50	3
198341	T303-2400-220	2,4	22	50	3
198342	T303-2500-240	2,5	24	50	3
198343	T303-2600-240	2,6	24	50	3
198344	T303-2700-240	2,7	24	50	3
198345	T303-2800-260	2,8	26	50	3
198346	T303-2900-260	2,9	26	50	3
198347	T303-3000-260	3	26	50	3

Shorter configurations available upon request.



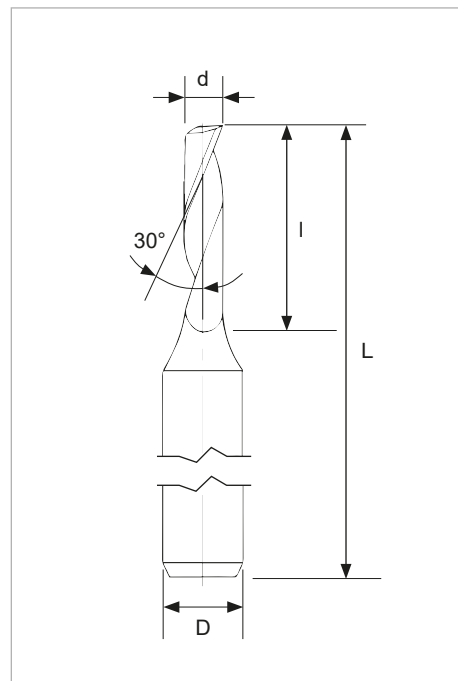
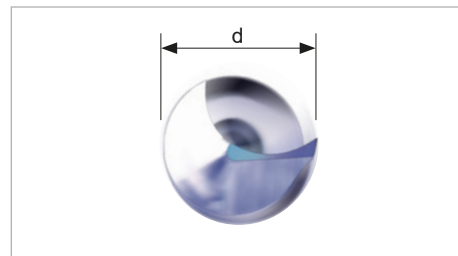
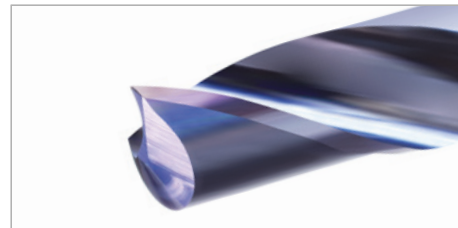


Internal Machining Single Flute Milling Cutter



M823

- Specified polymer geometry
- Excellent cutting performance
- Optimized chip evacuation and stabilized cutting edge
- Polished Flute
- Improved positioning accuracy



PUR
PTFE
POM
PA
PVC
PET
PVDF
PEI
PPS
PMMA
PC

Item no.	Designation	Ø d	l	L	Ø D
155046	M823-0100-050-038-03	1	5	38	3
155053	M823-0150-050-038-03	1,5	5	38	3
155056	M823-0200-060-038-03	2	6	38	3
155057	M823-0200-060-050-06	2	6	50	6
155058	M823-0200-100-038-03	2	10	38	3
155061	M823-0200-110-038-03	2	11	38	3
155062	M823-0300-100-038-03	3	10	38	3
155063	M823-0300-110-038-03	3	11	38	3
155064	M823-0300-110-050-06	3	11	50	6
155065	M823-0300-220-060-06	3	22	60	6
155066	M823-0400-140-050-04	4	14	50	4
155067	M823-0400-140-050-06	4	14	50	6
155068	M823-0500-160-060-06	5	16	60	6
155069	M823-0600-200-060-06	6	20	60	6
155070	M823-0600-220-050-06	6	22	50	6
155071	M823-0600-320-064-06	6	32	64	6
155072	M823-0800-200-075-08	8	20	75	8
155074	M823-0800-320-064-08	8	32	64	8
155075	M823-1000-220-064-10	10	22	64	10
155076	M823-1200-220-064-12	12	22	64	12



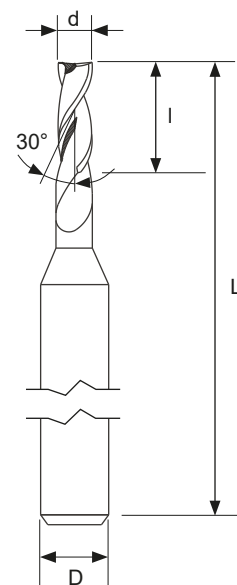
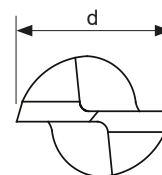
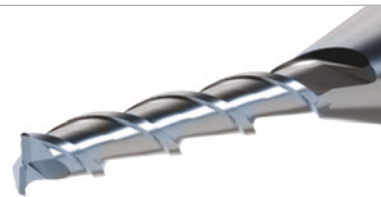
Internal Machining Mills

M966

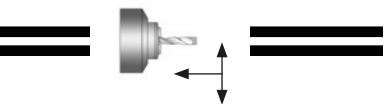
- Two-Flute Milling Cutter
- Specified polymer geometry
- Polished surfaces
- Improved chip removal
- More stable cutting behavior
- Improved smoothness

PUR
PTFE
POM
PA
PVC
PP
PE-HD
PEEK
Vulkollan
PMMA
PC
PET
PVDF
PEI
PPS

Item no.	Designation	Ø d	l	L	Ø D
155120	M966-0010-002-038-03	0,1	0,2	38	3
155121	M966-0020-004-038-03	0,2	0,4	38	3
155122	M966-0020-006-038-03	0,2	0,6	38	3
155123	M966-0030-009-038-03	0,3	0,9	38	3
155124	M966-0040-012-038-03	0,4	1,2	38	3
155125	M966-0050-005-038-03	0,5	0,5	38	3
155126	M966-0050-010-038-03	0,5	1	38	3
155127	M966-0050-015-038-03	0,5	1,5	38	3
155128	M966-0060-020-038-03	0,6	2	38	3
155130	M966-0070-007-038-03	0,7	0,7	38	3
155131	M966-0070-030-038-03	0,7	3	38	3
155132	M966-0080-016-038-03	0,8	1,6	38	3
155133	M966-0080-024-038-03	0,8	2,4	38	3
155134	M966-0080-030-038-03	0,8	3	38	3
155135	M966-0090-027-038-03	0,9	2,7	38	3
155136	M966-0100-010-038-03	1	1	38	3
155137	M966-0100-020-038-03	1	2	38	3
155138	M966-0100-030-038-03	1	3	38	3
155139	M966-0120-036-038-03	1,2	3,6	38	3
155141	M966-0150-045-038-03	1,5	4,5	38	3
155142	M966-0160-048-038-03	1,6	4,8	38	3
155143	M966-0180-054-038-03	1,8	5,4	38	3
155150	M966-0200-020-038-03	2	2	38	3
155170	M966-0200-040-038-03	2	4	38	3
155171	M966-0200-060-038-03	2	6	38	3
155172	M966-0200-070-050-06	2	7	50	6
155173	M966-0200-090-038-03	2	9	38	3
155174	M966-0250-075-038-03	2,5	7,5	38	3
155175	M966-0300-070-050-06	3	7	50	6
155177	M966-0300-090-038-03	3	9	38	3
155179	M966-0300-120-038-03	3	12	38	3
155180	M966-0400-080-050-06	4	8	50	6
155181	M966-0400-120-050-04	4	12	50	4
155182	M966-0500-100-050-06	5	10	50	6
155183	M966-0500-150-050-06	5	15	50	6
155184	M966-0600-120-050-06	6	12	50	6
155186	M966-0600-180-060-06	6	18	60	6



Internal Machining Mills

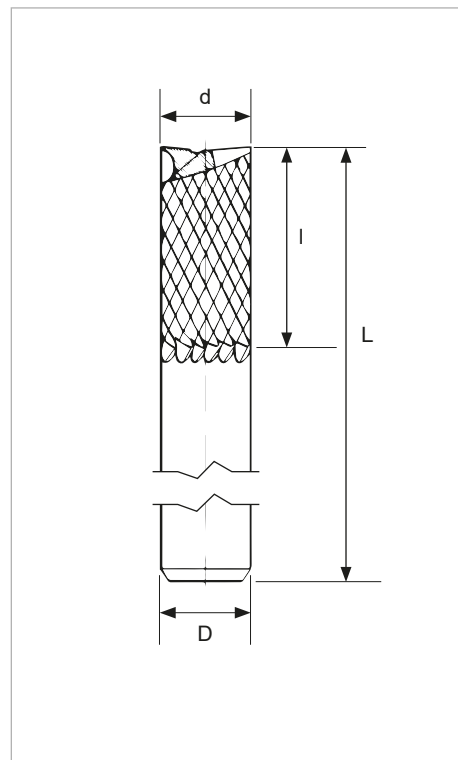
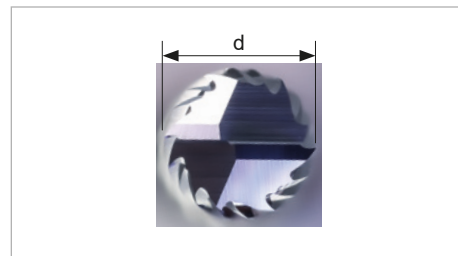
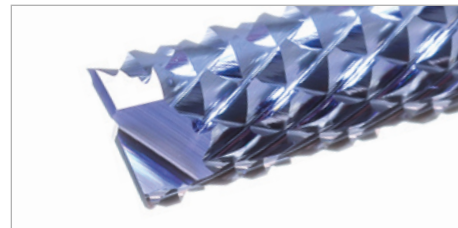


M640

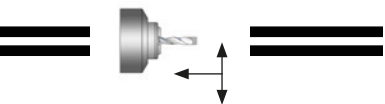
- **cutting edge beyond center**
- Fine cut type - up-cut
- Especially for the machining of abrasive materials and fibre-reinforced plastics
- 3 Machining Directions
- High performance criss-cross cutting right-hand cutting
- Also available with CVD coating

Plastics
with
fillers
GFK
CFK

Item no.	Designation	Ø d	l	L	Ø D
155461	M640-0300-060-040-03	3	6	40	3
155462	M640-0300-090-040-03	3	9	40	3
155463	M640-0300-120-040-03	3	12	40	3
155465	M640-0300-120-050-06	3	12	50	6
155464	M640-0300-160-050-03	3	16	50	3
155466	M640-0300-160-050-06	3	16	50	6
155467	M640-0400-060-040-04	4	6	40	4
155468	M640-0400-100-040-04	4	10	40	4
155472	M640-0400-120-050-06	4	12	50	6
155469	M640-0400-140-050-04	4	14	50	4
155473	M640-0400-160-050-06	4	16	50	6
155470	M640-0400-180-050-04	4	18	50	4
155471	M640-0400-220-060-04	4	22	60	4
155475	M640-0500-140-050-06	5	14	50	6
155474	M640-0500-160-060-05	5	16	60	5
155476	M640-0500-220-060-06	5	22	60	6
155477	M640-0600-140-050-06	6	14	50	6
155478	M640-0600-220-060-06	6	22	60	6
155479	M640-0600-320-070-06	6	32	70	6
155480	M640-0800-220-060-08	8	22	60	8
155481	M640-0800-320-075-08	8	32	75	8
155482	M640-1000-320-075-10	10	32	75	10



Internal Machining Mills

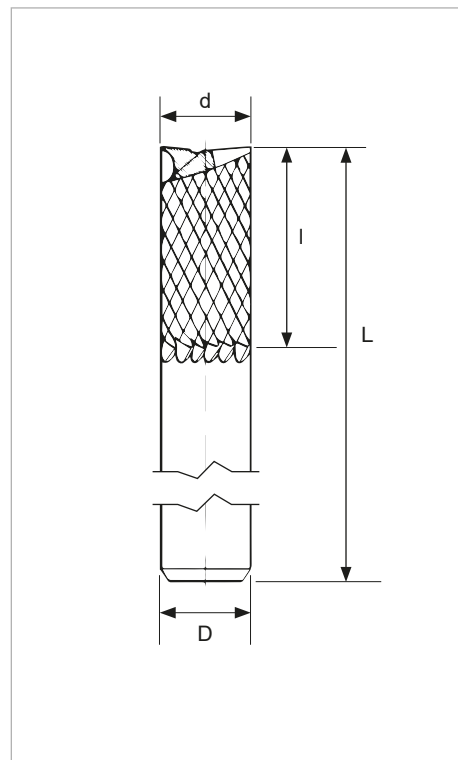
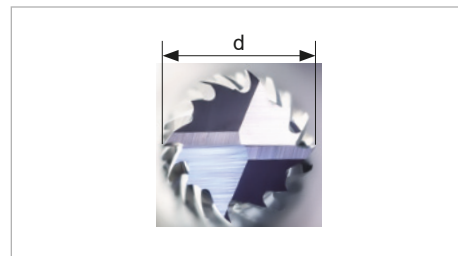
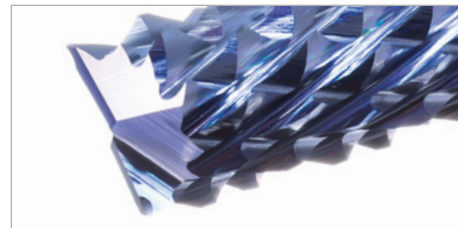


M639

- Medium-fine cut type - up-cut
- Especially for the machining of abrasive materials and fibre-reinforced plastics
- 3 Machining Directions
- High performance criss-cross cutting right-hand cutting
- Also available with CVD coating

Plastics
with
fillers
GFK
CFK

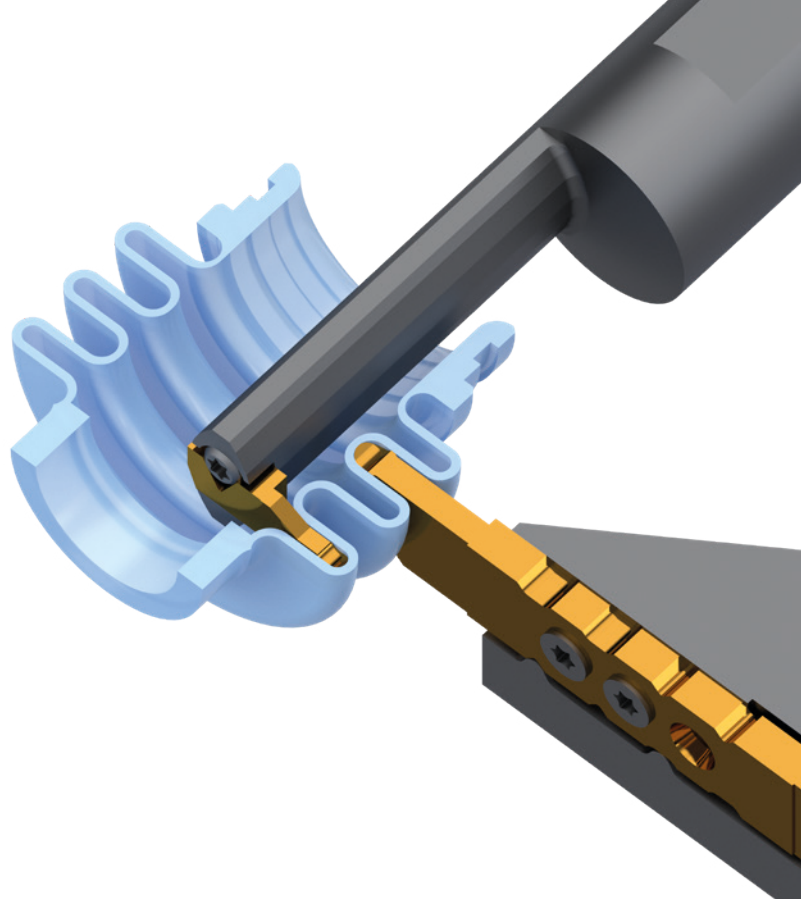
Item no.	Designation	Ø d	l	L	Ø D
155504	M639-0300-060-040-03	3	6	40	3
155506	M639-0300-090-040-03	3	9	40	3
155507	M639-0300-120-040-03	3	12	40	3
155509	M639-0300-120-050-06	3	12	50	6
155508	M639-0300-160-050-03	3	16	50	3
155510	M639-0300-160-050-06	3	16	50	6
155511	M639-0400-060-040-04	4	6	40	4
155512	M639-0400-100-040-04	4	10	40	4
155517	M639-0400-120-050-06	4	12	50	6
155513	M639-0400-140-050-04	4	14	50	4
155518	M639-0400-160-050-06	4	16	50	6
155515	M639-0400-180-050-04	4	18	50	4
155516	M639-0400-220-060-04	4	22	60	4
155520	M639-0500-140-050-06	5	14	50	6
155519	M639-0500-160-060-05	5	16	60	5
155521	M639-0500-220-060-06	5	22	60	6
155522	M639-0600-140-050-06	6	14	50	6
155523	M639-0600-220-060-06	6	22	60	6
155524	M639-0600-320-070-06	6	32	70	6
155525	M639-0800-220-060-08	8	22	60	8
155526	M639-0800-320-075-08	8	32	75	8
155527	M639-1000-320-075-10	10	32	75	10



Special tooling solutions for plastic processing

Do you want to make your production even more efficient? Dieterle forming tools are the solution! The long service life in plastic processing makes tools that machine finished contours in a single pass particularly economical.

Our extensive expertise in developing high-end tools for plastic processing flows into the manufacture of your custom tools. The highest precision, efficiency, and effectiveness in every part are our standard.



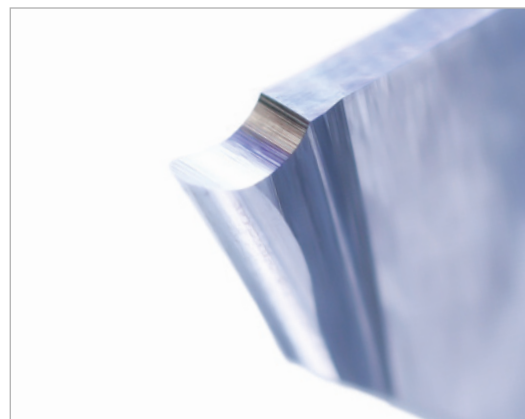
Easy requests!

Customized, we also solve your challenges in plastic processing. Submit your request easily at www.dieterle-tools.com/einfach-anfragen.



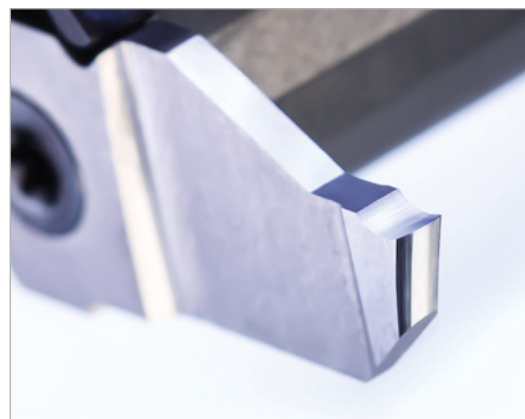
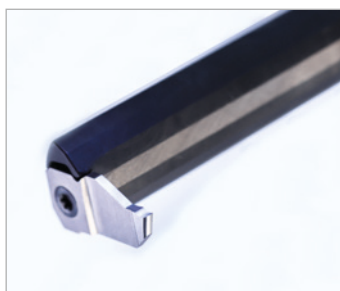
Bellows - exterior machining

For our Dieterle KP indexable insert system we developed these plunge- inserts with full radius. The highly positive rake angle and extreme sharpness ensure excellent results and satisfied customers.



Bellows - interior machining

The indexable insert system allows large plunging depths at small internal diameters. Highly positive rake angles and extreme sharpness round off perfect results.





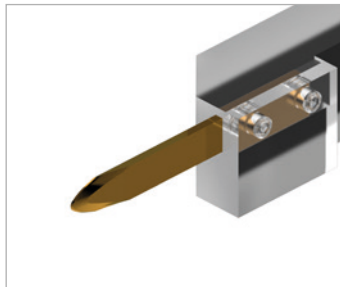
Internal Form Grooving



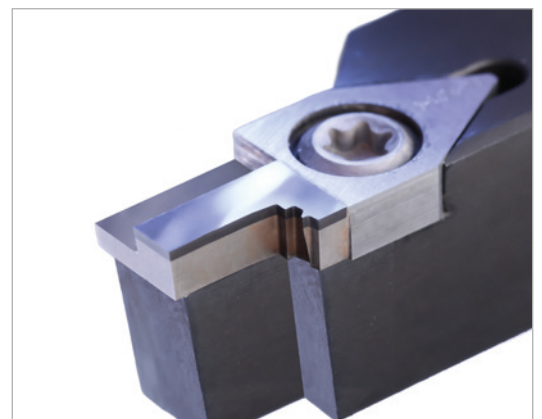
Chip-free interior machining



Parting-off tools up to > 45mm



PCD Form Grooving Tools



Cutting data



	45° 45°-R01 255 S1		S1-SP S2-SP2		S1-PKD PKD		VG 12° RX R3	
Material	vc [m/min]	f [U/min]	vc [m/min]	f [U/min]	vc [m/min]	f [U/min]	vc [m/min]	f [U/min]
PUR			200-500	0,1-0,5			200-500	0,1-0,5
PTFE (Teflon)	200-500	0,1-0,4	200-500	0,1-0,4				
POM	300-600	0,1-0,4	300-600	0,1-0,4			300-600	0,1-0,4
PA	200-500	0,1-0,4	200-500	0,1-0,4				
PVC	200-750	0,3-0,5	200-750	0,3-0,5			200-750	0,3-0,5
PP	250-500	0,1-0,5	250-500	0,1-0,5			250-500	0,1-0,5
PE-HD			250-500	0,1-0,5			250-500	0,1-0,5
PEEK	200-500	0,1-0,4	200-500	0,1-0,4			200-500	0,1-0,4
Vulkollan			300-800	0,1-0,5			300-800	0,1-0,5
PMMA (Plexiglass)	200-300	0,1-0,2	200-300	0,1-0,2				
With fillers					150-200	0,1-0,5		
PC	200-300	0,1-0,5	200-350	0,1-0,5				
PET							200-500	0,1-0,5
PVDF	150-500	0,1-0,3	150-500	0,1-0,3				
PEI			300-400	0,2-0,3			300-400	0,2-0,3
PPS	200-500	0,1-0,5	200-500	0,1-0,5				

Abbreviations

2-7 Tool system plastic processing 2-7
 2-9 Tool system plastic processing 2-9
 B Width
 CFK Carbon fiber reinforced plastics
 CVD Chemical Vapor Deposition
 D / d Diameter
 f Feed
 GFK Glass fiber reinforced plastics
 H Height
 KH Plastic holder
 KH-H Holders for chip-free machining
 KH-H1 Holders for R3-blade
 KP Plastic processing plates
 L / l Length
 M Thread sizes metric
 PA Polyamides
 PC Polycarbonate
 PE-HD ... High-density polyethylene
 PEEK Polyetheretherketone

PEI Polyetherimide
 PET Polyethylene terephthalate
 PKD Polycrystalline diamond
 PMMA Polymethyl methacrylate (Acrylic or Plexiglass)
 POM Polyoxymethylene
 PP Polypropylene
 PPS Polyurethane plastics
 PTFE Polytetrafluoroethylene (Teflon)
 PUR Polyurethane
 PVC Polyvinyl chloride
 PVDF Polyvinylidene fluoride
 S1 without cutting-off direction
 S2 with cutting-off direction
 S5 opposite cutting-off direction
 T TORX
 vc Cutting speed
 Vulkollan High-performance polyurethane
 With fillers Fibre-reinforced plastics







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