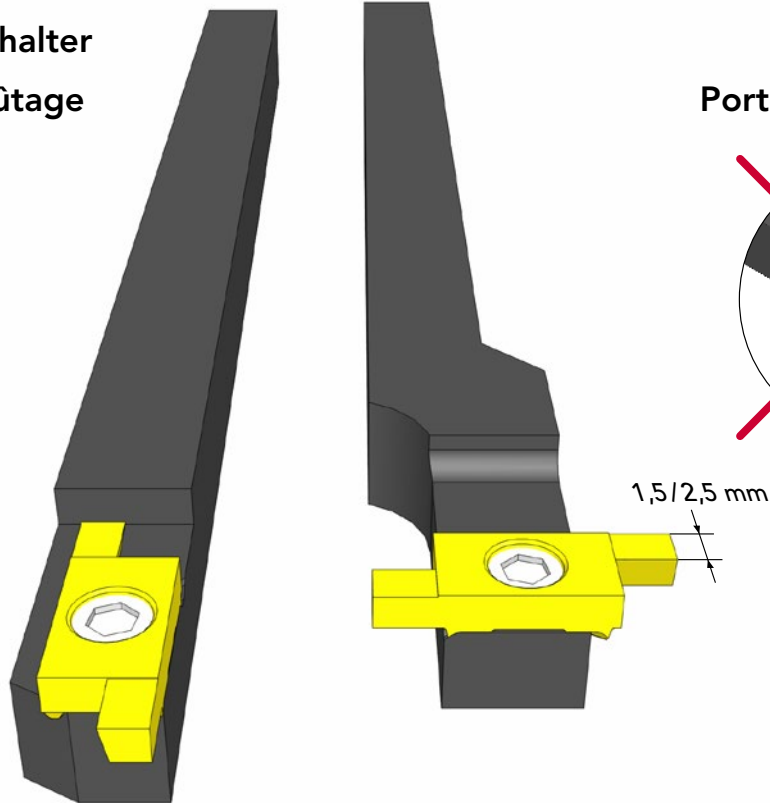


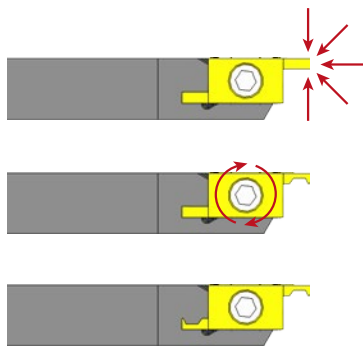
## PORTE OUTILS

- Porte outils a crochet avec plaquettes ..... FDE3.8.0#
- Porte outil double 400RD ..... FDE1.9.0#
- Porte outil de tronçonnage 121R ..... FDE6.1.0#
- Porte outil avec arrosage intégré ..... FDE1.6.0#
- Porte outils pour tours multibroches ..... FDE1.0.3#
- Porte outil de tournage pour contre opération ..... FDE1.1.0#
- Porte outil pour TORNOS DELTA 12/20 ..... FDE1.3.0#

Grinding tool-holder  
Schleifwerkzeughalter  
Porte-outil d'affûtage



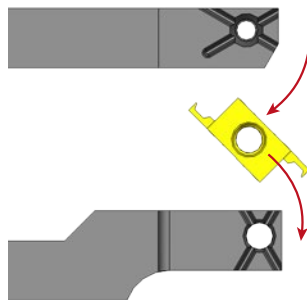
Machining tool-holder  
Drehhalter  
Porte-outil machine



1. Sharpening of the 2 cutting edges of the pre-rectified blank on the grinding tool-holder.

Einfaches Schleifen des Rohlings auf dem Schleifwerkzeughalter.

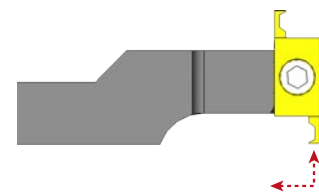
Meulage sans encombre des 2 arêtes de coupe de la plaquette ébauche pré-rectifiée sur le porte-outil d'affûtage.



2. Transfer of the grinded blank on the machining tool-holder.

Wechseln der Patte vom Schleifhalter auf den Drehhalter.

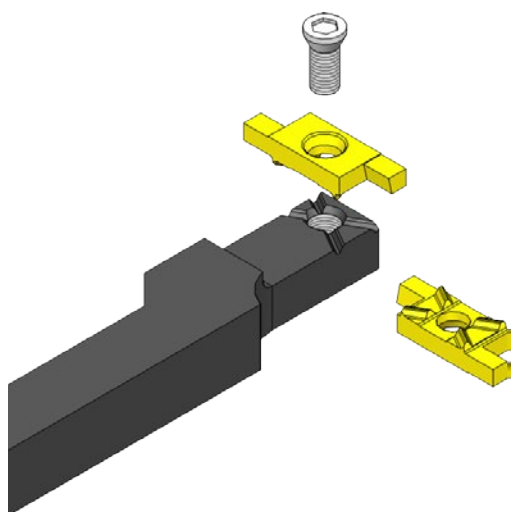
Transfert de la plaquette affûtée sur le porte-outil d'usinage.



3. Use of the insert set up on the machining tool-holder same as a standard hook tool-holder.

Verwendung des geschliffenen Rohlings wie ein Standard-Hakenstahl.

Utilisation de la plaquette montée sur le porte-outil d'usinage comme un porte-outil à crochet standard.



### "X-Centering" fixing system

### Befestigungssystem "X-Centering"

### Système de fixation "X-Centering"

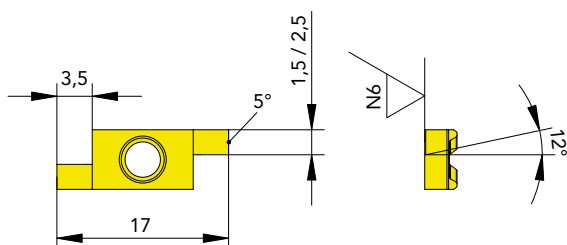
Repetitiveness of the cutting edge  $\pm 0,01$  mm.  
 Wiederholgenauigkeit der Schneidkante  $\pm 0,01$  mm.  
 Répétitivité de l'arête de coupe  $\pm 0,01$  mm.

Positioning in all axes.  
 Positionierung in allen Achsen.  
 Centrage dans tous les axes.

The screw is free of all radial stress.  
 Keine radialen Spannungen.  
 La vis est libre de toute tension radiale.

Insert turning without having to remove the screw.  
 Wenden der Schneidplatte ohne Entfernen der Schraube.  
 Retournement de la plaquette sans enlever la vis.

Two cutting edges available.  
 Zwei verfügbare Schneidkanten.  
 Deux arêtes de coupe disponibles.



Only blank inserts !  
 Nur Rohling !  
 Seulement plaquettes ébauches !

### Hook tool-holders / Hakenstahl / Porte-outils

Order Nr Bestellung Nr N° de cmde	Description Bezeichnung Description	Pour section Für Querschnitt For section
40812R	Right machining tool-holder Rechter Drehhalter Porte-outil machine à droite	8 mm (8 x 12) 8 mm (8 x 12) 8 mm (8 x 12)
41012R	Right machining tool-holder Rechter Drehhalter Porte-outil machine à droite	10 mm (10 x 12) 10 mm (10 x 12) 10 mm (10 x 12)
41215R	Right machining tool-holder Rechter Drehhalter Porte-outil machine à droite	12 mm (12 x 15) 12 mm (12 x 15) 12 mm (12 x 15)
41616R	Right machining tool-holder Rechter Drehhalter Porte-outil machine à droite	16 mm (16 x 16) 16 mm (16 x 16) 16 mm (16 x 16)
408R	Right grinding tool-holder Rechter Schleifwerkzeughalter Porte-outil d'affûtage à droite	8 mm (8 x 8) 8 mm (8 x 8) 8 mm (8 x 8)
40707L	Left machining tool-holder Linker Drehhalter Porte-outil machine à gauche	7 mm (7 x 7) 7 mm (7 x 7) 7 mm (7 x 7)
40808L	Left machining tool-holder Linker Drehhalter Porte-outil machine à gauche	8 mm (8 x 8) 8 mm (8 x 8) 8 mm (8 x 8)
41212L	Left machining tool-holder Linker Drehhalter Porte-outil machine à gauche	12 mm (12 x 12) 12 mm (12 x 12) 12 mm (12 x 12)
408L	Left grinding tool-holder Linker Schleifwerkzeughalter Porte-outil d'affûtage à gauche	8 mm (8 x 8) 8 mm (8 x 8) 8 mm (8 x 8)

### Inserts / Wendepatten / Plaquettes

Order Nr Bestellung Nr N° de cmde	e	Description Bezeichnung Description
421R1,5K10	1,5 1,5 1,5	Right insert without coating Rechte Wendepatte ohne Beschichtung Plaquette droite sans revêtement
421R1,5BI40	1,5 1,5 1,5	Right insert with PVD coating (TiAlN) Rechte Wendepatte mit PVD Beschichtung (TiAlN) Plaquette droite avec revêtement PVD (TiAlN)
421R2,5K10	2,5 2,5 2,5	Right insert without coating Rechte Wendepatte ohne Beschichtung Plaquette droite sans revêtement
421R2,5BI40	2,5 2,5 2,5	Right insert with PVD coating (TiAlN) Rechte Wendepatte mit PVD Beschichtung (TiAlN) Plaquette droite avec revêtement PVD (TiAlN)
421L1,5K10	1,5 1,5 1,5	Left insert without coating Linke Wendepatte ohne Beschichtung Plaquette gauche sans revêtement
421L1,5BI40	1,5 1,5 1,5	Left insert with PVD coating (TiAlN) Linke Wendepatte mit PVD Beschichtung (TiAlN) Plaquette gauche avec revêtement PVD (TiAlN)
421L2,5K10	2,5 2,5 2,5	Left insert without coating Linke Wendepatte ohne Beschichtung Plaquette gauche sans revêtement
421L2,5BI40	2,5 2,5 2,5	Left insert with PVD coating (TiAlN) Linke Wendepatte mit PVD Beschichtung (TiAlN) Plaquette gauche avec revêtement PVD (TiAlN)

### Key / Schlüssel / Clé

Order Nr Bestellung Nr N° de cmde	Description Bezeichnung Description
001-1	Key Torx 8 Schlüssel Torx 8 Clé Torx 8



Double the quantity of tools on all machines using 7, 8, 10, 12 or 16 mm section tool-holders !

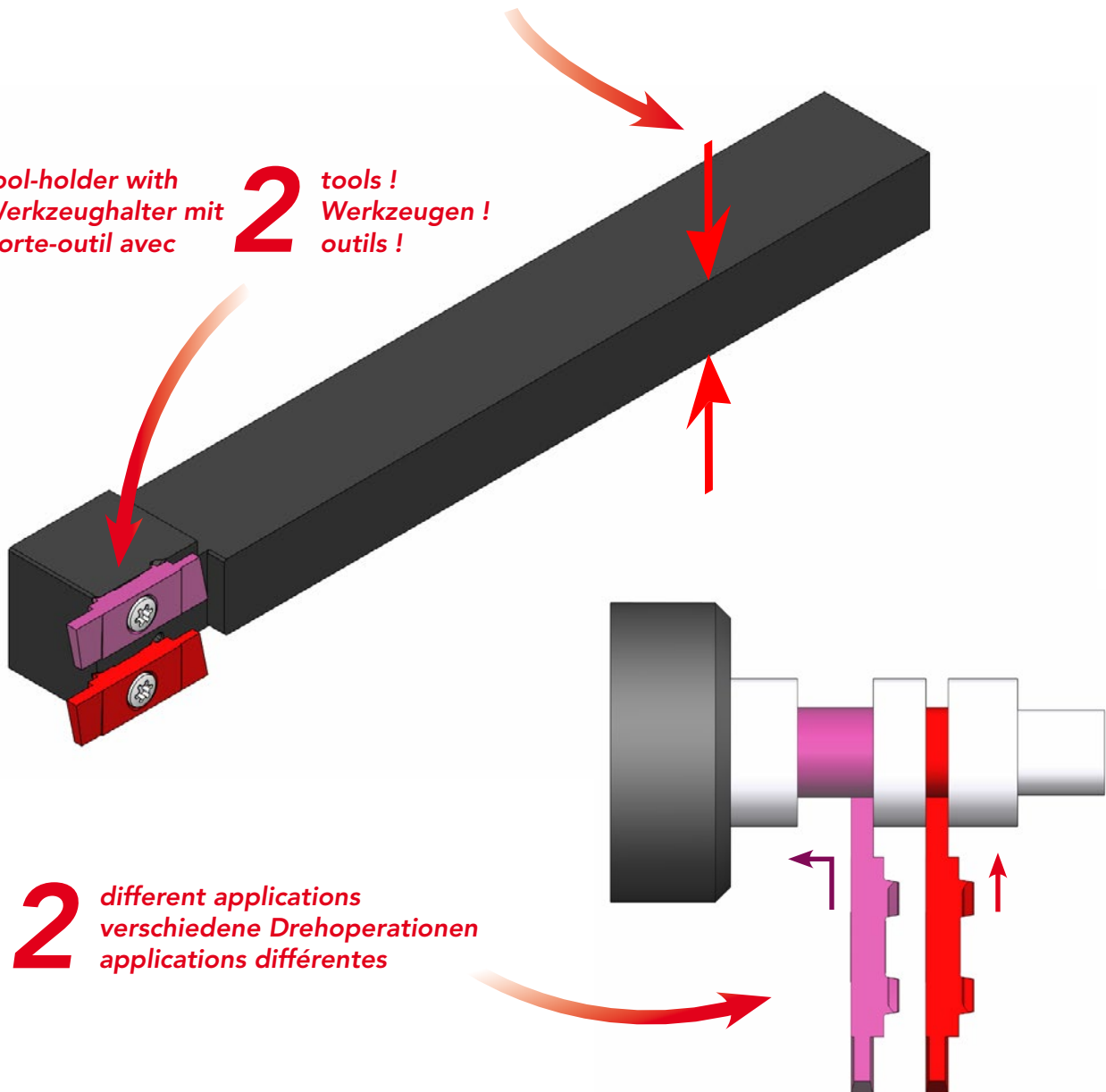
Verdoppelt die Werkzeuganzahl auf allen Maschinen, die 7, 8, 10, 12 oder 16 mm Querschnittswerkzeuge benutzen !

Double le nombre d'outils sur toutes les machines utilisant des porte-outils de section 7, 8, 10, 12 ou 16 mm !

Section  
Querschnitt  
Section

**7, 8, 10, 12, 16 mm**

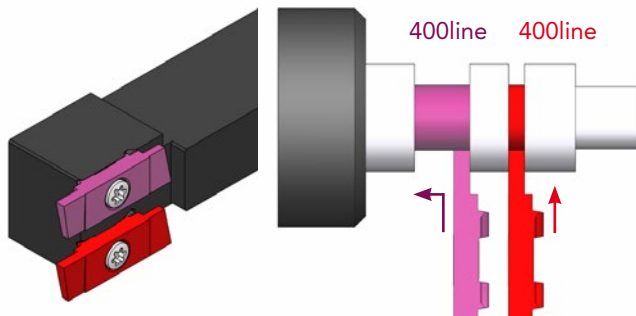
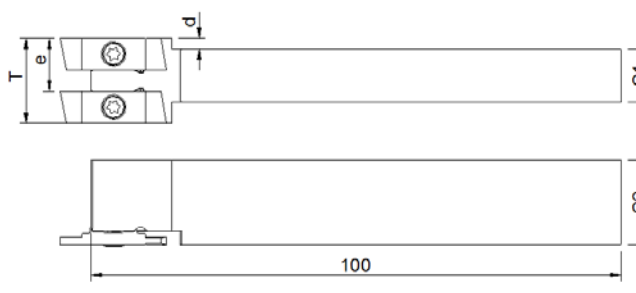
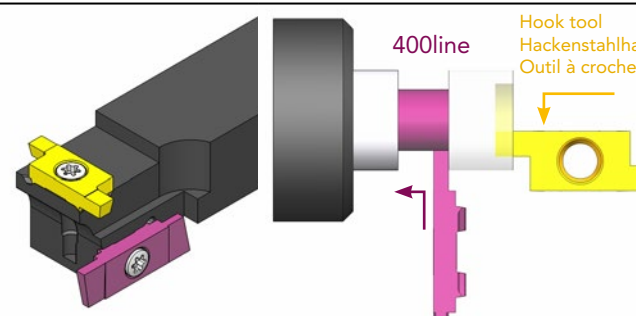
1 tool-holder with  
1 Werkzeughalter mit  
1 porte-outil avec **2** tools !  
Werkzeugen !  
outils !



**2** different applications  
verschiedene Drehoperationen  
applications différentes

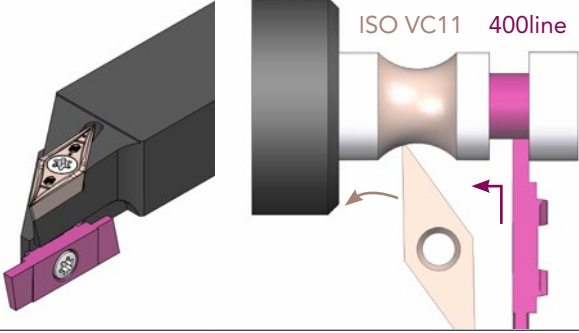
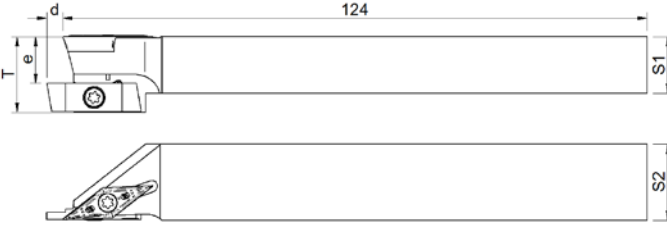
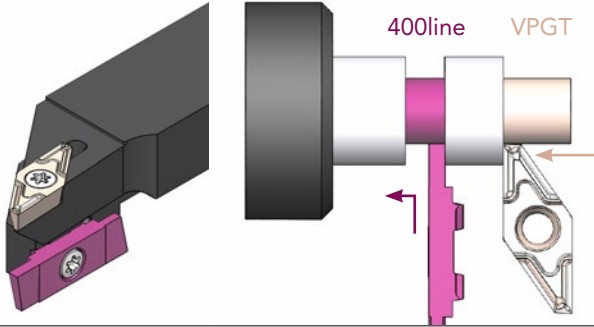
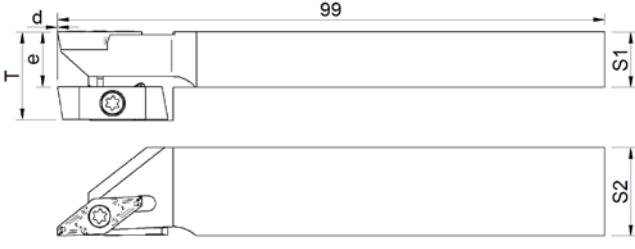
Maximum cutting-off :  
Maximal Abstechen :  $\varnothing 8 \text{ mm}$   
Tronçonnage maximum :

Maximum turning :  
Maximal Drehen :  $\varnothing \text{ ap } 2 \text{ mm}$   
Tournage maximum :

Examples of use for double tool-holders Anwendungsbeispiele für Doppelhalter Exemples d'utilisation de porte-outils doubles	S1	S2	T	d	e	Article nr. Artikel Nr. N° Article
	7	16	16	5	10	407RD
	8	16	16	4	10	408RD
	8	8	14	3	8	408RD8
	10	16	16	2	10	410RD
	12	16	16	2	10	412RD
	16	16	16	0	10	416RD
	10	16	16	3	10	410RDCR
	12	16	16	3	10	412RDCR

Maximum cutting-off :  
Maximal Abstechen :  $\varnothing 8 \text{ mm}$   
Tronçonnage maximum :

Maximum turning :  
Maximal Drehen :  $\varnothing \text{ ap } 2 \text{ mm}$   
Tournage maximum :

Examples of use for double tool-holders Anwendungsbeispiele für Doppelhalter Exemples d'utilisation de porte-outils doubles	S1	S2	T	d	e	Article nr. Artikel Nr. N° Article
 <p>ISO VC11 400line</p>	10	16	16	3	10	410RDVC11
 <p>124</p> <p>d, e, T, S1, S2</p>	12	16	16	3	10	412RDVC11
 <p>400line VPGT</p>	10	16	16	0	10	410RDVPGT
 <p>99</p> <p>d, e, T, S1, S2</p>						

**Tool-holder type 121 for Tornos Deco 7/10**

For small parts parting off. No need of special collet for pick-up attachment !

**Abstech-Werkzeughalter Typ 121 für Tornos Deco 7/10**

Zum Abstechen von kleinen Werkstücken. Abstechen ohne Abgreifzange mit Vorbau !

**Porte-outil de tronçonnage type 121 pour Tornos Deco 7/10**

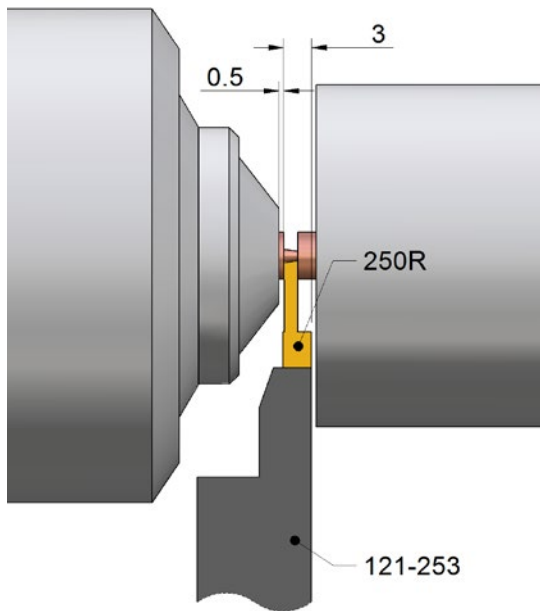
Pour le tronçonnage de petites pièces. Pas besoin de pince de prise de pièces à nez prolongé !



**Cutting off guide bush side**

**Abstechen an der Führungsbüchse**

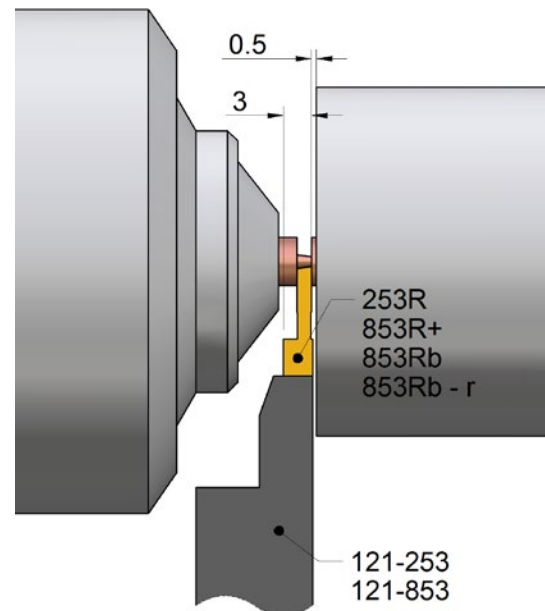
**Tronçonnage côté canon**



**Cutting off counter-spindle side**

**Abstechen an der Gegenspindel**

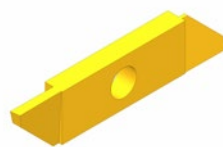
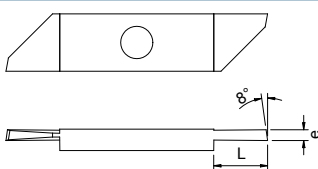
**Tronçonnage côté contre-broche**

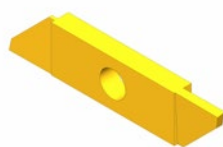
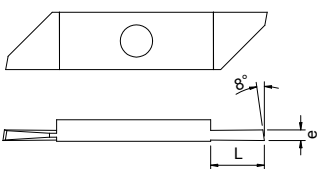



121-253	Description Bezeichnung Description	Article nr. Artikel Nr. N° Article
	<p>Cut-off tool-holder type 121 for inserts 250R and 253R Complete tool (articles 121-1 + 121-2), without insert</p> <p>Abstech-Werkzeughalter Typ 121 für Wendepplatten 250R und 253R Vollständiges Werkzeug (Artikel 121-1 + 121-2), ohne Wendepplatte</p> <p>Porte-outil de tronçonnage type 121 pour plaquettes 250R et 253R Outil complet (articles 121-1 + 121-2), sans plaquette</p>	121-253
121-853	Description Bezeichnung Description	Article nr. Artikel Nr. N° Article
	<p>Cut-off tool-holder type 121 for inserts 853R+, 853Rb and 853Rb - r Complete tool (articles 121-1 + 121-3), without insert</p> <p>Abstech-Werkzeughalter Typ 121 für Wendepplatten 853R+, 853Rb und 853Rb - r Vollständiges Werkzeug (Artikel 121-1 + 121-3), ohne Wendepplatte</p> <p>Porte-outil de tronçonnage type 121 pour plaquettes 853R+, 853Rb et 853Rb - r Outil complet (articles 121-1 + 121-3), sans plaquette</p>	121-853

121-x	Description Bezeichnung Description	Article nr. Artikel Nr. N° Article
	Only base plate Nur Basisplatte Uniquement plaque de base	121-1
	Only tool-holder for inserts 250R and 253R Nur Werkzeughalter für Wendepplatten 250R und 253R Uniquement porte-outil pour plaquettes 250R et 253R	121-2
	Only tool-holder for inserts 853R+, 853Rb and 853Rb - r Nur Werkzeughalter für Wendepplatten 853R+, 853Rb und 853Rb - r Uniquement porte-outil pour plaquettes 853R+, 853Rb et 853Rb - r	121-3

**Inserts**  
**Wendepplatten**  
**Plaquettes**

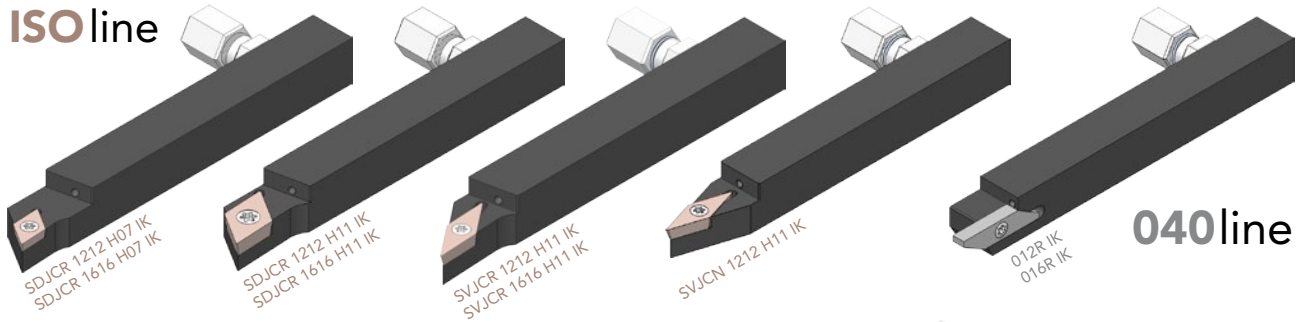
250R	Cutting insert Abstechplatte Tronçonneur	e	L	Article nr. Artikel Nr. N° Article	B120	B140	T1N
		1,0	4,5	250R1,0	x	✓	x
		1,2	4,5	250R1,2	✓	✓	x
		1,5	7,5	250R1,6	✓	✓	✓
		1,8	9,5	250R1,8	✓	✓	✓
		2,0	9,5	250R2,0	✓	✓	✓
		2,5	11,0	250R2,5	✓	✓	✓

253R	Opposite cutting insert Umgekehrte Abstechplatte Tronçonneur inversé	e	L	Article nr. Artikel Nr. N° Article	B120	B140	T1N
		1,0	7,5	253R1,0	✓	✓	x
		1,2	7,5	253R1,2	✓	✓	x
		1,5	7,5	253R1,5	✓	✓	x
		1,8	7,5	253R1,8	x	✓	x

800line+	Different cut off inserts Verschiedene Abstechplatten Différentes plaquettes de tronçonnage
	For further information about 853R+, 853Rb and 853Rb - r inserts, please see the «800line+» catalog.  Für mehr Informationen über 853R+, 853Rb und 853Rb - r Wendepplatten, bitte sehen Sie die Katalog «800line+».  Pour le détail des plaquettes 853R+, 853Rb et 853Rb - r, voir le catalogue «800line+».

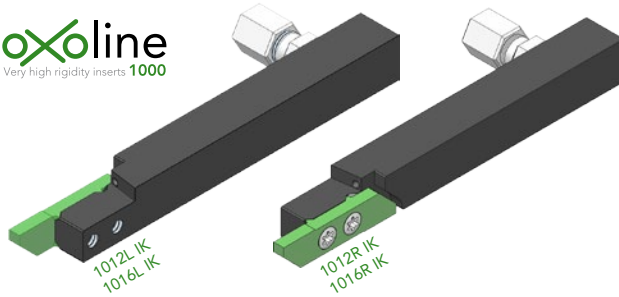


**ISO line**

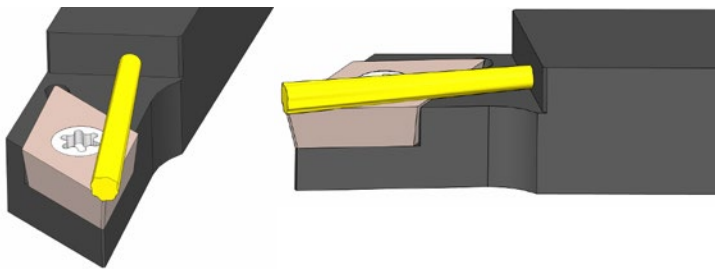
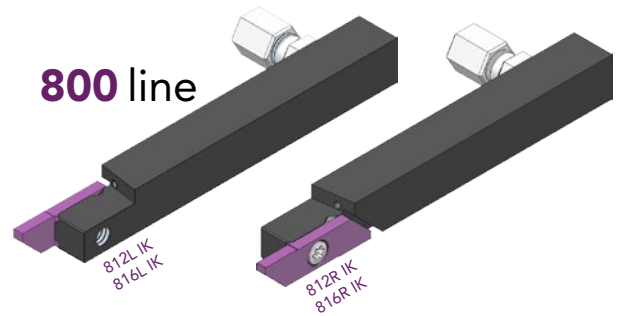


**040line**

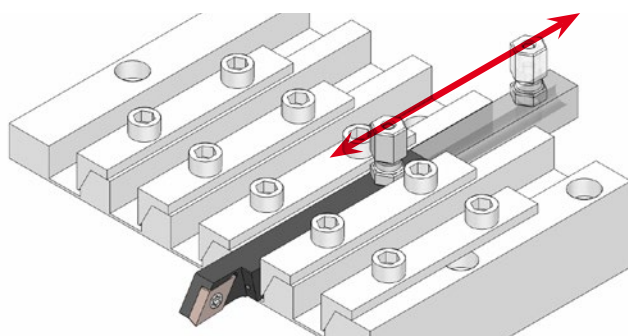
**oxoline**  
Very high rigidity inserts 1000



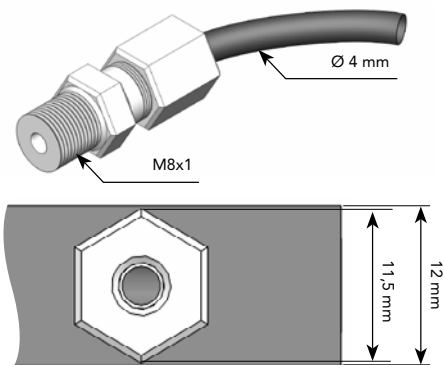
**800 line**



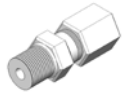
- High pressure coolant directly on the cutting edge. Coolant in the insert's axis.
- Durch Hochdruckkühlung entlang der Längsachse, direkt auf die Schneidkante der Wendeplatte, erhalten Sie eine deutlich bessere Oberflächengüte und erheblich längere Standzeiten Ihrer Werkzeuge.
- Arrosage haute pression sur l'arête de coupe. Jet dans l'axe de la plaquette.



- Possibility to slide the tool-holder on whole length for setting.
- Beim Einrichten können diese Werkzeughalter in ihrer gesamten Länge auf dem Träger gleiten.
- Possibilité de coulisser l'outil sur toute la longueur pour le réglage.



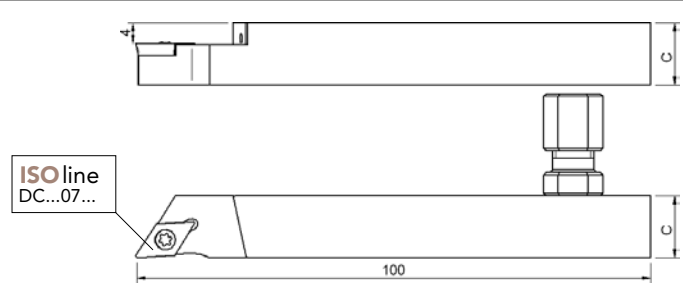
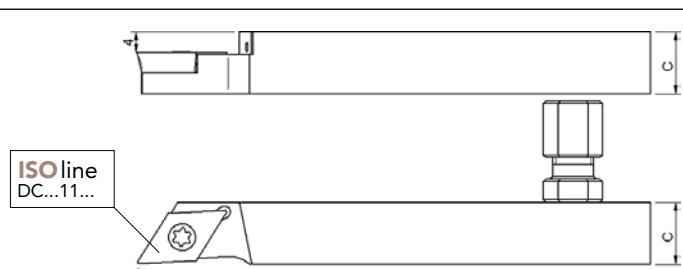
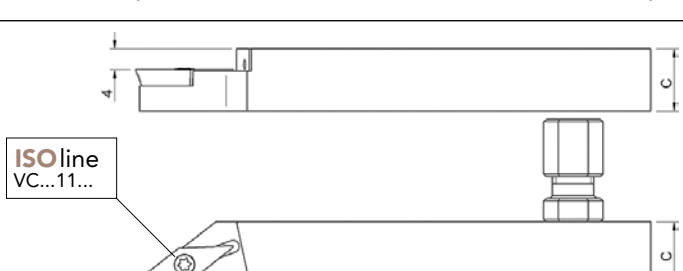
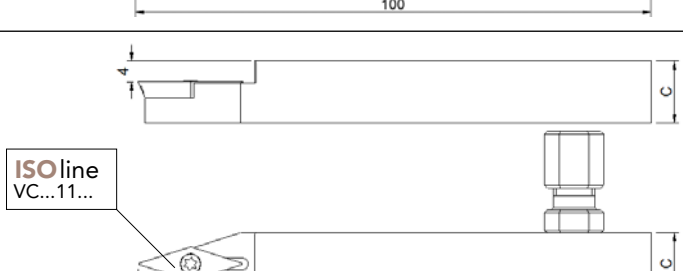
- The hydraulic fitting does not cover the tool, even for section 12x12 mm.
- Das hydraulische Anschlussstück ragt nicht über die Breite des Halters hinaus, auch nicht bei Querschnitten 12x12 mm.
- Le raccord hydraulique ne dépasse pas de l'outil même en section 12x12 mm.

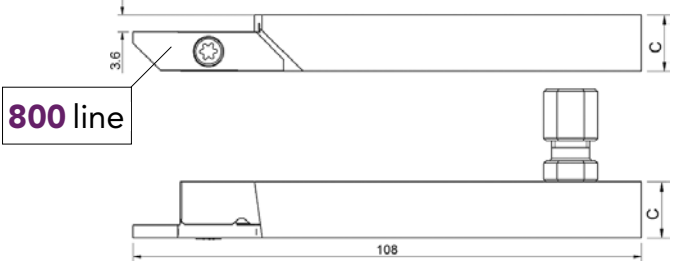
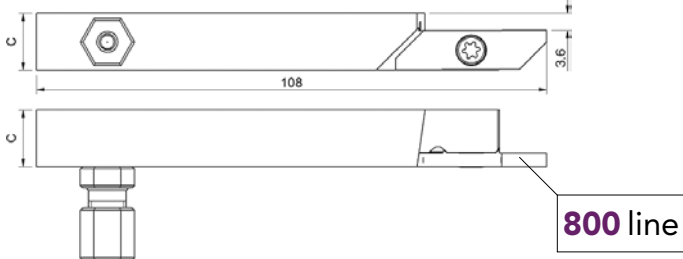
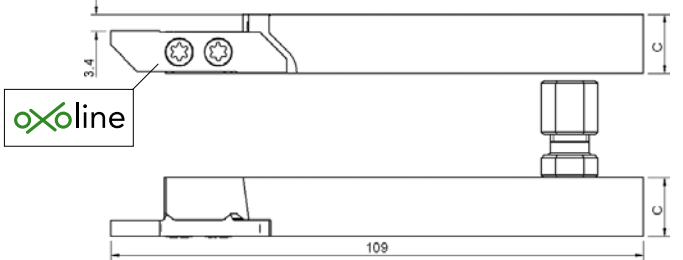
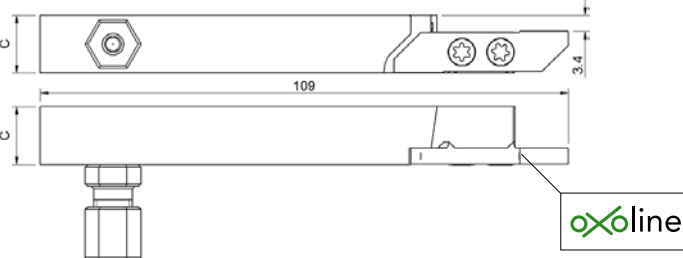
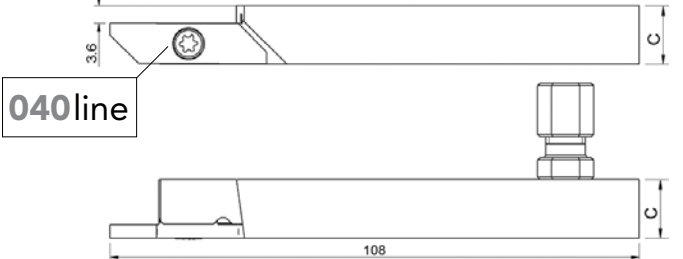


1 hydraulic fitting (M8x1, cone shape, output Ø 4 mm) is delivered with each tool-holder.  
1 hydraulischer Anschluss (M8x1, konisch, Ausgang Ø 4 mm) wird mit jedem Werkzeughalter geliefert.  
1 raccord hydraulique (M8x1 conique, sortie Ø 4 mm) est livré avec chaque porte-outil.



To guarantee the smooth running of tool-holders, the oil must be filtered in 60 µm.  
Um einen reibungslosen Ablauf der Werkzeughalter zu gewährleisten, muss das Öl in 60 µm filtriert werden.  
Afin de garantir le bon fonctionnement des porte-outils, l'huile doit être filtrée à 60 µm.

Tool-holders with internal coolant Werkzeughalter mit Innenkühlung Porte-outils avec arrosage	Section C Querschnitt C Section C	Article nr. Artikel Nr. N° Article
 <p>ISO line DC...07...</p>	12x12 mm	SDJCR 1212 H07 IK
	16x16 mm	SDJCR 1616 H07 IK
 <p>ISO line DC...11...</p>	12x12 mm	SDJCR 1212 H11 IK
	16x16 mm	SDJCR 1616 H11 IK
 <p>ISO line VC...11...</p>	12x12 mm	SVJCR 1212 H11 IK
	16x16 mm	SVJCR 1616 H11 IK
 <p>ISO line VC...11...</p>	12x12 mm	SVJCN 1212 H11 IK

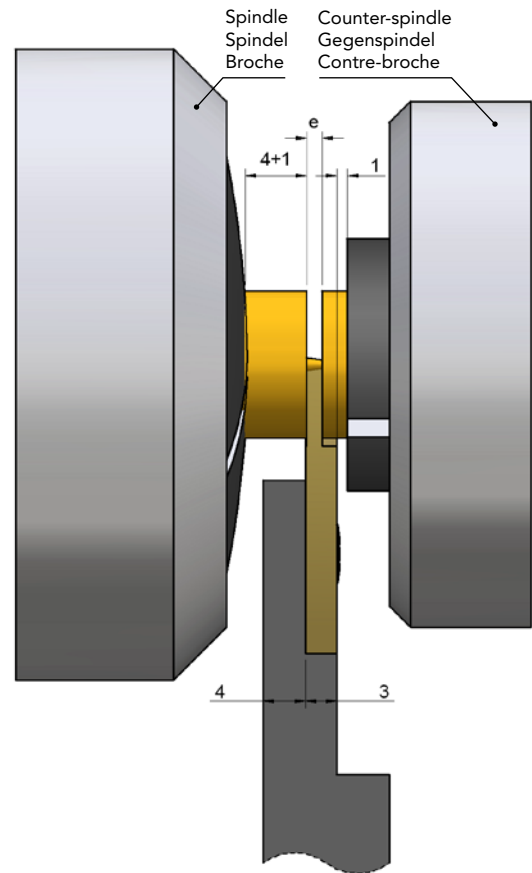
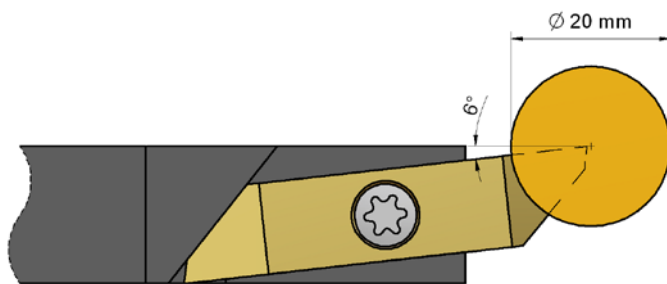
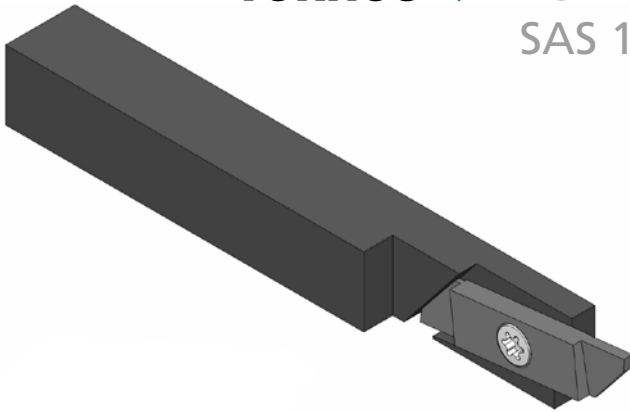
Tool-holders with internal coolant Werkzeughalter mit Innenkühlung Porte-outils avec arrosage	Section C Querschnitt C Section C	Article nr. Artikel Nr. N° Article
 <p><b>800 line</b></p>	12x12 mm	812R IK
	16x16 mm	816R IK
 <p><b>800 line</b></p>	12x12 mm	812L IK
	16x16 mm	816L IK
 <p><b>oxoline</b></p>	12x12 mm	1012R IK
	16x16 mm	1016R IK
 <p><b>oxoline</b></p>	12x12 mm	1012L IK
	16x16 mm	1016L IK
 <p><b>040 line</b></p>	12x12 mm	012R IK
	16x16 mm	016R IK

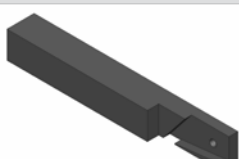
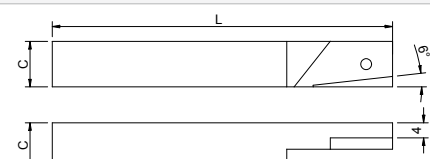
for | für | pour

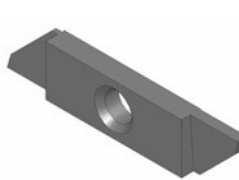
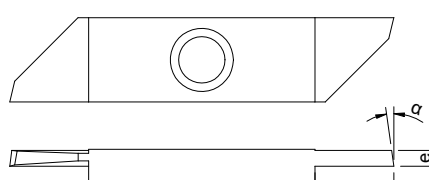



**TORNOS**


AS 14  
SAS 16

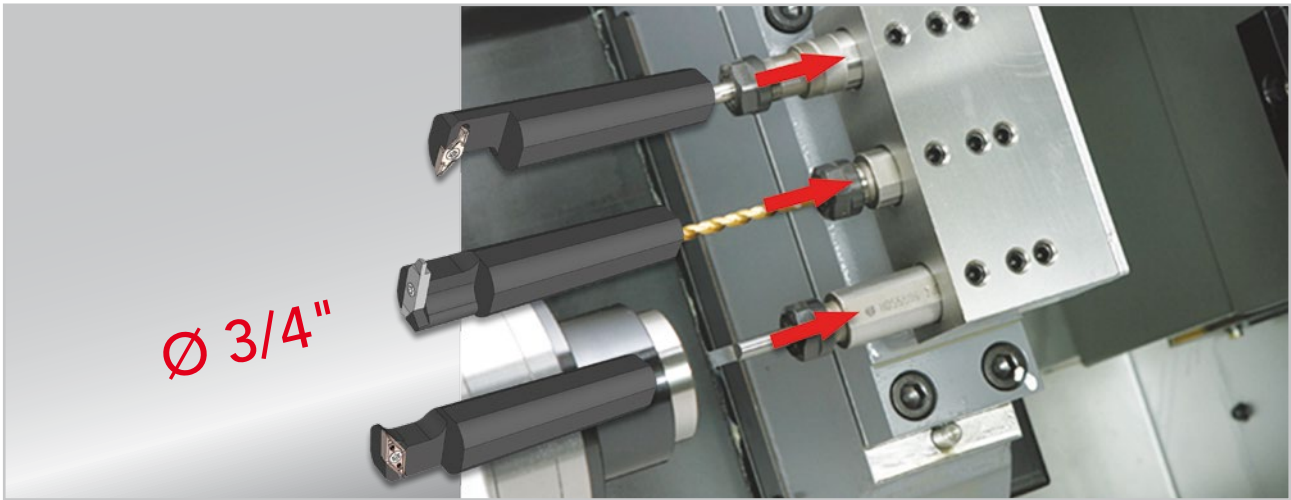


<b>2xxR</b>	Right tool-holder, «Pick-up» 4 mm, insert 3 mm at 6° Werkzeughalter rechts, «Pick-up» 4 mm, 3 mm Wendeplatte 6° Porte-outil à droite, déporté 4 mm, plaquette 3 mm à 6°	Section C Querschnitt C Section C	Length L Länge L Longueur L	Article nr. Artikel Nr. N° Article
		12 x 12	90	212R4-3-90

<b>250R</b>	Cutting insert 8° Abstechplatte 8° Tronçonneur 8°	e	L	Article nr. Artikel Nr. N° Article	BI40	TIN
		1,0	4,5	250R1,0	✓	✓
		1,2	4,5	250R1,2	✓	✓
		1,4	7,5	250R1,4	✓	✓
		1,5	7,5	250R1,5	✓	✓
		1,6	9,5	250R1,6	✓	✓
		1,8	9,5	250R1,8	✓	✓
		2,0	9,5	250R2,0	✓	✓
		2,5	11	250R2,5	✓	✓

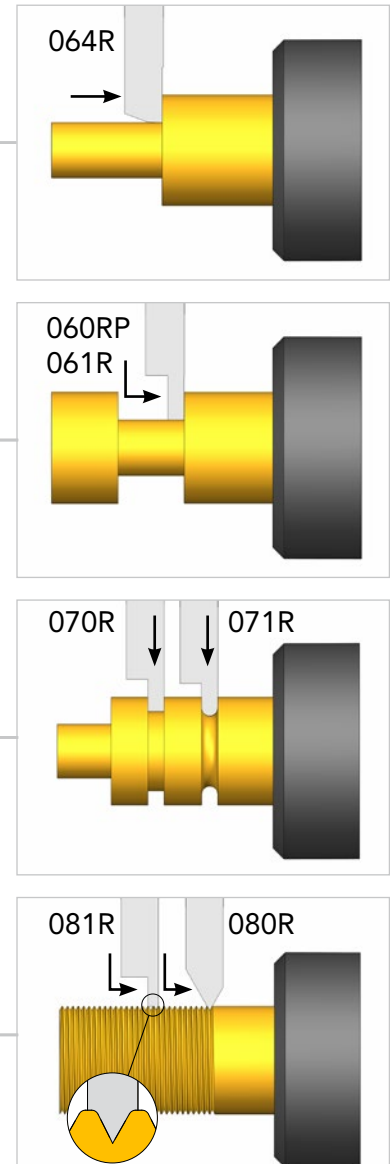
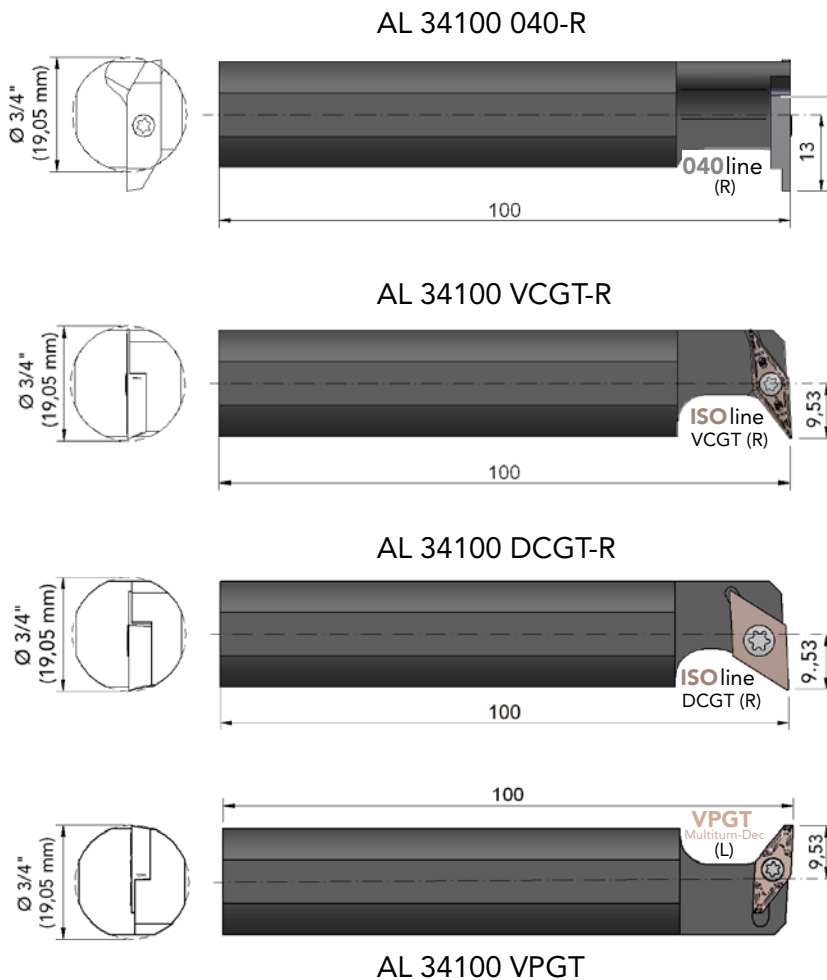
<b>100-1</b>	Key Schlüssel Clé	Article nr. Artikel Nr. N° Article
	Torx 15	100-1

<b>100-2c</b>	Screw for standard tool-holder Schraube für standard Werkzeughalter Vis pour porte-outil standard	Article nr. Artikel Nr. N° Article
	M3,5 x 7	100-2c



for | für | pour

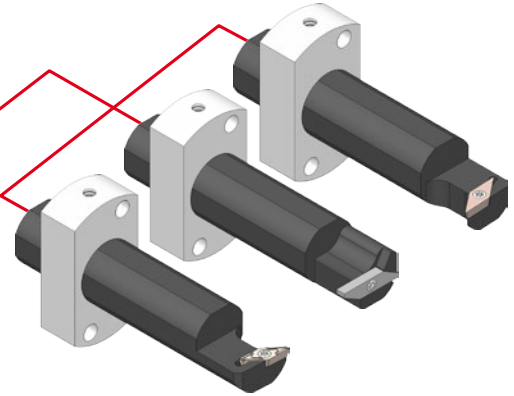
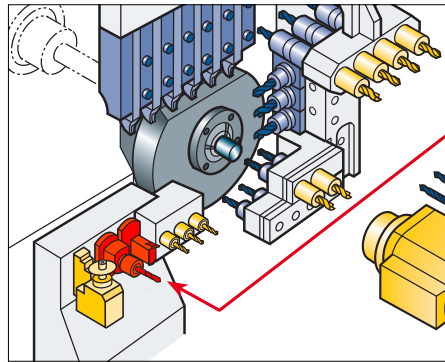
**Citizen**



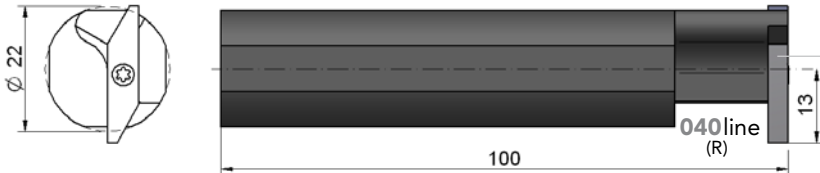
for | für | pour

**star**

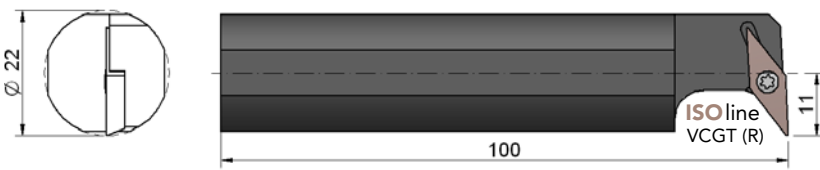
SR-20R III SB-16  
SR-20R IV SB-20  
SR-20J SW-20  
SR-20J N



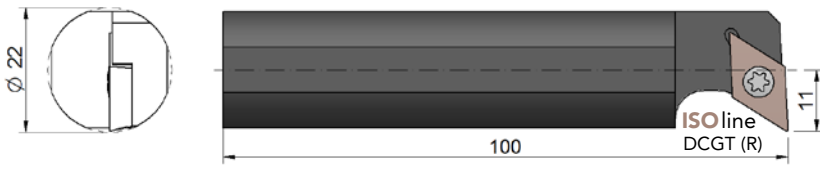
AL 22100 040-R



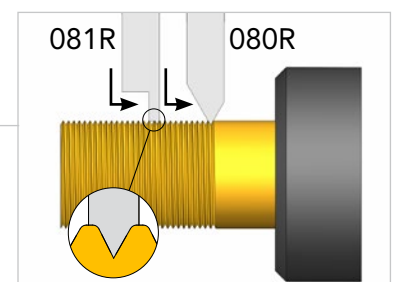
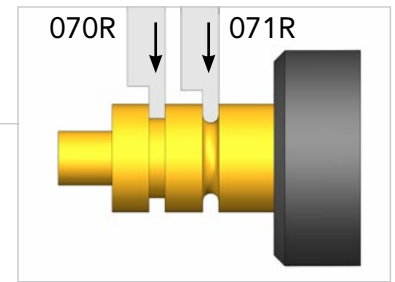
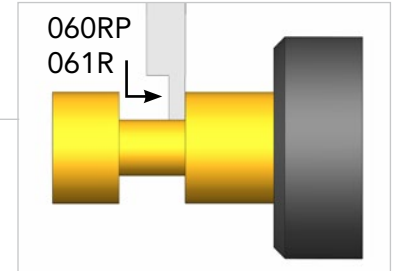
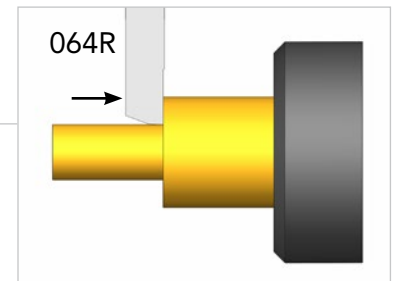
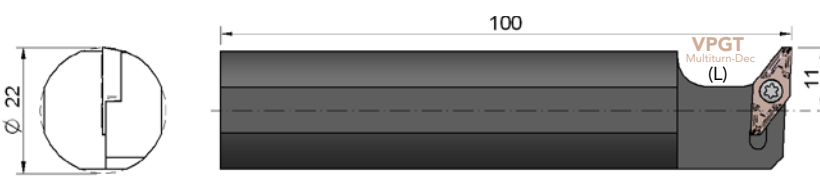
AL 22100 VCGT-R



AL 22100 DCGT-R

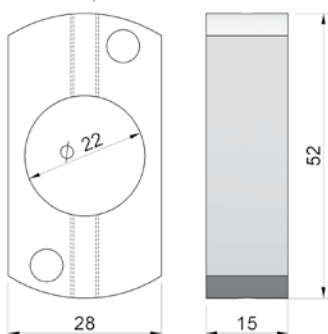


AL 22100 VPGT



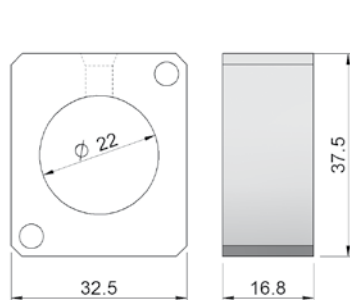
STAR-KP1-22SRR

SR-20R III | SR-20J | SR-20JN  
SB-16C/E | SB-20 C/E



STAR-KP1-22SW

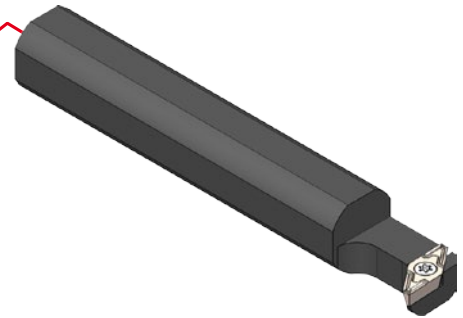
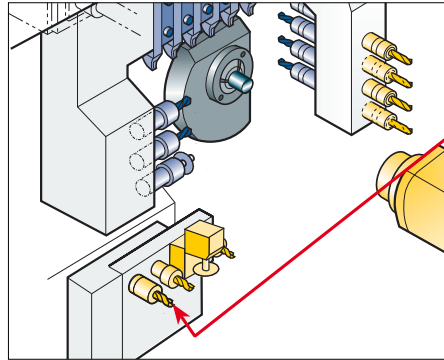
SR-20R IV | SW-20



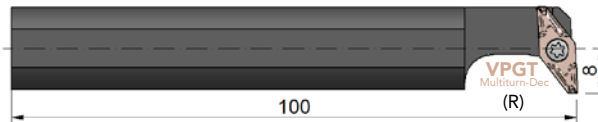
for | für | pour

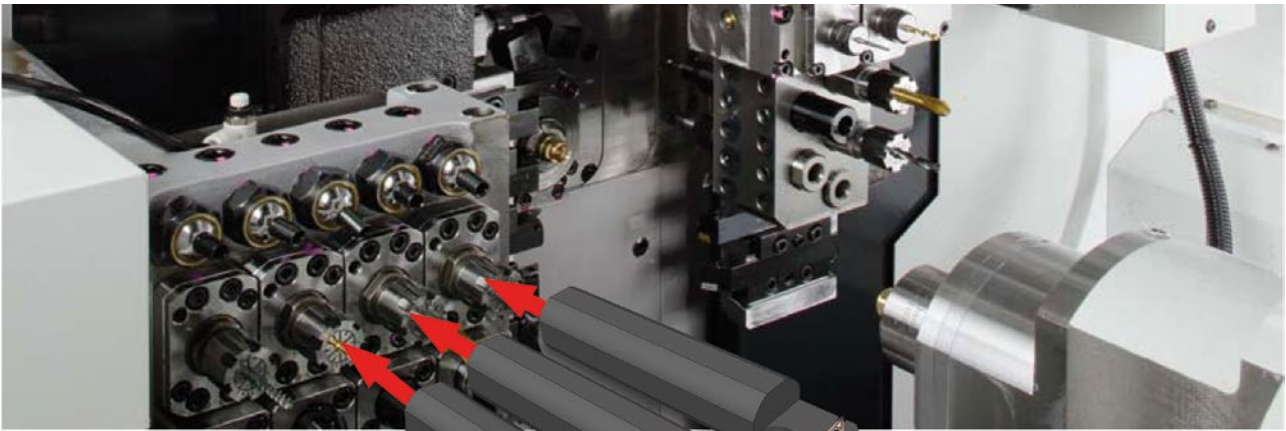
**star**

SR-10J



AL 16100 VPGT-R



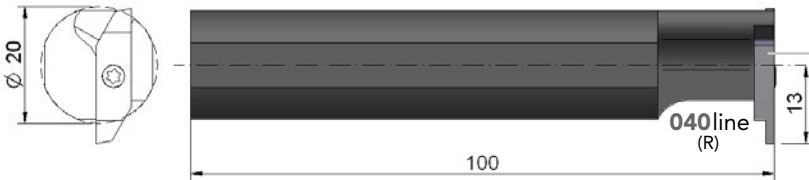


for | für | pour

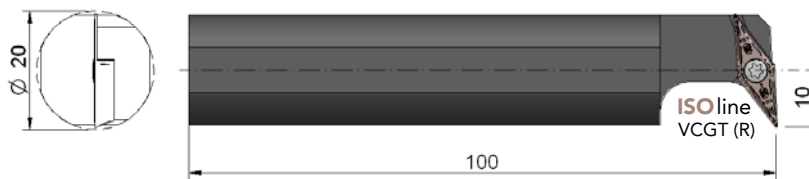


GAMMA 20  
DELTA 12 / DELTA 20  
EvoDECO 10

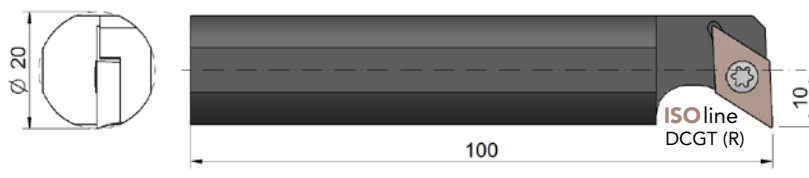
AL 20100 040-R



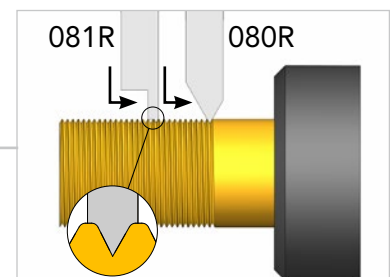
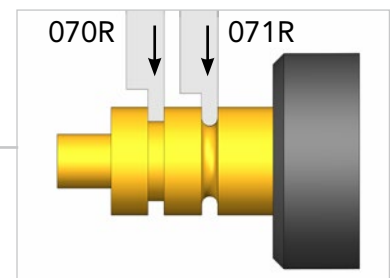
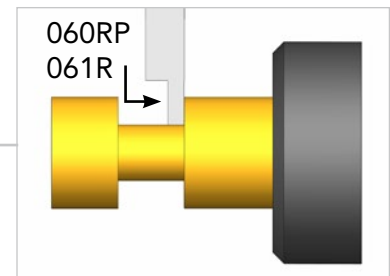
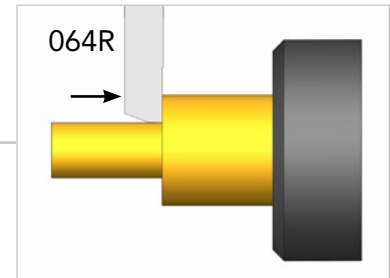
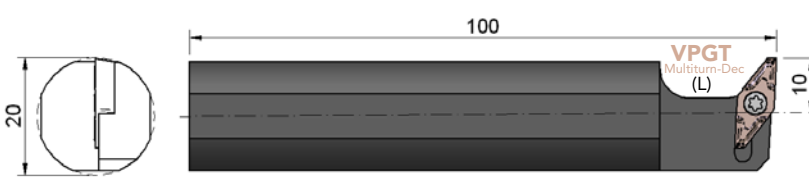
AL 20100 VCGT-R



AL 20100 DCGT-R



AL 20100 VPGT

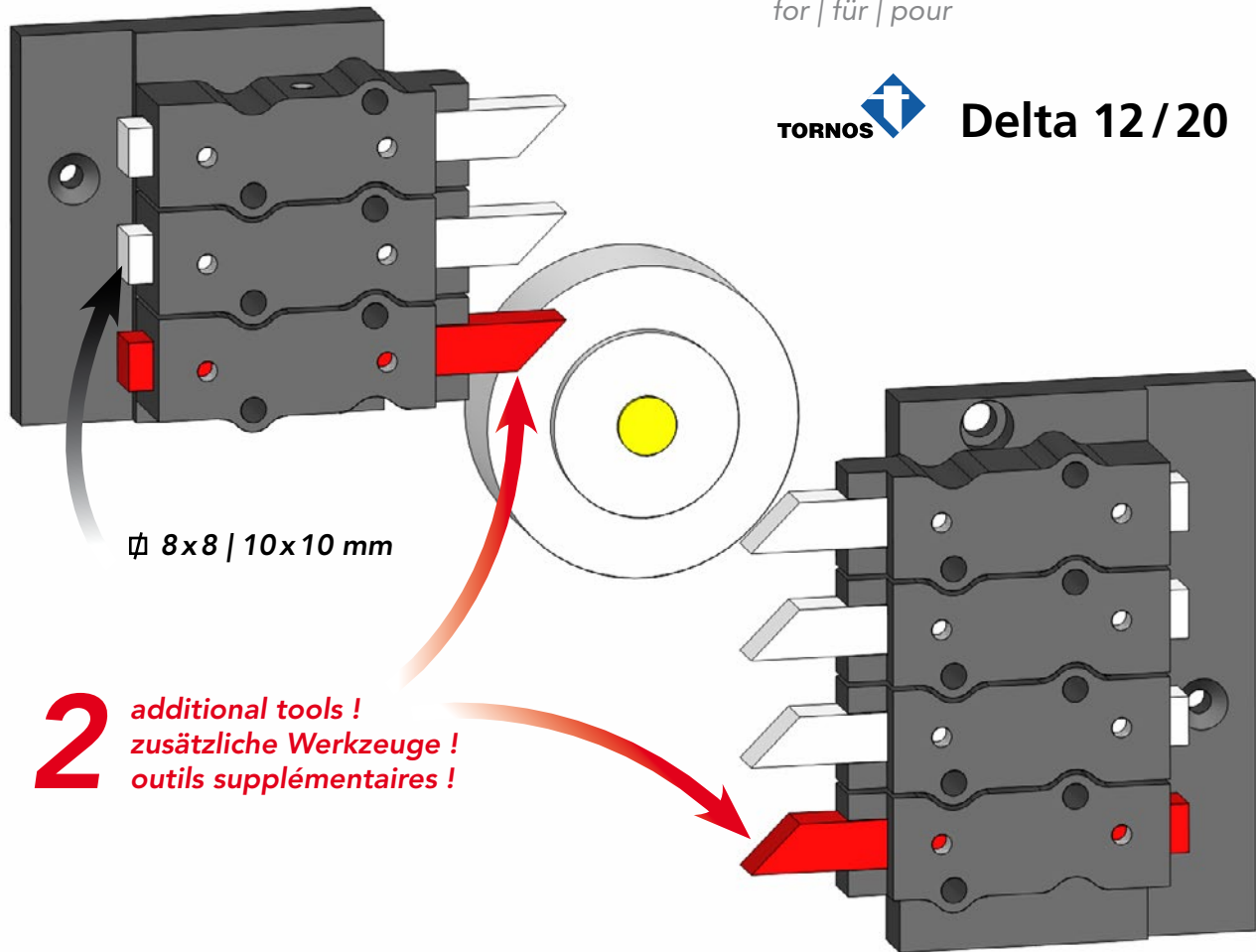




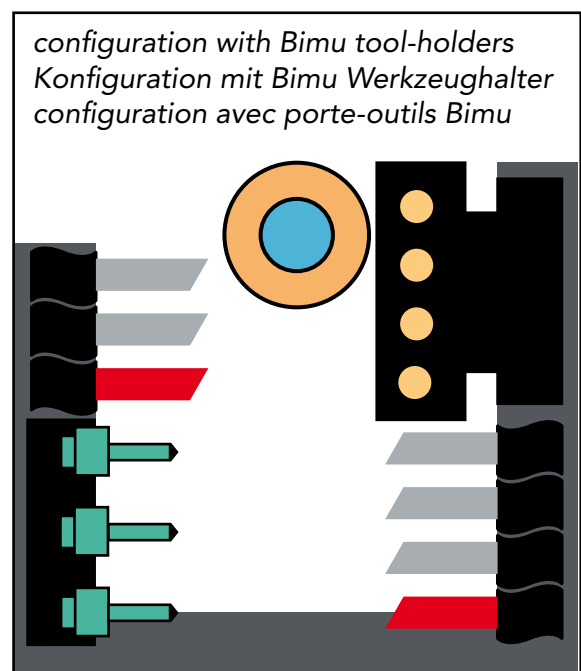
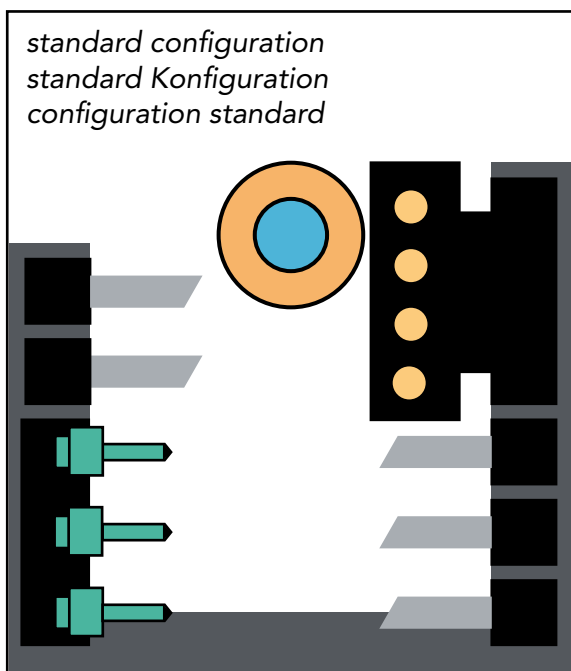
for | für | pour

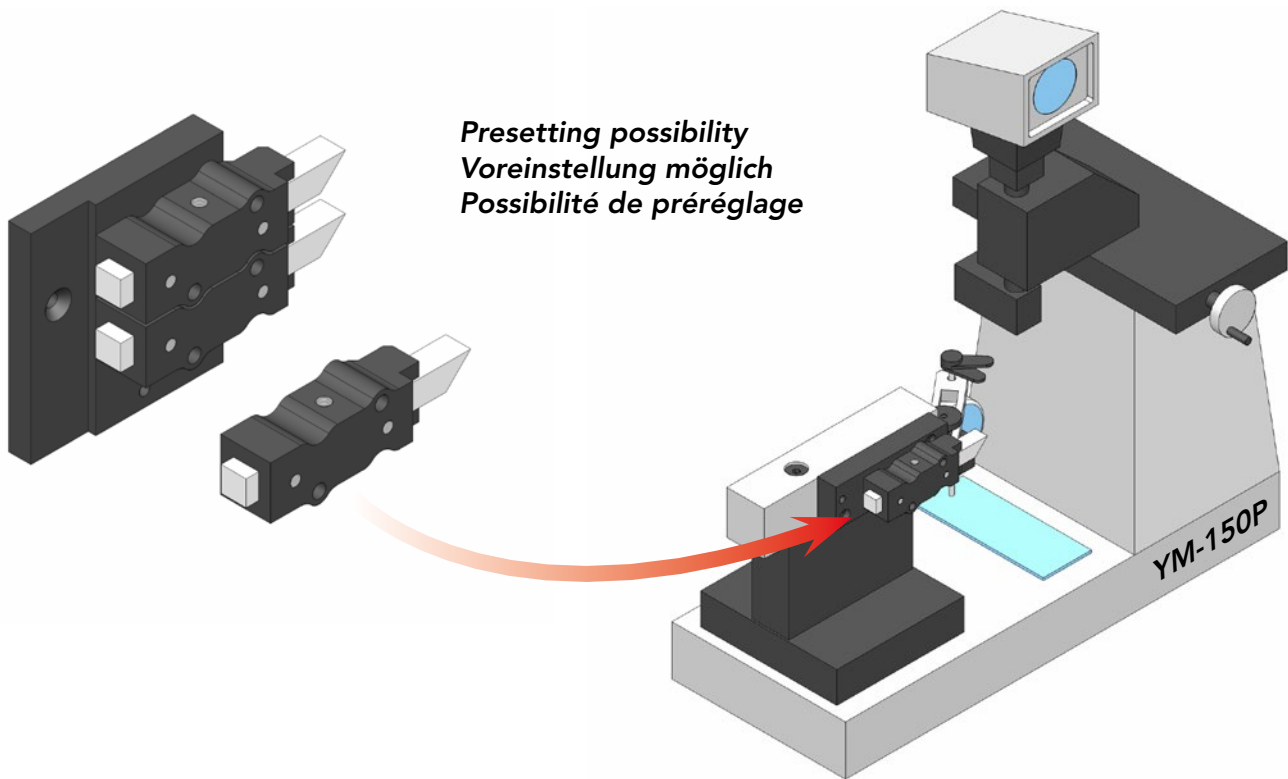




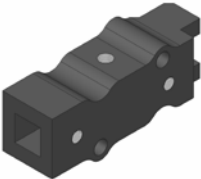

**Delta 12/20**



**2** additional tools !  
zusätzliche Werkzeuge !  
outils supplémentaires !





	Description Bezeichnung Description	Article nr. Artikel Nr. N° Article
	Baseplate 3 positions. Basisplatte mit 3 Positionen. Plaque de base 3 positions.	015.14.203
	Baseplate 4 positions. Basisplatte mit 4 Positionen. Plaque de base 4 positions.	015.14.204
	Tool-holder for chisel of section 8x8 or 10x10 mm. Werkzeughalter für Drehstahl, Querschnitt 8x8 oder 10x10 mm. Porte-outil pour burin de section 8x8 ou 10x10 mm.	015.14.210
	Presetting plate. Voreinstellplatte. Plaque de préréglage.	015.14.900