

PRODUCT CATALOG

New ULTRAMINI Tools

INSERT GEOMETRIES, SUBSTRATES AND COATINGS DESIGNED FOR SPECIFIC INDUSTRIES:
MEDILINE: Medical Line • XTRALINE: Aerospace Line • HARDLINE: Hard Part Machining



ULTRAMINI

New MINICUT Tools

Inch Widths with Radii • Larger T max. Series Inserts • Inserts with Chip Breakers



MINICUT



WHAT'S NEW

ULTRAMINI



Holders

- Type 645.G *****Best in Class***** .01 Repeatability
- Type 676.G *****Best in Class***** .01 Repeatability
- Type 660, 670 & 680 **New sizes.** Inch sizes available
- Type 645.PT **Premium line holder.** Improved cooling. Inch sizes available
- Type 676.PT **Premium line holder.** Improved cooling. Inch sizes available
- Type 687.PT **Premium line holder.** Improved cooling
- Type UM600H **High performance holder with coolant connection.** Inch sizes available

Inserts

- Type 053 **With corner radius**
- Mediline type M050 **Insert geometries, substrates and coatings designed for specific industries**
- Xtraline type X050 **Insert geometries, substrates and coatings designed for specific industries**
- Hardline type 050 **Insert geometries, substrates and coatings designed for specific industries**
- Type 050C **New sizes**
- Type 004M **With corner radius.** Inch size available
- Type 006M **With corner radius.** Inch sizes available
- Type 007 **New size.** Inch size available
- Type 007M **With corner radius.** New sizes. Inch sizes available
- Type 060 **New sizes**
- Whitworth Full Profile Threading **Inch sizes available**
- NPT Partial Profile Threading **Inch sizes available**
- Type 012 & 016 Face Grooving Inserts **New sizes**

MINICUT



Holders

- Type 608/609/611/614 **New size.** Inch sizes available
- Type 614.A & 618.A **New size**
- Type 614SQ (square) **New holder series**
- Type 614SQ.A (square) **New holder series**

Inserts

- Type Grooving Internal **New sizes.** Inch sizes available
 - Bore Ø from 8 - 16 mm
- Type NC - Profiling Internal **New sizes.** Inch sizes available
 - Bore Ø from 8 - 16 mm
- Type Grooving Internal **With full radius.** Inch size available
 - Bore Ø starting at 14 / 16 mm
- Type Boring and Copying Internal **New sizes**
 - Bore Ø from 7.8 / 9 / 9.8 / 11 / 13.8 / 14 / 15.5 mm
- Type Boring Internal **Special chipformer**
 - Bore Ø from 8 / 9 / 11 mm
- Type NPT Full Profile Threading **Inch sizes available**
 - Bore Ø from 8 mm
- Type Axial Face Grooving past the pin with corner radius **New sizes.** Inch sizes available
 - Outer groove Ø from 12 / 16 mm
- Type Axial Face Grooving **New sizes**
 - Outer groove Ø from 14 / 18 mm
- Type Axial Face Grooving past the pin with corner radius **With full radius**
 - Outer groove Ø from 12 mm
- Type Face Grooving **With full radius.** New sizes
 - Outer groove Ø from 14 mm



Ultramini



Grooving, boring and profiling
starting at \varnothing 0.2 mm

NEW

ULTRAMINI



Grooving, boring and profiling
starting at Ø 0.2 mm

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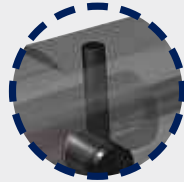
Over 1000 different inserts are available in stock

Standard Holders - Repeatable to .02 mm

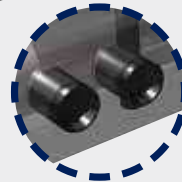
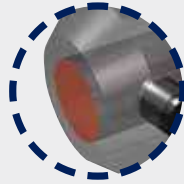
G Holders - Repeatable to .01 mm *****BEST IN CLASS*****

- Quick and easy changing of inserts
- Maximum repeating accuracy of the length and diameter setting
- Easy and correct compliance with peak heights

Coolant Through



Stop pin for high repeating accuracy (+/- .02 mm)



Double clamp holder for high clamping security



TOOL HOLDERS

NEW



Type **645.G**
for inserts with bore Ø 0.2 - Ø 5.0 mm

... 12

G Holders
*****BEST IN CLASS*****
.01 mm Repeatability

NEW



Type **676.G**
for inserts with bore Ø from 0.6 mm

... 13



Type **681**
for inserts with bore Ø from 7.8 mm

... 14



Type **687**
for inserts with bore Ø 6.8 mm

... 15

NEW



Type **660, 670, 680**
for inserts with bore Ø 6 mm, Ø 6.8 mm + Ø 7.8 mm

... 16



TOOL HOLDERS

NEW



Type 645.PT ... 17
for inserts with bore Ø 0.2 - Ø 5.0 mm

NEW



Type 676.PT ... 18
for inserts with bore Ø 6.0 - Ø 7.0 mm

NEW



Type 687.PT ... 19
for inserts with bore Ø 6.8 - Ø 7.8 mm

NEW



Type UM600H ... 20
for inserts with bore Ø 0.2 - Ø 7.0 mm



Type UM ... 23
for inserts D min. Ø 0.2 - 7.0 mm



Type UHCM ... 24
for inserts with bore Ø from Ø 12.0 mm



Type UM.18 / UM.28 ... 25
for inserts with bore Ø from Ø 10.0 mm

NEW

ULTRAMINI

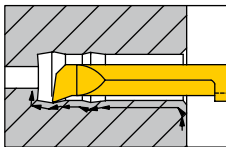


Grooving, boring and profiling
starting at Ø 0.2 mm

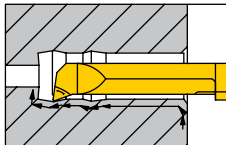
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INSERTS - Profiling and copying

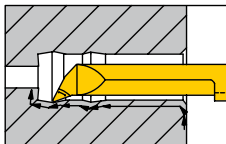
NEW



Type 050 . . . 26
profiling and copying
bore Ø from 0.2 mm

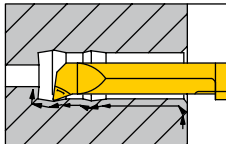


Type 050 . . . 28
profiling and copying
bore Ø from 2.0 mm

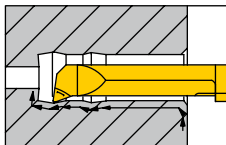


Type 050.20 . . . 30
profiling and copying
with frontside angle 20°
bore Ø from 2.0 mm

NEW

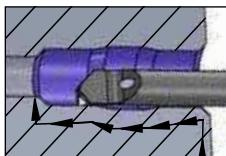


Type 053 . . . 31
profiling and copying
with corner radius 0.03 mm
bore Ø from 2.8 mm



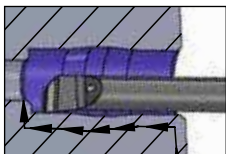
Type 055 . . . 32
profiling and copying
with corner radius 0.05 mm
bore Ø from 2.0 mm

NEW

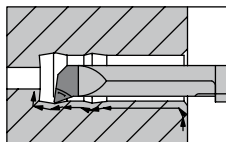


Mediline type M050 . . . 34
profiling and copying
with modified profile
bore Ø from 2.0 mm

NEW



Xtraline type X050 . . . 36
profiling and copying
with chipbreaker, extra
solid construction
bore Ø from 1.0 mm

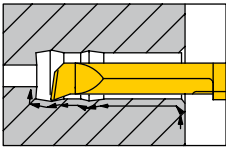


Type Hardline 050 . . . 40
ab Ø 2.0 mm

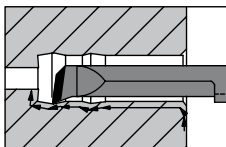


NEW

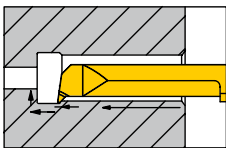
INSERTS - Profiling and copying



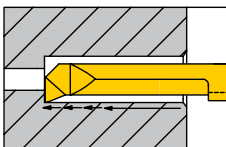
Type 050 C ... 42
 profiling and copying
 with chipbreaker for
 better chipcontrol
 bore Ø from 2.0 mm



Type 050 CBN ... 44
 profiling and copying
 bore Ø from 2.8 mm

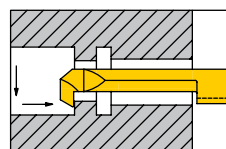


Type 047 ... 45
 boring and profiling
 with 47° geometry
 bore Ø from 4.0 mm



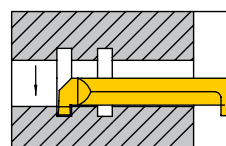
Type 090 ... 46
 boring and profiling
 with 90° geometry
 bore Ø from 2.8 mm

INSERTS - Backboring



Type 080 ... 47
 backboring
 bore Ø from 3.0 mm

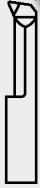
INSERTS - Grooving internal



Type 002 ... 48
 grooving
 bore Ø from 2.0 mm
 depth of groove
 up to 0.4 mm

NEW

ULTRAMINI

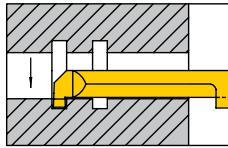


Grooving, boring and profiling
starting at Ø 0.2 mm

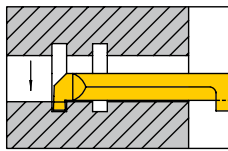
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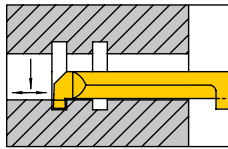
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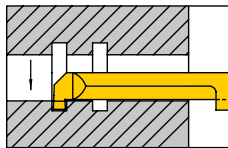
Type 003 ... 49
grooving
bore Ø from 3.0 mm
depth of groove
up to 0.6 mm



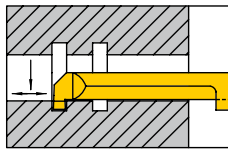
Type 004 ... 50
grooving internal
bore Ø from 4.0 mm
depth of groove
up to 0.8 mm



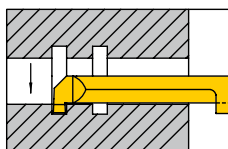
Type 004 M ... 51
grooving internal
with corner radius
bore Ø from 4.0 mm
depth of groove
up to 0.8 mm



Type 005 ... 52
grooving internal
bore Ø from 5.0 mm
depth of groove up to
1.0 mm overhang length
(L1) up to 7xD

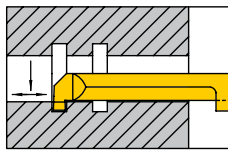


Type 005 M ... 54
grooving internal
with corner radius
bore Ø from 5.0 mm
depth of groove up
to 1.0 mm



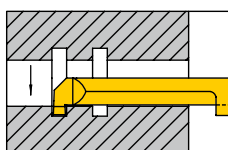
Type 006 ... 56
grooving internal
bore Ø from 6.0 mm
depth of groove up to
1.8 mm. overhang length
(L1) up to 7xD

NEW



Type 006 M ... 58
grooving internal
with corner radius
bore Ø from 6.0 mm
depth of groove up
to 1.8 mm

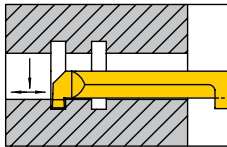
NEW



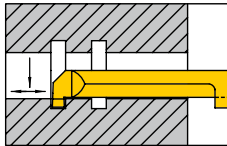
Type 007 ... 60
grooving internal
bore Ø from 6.8 mm
depth of groove up to
2.5 mm. overhang length
(L1) up to 7xD



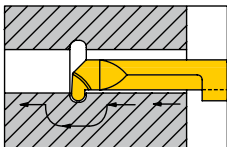
NEW



Type 007 M ... 62
grooving internal with corner radius
bore \varnothing from 6.8 mm
depth of groove up to 2.5 mm

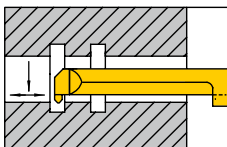


Type 008 M ... 63
grooving internal with corner radius
bore \varnothing from 7.8 mm
depth of groove up to 3.0 mm

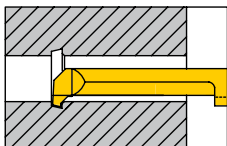


Type full radius ... 64
grooving internal copying
bore \varnothing from 4.0 mm
full radius 0.5-1.0 mm

NEW



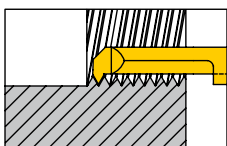
Type 060 ... 66
boring/ profiling and chamfering
bore \varnothing from 5.0 mm



Type 070 ... 67
pregrooving and chamfering
bore \varnothing from 4.0 mm

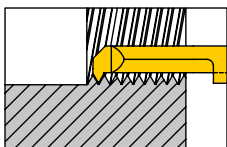
INSERTS - Threading internal

NEW

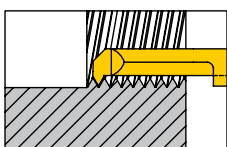


Type threading metric ISO-whitworth thread ... 68
full profile internal 55°
bore \varnothing from 6.0 mm

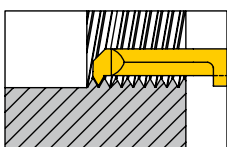
NEW



Type threading NPT thread ... 69
partial profile internal 60°
bore \varnothing from 6.0 mm
pitch P = 0.94-1.411 mm



Type threading metric ISO-standard thread ... 70
partial profile internal 60°
bore \varnothing from 2.4 mm
pitch P = 0.5-1.5 mm



Type threading metric ISO-fine thread ... 71
partial profile internal 60°
bore \varnothing from 3.2 mm
pitch P = 0.5-1.0 mm



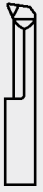
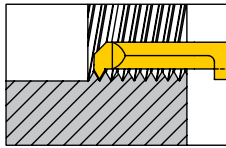
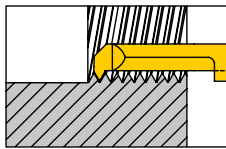


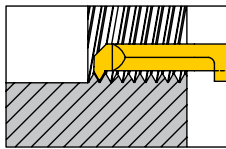
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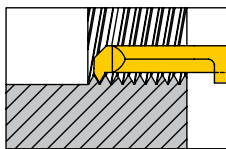
**Type threading
metric ISO-standard thread** ... 72
full profile internal 60°
bore Ø from 4.8 mm
pitch P = 0.8-1.5 mm



**Type threading
metric ISO-fine thread** ... 73
full profile internal 60°
bore Ø from 4.0 mm
pitch P = 0.5-1.0 mm

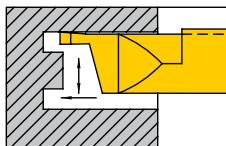


**Type threading
metric ISO-whitworth thread** ... 74
partial profile internal 55°
bore Ø from 4.8 mm

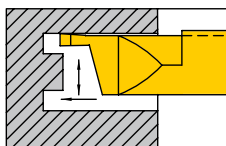


**Type threading
trapezoidal thread** ... 75
partial profile internal 30°
bore Ø from 7.0 mm
pitch P = 2.0-3.0 mm

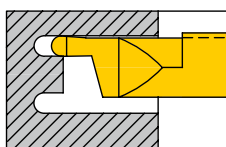
INSERTS - Face grooving



Type 510 M ... 76
face grooving internal
with corner radius
bore Ø from 5.0 mm
depth of groove up to
4.0 mm

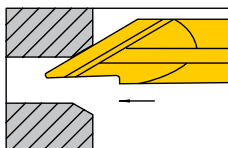
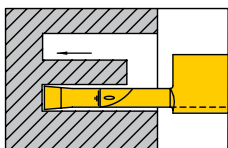
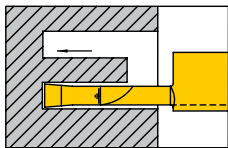
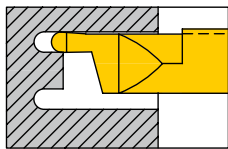
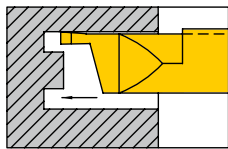
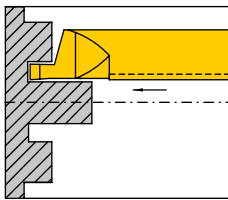
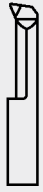


Type 610 ... 77
face grooving internal
bore Ø from 6.0 mm



Type 610 M ... 78
face grooving internal
with corner radius
bore Ø from 6.0 mm

Type 610 full radius ... 79
face grooving internal
full radius
bore Ø from 6.0 mm



NEW

Type 620 ... 80

face grooving internal
axial grooving past the pin
with corner radius
bore Ø from 6.0 mm

Type 620 M ... 81

face grooving internal
axial grooving past the pin
with corner radius
bore Ø from 6.0 mm

Type 010 ... 82

face grooving internal
bore Ø from 8.0 mm

Type 010 M ... 84

face grooving internal
with corner radius
bore Ø from 8.0 mm

Type 010 full radius ... 85

face grooving internal
full radius
bore Ø from 6.0 mm

Type 015 ... 86

face grooving
bore Ø from 8.0 mm

Type 015 M ... 87

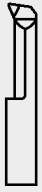
face grooving
with corner radius
bore Ø from 8.0 mm

Type 012/016/020 ... 88

face grooving
with double internal
cooling channel
bore Ø from 16.0 mm

Type 520 ... 89

chamfering internal bore
bore Ø from 1.0 mm



ULTRAMINI

Grooving, boring and profiling
starting at Ø 0.2 mm

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SETS



Set 1
boring/profiling, copying
and grooving right

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Set 2
grooving right

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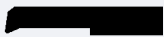
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boring/profiling,
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Set 6
right face grooving

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ULTRAMINI

Machining example

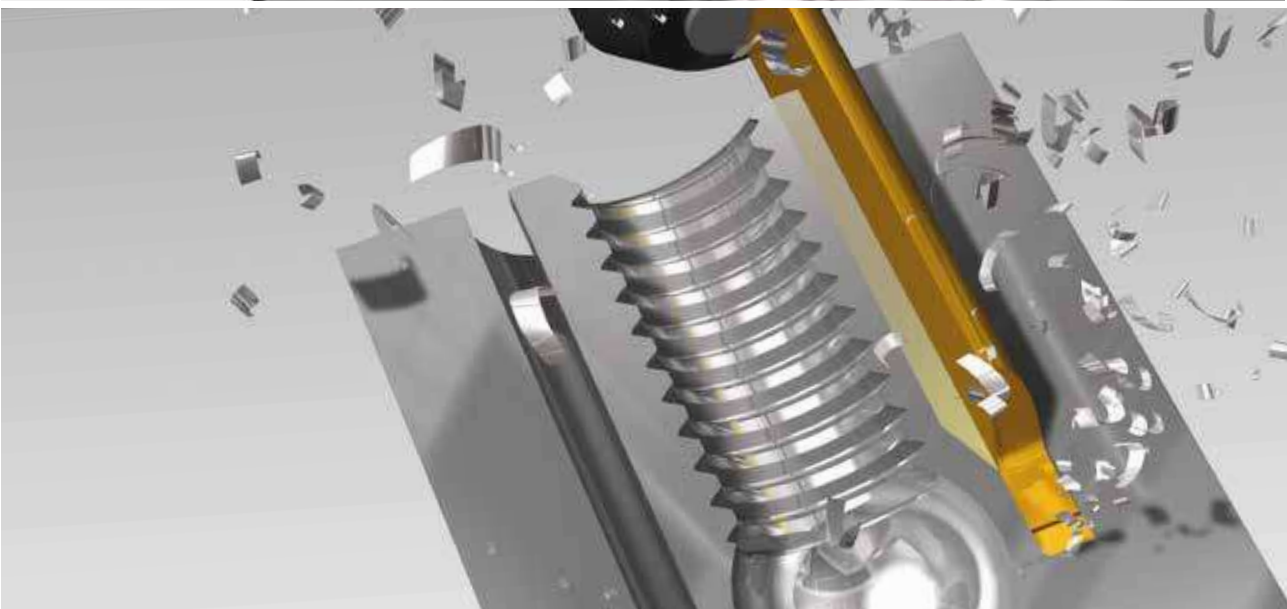


Grooving, boring and profiling
starting at \varnothing 0.2 mm



Only 2 tool holders for over 1000 different inserts.
The superior system in the world of minature machining.

 Dümmel®



NEW

ULTRAMINI



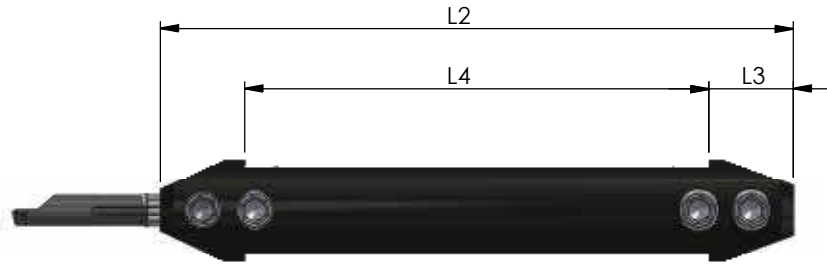
Grooving, boring, profiling,
threading and chamfering
starting at \varnothing 0.2 mm

Type 645.G

Tool holder improved version
with modified clamping screw

Starting at \varnothing 12.0 mm
for insert
D min. \varnothing 0.2 mm - 5.0 mm

G Holders
*****BEST IN CLASS*****
.01 mm Repeatability



Clamping side
 \varnothing 4.0 mm

Clamping side
 \varnothing 5.0 mm



Tool holder usable for right and
left hand inserts
All inserts with shaft diameter
4-7 mm can be clamped with
only two tool holders
Dimensions in mm

part number	\varnothing d g6	\varnothing d g6 (Inch)	L2	L3	L4	for D min.	U.S.A. STOCK	screw	key
NEW 645.G012-D	12	-	75	10	55	0.2 - 5	●	G012	111.645
645.G0127-D INCH SIZE	12.7	0.50"	75	10	55	0.2 - 5	●	G012	111.645
645.G016-D	16	-	75	10	55	0.2 - 5	●	G016	111.645
645.G018-D	18	-	90	10	70	0.2 - 5	○	G016	111.645
645.G01905-D INCH SIZE	19.05	0.75"	90	10	70	0.2 - 5	●	G016	111.645
645.G020-D	20	-	90	10	70	0.2 - 5	●	G020	111.645
645.G022-D	22	-	90	10	70	0.2 - 5	○	G020	111.645
645.G025-D	25	-	95	10	75	0.2 - 5	○	G020	111.645
645.G0254-D INCH SIZE	25.4	1.0"	95	10	75	0.2 - 5	●	G020	111.645
645.G028-D	28	-	95	10	75	0.2 - 5	○	G020	111.645

U.S.A. Stock

- = In Stock
- = Express Delivery

Type 676.G

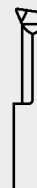
Improved version with modified clamping screw

Starting at Ø 16.0 mm for insert
D min. Ø 6.0 mm

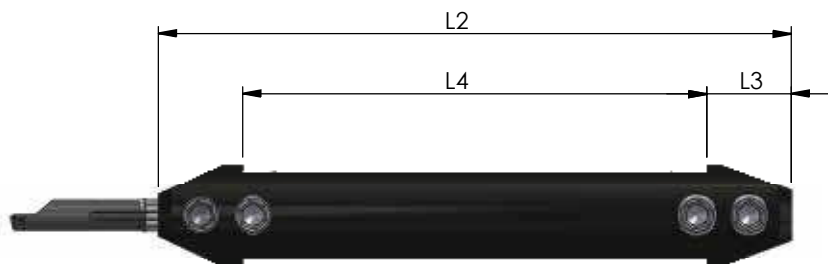
ULTRAMINI

Grooving, boring, profiling, threading and chamfering starting at ø 0.2 mm

NEW



G Holders
BEST IN CLASS
.01 mm Repeatability



Clamping side
Ø 7.0 mm

Clamping side
Ø 6.0 mm



Tool holder for right and left inserts usable

Dimensions in mm



part number	Ø d g6	Ø d g6 (Inch)	L2	L3	L4	for D min.	U.S.A. STOCK	screw	key
676.G016-D	16	-	75	10	55	≥ 6.0	●	G016	111.645
676.G018-D	18	-	90	10	70	≥ 6.0	○	G016	111.645
676.G01905-D INCH SIZE	19.05	0.75"	90	10	70	≥ 6.0	●	G016	111.645
676.G020-D	20	-	90	10	70	≥ 6.0	●	G020	111.645
676.G022-D	22	-	90	10	70	≥ 6.0	○	G020	111.645
676.G025-D	25	-	95	10	75	≥ 6.0	○	G020	111.645
676.G0254-D INCH SIZE	25.4	1.0"	95	10	75	≥ 6.0	●	G020	111.645
676.G028-D	28	-	95	10	75	≥ 6.0	○	G020	111.645

U.S.A. Stock

- = In Stock
- = Express Delivery



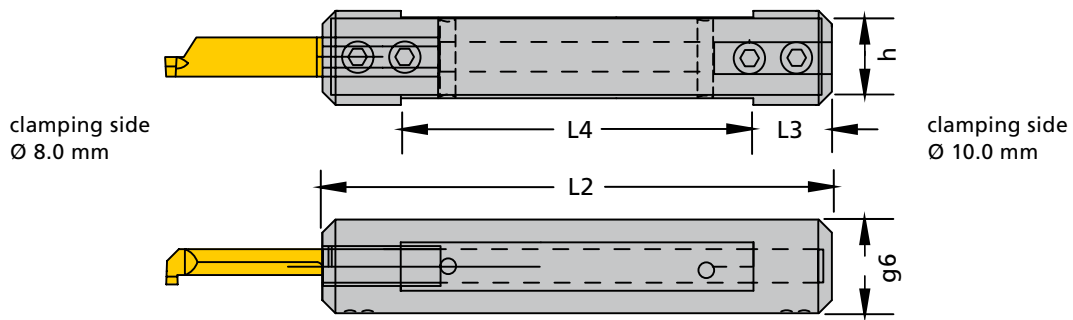
ULTRAMINI

Grooving, boring and profiling starting at Ø 0.2 mm

Type 681

Tool holder

Starting at Ø 20.0 mm for insert starting at D min. Ø 7.8 mm



Tool holder for right and left inserts usable

Dimensions in mm



part number	Ø d g6	L2	L3	L4	h	for D min.	U.S.A. Stock	spare parts Ø tool holder	screw	key
681.0020-D	20.0	100.0	10.0	80.0	18.0	≥ 7.8	○	20.0	110.681-20	111.681

U.S.A. Stock

- = In Stock
- = Express Delivery

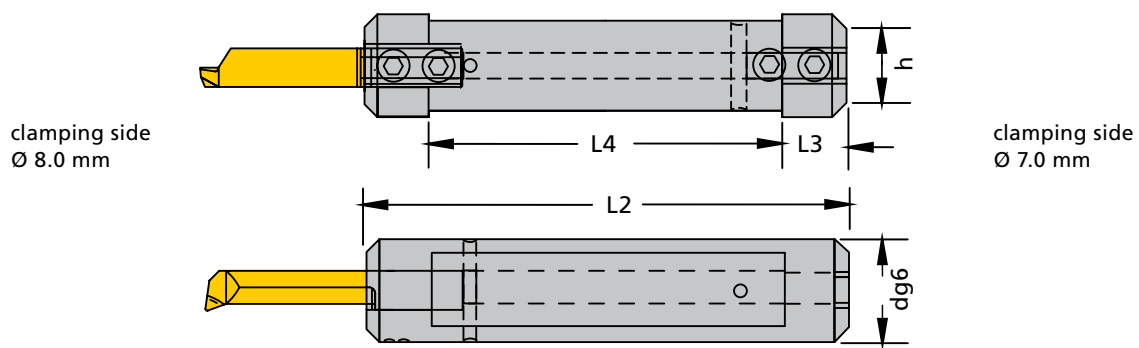
ULTRAMINI

Type 687

Grooving, boring and profiling starting at Ø 0.2 mm

Tool holder

Starting at Ø 16.0 mm for insert starting at D min. Ø 6.8 mm



Tool holder for right and left inserts usable

Dimensions in mm



part number	Ø d g6	L2	L3	L4	h	for D min.	U.S.A. Stock		spare parts Ø tool holder	screw	key
							●	○			
687.0016-D	16	75	10	55	14	≥ 6.8	●		16	110.687-16	111.687
687.0020-D	20	90	10	70	18	≥ 6.8	●		20	110.687-20	111.687

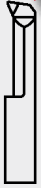
U.S.A. Stock

- = In Stock
- = Express Delivery

NEW

ULTRAMINI

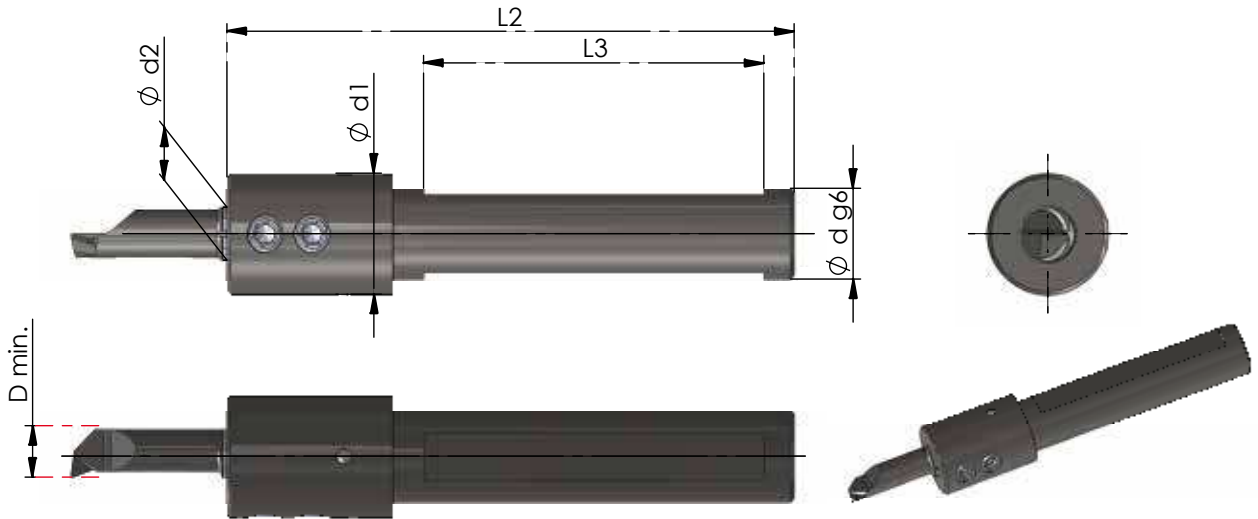
Type 660, 670, 680



Grooving, boring and profiling starting at Ø 0.2 mm

Tool holder

Starting at Ø 12 mm for insert
D min. Ø 6 , 6.8 , 7.8 mm



Tool holder for right and left inserts usable

Dimensions in mm

part number	D min.	Ø d g6	Ø d g6 (Inch)	Ø d1	L2	L3	U.S.A. Stock	screw	key	Ø d2 ≤ Ø d h6 insert
660.0012	6.0	12	-	16	75	53	●	G016	111.645	6
NEW 660.0127 INCH SIZE	6.0	12.7	0.50"	16	75	53	●	G016	111.645	6
670.0012	6.8	12	-	16	75	53	○	G016	111.645	7
NEW 670.0127 INCH SIZE	6.8	12.7	0.50"	16	75	53	●	G016	111.645	7
680.0012	7.8	12	-	16	75	53	●	G016	111.645	8
NEW 680.0127 INCH SIZE	7.8	12.7	0.50"	16	75	53	●	G016	111.645	8

U.S.A. Stock

- = In Stock
- = Express Delivery

Order example:
660.0012

ULTRAMINI

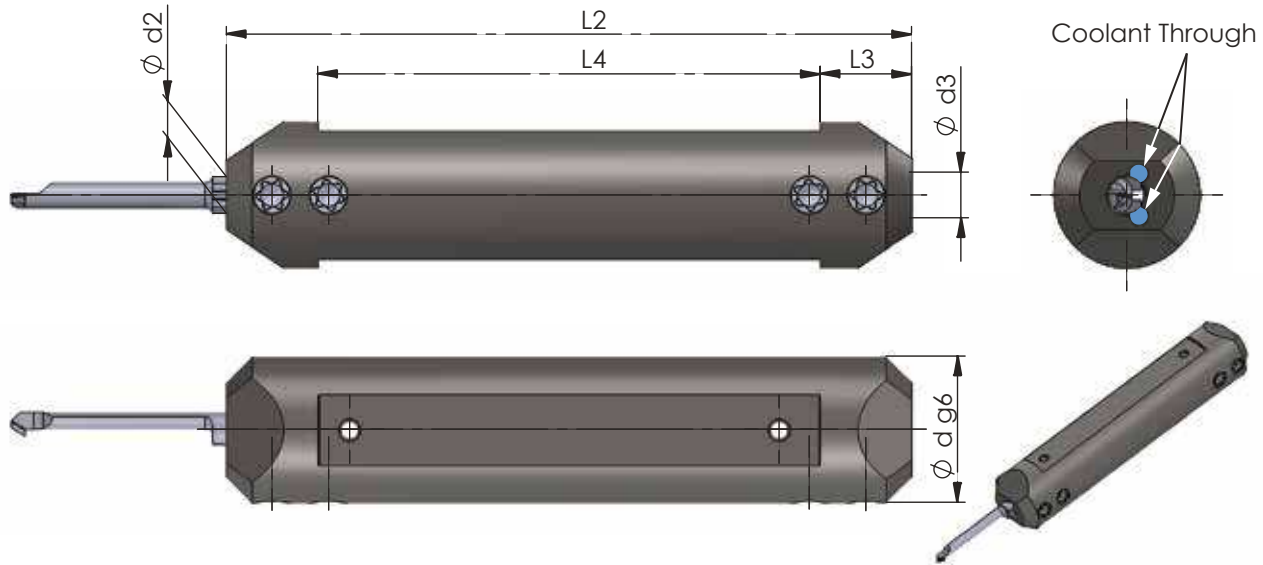
Type 645.PT

NEW

Grooving, boring and profiling starting at Ø 0.2 mm

tool holder,
Premium line with improved cooling

for inserts with bore Ø 0.2 - 5.0 mm



Tool holder for right and left inserts usable

Dimensions in mm



part number	Ø d g6	Ø d g6 (Inch)	L2	L3	L4	screw	key driver	torque	U.S.A. Stock	Ø d2 ≤ Ø d h6 insert	Ø d3 ≤ Ø d h6 insert
NEW 645.PT12-D	12	-	75	10	55	PT12	T10F	1.2 Nm	○	4	5
NEW 645.PT127-D INCH SIZE	12.7	0.050"	75	10	55	PT12	T10F	1.2 Nm	○	4	5
NEW 645.PT1587-D INCH SIZE	15.87	0.625"	75	10	55	PT16	T10F	1.2 Nm	○	4	5
NEW 645.PT16-D	16	-	75	10	55	PT16	T10F	1.2 Nm	○	4	5
NEW 645.PT18-D	18	-	90	10	70	PT16	T10F	1.2 Nm	○	4	5
NEW 645.PT1905-D INCH SIZE	19.05	0.750"	90	10	70	PT16	T10F	1.2 Nm	○	4	5
NEW 645.PT20-D	20	-	90	10	70	PT20	T10F	1.2 Nm	○	4	5
NEW 645.PT22-D	22	-	90	10	70	PT20	T10F	1.2 Nm	○	4	5
NEW 645.PT25-D	25	-	95	10	75	PT20	T10F	1.2 Nm	○	4	5
NEW 645.PT254-D INCH SIZE	25.4	1.00"	95	10	75	PT20	T10F	1.2 Nm	○	4	5
NEW 645.PT28-D	28	-	95	10	75	PT20	T10F	1.2 Nm	○	4	5

U.S.A. Stock

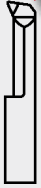
- = In Stock
- = Express Delivery

Order example:
645.PT12-D

NEW

ULTRAMINI

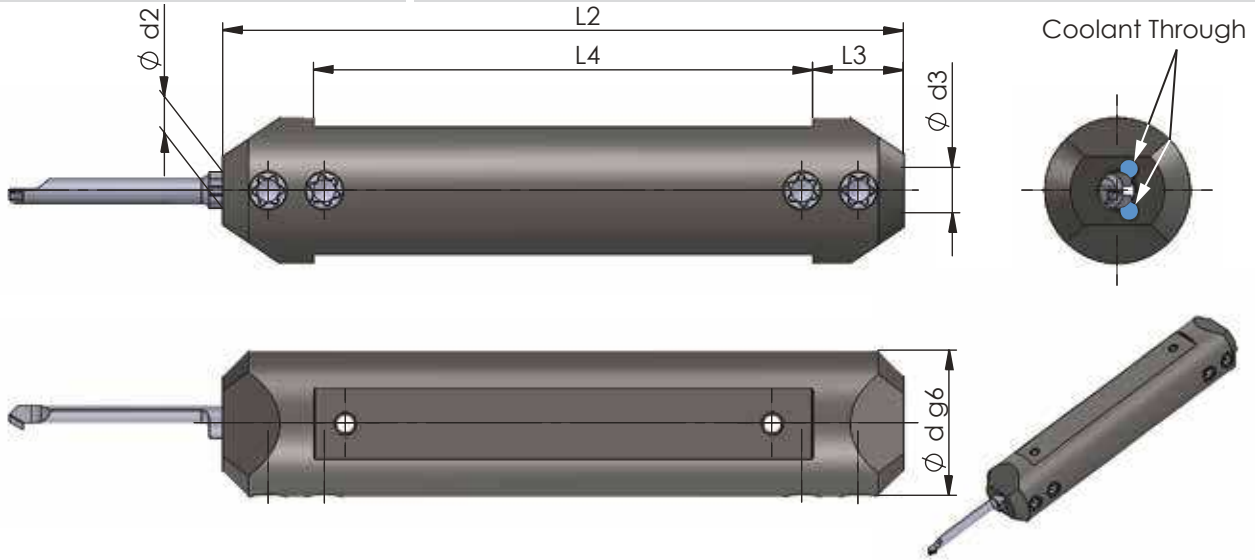
Type 676.PT



Grooving, boring and profiling starting at Ø 0.2 mm

Tool holder, Premium line with improved cooling

for inserts with bore Ø 6.0 - 7.0 mm



Tool holder for right and left inserts usable

Dimensions in mm

part number	Ø d g6	Ø d g6 (inch)	L2	L3	L4	screw	key driver	torque	U.S.A. Stock	Ø d2 ≤ Ø d h6 insert	Ø d3 ≤ Ø d h6 insert
NEW 676.PT1587-D	16	-	75	10	55	PT16	T10F	1.2 Nm	○	6	7
NEW 676.PT16-D	16	-	75	10	55	PT16	T10F	1.2 Nm	○	6	7
NEW 676.PT18-D	18	-	90	10	70	PT16	T10F	1.2 Nm	○	6	7
NEW 676.PT1905-D INCH SIZE	19.05	0.750"	90	10	70	PT16	T10F	1.2 Nm	○	6	7
NEW 676.PT20-D	20	-	90	10	70	PT20	T10F	1.2 Nm	○	6	7
NEW 676.PT22-D	22	-	90	10	70	PT20	T10F	1.2 Nm	○	6	7
NEW 676.PT25-D	25	-	95	10	75	PT20	T10F	1.2 Nm	○	6	7
NEW 676.PT254-D INCH SIZE	25.4	1.00"	95	10	75	PT20	T10F	1.2 Nm	○	6	7
NEW 676.PT28-D	28	-	95	10	75	PT20	T10F	1.2 Nm	○	6	7

U.S.A. Stock

- = In Stock
- = Express Delivery

Order example:
676.PT16-D

ULTRAMINI

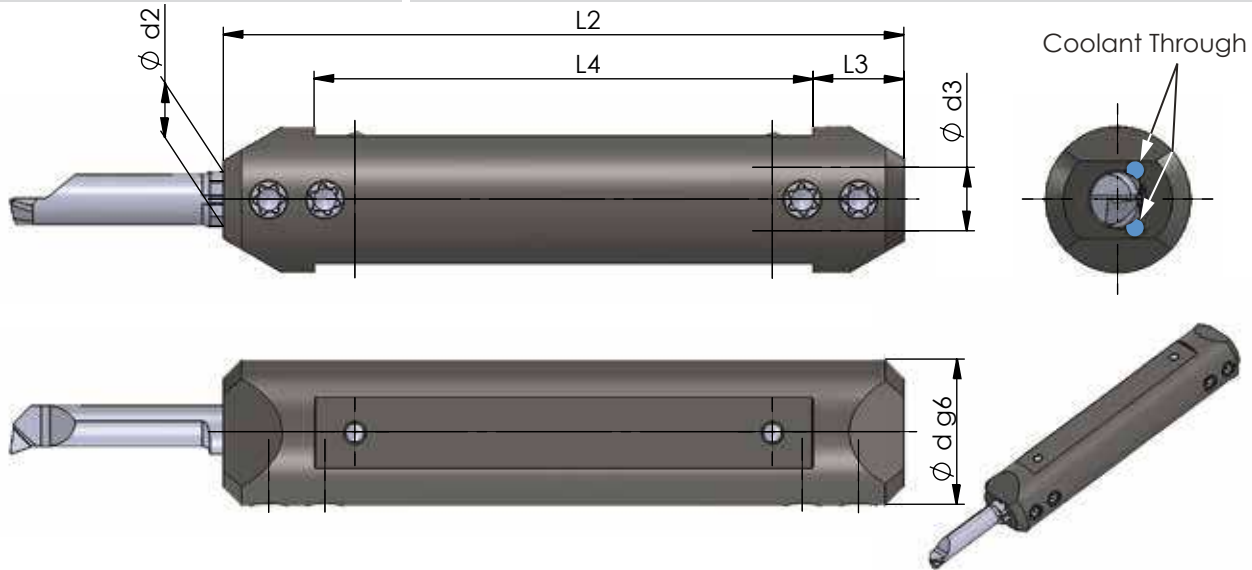
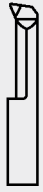
Type 687.PT

NEW

Grooving, boring and profiling starting at $\varnothing 0.2$ mm

Tool holder, Premium line with improved cooling

for inserts with bore $\varnothing 6.8 - 7.8$ mm



Tool holder for right and left inserts usable

Dimensions in mm



part number	$\varnothing d g6$	L2	L3	L4	screw	key driver	torque	U.S.A. Stock	$\varnothing d2$	$\varnothing d h6$ insert	$\varnothing d3$	$\varnothing d h6$ insert
									\leq	\leq	\leq	\leq
NEW 687.PT16-D	16	75	10	55	PT12	T10F	1.2 Nm	○	7	8	8	8
NEW 687.PT20-D	20	90	10	70	PT16	T10F	1.2 Nm	○	7	8	8	8

U.S.A. Stock

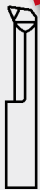
- = In Stock
- = Express Delivery

Order example:
687.PT16-D

NEW

ULTRAMINI

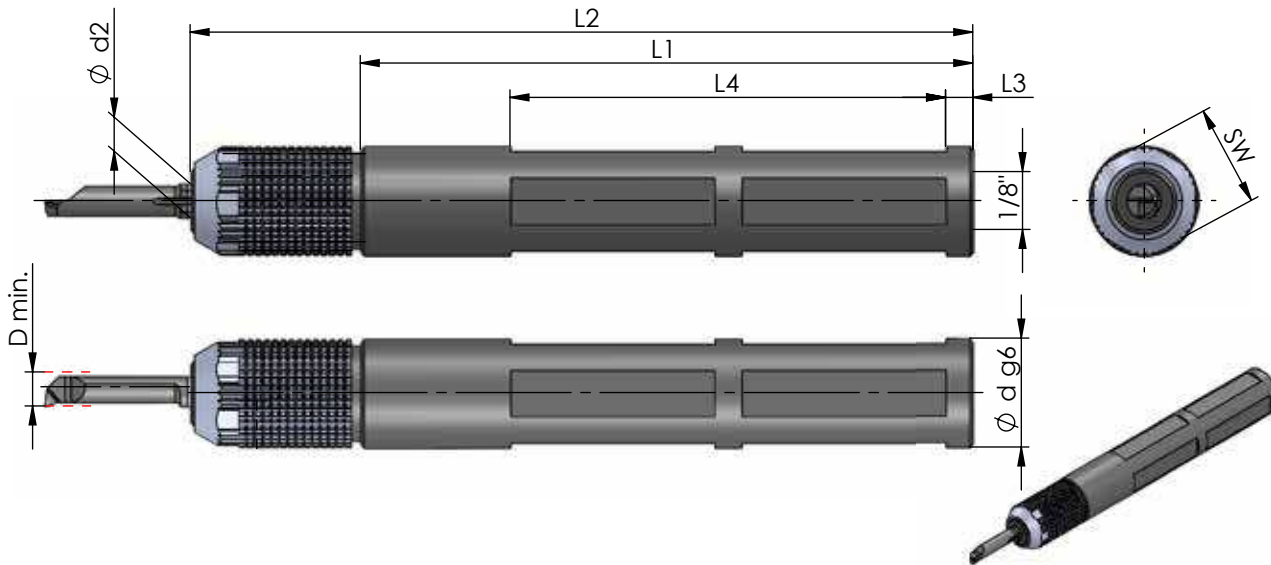
Type UM600H



Grooving, boring and profiling starting at Ø 0.2 mm

High-performance tool holder with coolant connection

Starting at Ø 12 mm for inserts with bore Ø 0.2 - 7.0 mm



Tool holder for right and left inserts usable

Dimensions in mm

part number	Ø d g6	L2	L1	L3	L4	U.S.A. Stock	union nut	nut	Ø d2 ≤ Ø d h6 insert
NEW UM600H.0012.4	12	115	90	4	64	○	UM600H.M4	UM600H.K	4
NEW UM600H.0012.5	12	115	90	4	64	○	UM600H.M5	UM600H.K	5
NEW UM600H.0012.6	12	115	90	4	64	○	UM600H.M6	UM600H.K	6
NEW UM600H.0012.7	12	115	90	4	64	○	UM600H.M7	UM600H.K	7
NEW UM600H.0016.4	16	115	90	4	64	○	UM600H.M4	UM600H.K	4
NEW UM600H.0016.5	16	115	90	4	64	○	UM600H.M5	UM600H.K	5
NEW UM600H.0016.6	16	115	90	4	64	○	UM600H.M6	UM600H.K	6
NEW UM600H.0016.7	16	115	90	4	64	○	UM600H.M7	UM600H.K	7

Characteristics:

- manual clamping without additional wrench
- continuous repeatability ± 0.005 mm (high precision)
- simplest operation
- ideal where space is tight
- clamping by standard wrench SW15 is possible

U.S.A. Stock

- = In Stock
- = Express Delivery

Order example:
UM600H.0012.4

ULTRAMINI

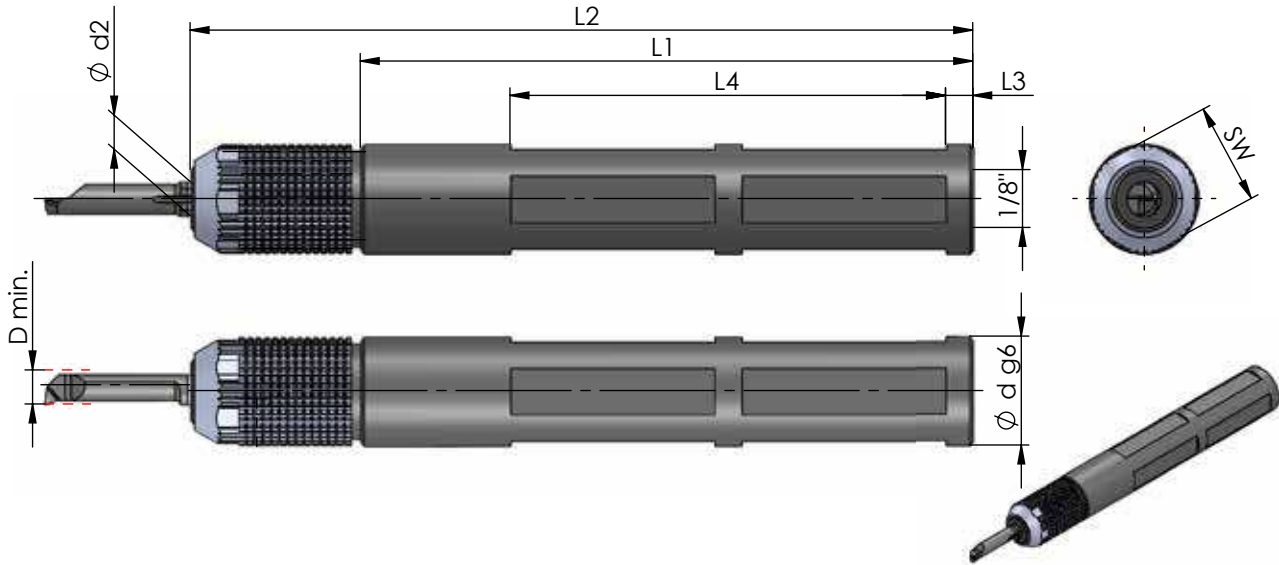
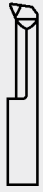
Type UM600H

NEW

Grooving, boring and profiling starting at Ø 0.2 mm

High-performance tool holder with coolant connection

Starting at Ø 19.05 mm for inserts with bore Ø 0.2 - 7.0 mm



Tool holder for right and left inserts usable

Dimensions in mm



	part number	Ø d g6	Ø d g6 (Inch)	L2	L1	L3	L4	U.S.A. Stock	union nut	nut	Ø d2 ≤	Ø d h6 insert
NEW	UM600H.001905.4 INCH SIZE	19.05	0.750"	115	90	4	64	○	UM600H.M4	UM600H.K	4	
NEW	UM600H.001905.5 INCH SIZE	19.05	0.750"	115	90	4	64	○	UM600H.M5	UM600H.K	5	
NEW	UM600H.001905.6 INCH SIZE	19.05	0.750"	115	90	4	64	○	UM600H.M6	UM600H.K	6	
NEW	UM600H.001905.7 INCH SIZE	19.05	0.750"	115	90	4	64	○	UM600H.M7	UM600H.K	7	
NEW	UM600H.0020.4	20	-	115	90	4	64	○	UM600H.M4	UM600H.K	4	
NEW	UM600H.0020.5	20	-	115	90	4	64	○	UM600H.M5	UM600H.K	5	
NEW	UM600H.0020.6	20	-	115	90	4	64	○	UM600H.M6	UM600H.K	6	
NEW	UM600H.0020.7	20	-	115	90	4	64	○	UM600H.M7	UM600H.K	7	
NEW	UM600H.0022.4	22	-	115	90	4	64	○	UM600H.M4	UM600H.K	4	
NEW	UM600H.0022.5	22	-	115	90	4	64	○	UM600H.M5	UM600H.K	5	
NEW	UM600H.0022.6	22	-	115	90	4	64	○	UM600H.M6	UM600H.K	6	
NEW	UM600H.0022.7	22	-	115	90	4	64	○	UM600H.M7	UM600H.K	7	

U.S.A. Stock

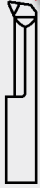
- = In Stock
- = Express Delivery

Order example:
UM600H.001905.4

NEW

ULTRAMINI

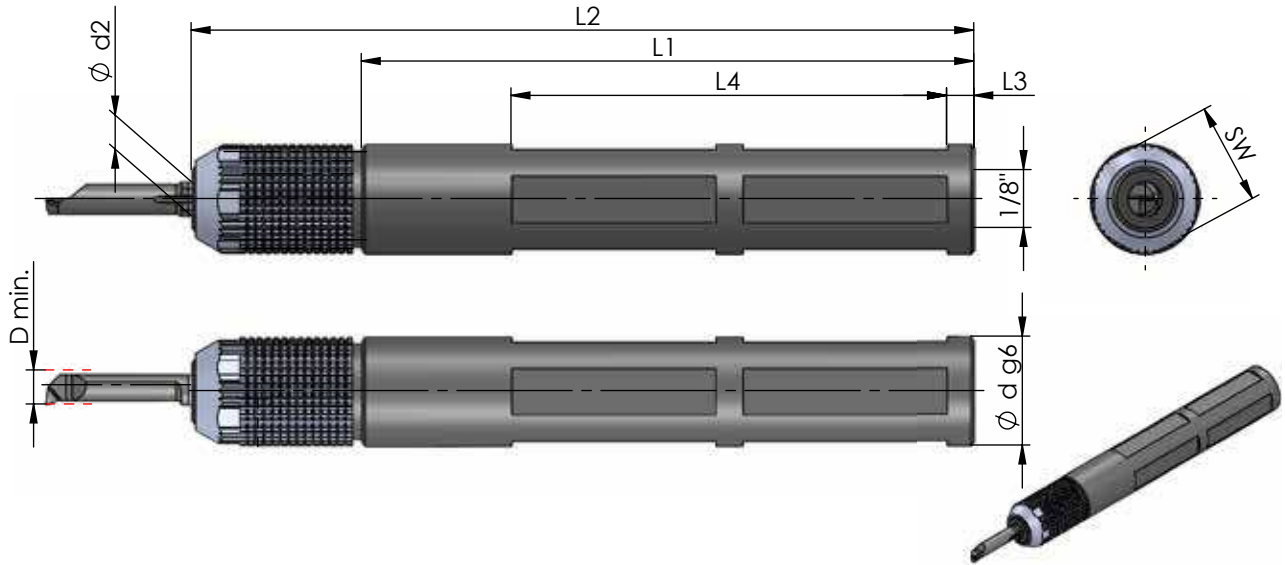
Type UM600H



Grooving, boring and profiling starting at Ø 0.2 mm

High-performance tool holder with coolant connection

Starting at Ø 25 mm for inserts with bore Ø 0.2 - 7.0 mm



Tool holder for right and left inserts usable

Dimensions in mm

part number	Ø d g6	Ø d g6 (Inch)	L2	L1	L3	L4	U.S.A. Stock	union nut	nut	Ø d2 <= Ø d h6 insert
NEW UM600H.0025.4	25	-	115	90	4	64	○	UM600H.M4	UM600H.K	4
NEW UM600H.0025.5	25	-	115	90	4	64	○	UM600H.M5	UM600H.K	5
NEW UM600H.0025.6	25	-	115	90	4	64	○	UM600H.M6	UM600H.K	6
NEW UM600H.0025.7	25	-	115	90	4	64	○	UM600H.M7	UM600H.K	7
NEW UM600H.00254.4 INCH SIZE	25.4	1.00"	115	90	4	64	○	UM600H.M4	UM600H.K	4
NEW UM600H.00254.5 INCH SIZE	25.4	1.00"	115	90	4	64	○	UM600H.M5	UM600H.K	5
NEW UM600H.00254.6 INCH SIZE	25.4	1.00"	115	90	4	64	○	UM600H.M6	UM600H.K	6
NEW UM600H.00254.7 INCH SIZE	25.4	1.00"	115	90	4	64	○	UM600H.M7	UM600H.K	7
NEW UM600H.0028.4	28	-	115	90	4	64	○	UM600H.M4	UM600H.K	4
NEW UM600H.0028.5	28	-	115	90	4	64	○	UM600H.M5	UM600H.K	5
NEW UM600H.0028.6	28	-	115	90	4	64	○	UM600H.M6	UM600H.K	6
NEW UM600H.0028.7	28	-	115	90	4	64	○	UM600H.M7	UM600H.K	7

U.S.A. Stock

- = In Stock
- = Express Delivery

order-example:
UM600H.0025.4

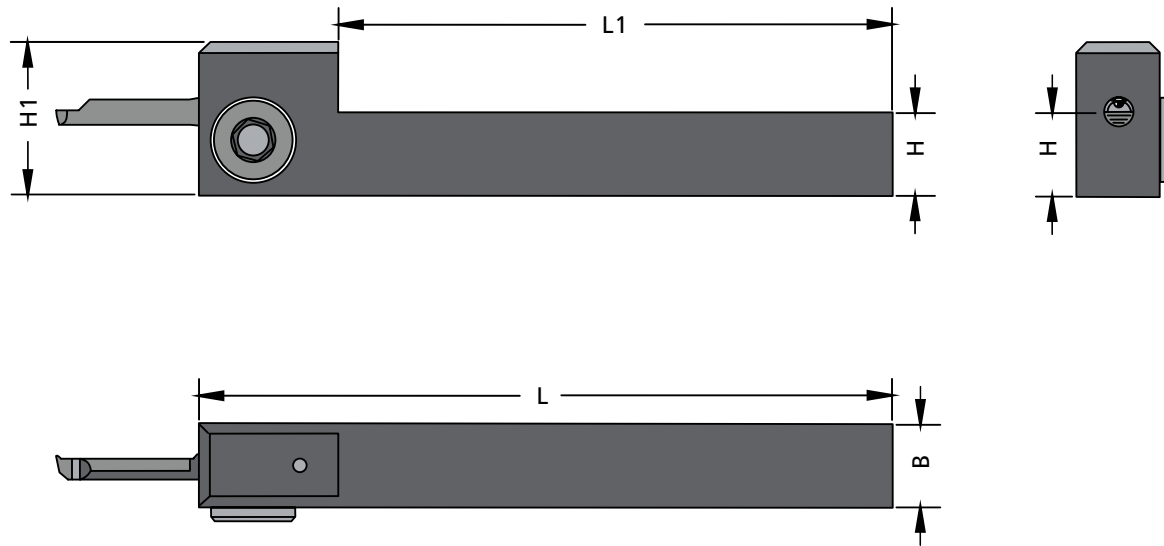
ULTRAMINI

Type UM

Grooving, boring and profiling starting at Ø 0.2 mm

Tool holder

Starting at 10.0 mm for insert
D min. Ø 0.2 mm - 7.0 mm



Tool holder for right and left inserts

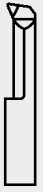
Dimensions in mm



part number	U.S.A. Stock						spare parts	
	Ø d	H	B	H1	L	L1		
UM.1010.4	4	10	10	20	100	75	○	UM12
UM.1010.5	5	10	10	20	100	75	○	UM12
UM.1212.4	4	12	12	22	100	75	○	UM12
UM.1212.5	5	12	12	22	100	75	○	UM12
UM.1212.6	6	12	12	22	100	75	○	UM16
UM.1616.4	4	16	16	25	125	100	○	UM12
UM.1616.5	5	16	16	25	125	100	○	UM12
UM.1616.6	6	16	16	25	125	100	○	UM16
UM.1616.7	7	16	16	25	125	100	●	UM16

U.S.A. Stock

- = In Stock
- = Express Delivery



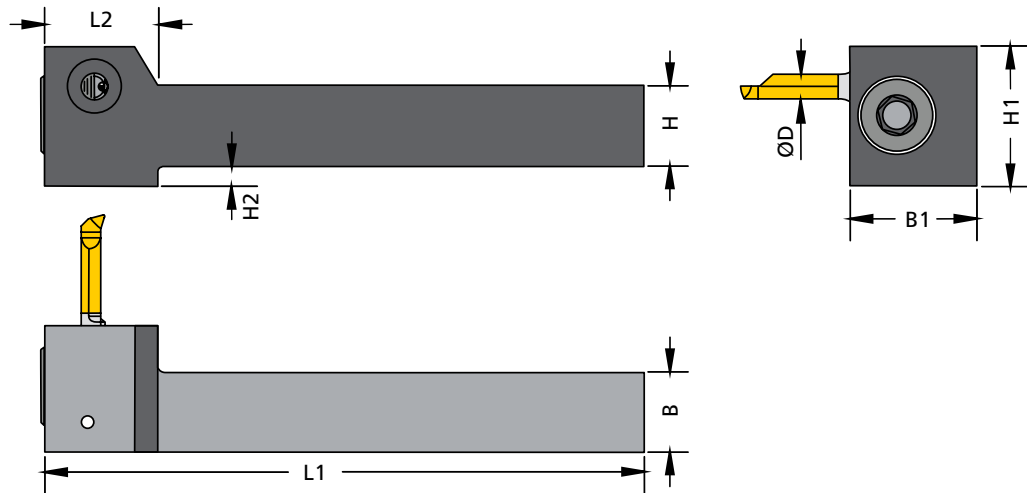
Type UHCM

Tool holder

Starting at 12.0 mm
for insert
D min. Ø 0.2 mm - 7.0 mm

ULTRAMINI

Grooving, boring and profiling
starting at Ø 0.2 mm



Tool holder for right and left
inserts

Left hand version shown

Dimensions in mm



part number	Ø D	H	B	L1	L2	B1	H1	H2	U.S.A. Stock		spare parts
									●	○	
R/L.UHCM.1212.4	4	12	12	90	17	20	18	-	○		UM12
R/L.UHCM.1212.5	5	12	12	90	17	20	18	-	○		UM12
R/L.UHCM.1212.6	6	12	12	90	17	20	21	3	○		UM16
R/L.UHCM.1212.7	7	12	12	90	17	20	21	3	○		UM16
R/L.UHCM.1616.4	4	16	16	130	17	20	22	-	○		UM12
R/L.UHCM.1616.5	5	16	16	130	17	20	22	-	○		UM12
R/L.UHCM.1616.6	6	16	16	130	17	20	22	-	○		UM16
R/L.UHCM.1616.7	7	16	16	130	17	20	22	-	○		UM16

U.S.A. Stock

- = In Stock
- = Express Delivery

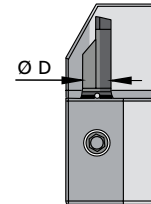
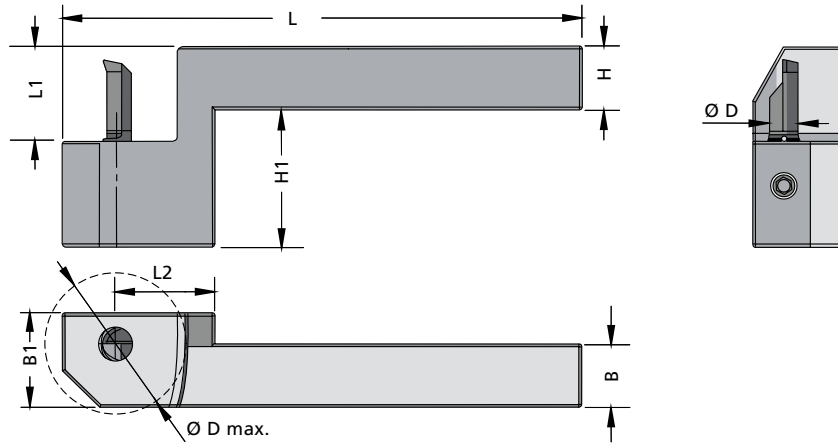
ULTRAMINI

Type UM.18 / UM.28

Grooving, boring and profiling starting at \varnothing 0.2 mm

Tool holder

Starting at 10.0 mm for insert
D min. \varnothing 0.2 mm - 7.0 mm



Tool holder for right and left inserts

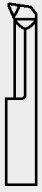
Dimensions in mm



part number	\varnothing D	H	B	L	L1	L2	B1	H1	\varnothing D max.	U.S.A. Stock	spare parts	
											screw	key
R/L.UM.18.1010.4	4	10	10	99	18	19	16	38	26	○		
R/L.UM.18.1010.5	5	10	10	99	18	19	16	38	26	○	110.650	111.645
R/L.UM.18.1010.6	6	10	10	99	18	19	16	38	26	○		
R/L.UM.18.1010.7	7	10	10	99	18	19	16	38	26	○		
R/L.UM.28.1010.4	4	10	10	99	28	19	16	48	26	○		
R/L.UM.28.1010.5	5	10	10	99	28	19	16	48	26	○	110.650	111.645
R/L.UM.28.1010.6	6	10	10	99	28	19	16	48	26	○		
R/L.UM.28.1010.7	7	10	10	99	28	19	16	48	26	○		
R/L.UM.18.1212.4	4	12	12	99	18	19	18	38	26	○		
R/L.UM.18.1212.5	5	12	12	99	18	19	18	38	26	○	110.650	111.645
R/L.UM.18.1212.6	6	12	12	99	18	19	18	38	26	○		
R/L.UM.18.1212.7	7	12	12	99	18	19	18	38	26	○		
R/L.UM.28.1212.4	4	12	12	99	28	19	18	48	26	○		
R/L.UM.28.1212.5	5	12	12	99	28	19	18	48	26	○	110.650	111.645
R/L.UM.28.1212.6	6	12	12	99	28	19	18	48	26	○		
R/L.UM.28.1212.7	7	12	12	99	28	19	18	48	26	○		

U.S.A. Stock

- = In Stock
- = Express Delivery



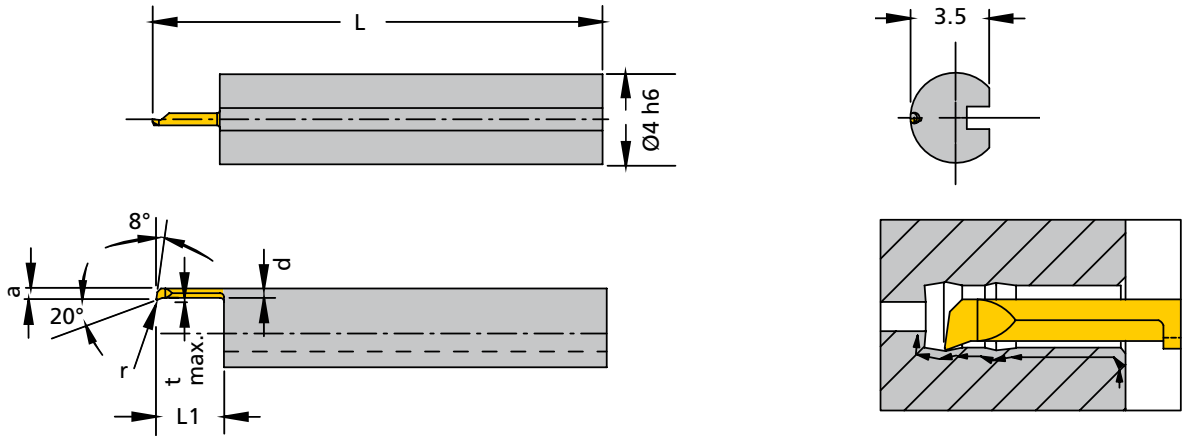
ULTRAMINI

Type 050

Grooving, boring and profiling starting at Ø 0.2 mm

Profiling and copying

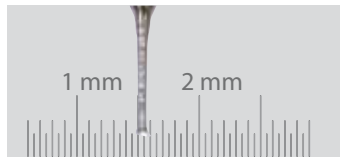
Bore Ø from 0.2 mm



Right hand version shown

State right (R) or left (L) version

Dimensions in mm



part number	r	d	a	L	L1	t max.	D min.	U.S.A. Stock			suitable Tool holder type
								K10F	CN45F	AL41F	
R/L050.02-1	0.02	0.12	0.15	20	1.0	0.02	0.2	—	—	—	645.xxx / xxx.4
R/L050.05-2	0.04	0.32	0.4	20	2.0	0.06	0.5	○	◐	○	
R/L050.06-2	0.04	0.4	0.5	20	2.0	0.08	0.6	○	○	—	
R/L050.06-3	0.04	0.4	0.5	20	3.0	0.08	0.6	○	◐	—	
R/L050.08-4	0.04	0.6	0.7	20	4.0	0.08	0.8	○	○	○	
R/L050.1-5	0.05	0.75	0.9	20	4.5	0.1	1.0	◐	◐	◐	
R/L050.1-7	0.05	0.75	0.9	22	6.5	0.1	1.0	○	◐	○	
R/L050.1-8	0.05	0.75	0.9	22	8.0	0.1	1.0	○	—	○	
R/L050.15-5	0.05	1.15	1.3	19	5.0	0.1	1.5	◐	●	◐	
R/L050.15-10	0.05	1.15	1.3	24	10.0	0.1	1.5	◐	●	◐	
R/L050.15-12	0.05	1.15	1.3	26	12.0	0.1	1.5	○	○	○	

U.S.A. Stock

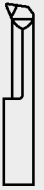
- = Both Right & Left Hand in Stock
- = Express Delivery
- ◐ = Left Hand in Stock
- ◑ = Right Hand in Stock

Carbide grades p. 147 see «grades summary»

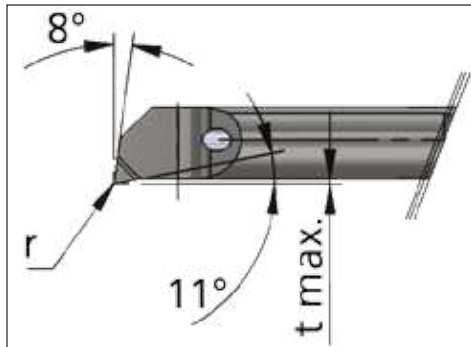
Order-example: right hand version
CN45F: R050.02-1/CN45F

MEDILINE, XTRALINE AND HARDLINE

INSERT GEOMETRIES, SUBSTRATES AND COATINGS DESIGNED FOR SPECIFIC INDUSTRIES
See pages 34 - 41

**MEDILINE - MEDICAL LINE**

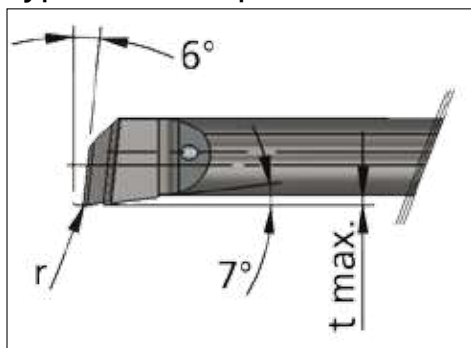
Type M050 modified profile



- Specifically designed for 316 SS and Titanium materials
- Coolant delivered thru the tool
- Reduced t max. for higher stability
- Superior grinding surface quality
- Corner radius provides longer tool life and better surface finishes

XTRALINE - AEROSPACE LINE

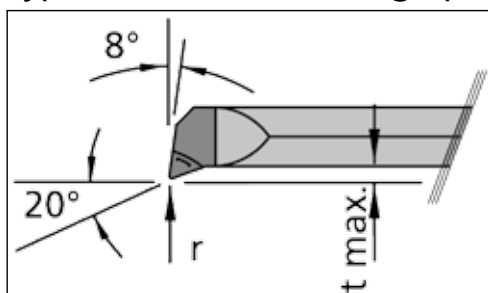
Type X050 chipbreaker



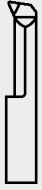
- Specifically designed for Nickel and Chrome based alloys
- Coolant delivered thru the tool
- Coolant hole location optimized for greatest tool rigidity
- Reduced t max. for higher stability
- Various corner radii provides for longer tool life and better surface finishes
- Chip breaker reduces cutting forces and provides for higher cutting feed

HARDLINE - HARD PARTS MACHINING

Type 050 hard machining up to 66HRC



- More economical than CBN
- Machine up to HRC 66
- Reduce scrap
- Perfect for thin wall materials



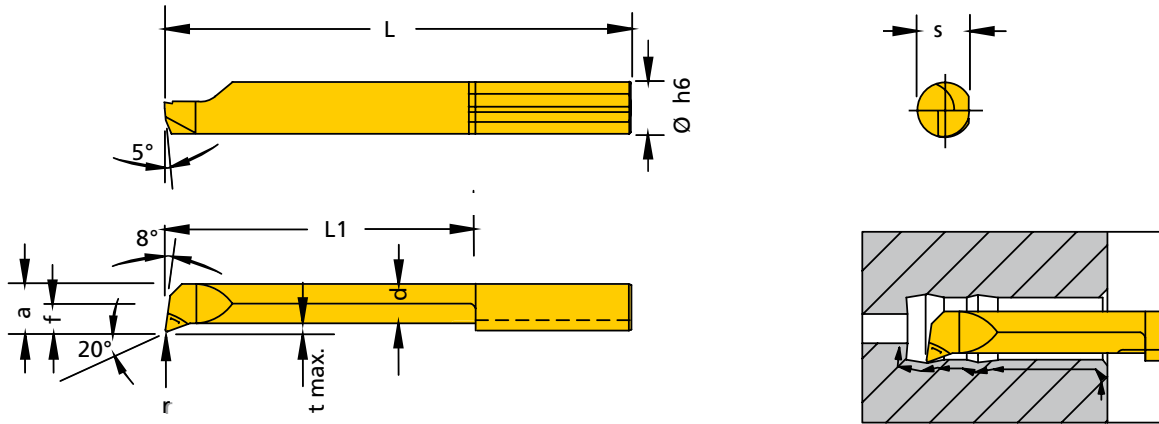
Type 050

ULTRAMINI

Profiling and copying

Bore \varnothing from 2.0 mm
overhang length (L1) up to 8x D

Grooving, boring and profiling
starting at \varnothing 0.2 mm



Right hand version shown

State right (R) or left (L) version

Dimensions in mm



part number	r	s	f	d	a	L	L1	t max.	D min.	Ø h6	U.S.A. Stock				suitable Tool holder type (page 18-28)
											K10F	CN45F	AL41F	XC2A-NH	
R/L050.2-5	0.05	3.5	-	1.5	1.7	19	5	0.1	2.0	4.0	○	●	◐	○	645.xxx / xxx.4
R/L050.2-10	0.05	3.5	-	1.5	1.7	24	10	0.1	2.0	4.0	○	●	◐	○	
R/L050.2-15	0.05	3.5	-	1.5	1.7	29	15	0.1	2.0	4.0	○	●	◐	◑	
R/L050.25-5	0.05	3.5	0.2	2.0	2.2	19	5	0.15	2.5	4.0	○	○	○	—	
R/L050.25-10	0.05	3.5	0.2	2.0	2.2	24	10	0.15	2.5	4.0	○	○	◐	—	
R/L050.25-16	0.05	3.5	0.2	2.0	2.2	30	16	0.15	2.5	4.0	○	○	○	—	
R/L050.3-10	0.1	3.5	0.6	2.3	2.6	24	10	0.2	2.8	4.0	◐	●	◑	◒	
R/L050.3-16	0.1	3.5	0.6	2.3	2.6	30	16	0.2	2.8	4.0	○	●	◐	◑	
R/L050.3-20	0.1	3.5	0.6	2.3	2.6	34	20	0.2	2.8	4.0	○	●	◐	◑	
R/L050.35-10	0.1	3.5	1.1	2.8	3.1	24	10	0.25	3.5	4.0	○	○	○	—	
R/L050.35-16	0.1	3.5	1.1	2.8	3.1	30	16	0.25	3.5	4.0	○	○	○	—	
R/L050.35-20	0.1	3.5	1.1	2.8	3.1	34	20	0.25	3.5	4.0	○	○	○	—	
R/L050.35-24	0.1	3.5	1.1	2.8	3.1	38	24	0.25	3.5	4.0	—	○	○	—	

U.S.A. Stock

- = Both Right & Left Hand in Stock
- = Express Delivery
- ◐ = Left Hand in Stock
- ◑ = Right Hand in Stock

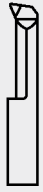
Carbide grades p. 147 see «grades summary»

Order-example: right hand version and grade
CN45F: R050.2-5/CN45F

ULTRAMINI

Type 050

NEW



Grooving, boring and profiling starting at Ø 0.2 mm

Profiling and copying

Bore Ø from 2.0 mm overhang length (L1) up to 8x D

part number	r	s	f	d	a	L	L1	t max.	D min.	Ø h6	U.S.A. Stock				suitable Tool holder type
											K10F	CN45F	AL41F	XC2A-NH	
R/L050.4-10	0.1	3.5	1.5	3.0	3.5	24	10	0.3	4.0	4.0	○	●	◐	◑	645.xxx / xxx.4
R/L050.4-16	0.1	3.5	1.5	3.0	3.5	30	16	0.3	4.0	4.0	○	●	◐	◑	
R/L050.4-20	0.1	3.5	1.5	3.0	3.5	34	20	0.3	4.0	4.0	○	●	◐	◑	
R/L050.4-24	0.1	3.5	1.5	3.0	3.5	38	24	0.3	4.0	4.0	—	◐	◑	◒	
R/L050.4-28	0.1	3.5	1.5	3.0	3.5	42	28	0.3	4.0	4.0	○	●	◐	○	
R/L050.5-10	0.15	4.4	1.9	3.8	4.4	25	10	0.5	5.0	5.0	○	●	◐	◑	645.xxx / xxx.5
R/L050.5-15	0.15	4.4	1.9	3.8	4.4	30	15	0.5	5.0	5.0	○	●	◐	◑	
R/L050.5-20	0.15	4.4	1.9	3.8	4.4	35	20	0.5	5.0	5.0	○	●	◐	◑	
R/L050.5-25	0.15	4.4	1.9	3.8	4.4	40	25	0.5	5.0	5.0	◐	●	◑	◒	
R/L050.5-30	0.15	4.4	1.9	3.8	4.4	45	30	0.5	5.0	5.0	◐	●	◑	◒	
R/L050.5-35	0.15	4.4	1.9	3.8	4.4	50	35	0.5	5.0	5.0	○	●	◐	○	
R/L050.5-40	0.15	4.4	1.9	3.8	4.4	55	40	0.5	5.0	5.0	—	○	○	—	
R/L050.6-15	0.15	5.3	2.3	4.5	5.3	30	15	0.5	6.0	6.0	—	●	◐	◑	676.xxx
R/L050.6-22	0.15	5.3	2.3	4.5	5.3	37	22	0.5	6.0	6.0	○	●	◐	◑	
R/L050.6-25	0.15	5.3	2.3	4.5	5.3	40	25	0.5	6.0	6.0	○	●	◐	◑	
R/L050.6-30	0.15	5.3	2.3	4.5	5.3	45	30	0.5	6.0	6.0	○	●	◐	◑	
R/L050.6-35	0.15	5.3	2.3	4.5	5.3	50	35	0.5	6.0	6.0	—	◐	◑	○	
R/L050.6-42	0.15	5.3	2.3	4.5	5.3	57	42	0.5	6.0	6.0	—	◐	◑	○	
R/L050.7-20	0.15	6.3	2.8	5.5	6.3	35	20	0.6	6.8	7.0	○	●	◐	◑	670 / xxx.7
R/L050.7-25	0.15	6.3	2.8	5.5	6.3	40	25	0.6	6.8	7.0	○	●	◐	◑	
R/L050.7-30	0.15	6.3	2.8	5.5	6.3	45	30	0.6	6.8	7.0	○	●	◐	◑	
R/L050.7-35	0.15	6.3	2.8	5.5	6.3	50	35	0.6	6.8	7.0	—	●	◐	◑	
R/L050.7-40	0.15	6.3	2.8	5.5	6.3	55	40	0.6	6.8	7.0	—	●	◐	○	
R/L050.7-45	0.15	6.3	2.8	5.5	6.3	60	45	0.6	6.8	7.0	—	●	◐	○	
R/L050.7-50	0.15	6.3	2.8	5.5	6.3	65	50	0.6	6.8	7.0	—	●	◐	◑	
R/L050.8-50	0.2	7.3	3.3	6.5	7.3	70	50	0.7	7.8	8.0	—	—	◐	—	
R/L050.8-60	0.2	7.3	3.3	6.5	7.3	80	60	0.7	7.8	8.0	—	—	○	—	
R/L050.10-35	0.2	9.3	4.2	7.5	9.2	80	35	1.0	9.8	10.0	—	—	○	—	681

NEW



U.S.A. Stock

- = Both Right & Left Hand in Stock
- = Express Delivery
- ◐ = Left Hand in Stock
- ◑ = Right Hand in Stock



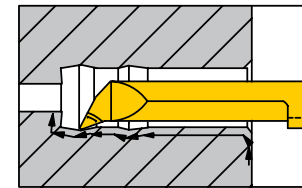
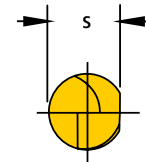
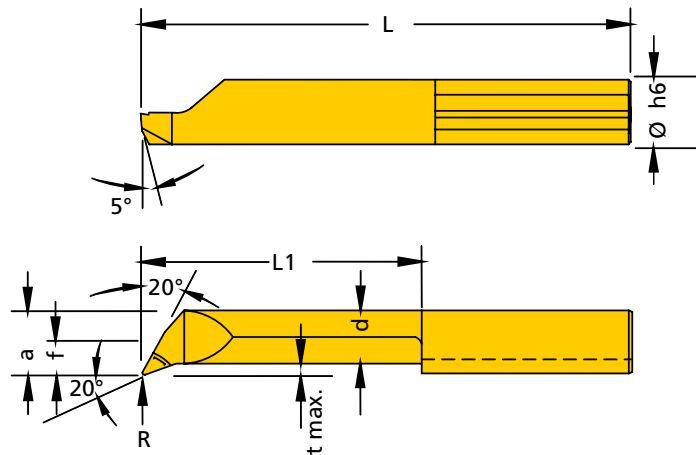
Type 050.20

Profiling and copying
with front-side angle 20°

Bore Ø from 2.0 mm

ULTRAMINI

Grooving, boring and profiling
starting at Ø 0.2 mm



Right hand version shown

State right (R) or left (L) version

Dimensions in mm



part number	U.S.A. Stock										suitable tool holder type		
	R	s	f	d	a	L	L1	t max.	D min.	Ø h6		AL41F	
R/L050.20.2-5	0.05	3.5	-	1.5	1.7	19	5	0.1	2.0	4.0	○	645.xxx	xxx.4
R/L050.20.2-10	0.05	3.5	-	1.5	1.7	24	10	0.1	2.0	4.0	○		
R/L050.20.2-15	0.05	3.5	-	1.5	1.7	29	15	0.1	2.0	4.0	○		
R/L050.20.3-10	0.1	3.5	0.6	2.3	2.6	24	10	0.2	2.8	4.0	◐		
R/L050.20.3-16	0.1	3.5	0.6	2.3	2.6	30	16	0.2	2.8	4.0	○		
R/L050.20.3-20	0.1	3.5	0.6	2.3	2.6	34	20	0.2	2.8	4.0	○		
R/L050.20.4-10	0.15	3.5	1.5	3.0	3.5	24	10	0.3	4.0	4.0	◐		
R/L050.20.4-16	0.15	3.5	1.5	3.0	3.5	30	16	0.3	4.0	4.0	○		
R/L050.20.4-20	0.15	3.5	1.5	3.0	3.5	34	20	0.3	4.0	4.0	○		
R/L050.20.4-24	0.15	3.5	1.5	3.0	3.5	38	24	0.3	4.0	4.0	○		
R/L050.20.4-28	0.15	3.5	1.5	3.0	3.5	42	28	0.3	4.0	4.0	○		
R/L050.20.5-10	0.15	4.4	1.9	3.8	4.4	25	10	0.5	5.0	5.0	◐	xxx.5	
R/L050.20.5-20	0.15	4.4	1.9	3.8	4.4	35	20	0.5	5.0	5.0	○		
R/L050.20.5-35	0.15	4.4	1.9	3.8	4.4	50	35	0.5	5.0	5.0	◐		

U.S.A. Stock

- = Both Right & Left Hand in Stock
- = Express Delivery
- ◐ = Left Hand in Stock
- ◑ = Right Hand in Stock

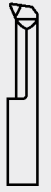
Carbide grades p. 93 see «grades summary»

Order-example: Right hand version and grade
AL41F: R050.20.2-5/AL41F

ULTRAMINI

Type 053

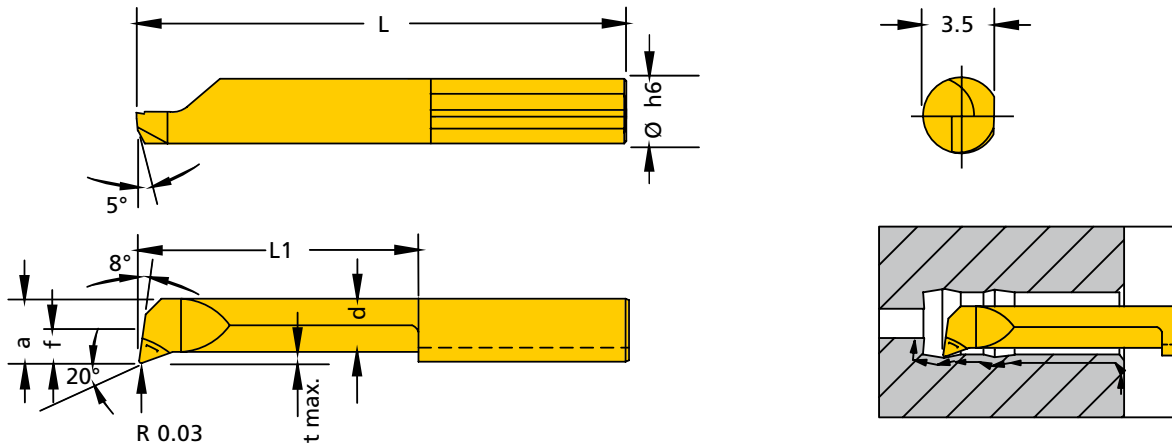
NEW



Grooving, boring and profiling starting at Ø 0.2 mm

Profiling and copying with corner-radius 0.03 mm

Bore Ø from 2.8 mm



Right hand version shown

State right (R) or left (L) version

Dimensions in mm



part number

f	d	a	L	L1	t max.	D min.	Ø h6
0.6	2.3	2.6	24	10	0.2	2.8	4.0
0.6	2.3	2.6	30	16	0.2	2.8	4.0
0.6	2.3	2.6	34	20	0.2	2.8	4.0
1.5	3.0	3.5	24	10	0.3	4.0	4.0
1.5	3.0	3.5	30	16	0.3	4.0	4.0
1.5	3.0	3.5	34	20	0.3	4.0	4.0
1.5	3.0	3.5	38	24	0.3	4.0	4.0
1.5	3.0	3.5	42	28	0.3	4.0	4.0

U.S.A. Stock

AL41F

suitable Tool holder type

645.xxx / xxx.4

NEW
NEW
NEW

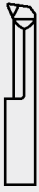
NEW
NEW
NEW
NEW
NEW

U.S.A. Stock

- = Both Right & Left Hand in Stock
- = Express Delivery
- ◐ = Left Hand in Stock
- ◑ = Right Hand in Stock

Carbide grades p. 93 see «grades summary»

Order-example: right hand version and grade
AL41F: R053.03-10/AL41F



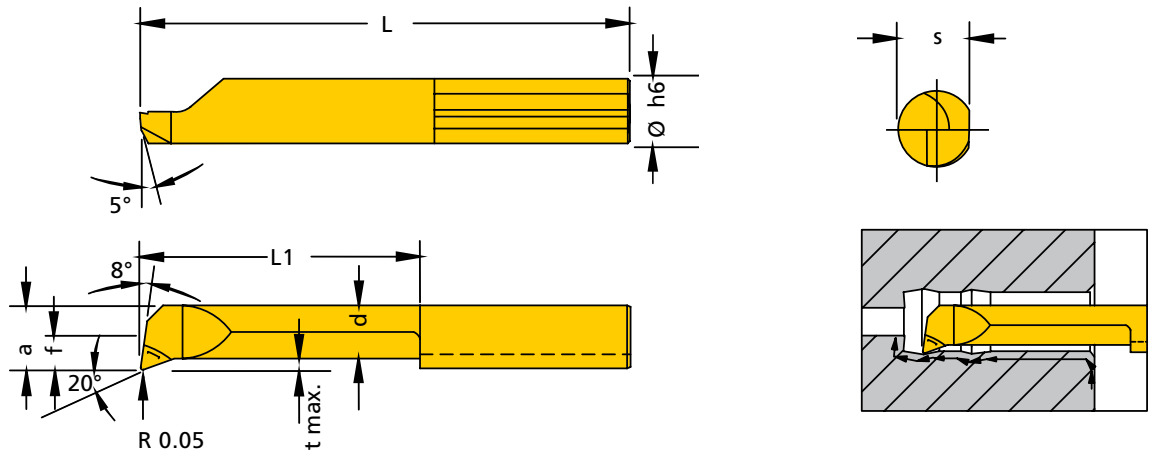
Type 055

Profiling and copying
with corner-radius 0.05 mm

Bore \varnothing from 2.0 mm

ULTRAMINI

Grooving, boring and profiling
starting at \varnothing 0.2 mm



Right hand version shown

State right (R) or left (L) version

Dimensions in mm



part number										U.S.A. Stock		suitable Tool holder type
	s	f	d	a	L	L1	t max.	D min.	$\varnothing h6$	AL41F		
R/L055.2-5	3.5	-	1.5	1.7	19	5	0.1	2.0	4.0	●	645.xxx / xxx.4	
R/L055.2-10	3.5	-	1.5	1.7	24	10	0.1	2.0	4.0	●		
R/L055.2-15	3.5	-	1.5	1.7	29	15	0.1	2.0	4.0	●		
R/L055.3-10	3.5	0.6	2.3	2.6	24	10	0.2	2.8	4.0	●		
R/L055.3-16	3.5	0.6	2.3	2.6	30	16	0.2	2.8	4.0	●		
R/L055.3-20	3.5	0.6	2.3	2.6	34	20	0.2	2.8	4.0	●		
R/L055.4-10	3.5	1.5	3.0	3.5	24	10	0.3	4.0	4.0	●		
R/L055.4-16	3.5	1.5	3.0	3.5	30	16	0.3	4.0	4.0	●		
R/L055.4-20	3.5	1.5	3.0	3.5	34	20	0.3	4.0	4.0	●		
R/L055.4-24	3.5	1.5	3.0	3.5	38	24	0.3	4.0	4.0	●		
R/L055.4-28	3.5	1.5	3.0	3.5	42	28	0.3	4.0	4.0	●		

U.S.A. Stock

- = Both Right & Left Hand in Stock
- = Express Delivery
- ◐ = Left Hand in Stock
- ◑ = Right Hand in Stock

Carbide grades p. 93 see «grades summary»

Order-example: right hand version and grade
AL41F: R055.2-5/AL41F

ULTRAMINI

Type 055

Grooving, boring and profiling starting at Ø 0.2 mm

Profiling and copying with corner-radius 0.05 mm

Bore Ø from 2.0 mm



part number	s	f	d	a	L	L1	t max.	D min.	Ø h6	U.S.A. Stock		suitable Tool holder type	
										AL41F			
R/L055.5-10	4.4	1.9	3.8	4.4	25	10	0.5	5.0	5.0	●		645.xxx	xxx.5
R/L055.5-15	4.4	1.9	3.8	4.4	30	15	0.5	5.0	5.0	●			
R/L055.5-20	4.4	1.9	3.8	4.4	35	20	0.5	5.0	5.0	●			
R/L055.5-25	4.4	1.9	3.8	4.4	40	25	0.5	5.0	5.0	●			
R/L055.5-30	4.4	1.9	3.8	4.4	45	30	0.5	5.0	5.0	●			
R/L055.5-35	4.4	1.9	3.8	4.4	50	35	0.5	5.0	5.0	●			
R/L055.6-15	5.3	2.3	4.5	5.3	30	15	0.5	6.0	6.0	●		676.xxx / xxx.6	660
R/L055.6-22	5.3	2.3	4.5	5.3	37	22	0.5	6.0	6.0	●			
R/L055.6-25	5.3	2.3	4.5	5.3	40	25	0.5	6.0	6.0	●			
R/L055.6-30	5.3	2.3	4.5	5.3	45	30	0.5	6.0	6.0	●			
R/L055.6-35	5.3	2.3	4.5	5.3	50	35	0.5	6.0	6.0	○			
R/L055.6-42	5.3	2.3	4.5	5.3	57	42	0.5	6.0	6.0	●			



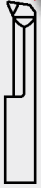
U.S.A. Stock

- = Both Right & Left Hand in Stock
- = Express Delivery
- ◐ = Left Hand in Stock
- ◑ = Right Hand in Stock

NEW

ULTRAMINI

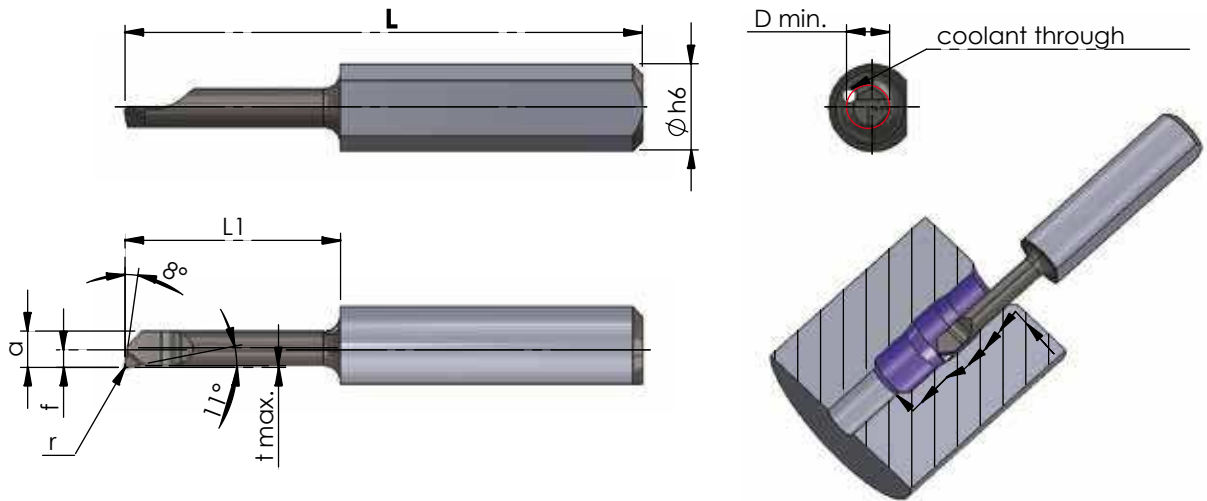
Mediline Type M050



Grooving, boring, profiling, threading and chamfering starting at \varnothing 0.2 mm

Profiling and copying with modified profile

Bore $\varnothing \leq 2.0$ mm



Right hand (R): as shown
Left hand version (L): mirror image

State right (R) or left (L) version

Dimensions in mm

	part number	r	f	a	L	L1	t max.	D min.	Ø h6	U.S.A. Stock		tool holder type
										K10F	P07C	
NEW	R/LM050.05-2	0.02	0.2	0.4	20	2	0.02	0.5	4	○	●	645.xxx / xxx.4
NEW	R/LM050.08-4	0.02	0.35	0.7	20	4	0.03	0.8	4	○	●	
NEW	R/LM050.1-5	0.02	0.4	0.9	20	5	0.05	1	4	○	●	
NEW	R/LM050.1-7	0.02	0.4	0.9	22	7	0.05	1	4	○	●	
NEW	R/LM050.15-5	0.02	0.6	1.15	19	5	0.08	1.5	4	○	●	
NEW	R/LM050.15-10	0.02	0.6	1.15	24	10	0.08	1.5	4	○	●	
NEW	R/LM050.2-5	0.02	0.8	1.7	19	5	0.08	2	4	○	●	
NEW	R/LM050.2-10	0.02	0.8	1.7	24	10	0.08	2	4	○	●	

U.S.A. Stock

- = Both Right & Left Hand in Stock
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More carbide grades can be found in the grades summary in the section "technical instructions"

Order example:
Right hand version and grade
RM050.2-10/P07C

ULTRAMINI

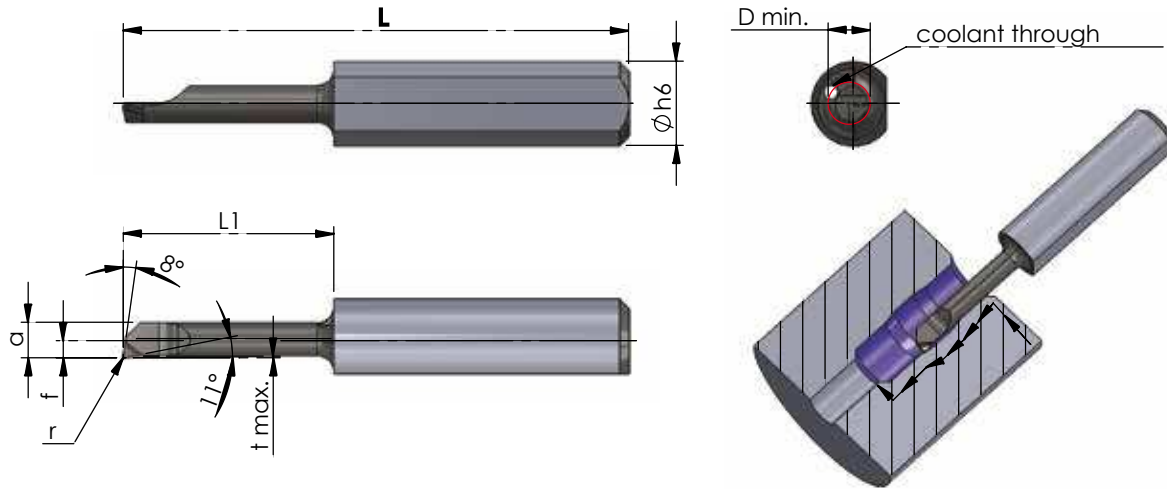
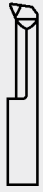
Grooving, boring, profiling, threading and chamfering starting at $\varnothing 0.2$ mm

Mediline Type M050

Profiling and copying with modified profile

Bore $\varnothing \leq 4.0$ mm

NEW



Right hand (R): as shown
Left hand version (L): mirror image

State right (R) or left (L) version

Dimensions in mm



	part number	r	f	a	L	L1	t max.	D min.	Ø h6	U.S.A. Stock		tool holder type
										K10F	P07C	
NEW	R/LM050.25-5	0.02	0.2	2.2	19	5	0.1	2.5	4	○	●	645.xxx / xxx.4
NEW	R/LM050.25-10	0.02	0.2	2.2	24	10	0.1	2.5	4	○	●	
NEW	R/LM050.3-10	0.02	0.6	2.6	24	10	0.15	3	4	○	●	
NEW	R/LM050.3-16	0.02	0.6	2.6	30	16	0.15	3	4	○	●	
NEW	R/LM050.35-10	0.02	1.1	3.1	24	10	0.17	3.5	4	○	●	
NEW	R/LM050.35-16	0.02	1.1	3.1	30	16	0.17	3.5	4	○	●	
NEW	R/LM050.35-20	0.02	1.1	3.1	34	20	0.17	3.5	4	○	●	
NEW	R/LM050.4-10	0.02	1.5	3.5	24	10	0.2	4	4	○	●	
NEW	R/LM050.4-16	0.02	1.5	3.5	30	16	0.2	4	4	○	●	
NEW	R/LM050.4-20	0.02	1.5	3.5	34	20	0.2	4	4	○	●	
NEW	R/LM050.4-24	0.02	1.5	3.5	38	24	0.2	4	4	○	●	

U.S.A. Stock

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- ◐ = Left Hand in Stock
- ◑ = Right Hand in Stock

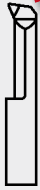
More carbide grades can be found in the grades summary in the section "technical instructions".

Order example:
Right hand version and grade
RM050.25-10/P07C

NEW

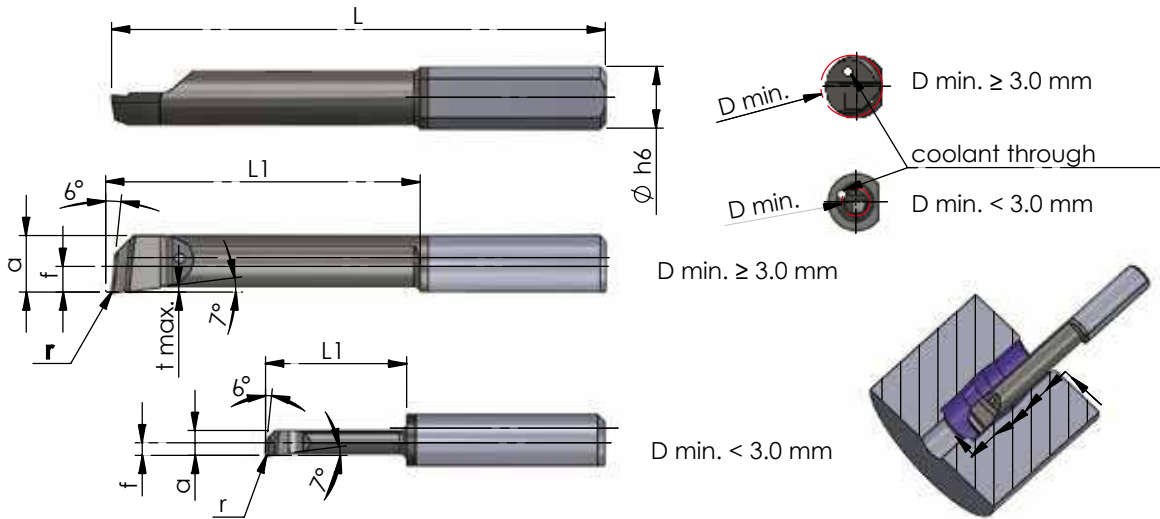
ULTRAMINI

Xtraline Type X050



Grooving, boring, profiling, threading and chamfering starting at \varnothing 0.2 mm

Profiling and copying with chipbreaker, Bore \varnothing from 1.0 mm
extra solid construction



Right hand (R): as shown
Left hand version (L): mirror image
State right (R) or left (L) version
Dimensions in mm

	part number	r	f	a	L	L1	t max.	D min.	Ø h6	U.S.A. Stock		tool holder type
										K10F	P18C	
NEW	R/LX050.1-5R05	0.05	0.7	0.9	20	5	0.03	1	4	○	●	645.xxx / xxx.4
NEW	R/LX050.15-7R10	0.1	0.7	1.35	22	7	0.05	1.5	4	○	●	
NEW	R/LX050.2-5R15	0.15	0.7	1.8	19	5	0.1	2	4	○	●	
NEW	R/LX050.2-10R05	0.05	0.7	1.8	24	10	0.1	2	4	○	●	
NEW	R/LX050.2-10R15	0.15	0.7	1.8	24	10	0.1	2	4	○	●	
NEW	R/LX050.3-10R05	0.05	0.7	2.7	24	10	0.15	3	4	○	●	
NEW	R/LX050.3-10R20	0.2	0.7	2.7	24	10	0.15	3	4	○	●	
NEW	R/LX050.3-16R05	0.05	0.7	2.7	30	16	0.15	3	4	○	●	
NEW	R/LX050.3-16R20	0.2	0.7	2.7	30	16	0.15	3	4	○	●	

U.S.A. Stock

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- = Express Delivery
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- ◑ = Right Hand in Stock

More carbide grades can be found in the grades summary in the section "technical instructions".

Order example:
Right hand version and grade
RX050.1-5R05/P18C

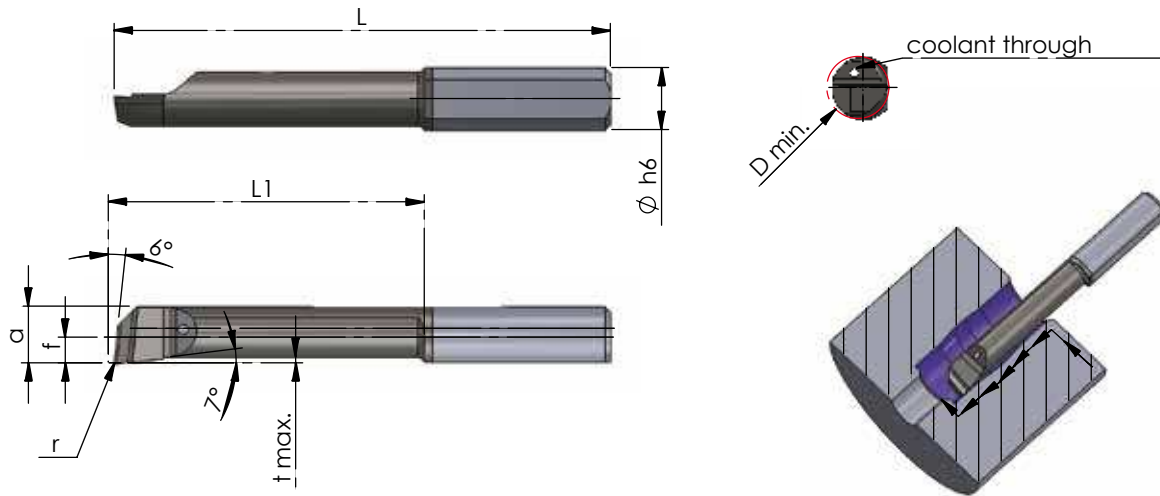
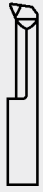
ULTRAMINI

Xtraline Type X050

NEW

Grooving, boring, profiling, threading and chamfering starting at \varnothing 0.2 mm

Profiling and copying with chipbreaker, extra solid construction Bore \varnothing from 4.0 mm



Right hand (R): as shown
Left hand version (L): mirror image

State right (R) or left (L) version

Dimensions in mm



	part number	r	f	a	L	L1	t max.	D min.	Ø h6	U.S.A. Stock		tool holder type
										K10F	P18C	
NEW	R/LX050.4-10R10	0.1	1.6	3.6	24	10	0.2	4	4	○	●	645.xxx
NEW	R/LX050.4-10R20	0.2	1.6	3.6	24	10	0.2	4	4	○	●	
NEW	R/LX050.4-16R05	0.05	1.6	3.6	30	16	0.2	4	4	○	●	
NEW	R/LX050.4-16R10	0.1	1.6	3.6	30	16	0.2	4	4	○	●	
NEW	R/LX050.4-16R20	0.2	1.6	3.6	30	16	0.2	4	4	○	●	
NEW	R/LX050.4-24R10	0.1	1.6	3.6	38	24	0.2	4	4	○	●	
NEW	R/LX050.4-24R20	0.2	1.6	3.6	38	24	0.2	4	4	○	●	xxx.5
NEW	R/LX050.5-15R05	0.05	2.1	4.6	30	15	0.3	5	5	○	●	
NEW	R/LX050.5-15R10	0.1	2.1	4.6	30	15	0.3	5	5	○	●	
NEW	R/LX050.5-15R20	0.2	2.1	4.6	30	15	0.3	5	5	○	●	
NEW	R/LX050.5-25R10	0.1	2.1	4.6	40	25	0.3	5	5	○	●	
NEW	R/LX050.5-25R20	0.2	2.1	4.6	40	25	0.3	5	5	○	●	
NEW	R/LX050.5-30R10	0.1	2.1	4.6	45	30	0.3	5	5	○	●	xxx.5
NEW	R/LX050.5-30R20	0.2	2.1	4.6	45	30	0.3	5	5	○	●	

U.S.A. Stock

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- ◑ = Right Hand in Stock

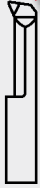
More carbide grades can be found in the grades summary in the section "technical instructions".

Order example:
Right hand version and grade
RX050.4-10R10/P18C

NEW

ULTRAMINI

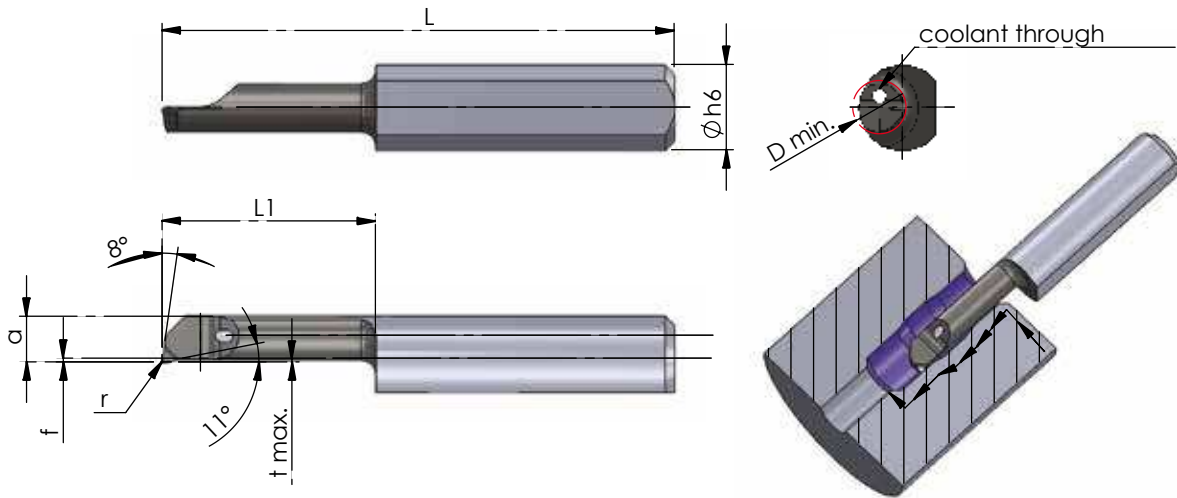
Xtraline Type X050



Grooving, boring, profiling, threading and chamfering starting at \varnothing 0.2 mm

Profiling and copying with chipbreaker, extra solid construction

Bore \varnothing from 6.0 mm



Right hand (R): as shown
Left hand version (L): mirror image

State right (R) or left (L) version

Dimensions in mm

part number	r	f	a	L	L1	t max.	D min.	$\varnothing h6$	U.S.A. Stock		tool holder type
									K10F	P18C	
NEW R/LX050.6-15R05	0.05	2.5	5.5	30	15	0.4	6	6	○	●	676.xxx 660.xxx / xxx.6
NEW R/LX050.6-15R10	0.1	2.5	5.5	30	15	0.4	6	6	○	●	
NEW R/LX050.6-15R20	0.2	2.5	5.5	30	15	0.4	6	6	○	●	
NEW R/LX050.6-22R20	0.2	2.5	5.5	37	22	0.4	6	6	○	●	
NEW R/LX050.6-30R20	0.2	2.5	5.5	45	30	0.4	6	6	○	●	
NEW R/LX050.6-35R20	0.2	2.5	5.5	50	35	0.4	6	6	○	●	
NEW R/LX050.6-50R20	0.2	2.5	5.5	65	50	0.4	6	6	○	●	
NEW R/LX050.7-25R20	0.2	3	6.5	40	25	0.5	7	7	○	●	687.xxx
NEW R/LX050.7-30R20	0.2	3	6.5	45	30	0.5	7	7	○	●	670.xxx / xxx.7

U.S.A. Stock

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- = Express Delivery
- ◐ = Left Hand in Stock
- ◑ = Right Hand in Stock

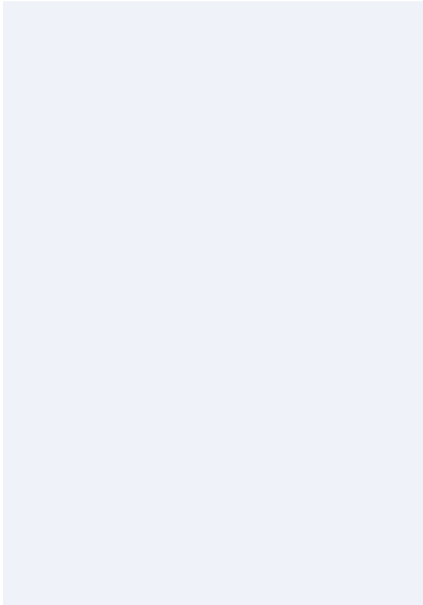
More carbide grades can be found in the grades summary in the section "technical instructions".

Order example:
Right hand version and grade
RX050.6-15R05/P18C

Impressions

ULTRAMINI

Grooving, boring and profiling
starting at \varnothing 0.2 mm





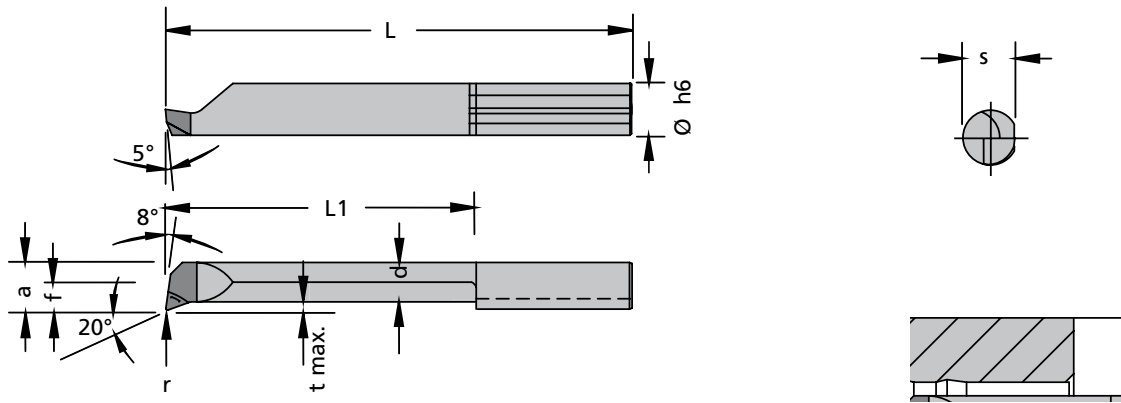
Hardline Type 050

Type 050
profiling and copying

Bore \varnothing from 2.0 mm
overhang length (L1) up to 7x D
hard machining up to 66 HRC

ULTRAMINI

Grooving, boring and profiling
starting at \varnothing 0.2 mm



Right hand version shown
State right (R) or left (L) version

Dimensions in mm

part number	U.S.A. Stock											XC2A-NH	suitable Tool holder type	
	r	s	f	d	a	L	L1	t max.	D min.	\varnothing h6				
R/L050.2-5	0.05	3.5	-	1.5	1.7	19.0	5.0	0.1	2.0	4.0	●			
R/L050.2-10	0.05	3.5	-	1.5	1.7	24.0	10.0	0.1	2.0	4.0	●			
R/L050.2-15	0.05	3.5	-	1.5	1.7	29.0	15.0	0.1	2.0	4.0	●			
R/L050.3-10	0.1	3.5	0.6	2.3	2.6	24.0	10.0	0.2	2.8	4.0	●			
R/L050.3-16	0.1	3.5	0.6	2.3	2.6	30.0	16.0	0.2	2.8	4.0	●			
R/L050.3-20	0.1	3.5	0.6	2.3	2.6	34.0	20.0	0.2	2.8	4.0	●	645.xxx	xxx.4	
R/L050.4-10	0.1	3.5	1.5	3.0	3.5	24.0	10.0	0.3	4.0	4.0	●			
R/L050.4-16	0.1	3.5	1.5	3.0	3.5	30.0	16.0	0.3	4.0	4.0	●			
R/L050.4-20	0.1	3.5	1.5	3.0	3.5	34.0	20.0	0.3	4.0	4.0	●			
R/L050.4-24	0.1	3.5	1.5	3.0	3.5	38.0	24.0	0.3	4.0	4.0	●			
R/L050.4-28	0.1	3.5	1.5	3.0	3.5	42.0	28.0	0.3	4.0	4.0	●			



COOLANT REQUIRED IN THE HARDLINE SERIES

U.S.A. Stock

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- ◑ = Right Hand in Stock

Carbide grades page 93

Order-example:
right hand version and grade
R050.2-5/XC2A-NH

ULTRAMINI

Hardline Type 050

Grooving, boring and profiling starting at Ø 0.2 mm

Type 050 profiling and copying

Bore Ø from 2.0 mm overhang length (L1) up to 7x D hard machining up to 66 HRC



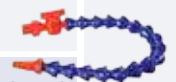
part number	r	s	f	d	a	L	L1	t max.	D min.	Ø h6	U.S.A. Stock		suitable tool holder type
											XC2A-NH		
R/L050.5-10	0.15	4.4	1.9	3.8	4.4	25.0	10.0	0.5	5.0	5.0	●		645.xxx xxx.5
R/L050.5-15	0.15	4.4	1.9	3.8	4.4	30.0	15.0	0.5	5.0	5.0	●		
R/L050.5-20	0.15	4.4	1.9	3.8	4.4	35.0	20.0	0.5	5.0	5.0	●		
R/L050.5-25	0.15	4.4	1.9	3.8	4.4	40.0	25.0	0.5	5.0	5.0	●		
R/L050.5-30	0.15	4.4	1.9	3.8	4.4	45.0	30.0	0.5	5.0	5.0	●		
R/L050.5-35	0.15	4.4	1.9	3.8	4.4	50.0	35.0	0.5	5.0	5.0	●		
R/L050.6-15	0.15	5.3	2.3	4.5	5.3	30.0	15.0	0.5	6.0	6.0	●		660 / xxx.6
R/L050.6-22	0.15	5.3	2.3	4.5	5.3	37.0	22.0	0.5	6.0	6.0	●		
R/L050.6-25	0.15	5.3	2.3	4.5	5.3	40.0	25.0	0.5	6.0	6.0	●		
R/L050.6-30	0.15	5.3	2.3	4.5	5.3	45.0	30.0	0.5	6.0	6.0	●		
R/L050.6-35	0.15	5.3	2.3	4.5	5.3	50.0	35.0	0.5	6.0	6.0	●		
R/L050.6-42	0.15	5.3	2.3	4.5	5.3	57.0	42.0	0.5	6.0	6.0	●		
R/L050.7-20	0.15	6.3	2.8	5.5	6.3	35.0	20.0	0.6	6.8	7.0	●		676.xxx 687 670 / xxx.7
R/L050.7-25	0.15	6.3	2.8	5.5	6.3	40.0	25.0	0.6	6.8	7.0	●		
R/L050.7-30	0.15	6.3	2.8	5.5	6.3	45.0	30.0	0.6	6.8	7.0	●		
R/L050.7-35	0.15	6.3	2.8	5.5	6.3	50.0	35.0	0.6	6.8	7.0	●		
R/L050.7-40	0.15	6.3	2.8	5.5	6.3	55.0	40.0	0.6	6.8	7.0	●		
R/L050.7-45	0.15	6.3	2.8	5.5	6.3	60.0	45.0	0.6	6.8	7.0	●		
R/L050.7-50	0.15	6.3	2.8	5.5	6.3	65.0	50.0	0.6	6.8	7.0	●		



U.S.A. Stock

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- ◐ = Left Hand in Stock
- ◑ = Right Hand in Stock

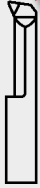
COOLANT REQUIRED IN THE HARDLINE SERIES



NEW

ULTRAMINI

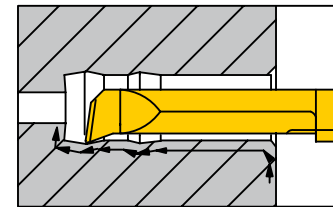
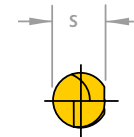
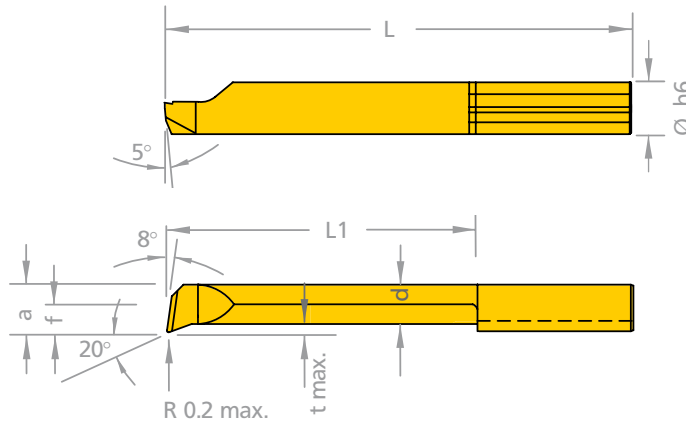
Type 050 C



Grooving, boring and profiling starting at Ø 0.2 mm

Profiling and copying with chipbreaker for better chip control

Bore Ø from 4.0 mm overhang length (L1) up to 7x D



Right hand version shown

State right (R) or left (L) version

Dimensions in mm



part number	U.S.A. Stock									AL41F	suitable toolholder type
	s	f	d	a	L	L1	t max.	D min.	Ø h6		
NEW R/L050.2-10C	3.5	-	1.5	1.7	24.0	10.0	0.1	2.0	4.0	○	645.xxx
NEW R/L050.3-10C	3.5	0.6	2.3	2.6	24.0	10.0	0.2	2.8	4.0	○	
NEW R/L050.3-16C	3.5	0.6	2.3	2.6	30.0	16.0	0.2	2.8	4.0	○	
R/L050.4-10C	3.5	1.5	3.0	3.5	24	10	0.3	4.0	4.0	●	
R/L050.4-16C	3.5	1.5	3.0	3.5	30	16	0.3	4.0	4.0	●	
R/L050.4-20C	3.5	1.5	3.0	3.5	34	20	0.3	4.0	4.0	●	
R/L050.4-24C	3.5	1.5	3.0	3.5	38	24	0.3	4.0	4.0	●	
R/L050.4-28C	3.5	1.5	3.0	3.5	42	28	0.3	4.0	4.0	●	
R/L050.5-10C	4.4	1.9	3.8	4.4	25	10	0.5	5.0	5.0	●	
R/L050.5-15C	4.4	1.9	3.8	4.4	30	15	0.5	5.0	5.0	●	
R/L050.5-20C	4.4	1.9	3.8	4.4	35	20	0.5	5.0	5.0	●	
R/L050.5-25C	4.4	1.9	3.8	4.4	40	25	0.5	5.0	5.0	●	
R/L050.5-30C	4.4	1.9	3.8	4.4	45	30	0.5	5.0	5.0	●	
R/L050.5-35C	4.4	1.9	3.8	4.4	50	35	0.5	5.0	5.0	●	

U.S.A. Stock

- = Both Right & Left Hand in Stock
- = Express Delivery
- ◐ = Left Hand in Stock
- ◑ = Right Hand in Stock

Carbide grades p. 93 see «grades summary»

Order-example: right hand version and gradeAL41F: R050.4-10C/AL41F

Type 050 C

ULTRAMINI

Profiling and copying with chipbreaker for better chip controll

Bore Ø from 4.0 mm overhang length (L1) up to 7x D

Grooving, boring and profiling starting at Ø 0.2 mm

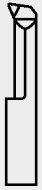


part number	s	f	d	a	L	L1	t max.	D min.	Ø h6	U.S.A. Stock		suitable toolholder type
										AL41F		
R/L050.6-15C	5.3	2.3	4.5	5.3	30	15	0.5	6.0	6.0	●		660 / xxx.6
R/L050.6-22C	5.3	2.3	4.5	5.3	37	22	0.5	6.0	6.0	●		
R/L050.6-25C	5.3	2.3	4.5	5.3	40	25	0.5	6.0	6.0	●		
R/L050.6-30C	5.3	2.3	4.5	5.3	45	30	0.5	6.0	6.0	●		
R/L050.6-35C	5.3	2.3	4.5	5.3	50	35	0.5	6.0	6.0	●		
R/L050.6-42C	5.3	2.3	4.5	5.3	57	42	0.5	6.0	6.0	●		
R/L050.7-20C	6.3	2.8	5.5	6.3	35	20	0.6	6.8	7.0	●	676.xxx	687 / 670 / xxx.7
R/L050.7-25C	6.3	2.8	5.5	6.3	40	25	0.6	6.8	7.0	●		
R/L050.7-30C	6.3	2.8	5.5	6.3	45	30	0.6	6.8	7.0	●		
R/L050.7-35C	6.3	2.8	5.5	6.3	50	35	0.6	6.8	7.0	●		
R/L050.7-40C	6.3	2.8	5.5	6.3	55	40	0.6	6.8	7.0	●		
R/L050.7-45C	6.3	2.8	5.5	6.3	60	45	0.6	6.8	7.0	●		
R/L050.7-50C	6.3	2.8	5.5	6.3	65	50	0.6	6.8	7.0	●		



U.S.A. Stock

- = Both Right & Left Hand in Stock
- = Express Delivery
- ◐ = Left Hand in Stock
- ◑ = Right Hand in Stock



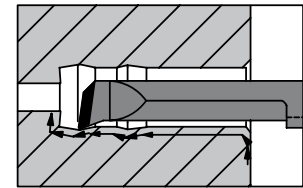
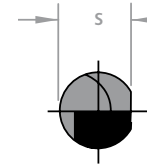
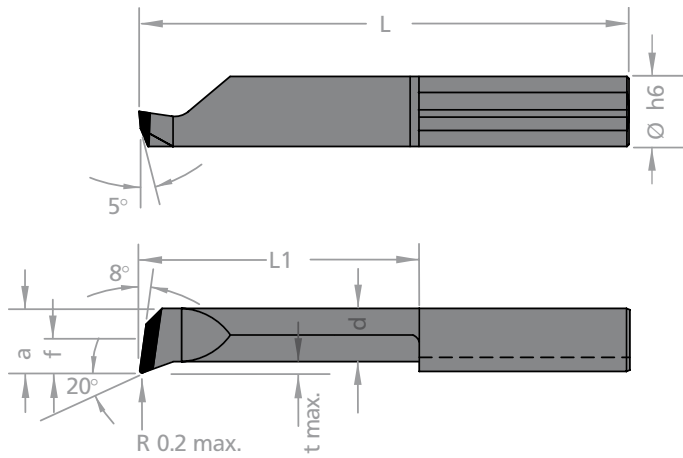
Type 050 CBN

Profiling and copying
for hard machining

Bore \varnothing from 2.8 mm

ULTRAMINI

Grooving, boring and profiling
starting at \varnothing 0.2 mm



Right hand version shown

State right (R) or left (L) version

Dimensions in mm



part number	U.S.A. Stock										suitable toolholder type	
	s	f	d	a	L	L1	t max.	D min.	\varnothing h6	CBN		
R050.3-10/CBN	3.5	0.6	2.3	2.6	25.5	10	0.2	2.8	4.0	●	645.xxx	xxx.4
R050.4-10/CBN	3.5	1.5	3.0	3.5	25.5	10	0.3	4.0	4.0	●		xxx.5
R050.5-15/CBN	4.3	1.9	3.8	4.4	31.5	15	0.5	5.0	5.0	●		676.xxx
R050.6-15/CBN	5.3	2.3	4.5	5.3	31.5	15	0.5	6.0	6.0	○	687 / 670 / xxx.7	
R050.7-20/CBN	6.3	2.8	5.5	6.3	36.5	20	0.6	6.8	7.0	○		

U.S.A. Stock

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- ◑ = Right Hand in Stock

Carbide grades p. 93 see «grades summary»

Order-example: right hand version and grade
R050.3-10/CBN

ULTRAMINI

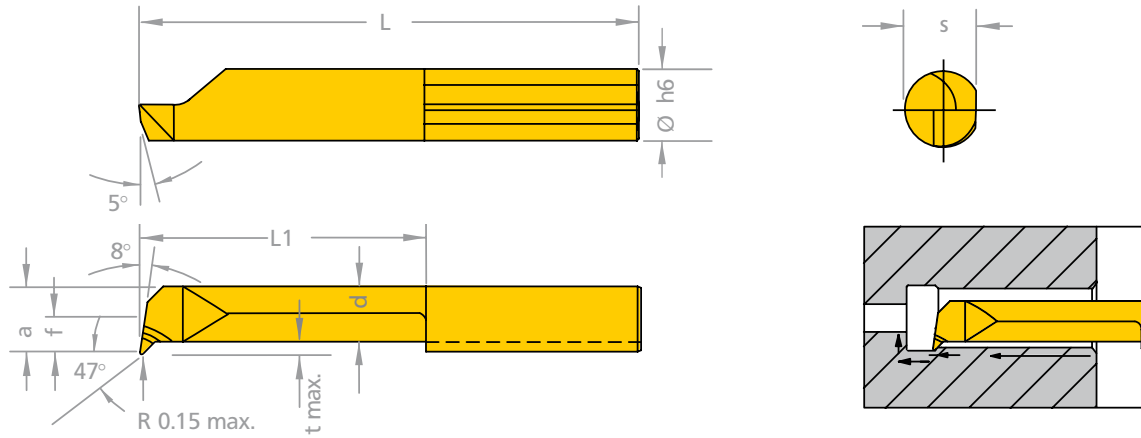
Type 047

Version T with extended t max.

Grooving, boring and profiling starting at Ø 0.2 mm

Profiling and copying with 47° geometry

Bore Ø from 4.0 mm



Right hand version shown

State right (R) or left (L) version

Dimensions in mm



Version T with extended t max.

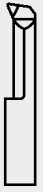
part number										U.S.A. Stock	suitable toolholder	
	s	f	d	a	L	L1	t max.	D min.	Ø h6	AL41F	type	type
R/L047.T2-10	3.5	-	1.2	1.7	24	10	0.4	2.0	4.0	○	645.xxx	xxx.4
R/L047.T3-15	3.5	0.6	1.9	2.6	29	15	0.6	2.8	4.0	●		
R/L047.T4-10	3.5	1.5	2.8	3.5	24	10	0.6	4.0	4.0	◐		
R/L047.4-20	3.5	1.5	3.0	3.5	34	20	0.3	4.0	4.0	○		
R/L047.T4-20	3.5	1.5	2.8	3.5	34	20	0.6	4.0	4.0	○		
R/L047.T5-15	4.4	1.9	3.5	4.4	30	15	0.8	5.0	5.0	◐	xxx.5	
R/L047.5-25	4.4	1.9	3.8	4.4	40	25	0.5	5.0	5.0	○		
R/L047.T5-25	4.4	1.9	3.5	4.4	40	25	0.8	5.0	5.0	○		
R/L047.T6-22	5.3	2.3	3.4	5.3	37	22	1.8	6.0	6.0	◐	676.xxx	660 / xxx.6
R/L047.6-30	5.3	2.3	4.5	5.3	45	30	0.5	6.0	6.0	◐		
R/L047.T6-30	5.3	2.3	3.4	5.3	45	30	1.8	6.0	6.0	◐		

U.S.A. Stock

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- = Express Delivery
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- ◑ = Right Hand in Stock

Carbide grades p. 93 see «grades summary»

Order-example: right hand version and grade
CN45F: R047.T2-10/CN45F



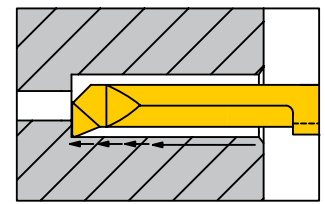
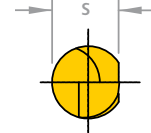
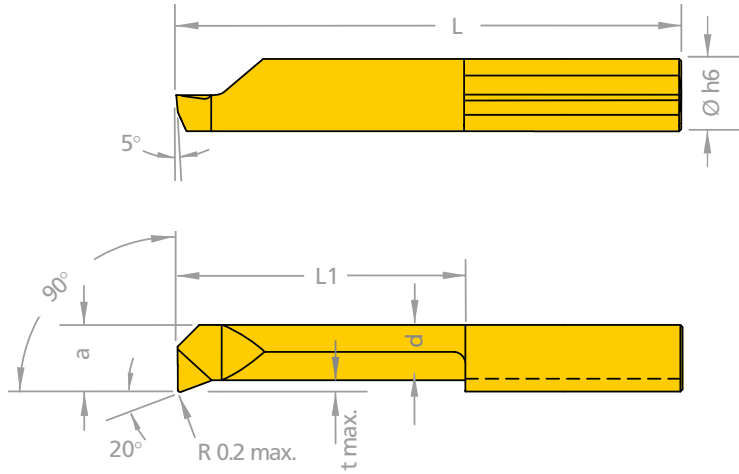
Type 090

Profiling and copying with geometry 90°

Bore Ø from 2.8 mm

ULTRAMINI

Grooving, boring and profiling starting at Ø 0.2 mm



Right hand version shown

State right (R) or left (L) version

Dimensions in mm

part number	U.S.A. Stock										suitable toolholder type	
	s	f	d	a	L	L1	t max.	D min.	Ø h6	CN45F		
R/L090.3-10	3.5	0.6	2.3	2.6	24	10	0.2	2.8	4.0	●	645.xxx	xxx.4
R/L090.3-16	3.5	0.6	2.3	2.6	30	16	0.2	2.8	4.0	●		
R/L090.4-10	3.5	1.5	3.0	3.5	24	10	0.3	4.0	4.0	●	645.xxx	xxx.5
R/L090.4-16	3.5	1.5	3.0	3.5	30	16	0.3	4.0	4.0	●		
R/L090.5-10	4.4	1.9	3.8	4.4	25	10	0.5	5.0	5.0	●	645.xxx	xxx.5
R/L090.5-15	4.4	1.9	3.8	4.4	30	15	0.5	5.0	5.0	●		
R/L090.5-20	4.4	1.9	3.8	4.4	35	20	0.5	5.0	5.0	●		

U.S.A. Stock

- = Both Right & Left Hand in Stock
- = Express Delivery
- ◐ = Left Hand in Stock
- ◑ = Right Hand in Stock

Carbide grades p. 93 see «grades summary»

Order-example: right hand version and grade
CN45F: R090.3-10/CN45F

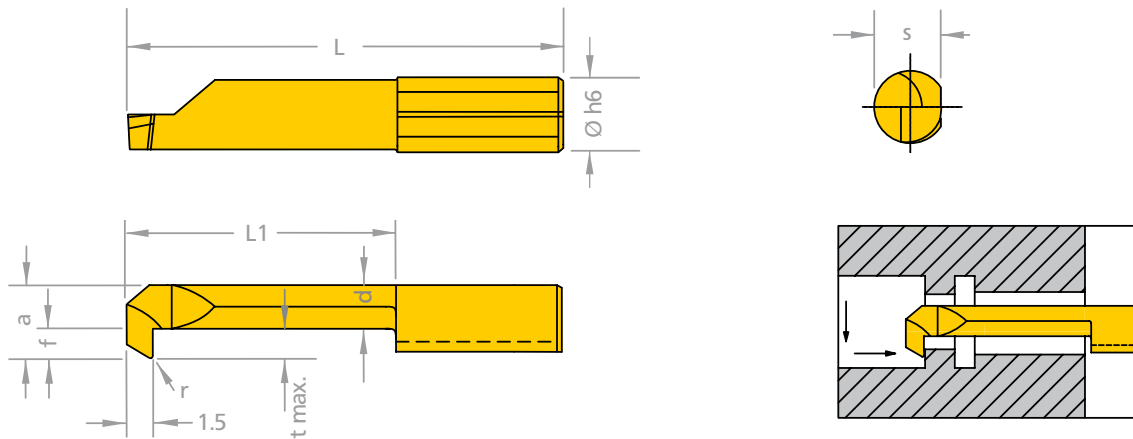
ULTRAMINI

Type 080

Grooving, boring and profiling starting at Ø 0.2 mm

Backboring

Bore Ø from 3.0 mm



Right hand version shown

State right (R) or left (L) version

Dimensions in mm



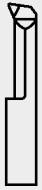
part number											U.S.A. Stock	suitable toolholder type	
	r	s	f	d	a	L	L1	t max.	D min.	Ø h6	CN45F		
R/L080.0003-15	0.1	3.5	0.6	1.9	2.6	29	15	0.5	3.0	4.0	●	645.xxx	xxx.4
R/L080.0003-20	0.1	3.5	0.6	1.9	2.6	34	20	0.5	3.0	4.0	○		
R/L080.0004-15	0.15	3.5	1.5	2.4	3.5	29	15	0.8	4.0	4.0	●	645.xxx	xxx.5
R/L080.0004-25	0.15	3.5	1.5	2.4	3.5	39	25	0.8	4.0	4.0	○		
R/L080.0005-20	0.2	4.4	1.9	3.3	4.4	35	20	1.0	5.0	5.0	●	676.xxx	660 / xxx.6
R/L080.0005-30	0.2	4.4	1.9	3.3	4.4	45	30	1.0	5.0	5.0	○		
R/L080.0006-20	0.2	5.3	2.3	3.4	5.3	35	20	1.8	6.0	6.0	●	676.xxx	687 / 670 / xxx.7
R/L080.0006-30	0.2	5.3	2.3	3.4	5.3	45	30	1.8	6.0	6.0	○		
R/L080.0007-20	0.2	6.3	2.8	3.7	6.3	35	20	2.5	7.0	7.0	●		
R/L080.0007-30	0.2	6.3	2.8	3.7	6.3	45	30	2.5	7.0	7.0	○		

U.S.A. Stock

- = Both Right & Left Hand in Stock
- = Express Delivery
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- ◑ = Right Hand in Stock

Carbide grades p. 93 see «grades summary»

Order-example: right hand version and grade
CN45F: R080.0003-15/CN45F



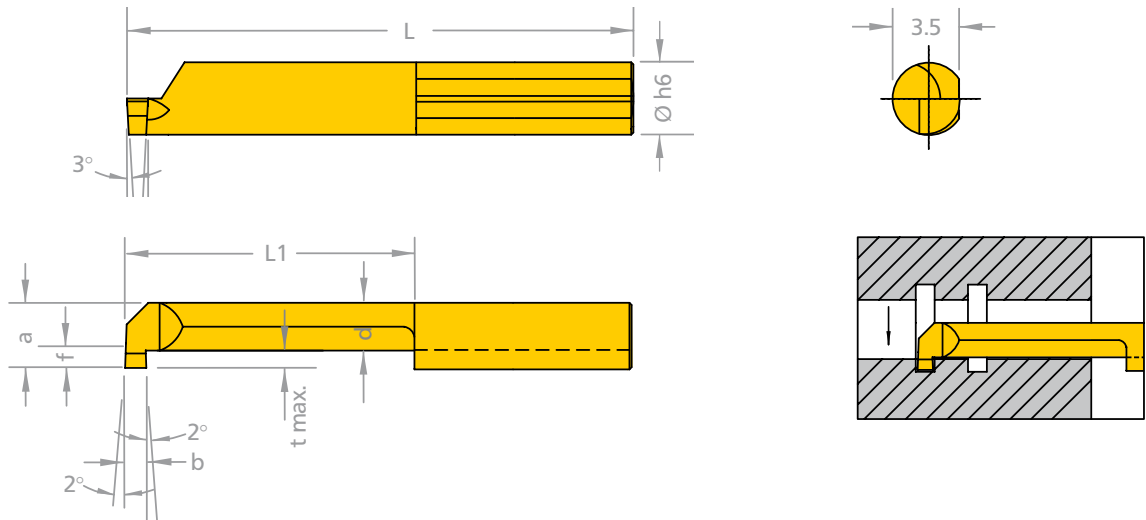
Type 002

ULTRAMINI

Grooving

Bore \varnothing from 2.0 mm
depth of groove up to 0.4 mm

Grooving, boring and profiling
starting at \varnothing 0.2 mm



Right hand version shown

State right (R) or left (L) version

Dimensions in mm



part number	b +0.05	d	a	L	L1	t max.	D min.	Ø h6	U.S.A. Stock		suitable toolholder type
									AL41F		
R/L002.0050-5	0.5	1.2	1.8	19	5	0.4	2.0	4.0	●		645.xxx / xxx.4
R/L002.0050-10	0.5	1.2	1.8	24	10	0.4	2.0	4.0	●		
R/L002.0050-15	0.5	1.2	1.8	29	15	0.4	2.0	4.0	●		

U.S.A. Stock

- = Both Right & Left Hand in Stock
- = Express Delivery
- ◐ = Left Hand in Stock
- ◑ = Right Hand in Stock

Carbide grades p. 93 see «grades summary»

Order-example: right hand version and grade
AL41F: R002.0050-5/AL41F

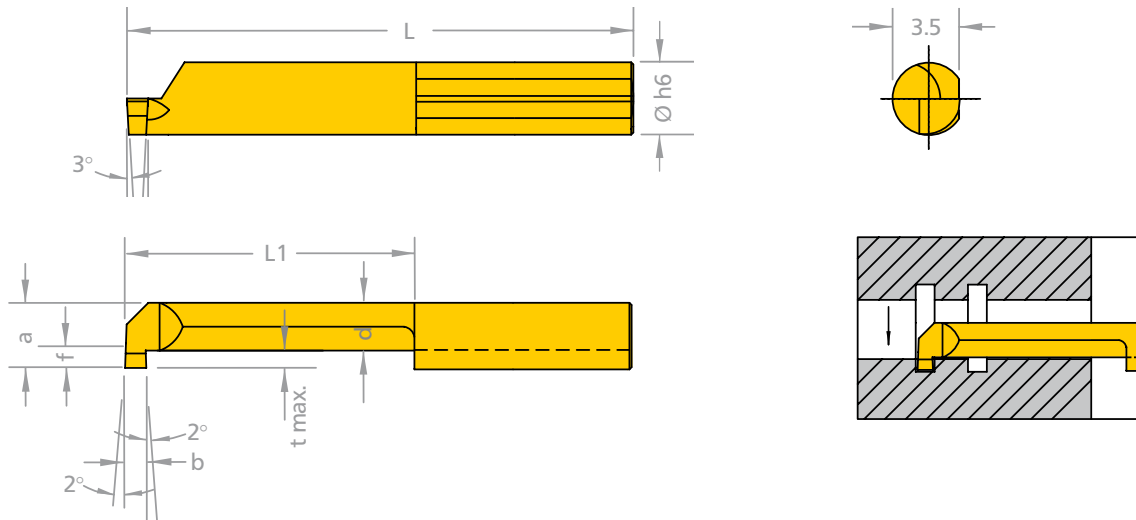
ULTRAMINI

Type 003

Grooving, boring and profiling starting at \varnothing 0.2 mm

Grooving

Bore \varnothing from 3.0 mm
depth of groove up to 0.6 mm



Right hand version shown

State right (R) or left (L) version

Dimensions in mm



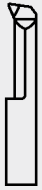
part number	U.S.A. Stock									suitable toolholder type	
	b +0.05	f	d	a	L	L1	t max.	D min.	\varnothing h6		AL41F
R/L003.0070-5	0.7	0.7	1.9	2.7	19	5	0.6	3.0	4.0	●	645.xxx / xxx.4
R/L003.0070-10	0.7	0.7	1.9	2.7	24	10	0.6	3.0	4.0	●	
R/L003.0070-16	0.7	0.7	1.9	2.7	30	16	0.6	3.0	4.0	●	

U.S.A. Stock

- = Both Right & Left Hand in Stock
- = Express Delivery
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- ◑ = Right Hand in Stock

Carbide grades p. 93 see «grades summary»

Order-example: right hand version and grade
AL41F: R003.0070-5/AL41F



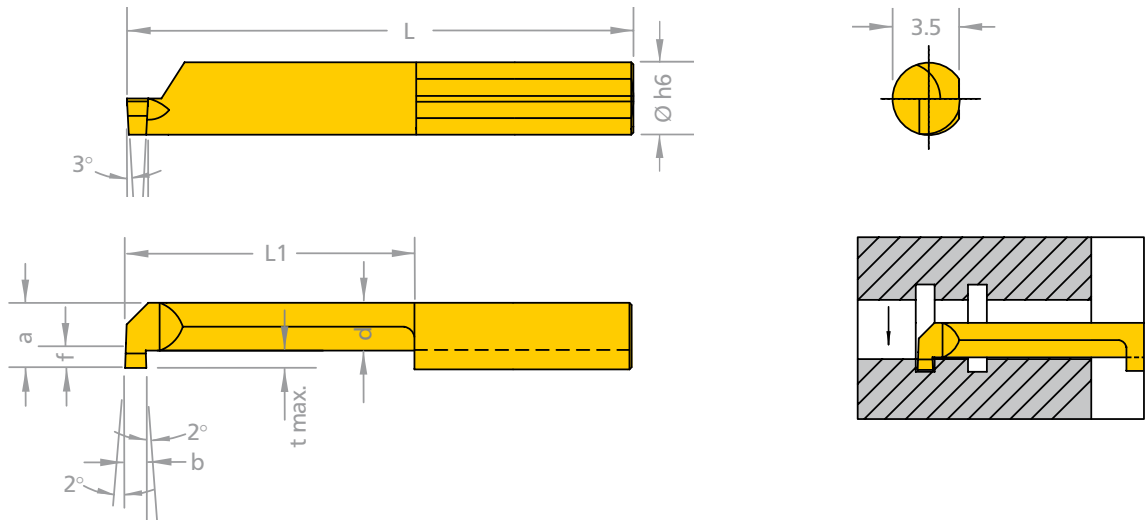
Type 004

ULTRAMINI

Grooving

Bore Ø from 4.0 mm
depth of groove up to 0.8 mm

Grooving, boring and profiling
starting at Ø 0.2 mm



Right hand version shown

State right (R) or left (L) version

Dimensions in mm



part number	U.S.A. Stock									suitable toolholder type	
	b +0.05	f	d	a	L	L1	t max.	D min.	Ø h6		CN45F
R/L004.0100-10	1.0	1.5	2.4	3.5	24	10	0.8	4.0	4.0	●	645.xxx / xxx.4
R/L004.0100-16	1.0	1.5	2.4	3.5	30	16	0.8	4.0	4.0	●	
R/L004.0100-20	1.0	1.5	2.4	3.5	34	20	0.8	4.0	4.0	●	

U.S.A. Stock

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- ◑ = Right Hand in Stock

Carbide grades p. 93 see «grades summary»

Order-example: right hand version and grade
CN45F: R004.0100-10/CN45F

ULTRAMINI

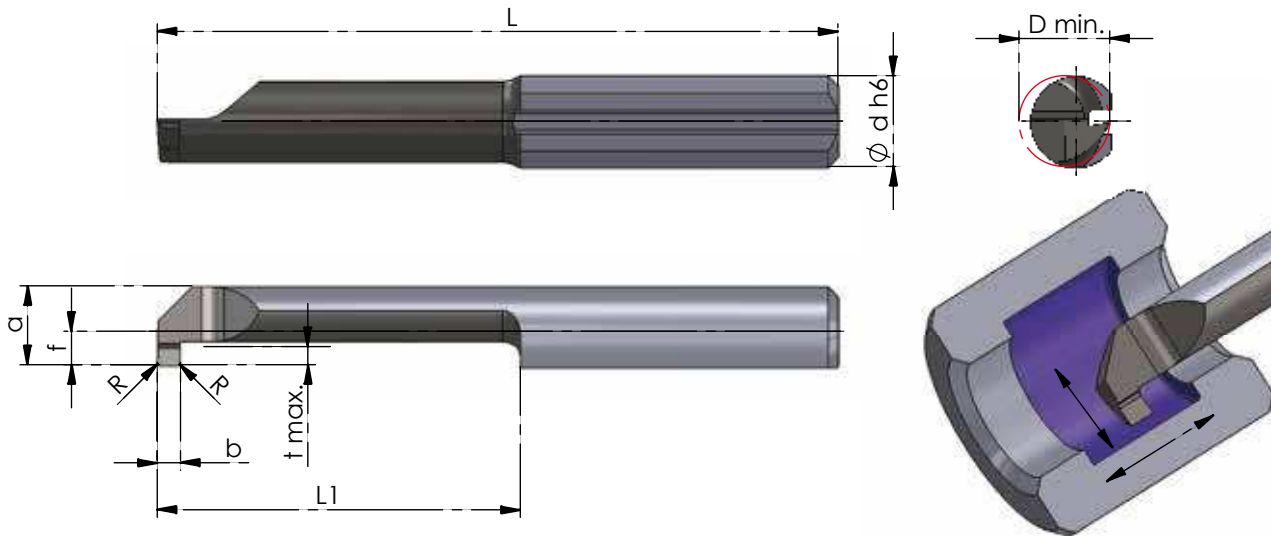
Type 004 M

NEW

Grooving, boring, profiling, threading and chamfering starting at \varnothing 0.2 mm

Grooving with corner-radius

Bore \varnothing starting at 4 mm depth of groove t max. 0.8 mm



Right hand version shown

State right (R) or left (L) version

Dimensions in mm

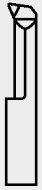


NEW

part number	b +0.05	b (inch)	f	a	L	L1	t max.	D min.	\varnothing d h6	R	U.S.A. Stock	toolholder type
											AL41F	
R/L004M0079-20 INCH SIZE	0.79	0.031"	1.5	3.5	34	20	0.8	4	4	0.1	●	645.xxx xxx.4
R/L004M0100-10	1.0	-	1.5	3.5	24	10	0.8	4	4	0.1	○	
R/L004M0100-16	1.0	-	1.5	3.5	30	16	0.8	4	4	0.1	○	
R/L004M0100-20	1.0	-	1.5	3.5	34	20	0.8	4	4	0.1	○	

More carbide grades can be found in the grades summary in the section "technical instructions".

Order example:
Right hand version and grade AL41F:
R004M0100-10/AL41F



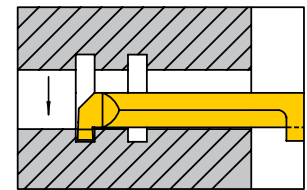
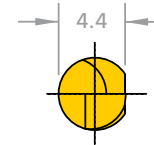
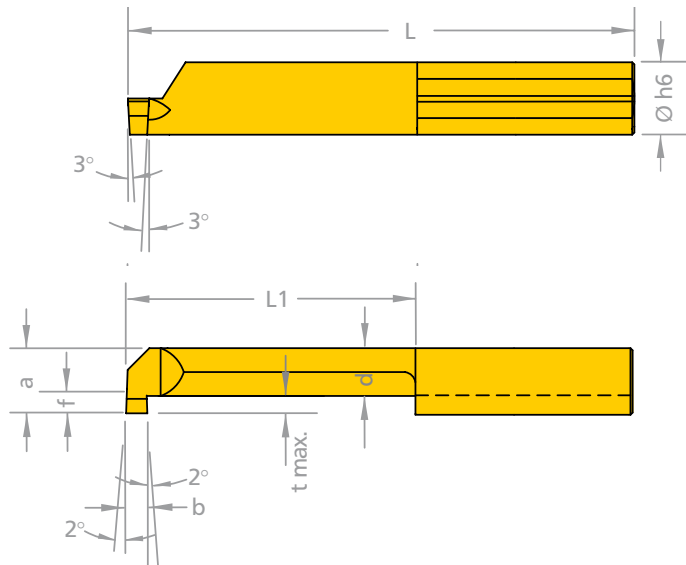
Type 005

ULTRAMINI

Grooving

Bore Ø from 5.0 mm
depth of groove up to 1.0 mm
overhang length (L1) up to 7x D

Grooving, boring and profiling
starting at Ø 0.2 mm



Right hand version shown

State right (R) or left (L) version

Dimensions in mm

part number										U.S.A. Stock	suitable toolholder type
	b +0.05	f	d	a	L	L1	t max.	D min.	Ø h6	CN45F	
R/L005.0100-10	1.0	1.9	3.3	4.4	25	10	1.0	5.0	5.0	●	645.xxx / xxx.5
R/L005.0100-15	1.0	1.9	3.3	4.4	30	15	1.0	5.0	5.0	●	
R/L005.0100-20	1.0	1.9	3.3	4.4	35	20	1.0	5.0	5.0	●	
R/L005.0100-25	1.0	1.9	3.3	4.4	40	25	1.0	5.0	5.0	●	
R/L005.0100-30	1.0	1.9	3.3	4.4	45	30	1.0	5.0	5.0	●	
R/L005.0100-35	1.0	1.9	3.3	4.4	50	35	1.0	5.0	5.0	●	
R/L005.0150-10	1.5	1.9	3.3	4.4	25	10	1.0	5.0	5.0	●	
R/L005.0150-15	1.5	1.9	3.3	4.4	30	15	1.0	5.0	5.0	●	
R/L005.0150-20	1.5	1.9	3.3	4.4	35	20	1.0	5.0	5.0	●	
R/L005.0150-25	1.5	1.9	3.3	4.4	40	25	1.0	5.0	5.0	●	
R/L005.0150-30	1.5	1.9	3.3	4.4	45	30	1.0	5.0	5.0	●	

U.S.A. Stock

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- ◑ = Right Hand in Stock

Carbide grades p. 93 see «grades summary»

Order-example: right hand version and grade
CN45F: R005.0100-10/CN45F

ULTRAMINI

Grooving, boring and profiling starting at Ø 0.2 mm

Type 005

Grooving

Bore Ø from 5.0 mm
depth of groove up to 1.0 mm
overhang length (L1) up to 7x D



part number	b +0.05	f	d	a	L	L1	t max.	D min.	Ø h6	U.S.A. Stock		suitable toolholder type
										K10F	CN45F	
R/L005.0200-10	2.0	1.9	3.3	4.4	25	10	1.0	5.0	5.0	○	●	645.xxx / xxx.5
R/L005.0200-15	2.0	1.9	3.3	4.4	30	15	1.0	5.0	5.0	○	●	
R/L005.0200-20	2.0	1.9	3.3	4.4	35	20	1.0	5.0	5.0	○	●	
R/L005.0200-25	2.0	1.9	3.3	4.4	40	25	1.0	5.0	5.0	○	○	
R/L005.0200-30	2.0	1.9	3.3	4.4	45	30	1.0	5.0	5.0	○	●	



U.S.A. Stock

- = Both Right & Left Hand in Stock
- = Express Delivery
- ◐ = Left Hand in Stock
- ◑ = Right Hand in Stock



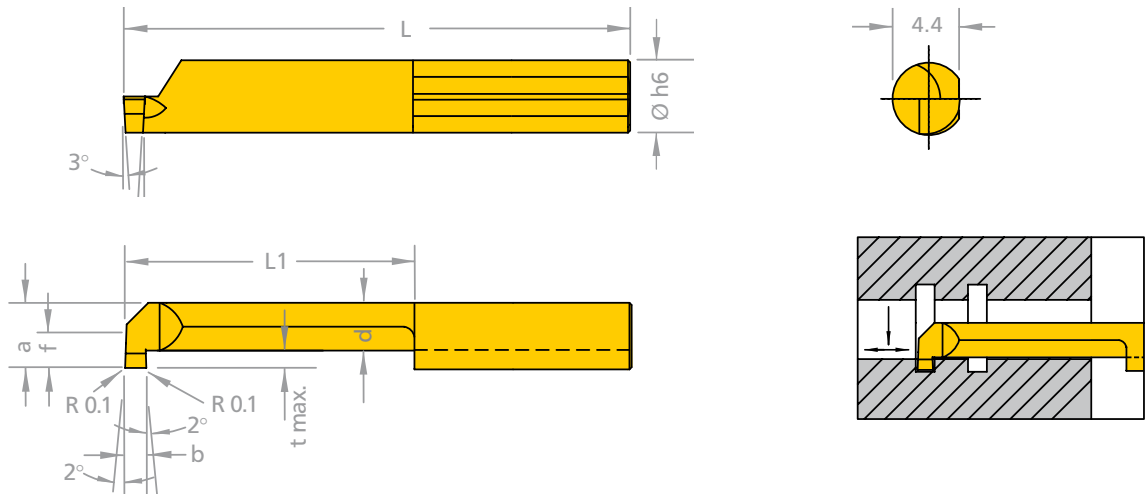
Type 005 M

Grooving with corner-radius

Bore \varnothing from 5.0 mm
depth of groove up to 1.0 mm

ULTRAMINI

Grooving, boring and profiling
starting at \varnothing 0.2 mm



Right hand version shown

State right (R) or left (L) version

Dimensions in mm



part number										U.S.A. Stock		suitable toolholder type
	b +0.05	f	d	a	L	L1	t max.	D min.	\varnothing h6	AL41F		
R/L005M0100-10	1.0	1.9	3.3	4.4	25	10	1.0	5.0	5.0	○	645.xxx / xxx.5	
R/L005M0100-15	1.0	1.9	3.3	4.4	30	15	1.0	5.0	5.0	○		
R/L005M0100-20	1.0	1.9	3.3	4.4	35	20	1.0	5.0	5.0	○		
R/L005M0100-25	1.0	1.9	3.3	4.4	40	25	1.0	5.0	5.0	○		
R/L005M0100-30	1.0	1.9	3.3	4.4	45	30	1.0	5.0	5.0	○		
R/L005M0150-10	1.5	1.9	3.3	4.4	25	10	1.0	5.0	5.0	○		
R/L005M0150-15	1.5	1.9	3.3	4.4	30	15	1.0	5.0	5.0	○		
R/L005M0150-20	1.5	1.9	3.3	4.4	35	20	1.0	5.0	5.0	○		
R/L005M0150-25	1.5	1.9	3.3	4.4	40	25	1.0	5.0	5.0	○		
R/L005M0150-30	1.5	1.9	3.3	4.4	45	30	1.0	5.0	5.0	○		

U.S.A. Stock

- = Both Right & Left Hand in Stock
- = Express Delivery
- ◐ = Left Hand in Stock
- ◑ = Right Hand in Stock

Carbide grades p. 93 see «grades summary»

Order-example: right hand version and grade
AL41F: R005M0100-10/AL41F

ULTRAMINI

Grooving, boring and profiling starting at Ø 0.2 mm

Type 005 M

Grooving with corner-radius

Bore Ø from 5.0 mm
depth of groove up to 1.0 mm

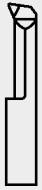


part number	b +0.05	f	d	a	L	L1	t max.	D min.	Ø h6	U.S.A. Stock		suitable toolholder type
										AL41F		
R/L005M0200-10	2.0	1.9	3.3	4.4	25	10	1.0	5.0	5.0	○		645.xxx / xxx.5
R/L005M0200-15	2.0	1.9	3.3	4.4	30	15	1.0	5.0	5.0	○		
R/L005M0200-20	2.0	1.9	3.3	4.4	35	20	1.0	5.0	5.0	○		
R/L005M0200-25	2.0	1.9	3.3	4.4	40	25	1.0	5.0	5.0	○		
R/L005M0200-30	2.0	1.9	3.3	4.4	45	30	1.0	5.0	5.0	○		



U.S.A. Stock

- = Both Right & Left Hand in Stock
- = Express Delivery
- ◐ = Left Hand in Stock
- ◑ = Right Hand in Stock



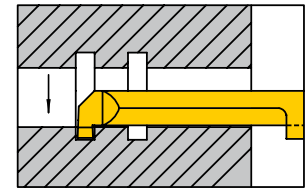
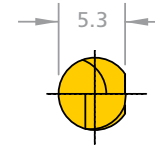
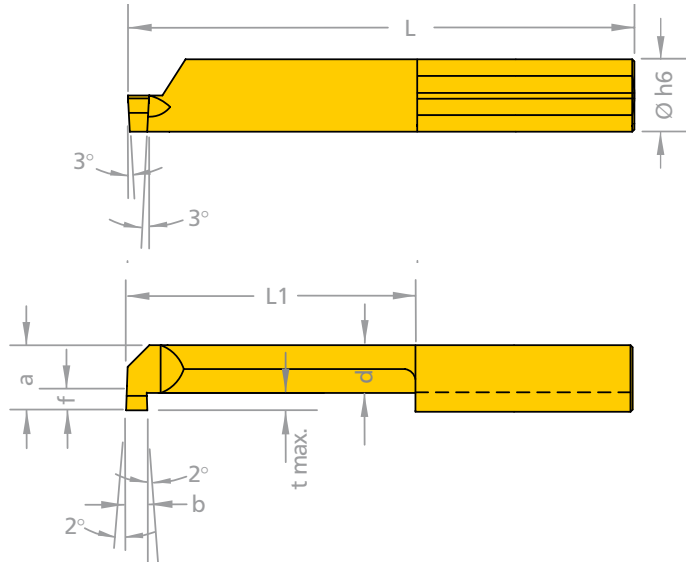
Type 006

ULTRAMINI

Grooving

Bore Ø from 6.0 mm
depth of groove up to 1.8 mm
overhang length (L1) up to 7x D

Grooving, boring and profiling
starting at Ø 0.2 mm



Right hand version shown

State right (R) or left (L) version

Dimensions in mm



part number	b +0.05	f	d	a	L	L1	t max.	D min.	Ø h6	U.S.A. Stock		suitable toolholder type	
										K10F	CN45F		
R/L006.0100-10	1.0	2.3	3.4	5.3	25	10	1.8	6.0	6.0	○	●	676.xxx / xxx.6	660
R/L006.0100-15	1.0	2.3	3.4	5.3	30	15	1.8	6.0	6.0	○	●		
R/L006.0100-22	1.0	2.3	3.4	5.3	37	22	1.8	6.0	6.0	○	●		
R/L006.0100-25	1.0	2.3	3.4	5.3	40	25	1.8	6.0	6.0	○	●		
R/L006.0100-30	1.0	2.3	3.4	5.3	45	30	1.8	6.0	6.0	○	●		
R/L006.0100-35	1.0	2.3	3.4	5.3	50	35	1.8	6.0	6.0	—	○		
R/L006.0100-42	1.0	2.3	3.4	5.3	57	42	1.8	6.0	6.0	—	○		
R/L006.0150-10	1.5	2.3	3.4	5.3	25	10	1.8	6.0	6.0	●	●		
R/L006.0150-15	1.5	2.3	3.4	5.3	30	15	1.8	6.0	6.0	○	●		
R/L006.0150-22	1.5	2.3	3.4	5.3	37	22	1.8	6.0	6.0	○	●		
R/L006.0150-25	1.5	2.3	3.4	5.3	40	25	1.8	6.0	6.0	○	●		
R/L006.0150-30	1.5	2.3	3.4	5.3	45	30	1.8	6.0	6.0	○	●		
R/L006.0150-35	1.5	2.3	3.4	5.3	50	35	1.8	6.0	6.0	—	○		

U.S.A. Stock

- = Both Right & Left Hand in Stock
- = Express Delivery
- ◐ = Left Hand in Stock
- ◑ = Right Hand in Stock

Carbide grades p. 93 see «grades summary»

Order-example: right hand version and grade
CN45F: R006.0100-10/CN45F

ULTRAMINI

Grooving, boring and profiling starting at Ø 0.2 mm

Type 006

Grooving

Bore Ø from 6.0 mm
depth of groove up to 1.8 mm
overhang length (L1) up to 7x D



part number	b +0.05	f	d	a	L	L1	t max.	D min.	Ø h6	U.S.A. Stock			suitable toolholder type	
										K10F	CN45F	AL41F		
R/L006.0200-10	2.0	2.3	3.4	5.3	25	10	1.8	6.0	6.0	○	●	—	676.xxx / xxx.6	660
R/L006.0200-15	2.0	2.3	3.4	5.3	30	15	1.8	6.0	6.0	○	●	—		
R/L006.0200-22	2.0	2.3	3.4	5.3	37	22	1.8	6.0	6.0	○	●	—		
R/L006.0200-25	2.0	2.3	3.4	5.3	40	25	1.8	6.0	6.0	○	●	—		
R/L006.0200-30	2.0	2.3	3.4	5.3	45	30	1.8	6.0	6.0	○	●	—		



U.S.A. Stock

- = Both Right & Left Hand in Stock
- = Express Delivery
- ◐ = Left Hand in Stock
- ◑ = Right Hand in Stock

NEW

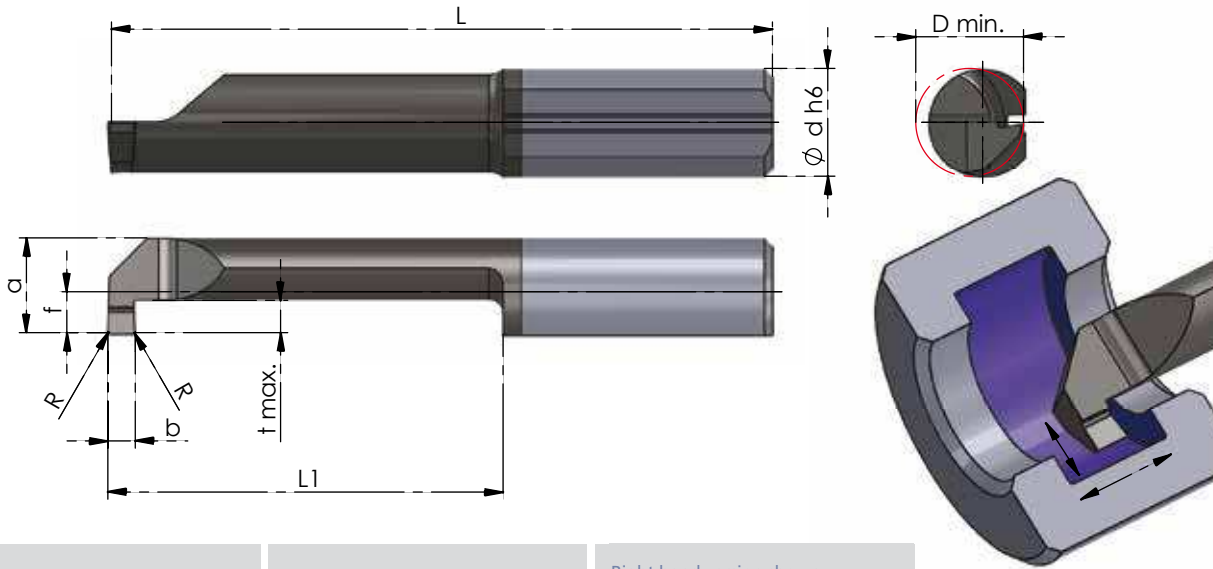
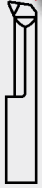
ULTRAMINI

Type 006 M

Grooving, boring, profiling, threading and chamfering starting at \varnothing 0.2 mm

Grooving with corner-radius

Bore \varnothing starting at 6 mm depth of groove t max. 1.8 mm



Right hand version shown
State right (R) or left (L) version
Dimensions in mm

part number	b +0.05	b (inch)	f	a	L	L1	t max.	D min.	Ø d h6	R	U.S.A. Stock	AL41F	tool holder type
R/L006M0100-10	1.0	-	2.3	5.3	25	10	1.8	6	6	0.1	○	○	676.xxx / xxx.6 660
R/L006M0100-15	1.0	-	2.3	5.3	30	15	1.8	6	6	0.1	○	○	
R/L006M0100-22	1.0	-	2.3	5.3	37	22	1.8	6	6	0.1	○	○	
R/L006M0100-25	1.0	-	2.3	5.3	40	25	1.8	6	6	0.1	○	○	
R/L006M0100-30	1.0	-	2.3	5.3	45	30	1.8	6	6	0.1	○	○	
NEW R/L006M0116-15 INCH SIZE	1.17	0.046"	2.3	5.3	30	15	1.8	6	6	0.1	◐	○	
R/L006M0150-10	1.5	-	2.3	5.3	25	10	1.8	6	6	0.1	○	○	
R/L006M0150-15	1.5	-	2.3	5.3	30	15	1.8	6	6	0.1	○	○	
R/L006M0150-22	1.5	-	2.3	5.3	37	22	1.8	6	6	0.1	○	○	
R/L006M0150-25	1.5	-	2.3	5.3	40	25	1.8	6	6	0.1	○	○	
R/L006M0150-30	1.5	-	2.3	5.3	45	30	1.8	6	6	0.1	○	○	
NEW R/L006M0198-15 INCH SIZE	1.98	0.078"	2.3	5.3	30	15	1.8	6	6	0.1	◐	○	
R/L006M0200-10	2.0	-	2.3	5.3	25	10	1.8	6	6	0.1	○	○	
R/L006M0200-15	2.0	-	2.3	5.3	30	15	1.8	6	6	0.1	○	○	
R/L006M0200-22	2.0	-	2.3	5.3	37	22	1.8	6	6	0.1	○	○	
R/L006M0200-25	2.0	-	2.3	5.3	40	25	1.8	6.0	6.0	0.1	○	○	
R/L006M0200-30	2.0	-	2.3	5.3	45	30	1.8	6.0	6.0	0.1	○	○	

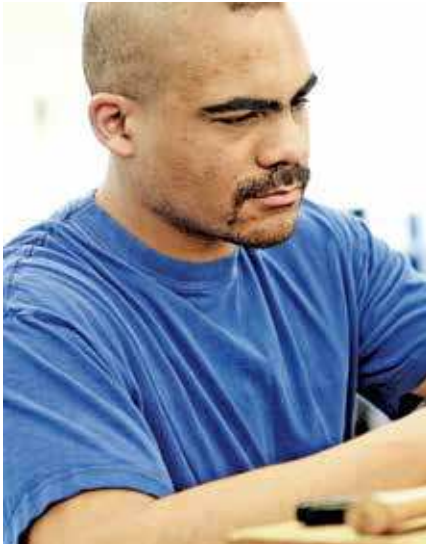
More carbide grades can be found in the grades summary in the section "technical instructions".

Order example:
Right hand version and grade AL41F:
R006M0100-10/AL41F

Impressions

ULTRAMINI

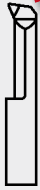
Grooving, boring and profiling
starting at \varnothing 0.2 mm



NEW

ULTRAMINI

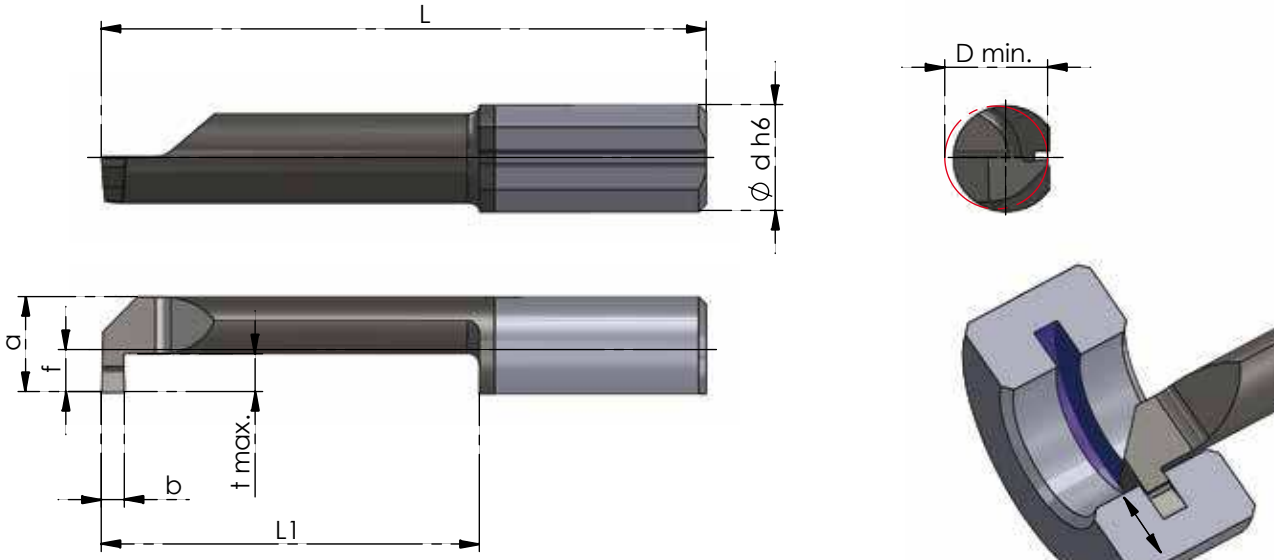
Type 007



Grooving, boring, profiling, threading and chamfering starting at \varnothing 0.2 mm

Grooving

Bore \varnothing starting at 6.8 mm
depth of groove t max. 2.5 mm
overhang length (L1) up to 7x D



Right hand version shown

State right (R) or left (L) version

Dimensions in mm

part number	b +0.05	b (inch)	f	a	L	L1	t max.	D min.	Ø d h6	U.S.A. Stock		tool holder type
										CN45F	AL41F	
NEW R/L007.0079-25 INCH SIZE	0.79	0.031"	2.8	6.3	40	25	2.5	6.8	7.0	-	●	676.xxx / 687 670 / xxx.7
R/L007.0100-10	1.0	-	2.8	6.3	25	10	2.5	6.8	7.0	●	-	
R/L007.0100-15	1.0	-	2.8	6.3	30	15	2.5	6.8	7.0	●	-	
R/L007.0100-22	1.0	-	2.8	6.3	37	22	2.5	6.8	7.0	●	-	
R/L007.0100-25	1.0	-	2.8	6.3	40	25	2.5	6.8	7.0	●	-	
R/L007.0100-30	1.0	-	2.8	6.3	45	30	2.5	6.8	7.0	●	-	
R/L007.0100-35	1.0	-	2.8	6.3	50	35	2.5	7.0	7.0	○	-	
R/L007.0100-40	1.0	-	2.8	6.3	55	40	2.5	7.0	7.0	○	-	
R/L007.0100-45	1.0	-	2.8	6.3	60	45	2.5	7.0	7.0	○	-	
R/L007.0100-50	1.0	-	2.8	6.3	65	50	2.5	7.0	7.0	●	-	

U.S.A. Stock

- = Both Right & Left Hand in Stock
- = Express Delivery
- ◐ = Left Hand in Stock
- ◑ = Right Hand in Stock

More carbide grades can be found in the grades summary in the section "technical instructions".

Order example:
Right hand version and grade CN45F:
R007.0100-10/CN45F

Type 007

ULTRAMINI

Grooving

Bore Ø from 6.8 mm
depth of groove up to 2.5 mm
overhang length (L1) up to 7x D

Grooving, boring and profiling
starting at Ø 0.2 mm



part number	b +0.05	b (inch)	f	d	a	L	L1	t max.	D min.	Ø h6	U.S.A. Stock		suitable toolholder type	
											●	○		
R/L007.0150-10	1.5	-	2.8	3.7	6.3	25	10	2.5	6.8	7.0	●		676.xxx / 687	670 / xxx.7
R/L007.0150-15	1.5	-	2.8	3.7	6.3	30	15	2.5	6.8	7.0	●			
R/L007.0150-22	1.5	-	2.8	3.7	6.3	37	22	2.5	6.8	7.0	●			
R/L007.0150-25	1.5	-	2.8	3.7	6.3	40	25	2.5	6.8	7.0	●			
R/L007.0150-30	1.5	-	2.8	3.7	6.3	45	30	2.5	6.8	7.0	●			
R/L007.0150-35	1.5	-	2.8	3.7	6.3	50	35	2.5	7.0	7.0	○			
R/L007.0150-40	1.5	-	2.8	3.7	6.3	55	40	2.5	7.0	7.0	●			
R/L007.0200-10	2.0	-	2.8	3.7	6.3	25	10	2.5	6.8	7.0	●			
R/L007.0200-15	2.0	-	2.8	3.7	6.3	30	15	2.5	6.8	7.0	●			
R/L007.0200-22	2.0	-	2.8	3.7	6.3	37	22	2.5	6.8	7.0	●			
R/L007.0200-25	2.0	-	2.8	3.7	6.3	40	25	2.5	6.8	7.0	●			
R/L007.0200-30	2.0	-	2.8	3.7	6.3	45	30	2.5	6.8	7.0	●			
R/L007.0200-35	2.0	-	2.8	3.7	6.3	50	35	2.5	7.0	7.0	●			



U.S.A. Stock

- = Both Right & Left Hand in Stock
- = Express Delivery
- ◐ = Left Hand in Stock
- ◑ = Right Hand in Stock

NEW

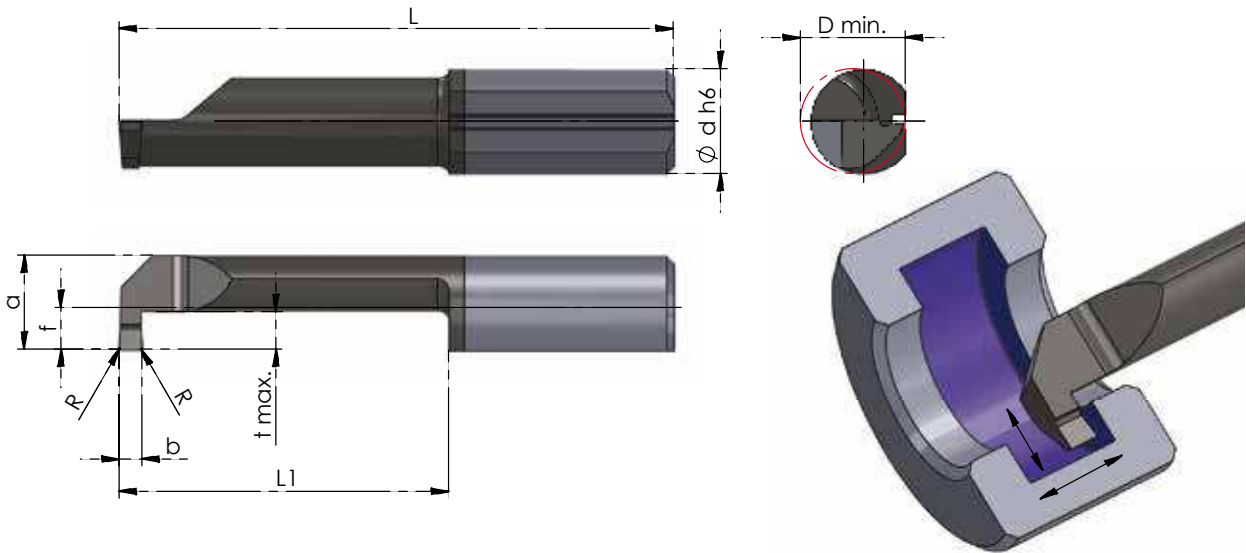
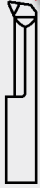
ULTRAMINI

Type 007 M

Grooving, boring, profiling, threading and chamfering starting at \varnothing 0.2 mm

Grooving with corner-radius

Bore \varnothing starting at 6.8 mm depth of groove t max. 2.5 mm



Right hand version shown

State right (R) or left (L) version

Dimensions in mm

part number	b +0.05	b (inch)	f	a	L	L1	t max.	D min.	$\varnothing d h6$	R	U.S.A. Stock AL41F	toolholder type
R/L007M0100-10	1.0	-	2.8	6.3	25	10	2.5	6.8	7	0.1	○	676.xxx / 687 670 / xxx.7
R/L007M0100-15	1.0	-	2.8	6.3	30	15	2.5	6.8	7	0.1	○	
R/L007M0100-22	1.0	-	2.8	6.3	37	22	2.5	6.8	7	0.1	○	
R/L007M0100-25	1.0	-	2.8	6.3	40	25	2.5	6.8	7	0.1	○	
R/L007M0100-30	1.0	-	2.8	6.3	45	30	2.5	6.8	7	0.1	○	
NEW R/L007M0117-10 INCH SIZE	1.17	0.046"	2.8	6.3	25	10	2.5	6.8	7	0.1	◐	
NEW R/L007M0117-22 INCH SIZE	1.17	0.046"	2.8	6.3	37	22	2.5	6.8	7	0.1	◐	
R/L007M0150-10	1.5	-	2.8	6.3	25	10	2.5	6.8	7	0.1	○	
R/L007M0150-15	1.5	-	2.8	6.3	30	15	2.5	6.8	7	0.1	○	
R/L007M0150-22	1.5	-	2.8	6.3	37	22	2.5	6.8	7	0.1	○	
R/L007M0150-25	1.5	-	2.8	6.3	40	25	2.5	6.8	7	0.1	○	
R/L007M0150-30	1.5	-	2.8	6.3	45	30	2.5	6.8	7	0.1	○	
NEW R/L007M0157-25 INCH SIZE	1.57	0.062"	2.8	6.3	40	25	2.5	6.8	7	0.1	◐	
R/L007M0200-10	2.0	-	2.8	6.3	25	10	2.5	6.8	7	0.1	○	
R/L007M0200-15	2.0	-	2.8	6.3	30	15	2.5	6.8	7	0.1	○	
R/L007M0200-22	2.0	-	2.8	6.3	37	22	2.5	6.8	7	0.1	○	
R/L007M0200-25	2.0	-	2.8	6.3	40	25	2.5	6.8	7	0.1	○	
R/L007M0200-30	2.0	-	2.8	6.3	45	30	2.5	6.8	7	0.1	○	

U.S.A. Stock

- = Both Right & Left Hand in Stock
- = Express Delivery
- ◐ = Left Hand in Stock
- ◑ = Right Hand in Stock

More carbide grades can be found in the grades summary in the section "technical instructions".

Order example:
Right hand version and grade AL41F:
R007M0100-10/AL41F

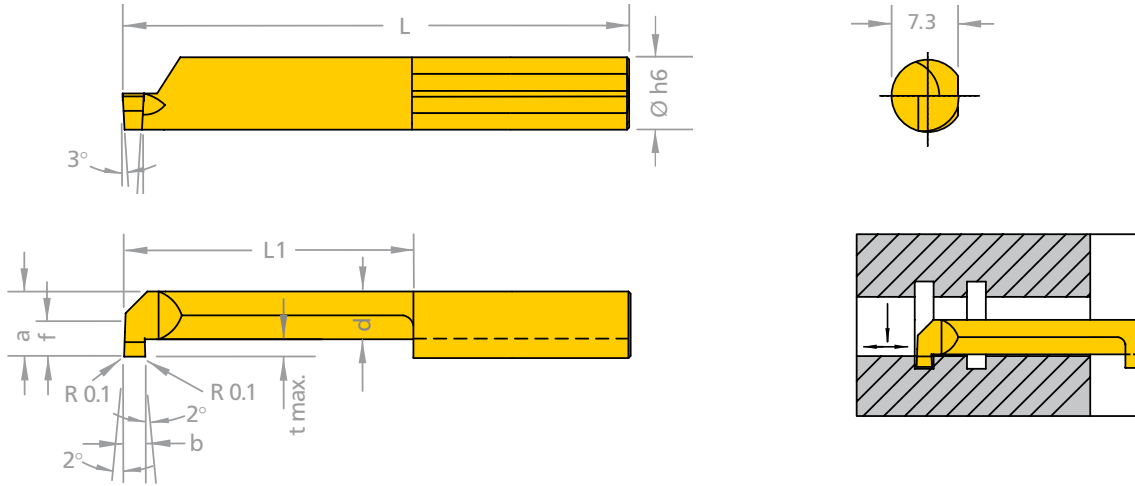
Type 008 M

ULTRAMINI

Grooving with corner-radius

Bore \varnothing from 7.8 mm
depth of groove up to 3.0 mm

Grooving, boring and profiling
starting at \varnothing 0.2 mm



Right hand version shown

State right (R) or left (L) version

Dimensions in mm



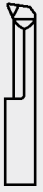
part number	U.S.A. Stock									suitable toolholder type		
	b +0.05	f	d	a	L	L1	t max.	D min.	Ø h6	AL41F		
R/L008M0100-30	1.0	3.3	4.2	7.3	50	30	3.0	7.8	8.0	○		
R/L008M0100-40	1.0	3.3	4.2	7.3	60	40	3.0	7.8	8.0	○		
R/L008M0200-30	2.0	3.3	4.2	7.3	50	30	3.0	7.8	8.0	◐	687	680
R/L008M0200-40	2.0	3.3	4.2	7.3	60	40	3.0	7.8	8.0	○		
R/L008M0250-30	2.5	3.3	4.2	7.3	50	30	3.0	7.8	8.0	○		
R/L008M0250-40	2.5	3.3	4.2	7.3	60	40	3.0	7.8	8.0	●		

U.S.A. Stock

- = Both Right & Left Hand in Stock
- = Express Delivery
- ◐ = Left Hand in Stock
- ◑ = Right Hand in Stock

Carbide grades p. 93 see grades summary

Order-example: right hand version
and grade
AL41F: R008M0100-30/AL41F



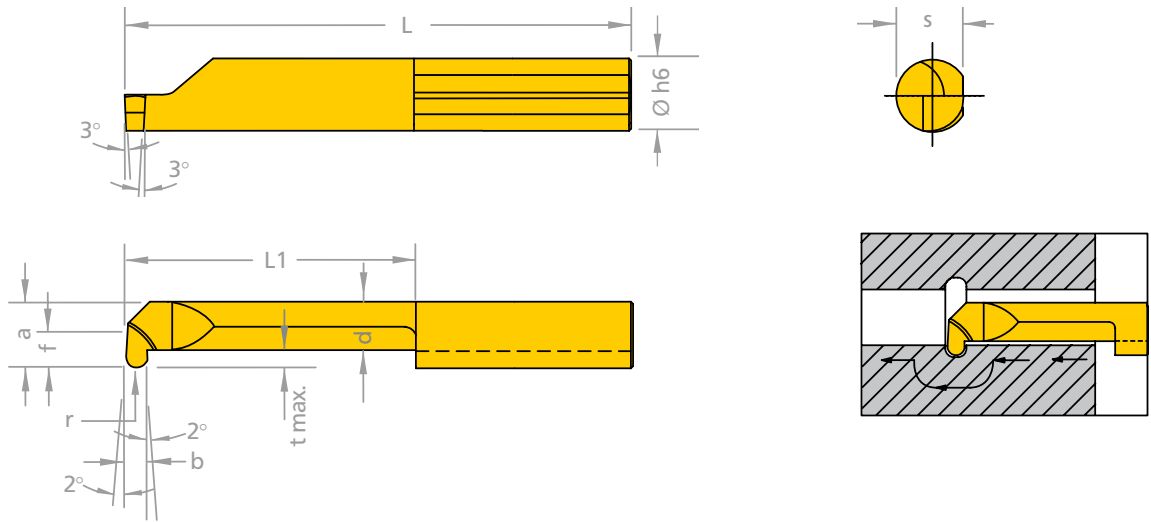
ULTRAMINI

Grooving, boring and profiling starting at Ø 0.2 mm

Type Full Radius

Type full radius grooving and copying

Bore Ø from 4.0 mm full radius 0.5-1.0 mm



Right hand version shown

State right (R) or left (L) version

Dimensions in mm



part number	s	b +0.05	r	f	d	a	L	L1	t max.	D min.	Ø h6	U.S.A. Stock		suitable toolholder type
												CN45F		
R/L004-0.50-16	3.5	1.0	0.5	1.5	2.4	3.5	30	16	0.8	4.0	4.0	●		xxx.4
R/L005-0.50-20	4.4	1.0	0.5	1.9	3.3	4.4	35	20	1.0	5.0	5.0	●	645.xxx	xxx.5
R/L005-0.75-20	4.4	1.5	0.75	1.9	3.3	4.4	35	20	1.0	5.0	5.0	●		
R/L005-1.00-20	4.4	2.0	1.0	1.9	3.3	4.4	35	20	1.0	5.0	5.0	●		
R/L006-0.50-25	5.3	1.0	0.5	2.3	3.4	5.3	40	25	1.8	6.0	6.0	●	676.xxx	660 / xxx.6
R/L006-0.75-25	5.3	1.5	0.75	2.3	3.4	5.3	40	25	1.8	6.0	6.0	●		
R/L006-1.00-25	5.3	2.0	1.0	2.3	3.4	5.3	40	25	1.8	6.0	6.0	●		
R/L007-0.50-30	6.3	1.0	0.5	2.8	3.7	6.3	45	30	2.5	6.8	7.0	●	687 / 670 / xxx.7	
R/L007-0.75-30	6.3	1.5	0.75	2.8	3.7	6.3	45	30	2.5	6.8	7.0	●		
R/L007-1.00-30	6.3	2.0	1.0	2.8	3.7	6.3	45	30	2.5	6.8	7.0	●		

U.S.A. Stock

- = Both Right & Left Hand in Stock
- = Express Delivery
- ◐ = Left Hand in Stock
- ◑ = Right Hand in Stock

Carbide grades p. 93 see grades summary

Order-example: right hand version and grade
CN45F: R004-0.50-16/CN45F

Impressions

ULTRAMINI

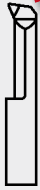
Grooving, boring and profiling
starting at \varnothing 0.2 mm



NEW

ULTRAMINI

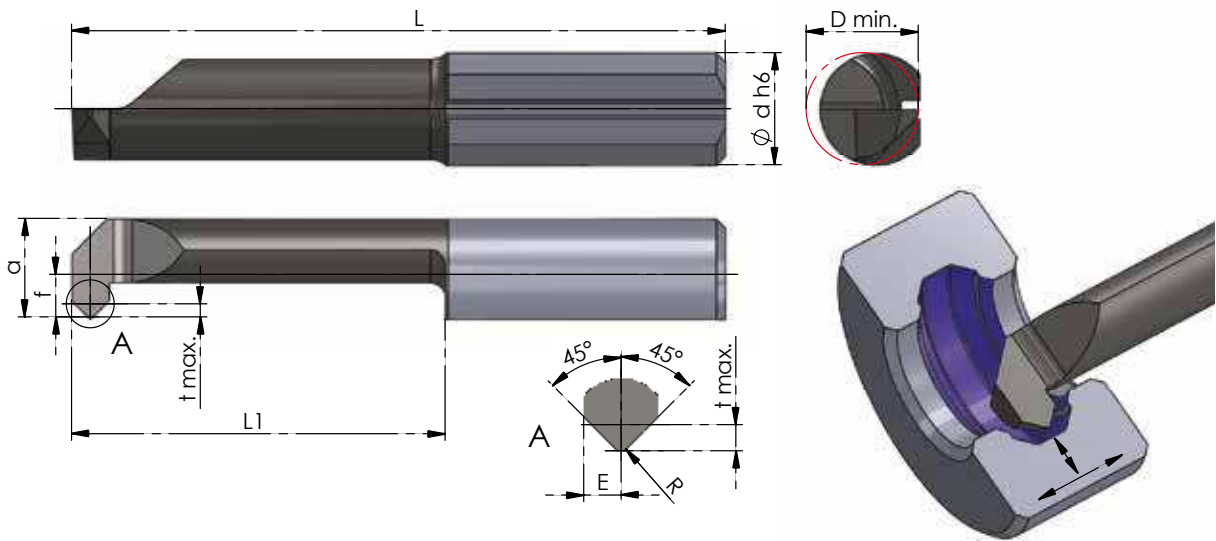
Type 060



Grooving, boring, profiling, threading and chamfering starting at \varnothing 0.2 mm

Profiling and chamfering

Bore \varnothing starting at 3 mm



Right hand version shown

State right (R) or left (L) version

Dimensions in mm

	part number							t max.	D min.	Ø d h6	U.S.A. Stock CN45F	tool holder type
		E	R	f	a	L	L1					
NEW	R/L060.3-10	1	0.2	0.7	2.7	24	10	0.4	3.0	4	○	645.xxx / xxx.4
NEW	R/L060.4-16	1	0.2	1.5	3.5	30	16	0.5	4.0	4	○	645.xxx / xxx.5
	R/L060.5-15	1	0.2	1.9	4.4	30	15	0.7	5.0	5	◐	645.xxx / xxx.5
	R/L060.5-20	1	0.2	1.9	4.4	35	20	0.7	5.0	5	◐	676.xxx / 660 xxx.6
	R/L060.6-20	1	0.2	2.3	5.3	35	20	0.7	6.0	6	○	676.xxx / 687 670 / xxx.7
	R/L060.6-25	1	0.2	2.3	5.3	40	25	0.7	6.0	6	○	
	R/L060.7-20	1	0.2	2.8	6.3	35	20	0.7	6.8	7	◐	
	R/L060.7-40	1	0.2	2.8	6.3	55	40	0.7	6.8	7	○	

U.S.A. Stock

- = Both Right & Left Hand in Stock
- = Express Delivery
- ◐ = Left Hand in Stock
- ◑ = Right Hand in Stock

More carbide grades can be found in the grades summary in the section "technical instructions".

Order example:
Right hand version and grade CN45F:
R060.5-15/CN45F

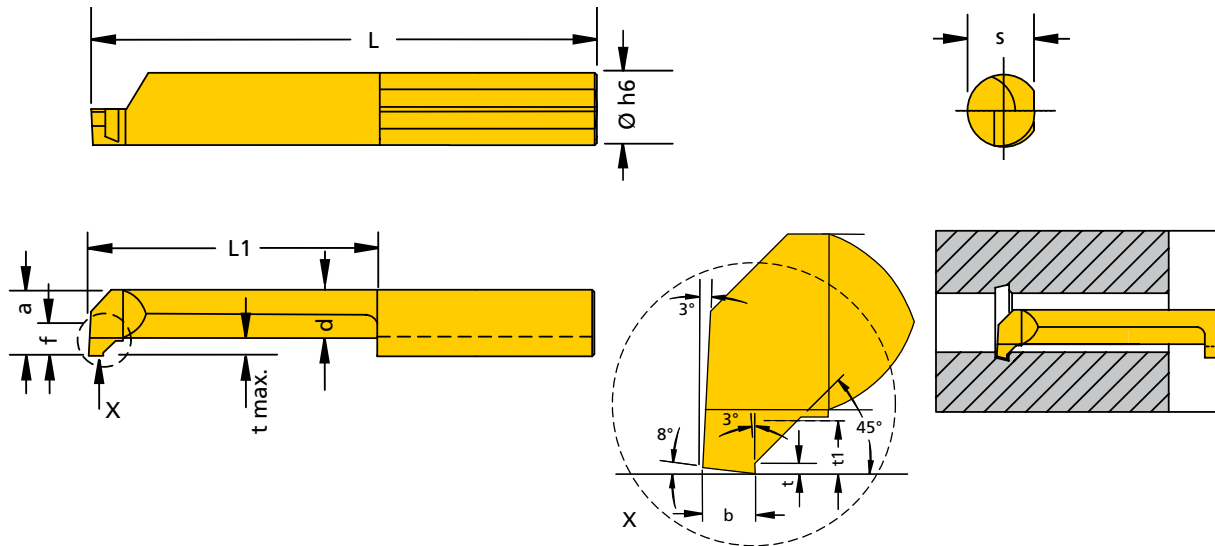
type 070

ULTRAMINI

Pregrooving and chamfering

Bore \varnothing from 4.0 mm

Grooving, boring and profiling starting at \varnothing 0.2 mm



View X enlarged
Right hand version shown
State right (R) or left (L) version
Dimensions in mm



part number	U.S.A. Stock												suitable toolholder type	
	s	b	f	d	a	L	L1	t	t max.	D min.	\varnothing h6	CN45F		
R/L070.4-10	3.5	1.0	1.5	2.4	3.5	25	10	0.2	0.8	4.0	4.0	○	xxx.4	
R/L070.4-16	3.5	1.0	1.5	2.4	3.5	30	16	0.2	0.8	4.0	4.0	○		
R/L070.5-15	4.4	1.0	1.9	3.3	4.4	30	15	0.2	1.0	5.0	5.0	●	xxx.5	
R/L070.5-20	4.4	1.0	1.9	3.3	4.4	35	20	0.2	1.0	5.0	5.0	●		
R/L070.5-30	4.4	1.0	1.9	3.3	4.4	45	30	0.2	1.0	5.0	5.0	○	xxx.6	
R/L070.6-30	5.3	1.0	2.3	4.2	5.3	45	30	0.2	1.0	6.0	6.0	●		
R/L070.6-42	5.3	1.0	2.3	4.2	5.3	57	42	0.2	1.0	6.0	6.0	●	660 / xxx.6	

U.S.A. Stock

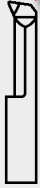
- = Both Right & Left Hand in Stock
- = Express Delivery
- ◐ = Left Hand in Stock
- ◑ = Right Hand in Stock

Carbide grades p. 93 see grades summary

Order-example: right hand version and grade
CN45F: R070.4-10/CN45F

NEW

ULTRAMINI

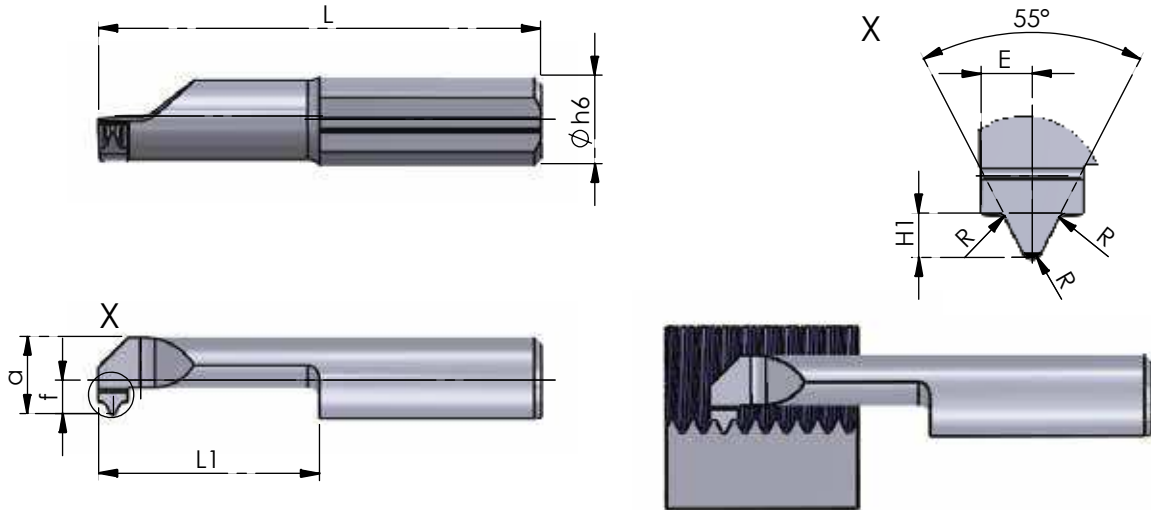


Grooving, boring, profiling, threading and chamfering starting at ϕ 0.2 mm

Type Threading

Whitworth full profile

Bore ϕ from 6.0 mm



View X: enlarged
Right hand version shown

State right (R) or left (L) version

Dimensions in mm

part number	P pitch	H1	Gg (INCH)	R	E	f	a	L	L1	ϕ h6	U.S.A. Stock AL41F	tool holder type
NEW R/L106.5519-15 INCH SIZE	1.336	0.86	19	0.18	1	2.3	5.3	30	15	6	○	676.xxx 660 xxx.6
NEW R/L106.5522-15 INCH SIZE	1.154	0.74	22	0.16	1	2.3	5.3	30	15	6	○	
NEW R/L106.5528-15 INCH SIZE	0.907	0.58	28	0.12	0.8	2.3	5.3	30	15	6	○	

U.S.A. Stock

- = Both Right & Left Hand in Stock
- = Express Delivery
- ◐ = Left Hand in Stock
- ◑ = Right Hand in Stock

More carbide grades can be found in the grades summary in the section "technical instructions".

Order example:
Right hand version and grade
R106.5519-15/AL41F

ULTRAMINI

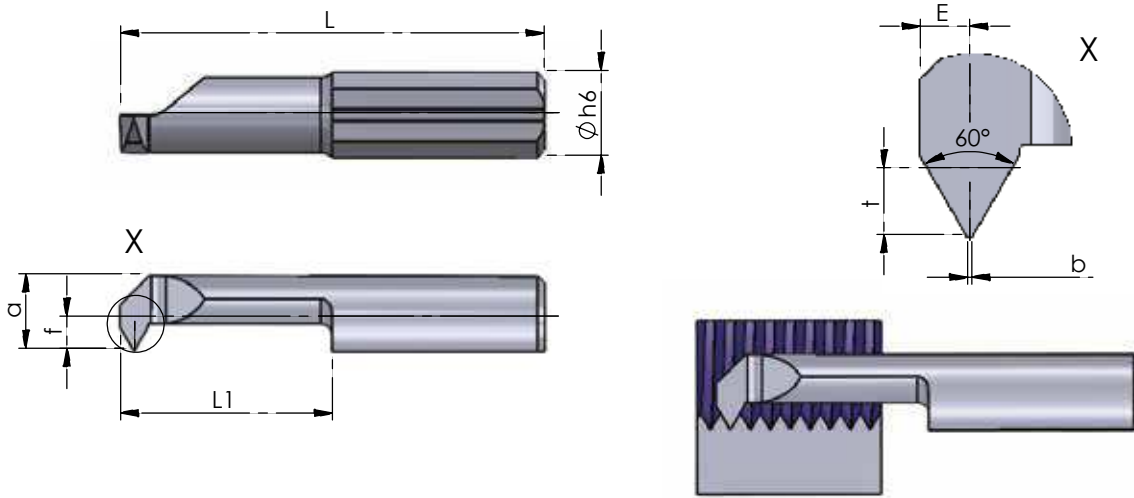
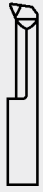
Grooving, boring, profiling, threading and chamfering starting at \varnothing 0.2 mm

Type Threading

NPT partial profile

Bore \varnothing from 6.0 mm

NEW



View X: enlarged
Right hand version shown

State right (R) or left (L) version

Dimensions in mm



	part number	P pitch	t	Gg (INCH)	b	E	f	a	L	L1	\varnothing h6	U.S.A. Stock	tool holder type
												AL41F	
NEW	R/L006.NP18-15 INCH SIZE	1.411	1.35	18	0.09	1	2.3	5.3	30	15	6	●	676.xxx 660 xxx.6
NEW	R/L006.NP18-22 INCH SIZE	1.411	1.35	18	0.09	1	2.3	5.3	37	22	6	●	
NEW	R/L006.NP27-15 INCH SIZE	0.940	1	27	0.06	0.8	2.3	5.3	30	15	6	●	
NEW	R/L006.NP27-22 INCH SIZE	0.940	1	27	0.06	0.8	2.3	5.3	37	22	6	●	

U.S.A. Stock

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- ◑ = Right Hand in Stock

More carbide grades can be found in the grades summary in the section "technical instructions".

Order example:
Right hand version and grade
R006.NP18-15/AL41-F



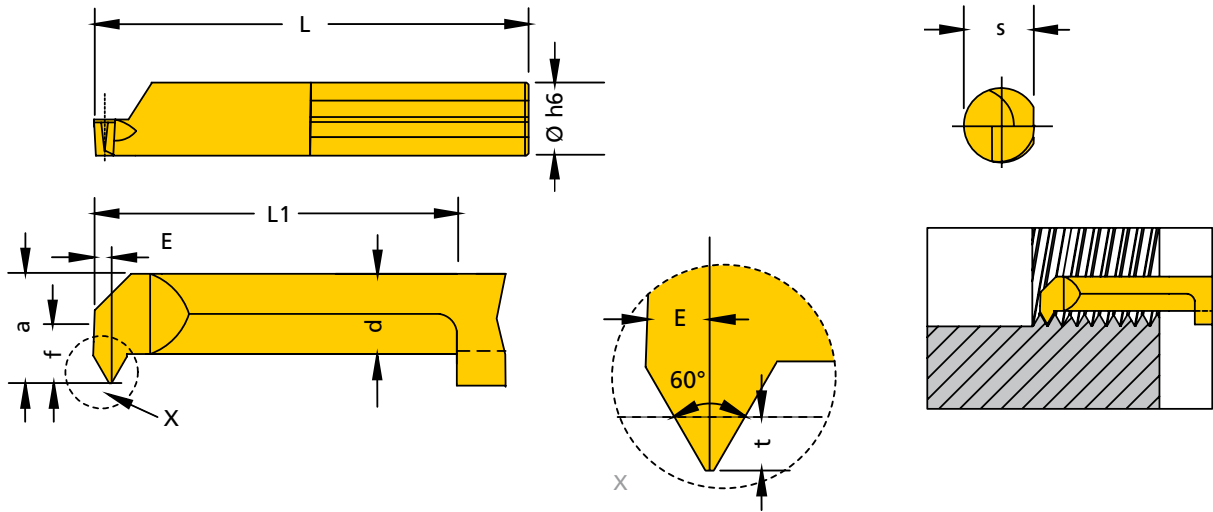
ULTRAMINI

Grooving, boring and profiling starting at $\varnothing 0.2$ mm

Type Metric ISO-Standard Thread

Metric ISO-standard thread partial profile internal 60°

Bore \varnothing from 2.4 mm pitch P = 0.5-1.5 mm



View X enlarged
Right hand version shown
state right (R) or left (L) version

Dimensions in mm



part number	pitch P	t	s	E	f	d	a	L	L1	D min.	$\varnothing h6$	U.S.A. Stock		suitable toolholder type	
												CN45F	AL41F		
R/L003.0105-8	0.5	0.27	3.5	0.33	0.3	1.8	2.3	22	8	2.4	4.0	—	●	645.xxx	xxx.4
R/L004.0408-15	0.8	0.43	3.5	0.45	1.75	2.4	3.5	30	15	4.0	4.0	—	○		xxx.5
R/L005.0510-15	1.0	0.55	4.4	0.55	1.9	3.3	4.4	30	15	4.8	5.0	●	●	676.xxx	660 / xxx.6
R/L005.0510-20	1.0	0.55	4.4	0.55	1.9	3.3	4.4	35	20	4.8	5.0	●	○		
R/L006.0612-15	1.25	0.68	5.3	0.65	2.3	3.4	5.3	30	15	6.0	6.0	●	○	676.xxx	660 / xxx.6
R/L006.0612-22	1.25	0.68	5.3	0.65	2.3	3.4	5.3	37	22	6.0	6.0	●	—		
R/L006.0815-15	1.5	0.81	5.3	0.75	2.3	3.4	5.3	30	15	6.0	6.0	●	○	676.xxx	660 / xxx.6
R/L006.0815-22	1.5	0.81	5.3	0.75	2.3	3.4	5.3	37	22	6.0	6.0	●	—		
R/L007.0815-15	1.5	0.81	6.3	0.75	2.7	3.8	6.3	30	15	7.0	7.0	●	●	687 / 670 / xxx.7	687 / 670 / xxx.7
R/L007.0815-25	1.5	0.81	6.3	0.75	2.7	3.8	6.3	40	25	7.0	7.0	●	○		

U.S.A. Stock

- = Both Right & Left Hand in Stock
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- ◑ = Right Hand in Stock

Carbide grades p. 93 see grades summary

Order-example: right hand version and grade
CN45F: R003.0105-8/CN45F

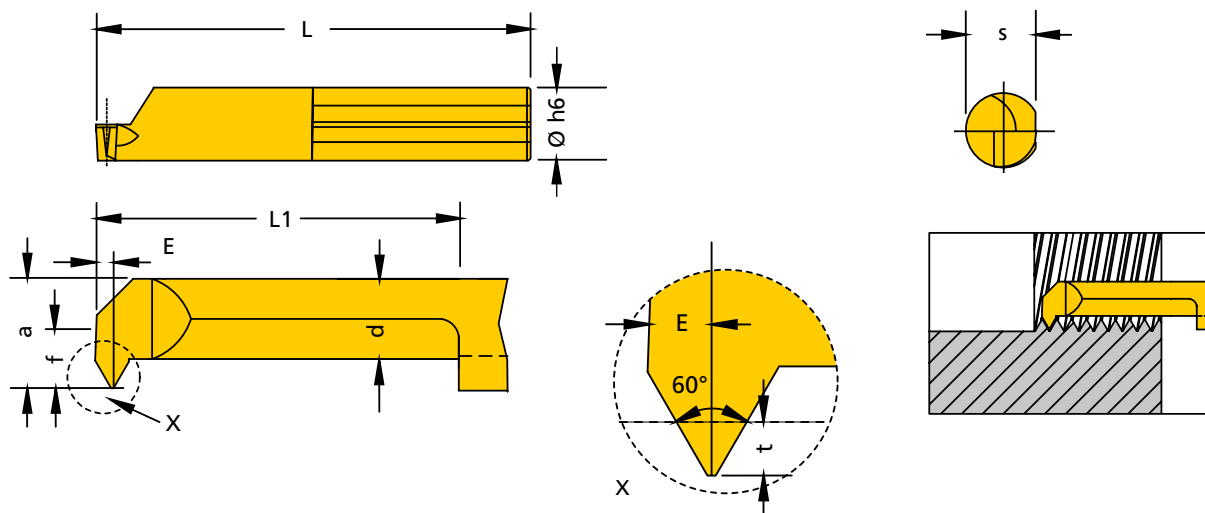
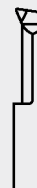
Type Metric ISO-Fine Thread

ULTRAMINI

Metric ISO-fine thread
partial profile internal 60°

Bore Ø from 3.2 mm
pitch P = 0.5-1.0 mm

Grooving, boring and profiling
starting at Ø 0.2 mm



View X enlarged
Right hand version shown
state right (R) or left (L) version
Dimensions in mm



part number	pitch P	t	s	E	f	d	a	L	L1	D min.	Ø h6	U.S.A. Stock		suitable toolholder type
												CN45F	AL41F	
R/L004.0105-10	0.5	0.27	3.5	0.44	1.0	2.3	3.0	24	10	3.2	4.0	—	●	xxx.4
R/L004.0205-15	0.5	0.27	3.5	0.35	1.5	2.4	3.5	30	15	4.0	4.0	●	○	
R/L005.0205-15	0.5	0.27	4.4	0.35	1.9	3.3	4.4	30	15	5.0	5.0	●	○	645.xxx
R/L005.0205-20	0.5	0.27	4.4	0.35	1.9	3.3	4.4	35	20	5.0	5.0	●	—	
R/L005.0407-15	0.75	0.40	4.4	0.45	1.9	3.3	4.4	30	15	5.0	5.0	●	○	xxx.5
R/L005.0407-20	0.75	0.40	4.4	0.45	1.9	3.3	4.4	35	20	5.0	5.0	●	—	
R/L006.0510-15	1.0	0.55	5.3	0.55	2.3	3.4	5.3	30	15	6.0	6.0	●	○	676.xxx
R/L006.0510-22	1.0	0.55	5.3	0.55	2.3	3.4	5.3	37	22	6.0	6.0	●	○	

U.S.A. Stock

- = Both Right & Left Hand in Stock
- = Express Delivery
- ◐ = Left Hand in Stock
- ◑ = Right Hand in Stock

Carbide grades p. 93 see grades summary

Order-example: right hand version
and grade
CN45F: R004.0105-10/CN45F



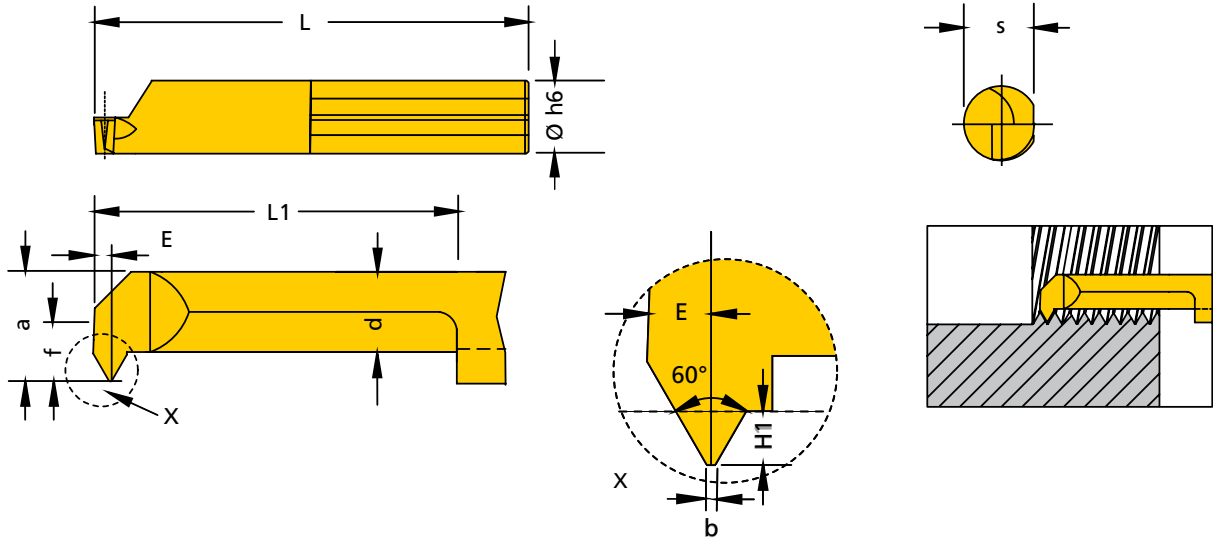
ULTRAMINI

Grooving, boring and profiling starting at Ø 0.2 mm

Type Metric ISO-Standard Thread

Metric ISO-standard thread full profile internal 60°

Bore Ø from 4.8 mm pitch P = 0.8 - 1.5 mm



View X enlarged
Right hand version shown
state right (R) or left (L) version
Dimensions in mm



part number	pitch P	U.S.A. Stock											suitable toolholder type		
		b	H1	s	E	f	d	a	L	L1	D min.	Ø h6		AL41F	
R/L105.0408-15	0.8	0.10	0.43	4.4	0.5	1.9	3.3	4.4	30	15	4.8	5.0	○	645.xxx / xxx.5	
R/L105.0510-15	1.0	0.12	0.54	4.4	0.55	1.9	3.3	4.4	30	15	4.8	5.0	●		
R/L106.0612-15	1.25	0.15	0.67	5.3	0.65	2.3	3.4	5.3	30	15	6.0	6.0	○	676.xxx	660 / xxx.6
R/L106.0815-15	1.5	0.18	0.81	5.3	0.75	2.3	3.4	5.3	30	15	6.0	6.0	●		
R/L107.0815-15	1.5	0.18	0.81	6.3	0.75	2.8	3.8	6.3	30	15	7.0	7.0	●	687	670 / xxx.7

U.S.A. Stock

- = Both Right & Left Hand in Stock
- = Express Delivery
- ◐ = Left Hand in Stock
- ◑ = Right Hand in Stock

Carbide grades p. 93 see grades summary

Order-example: right hand version
and grade
AL41F: R105.0408-15/AL41F

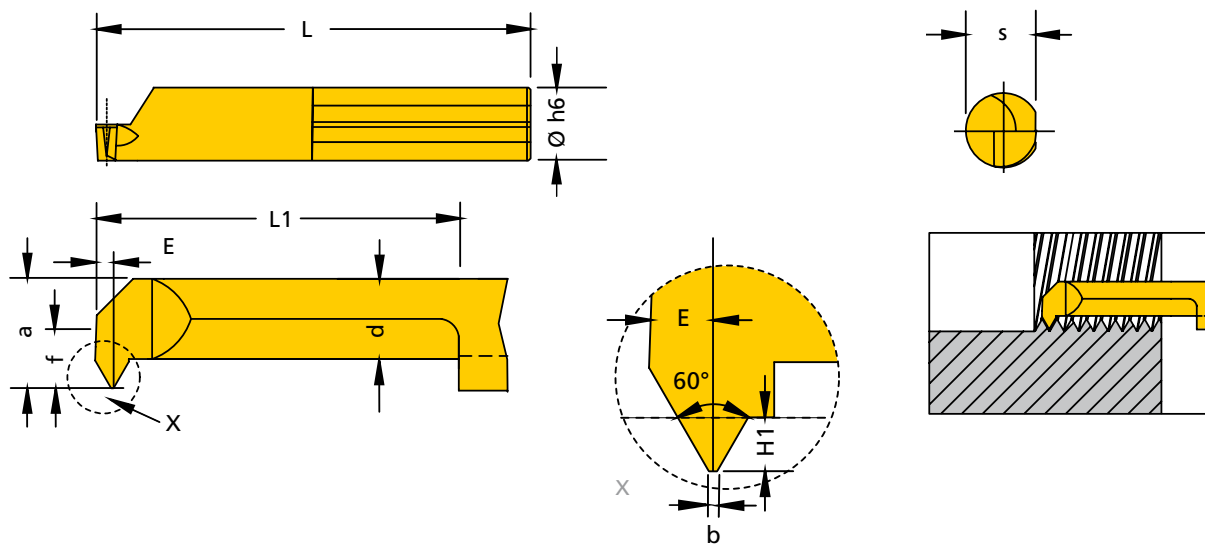
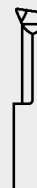
Type Metric ISO-Fine Thread

ULTRAMINI

Metric ISO-fine thread
full profile internal 60°

Bore Ø from 4.0 mm
pitch P = 0.5 - 1.0 mm

Grooving, boring and profiling
starting at Ø 0.2 mm



View X enlarged
Right hand version shown
state right (R) or left (L) version
Dimensions in mm



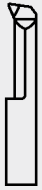
part number	pitch P	U.S.A. Stock										suitable toolholder type			
		b	H1	s	E	f	d	a	L	L1	D min.		Ø h6	AL41F	
R/L104.0205-15	0.5	0.06	0.27	3.5	0.35	1.5	2.4	3.5	30	15	4.0	4.0	●	645.xxx	xxx.4
R/L105.0205-15	0.5	0.06	0.27	4.4	0.35	1.9	3.3	4.4	30	15	5.0	5.0	●		xxx.5
R/L105.0407-15	0.75	0.09	0.40	4.4	0.45	1.9	3.3	4.4	30	15	5.0	5.0	●	676.xxx	660 / xxx.6
R/L106.0510-15	1.0	0.12	0.54	5.3	0.55	2.3	3.4	5.3	30	15	6.0	6.0	●		

U.S.A. Stock

- = Both Right & Left Hand in Stock
- = Express Delivery
- ◐ = Left Hand in Stock
- ◑ = Right Hand in Stock

Carbide grades p. 93 see grades summary

Order-example: right hand version
and grade
AL41F: R104.0205-15/AL41F



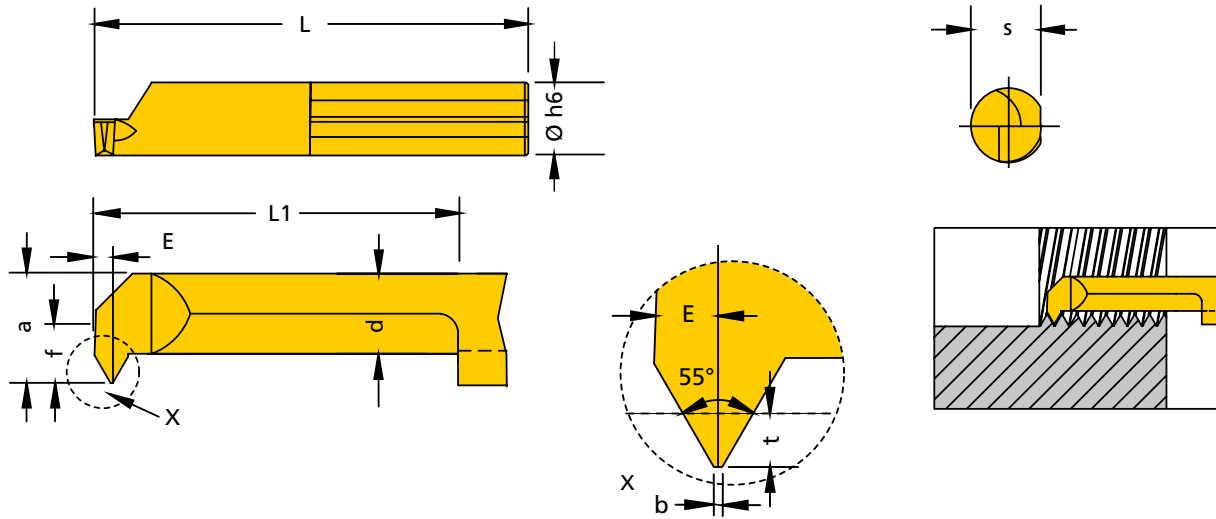
ULTRAMINI

Grooving, boring and profiling starting at Ø 0.2 mm

Type Metric ISO-Whitworth Thread

Metric ISO-whitworth thread partial profile internal 55°

Bore Ø from 4.8 mm



View X enlarged
Right hand version shown
State right (R) or left (L) version
Dimensions in mm



part number	TPI*	t	s	b	E	f	d	a	L	L1	D min.	Ø h6	U.S.A. Stock		suitable toolholder type	
													CN45F			
R/L005.5548-15	48-24	0.40	4.4	0.06	0.45	1.9	3.3	4.4	30	15	4.8	5.0	●		645.xxx	xxx.5
R/L006.5548-15	48-24	0.40	5.3	0.06	0.45	2.3	3.4	5.3	30	15	6.0	6.0	●		676.xxx	660 /xxx.6
R/L006.5524-15	24-16	0.81	5.3	0.12	0.75	2.3	3.4	5.3	30	15	6.0	6.0	●			
R/L007.5524-15	24-16	0.81	6.3	0.12	0.75	2.8	3.8	6.3	30	15	7.0	7.0	●			670 /xxx.7

*: TPI = threads per inch

U.S.A. Stock

- = Both Right & Left Hand in Stock
- = Express Delivery
- ◐ = Left Hand in Stock
- ◑ = Right Hand in Stock

Carbide grades p. 93 see grades summary

Order-example: right hand version and grade
CN45F: R005.5548-15/CN45F

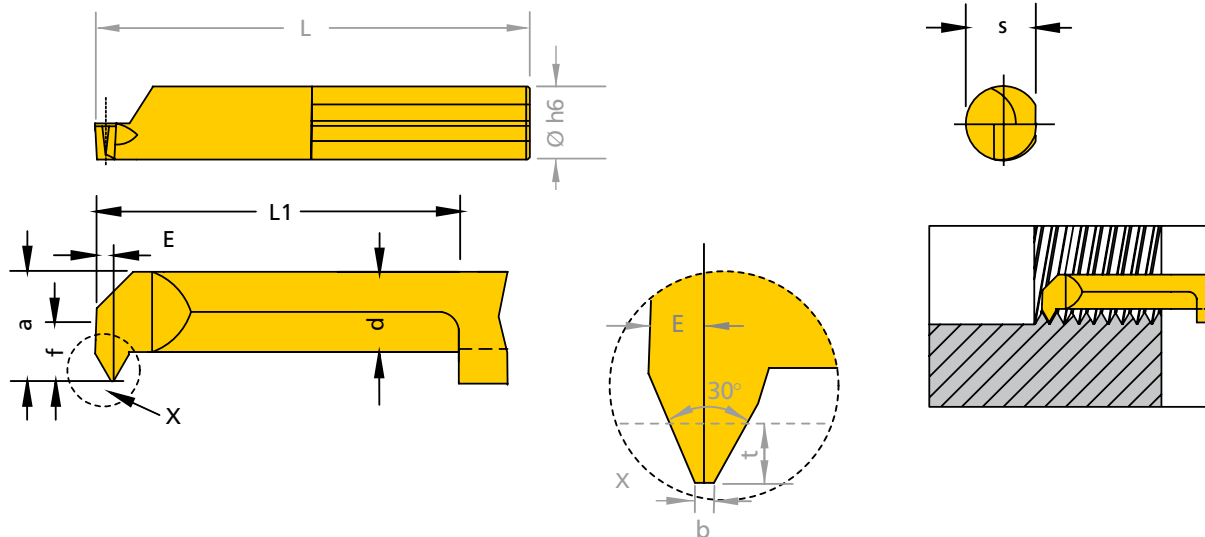
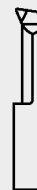
Type Trapezoidal Thread

ULTRAMINI

Trapezoidal thread
partial profile internal 30°

Bore Ø from 7.0 mm
pitch P = 2.0 - 3.0 mm

Grooving, boring and profiling
starting at Ø 0.2 mm



View X enlarged
Right hand version shown
State right (R) or left (L) version

Dimensions in mm



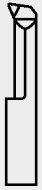
part number	pitch P	b	t	s	E	f	d	a	L	L1	D min.	Ø h6	U.S.A. Stock		suitable toolholder type	
													AL41F			
R/L007.1220-22	2.0	0.6	1.25	6.3	0.75	2.8	3.8	6.3	37	22	7.0	7.0	○		676.xxx / 687	670 / xxx.7
R/L007.1220-30	2.0	0.6	1.25	6.3	0.75	2.8	3.8	6.3	45	30	7.0	7.0	○			
R/L007.1730-22	3.0	1.0	1.75	6.3	1.1	2.8	3.8	6.3	37	22	7.0	7.0	○		676.xxx / 687	670 / xxx.7
R/L007.1730-30	3.0	1.0	1.75	6.3	1.1	2.8	3.8	6.3	45	30	7.0	7.0	●			

U.S.A. Stock

- = Both Right & Left Hand in Stock
- = Express Delivery
- ◐ = Left Hand in Stock
- ◑ = Right Hand in Stock

Carbide grades p. 93 see grades summary

Order-example: right hand version
and grade
AL41F: R007.xxxx-20/AL41F



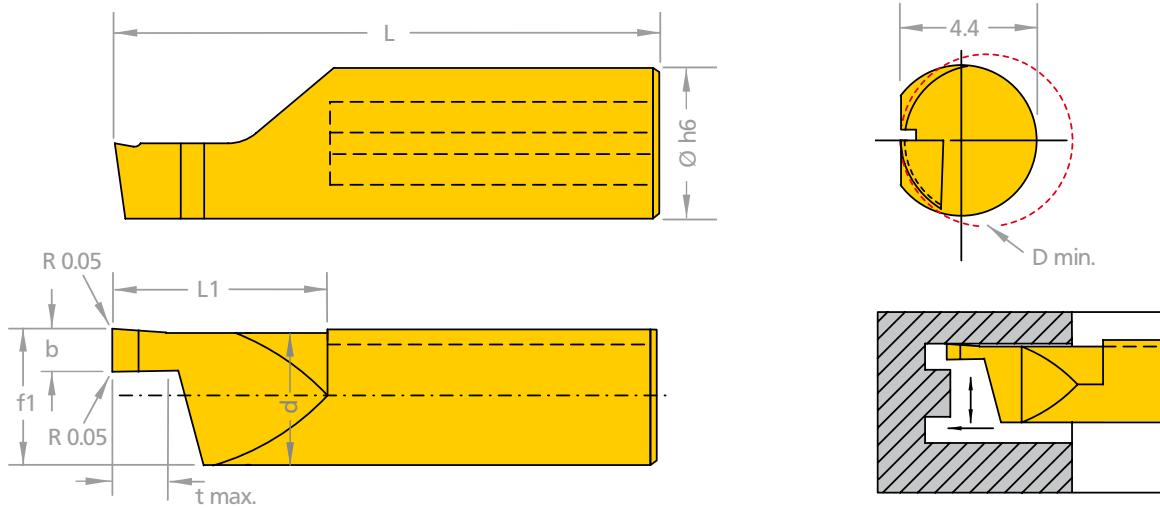
ULTRAMINI

Type 510 M

Grooving, boring and profiling starting at $\varnothing 0.2$ mm

Face grooving internal with corner-radius

From outer groove $\varnothing 5.0$ mm
depth of groove up to 4.0 mm
width of groove up to 2.0 mm



Left hand version shown

State right (R) or left (L) version

Dimensions in mm



part number	U.S.A. Stock									suitable toolholder type
	b +0.05	f1	d	L	L1	t max.	D min.	Ø h6	AL41F	
R/L510M1008-10	1.0	4.3	4.0	26	11	2.0	5.0	5.0	○	645.xxx / xxx.5
R/L510M1508-10	1.5	4.3	4.0	26	11	3.0	5.0	5.0	○	
R/L510M2008-10	2.0	4.3	4.0	26	11	4.0	5.0	5.0	○	
R/L510M1008-20	1.0	4.3	4.0	35	20	2.0	5.0	5.0	○	
R/L510M1508-20	1.5	4.3	4.0	35	20	3.0	5.0	5.0	○	
R/L510M2008-20	2.0	4.3	4.0	35	20	4.0	5.0	5.0	○	

U.S.A. Stock

- = Both Right & Left Hand in Stock
- = Express Delivery
- ◐ = Left Hand in Stock
- ◑ = Right Hand in Stock

Carbide grades p. 93 see grades summary

Order-example: right hand version and grade
AL41F: R510M1008-10/AL41F

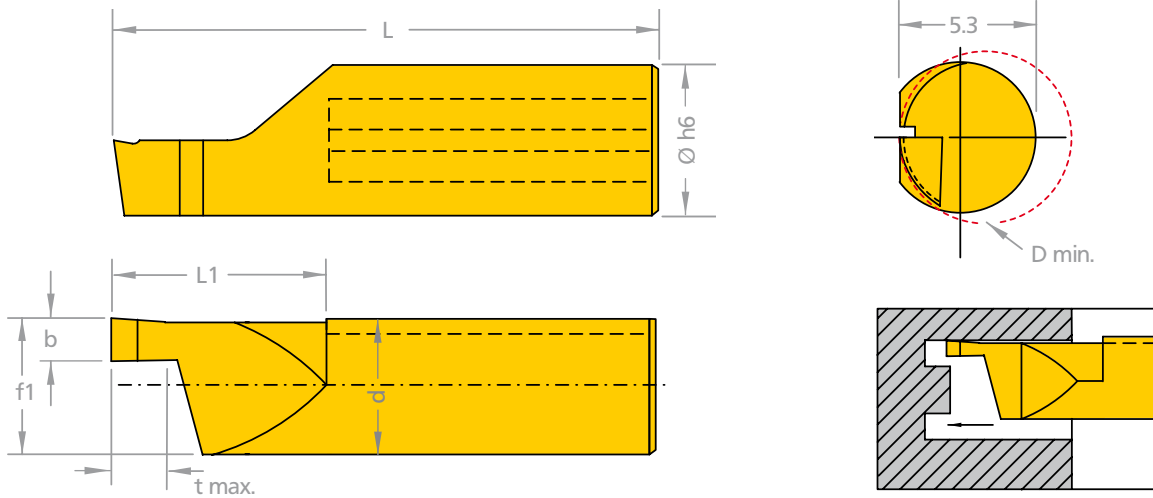
Type 610

ULTRAMINI

Face grooving internal

From outer groove \varnothing 6.0 mm
 Depth of groove up to 3.5 mm
 Width of groove up to 3.0 mm

Grooving, boring and profiling
 starting at \varnothing 0.2 mm



Left hand version shown
 State right (R) or left (L) version
 Dimensions in mm



part number	U.S.A. Stock								suitable toolholder type			
	b +0.05	f1	d	L	L1	t max.	D min.	$\varnothing h6$			CN45F	AL41F
R/L610.1008-10	1.0	5.2	4.9	26	11	1.5	6.0	6.0	○	○	676.xxx / xxx.6	660
R/L610.1508-10	1.5	5.2	4.9	26	11	2.5	6.0	6.0	○	○		
R/L610.2008-10	2.0	5.2	4.9	26	11	3.0	6.0	6.0	○	○		
R/L610.2508-10	2.5	5.2	4.9	26	11	3.5	6.0	6.0	○	○		
R/L610.3008-10	3.0	5.2	4.9	26	11	3.5	6.0	6.0	○	○		
R/L610.1008-20	1.0	5.2	4.9	35	20	1.5	6.0	6.0	○	○	676.xxx / xxx.6	660
R/L610.1508-20	1.5	5.2	4.9	35	20	2.5	6.0	6.0	○	○		
R/L610.2008-20	2.0	5.2	4.9	35	20	3.0	6.0	6.0	○	○		
R/L610.2508-20	2.5	5.2	4.9	35	20	3.5	6.0	6.0	○	○		
R/L610.3008-20	3.0	5.2	4.9	35	20	3.5	6.0	6.0	○	○		
R/L610.1008-30	1.0	5.2	4.9	45	30	1.5	6.0	6.0	○	○	676.xxx / xxx.6	660
R/L610.1508-30	1.5	5.2	4.9	45	30	2.5	6.0	6.0	○	○		
R/L610.2008-30	2.0	5.2	4.9	45	30	3.0	6.0	6.0	○	○		
R/L610.2508-30	2.5	5.2	4.9	45	30	3.5	6.0	6.0	○	○		
R/L610.3008-30	3.0	5.2	4.9	45	30	3.5	6.0	6.0	○	●		

U.S.A. Stock

- = Both Right & Left Hand in Stock
- = Express Delivery
- ◐ = Left Hand in Stock
- ◑ = Right Hand in Stock

Carbide grades p. 93 see grades summary

Order-example: right hand version
 and grade
 CN45F: R610.1008-10/CN45F



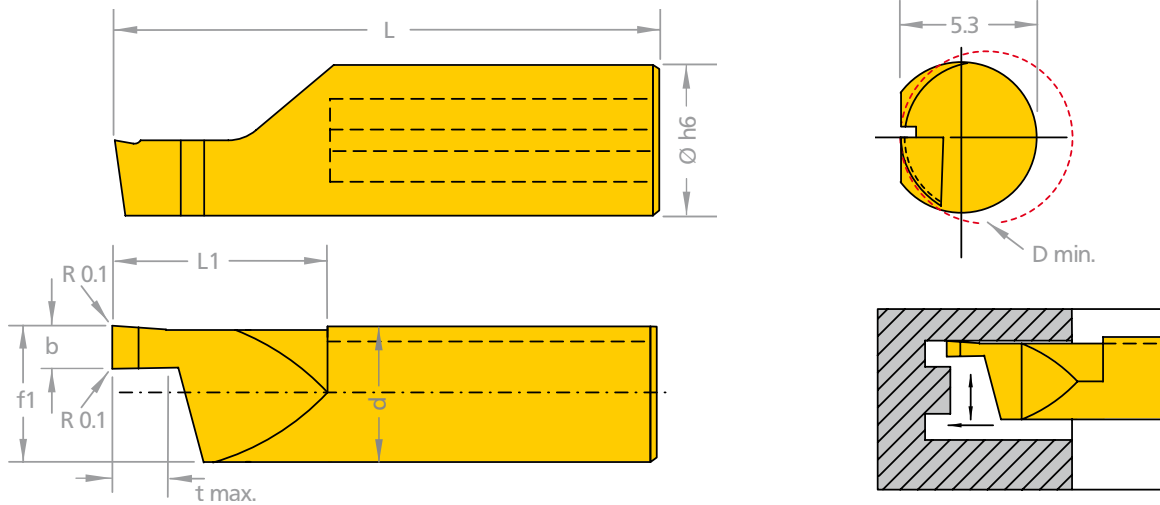
ULTRAMINI

Type 610 M

Grooving, boring and profiling starting at $\varnothing 0.2$ mm

Face grooving internal with corner-radius

From outer groove $\varnothing 6.0$ mm
Depth of groove up to 6.0 mm
Width of groove up to 3.0 mm



Left hand version shown

State right (R) or left (L) version

Dimensions in mm



part number	U.S.A. Stock									suitable toolholder type		
	b +0.05	f1	d	L	L1	t max.	D min.	Ø h6	AL41F			
R/L610M1008-10	1.0	5.2	4.9	26	11	2.0	6.0	6.0	○		676.xxx / xxx.6	660
R/L610M1508-10	1.5	5.2	4.9	26	11	3.0	6.0	6.0	○			
R/L610M2008-10	2.0	5.2	4.9	26	11	4.0	6.0	6.0	○			
R/L610M2508-10	2.5	5.2	4.9	26	11	5.0	6.0	6.0	○			
R/L610M3008-10	3.0	5.2	4.9	26	11	6.0	6.0	6.0	○			
R/L610M1008-20	1.0	5.2	4.9	35	20	2.0	6.0	6.0	○		676.xxx / xxx.6	660
R/L610M1508-20	1.5	5.2	4.9	35	20	3.0	6.0	6.0	○			
R/L610M2008-20	2.0	5.2	4.9	35	20	4.0	6.0	6.0	○			
R/L610M2508-20	2.5	5.2	4.9	35	20	5.0	6.0	6.0	○			
R/L610M3008-20	3.0	5.2	4.9	35	20	6.0	6.0	6.0	○			
R/L610M1008-30	1.0	5.2	4.9	45	30	2.0	6.0	6.0	○		676.xxx / xxx.6	660
R/L610M1508-30	1.5	5.2	4.9	45	30	3.0	6.0	6.0	○			
R/L610M2008-30	2.0	5.2	4.9	45	30	4.0	6.0	6.0	○			
R/L610M2508-30	2.5	5.2	4.9	45	30	5.0	6.0	6.0	○			
R/L610M3008-30	3.0	5.2	4.9	45	30	6.0	6.0	6.0	○			

U.S.A. Stock

- = Both Right & Left Hand in Stock
- = Express Delivery
- ◐ = Left Hand in Stock
- ◑ = Right Hand in Stock

Carbide grades p. 93 see grades summary

Order-example: right hand version and grade
AL41F: R610M1008-10/AL41F

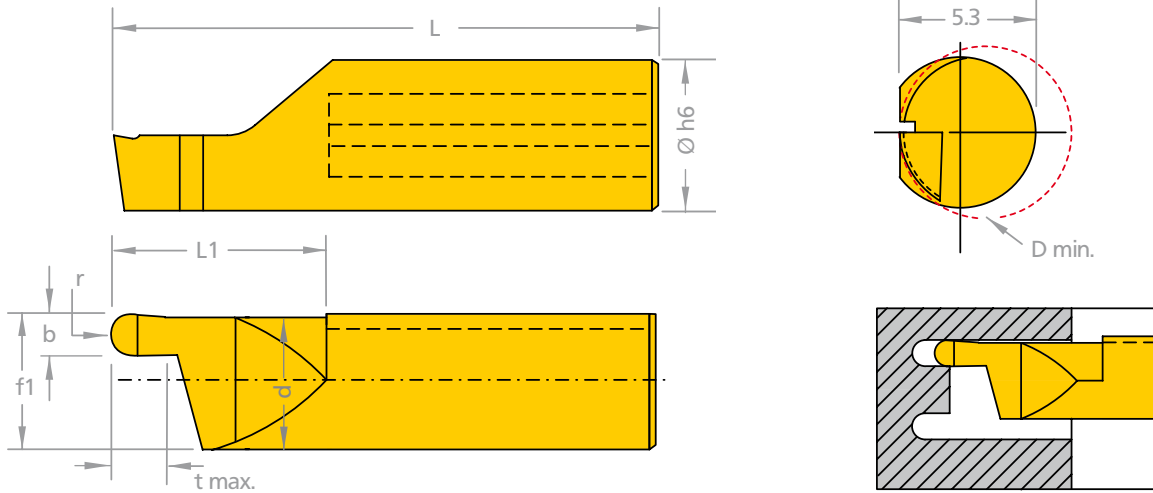
Type 610

ULTRAMINI

Full Radius
Face grooving internal

From outer groove \varnothing 6.0 mm
Depth of groove up to 6.0 mm
Width of groove up to 3.0 mm

Grooving, boring and profiling
starting at \varnothing 0.2 mm



Left hand version shown
State right (R) or left (L) version
Dimensions in mm



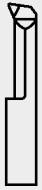
part number	U.S.A. Stock									suitable toolholder type		
	b +0.05	f1	r	d	L	L1	t max.	D min.	\varnothing h6	AL41F		
R/L610.1005-10	1.0	5.2	0.5	4.9	26	11	2.0	6.0	6.0	●	676.xxx / xxx.6	660
R/L610.1608-10	1.6	5.2	0.8	4.9	26	11	3.0	6.0	6.0	●		
R/L610.2010-10	2.0	5.2	1.0	4.9	26	11	4.0	6.0	6.0	●		
R/L610.2512-10	2.5	5.2	1.25	4.9	26	11	5.0	6.0	6.0	○		
R/L610.3015-10	3.0	5.2	1.5	4.9	26	11	6.0	6.0	6.0	○		
R/L610.1005-20	1.0	5.2	0.5	4.9	35	20	2.0	6.0	6.0	○		
R/L610.1608-20	1.6	5.2	0.8	4.9	35	20	3.0	6.0	6.0	○		
R/L610.2010-20	2.0	5.2	1.0	4.9	35	20	4.0	6.0	6.0	○		
R/L610.2512-20	2.5	5.2	1.25	4.9	35	20	5.0	6.0	6.0	○		
R/L610.3015-20	3.0	5.2	1.5	4.9	35	20	6.0	6.0	6.0	○		

U.S.A. Stock

- = Both Right & Left Hand in Stock
- = Express Delivery
- ◐ = Left Hand in Stock
- ◑ = Right Hand in Stock

Carbide grades p. 93 see grades summary

Order-example: right hand version
and grade
AL41F: R610.1005-10/AL41F



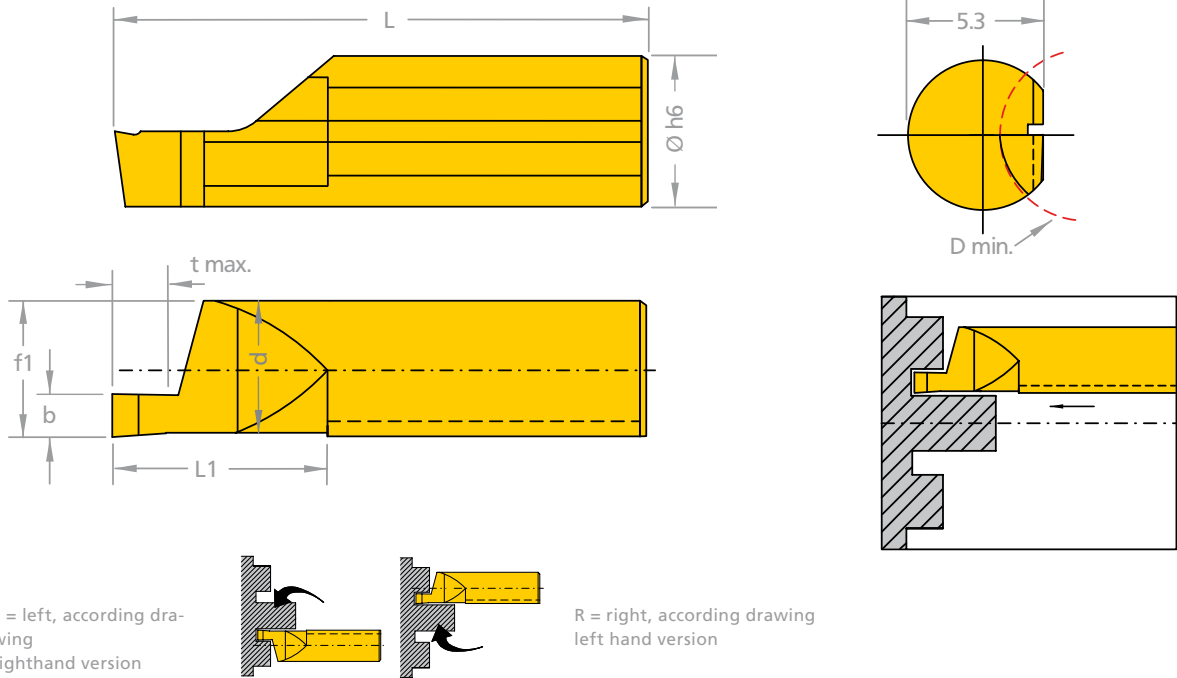
ULTRAMINI

Type 620

Grooving, boring and profiling starting at $\varnothing 0.2$ mm

Face grooving Internal
Axial grooving past the pin with corner radius

From outer groove $\varnothing 6.0$ mm
Depth of groove up to 6.0 mm
Width of groove up to 3.0 mm



L = left, according drawing
righthand version

R = right, according drawing
left hand version

Left hand version shown
State right (R) or left (L) version
Dimensions in mm



part number	U.S.A. Stock								AL41F	suitable toolholder type	
	b +0.05	f1	d	L	L1	t max.	D min.	Ø h6			
R/L620.1006-20	1.0	5.2	4.9	35	20	2.0	6.0	6.0	●	676.xxx / xxx.6	660
R/L620.1506-20	1.5	5.2	4.9	35	20	3.0	6.0	6.0	●		
R/L620.2006-20	2.0	5.2	4.9	35	20	4.0	6.0	6.0	●		
R/L620.2506-20	2.5	5.2	4.9	35	20	5.0	6.0	6.0	●		
R/L620.3006-20	3.0	5.2	4.9	35	20	6.0	6.0	6.0	●		

U.S.A. Stock

- = Both Right & Left Hand in Stock
- = Express Delivery
- ◐ = Left Hand in Stock
- ◑ = Right Hand in Stock

Carbide grades p. 93 see grades summary

Order-example: right hand version
and grade
AL41F: R620.1006-20/AL41F

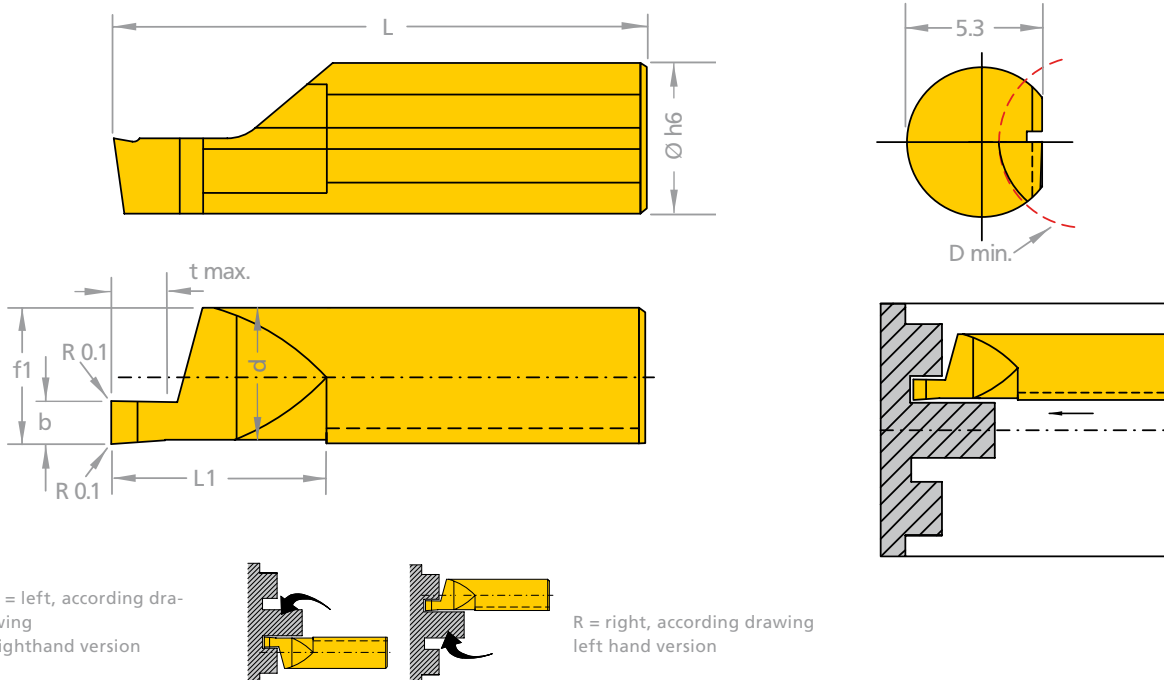
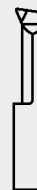
Type 620 M

ULTRAMINI

Face grooving internal
Axial grooving past the pin with corner radius

From outer groove \varnothing 6.0 mm
Depth of groove up to 6.0 mm
Width of groove up to 3.0 mm

Grooving, boring and profiling
starting at \varnothing 0.2 mm



Left hand version shown
State right (R) or left (L) version
Dimensions in mm



part number	U.S.A. Stock									suitable toolholder type	
	b +0.05	f1	d	L	L1	t max.	D min.	\varnothing h6	AL41F		
R/L620M1006-20	1.0	5.2	4.9	35	20	2.0	6.0	6.0	○		
R/L620M1506-20	1.5	5.2	4.9	35	20	3.0	6.0	6.0	○		
R/L620M2006-20	2.0	5.2	4.9	35	20	4.0	6.0	6.0	○		
R/L620M2506-20	2.5	5.2	4.9	35	20	5.0	6.0	6.0	○		
R/L620M3006-20	3.0	5.2	4.9	35	20	6.0	6.0	6.0	○		

676.xxx /
xxx.6

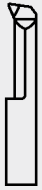
660

U.S.A. Stock

- = Both Right & Left Hand in Stock
- = Express Delivery
- ◐ = Left Hand in Stock
- ◑ = Right Hand in Stock

Carbide grades p. 93 see grades summary

Order-example: right hand version
and grade
AL41F: R620M1006-20/AL41F



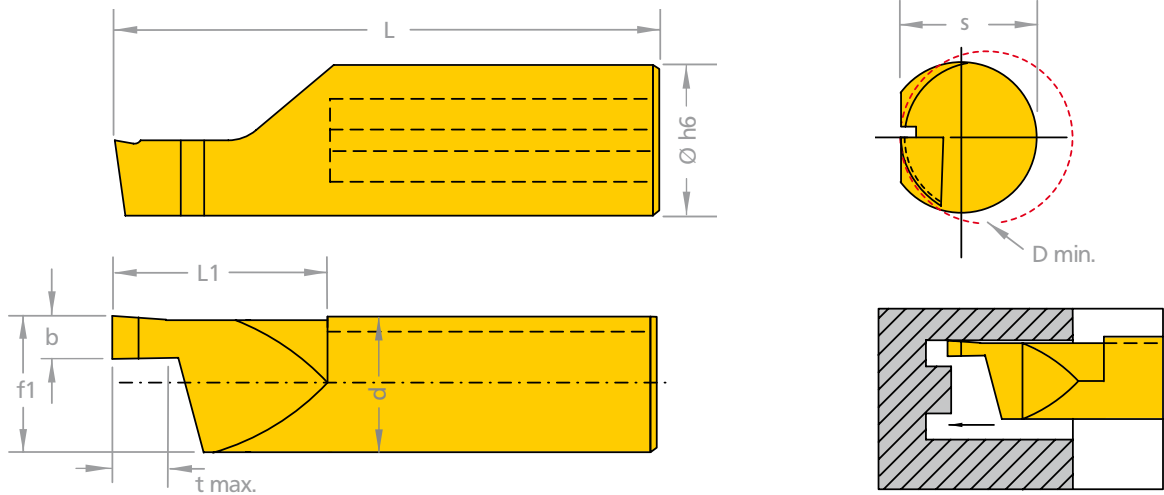
ULTRAMINI

Grooving, boring and profiling starting at $\varnothing 0.2$ mm

Type 010

Face grooving internal

From outer groove $\varnothing 6.0$ mm
Depth of groove up to 3.5 mm
Width of groove up to 3.0 mm



Left hand version shown

State right (R) or left (L) version

Dimensions in mm



part number	U.S.A. Stock									suitable toolholder type			
	s	b +0.05	f1	d	L	L1	t max.	D min.	Ø h6	CN45F	AL41F		
R/L010.1006-10	5.3	1.0	5.2	4.9	26	11	1.5	6.0	6.0	●	●		
R/L010.1506-10	5.3	1.5	5.2	4.9	26	11	2.0	6.0	6.0	●	●	660 / xxx.6	
R/L010.1008-10	6.3	1.0	5.9	5.6	26	11	1.5	8.0	7.0	●	●		
R/L010.1508-10	6.3	1.5	5.9	5.6	26	11	2.5	8.0	7.0	●	●		
R/L010.2008-10	6.3	2.0	5.9	5.6	26	11	3.0	8.0	7.0	●	●		
R/L010.2508-10	6.3	2.5	5.9	5.6	26	11	3.5	8.0	7.0	●	●		
R/L010.3008-10	6.3	3.0	5.9	5.6	26	11	3.5	8.0	7.0	●	●		
R/L010.1008-20	6.3	1.0	5.9	5.6	35	20	1.5	8.0	7.0	○	●		
R/L010.1508-20	6.3	1.5	5.9	5.6	35	20	2.5	8.0	7.0	○	●		
R/L010.2008-20	6.3	2.0	5.9	5.6	35	20	3.0	8.0	7.0	●	●		
R/L010.2508-20	6.3	2.5	5.9	5.6	35	20	3.5	8.0	7.0	●	●		
R/L010.3008-20	6.3	3.0	5.9	5.6	35	20	3.5	8.0	7.0	●	●		

U.S.A. Stock

- = Both Right & Left Hand in Stock
- = Express Delivery
- ◐ = Left Hand in Stock
- ◑ = Right Hand in Stock

Carbide grades p. 93 see grades summary

Order-example: right hand version and grade
CN45F: R010.1008-10/CN45F

Type 010

ULTRAMINI

Face grooving internal

From outer groove Ø 6.0 mm
 Depth of groove up to 3.5 mm
 Width of groove up to 3.0 mm

Grooving, boring and profiling
 starting at Ø 0.2 mm



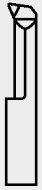
part number	s	b +0.05	f1	d	L	L1	t max.	D min.	Ø h6	U.S.A. Stock		suitable toolholder type	
										CN45F	AL41F		
R/L010.1008-30	6.3	1.0	5.9	5.6	45	30	1.5	8.0	7.0	●	○		
R/L010.1508-30	6.3	1.5	5.9	5.6	45	30	2.5	8.0	7.0	○	●		
R/L010.2008-30	6.3	2.0	5.9	5.6	45	30	3.0	8.0	7.0	●	○	676.xxx /	670 /
R/L010.2508-30	6.3	2.5	5.9	5.6	45	30	3.5	8.0	7.0	○	○	687	xxx.7
R/L010.3008-30	6.3	3.0	5.9	5.6	45	30	3.5	8.0	7.0	●	○		



Dümmel®

U.S.A. Stock

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- = Express Delivery
- ◐ = Left Hand in Stock
- ◑ = Right Hand in Stock



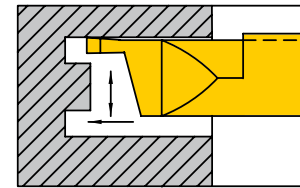
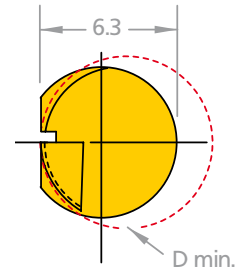
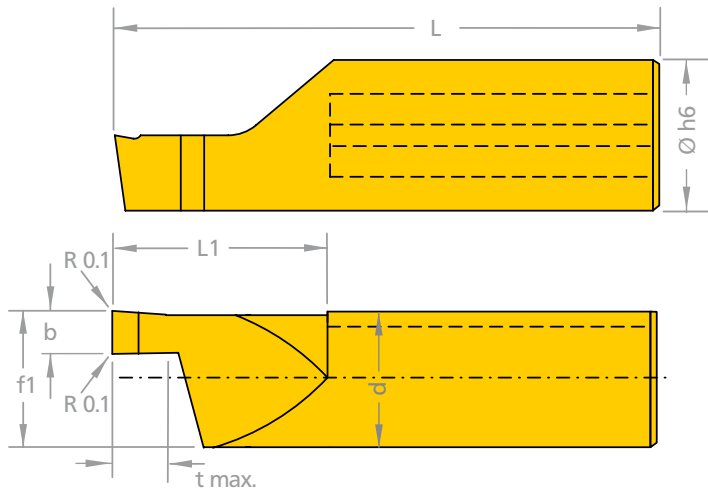
ULTRAMINI

Type 010 M

Grooving, boring and profiling starting at $\varnothing 0.2$ mm

Face grooving internal with corner radius

From outer groove $\varnothing 8.0$ mm
Depth of groove up to 6.0 mm
Width of groove up to 3.0 mm



Left hand version shown

State right (R) or left (L) version

Dimensions in mm



part number	U.S.A. Stock									suitable toolholder type	
	b +0.05	f1	d	L	L1	t max.	D min.	Ø h6	AL41F		
R/L010M1008-10	1.0	5.9	5.6	26	11	2.0	8.0	7.0	○	676.xxx / 687	670 / xxx.7
R/L010M1508-10	1.5	5.9	5.6	26	11	3.0	8.0	7.0	○		
R/L010M2008-10	2.0	5.9	5.6	26	11	4.0	8.0	7.0	○		
R/L010M2508-10	2.5	5.9	5.6	26	11	5.0	8.0	7.0	○		
R/L010M3008-10	3.0	5.9	5.6	26	11	6.0	8.0	7.0	○		
R/L010M1008-20	1.0	5.9	5.6	35	20	2.0	8.0	7.0	○		
R/L010M1508-20	1.5	5.9	5.6	35	20	3.0	8.0	7.0	○		
R/L010M2008-20	2.0	5.9	5.6	35	20	4.0	8.0	7.0	○		
R/L010M2508-20	2.5	5.9	5.6	35	20	5.0	8.0	7.0	○		
R/L010M3008-20	3.0	5.9	5.6	35	20	6.0	8.0	7.0	○		
R/L010M1008-30	1.0	5.9	5.6	45	30	2.0	8.0	7.0	○		
R/L010M1508-30	1.5	5.9	5.6	45	30	3.0	8.0	7.0	○		
R/L010M2008-30	2.0	5.9	5.6	45	30	4.0	8.0	7.0	○		
R/L010M2508-30	2.5	5.9	5.6	45	30	5.0	8.0	7.0	○		
R/L010M3008-30	3.0	5.9	5.6	45	30	6.0	8.0	7.0	○		

U.S.A. Stock

- = Both Right & Left Hand in Stock
- = Express Delivery
- ◐ = Left Hand in Stock
- ◑ = Right Hand in Stock

Carbide grades p. 93 see grades summary

Order-example: right hand version and grade
CN45F: R010.1008-10/CN45F

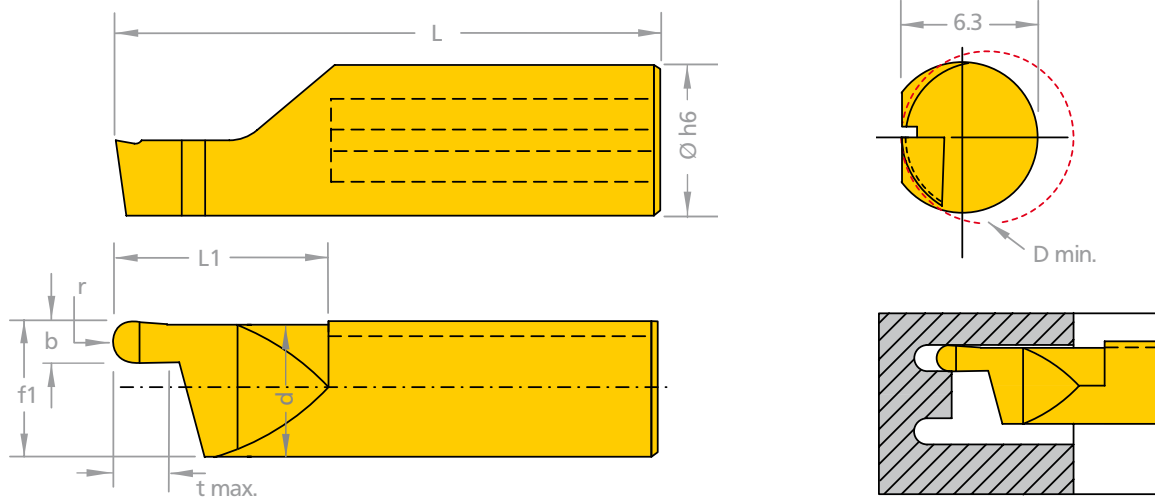
ULTRAMINI

Type 010

Grooving, boring and profiling starting at $\varnothing 0.2$ mm

Full Radius
Face grooving internal

From outer groove $\varnothing 8.0$ mm
Depth of groove up to 6.0 mm
Width of groove up to 3.0 mm



Left hand version shown
State right (R) or left (L) version
Dimensions in mm



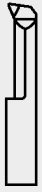
part number	U.S.A. Stock									AL41F	suitable toolholder type	
	b +0.05	f1	r	d	L	L1	t max.	D min.	\varnothing h6			
R/L010.1005-10	1.0	5.9	0.5	5.6	26	11	2.0	8.0	7.0	●	676.xxx / 687	670 / xxx.7
R/L010.1608-10	1.6	5.9	0.8	5.6	26	11	3.0	8.0	7.0	●		
R/L010.2010-10	2.0	5.9	1.0	5.6	26	11	4.0	8.0	7.0	●		
R/L010.2512-10	2.5	5.9	1.25	5.6	26	11	5.0	8.0	7.0	●		
R/L010.3015-10	3.0	5.9	1.5	5.6	26	11	6.0	8.0	7.0	●		
R/L010.1005-20	1.0	5.9	0.5	5.6	35	20	2.0	8.0	7.0	●		
R/L010.1608-20	1.6	5.9	0.8	5.6	35	20	3.0	8.0	7.0	●		
R/L010.2010-20	2.0	5.9	1.0	5.6	35	20	4.0	8.0	7.0	●		
R/L010.2512-20	2.5	5.9	1.25	5.6	35	20	5.0	8.0	7.0	○		
R/L010.3015-20	3.0	5.9	1.5	5.6	35	20	6.0	8.0	7.0	●		

U.S.A. Stock

- = Both Right & Left Hand in Stock
- = Express Delivery
- ◐ = Left Hand in Stock
- ◑ = Right Hand in Stock

Carbide grades p. 93 see grades summary

Order-example: right hand version and grade
AL41F: R010.1005-10/AL41F



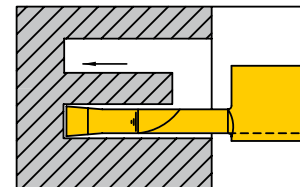
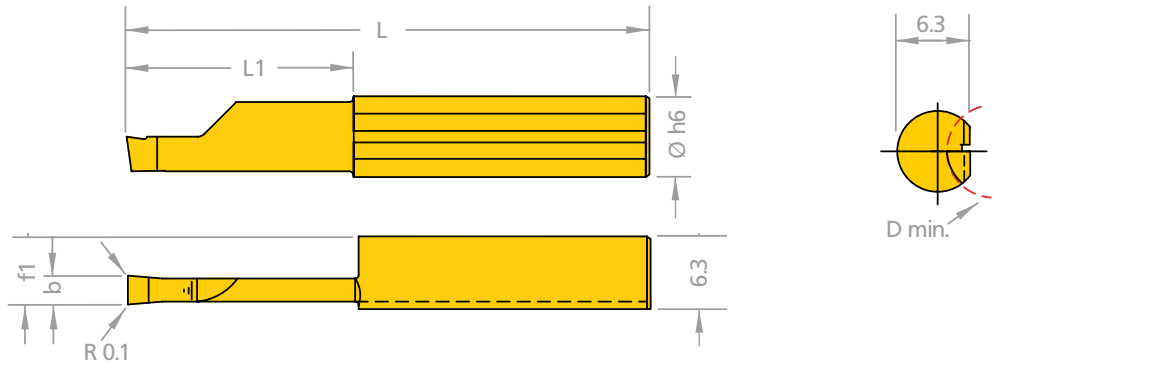
Type 015

ULTRAMINI

Face grooving

From outer groove \varnothing 8.0 mm
Depth of groove t max. 30.0 mm

Grooving, boring and profiling
starting at \varnothing 0.2 mm



Left hand version shown
State right (R) or left (L) version
Dimensions in mm



part number	b +0.05	f1	L	L1	t max.	D min.	Ø h6	U.S.A. Stock		suitable toolholder type	
								CN45F	AL41F		
R/L015.1515-10	1.5	5.9	25	10	10	8.0	7.0	○ ●		676.xxx / 687	670 / xxx.7
R/L015.2015-15	2.0	5.9	30	15	15	8.0	7.0	○ ●			
R/L015.2015-20	2.0	5.9	35	20	20	8.0	7.0	○ ○			
R/L015.2515-20	2.5	5.9	35	20	20	8.0	7.0	● ●			
R/L015.3015-20	3.0	5.9	35	20	20	8.0	7.0	● ●			
R/L015.3015-30	3.0	5.9	45	30	30	8.0	7.0	● ●			

U.S.A. Stock

- = Both Right & Left Hand in Stock
- = Express Delivery
- ◐ = Left Hand in Stock
- ◑ = Right Hand in Stock

Carbide grades p. 93 see grades summary

Order-example: right hand version
and grade
CN45F: R015.2515-20/CN45F

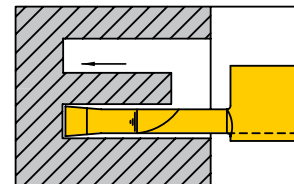
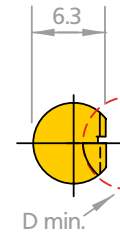
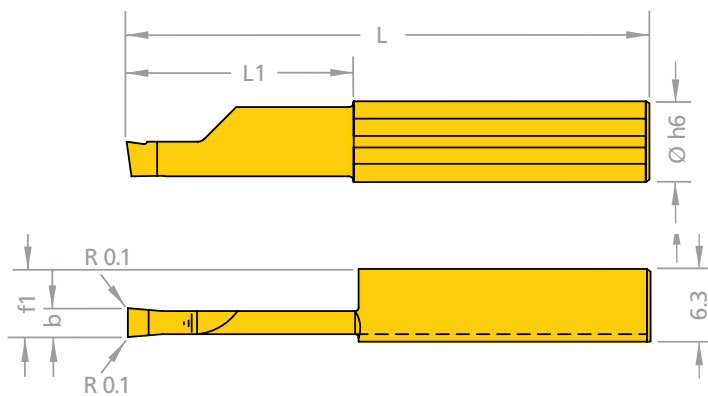
ULTRAMINI

Type 015 M

Grooving, boring and profiling starting at \varnothing 0.2 mm

Face grooving with corner-radius

From outer groove \varnothing 8.0 mm
Depth of groove t max. 30.0 mm



Right hand version shown
State right (R) or left (L) version
Dimensions in mm



part number	U.S.A. Stock								suitable toolholder type	
	b +0.05	f1	L	L1	t max.	D min.	\varnothing h6	AL41F		
R/L015M.1515-10	1.5	5.9	25	10	10	8.0	7.0	○		
R/L015M.2015-15	2.0	5.9	30	15	15	8.0	7.0	◐		
R/L015M.2014-20	2.0	5.9	35	20	20	8.0	7.0	○	676.xxx / 687	670 / xxx.7
R/L015M.2515-20	2.5	5.9	35	20	20	8.0	7.0	○		
R/L015M.3015-20	3.0	5.9	35	20	20	8.0	7.0	○		
R/L015M.3015-30	3.0	5.9	45	30	30	8.0	7.0	○		

U.S.A. Stock

- = Both Right & Left Hand in Stock
- = Express Delivery
- ◐ = Left Hand in Stock
- ◑ = Right Hand in Stock

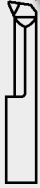
Carbide grades p. 93 see grades summary

Order-example:
right hand version and grade
CN45F: R015M2515-20/CN45F

NEW

ULTRAMINI

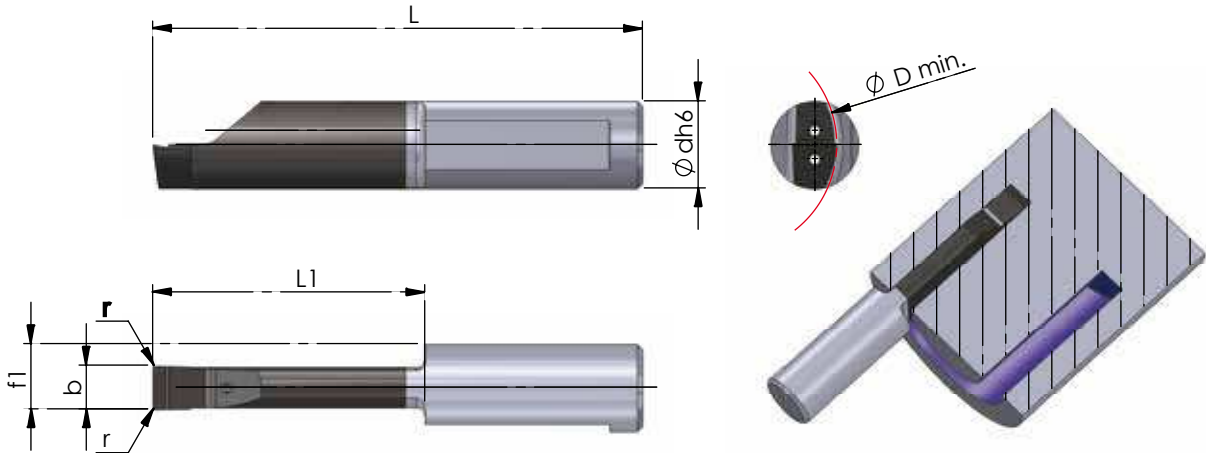
Type 012/016/020



Grooving, boring, profiling, threading and chamfering starting at \varnothing 0.2 mm

Face grooving with double internal cooling

From outer groove \varnothing 12 mm depth of groove t max. 20 mm



Right hand version shown

State right (R) or left (L) version

Dimensions in mm

	part number	b +0,05	r	f1	L	L1	t max.	D min.	$\varnothing h6$	U.S.A. Stock AL41F	toolholder type
NEW	R/L012.0200-10	2.0	0.2	5	30	10	10	12	8.0	○	687.xxx 680
NEW	R/L012.0200-15	2.0	0.2	5	35	15	15	12	8.0	○	
NEW	R/L012.0250-10	2.5	0.2	5.25	30	10	10	12	8.0	○	
NEW	R/L012.0250-20	2.5	0.2	5.25	40	20	20	12	8.0	○	
	R/L016.0300-10	3.0	0.2	5.5	30	10	10	16	8.0	○	
NEW	R/L016.0300-20	3.0	0.2	5.5	40	20	20	16	8.0	○	
	R/L020.0300-25	3.0	0.2	5.5	45	25	25	20	8.0	○	
	R/L020.0300-30	3.0	0.2	5.5	50	30	30	20	8.0	◐	
	R/L020.0300-35	3.0	0.2	5.5	55	35	35	20	8.0	◑	
	R/L020.0300-40	3.0	0.2	5.5	60	40	40	20	8.0	◒	
NEW	R/L016.0400-10	4.0	0.2	6.0	30	10	10	16	8.0	○	
	R/L016.0400-20	4.0	0.2	6.0	40	20	20	16	8.0	○	
	R/L020.0400-25	4.0	0.2	6.0	45	25	25	20	8.0	○	
	R/L020.0400-30	4.0	0.2	6.0	50	30	30	20	8.0	◐	
	R/L020.0400-35	4.0	0.2	6.0	55	35	35	20	8.0	◑	
	R/L020.0400-40	4.0	0.2	6.0	60	40	40	20	8.0	◒	
	R/L020.0500-20	5.0	0.2	6.5	40	20	20	20	8.0	◐	
	R/L020.0500-25	5.0	0.2	6.5	45	25	25	20	8.0	○	
	R/L020.0500-30	5.0	0.2	6.5	50	30	30	20	8.0	◐	
	R/L020.0500-35	5.0	0.2	6.5	55	35	35	20	8.0	◑	
	R/L020.0500-40	5.0	0.2	6.5	60	40	40	20	8.0	◒	

U.S.A. Stock

- = Both Right & Left Hand in Stock
- = Express Delivery
- ◐ = Left Hand in Stock
- ◑ = Right Hand in Stock

More carbide grades can be found in the grades summary page 93
Order example:
Right hand version and grade
R012.0200-10/AL41F

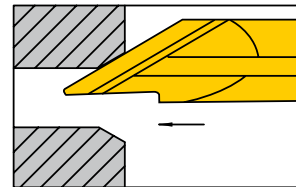
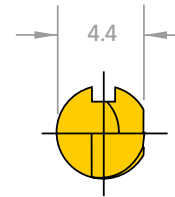
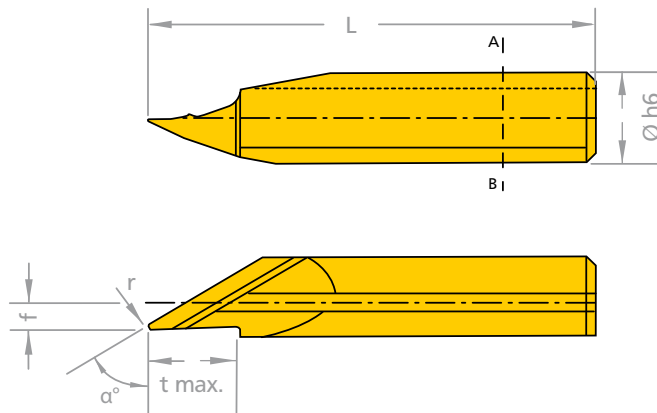
Type 520

ULTRAMINI

Chamfering internal bore

Bore \varnothing from 1.0 mm

Grooving, boring and profiling starting at \varnothing 0.2 mm



Right hand version shown

State right (R) or left (L) version

Dimensions in mm



part number

U.S.A. Stock

suitable toolholder type

	a	f	r	L	t max.	D min.	\varnothing h6
R/L520.0045-15	45°	1.5	0.2	30	3.5	1.0	5.0
R/L520.0060-15	60°	1.5	0.2	30	4.0	1.0	5.0

AL41F
<input type="radio"/>
<input type="radio"/>

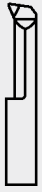
645.xxx / xxx.5

U.S.A. Stock

- = Both Right & Left Hand in Stock
- = Express Delivery
- ◐ = Left Hand in Stock
- ◑ = Right Hand in Stock

Carbide grades p. 93 see grades summary

Order-example: right hand version and grade
AL41F: R520.0045-15/AL41F



ULTRAMINI

Grooving, boring and profiling starting at Ø 0.2 mm

Sets Ultramini 1 and 2



Set 1

Boring/ profiling, copying and grooving right

Set 2

Grooving right

	part number		part number
Toolholder	676.0016-D 645.0016-D	Toolholder	676.0016-D 645.0016-D
insert	R050.6-22/CN45F R050.5-20/CN45F R.060.5-20/CN45F R050.4-16/CN45F R.050.3-16/CN45F R006.0200-22/CN45F R.006.0150-22/CN45F R005.0200-20/CN45F R005.0150-20/CN45F R004.0100-16/CN45F	insert	R006.0200-22/CN45F R.006.0150-22/CN45F R005.0200-20/CN45F R005.0150-20/CN45F R004.0100-16/CN45F
Part number of set	730 85 999	Part number of set	730 85 992

ULTRAMINI

Sets Ultramini 3 and 6

Grooving, boring and profiling starting at Ø 0.2 mm



Set 3

Boring/ profiling, copying right

Set 6

Right face grooving (internal) bore Ø dmin. 8.0 mm

part number

part number

Toolholder

676.0016-D
645.0016-D

Toolholder

676.0016-D

insert

R050.6-22/CN45F
R050.5-20/CN45F

R050.4-16/CN45F
R.050.3-16/CN45F

insert

R010.2508-20/CN45F
R010.2008-10/CN45F
R010.1508-10/CN45F

R010.3008-20/CN45F
R010.1008-10/CN45F

Part number of set

730 85 994

Part number of set

730 85 996



ULTRAMINI

grooving, boring and profiling

Technical Instructions

Cutting data and number of passes for threading



Recommended number of passes

The number of passes is only a recommendation for threading. To reach a good tool life you have to mention the explanation for the infeed. Finishing passes are not considered in that chart.

		Steel (N/mm ² tensile strength)					Stainless Steel	Cast Iron	aluminium
		400-500	500-700	700-850	850-1150	>1150			
SFM		525	459	394	295	230	295	328	984
Pitch P		number of passes							
mm	Gg/" TPI								
0,5	48	5	5	5	5	8	8	5	5
0,8	32	6	6	6	6	8	8	6	6
1	24	7	7	7	7	8	8	7	7
1,25	20-19	8	8	8	8	10	10	8	8
1,5	16	10	10	10	10	12	12	10	10
1,75	14	12	12	12	12	14	14	12	12
2	12-11	13	13	13	13	15	15	13	13
2,5	10	15	15	16	16	18	18	16	15
3 - 3,5	8	16	16	17	17	20	20	17	16
4		18	18	19	19	22	22	19	18
5		20	20	21	21	24	24	21	20
6		22	22	23	23	26	26	23	22

ULTRAMINI

Grooving, boring and profiling

Technical Instructions

Carbide grade and coatings



K10F

All purpose micrograin carbide with good abrasion resistance. Uncoated for applications with low or medium cutting speeds and machining of nonferrous materials.

CBN

Ductile CBN grade for applications with lower cutting speed. Suitable for hardened steel, interrupted cuts and cast iron.

CN45F

PVD-TiN coating - all purpose, all around grade is suitable for low and medium cutting speed with restrictions on non-ferrous materials.

AL41F

TiAlN coating - very universal with a high resistance to high temperature and hardness. Very suitable also for non-ferrous metals.

PD2F

Coating for universal use with medium and low speed.

XC2A

AlCrN coating - excellent hot hardness, maximum temperature of 1100°, high oxidation resistance and thermal insulation capacity. Perfect for hard machining >60 HRC.

P01C

Coating for the processing of tough material with medium or low cutting speed.

P03C

Coating for materials which are difficult to machine. Perfect to use for dry machining.

P07C

TiCrN coating - maximum temperature of 800° perfect for titanium, stainless steel and molybdenum.

P18C

AlTiCrN coating - very universal, high performance coating with high oxidation resistance, wear resistance and hot hardness resistance. Maximum temperature of 800°. Usable for maximum HRC54.

NEME

ta-C (carbon layer very thin) coating - maximum temperature of 500° for machining aluminium, alloys, non-ferrous metals and composite materials.





ULTRAMINI

grooving, boring and profiling
starting at $\varnothing 0.2$ mm

Technical instructions,
basic points



Center Height Ultramini:

The seatings of the Ultramini tools guarantee an accurate center height of these tools. In spite of this please have always a look at your tools because a difference may cause problems, especially when machining small diameters.

Removal of Chips Ultramini:

Please choose inserts with small cutting width, so the chips keep smoothly and will be able to flow out of the bore beside the tool. To avoid jam of chips use the technique to groove by steps.

Coolant Ultramini:

Use filtered coolant for transporting the chips out and for cooling the insert itself. A coolant pressure of 5 bar minimum is recommended.

ULTRAMINI

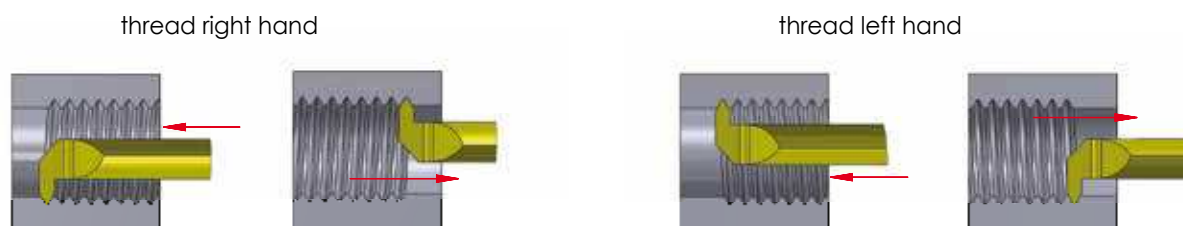
grooving, boring and profiling
starting at Ø 0.2 mm

Technical instructions,
threading



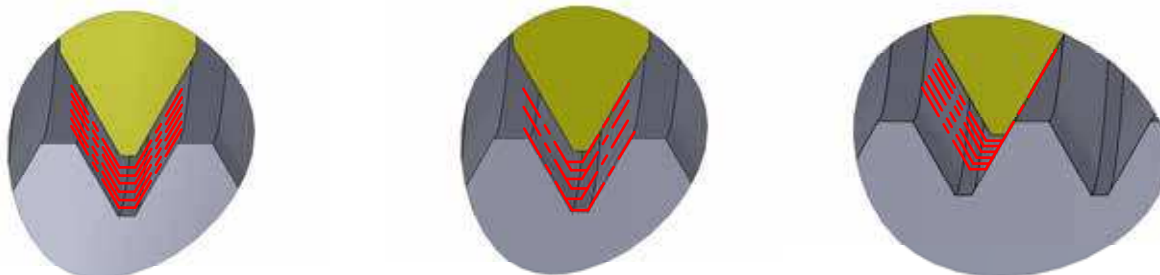
Feed Direction

Every insert can be used for right- and lefthand thread. You only have to consider the following feed direction:



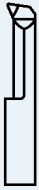
Infeed Possibilities

Radial infeed	Alternating flank infeed	Flank infeed
The most used method for threading. both sides are at the same time in process.	The flanks are alternating used	Only one cutting edge is used for the complete thread
Problematic chip education, high cutting force and weariness at insert and work piece	Reduced cutting force, higher state time and chip education	Reduced cutting force and better chip education, but one-sided weariness



ULTRAMINI

Technical Instructions



Grooving, boring and profiling

Cutting data



	MATERIAL	STRENGTH (psi)	MATERIAL NUMBER	MATERIAL DESCRIPTION	ANSI	MATERIAL NUMBER	MATERIAL DESCRIPTION
P	General Construction Steel	< 116030	1.0037	St37-2	A284	1.0570	St52-3
	Free-cutting steel	< 116030	1.0718	95MnPb28	12L13	1.0727	45S20
	Non-Alloyed Steel	< 116030	1.0401	C15	1015	1.0481	17Mn4
	Alloy Steel	< 145038	1.7331	16MnCr5 (EC80)	5120	1.7015	13Cr3 (EC60)
	Compensation Steel Unalloyed	< 123282	1.0503	C45	1045	1.1191	Ck45
	Compensation Steel Unalloyed	< 145038	1.0601	C60	1060	1.1221	Ck60
	Alloy Steel	< 116030	1.5131	50MnSi4		1.7030	28Cr4
	Alloy Steel	< 188549	1.5755	31NiCr14		1.7033	34Cr4
	Cast Steel	< 123282	0.9650	G-X260Cr27		1.6750	GS-20NiCrMo3 7
	Nitriding Steel	< 145038	1.8504	34CrAl6		1.8507	34AlMo5
	Nitriding Steel	< 174045	1.8515	31CrMo12		1.8523	39CrMoV19 3
	Bearing Steel	< 174045	1.3505	100Cr6 (W3)	52100	1.3543	X192CrMo17
	Bearing Steel	< 174045	1.5026	55Si7	-	1.7176	55Cr3
	High Speed Steel	< 188549	1.3344	S 6-5-3		1.3255	S 18-1-2-5
	Tool Steel for Cold Work	< 188549	1.2312	40CrMnMoS8 6		1.2379	X155CrVMo12 1
	Tool Steel for Warm Work	< 188549	1.2343	X38CrMoV 5 1	H11	1.2767	X45NiCrMo4
	M	Steel and cast steel rostfei sulfurized	< 123282	1.4305	X8CrNiS18 9	303	1.4105
Stainless Steel, Ferritic		< 108778	1.4510	X3CrTi17		1.4528	X105CrCoMo18 2
Stainless Steel, Martensitic		< 130534	1.4034	X46Cr13	-	1.4116	X50CrMoV15
Non-rusting. Steel, Ferritic / Martensite		< 159542	1.4313	X3CrNi13-4		1.4028	X30Cr13
Non-rusting. Steel, Austenitic / Ferritic		< 123282	1.4460	X8CrNiMo27 5	S32900	1.4821	X20CrNiSi25 4
Stainless Steel, Austenitic		< 108778	1.4301	X5CrNi18-10	304	1.4571	X6CrNiMoTi17 12 2
Heat Resistant		< 159542	1.4747	X80CrNiSi20		1.4876	X10NiCrAlTi32-21
K	Gray Cast Iron with Lamellar Graphite	14504-50763	0.6010	GG10	CLASS20	0.6025	GG25
	Gray Cast Iron with Lamellar Graphite	43511-145038	0.6030	GG30	CLASS45	0.6045	GG45
	Ball Graphite Castings	43511-72519	0.7040	GGG40	60-40-18	0.7050	GGG50
	Ball Graphite Castings	79771-116030	0.7060	GGG60	-	0.7080	GGG80
	Malleable Cast Iron	50763-65367	0.8035	GTW35	-	0.8045	GTW45
	Malleable Cast Iron	72519-94274	0.8055	GTW55	-	0.8065	GTW65
	Malleable Cast Iron Black	50763-65267	0.8135	GTS35	32510	0.8145	GTS45
N	Malleable Cast Iron Black	72519-101526	0.8155	GTS55	50005	0.8170	GTS70
	Aluminum (unalloyed, low alloy)	< 50763	3.0255	Al99,5	1000	3.3308	Al99,9Mg0,5
	Aluminum Alloys < 0,5%	< 72519	3.0515	AlMn1		3.1355	AlCuMg2
	Aluminum Alloys 0,5-10%	< 58015	3.2152	GD-AlSi6Cu4		3.2373	GD-AlSi9Mg
	Aluminum Alloys 10-15%	< 58015	3.2381	G-AlSi10Mg	-	3.5562	G-MgAl6
	Aluminum Alloys > 15%	< 58015		G-AlSi17Cu4			G-AlSi25CuNiMg
	Copper (unalloyed, low alloy)	< 50763	2.0060	E-Cu57		2.0090	SF-Cu
	Copper Wrought Alloys	< 101526	2.0240	CuZn15	C23000	2.0265	CuZn30
	Copper Special Alloys	< 200 HB	2.0916	CuAl5		2.1525	CuSi3Mn
	Copper Special Alloys	< 300HB	2.0978	CuAl11Ni6Fe5			
	Copper Special Alloys	> 300 HB	2.1247	CuBe2F125			
	Brass Short-Spanning, Bronze, Gunmetal	< 87023	2.0360	CuZn40 (Ms60)	C28000	2.0380	CuZn39Pb2 (Ms58)
	Brass Long-Spanning	< 87023	2.0335	CuZn36 (Ms63)	C36000	2.1293	CuCrZr
	Thermoplastics			Delrin, Hostalen			Makrolon, Novodur
	Thermosets			Ferrozell, Bakelit			Pertinax
	Fiber Reinforced Plastics			GFK (Glasfaserverstärkt)			CFK (Kohlefaserverstärkt)
	Magnesium and Magnesium Alloys	< 123282	3.5200	M2, MgMn2		3.5612	MgAl6Zn1
Graphite			C8000, R8500X			R8650	
Tungsten and Tungsten Alloys			W-NiFe (Densimet W)			W-Cu80/20	
Molybdenum and Molybdenum Alloys			Mo , Mo-50Re			TZC, TZM	
S	Pure Nickel		1.3911	RNi24		1.3927	RNi8
	Nickel Alloys		1.3912	Ni36 (Invar)		1.3924	Ni54
	Nickel Alloys	< 123282	2.4360	S-NiCu 30 Fe			NiCu 30 Fe
	Nickel-Chromium Alloy		2.4886	SG-NiMo16Cr16W		2.4610	NiMo16Cr16Ti
	Nickel and Cobalt Alloys	< 188549	2.4632	NiCr20Co18Ti		2.4631	NiCr20TiAl
	Nickel and Cobalt Alloys	< 188549	2.4634	NiCo20Cr15MoAlTi		2.4654	NiCr19Co14Mo4Ti
	High-Temperature Resistant Alloys	< 188549		Hardox 400		1.4939	X12CrNiMo12
	Nickel-Cobalt-(Chrome-) Alloys	< 203053	2.4806	SG-NiCr20Nb, Inconel 82		2.4851	NiCr23Fe, Inconel 601
	Pure Titanium	< 130534	3.7025	Ti99,8		3.7034	Ti99,7
	Titanium Alloys	< 101526	3.7114	TiAl5Sn2	-	3.7174	TiAl6V6Sn2
H	Titanium Alloys	< 174045	3.7164	TiAl5V4		3.7144	TiAl6Sn2Zr4Mo2
	Hardened Steel	< 45 HRC					
		46-55HRC					
		56-60 HRC					
	61-65 HRC						
	65-70 HRC						

Data on this page is for reference and planning only. Materials and processes should be tested in your environment to achieve desired results.

feed f:

groove: 0.0004 - 0.0012 in/Rev.

copy turning: 0.0008 - 0.0031 in/Rev.

axial groove: 0.0008 - 0.002 in/Rev.



ANSI	MATERIAL NUMBER	MATERIAL DESCRIPTION	ANSI	K10F (SFM)	CN45F (SFM)	AL41F (SFM)	P18C (SFM)	P07C (SFM)	XC2A-NH (SFM)
	1.0060	St60-2	A572	98-426	98-591	262-656	262-656	262-656	
	1.0757	46SPb2		98-426	131-656	262-656	262-656	262-656	
	1.1141	C15E (CK15)	1015	98-426	131-591	262-656	262-656	262-656	
	1.5919	15CrNi6	3115	49-295	98-459	262-525	262-525	262-525	
1045	1.0535	C55	1055	49-295	98-328	262-459	262-459	262-459	
1060	1.0540	C50		49-295	98-328	262-525	262-525	262-525	
	1.7225	42CrMo4	4140	98-426	98-328	262-525	262-525	262-525	
5132	1.3565	48CrMo4		49-295	98-328	262-492	262-492	262-492	
	1.6582	GS-34 CrNiMo 6	4337	98-426	131-656	262-656	262-656	262-656	
	1.8509	41CrAlMo7	A355	49-295	98-328	230-459	230-459	230-459	
	1.8550	34 CrAlNi 7		49-295	98-328	230-459	230-459	230-459	
	1.3520	100 CrMn 6 (W4)		49-295	98-328	230-459	230-459	230-459	
5155	1.7701	51CrMoV4							
1015	1.3294	PMH56-5-3-8; ASP30							
D2	1.2316	X38CrMo16; RAMAX		49-148	98-328				
	1.2842	90MnCrV8	02	49-148	98-328				
430F	1.4107	GX8CrNi12			98-328	262-525	262-525	262-525	
	1.4016	X6Cr17	430		98-328	262-525	262-525	262-525	
	1.4106	X2CrMoSiS18-2-1			98-328	262-525	262-525	262-525	
420F	1.4104	X14CrMoS17	430 F		66-295	66-279	66-279	66-279	
	1.4462	X2CrNiMoN22-5-3 (Duplex)	UNS31803		66-213	66-246	66-246	66-246	
316 Ti	1.4449	X3CrNiMo18-12-3	317		66-262	66-213	66-213	66-213	
B163	1.4825	GX25CrNiSi18-9			66-262	66-213	66-213	66-213	
A48-40 B				98-361	230-492	98-591	98-591	98-591	
				98-295	164-394	98-492	98-492	98-492	
65-45-12				82-361	98-426	98-591	98-591	98-591	
120-90-02				82-262	98-361	98-394	98-394	98-394	
				98-361	98-328	98-295	98-295	98-295	
				98-295	98-295	66-262	66-262	66-262	
				98-361	98-328	98-295	98-295	98-295	
				98-295	98-295	66-262	66-262	66-262	
	3.0256	E-Al H		361-689	328-1969	394-1968	394-1969	394-1969	
2024	3.3315	AlMg1		295-656	328-1969	394-1968	394-4969	394-1969	
	3.2134	GD-AlSi5Cu1Mg		295-656	328-1640	328-1476	328-1476	328-1476	
	3.2525	S-AlSi12		164-459	262-1148	230-984	230-984	230-984	
		G-AlSi21CuNiMg			262-656	197-492	197-492	197-492	
	2.1522	CuSi2Mn		164-459	230-525	197-492	197-492	197-492	
	2.0321	CuZn37		197-492	262-591	328-591	328-591	328-591	
		Ampco 8-16		164-459	262-591	295-591	295-591	295-591	
		Ampco 18-26		164-459	262-591	262-591	262-591	262-591	
		Ampco M-4		164-459	262-591	262-591	262-591	262-591	
	2.0410	CuZn44Pb2		262-525	328-656	394-722	394-722	394-722	
	2.1080	CuSn6Zn6		164-394	262-591	230-492	230-492	230-492	
		Acrylglas, Polystyrol		131-394	230-525	262-591	262-591	262-591	
		Resopal							
		AFK (Amidfaserverstärkt)							
	3.5812	MgAl8Zn1							
		Technograph15							
		W93NiFe (DENAL)		49-230					
		MHC , ODS							
	1.3926	RNi12			98-262	98-262	98-262	98-262	
	1.3921	Ni49			59-246	59-246	59-246	59-246	
		Monel 400			59-246	59-246	59-246	59-246	
		Hastelloy C-276				131-230	131-230	131-230	197-230
		Nimonic 80			59-131	131-230	131-230	131-230	197-230
		Waspaloy			59-131	131-230	131-230	131-230	197-230
904L	1.4980	X6NiCrTiMoVB25-15-2		49-98	131-230	131-230	131-230	131-230	197-230
	2.4667	SG-NiCr19NbMoTi		49-98	131-230	131-230	131-230	131-230	197-230
	3.7064	Ti99,5			131-230	131-230	131-230	230-192	
	3.7124	TiCu2			131-230	131-230	131-230	230-192	
	3.7154	TiAl6Zr5			131-230	131-230	131-230	230-192	
									164-394
									164-394
									164-394



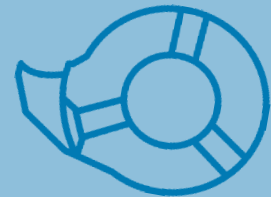
Data on this page is for reference and planning only. Materials and processes should be tested in your environment to achieve desired results.

feed f:
 groove: 0.0004 - 0.0012 in/Rev.
 copy turning: 0.0008 - 0.0031 in/Rev.
 axial groove: 0.0008 - 0.002 in/Rev.





Minicut



**Grooving, boring and profiling
starting at Ø 7.8 mm**



MINICUT

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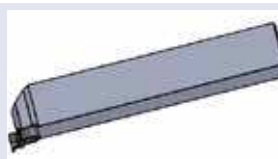


tool holder straight shank

dimensions

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tool holder square shank

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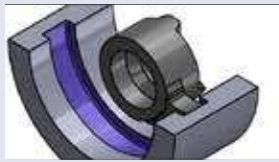
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Dümmel
WERKZEUGFABRIK

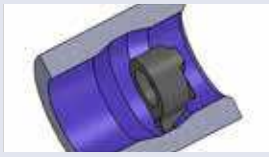




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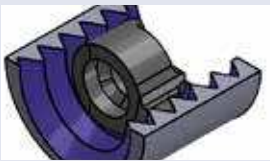
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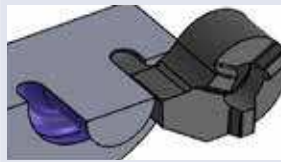
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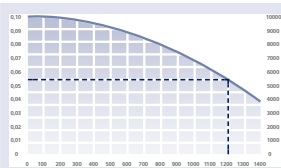
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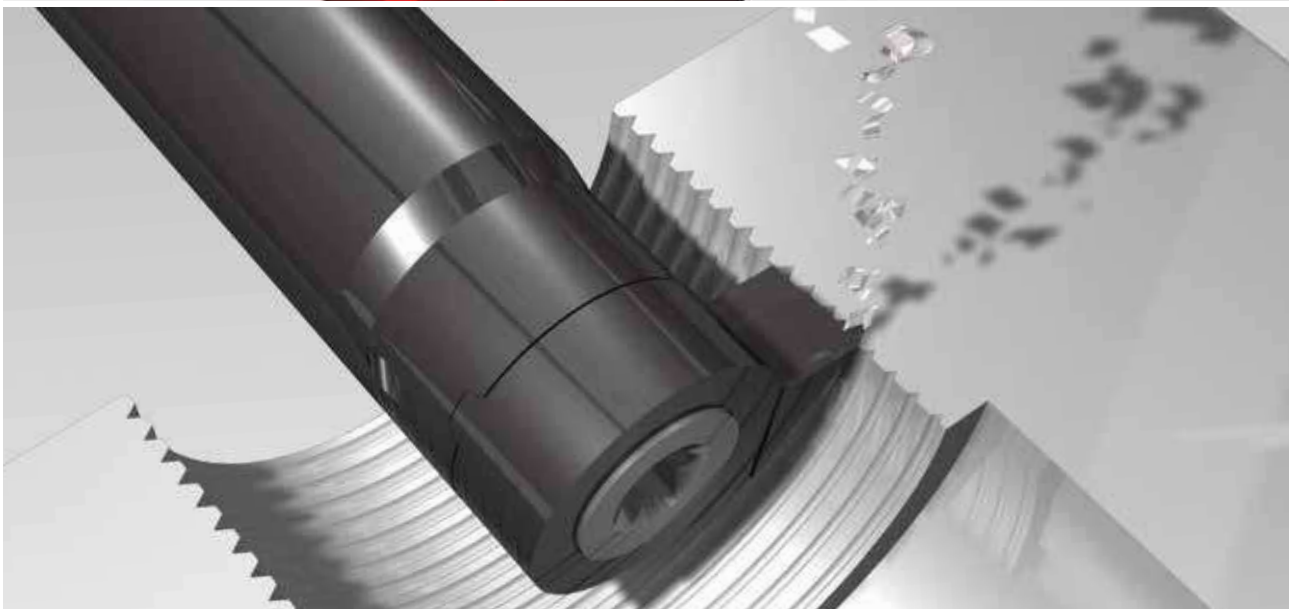
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Grooving, boring and profiling

Machining example

 Dümmel®

In the Minicut system, the indexable carbide inserts are frontal screwed by the proven three ribs coupling. This guarantees best repeat accuracy by most simple handling.



MINICUT

Type 608 / 609 / 611 / 614

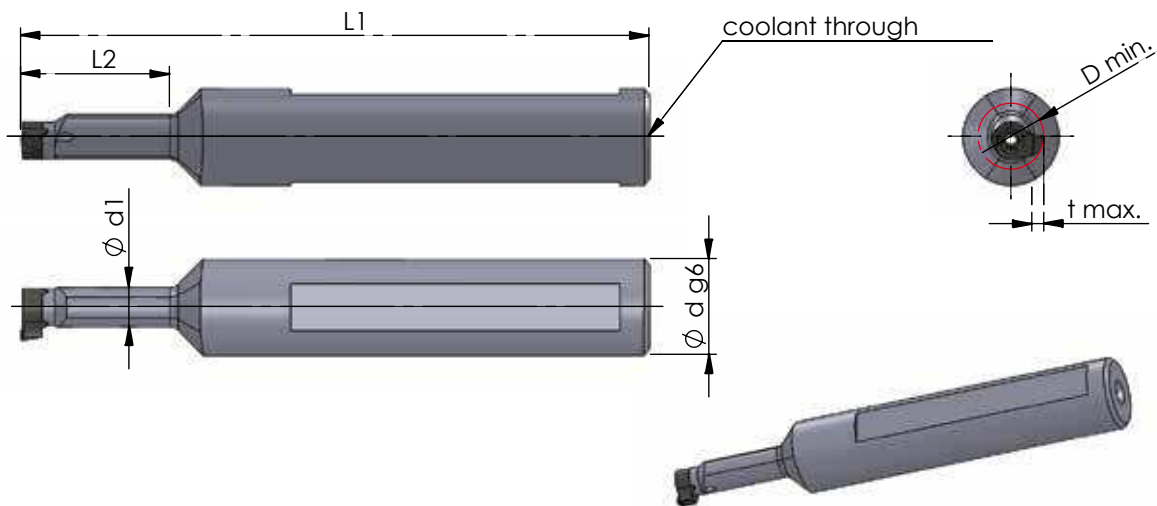
NEW



Grooving, boring and profiling

Tool holder steel

Bore Ø from 7.8 mm



Dimensions in mm



NEW

part number	Ø d g6	Ø d g6 (INCH)	Ø d1	L1	L2	Typ: t max. / D min.	U.S.A. Stock	screw	key driver	torque	use with insert
608.0158.1E.ST INCH SIZE	15.875	0.625"	6x7	90	22		●	M2.6-MC	T8	1.0-1.5 Nm	R/L S08 R/L S008
608.0016.1ST	16	-	6	80	12	R/L S008: 1.0 / ø8	●				
608.0016.1E.ST	16	-	6x7	90	22		●				
609.0158.1E.ST INCH SIZE	15.875	0.625"	6.6x7.4	105	25		●	M2.6-MC	T8	2.0 Nm	R/L S09 R/L S009
609.0016.1ST	16	-	6.6x7.4	95	14	R/L S009: 1.8 / ø9	○				
609.0016.1E.ST	16	-	6.6x7.4	105	25	R/L S09: 2.8 / ø10	○				
611.0158.2E.ST INCH SIZE	15.875	0.625"	8x9.5	110	29		●	M3.5-MC	T10	2.5-3.0 Nm	R/L S11 R/L S011
611.0016.2ST	16	-	8	97	16	R/L S011: 2.3 / ø11	●				
611.0016.2E.ST	16	-	8x9.5	110	29		●				
614.0158.3E.ST INCH SIZE	15.875	0.625"	9.5x11	120	38		●	M4-MC	T15	4.0-4.5 Nm	R/L S14 R/L S014 R/L S55 R/L S65
614.0016.3ST	16	-	9.5x11	100	18	R/L S014: 4.0 / ø14	●				
614.0016.3E.ST	16	-	9.5x11	120	38	R/L S55: 5.5 / ø16 R/L S65: 6.5 / ø17	●				

U.S.A. Stock

- = In Stock
- = Express Delivery



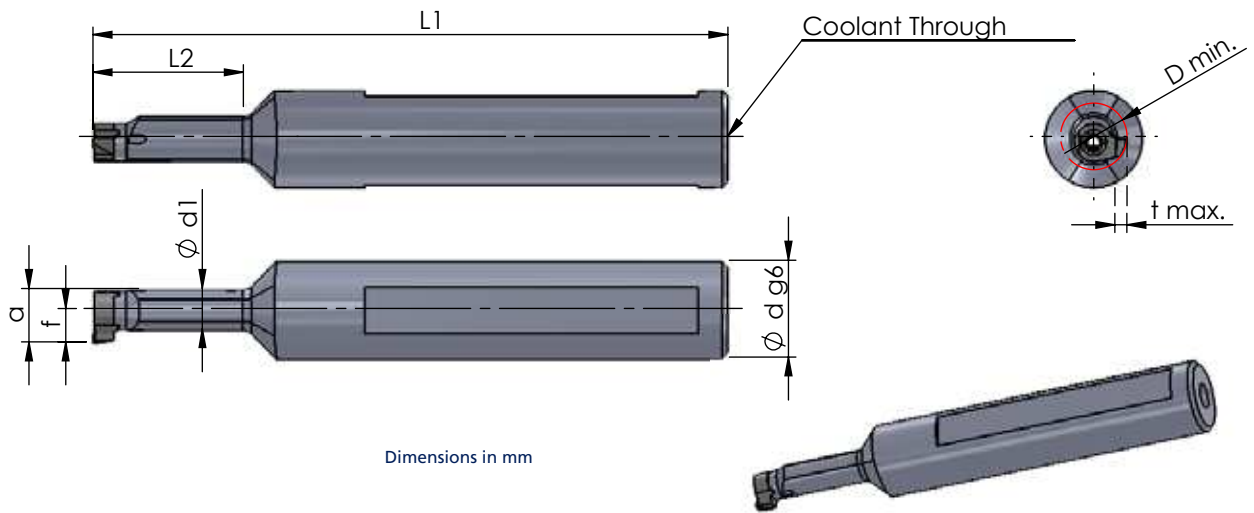
MINICUT

Type 616 / 618

Grooving, boring and profiling

Tool holder steel

Bore Ø from 7.8 mm



Dimensions in mm

part number	Ø d g6	Ø d g6 (INCH)	d1	L1	L2	f	a	t max.	D min.	U.S.A. Stock	screw	key	torque	use with insert
616.0158.3E.ST INCH SIZE	15.875	0.625"	11x13.5	120	42	10.2	15.7	4.3	16	●				
616.0016.3ST	16	-	11	100	22	10.2	15.7	4.3	16	●				R/LS16
616.0016.3E.ST	16	-	11x13.5	120	42	10.2	15.7	4.3	16	●	M5-MC	T20	6-6.5 Nm	
618.0020.3ST	20	-	11.5	95	25	*	*	8	18	●				
618.0020.3E.ST	20	-	11.5	120	45	*	*	8	18	○				R/LS 18

U.S.A. Stock

- = In Stock
- = Express Delivery

* Dimension according insert

Type 608 / 609

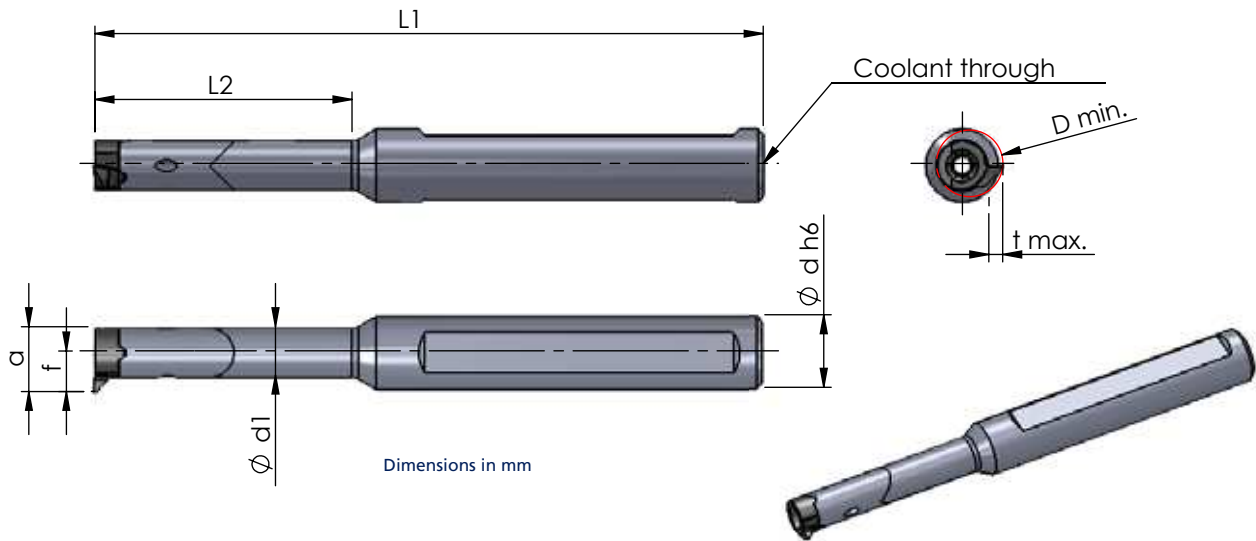
MINICUT



Tool holder carbide

Bore Ø from 7.8 mm

Grooving, boring and profiling



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part number	Ø d h6	Ø d g6 (INCH)	d1	L1	L2	f	a	t max.	D min.	U.S.A. Stock	screw	key	torque	use with insert
608.0012.1HM	12	-	6	80	21	4.8	7.8	1	8	●	M2.6-MC T8		1-1.5 Nm	R/LS08
608.0012.2HM	12	-	6	90	30	4.8	7.8	1	8	●				
608.0012.3HM	12	-	6	100	42	4.8	7.8	1	8	●				
608.0012.4HM	12	-	6	115	50	4.8	7.8	1	8	●				
608.0127.1HM INCH SIZE	12.7	0.500"	6	80	21	4.8	7.8	1	8	●				
608.0127.2HM INCH SIZE	12.7	0.500"	6	90	30	4.8	7.8	1	8	●				
608.0127.3HM INCH SIZE	12.7	0.500"	6	100	42	4.8	7.8	1	8	●				
609.0012.1HM	12	-	6.6x7.4	90	22	5.5	8.6	2/3	9 / 10	○				
609.0012.2HM	12	-	6.6x7.4	98	30	5.5	8.6	2/3	9 / 10	○				
609.0012.3HM	12	-	6.6x7.4	110	42	5.5	8.6	2/3	9 / 10	○			2 Nm	R/LS09
609.0012.4HM	12	-	6.6x7.4	122	56	5.5	8.6	2/3	9 / 10	●				

U.S.A. Stock

- = In Stock
- = Express Delivery

* Dimension according insert



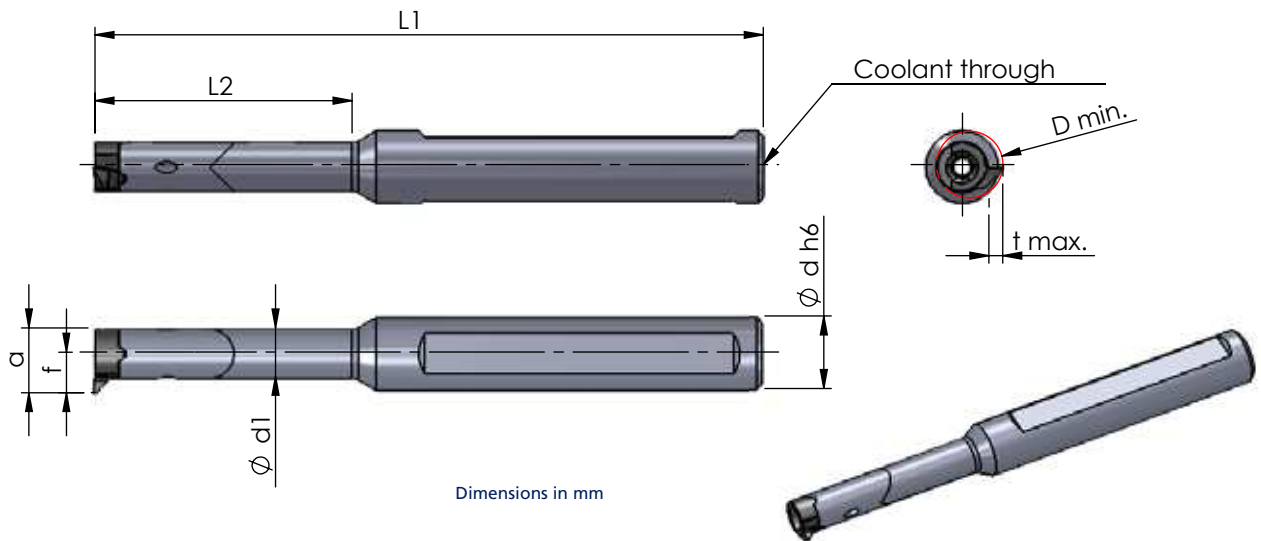
MINICUT

Grooving, boring and profiling

Type 611

Tool holder carbide

Bore Ø from 7.8 mm



Dimensions in mm

part number	Ø d h6	Ø d g6 (INCH)	d1	L1	L2	f	a	t max.	D min.	U.S.A. Stock	screw	key	torque	use with insert
611.0012.1HM	12	-	8	95	29	6.7	10.7	2.3	11	●				
611.0012.2HM	12	-	8	110	42	6.7	10.7	2.3	11	●				
611.0012.3HM	12	-	8	120	56	6.7	10.7	2.3	11	●				
611.0012.4HM	12	-	8	130	64	6.7	10.7	2.3	11	●	M3.5-MC	T10	2.5-3 Nm	R/LS11
611.0127.1HM INCH SIZE	12.7	0.500"	8	95	29	6.7	10.7	2.3	11	●				
611.0127.2HM INCH SIZE	12.7	0.500"	8	110	42	6.7	10.7	2.3	11	●				
611.0127.3HM INCH SIZE	12.7	0.500"	8	120	56	6.7	10.7	2.3	11	●				

U.S.A. Stock

- = In Stock
- = Express Delivery

* Dimension according insert

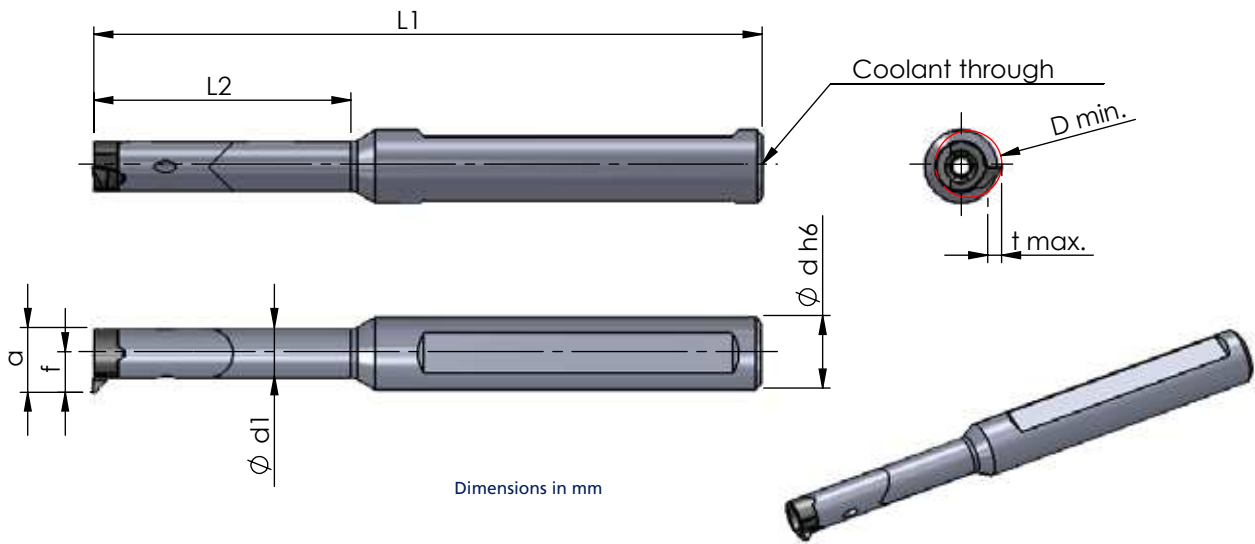
Type 614

MINICUT

Tool holder carbide

Bore Ø from 7.8 mm

Grooving, boring and profiling



part number	Ø d h6	Ø d g6 (INCH)	d1	L1	L2	f	a	t max.	D min.	U.S.A. Stock	screw	key	torque	use with insert
614.0012.1HM	12	-	9.5x11	100	34	*	*	4/6.5	14/17	●				
614.0012.2HM	12	-	9.5x11	110	45	*	*	4/6.5	14/17	●				
614.0012.3HM	12	-	9.5x11	130	64	*	*	4/6.5	14/17	●				
614.0127.1HM INCH SIZE	12.7	0.500"	9.5x11	100	34	*	*	4/6.5	14/17	●				
614.0127.2HM INCH SIZE	12.7	0.500"	9.5x11	110	45	*	*	4/6.5	14/17	●				
614.0127.3HM INCH SIZE	12.7	0.500"	9.5x11	130	64	*	*	4/6.5	14/17	●				
614.0158.1HM INCH SIZE	15.875	0.625"	9.5x11	100	34	*	*	4/6.5	14/17	●	M4-MC	T15	4-4.5 Nm	R/LS14 R/LS55 R/LS65
614.0158.2HM INCH SIZE	15.875	0.625"	9.5x11	110	45	*	*	4/6.5	14/17	●				
614.0158.3HM INCH SIZE	15.875	0.625"	9.5x11	130	64	*	*	4/6.5	14/17	●				
614.0016.1HM	16	-	9.5x11	100	34	*	*	4/6.5	14/17	●				
614.0016.2HM	16	-	9.5x11	110	45	*	*	4/6.5	14/17	●				
614.0016.3HM	16	-	9.5x11	130	64	*	*	4/6.5	14/17	●				
614.0016.4HM	16	-	9.5x11	145	75	*	*	4/6.5	14/17	●				

U.S.A. Stock

- = In Stock
- = Express Delivery

* Dimension according insert



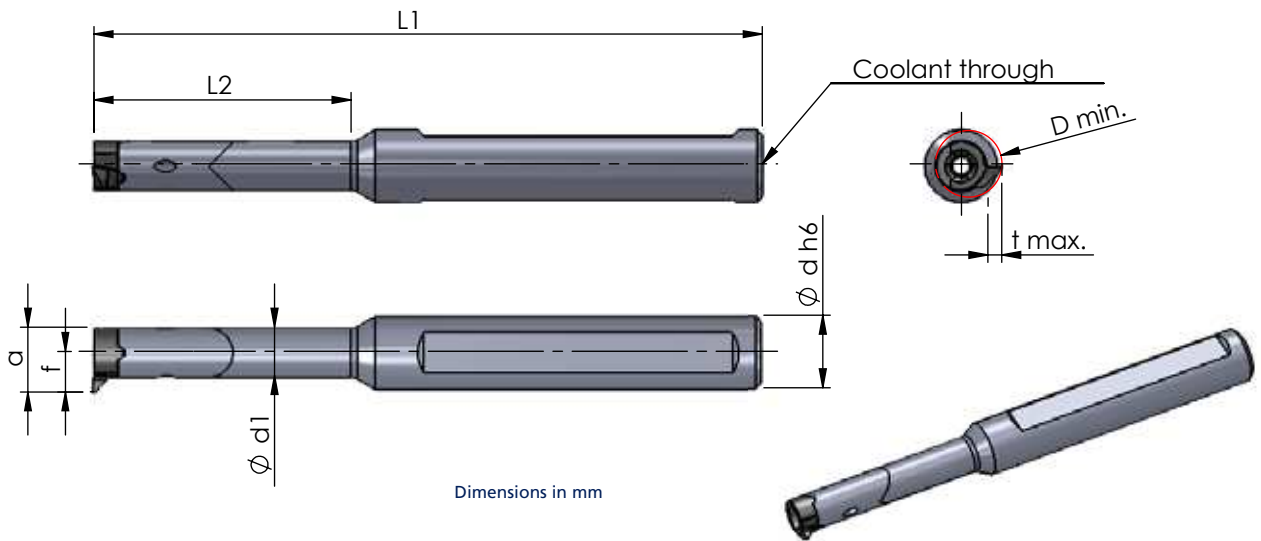
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Grooving, boring and profiling

Type 616

Tool holder carbide

Bore Ø from 7.8 mm



Dimensions in mm

part number	Ø d h6	Ø d g6 (INCH)	d1	L1	L2	f	a	t max.	D min.	U.S.A. Stock	screw	key	torque	use with insert
616.0012.1HM	12	-	11	130	40	10.2	15.7	4.3	16	●				
616.0012.2HM	12	-	11	130	56	10.2	15.7	4.3	16	●				
616.0012.3HM	12	-	11	150	80	10.2	15.7	4.3	16	●				
616.0127.1HM INCH SIZE	12.7	0.500"	11	130	40	10.2	15.7	4.3	16	●				
616.0127.2HM INCH SIZE	12.7	0.500"	11	130	56	10.2	15.7	4.3	16	●				
616.0127.3HM INCH SIZE	12.7	0.500"	11	150	80	10.2	15.7	4.3	16	●				
616.0158.1HM INCH SIZE	15.875	0.625"	11	130	40	10.2	15.7	4.3	16	●	M5-MC	T20	6-6.5 Nm	R/LS16
616.0158.2HM INCH SIZE	15.875	0.625"	11	130	56	10.2	15.7	4.3	16	●				
616.0158.3HM INCH SIZE	15.875	0.625"	11	150	80	10.2	15.7	4.3	16	●				
616.0016.1HM	16	-	11	130	40	10.2	15.7	4.3	16	●				
616.0016.2HM	16	-	11	130	56	10.2	15.7	4.3	16	●				
616.0016.3HM	16	-	11	150	80	10.2	15.7	4.3	16	●				

U.S.A. Stock

- = In Stock
- = Express Delivery

* Dimension according insert

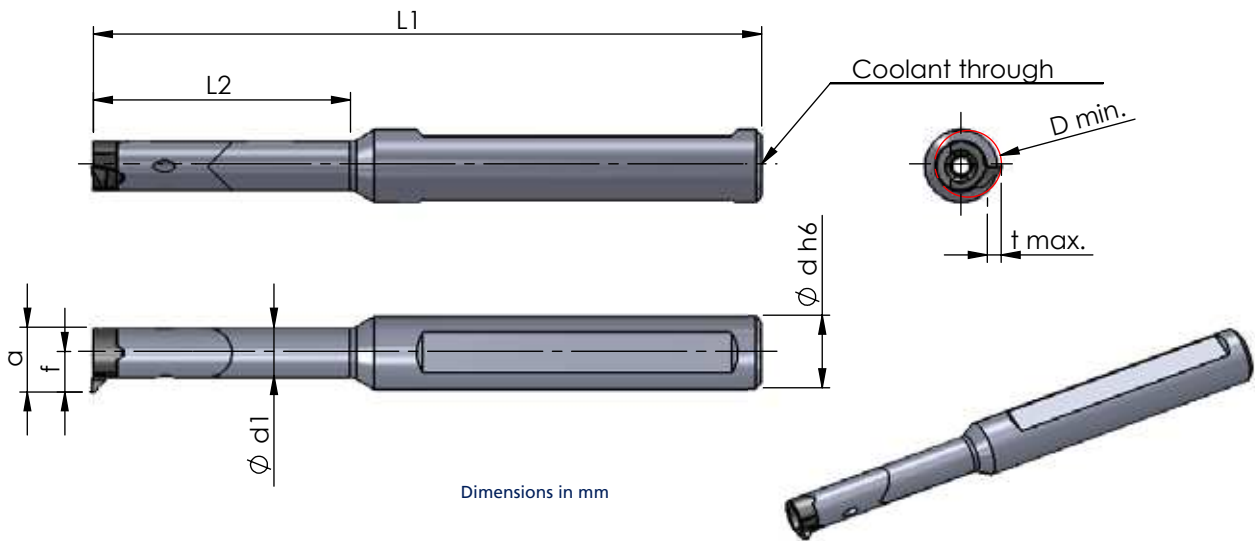
Type 618

MINICUT

Tool holder carbide

Bore Ø from 7.8 mm

Grooving, boring and profiling



part number	Ø d h6	d1	L1	L2	f	a	t max.	D min.	U.S.A. Stock	screw	key	torque	use with insert
618.0016.1HM	16	11.5	100	42	*	*	8	18	○				
618.0016.2HM	16	11.5	130	60	*	*	8	18	●				
618.0016.3HM	16	11.5	160	85	*	*	8	18	○	M5-MC	T20	6-6.5 Nm	RLS18
618.0020.3HM	20	11.5	160	85	*	*	8	18	○				

U.S.A. Stock

- = In Stock
- = Express Delivery

* Dimension according insert



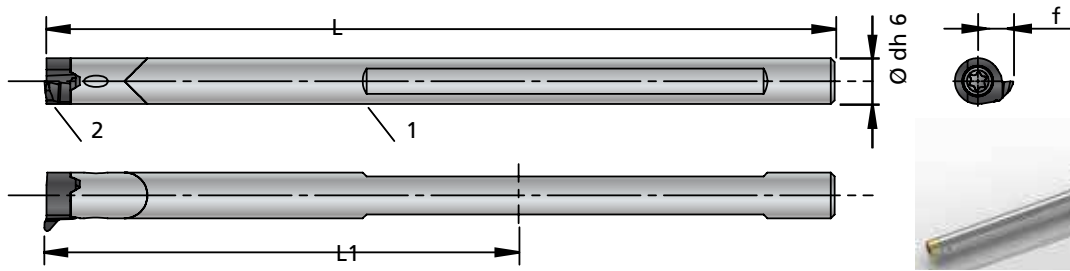
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Grooving, boring and profiling

Type V08, V11

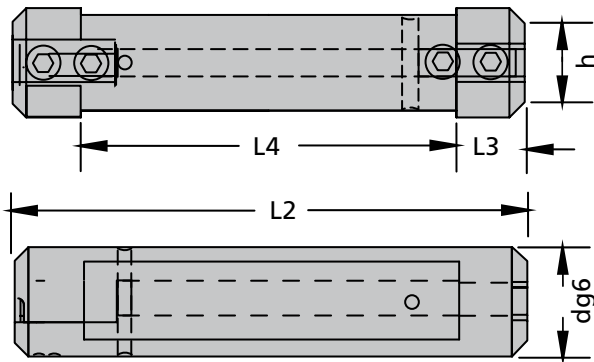
Flexo-tool holder V

Min. bore Ø from 8.0 mm



part number	D min.	d h6	L	L1 min.	L1 max.	U.S.A. Stock	insert
V08.0006.2 HM	8	6	85	18	42	○	R/LS08
V08.0006.4 HM	8	6	103	40	80	○	R/LS08
V11.0008.2 HM	11	8	79	20	55	○	R/LS11
V11.0008.4 HM	11	8	129	50	105	●	R/LS11

Tool holder basic VG



Tool holder for right and left Inserts usable

Dimensions in mm



part number	Ø d g6	L2	L3	L4	h	U.S.A. Stock	spare parts Ø toolholder	screw	key
VG08-16	16	75	10	55	14	○	16	110.687-16	111.687
VG08-20	20	90	10	70	18	○	20	110.687-20	111.687
VG11-16	16	75	10	55	14	○	16	110.687-16	111.687
VG11-20	20	90	10	70	18	●	20	110.687-20	111.687

● = In Stock
○ = Express Delivery

MINICUT

Type 614.A / 618.A

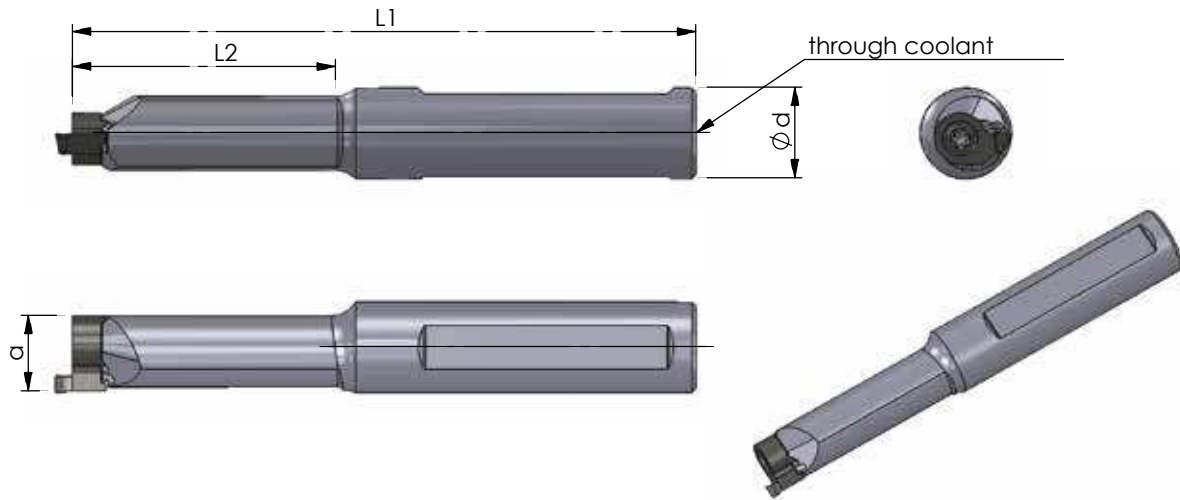
NEW



Grooving, boring and profiling

Tool holder axial face grooving

Bore Ø starting at 12 / 14 / 16 / 18 mm



Right hand tool holder - use right hand insert
Left hand tool holder - use left hand insert

Dimensions in mm



part number	Ø d g6	a	L1	L2	U.S.A. Stock	screw	key driver	torque	use with insert
R/L614.A016.35T	16	13.5	90	25	●	M4-MC	T15	4.0-4.5 Nm	R/L S014
R/L614.A016.3E.ST	16	13.5	110	45	●	M4-MC	T15	4.0-4.5 Nm	R/L S014

part number	Ø d h6	a	L1	L2	U.S.A. Stock	screw	key driver	torque	use with insert
R/L614.A016.3HM	16	13.5	120	60	●	M4-MC	T15	4.0-4.5 Nm	R/L S014

part number	Ø d g6	a	L1	L2	U.S.A. Stock	screw	key driver	torque	use with insert
NEW R/L618.A016.35T	16	16.5/17	90	30	○	M5-MC	T20	6.0-6.5 Nm	R/L S018

U.S.A. Stock

- = In Stock
- = Express Delivery

Note:
Carbide tool holder with damaged seating can be repaired by Dümmel.

Order example:
R614.A016.35T



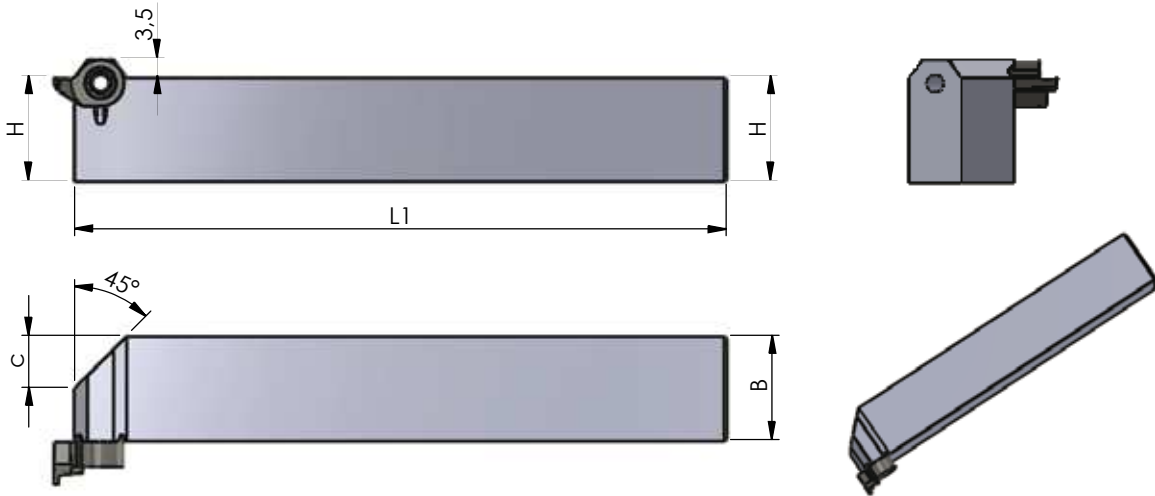
MINICUT

Type 614.SQ / 618.SQ

Grooving, boring and profiling

Tool holder steel, square shank, face grooving

Bore Ø starting at 12 / 14 / 16 / 18 mm



Drawing: Tool holder (R)
insert (L)

Please notice: Use right hand tool holder with left hand insert and vice versa.

Dimensions in mm

part number	H	B	L1	c	U.S.A. Stock	screw	key driver	torque	use with insert
NEW R/L614.SQ12.ST	12	12	100	2	○	M4-MC	T15	4.0-4.5 Nm	R/L S014
NEW R/L614.SQ16.ST	16	16	125	6	○				
NEW R/L614.SQ20.ST	20	20	125	10	○				
NEW R/L614.SQ25.ST	25	25	150	15	○				

part number	H	B	L1	c	U.S.A. Stock	screw	key driver	torque	use with insert
NEW R/L618.SQ20.ST	20	20	125	10	○	M5-MC	T20	6.0-6.5 Nm	R/L S018
NEW R/L618.SQ25.ST	25	25	150	15	○				

U.S.A. Stock

- = In Stock
- = Express Delivery

Order example:
Right hand version
R614.SQ12.ST

MINICUT

Type 614.SQ.A / 618.SQ.A

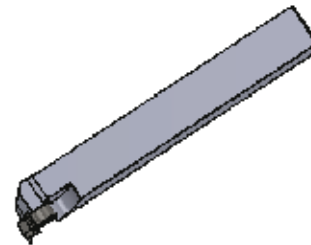
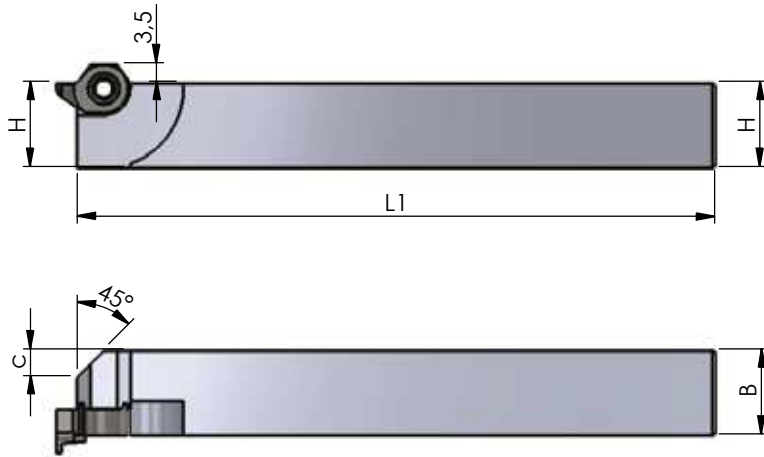
NEW



Grooving, boring and profiling

Tool holder steel, square shank, with offset, face grooving

Bore Ø starting at 12 / 14 / 16 / 18 mm



Drawing: Tool holder (R)
insert (L)
Please notice: Use right hand tool holder with left hand insert and vice versa.
Dimensions in mm



	part number	H	B	L1	c	U.S.A. Stock	screw	key driver	torque	use with insert
NEW	R/L614.SQ12.ST.A	12	12	100	4	○	M4-MC	T15	4.0-4.5 Nm	R/L S014
NEW	R/L614.SQ16.ST.A	16	16	120	5	○				
NEW	R/L614.SQ20.ST.A	20	20	120	5	○				
NEW	R/L614.SQ25.ST.A	25	25	150	9	○				

	part number	H	B	L1	c	U.S.A. Stock	screw	key driver	torque	use with insert
NEW	R/L618.SQ20.ST.A	20	20	120	5	○	M5-MC	T20	6.0-6.5 Nm	R/L S018
NEW	R/L618.SQ25.ST.A	25	25	150	9	○				

U.S.A. Stock

- = In Stock
- = Express Delivery

Order example:
Right hand version
R614.SQ12.ST.A



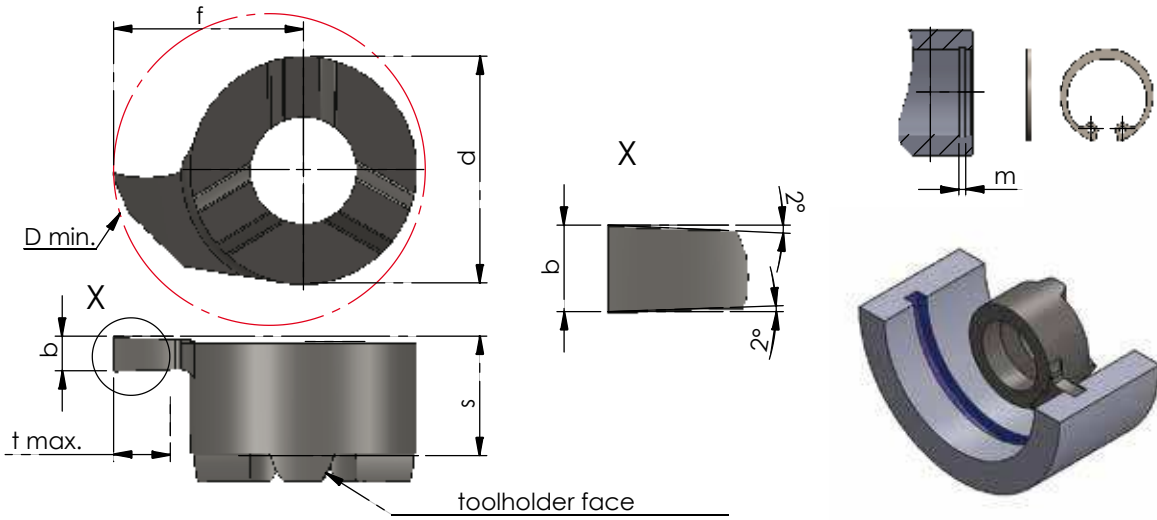
MINICUT

Type Grooving Internal

Grooving, boring and profiling

Type grooving internal,
for circlips DIN 471 / 472
and grooving

Bore Ø from 8 mm



Right hand (R): as shown
left hand version (L): mirror image

State right (R) or left (L) version

Dimensions in mm

part number	groove dim. m	DIN 471 / DIN 472	b +0.03	b (INCH)	f	s	d	t max.	D min.	U.S.A. Stock		tool holder type
										AL41F		
R/LS008.0070	0.7	☉	0.73	-	4.8	3.3	6	1.0	8	●		608
NEW R/LS008.0079 INCH SIZE	-	-	0.79	0.031"	4.8	3.3	6	1.0	8	●		
R/LS008.0080	0.8	☉	0.83	-	4.8	3.3	6	1.0	8	●		
R/LS008.0090	0.9	☉	0.93	-	4.8	3.3	6	1.0	8	●		
NEW R/LS008.0099 INCH SIZE	-	-	0.99	0.039"	4.8	3.3	6	1.0	8	●		
R/LS008.0100	-	-	1.00	-	4.8	3.3	6	1.0	8	●		
R/LS008.0110	1.1	☉	1.20	-	4.8	3.3	6	1.0	8	●		
NEW R/LS008.0117 INCH SIZE	-	-	1.17	0.046"	4.8	3.3	6	1.0	8	●		
R/LS008.0130	1.3	☉	1.40	-	4.8	3.3	6	1.0	8	●		
NEW R/LS008.0142 INCH SIZE	-	-	1.42	0.056"	4.8	3.3	6	1.0	8	●		
R/LS008.0150	-	-	1.50	-	4.8	3.3	6	1.0	8	●		
NEW R/LS008.0157 INCH SIZE	-	-	1.57	0.062"	4.8	3.3	6	1.0	8	●		
R/LS008.0160	1.6	☉	1.70	-	4.8	3.3	6	1.0	8	●		
NEW R/LS008.0198 INCH SIZE	-	-	1.98	0.078"	4.8	3.3	6	1.0	8	●		
R/LS008.0200	-	-	2.00	-	4.8	3.3	6	1.0	8	●		

U.S.A. Stock

- = Both Right & Left Hand in Stock
- = Express Delivery
- ◐ = Left Hand in Stock
- ◑ = Right Hand in Stock

More carbide grades can be found in the grades summary in the chapter "technical instructions".

Order example:
Right hand version and grade
RS008.0070/AL41F

MINICUT

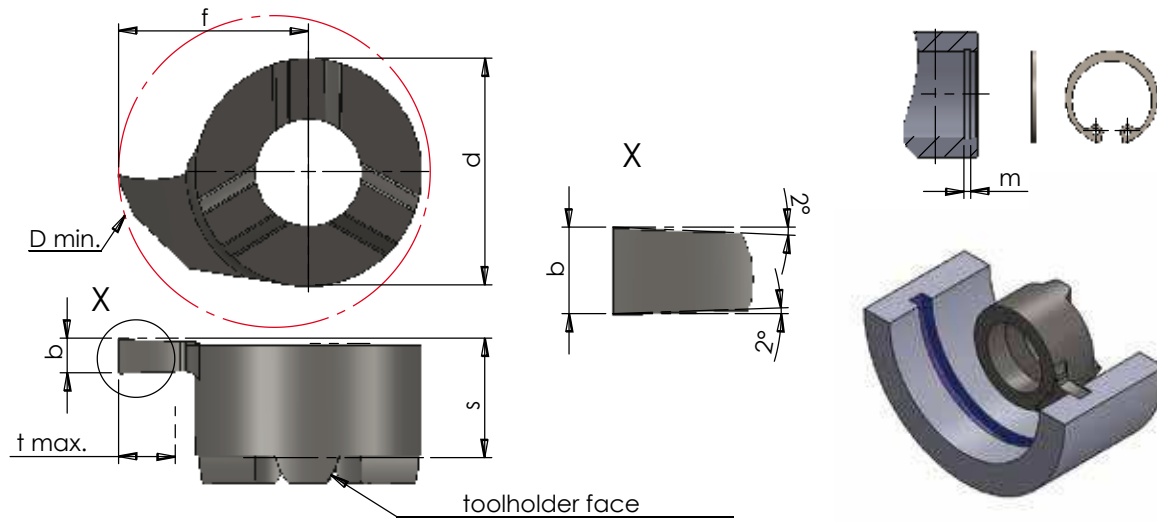
Type Grooving Internal



Grooving, boring and profiling

Type grooving internal,
for circlips DIN 471 / 472
and grooving

bore Ø from 9 mm



Right hand (R): as shown
Left hand version (L): mirror image

State right (R) or left (L) version

Dimensions in mm



part number	groove dim. m	DIN 471 / DIN 472	b +0.03	f	s	d	t max.	D min.	U.S.A. Stock	
									AL41F	tool holder type
R/LS009.0070	0.7		0.73	5.5	3.6	6.2	1.2	9	<input checked="" type="radio"/>	609
R/LS009.0080	0.8		0.83	5.5	3.6	6.2	1.3	9	<input checked="" type="radio"/>	
R/LS009.0090	0.9		0.93	5.5	3.6	6.2	1.5	9	<input checked="" type="radio"/>	
R/LS009.0100	-	-	1.00	5.5	3.6	6.2	1.8	9	<input checked="" type="radio"/>	
R/LS009.0110	1.1		1.20	5.5	3.6	6.2	1.8	9	<input checked="" type="radio"/>	
R/LS009.0130	1.3		1.40	5.5	3.6	6.2	1.8	9	<input checked="" type="radio"/>	
R/LS009.0150	-	-	1.50	5.5	3.6	6.2	1.8	9	<input checked="" type="radio"/>	
R/LS009.0160	1.6		1.70	5.5	3.6	6.2	1.8	9	<input checked="" type="radio"/>	
R/LS009.0200	-	-	2.00	5.5	3.6	6.2	1.8	9	<input checked="" type="radio"/>	
R/LS009.0250	-	-	2.50	5.5	3.6	6.2	1.8	9	<input checked="" type="radio"/>	
R/LS009.0300	-	-	3.00	5.5	3.6	6.2	1.8	9	<input checked="" type="radio"/>	

U.S.A. Stock

- = Both Right & Left Hand in Stock
- = Express Delivery
- = Left Hand in Stock
- = Right Hand in Stock

More carbide grades you can find in the grades summary in the section "technical instructions"

Order example:
right hand version and grade
RS009.0070/AL41F



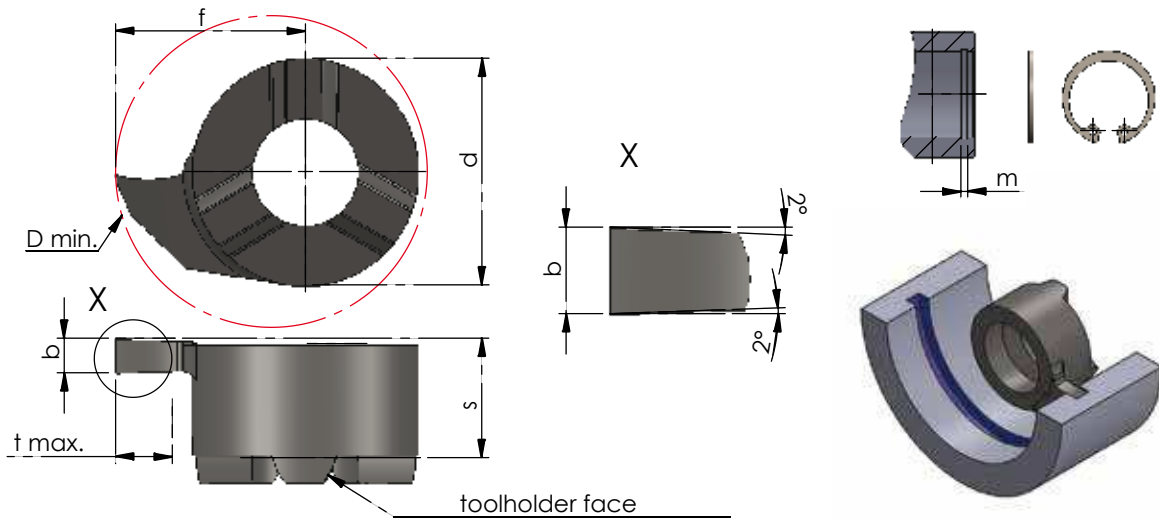
MINICUT

Type Grooving Internal

Grooving, boring and profiling

Type grooving internal,
for circlips DIN 471 / 472
and grooving

Bore Ø from 11 mm



Right hand (R): as shown
Left hand version (L): mirror image

State right (R) or left (L) version

Dimensions in mm

part number	groove dim. m	DIN 471 / DIN 472	b +0.03	b (inch)	f	s	d	t max.	D min.	U.S.A. Stock		tool holder type
										AL41F		
R/LS011.0070	0.7	☉	0.73	-	6.7	4.2	8	1.2	11	●		611
R/LS011.0080	0.8	☉	0.83	-	6.7	4.2	8	1.3	11	●		
R/LS011.0090	0.9	☉	0.93	-	6.7	4.2	8	1.5	11	●		
R/LS011.0100	-	-	1.00	-	6.7	4.2	8	2.3	11	●		
R/LS011.0110	1.1	☉	1.20	-	6.7	4.2	8	2.3	11	●		
NEW R/LS011.0117 INCH SIZE	-	-	1.17	0.046"	6.7	4.2	8	2.3	11	☉		
R/LS011.0130	1.3	☉	1.40	-	6.7	4.2	8	2.3	11	●		
R/LS011.0150	-	-	1.50	-	6.7	4.2	8	2.3	11	●		
NEW R/LS011.0157 INCH SIZE	-	-	1.57	0.062"	6.7	4.2	8	2.3	11	☉		
R/LS011.0160	1.6	☉	1.70	-	6.7	4.2	8	2.3	11	●		
R/LS011.0200	-	-	2.00	-	6.7	4.2	8	2.3	11	●		
NEW R/LS011.0238 INCH SIZE	-	-	2.38	0.094"	6.7	4.2	8	2.3	11	☉		
R/LS011.0250	-	-	2.50	-	6.7	4.2	8	2.3	11	●		
R/LS011.0300	-	-	3.00	-	6.7	4.2	8	2.3	11	☉		

U.S.A. Stock

- = Both Right & Left Hand in Stock
- ☉ = Express Delivery
- ◐ = Left Hand in Stock
- ◑ = Right Hand in Stock

More carbide grades can be found in the grades summary in the section "technical instructions".

Order example:
Right hand version and grade
RS011.0070/AL41F

MINICUT

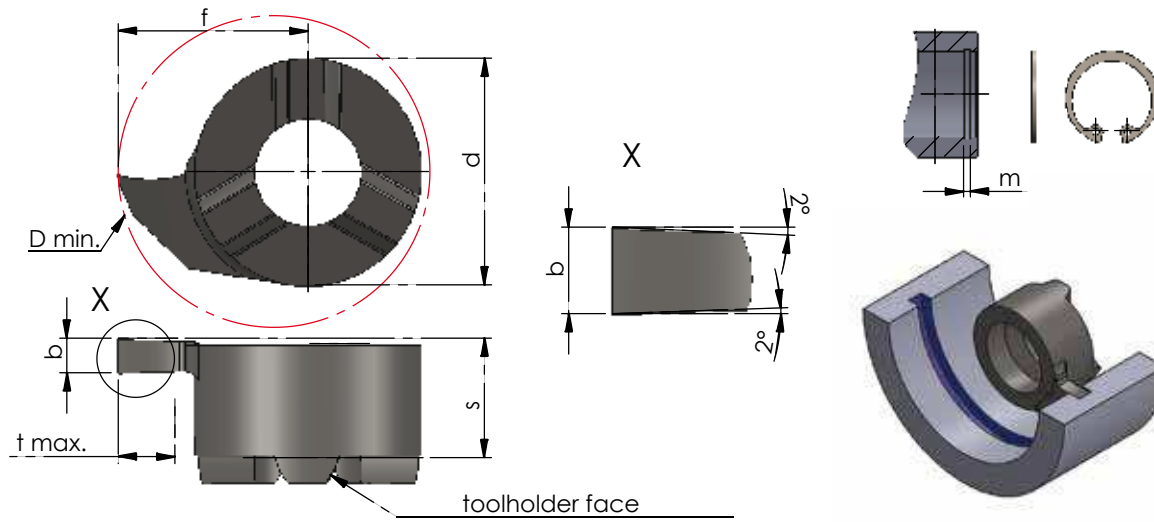
Type Grooving Internal



Grooving, boring and profiling

Type grooving internal,
for circlips DIN 471 / 472
and grooving

Bore Ø from 14 mm



Right hand (R): as shown
Left hand version (L): mirror image

State right (R) or left (L) version

Dimensions in mm



NEW

NEW

part number	groove dim. m	DIN 471 / DIN 472	b +0.03	b (inch)	f	s	d	t max.	D min.	U.S.A. Stock		tool holder type
										AL41F		
R/LS014.0070	0.7		0.73	-	9.0	5.2	9	1.2	14			614
R/LS014.0080	0.8		0.83	-	9.0	5.2	9	1.3	14			
R/LS014.0090	0.9		0.93	-	9.0	5.2	9	1.5	14			
R/LS014.0100	-	-	1.10	-	9.0	5.2	9	4.0	14			
R/LS014.0110	1.1		1.20	-	9.0	5.2	9	4.0	14			
R/LS014.0130	1.3		1.40	-	9.0	5.2	9	4.0	14			
R/LS014.0150	-	-	1.50	-	9.0	5.2	9	4.0	14			
R/LS014.0160	1.6		1.70	-	9.0	5.2	9	4.0	14			
R/LS014.0200	-	-	2.00	-	9.0	5.2	9	4.0	14			
R/LS014.0238 INCH SIZE	-	-	2.38	0.094"	9.0	5.2	9	4.0	14			
R/LS014.0250	-	-	2.50	-	9.0	5.2	9	4.0	14			
R/LS014.0300	-	-	3.00	-	9.0	5.2	9	4.0	14			

U.S.A. Stock

- = Both Right & Left Hand in Stock
- = Express Delivery
- = Left Hand in Stock
- = Right Hand in Stock

More carbide grades can be found in the grades summary in the section "technical instructions".

Order example:
Right hand version and grade
RS014.0070/AL41F



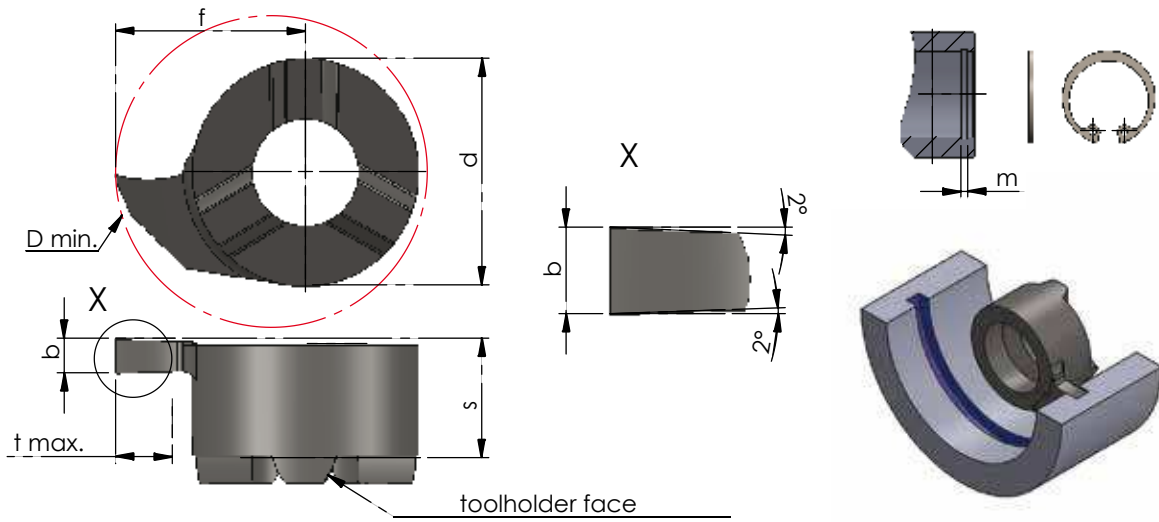
MINICUT

Type Grooving Internal

Grooving, boring and profiling

Type grooving internal,
for circlips DIN 471 / 472
and grooving

Bore Ø from 16 mm



Right hand (R): as shown
Left hand version (L): mirror image

State right (R) or left (L) version

Dimensions in mm

part number	groove dim. m	DIN 471 / DIN 472	b +0.03	b (inch)	f	s	d	t max.	D min.	U.S.A. Stock		tool holder type
										AL41F		
R/LS016.0070	0.7		0.73	-	10.2	5.4	11	1.2	16			616
R/LS016.0080	0.8		0.83	-	10.2	5.4	11	1.3	16			
R/LS016.0090	0.9		0.93	-	10.2	5.4	11	1.5	16			
R/LS016.0110	1.1		1.20	-	10.2	5.4	11	4.3	16			
NEW R/LS016.0117 INCH SIZE	-	-	1.17	0.046"	10.2	5.4	11	4.3	16			
R/LS016.0130	1.3		1.40	-	10.2	5.4	11	4.3	16			
R/LS016.0150	-	-	1.50	-	10.2	5.4	11	4.3	16			
NEW R/LS016.0157 INCH SIZE	-	-	1.57	0.062"	10.2	5.4	11	4.3	16			
R/LS016.0160	1.6		1.70	-	10.2	5.4	11	4.3	16			
R/LS016.0200	-	-	2.00	-	10.2	5.4	11	4.3	16			
NEW R/LS016.0238 INCH SIZE	-	-	2.38	0.094"	10.2	5.4	11	4.3	16			
R/LS016.0250	-	-	2.50	-	10.2	5.4	11	4.3	16			
R/LS016.0300	-	-	3.00	-	10.2	5.4	11	4.3	16			
R/LS016.0350	-	-	3.50	-	10.2	5.4	11	4.3	16			
R/LS016.0400	-	-	4.00	-	10.2	5.4	11	4.3	16			

U.S.A. Stock

- = Both Right & Left Hand in Stock
- = Express Delivery
- = Left Hand in Stock
- = Right Hand in Stock

More carbide grades can be found in the grades summary in the section "technical instructions".

Order example:
Right hand version and grade
RS016.0070/AL41F

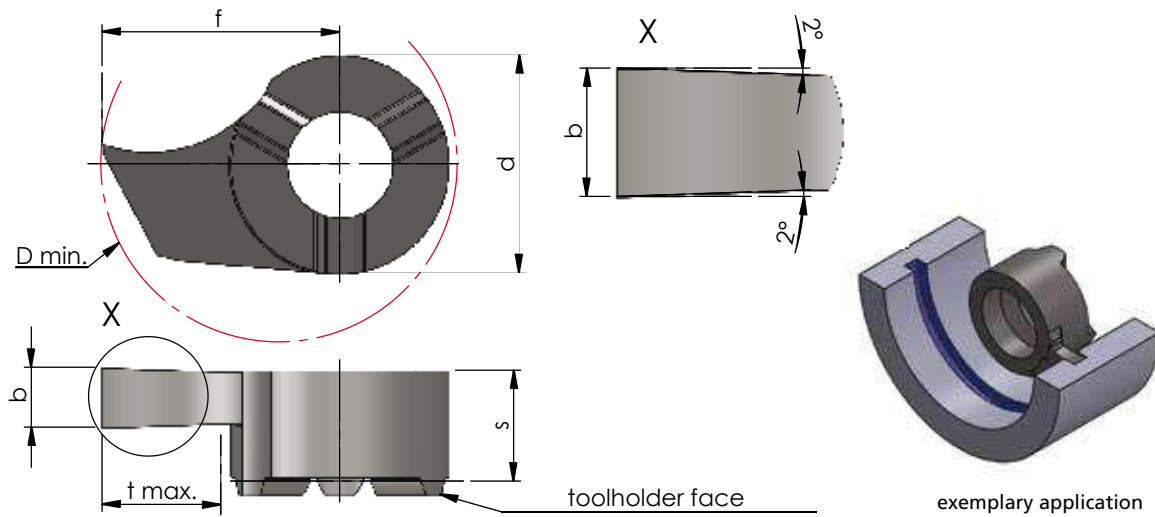
MINICUT

Type Grooving Internal

Grooving, boring and profiling

Type grooving internal,
general use

Bore Ø from 18 / 20 mm



Right hand (R): as shown
Left hand version (L): mirror image

State right (R) or left (L) version

Dimensions in mm



part number	b +0.03	f	s	d	t max.	D min.	U.S.A. Stock	tool holder type
							AL41F	
R/LS18.0150.00	1.5	12	5.6	11	6.0	18	○	618
R/LS18.0200.00	2.0	12	5.6	11	6.0	18	○	
R/LS18.0250.00	2.5	12	5.6	11	6.0	18	○	
R/LS18.0300.00	3.0	12	5.6	11	6.0	18	○	
R/LS18.0350.00	3.5	12	5.6	11	6.0	18	○	
R/LS18.0400.00	4.0	12	5.6	11	6.0	18	○	
R/LS20.0150.00	1.5	14	5.6	11	8.0	20	○	
R/LS20.0200.00	2.0	14	5.6	11	8.0	20	○	
R/LS20.0250.00	2.5	14	5.6	11	8.0	20	○	
R/LS20.0300.00	3.0	14	5.6	11	8.0	20	○	
R/LS20.0350.00	3.5	14	5.6	11	8.0	20	○	
R/LS20.0400.00	4.0	14	5.6	11	8.0	20	○	

More carbide grades can be found in the grades summary in the section "technical instructions".

Order example:
Right hand version and grade
RS20.0150.00/AL41F



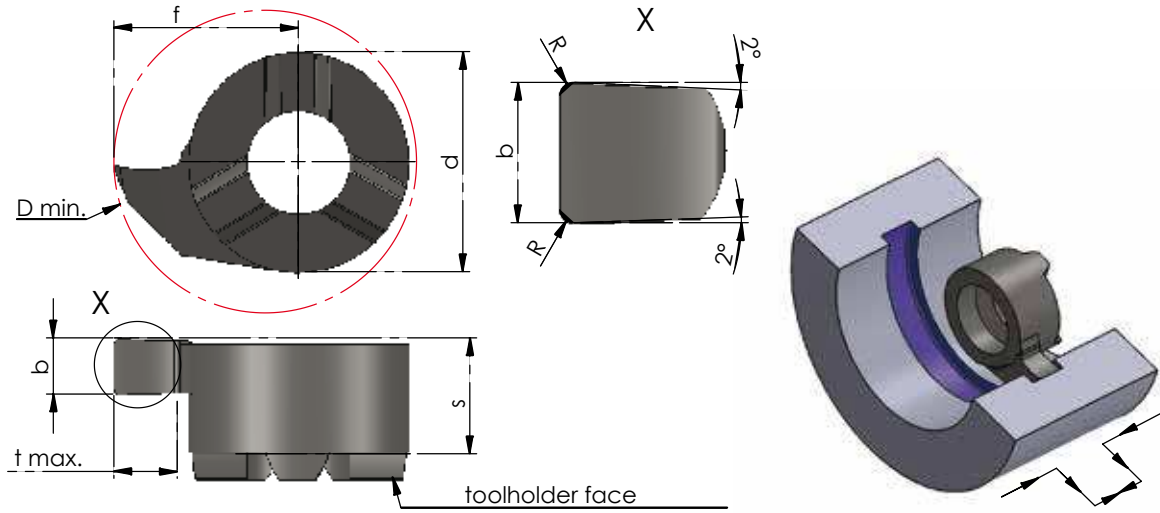
MINICUT

Type NC - Profiling Internal

Grooving, boring and profiling

NC-profiling, internal

Bore Ø from 8 - 16 mm



Right hand (R): as shown
 Left hand version (L): mirror image
 State right (R) or left (L) version
 Dimensions in mm

part number	b +0.03	b (inch)	R	f	s	d	Ap max.*	t max.	D min.	U.S.A. Stock	tool holder type
										AL41F	
NEW R/LS08.079.02 INCH SIZE	0.79	0.031"	0.2	4.8	3.3	6	0.2	1.0	8	●	608
NEW R/LS08.117.02 INCH SIZE	1.17	0.046"	0.2	4.8	3.3	6	0.2	1.0	8	●	
R/LS08.150.02	1.5	-	0.2	4.8	3.3	6	0.2	1.0	8	●	
NEW R/LS08.157.02 INCH SIZE	1.57	0.062"	0.2	4.8	3.3	6	0.2	1.0	8	●	
NEW R/LS08.198.02 INCH SIZE	1.98	0.078"	0.2	4.8	3.3	6	0.2	1.0	8	●	
R/LS08.200.02	2.0	-	0.2	4.8	3.3	6	0.2	1.0	8	●	609
R/LS09.150.02	1.5	-	0.2	5.5	3.6	6.2	0.2	1.8	9	○	
R/LS09.200.02	2.0	-	0.2	5.5	3.6	6.2	0.2	1.8	9	○	
R/LS09.150.02.10	1.5	-	0.2	6.5	3.6	6.2	0.2	2.8	10	○	
R/LS09.200.02.10	2.0	-	0.2	6.5	3.6	6.2	0.2	2.8	10	○	

U.S.A. Stock

- = Both Right & Left Hand in Stock
- = Express Delivery
- ◐ = Left Hand in Stock
- ◑ = Right Hand in Stock

*Ap max. = maximum depth of cut (depending on material)

More carbide grades can be found in the grades summary in the section "technical instructions".

Order example: Right hand version and grade RS14.200.02/AL41F

MINICUT

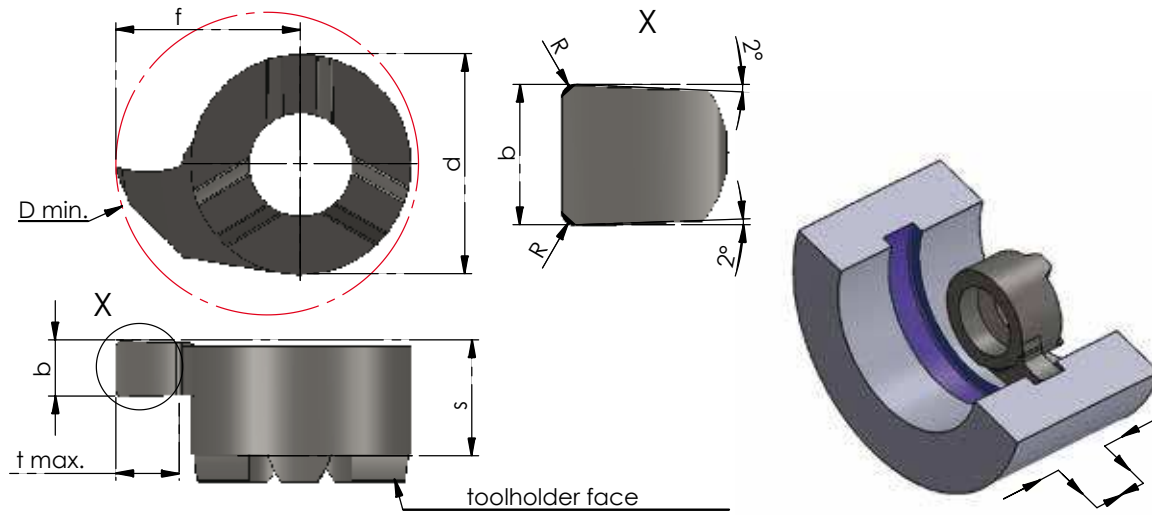
Type NC - Profiling Internal



Grooving, boring and profiling

NC-profiling, internal

Bore Ø from 8 - 16 mm



Right hand (R): as shown
 Left hand version (L): mirror image
 State right (R) or left (L) version
 Dimensions in mm



part number	b +0.03	b (inch)	R	f	s	d	Ap max.*	t max.	D min.	U.S.A. Stock		tool holder type
										AL41F		
NEW R/LS11.079.02 INCH SIZE	0.79	0.031"	0.2	6.7	4.2	8	0.2	2.3	11	●	○	611
NEW R/LS11.117.02 INCH SIZE	1.17	0.046"	0.2	6.7	4.2	8	0.2	2.3	11	●	○	
R/LS11.150.02	1.5	-	0.2	6.7	4.2	8	0.2	2.3	11	●	●	
NEW R/LS11.157.02 INCH SIZE	1.57	0.062"	0.2	6.7	4.2	8	0.2	2.3	11	●	○	
NEW R/LS11.198.02 INCH SIZE	1.98	0.078"	0.2	6.7	4.2	8	0.2	2.3	11	●	○	
R/LS11.200.02	2.0	-	0.2	6.7	4.2	8	0.2	2.3	11	●	●	
NEW R/LS11.238.02 INCH SIZE	2.38	0.094"	0.2	6.7	4.2	8	0.2	2.3	11	●	○	
NEW R/LS11.318.02 INCH SIZE	3.18	0.125"	0.2	6.7	4.2	8	0.2	2.3	11	●	○	
R/LS14.150.02	1.5	-	0.2	9.0	5.3	9	0.2	4.0	14	●	●	614
NEW R/LS14.157.02 INCH SIZE	1.57	0.062"	0.2	9.0	5.3	9	0.2	4.0	14	●	○	
R/LS14.200.02	2.0	-	0.2	9.0	5.3	9	0.2	4.0	14	●	●	
NEW R/LS16.157.02 INCH SIZE	1.57	0.062"	0.2	10.2	5.4	11	0.2	4.3	16	●	○	616
R/LS16.200.02	2.00	-	0.2	10.2	5.4	11	0.2	4.3	16	●	●	

U.S.A. Stock

- = Both Right & Left Hand in Stock
- = Express Delivery
- ◐ = Left Hand in Stock
- ◑ = Right Hand in Stock

*Ap max. = maximum depth of cut (depending on material)

More carbide grades can be found in the grades summary in the section "technical instructions".

Order example: Right hand version and grade RS14.200.02/AL41F



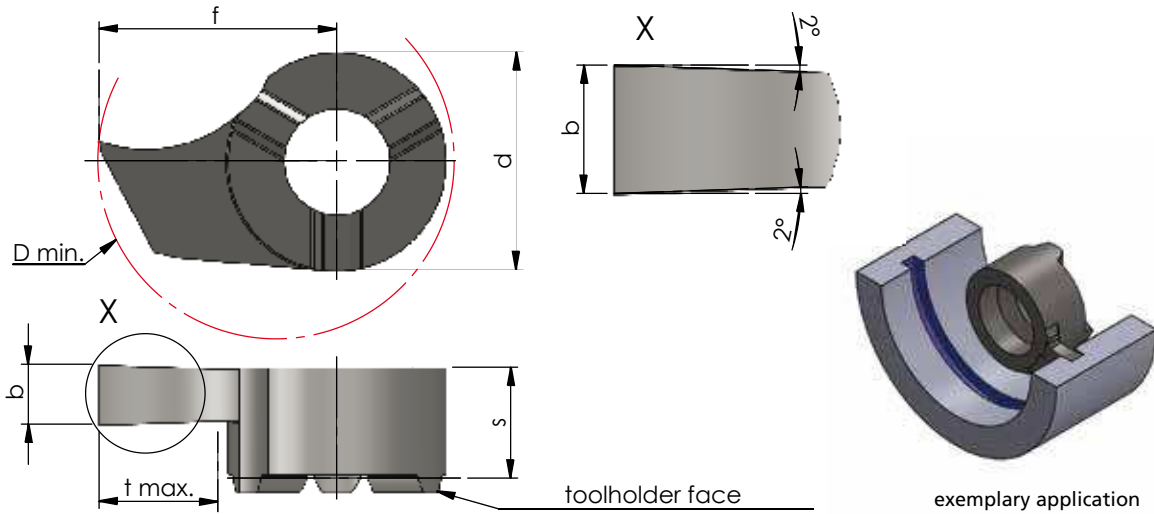
MINICUT

Grooving, boring and profiling

Type Grooving Internal

Type grooving internal, general use, maximum depth of groove

Bore Ø from 16 / 17 mm



Right hand (R): as shown
 Left hand version (L): mirror image
 State right (R) or left (L) version
 Dimensions in mm

part number	b +0.03	f	s	d	t max.	D min.	U.S.A. Stock	tool holder type
							AL41F	
R/LS55.150.00	1.5	10.5	5.2	9	5.5	16	●	614
R/LS55.200.00	2.0	10.5	5.2	9	5.5	16	○	
R/LS55.250.00	2.5	10.5	5.2	9	5.5	16	○	
R/LS55.300.00	3.0	10.5	5.2	9	5.5	16	○	
R/LS65.150.00	1.5	11.5	5.2	9	6.5	17	○	
R/LS65.200.00	2.0	11.5	5.2	9	6.5	17	●	
R/LS65.250.00	2.5	11.5	5.2	9	6.5	17	○	
R/LS65.300.00	3.0	11.5	5.2	9	6.5	17	○	

More carbide grades can be found in the grades summary in the section "technical instructions".

Order -example:
 Right hand version and grade
 RS55.150.00/AL41F

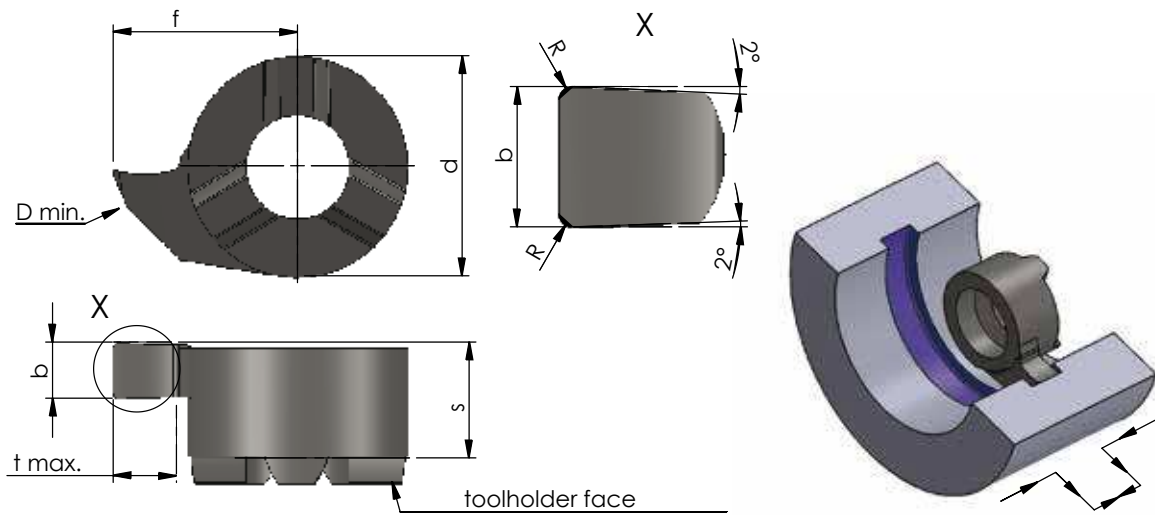
MINICUT

Type Grooving Internal

Grooving, boring and profiling

Type NC-profiling, internal,
maximum depth of groove

Bore Ø from 16 / 17 mm



Right hand (R): as shown
Left hand version (L): mirror image

State right (R) or left (L) version

Dimensions in mm



part number	b +0.03	R	f	s	d	t max.	D min.	U.S.A. Stock	tool holder type
								AL41F	
R/LS55.150.02	1.5	0.2	10.5	5.2	9	5.5	16	●	614
R/LS55.200.02	2.0	0.2	10.5	5.2	9	5.5	16	●	
R/LS55.250.02	2.5	0.2	10.5	5.2	9	5.5	16	●	
R/LS55.300.02	3.0	0.2	10.5	5.2	9	5.5	16	●	
R/LS65.150.02	1.5	0.2	11.5	5.2	9	6.5	17	●	
R/LS65.200.02	2.0	0.2	11.5	5.2	9	6.5	17	●	
R/LS65.250.02	2.5	0.2	11.5	5.2	9	6.5	17	●	
R/LS65.300.02	3.0	0.2	11.5	5.2	9	6.5	17	●	

U.S.A. Stock

- = Both Right & Left Hand in Stock
- = Express Delivery
- ◐ = Left Hand in Stock
- ◑ = Right Hand in Stock

More carbide grades can be found in the grades summary in the section "technical instructions".

Order example:
Right hand version and grade
RS55.150.02/AL41F



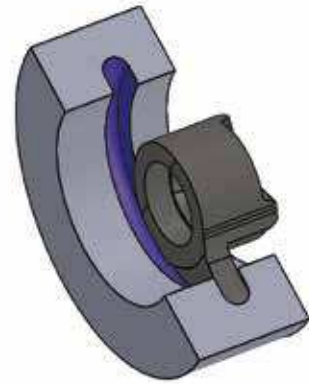
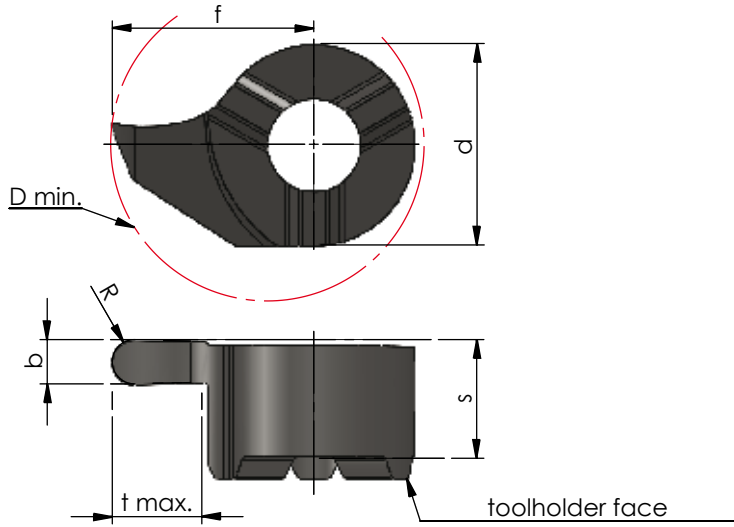
MINICUT

Grooving, boring and profiling

Type Grooving Internal

Type grooving internal, full radius

Bore Ø from 8 / 9 / 11 mm



Right hand (R): as shown
Left hand version (L): mirror image

State right (R) or left (L) version

Dimensions in mm

part number	b +0.05	R	f	s	d	t max.	D min.	U.S.A. Stock	tool holder type
								AL41F	
R/LS08.008R04	0.8	0.4	4.8	3.3	6	1.0	8	☉	608
R/LS08.012R06	1.2	0.6	4.8	3.3	6	1.0	8	☉	
R/LS08.018R09	1.8	0.9	4.8	3.3	6	1.0	8	●	
R/LS08.020R10	2.0	1.0	4.8	3.3	6	1.0	8	○	
R/LS09.008R04	0.8	0.4	5.5	3.5	6.2	1.6	9	○	609
R/LS09.012R06	1.2	0.6	5.5	3.5	6.2	1.6	9	○	
R/LS09.018R09	1.8	0.9	5.5	3.5	6.2	1.6	9	○	
R/LS09.020R10	2.0	1.0	5.5	3.5	6.2	1.6	9	○	
R/LS11.008R04	0.8	0.4	6.7	4.2	8	2.3	11	●	611
R/LS11.012R06	1.2	0.6	6.7	4.2	8	2.3	11	☉	
R/LS11.016R08	1.6	0.8	6.7	4.2	8	2.3	11	○	
R/LS11.018R09	1.8	0.9	6.7	4.2	8	2.3	11	☉	
R/LS11.020R10	2.0	1.0	6.7	4.2	8	2.3	11	●	
R/LS11.024R12	2.4	1.2	6.7	4.2	8	2.3	11	○	
R/LS11.030R15	3.0	1.5	6.7	4.2	8	2.3	11	●	

U.S.A. Stock

- = Both Right & Left Hand in Stock
- = Express Delivery
- ☉ = Left Hand in Stock
- = Right Hand in Stock

More carbide grades can be found in the grades summary in the section "technical instructions".

Order example:
Right hand version and grade
RS08.008R04/AL41F

MINICUT

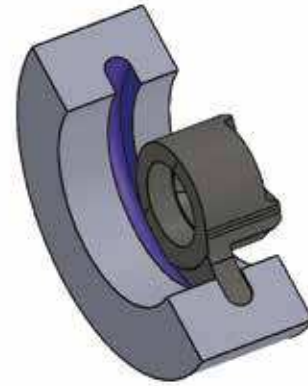
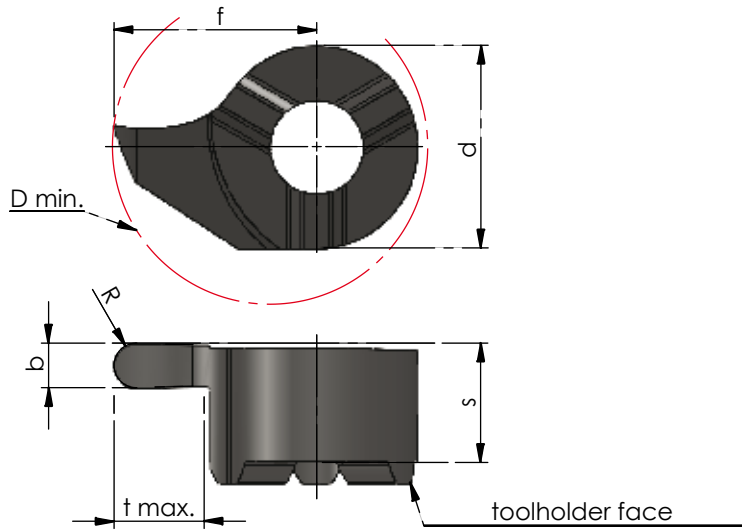
Type Grooving Internal



Grooving, boring and profiling

Type grooving internal,
full radius

Bore Ø starting at 14 / 16 mm



Right hand (R): as shown
Left hand version (L): mirror image

State right (R) or left (L) version

Dimensions in mm



NEW

part number	b +0.05	b (inch)	R	f	s	d	t max.	D min.	U.S.A. Stock		tool holder type
									AL41F		
R/LS14.008R04	0.8	-	0.4	9	5.3	9	4	14	○		614
R/LS14.012R06	1.2	-	0.6	9	5.3	9	4	14	●		
R/LS14.U15R08 INCH SIZE	1.57	0.062"	0.78	9	5.3	9	4	14	◐		
R/LS14.018R09	1.8	-	0.9	9	5.3	9	4	14	◑		
R/LS14.020R10	2.0	-	1.0	9	5.3	9	4	14	●		
R/LS14.022R11	2.2	-	1.1	9	5.3	9	4	14	◐		
R/LS14.030R15	3.0	-	1.5	9	5.3	9	4	14	●		
R/LS16.016R08	1.6	-	0.8	10.2	5.4	11	4.3	16	○		616
R/LS16.018R09	1.8	-	0.9	10.2	5.4	11	4.3	16	◐		
R/LS16.020R10	2.0	-	1.0	10.2	5.4	11	4.3	16	○		
R/LS16.022R11	2.2	-	1.1	10.2	5.4	11	4.3	16	◑		
R/LS16.024R12	2.4	-	1.2	10.2	5.4	11	4.3	16	○		
R/LS16.030R15	3.0	-	1.5	10.2	5.4	11	4.3	16	◐		
R/LS16.032R16	3.2	-	1.6	10.2	5.4	11	4.3	16	○		
R/LS16.040R20	4.0	-	2.0	10.2	5.4	11	4.3	16	◑		

U.S.A. Stock

- = Both Right & Left Hand in Stock
- = Express Delivery
- ◐ = Left Hand in Stock
- ◑ = Right Hand in Stock

More carbide grades can be found in the grades summary in the section "technical instructions".

Order example:
Right hand version and grade
RS14.012R06/AL41F



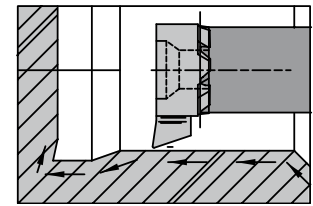
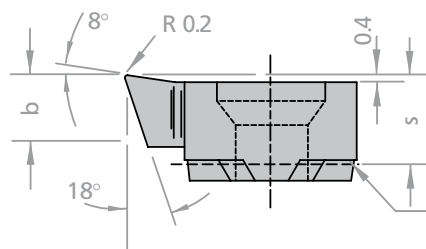
Inserts

Internal with CBN boring and copying of hardened parts

Min. bore \varnothing from 7.8 / 11 / 13.8 / 15.5 mm

MINICUT

Grooving, boring and profiling



Right hand (R): as shown
Left hand version (L): mirror image

State right (R) or left (L) version

Dimensions in mm



part number	U.S.A. Stock						tool holder type	standard carbide grade
	b	f	s	d	D min.	CBN		
R/LS08.1846.02/CBN	3.30	4.65	3.5	6	7.8	○	608	CBN
R/LS11.1867.02/CBN	3.90	6.70	4.2	8	11.0	○	611	
R/LS14.1887.02/CBN	5.00	8.70	5.3	9	13.8	○	614	
R/LS16.1897.02/CBN	5.00	9.70	5.4	11	15.5	○	616	

U.S.A. Stock

- = Both Right & Left Hand in Stock
- = Express Delivery
- ◐ = Left Hand in Stock
- ◑ = Right Hand in Stock

See pages 105 through 115 for tool holders

Order example:
Right hand version and grade CBN:
RS08.1846.02/CBN

MINICUT

Inserts

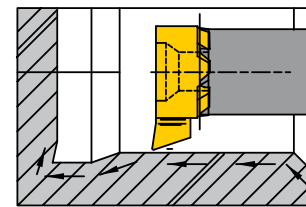
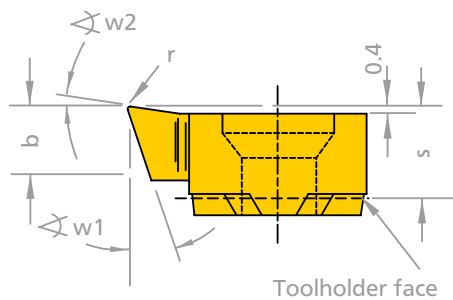
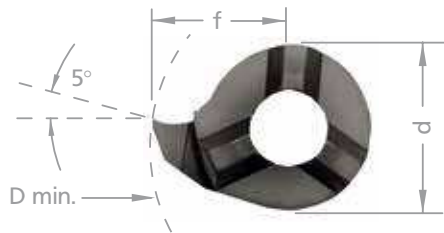
NEW



Grooving, boring and profiling

Boring and copying internal

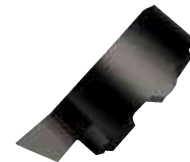
Min. bore Ø
from 7.8 / 9 / 9.8 / 11 /
13.8 / 14 / 15.5 mm



Right hand (R): as shown
Left hand version (L): mirror image

State right (R) or left (L) version

Dimensions in mm



part number	b	w1	w2	r	f	s	d	Ap max.*	D min.	AL41F	tool holder type	standard carbide grade
NEW R/LS08.1846.005	3.04	18°	8°	0.05	4.65	3.5	6	0.6	7.8	○	608	AL41F (=TiAlN)
R/LS08.1846.02	3.3	18°	8°	0.2	4.65	3.5	6	0.6	7.8	◐		
NEW R/LS08.2046.02	3.4	20°	20°	0.2	4.65	3.5	6	0.6	7.8	○		
NEW R/LS09.1855.02	3.5	18°	8°	0.2	5.5	3.6	6.2	0.8	9	○	609	
NEW R/LS09.2055.02	3.5	20°	20°	0.2	5.5	3.6	6.2	0.8	9	○		
R/LS11.1855.02	3.9	18°	8°	0.2	5.5	4.2	8	1	9.8	●	611	
R/LS11.1867.02	3.9	18°	8°	0.2	6.7	4.2	8	1	11	●		
NEW R/LS11.2067.02	4.1	20°	20°	0.2	6.7	4.2	8	1	11	○		
R/LS14.1887.02	5	18°	8°	0.2	8.7	5.3	9	1.5	13.8	●	614	
NEW R/LS14.2087.02	5.2	20°	20°	0.2	8.7	5.3	9	1.5	14	◐		
NEW R/LS16.1897.02	5	18°	8°	0.2	9.7	5.4	11	1.5	15.5	●	616	

U.S.A. Stock

- = Both Right & Left Hand in Stock
- = Express Delivery
- ◐ = Left Hand in Stock
- ◑ = Right Hand in Stock

* Ap. max = maximum depth of cut (depending on material)

For use with toolholder:
608 / 609 / 611 / 614 / 616 see pages 105 through 115

Order example: right hand version and grade AL41F: RS08.1846.02/AL41F

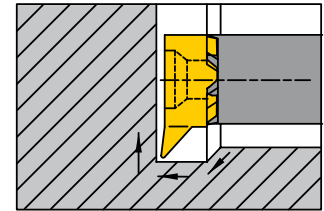
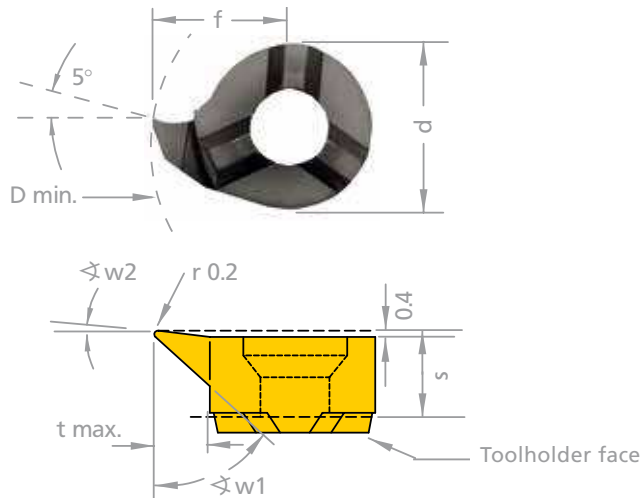


Inserts

MINICUT

Boring and profiling
undercuts DIN 509 and copying

Min. bore Ø
from 7.8 / 9 / 11 / 13.7 / 15.8 / 18 / 20 mm



Right hand (R): as shown
Left hand version (L): mirror image

State right (R) or left (L) version

Dimensions in mm



Boring and profiling undercuts (DIN 509)

part number	w1	w2	f	s	d	Ap max.*	t max.	D min.	U.S.A. Stock		toolholder type	standard carbide grade
									AL41F			
R/LS08.4746.02	47°	3°	4.65	3.5	6	0.4	1.2	7.8	●		608	AL41F (=TiAlN)
R/LS09.4755.02	47°	3°	5.5	3.6	6.2	0.5	1.5	9	○		609	
R/LS11.4767.02	47°	3°	6.7	4.2	8	0.6	2.3	11	●		611	
R/LS14.4787.02	47°	3°	8.7	5.3	9	0.8	3	13.7	●		614	
R/LS16.4710.02	47°	3°	10.2	5.4	11	1	4.3	15.8	◐		616	
R/LS18.4712.02	47°	3°	12	5.6	11	1	6	18	○		618	
R/LS20.4714.02	47°	3°	14	5.6	11	1.2	8	20	○		618	

U.S.A. Stock

- = Both Right & Left Hand in Stock
- = Express Delivery
- ◐ = Left Hand in Stock
- ◑ = Right Hand in Stock

* Ap. max = maximum depth of cut (depending on material)

For use with tool holder 608 / 609 / 611 / 614 / 616 / 618: see page 105 through 115

Order example:
right hand version and grade AL41F:
RS08.4746.02/AL41F

MINICUT

Inserts



Boring and profiling
undercuts DIN 509 and copying

Min. bore Ø
from 7.8 / 11 / 13.7 / 15.8 mm

Copying

part number	w1	w2	f	s	d	Ap max.*	t max.	D min.	U.S.A. Stock		tool holder type	standard carbide grade
									AL41F			
R/LS08.2555.02	30°	5°	4.65	3.5	6	0.4	1.2	7.8	●		608	AL41F (=TiAlN)
R/LS11.2755.02	30°	5°	6.7	4.2	8	0.6	2.3	11	◐		611	
R/LS14.3555.02	30°	5°	8.7	5.3	9	0.8	4	13.7	◑		614	
R/LS16.4055.02	30°	5°	10.2	5.4	11	0.8	4.3	15.8	◒		616	



U.S.A. Stock

- = Both Right & Left Hand in Stock
- = Express Delivery
- ◐ = Left Hand in Stock
- ◑ = Right Hand in Stock

* Ap. max = maximum depth of cut
(depending on material)

For use with toolholder 608 / 611 / 614 / 616:
see pages 105 through 115

Order example:
Right hand version and grade AL41F:
RS08.3046.02/AL41F



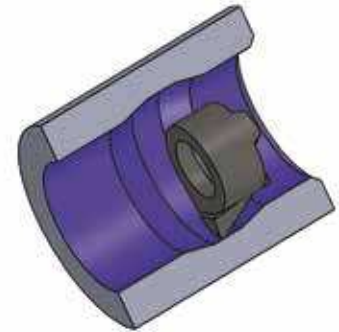
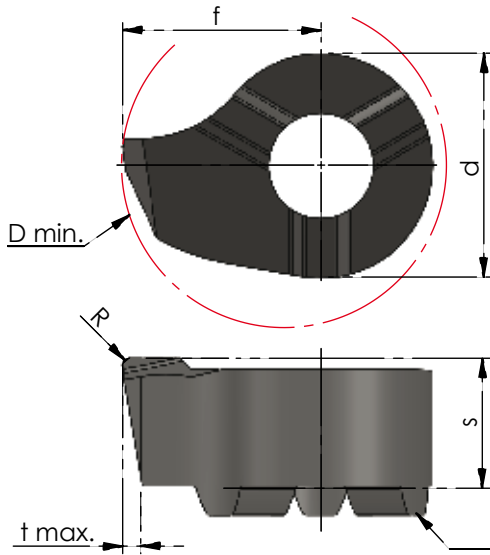
MINICUT

Type Boring Internal

Grooving, boring and profiling

Boring with special chipformer

Bore Ø from 8 / 9 / 11 mm



toolholder face

exemplary application

Right hand (R): as shown
 Left hand version (L): mirror image
 State right (R) or left (L) version
 Dimensions in mm

Part number	R	f	s	d	Ap max.*	t max.	D min.	U.S.A. Stock	tool holder type
								AL41F	
NEW R/LS08.046C.02	0.2	4.65	3.5	6.0	0.4	0.5	8	●	608
R/LS09.055C.02	0.2	5.5	3.6	6.2	0.5	0.5	9	○	609
NEW R/LS11.067C.02	0.2	6.7	4.2	8.0	0.6	0.5	11	●	611

U.S.A. Stock

- = Both Right & Left Hand in Stock
- = Express Delivery
- ◐ = Left Hand in Stock
- ◑ = Right Hand in Stock

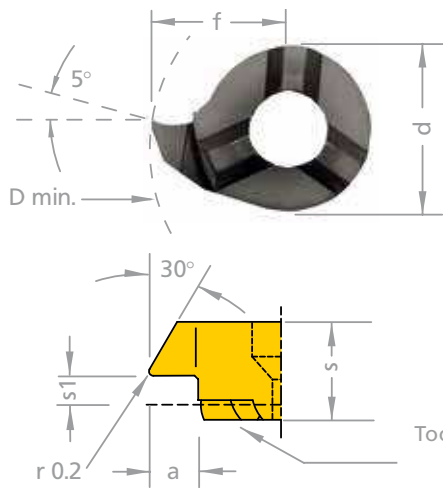
*Ap max. = maximum depth of cut (depending on material)

More carbide grades can be found in the grades summary in the section "technical instructions".
 Order example: Right hand version and grade R/LS09.055C.02/AL41F

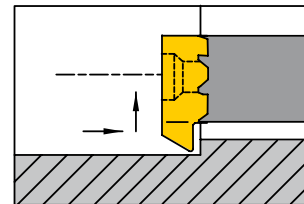


Boring by backward motion internal

Min. bore Ø from 7.8 / 9 / 10 / 11 / 13.8 mm



Toolholder face



Right hand (R): as shown
Left hand version (L): mirror image

State right (R) or left (L) version

Dimensions in mm



part number	f	s	s1	d	Ap max.*	a	D min.	U.S.A. Stock		tool holder type	standard carbide grade
								AL41F			
R/LS08.3046.02	4.65	3.5	1	6	0.6	1.3	7.8	●		608	AL41F (=TiAlN)
R/LS09.3055.02	5.5	3.55	1.2	6.2	0.8	1.7	9	○		609	
R/LS09.3065.02	6.5	3.55	1.2	6.2	0.8	2.3	10	○			
R/LS11.3067.02	6.7	4.3	1.6	8	1	2.3	11	●		611	
R/LS14.3087.02	8.7	5.4	2.4	9	1.5	3.5	13.8	●		614	

U.S.A. Stock

- = Both Right & Left Hand in Stock
- = Express Delivery
- ◐ = Left Hand in Stock
- ◑ = Right Hand in Stock

* Ap. max = maximum depth of cut (depending on material)

For use with toolholder 608 / 609 / 611 / 614: see pages 105 through 115

Order example:
Right hand version and grade AL41F:
RS08.3046.02/AL41F



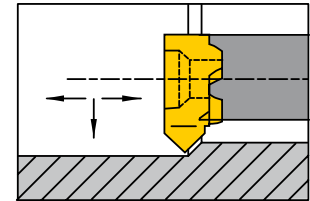
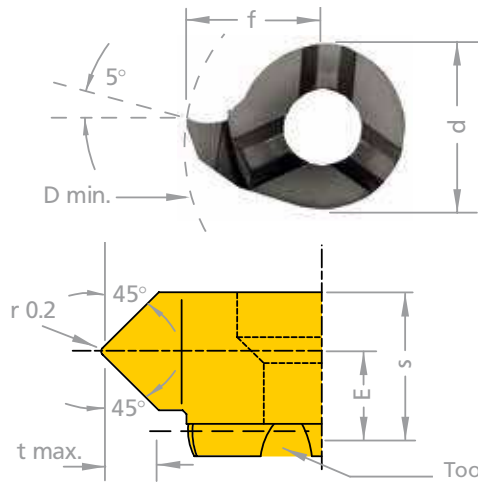
MINICUT

Grooving, boring and profiling

Inserts

Chamfering and profiling internal

Min. bore Ø from 8 / 9 / 11 / 14 mm



Toolholder face

Right hand (R): as shown
Left hand version (L): mirror image

State right (R) or left (L) version

Dimensions in mm



part number	f	s	d	E	Ap max.*	t max.	D min.	U.S.A. Stock		tool holder type	standard carbide grade
								AL41F			
R/LS08.4545.02	4.8	3.5	6	1.8	0.6	1.4	8	●		608	AL41F (=TiAlN)
R/LS09.4545.02	5.5	3.55	6.2	1.8	0.8	1.3	9	○		609	
R/LS11.4545.02	6.7	4.3	8	2.2	1	1.5	11	◐		611	
R/LS14.4545.02	9	5.4	9	2.8	1.2	1.5	14	◑		614	

U.S.A. Stock

- = Both Right & Left Hand in Stock
- = Express Delivery
- ◐ = Left Hand in Stock
- ◑ = Right Hand in Stock

* Ap. max = maximum depth of cut (depending on material)

For use with toolholder 608 / 609 / 611 / 614: see pages 105 through 115

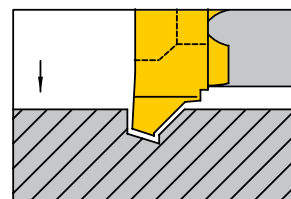
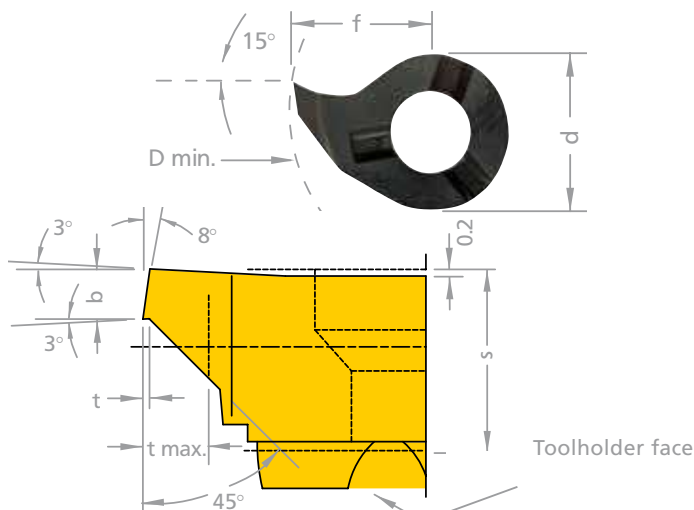
Order example:
Right hand version and grade AL41F:
R508.4545.02/AL41F

Inserts

MINICUT

Pregrooving and chamfering

min. bore Ø from 8 / 9 / 11 / 14 / 16 mm



Right hand (R): as shown
Left hand version (L): mirror image

State right (R) or left (L) version

Dimensions in mm



part number	U.S.A. Stock								tool holder type	standard carbide grade
	b	t	f	s	d	t max.	D min.	AL41F		
R/LS08.0810.45	1	0.2	4.8	3.3	6	1	8	●	608	AL41F (=TiAlN)
R/LS09.0810.45	1	0.2	5.5	3.6	6.2	1.5	9	○	609	
R/LS11.0810.45	1	0.2	6.7	4.2	8	1.5	11	●	611	
R/LS14.0815.45	1	0.2	9	5.3	9	1.5	14	◐	614	
R/LS16.0815.45	1	0.2	10.2	5.4	11	1.5	16	●	616	

U.S.A. Stock

- = Both Right & Left Hand in Stock
- = Express Delivery
- ◐ = Left Hand in Stock
- ◑ = Right Hand in Stock

For use with tool holder 608 / 609 / 611 / 614 / 616: see pages 105 through 115

Order example:
Right hand version and grade AL41F:
RS08.0810.45/AL41F



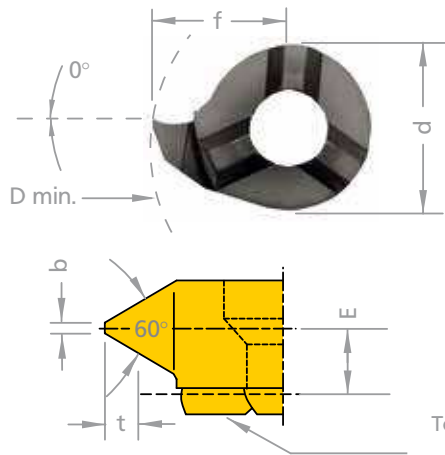
MINICUT

Inserts

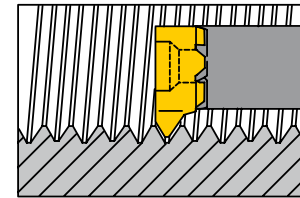
grooving, boring and profiling

Metric thread

Threading internal partial profile
min. bore Ø from 8 / 9 / 11 / 14 / 16 mm



Toolholder face



Eight hand (R): as shown
Left hand version (L): mirror image

State right (R) or left (L) version

Dimensions in mm



part number	P pitch	t	b	f	s	d	E	D min.	U.S.A. Stock		tool holder type	standard carbide grade
									AL41F			
R/LS08.0205.01	0.5 - 0.75	0.43	0.06	4.8	3.5	6	2.95	8	●		608	AL41F (=TiAlN)
R/LS08.0510.01	1 - 1.25	0.7	0.12	4.8	3.5	6	2.7	8	●		608	
R/LS08.0815.01	1.5 - 1.75	0.95	0.18	4.8	3.5	6	2.25	8	●		608	
R/LS09.0205.01	0.5 - 0.75	0.27	0.06	5.5	3.55	6.2	3.2	9	○		609	
R/LS09.0510.01	1 - 1.25	0.54	0.12	5.5	3.55	6.2	3	9	○		609	
R/LS09.0815.01	1.5 - 1.75	0.81	0.18	5.5	3.55	6.2	2.8	9	○		609	
R/LS09.0917.01	1.75 - 2	0.95	0.2	5.5	3.55	6.2	2.6	9	○		609	
R/LS09.1020.01	2 - 2.5	1.08	0.25	5.5	3.55	6.2	2.5	9	○		609	
R/LS09.1325.01	2.5 - 3	1.35	0.31	5.5	3.55	6.2	2.1	9	○		609	
R/LS09.1630.01	3 - 3.5	1.62	0.37	5.5	3.55	6.2	1.9	9	○		609	
R/LS11.0205.01	0.5 - 0.75	0.41	0.06	6.7	4.3	8	3.75	11	●		611	
R/LS11.0510.01	1 - 1.25	0.55	0.12	6.7	4.3	8	3.6	11	●		611	
R/LS11.0815.01	1.5 - 1.75	0.81	0.18	6.7	4.3	8	3.2	11	●		611	
R/LS11.1020.01	2 - 2.5	1.08	0.25	6.7	4.3	8	2.9	11	●		611	
R/LS11.1325.01	2.5 - 3	1.35	0.31	6.7	4.3	8	3	11	●		611	

U.S.A. Stock

- = Both Right & Left Hand in Stock
- = Express Delivery
- ◐ = Left Hand in Stock
- ◑ = Right Hand in Stock

For use with tool holder 608 / 609 / 611:
see pages 105 through 115

Order example:
Right hand version and grade AL41F:
RS08.0815.01/AL41F

Inserts

MINICUT



Metric thread

Threading internal partial profile
min. bore Ø from 8 / 9 / 11 / 14 / 16 mm

part number	P pitch	t	b	f	s	d	E	D min.	U.S.A. Stock		tool holder type	standard carbide grade
									AL41F			
R/LS14.0510.01	1.0 – 1.25	0.55	0.12	9	5.4	9	4.6	14	●		614	AL41F (=TiAlN)
R/LS14.0815.01	1.5 – 1.75	0.81	0.18	9	5.4	9	4.3	14	●		614	
R/LS14.1020.01	2.0 – 2.5	1.08	0.25	9	5.4	9	3.9	14	◐		614	
R/LS14.1325.01	2.5 – 3.0	1.35	0.31	9	5.4	9	3.65	14	◑		614	
R/LS16.0510.01	1.0 – 1.25	0.55	0.12	10.2	5.5	11	4.8	16	◐		616	
R/LS16.0815.01	1.5 – 1.75	0.81	0.18	10.2	5.5	11	4.3	16	◑		616	
R/LS16.1020.01	2.0 – 2.5	1.08	0.25	10.2	5.5	11	3.9	16	◑		616	
R/LS16.1325.01	2.5 – 3.0	1.35	0.31	10.2	5.5	11	3.7	16	◑		616	



U.S.A. Stock

- = Both Right & Left Hand in Stock
- = Express Delivery
- ◐ = Left Hand in Stock
- ◑ = Right Hand in Stock

* Ap. max = maximum depth of cut (depending on material)

For use with tool holder 614 / 616: see pages 105 through 115

Order example:
Right hand version and grade AL41F:
RS08.3046.02/AL41F



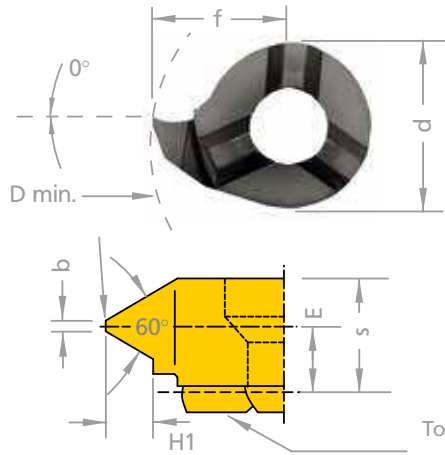
MINICUT

Grooving, boring and profiling

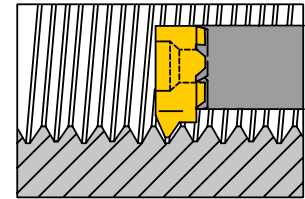
Inserts

Metric thread

Threading internal full profile
min. bore Ø from 9 / 11 / 14 mm



Toolholder face



Right hand (R): as shown
Left hand version (L): mirror image

State right (R) or left (L) version

Dimensions in mm



part number	P pitch	H1	b	f	s	d	E	D min.	U.S.A. Stock		tool holder type	standard carbide grade
									AL41F			
R/LS09.0205.02	0.5	0.27	0.06	5.5	3.55	6.2	3.25	9	○		609	AL41F (=TiAlN)
R/LS09.0510.02	1.0	0.54	0.12	5.5	3.55	6.2	3	9	○		609	
R/LS09.0815.02	1.5	0.81	0.18	5.5	3.55	6.2	2.8	9	○		609	
R/LS09.0917.02	1.75	0.95	0.2	5.5	3.55	6.2	2.7	9	○		609	
R/LS09.1020.02	2.0	1.08	0.25	5.5	3.55	6.2	2.6	9	○		609	
R/LS09.1325.02	2.5	1.35	0.31	5.5	3.55	6.2	2.5	9	○		609	
R/LS09.1630.02	3.0	1.62	0.37	5.5	3.55	6.2	2.2	9	○		609	
R/LS11.0510.02	1.0	0.54	0.12	6.7	4.3	8	3.6	11	○		611	
R/LS11.0815.02	1.5	0.81	0.18	6.7	4.3	8	3.3	11	◐		611	
R/LS11.1020.02	2.0	1.08	0.25	6.7	4.3	8	2.9	11	○		611	
R/LS11.1325.02	2.5	1.35	0.31	6.7	4.3	8	2.95	11	○		611	
R/LS11.1630.02	3.0	1.62	0.37	6.7	4.3	8	2.9	11	○		611	
R/LS14.0205.02	0.5	0.27	0.06	9	5.4	9	4.8	14	○		614	
R/LS14.0510.02	1.0	0.54	0.12	9	5.4	9	4.7	14	○		614	
R/LS14.0815.02	1.5	0.81	0.18	9	5.4	9	4.3	14	○		614	
R/LS14.1020.02	2.0	1.08	0.25	9	5.4	9	4.2	14	○		614	
R/LS14.1325.02	2.5	1.35	0.31	9	5.4	9	3.65	14	○		614	

U.S.A. Stock

- = Both Right & Left Hand in Stock
- = Express Delivery
- ◐ = Left Hand in Stock
- ◑ = Right Hand in Stock

For use with tool holder 609 / 611 / 614
see pages 105 through 115

Order example:
Right hand version and grade AL41F:
RS11.1020.02/AL41F

Inserts

Metric thread

Threading internal full profile
min. bore Ø from 16 mm

MINICUT

Grooving, boring and profiling



part number	P pitch	U.S.A. Stock								tool holder type	standard carbide grade
		H1	b	f	s	d	E	D min.	AL41F		
R/LS16.0510.02	1	0.54	0.12	10.2	5.5	11	4.8	16	○	616	AL41F (=TIALN)
R/LS16.0815.02	1.5	0.81	0.18	10.2	5.5	11	4.3	16	○		
R/LS16.1020.02	2	1.08	0.25	10.2	5.5	11	4.05	16	○		
R/LS16.1325.02	2.5	1.35	0.31	10.2	5.5	11	4.2	16	○		
R/LS16.1630.02	3	1.62	0.37	10.2	5.5	11	4.0	16	○		
R/LS16.1835.02	3.5	1.89	0.43	10.2	5.5	11	3.9	16	○		
R/LS16.2140.02	4	2.16	0.50	10.2	5.5	11	3.6	16	○		



U.S.A. Stock

- = Both Right & Left Hand in Stock
- = Express Delivery
- ◐ = Left Hand in Stock
- ◑ = Right Hand in Stock

For use with tool holder 616
see pages 105 through 115

Order example:
Right hand version and grade AL41F:
RS11.1020.02/AL41F



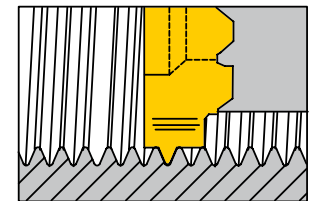
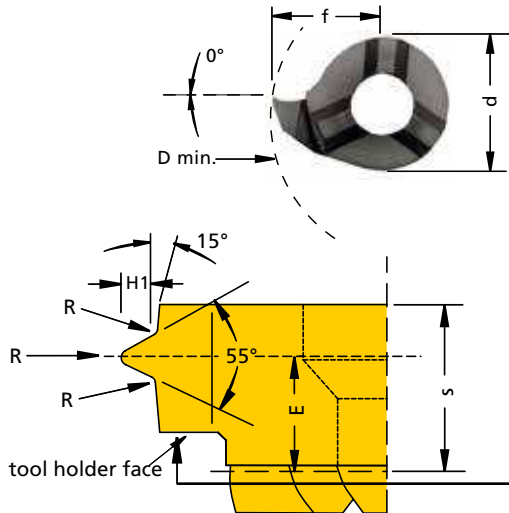
MINICUT

grooving, boring and profiling

Inserts

Threading internal Whitworth full profile

Min. bore Ø from 11 / 14 / 16 mm



Right hand (R): as shown
Left hand version (L): mirror image

State right (R) or left (L) version

Dimensions in mm



part number	P pitch	H1	Gg (INCH)	f	s	d	E	D min.	U.S.A. Stock	AL41F	tool holder type	standard carbide grade
R/LS11.0813.19 INCH SIZE	1.337	0.85	19	6.7	4.3	8	2.7	11	○		611	AL41F (=TIALN)
R/LS11.1118.14 INCH SIZE	1.814	1.16	14	6.7	4.3	8	3	11	○		611	
R/LS14.0813.19 INCH SIZE	1.337	0.85	19	9	5.35	9	3.8	14	○		614	
R/LS14.1118.14 INCH SIZE	1.814	1.16	14	9	5.35	9	3.6	14	○		614	
R/LS16.1118.14 INCH SIZE	1.814	1.16	14	10.2	5.5	11	3.9	16	○		616	
R/LS16.1423.11 INCH SIZE	2.309	1.48	11	10.2	5.5	11	3.5	16	○		616	

U.S.A. Stock

- = Both Right & Left Hand in Stock
- = Express Delivery
- ◐ = Left Hand in Stock
- ◑ = Right Hand in Stock

For use with tool holder 611 / 614 / 616: see pages 105 through 115

Order example:
Right hand version and grade AL41F:
RS11.0813.19/AL41F

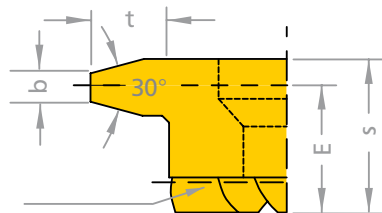
Inserts

MINICUT

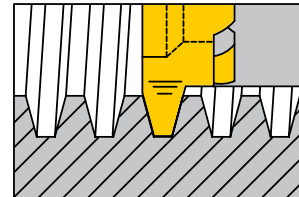
Trapezoidal thread
Threading internal

Min. bore Ø from 9 / 10 / 11 / 14 / 16 mm

Grooving, boring and profiling



Tool holder face



Right hand (R): as shown
Left hand version (L): mirror image

State right (R) or left (L) version

Dimensions in mm



part number	D min.	P pitch	t	f	E	s	b	d	U.S.A. Stock		tool holder type	standard carbide grade
									AL41F			
R/LS09.1015.01	9	1.5	0.9	5.5	3.0	3.55	0.47	6.2	○		609	AL41F (=TIALN)
R/LS09.1220.01	9	2.0	1.25	5.5	2.85	3.55	0.60	6.2	○			
R/LS09.1730.01	9	3.0	1.75	5.5	2.25	3.55	0.96	6.2	○			
R/LS09.2240.01	10	4.0	2.25	5.5	2.25	3.55	1.33	6.2	○			
R/LS11.1015.01	11.0	1.5	0.9	6.7	3.7	4.3	0.47	8.0	○		611	
R/LS11.1220.01	11.0	2.0	1.25	6.7	3.5	4.3	0.60	8.0	○			
R/LS11.1730.01	11.0	3.0	1.75	6.7	3.2	4.3	0.96	8.0	○			
R/LS11.2240.01	11.0	4.0	2.25	6.7	2.6	3.95	1.33	8.0	○			
R/LS14.1220.01	14.0	2.0	1.25	9.0	4.3	5.3	0.60	9.0	○		614	
R/LS14.1730.01	14.0	3.0	1.75	9.0	4.0	5.3	0.96	9.0	○			
R/LS14.2240.01	14.0	4.0	2.25	9.0	4.0	5.3	1.33	9.0	○			
R/LS14.2750.01	14.0	5.0	2.75	9.0	3.55	5.3	1.69	9.0	○			
R/LS16.1220.01	16.0	2.0	1.25	9.7	4.5	5.5	0.60	11.0	○		616	
R/LS16.1730.01	16.0	3.0	1.75	9.7	4.3	5.5	0.96	11.0	○			
R/LS16.2240.01	16.0	4.0	2.25	9.7	4.0	5.5	1.33	11.0	○			
R/LS16.2750.01	16.0	5.0	2.75	10.2	3.6	5.5	1.69	11.0	○			
R/LS16.3560.01	16.0	6.0	3.50	10.2	3.3	5.5	1.92	11.0	○			

U.S.A. Stock

- = Both Right & Left Hand in Stock
- = Express Delivery
- ◐ = Left Hand in Stock
- ◑ = Right Hand in Stock

For use with tool holder 609 / 611 / 614 / 616: see pages 105 through 115

Order example:
Right hand version and grade AL41F:
RS11.1015.01/AL41F



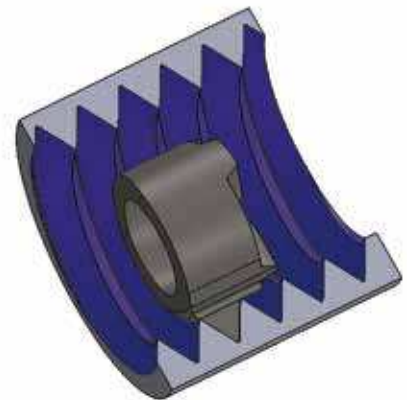
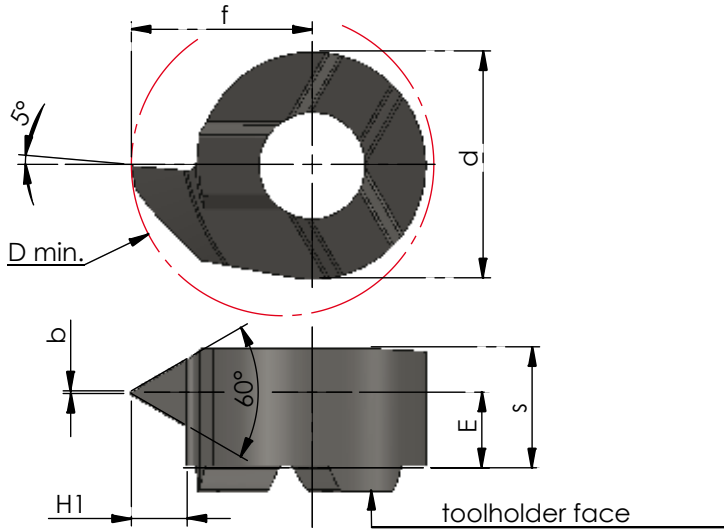
MINICUT

Type Threading

Grooving, boring and profiling

Threading,
NPT full profile

Bore Ø from 8 mm



Right hand (R): as shown
Left hand version (L): mirror image

State right (R) or left (L) version

Dimensions in mm

	part number	P pitch	H1	Gg (INCH)	b	f	s	d	E	D min.	U.S.A. Stock		tool holder type
											AL41F		
NEW	R/LS08.NP14.02 INCH SIZE	1.814	1.48	14	0.07	4.8	3.2	6	2.0	8	●		
NEW	R/LS08.NP18.02 INCH SIZE	1.411	1.19	18	0.05	4.8	3.5	6	2.6	8	●		608
NEW	R/LS08.NP27.02 INCH SIZE	0.940	0.80	27	0.04	4.8	3.5	6	2.8	8	●		

U.S.A. Stock

- = Both Right & Left Hand in Stock
- = Express Delivery
- ◐ = Left Hand in Stock
- ◑ = Right Hand in Stock

More carbide grades can be found in the grades summary in the section "technical instructions".

Order example:
Right hand version and grade
RS08.NP14.02/AL41F

MINICUT

Type Axial Grooving

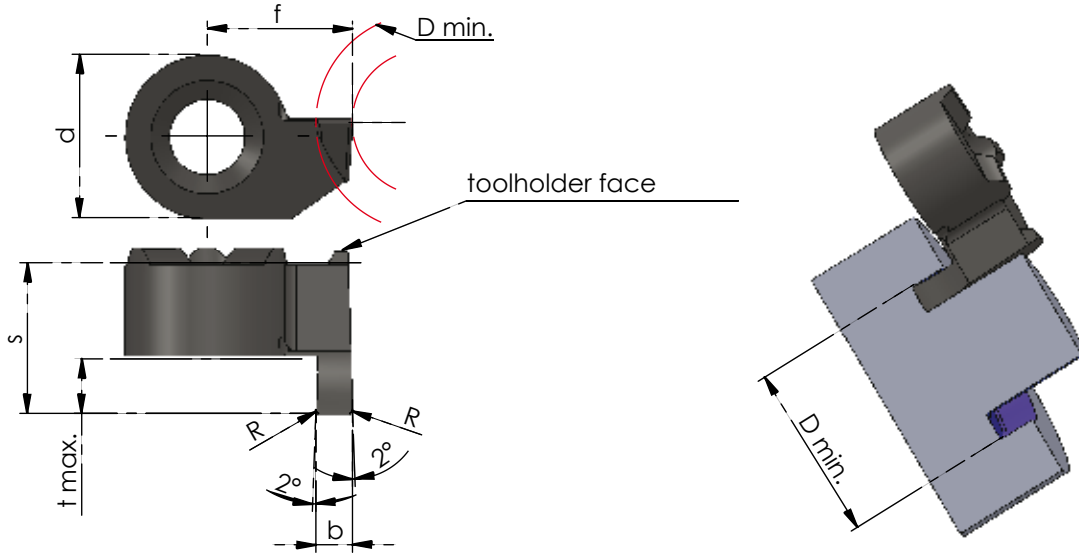
NEW



Grooving, boring and profiling

Type face grooving,
Axial grooving past the pin with
corner radius

Outer groove Ø starting at 12 / 16 mm



Right hand (R): as shown
(rotation left)
Left hand version (L): mirror image
(rotation right)
State right (R) or left (L) version

Dimensions in mm



	part number	b+0.03	b (INCH)	f	R	s	d	t max.	D min.	U.S.A. Stock	tool holder type	
										AL41F		
	R/LS014.1210.00	1.0	-	7.0	-	8.3	9	1.5	12	●	614 614.A	
	R/LS014.1215.02	1.5	-	7.5	0.2	8.3	9	2.5	12	●		
NEW	R/LS014.U219.02 INCH SIZE	1.98	0.078"	8.0	0.2	8.3	9	3.0	12	◐		
	R/LS014.1220.02	2.0	-	8.0	0.2	8.3	9	3.0	12	●		
NEW	R/LS014.U223.02 INCH SIZE	2.39	0.094"	8.4	0.2	8.3	9	3.0	12	◐		
	R/LS014.1225.02	2.5	-	8.5	0.2	8.3	9	3.0	12	◐		
	R/LS014.1230.02	3.0	-	9.0	0.2	8.3	9	3.0	12	●		
NEW	R/LS014.U231.02 INCH SIZE	3.18	0.125"	9.2	0.2	8.3	9	3.0	12	◐		
	R/LS014.1220.52	2.0	-	8.0	0.2	10.3	9	5.0	12	●		
	R/LS014.1225.52	2.5	-	8.5	0.2	10.3	9	5.0	12	●		
	R/LS014.1230.52	3.0	-	9.0	0.2	10.3	9	5.0	12	●		
	R/-S014.1230.62	3.0	-	9.0	0.2	11.3	9	6.0	12	◐		
NEW	R/LS018.1630.02	3.0	-	11	0.2	15.8	11	10	16	◐		618 618.A
NEW	R/LS018.1640.02	4.0	-	12	0.2	15.8	11	10	16	◐		

U.S.A. Stock

- = Both Right & Left Hand in Stock
- ◐ = Express Delivery
- ◑ = Left Hand in Stock
- ◒ = Right Hand in Stock

More carbide grades can be found in the grades summary in the section "technical instructions".

Order example:
Right hand version and grade
RS014.1210.00/AL41F



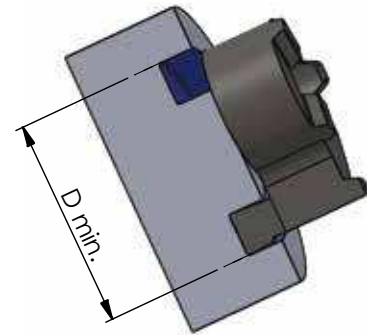
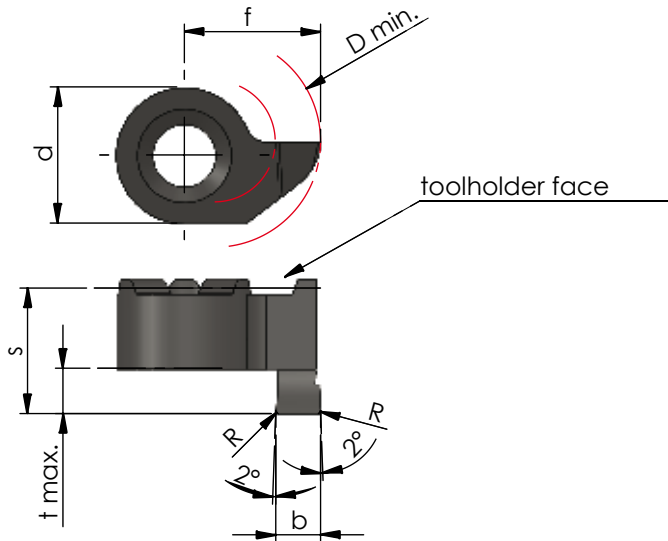
MINICUT

Type Axial Grooving

Grooving, boring and profiling

Type axial face grooving

Outer groove Ø starting at 14 / 18 mm



Right hand (R): as shown (rotation right)
 Left hand version (L): mirror image (rotation left)
 State right (R) or left (L) version

Dimensions in mm

part number	b+0.03	f	R	s	d	t max.	D min.	U.S.A. Stock	tool holder type
								AL41F	
R/LS014.1410.00	1.0	9	-	8.3	9	1.5	14	●	614 614.A
R/LS014.1415.02	1.5	9	0.2	8.3	9	2.5	14	●	
R/LS014.1420.02	2.0	9	0.2	8.3	9	3.0	14	●	
R/LS014.1425.02	2.5	9	0.2	8.3	9	3.0	14	◐	
R/LS014.1430.02	3.0	9	0.2	8.3	9	3.0	14	○	
R/LS014.1420.52	2.0	9	0.2	10.3	9	5.0	14	●	
R/LS014.1425.52	2.5	9	0.2	10.3	9	5.0	14	●	
R/LS014.1430.52	3.0	9	0.2	10.3	9	5.0	14	●	
R/-S014.1430.62	3.0	9	0.2	11.3	9	6.0	14	◑	
NEW R/LS018.1830.02	3.0	11	0.2	15.8	11	10	18	◑	618
NEW R/LS018.1840.02	4.0	11.5	0.2	15.8	11	10	18	◑	618.A

U.S.A. Stock

- = Both Right & Left Hand in Stock
- = Express Delivery
- ◐ = Left Hand in Stock
- ◑ = Right Hand in Stock

More carbide grades can be found in the grades summary in the section "technical instructions".

Order example:
 Right hand version and grade
 RS014.1410.00/AL41F

MINICUT

Type Axial Grooving

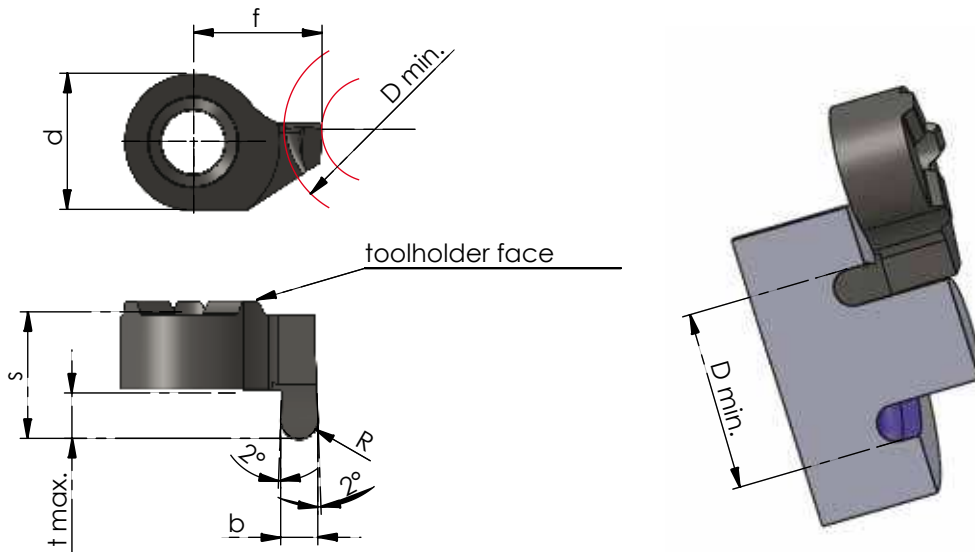
NEW



Grooving, boring and profiling

Face grooving,
Axial grooving past the pin with
corner radius, full radius

From outer groove Ø from 12 mm



Right hand (R): as shown
(rotation left)
Left hand version (L): mirror image
(rotation right)
State right (R) or left (L) version

Dimensions in mm



	part number	b+0.03	f	R	s	d	t max.	D min.	U.S.A. Stock		tool holder type
									AL41F		
NEW	R/LS014.1210.05	1.0	7.0	0.5	8.3	9	1.5	12	○		614 614A
NEW	R/LS014.1216.08	1.6	7.6	0.8	8.3	9	2.5	12	○		
NEW	R/LS014.1220.10	2.0	8.0	1.0	8.3	9	3.0	12	○		
NEW	R/LS014.1225.12	2.5	8.5	1.25	8.3	9	3.0	12	○		
NEW	R/LS014.1230.15	3.0	9.0	1.5	8.3	9	3.0	12	○		
NEW	R/LS014.1220.50	2.0	8.0	1.0	10.3	9	5.0	12	○		
NEW	R/LS014.1225.50	2.5	8.5	1.25	10.3	9	5.0	12	○		
NEW	R/LS014.1230.50	3.0	9.0	1.5	10.3	9	5.0	12	○		

U.S.A. Stock

- = Both Right & Left Hand in Stock
- = Express Delivery
- ◐ = Left Hand in Stock
- ◑ = Right Hand in Stock

More carbide grades can be found in the grades summary in the section "technical instructions".

Order example:
Right hand version and grade
RS014.1210.05/AL41F



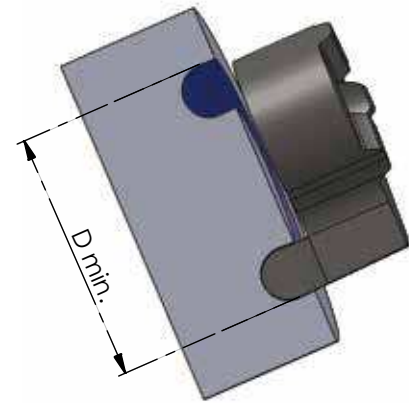
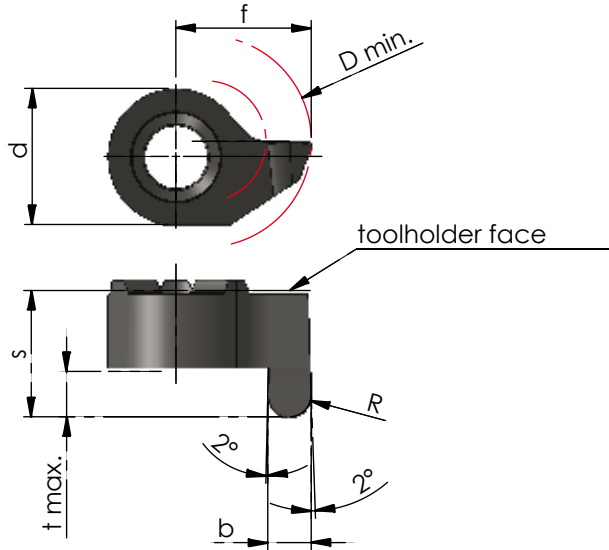
MINICUT

Type Face Grooving Full Radius

Grooving, boring and profiling

Face grooving full radius

From outer groove Ø from 14 mm



Right hand (R): as shown (rotation right)
 Left hand version (L): mirror image (rotation left)
 State right (R) or left (L) version

Dimensions in mm

part number	b+0.03	f	R	s	d	t max.	D min.	U.S.A. Stock		tool holder type
								AL41F		
R/LS014.1410.05	1.0	9	0.5	8.3	9	1.5	14	○		614 614A
R/LS014.1416.08	1.6	9	0.8	8.3	9	2.5	14	○		
R/LS014.1420.10	2.0	9	1.0	8.3	9	3.0	14	○		
R/LS014.1425.12	2.5	9	1.25	8.3	9	3.0	14	○		
R/LS014.1430.15	3.0	9	1.5	8.3	9	3.0	14	○		
NEW R/LS014.1420.50	2.0	9	1.0	10.3	9	5.0	14	○		
NEW R/LS014.1425.50	2.5	9	1.25	10.3	9	5.0	14	○		
NEW R/LS014.1430.50	3.0	9	1.5	10.3	9	5.0	14	○		

U.S.A. Stock

- = Both Right & Left Hand in Stock
- = Express Delivery
- ◐ = Left Hand in Stock
- ◑ = Right Hand in Stock

More carbide grades can be found in the grades summary in the section "technical instructions".

Order example:
 Right hand version and grade
 RS014.1410.05/AL41F

MINICUT

grooving, boring and profiling

Technical Instructions

Cutting data and number of passes for threading



Recommended number of passes

The number of passes is only a recommendation for threading. To reach a good tool life you have to mention the explanation for the infeed. Finishing passes are not considered in that chart.



		Steel (N/mm ² tensile strength)					Stainless Steel	Cast Iron	aluminium
		400-500	500-700	700-850	850-1150	>1150			
SFM		525	459	394	295	230	295	328	984
Pitch P		number of passes							
mm	Gg/" TPI								
0,5	48	5	5	5	5	8	8	5	5
0,8	32	6	6	6	6	8	8	6	6
1	24	7	7	7	7	8	8	7	7
1,25	20-19	8	8	8	8	10	10	8	8
1,5	16	10	10	10	10	12	12	10	10
1,75	14	12	12	12	12	14	14	12	12
2	12-11	13	13	13	13	15	15	13	13
2,5	10	15	15	16	16	18	18	16	15
3 - 3,5	8	16	16	17	17	20	20	17	16
4		18	18	19	19	22	22	19	18
5		20	20	21	21	24	24	21	20
6		22	22	23	23	26	26	23	22



MINICUT

Grooving, boring and profiling

Technical Instructions

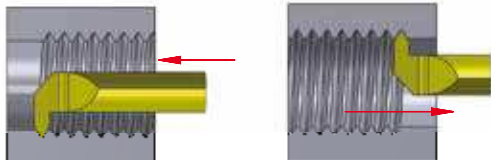
Threading



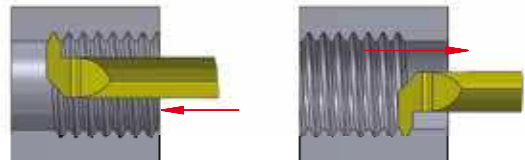
Feed direction

Every insert can be used for right and left hand threading. You only have to consider the following feed direction:

thread right hand

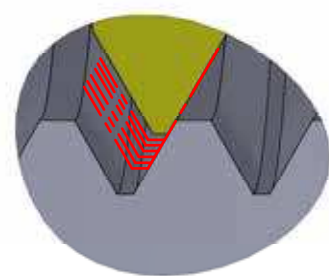
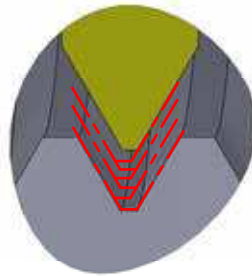
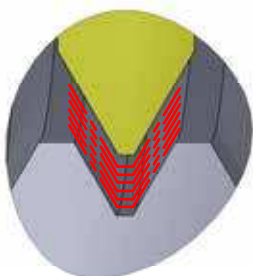


thread left hand



Infeed possibilities

Radial Infeed	Alternating Flank Infeed	Flank Infeed
The most used method for threading. Both sides are threaded at the same time during the process.	The flanks are alternating threaded.	Only one cutting edge is used for the complete thread.
Problematic chip formation, high cutting force and wearing at insert and work piece.	Reduced cutting force, higher state time and chip formation.	Reduced cutting force and better chip formation, but one-sided wearing.



MINICUT

Technical Instructions

Grooving, boring and profiling

Carbide grade and coatings



K10F

All purpose micrograin carbide with good abrasion resistance. Uncoated for applications with low or medium cutting speeds and machining of nonferrous materials.

CBN

Ductile CBN grade for applications with lower cutting speed. Suitable for hardened steel, interrupted cuts and cast iron.

CN45F

PVD-TiN coating - all purpose, all around grade is suitable for low and medium cutting speed with restrictions on non-ferrous materials.

AL41F

TiAlN coating - very universal with a high resistance to high temperature and hardness. Very suitable also for non-ferrous metals.

PD2F

Coating for universal use with medium and low speed.

XC2A

AlCrN coating - excellent hot hardness, maximum temperature of 1100°, high oxidation resistance and thermal insulation capacity. Perfect for hard machining >60 HRC.

P01C

Coating for the processing of tough material with medium or low cutting speed.

P03C

Coating for materials which are difficult to machine. Perfect to use for dry machining.

P07C

TiCrN coating - maximum temperature of 800° perfect for titanium, stainless steel and molybdenum.

P18C

AlTiCrN coating - very universal, high performance coating with high oxidation resistance, wear resistance and hot hardness resistance. Maximum temperature of 800°. Usable for maximum HRC54.

NEME

ta-C (carbon layer very thin) coating - maximum temperature of 500° for machining aluminium, alloys, non-ferrous metals and composite materials.





MINICUT

Grooving, boring and profiling

Technical Instructions

Cutting data



	MATERIAL	STRENGTH (psi)	MATERIAL NUMBER	MATERIAL DESCRIPTION	ANSI
P	General Construction Steel	< 116030	1.0037	St37-2	A284
	Free-cutting steel	< 116030	1.0718	95MnPb28	12L13
	Non-Alloyed Steel	< 116030	1.0401	C15	1015
	Alloy Steel	< 145038	1.7331	16MnCr5 (EC80)	5120
	Compensation Steel Unalloyed	< 123282	1.0503	C45	1045
	Compensation Steel Unalloyed	< 145038	1.0601	C60	1060
	Alloy Steel	< 116030	1.5131	50MnSi4	
	Alloy Steel	< 188549	1.5755	31NiCr14	
	Cast Steel	< 123282	0.9650	G-X260Cr27	
	Nitriding Steel	< 145038	1.8504	34CrAl6	
	Nitriding Steel	< 174045	1.8515	31CrMo12	
	Bearing Steel	< 174045	1.3505	100Cr6 (W3)	52100
	Bearing Steel	< 174045	1.5026	55Si7	-
	High Speed Steel	< 188549	1.3344	S 6-5-3	
M	Tool Steel for Cold Work	< 188549	1.2312	40CrMnMoS8 6	
	Tool Steel for Warm Work	< 188549	1.2343	X38CrMoV 5 1	H11
	Steel and cast steel rostfei sulfurized	< 123282	1.4305	X8CrNiS18 9	303
	Stainless Steel, Ferritic	< 108778	1.4510	X3CrTi17	
	Stainless Steel, Martensitic	< 130534	1.4034	X46Cr13	-
	Non-rusting. Steel, Ferritic / Martensite	< 159542	1.4313	X3CrNi13-4	
	Non-rusting. Steel, Austenitic / Ferritic	< 123282	1.4460	X8CrNiMo27 5	532900
	Stainless Steel, Austenitic	< 108778	1.4301	X5CrNi18-10	304
	Heat Resistant	< 159542	1.4747	X80CrNiSi20	
	Gray Cast Iron with Lamellar Graphite	14504-50763	0.6010	GG10	CLASS20
	Gray Cast Iron with Lamellar Graphite	43511-145038	0.6030	GG30	CLASS45
	Ball Graphite Castings	43511-72519	0.7040	GGG40	60-40-18
	Ball Graphite Castings	79771-116030	0.7060	GGG60	-
	Malleable Cast Iron	50763-65367	0.8035	GTW35	-
Malleable Cast Iron	72519-94274	0.8055	GTW55	-	
Malleable Cast Iron Black	50763-65267	0.8135	GTS35	32510	
Malleable Cast Iron Black	72519-101526	0.8155	GTS55	50005	
N	Aluminum (unalloyed, low alloy)	< 50763	3.0255	Al99,5	1000
	Aluminum Alloys < 0,5%	< 72519	3.0515	AlMn1	
	Aluminum Alloys 0,5-10%	< 58015	3.2152	GD-AlSi6Cu4	
	Aluminum Alloys 10-15%	< 58015	3.2381	G-AlSi10Mg	-
	Aluminum Alloys > 15%	< 58015		G-AlSi17Cu4	
	Copper (unalloyed, low alloy)	< 50763	2.0060	E-Cu57	
	Copper Wrought Alloys	< 101526	2.0240	CuZn15	C23000
	Copper Special Alloys	< 200 HB	2.0916	CuAl5	
	Copper Special Alloys	< 300HB	2.0978	CuAl11Ni6Fe5	
	Copper Special Alloys	> 300 HB	2.1247	CuBe2F125	
	Brass Short-Spanning, Bronze, Gunmetal	< 87023	2.0360	CuZn40 (Ms60)	C28000
	Brass Long-Spanning	< 87023	2.0335	CuZn36 (Ms63)	C36000, C48200
	Thermoplastics			Delrin, Hostalen	
	Thermosets			Ferrozell, Bakelit	
	Fiber Reinforced Plastics			GFK (Glasfaserverstärkt)	
	Magnesium and Magnesium Alloys	< 123282	3.5200	M2, MgMn2	
	Graphite			C8000, R8500X	
	Tungsten and Tungsten Alloys			W-NiFe (Densimet W)	
	Molybdenum and Molybdenum Alloys			Mo , Mo-50Re	
	S	Pure Nickel		1.3911	RNi24
Nickel Alloys			1.3912	Ni36 (Invar)	
Nickel Alloys		< 123282	2.4360	S-NiCu 30 Fe	
Nickel-Chromium Alloy			2.4886	SG-NiMo16Cr16W	
Nickel and Cobalt Alloys		< 188549	2.4632	NiCr20Co18Ti	
Nickel and Cobalt Alloys		< 188549	2.4634	NiCo20Cr15MoAlTi	
High-Temperature Resistant Alloys		< 188549		Hardox 400	
Nickel-Cobalt-(Chrome-) Alloys		< 203053	2.4806	SG-NiCr20Nb, Inconel 82	
Pure Titanium		< 130534	3.7025	Ti99,8	
Titanium Alloys		< 101526	3.7114	TiAl5Sn2	-
H	Titanium Alloys	< 174045	3.7164	TiAl5V4	
	Hardened Steel	< 45 HRC			
		46-55HRC			
		56-60 HRC			

Data on this page is for reference and planning only. Materials and processes should be tested in your environment to achieve desired results.

feed f:

groove: 0.0004 - 0.0012 in./Rev.

copy turning: 0.0012 - 0.0039 in./Rev.

axial groove: 0.0008 - 0.0024 in./Rev.



Grooving, boring and profiling

Cutting data

MATERIAL NUMBER	MATERIAL DESCRIPTION	ANSI	MATERIAL NUMBER	MATERIAL DESCRIPTION	ANSI	AL41F (SFM)
1.0570	St52-3		1.0060	St60-2	A572	262-656
1.0727	45S20		1.0757	46SPb2		262-656
1.0481	17Mn4		1.1141	C15E (CK15)	1015	262-656
1.7015	13Cr3 (EC60)		1.5919	15CrNi6	3115	262-525
1.1191	Ck45	1045	1.0535	C55	1055	262-459
1.1221	Ck60	1060	1.0540	C50		262-525
1.7030	28Cr4		1.7225	42CrMo4	4140	262-525
1.7033	34Cr4	5132	1.3565	48CrMo4		262-492
1.6750	GS-20NiCrMo3 7		1.6582	GS-34 CrNiMo 6	4337	262-656
1.8507	34AlMo5		1.8509	41CrAlMo7	A355	230-459
1.8523	39CrMoV19 3		1.8550	34 CrAlNi 7		230-459
1.3543	X192CrMo17		1.3520	100 CrMn 6 (W4)		230-459
1.7176	55Cr3	5155	1.7701	51CrMoV4		
1.3255	S 18-1-2-5	1015	1.3294	PMH56-5-3-8; ASP30		
1.2379	X155CrVMo12 1	D2	1.2316	X38CrMo16; RAMAX		
1.2767	X45NiCrMo4		1.2842	90MnCrV8	02	
1.4105	X4CrMo518	430F	1.4107	GX8CrNi12		262-525
1.4528	X105CrCoMo18 2		1.4016	X6Cr17	430	262-525
1.4116	X50CrMoV15		1.4106	X2CrMoSi18-2-1		262-525
1.4028	X30Cr13	420F	1.4104	X14CrMoS17	430 F	66-279
1.4821	X20CrNiSi25 4		1.4462	X2CrNiMoN22-5-3 (Duplex)	UNS31803	66-246
1.4571	X6CrNiMoTi17 12 2	316 Ti	1.4449	X3CrNiMo18-12-3	317	66-213
1.4876	X10NiCrAlTi32-21	B163	1.4825	GX25CrNiSi18-9		66-213
0.6025	GG25	A48-40 B				98-591
0.6045	GG45					98-492
0.7050	GGG50	65-45-12				98-591
0.7080	GGG80	120-90-02				98-394
0.8045	GTW45					98-295
0.8065	GTW65					66-262
0.8145	GTS45					98-295
0.8170	GTS70					66-262
3.3308	Al99,9Mg0,5		3.0256	E-Al H		394-1968
3.1355	AlCuMg2	2024	3.3315	AlMg1		394-1968
3.2373	GD-AlSi9Mg		3.2134	GD-AlSi5Cu1Mg		328-1476
3.5562	G-MgAl6		3.2525	S-AlSi12		230-984
	G-AlSi25CuNiMg			G-AlSi21CuNiMg		197-492
2.0090	SF-Cu		2.1522	CuSi2Mn		197-492
2.0265	CuZn30		2.0321	CuZn37		328-591
2.1525	CuSi3Mn			Ampco 8-16		295-591
				Ampco 18-26		262-591
				Ampco M-4		262-591
2.0380	CuZn39Pb2 (Ms58)		2.0410	CuZn44Pb2		394-722
2.1293	CuCrZr		2.1080	CuSn6Zn6		230-492
	Makrolon, Novodur			Acrylglas, Polystyrol		262-591
	Pertinax			Resopal		
	CFK (Kohlefaserverstärkt)			AFK (Amidfaserverstärkt)		
3.5612	MgAl6Zn1		3.5812	MgAl8Zn1		
	R8650			Technograph15		
	W-Cu80/20			W93NiFe (DENAL)		
	TZC, TZM			MHC , ODS		
1.3927	RNi8		1.3926	RNi12		98-262
1.3924	Ni54		1.3921	Ni49		59-246
	NiCu 30 Fe			Monel 400		59-246
2.4610	NiMo16Cr16Ti			Hastelloy C-276		131-230
2.4631	NiCr20TiAl			Nimonic 80		131-230
2.4654	NiCr19Co14Mo4Ti			Waspaloy		131-230
1.4939	X12CrNiMo12	904L	1.4980	X6NiCrTiMoVB25-15-2		131-230
2.4851	NiCr23Fe, Inconel 601		2.4667	SG-NiCr19NbMoTi		131-230
3.7034	Ti99,7		3.7064	Ti99,5		131-230
3.7174	TiAl6V6Sn2		3.7124	TiCu2		131-230
3.7144	TiAl6Sn2Zr4Mo2		3.7154	TiAl6Zr5		131-230



Data on this page is for reference and planning only. Materials and processes should be tested in your environment to achieve desired results.

feed f:

groove: 0.0004 - 0.0012 in./Rev.

copy turning: 0.0012 - 0.0039 in./Rev.

axial groove: 0.0008 - 0.0024 in./Rev.

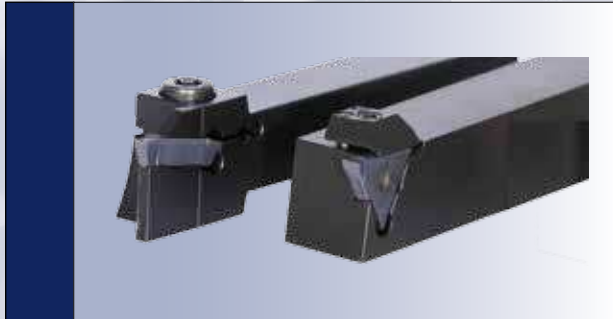


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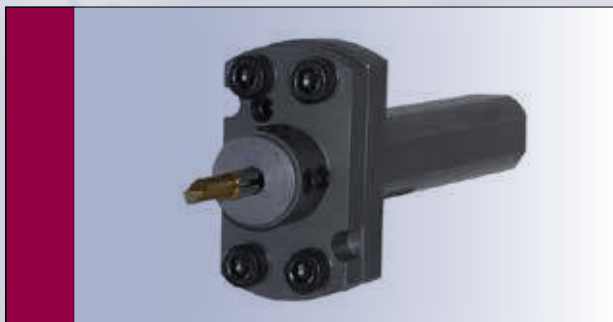
Other exceptional carbide cutting tools,
currently available only as express delivery items.
Contact us directly at (800) 621-5486 to inquire or
visit www.everede.net to view the product catalogs
for each of these tools

Dümmel
WERKZEUGFABRIK



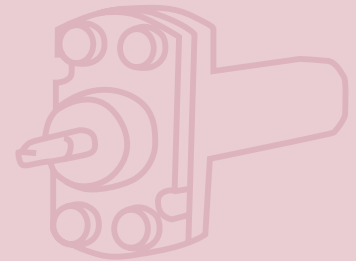
System DED

System DED: three cutting edge grooving
System ZTP: two cutting edge grooving



Tool Holders

Height adjustable
tool-holders



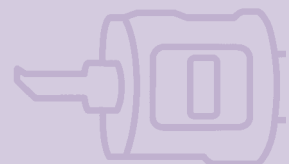
Broaching

Broaching keyways
in the range of 2-20 mm and
hexagon



rotaline

Precision boring starting
at \varnothing 0.4 mm



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Other exceptional carbide cutting tools, currently available only as express delivery items. Contact us directly at (800) 621-5486 to inquire or visit www.everede.net to view the product catalogs for each of these tools

		<p>Mikromill</p> <p>Groove milling by circular interpolation starting at \varnothing 1.3 mm</p> 
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		<p>Minimill</p> <p>Groove milling by circular interpolation with three and six cutting edges starting at \varnothing 10 mm</p> 
--	---	--

		<p>System 500</p> <p>Groove milling by circular interpolation groove milling and slotting cutter</p> 
--	---	---

		<p>Swissline</p> <p>Miniature External Machining. A turn and cut off tool system for Swiss type lathes up to \varnothing 32 mm.</p> 
--	---	---



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