



Kesici Takımlar İth. İhr. San. ve Tic. Ltd. Şti.

SPOTFACING
CHAMFERING
COUNTERBORING
DEBURRING



Automatic
Back Spotfacer

ZEUS

KESİCİ TAKIMLAR İTH. İHR. SAN VE TİC. LTD. ŞTİ

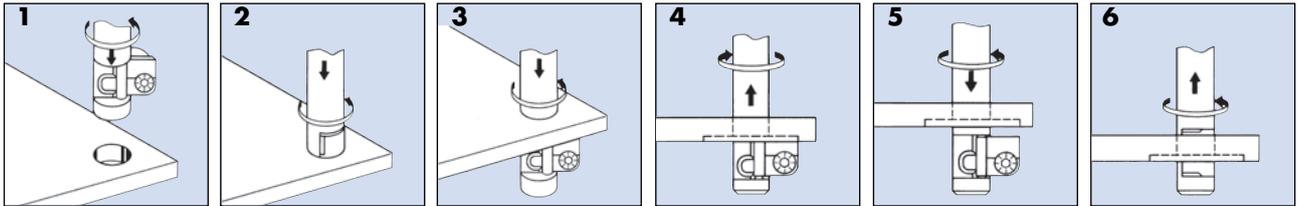
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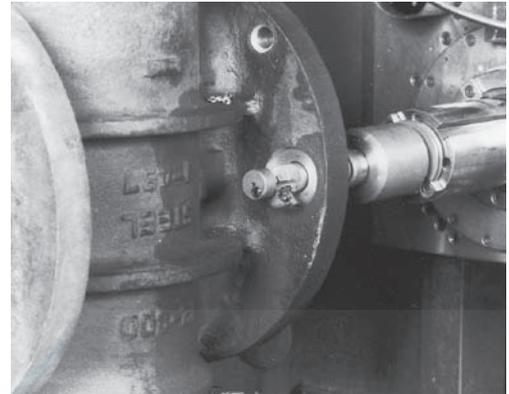
HOW THE TOOL OPERATES



Index

Page

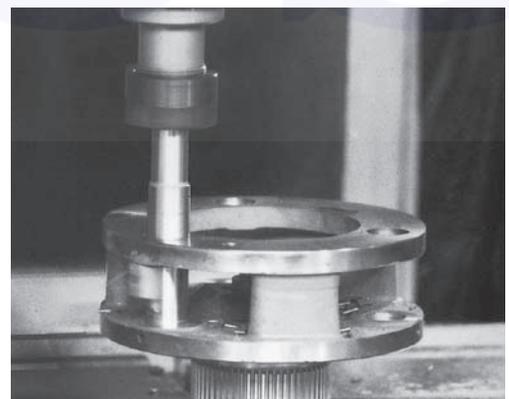
Technical Description	3
Feed and Speed	4
Directions for use	5
Smooth Operation	6-7
Operation in difficult materials	8
Morse Taper shanks	9
Weldon	9
Part numbering system	10
Semistandard and special tools	11
Back spotfacing	12-17
Back chamfering 45°	18-19
Back chamfering 60°	20
Back chamfering 30°	21
Front and Back spotfacing	22
Front and Back chamfering 45°	23
Combination table	24-27
Time and Cost analysis	28
Programming	29-30
Spare Parts	31



Back spotfacing large valve body.



Spindle with coolant through (CT).



Front and back spotfacing.



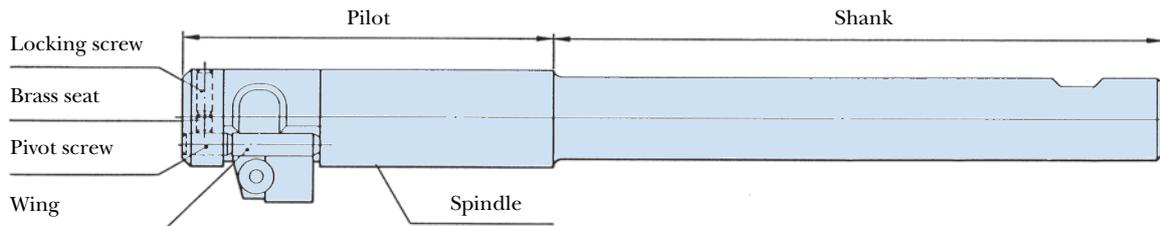
Front and Back chamfering.

SPOTFACING • CHAMFERING • COUNTERBORING • DEBURRING

TECHNICAL DESCRIPTION

Patented Design. Reliable Performance. The tool is an automatic back spotfacing or back chamfering tool consisting of a spindle and a cutter, called a wing, which folds into the spindle recess when the tool enters the hole in the workpiece. Excellent performance is ensured because there is only one moving part.

Save time and money. Working time saved when compared with conventional methods is normally between 60% and 70%, in some cases more than 90%.



SPINDLE.

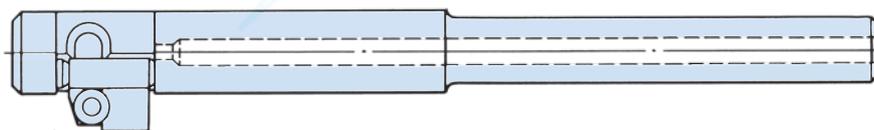
The pilot part of the spindle guides the spotfacer into the hole and takes up the cutting forces. The pilot diameter is less than the nominal hole diameter.

The difference in diameter is as follows:

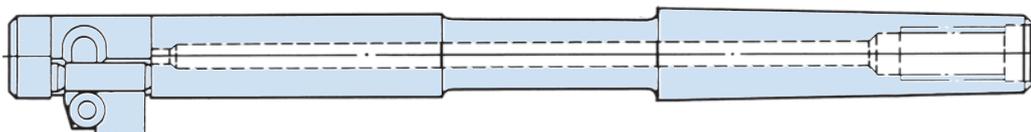
Hole dia.	Difference
4.5 – 9.0 mm	0.05 mm
10.0 – 13.0 mm	0.10 mm
14.0 – 24.0 mm	0.20 mm
25.0 – 30.0 mm	0.30 mm
above 30 mm	0.30 mm

Spindles above size 30 mm have a pilot diameter which is 1 mm less than the hole diameter. These spindles are provided with wear strips, which guide the spotfacer into the hole. Spindles size 4,5–9 mm have cylindrical shanks only. Larger spindles have either cylindrical or Morse Taper shanks.

COOLANT THROUGH



All spindles with cylindrical shanks, for hole size 10 mm and above, have coolant through.



All spindles with Morse Taper shanks (DIN 228A), for hole size 10 mm and above, can be drilled for coolant through. Morse Taper spindles with coolant through are coded with a suffix (CT) e.g. 27-14-MK2 (CT).

WING

During operation the wing must be free to swing. Therefore, when assembling a wing, **the pivot screw should be released about 30 degrees**, before tightening the locking screw.

Smaller wings are made of HSS with integral cutting edge. Larger size wings have square inserts type ISO SPUN or rectangular inserts type ISO/R242.

The inserts are clamped to the wings by means of Secodex **lefthand** threaded screws.

FEED And SPEED

When operating in different material

Workpiece Material		Hardness HB	Number and Letter Code	
			Wings HSS	Wings Carbide
1. Steel	1,1 Magnetic soft steel	≤ 120	35 E	70 E
	1,2 Structural steel	≤ 200	30 D	60 D
	1,3 Plain Carbon steel	≤ 250	25 D	50 D
	1,4 Alloy steel	≤ 250	20 C	40 C
	1,5 Alloy, tempered steel	> 250; ≤ 350	15 B	30 B
	1,6 Alloy, tempered steel	> 350	10 A	20 A
2. Stainless steel Stahl	2,1 Free machining, steel	≤ 250	15 E	40 E
	2,2 Austenitic	≤ 250	10 D	30 D
	2,3 Ferritic, Martensitic	≤ 300	5 C	20 C
3. Cast Iron	3,1 Lamellar graphite	≤ 150	30 E	40 E
	3,2 Lamellar graphite	> 150; ≤ 300	20 E	30 E
	3,3 Malleable Cast Iron	≤ 200	15 D	20 D
	3,4 Malleable Cast Iron	> 200; ≤ 300	10 D	10 D
4. Titanium	4,1 Titanium unalloyed	≤ 200	15 C	40 C
	4,2 Titanium alloyed	≤ 270	10 B	20 B
	4,3 Titanium alloyed	> 270; ≤ 350	5 B	10 B
5. Nickel	5,1 Nickel, unalloyed	≤ 150	10 B	40 B
	5,2 Nickel, alloyed	≤ 270	6 B	20 B
	5,3 Nickel, alloyed	> 270; ≤ 350	5 A	10 A
6. Copper	6,1 Copper	≤ 100	50 C	70 C
	6,2 B-Brass, Bronze	≤ 200	45 D	80 D
	6,3 α-Brass	≤ 200	40 D	80 D
	6,4 High Strength Bronze	≤ 470	20 E	40 E
7. Aluminium Magnesium	7,1 Al, Mg unalloyed	≤ 100	60 F	80 F
	7,2 Al alloyed, Si < 0,5%	≤ 150	50 F	70 F
	7,3 Al alloyed, 0,5% > Si < 10%	≤ 120	40 E	60 E
	7,4 Al alloyed, Si > 10%	≤ 120	30 E	40 E
8. Synthetic material	8,1 Thermoplastics	--	60 D	80 D
	8,2 Thermosetting plastics	--	40 B	60 B
	8,3 Reinforced plastic materials	--	30 A	40 A

How to use the tables

1. Enter the table to the left with the correct workpiece material and the relevant wing type (HSS or Carbide) and obtain Number and Letter Code.
Example: Suppose workpiece material is Plain Carbon steel to be cut with a wing fitted with a carbide insert. You will find the Code: 50D.

2. With this code you go to the two tables below, using also the Spotfacing or Chamfering diameter (*Please note! Not hole diameter*).

To the left, using Letter Code, you will find Feed in mm/REV, and to the right, using Number Code, you find Speed in RPM.

Example: Suppose you are going to operate our tool 90-25/45-CS20. With a Spotfacing diameter of 45 mm and the above Code 50D you will find:

Feed: 0,14 mm / REV

Speed: 338 RPM

This would give a feed rate of:
 $338 \times 0,14 = 47 \text{ mm/min}$.

Spot-facing/ Chamfering diameter in mm	Feed in mm / REV						Speed in REV / min												
	Letter Code						Speed m/min												
	A	B	C	D	E	F	5	10	15	20	25	30	35	40	45	50	60	70	80
8	0,01	0,015	0,02	0,03	0,04	0,05	200	400	600	800	950	1200	1400	1600	1800	1900	2400	2800	3200
11	0,015	0,02	0,025	0,035	0,05	0,06	145	290	435	580	725	870	1015	1160	1300	1450	1740	2030	2320
14	0,02	0,025	0,03	0,04	0,06	0,07	115	230	340	455	570	680	795	910	1020	1140	1360	1590	1820
18	0,025	0,03	0,035	0,05	0,07	0,08	88	177	265	352	442	530	618	704	796	884	1060	1236	1408
21	0,03	0,035	0,04	0,06	0,08	0,10	76	152	228	304	380	456	534	608	687	760	912	1068	1216
25	0,035	0,04	0,05	0,08	0,10	0,12	64	128	192	256	320	382	446	512	573	640	764	892	1024
30	0,04	0,05	0,06	0,09	0,12	0,14	53	106	159	212	265	318	371	424	477	530	636	742	850
35	0,045	0,055	0,07	0,11	0,14	0,16	46	92	138	184	227	276	320	368	410	454	552	640	728
40	0,05	0,06	0,08	0,12	0,16	0,18	40	80	120	160	190	240	280	320	360	380	480	560	640
45	0,055	0,07	0,10	0,14	0,18	0,21	36	71	107	142	169	213	249	284	320	338	427	498	569
50	0,06	0,08	0,12	0,16	0,20	0,24	32	64	96	128	160	192	224	256	288	320	384	448	510
60	0,065	0,09	0,13	0,18	0,22	0,27	27	54	81	108	135	162	189	216	243	270	324	378	425
70	0,07	0,10	0,14	0,22	0,25	0,33	23	46	69	92	115	138	160	184	207	230	276	320	364
80	0,075	0,11	0,16	0,24	0,28	0,37	20	40	60	80	95	120	140	160	180	190	240	280	320
>80	0,08	0,12	0,18	0,25	0,30	0,40	15	20	50	65	80	95	110	125	145	160	190	220	250

DIRECTIONS FOR USE OF SPOT FACERS

Before Using The Tool Make The Following Checks

TOOL

- Check that the wing is free to swing. To prevent tightening of the wing caused by heat expansion, the **pivot screw** should have been **released about 30 degrees**.
- Spot Facers above size 30 mm have wings provided with a guide tang to keep the wing in a working position even at low speeds and in horizontal position. It is of **utmost importance** to check that the **entire length** of wing **including the guide tang** will **have space** enough within the workpiece to swing free before cutting operation starts. If this is not the case damage to wing and spindle will be caused.
- Check insert quality. **Use ISO K20 for cast iron** and **ISO P40 for steel**. Spot Facers are normally fitted with insert of grade ISO K20. When changing inserts note that the **clamping screw is lefthand threaded**.

TOOL HOLDER

Thoroughly fasten tool or tool holder with tool into the machine spindle.

WORKPIECE

Since the hole acts as a guiding surface for the Spot Facer, **a few drops of thin oil** in the hole **should be used**. When machining in steel coolant should be used.

OPERATION

Choose machine spindle **speed according to table**.

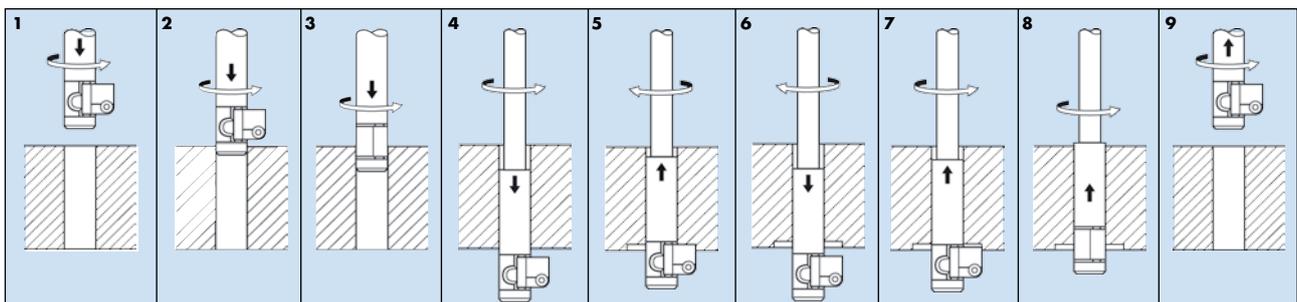
Start the machine spindle **counter-clockwise** (looking away from machine headstock) and **feed** the Spot Facer **rapidly up to the hole**. Since the wing must make contact with the workpiece in order to properly close, the **feedrate should be reduced to maximum 0,2 mm/rev. when entering** the hole. The wing will remain folded in, while passing through the hole and will swing out again by centrifugal force after having passed through. **Make sure that the entire length of the wing including the guide tang swings free of workpiece before reversing to clockwise rotation**. Then **apply feed according to table**.

IMPORTANT! *The wing closes through contact with the workpiece, not through the centrifugal force.*

After spot-facing, rapid traverse the wing away from the spotfaced surface. **If the wing has a guide tang the traverse must also clear the guide tang**.

Now reverse the spindle rotation and **back feed rapidly** until wing (or guide tang) is **near the spot faced surface**. Then the **feedrate should be reduced** again to **maximum 0,2 mm/rev.** until the wing is completely closed. The tool may then be withdrawn from the hole in rapid traverse.

IMPORTANT! *When cutting in a fillet (interrupted cut), with a horizontal spindle 30 mm or less, speed should be increased up to 2 times figures given in table. Feed to be reduced by 20-30%.*



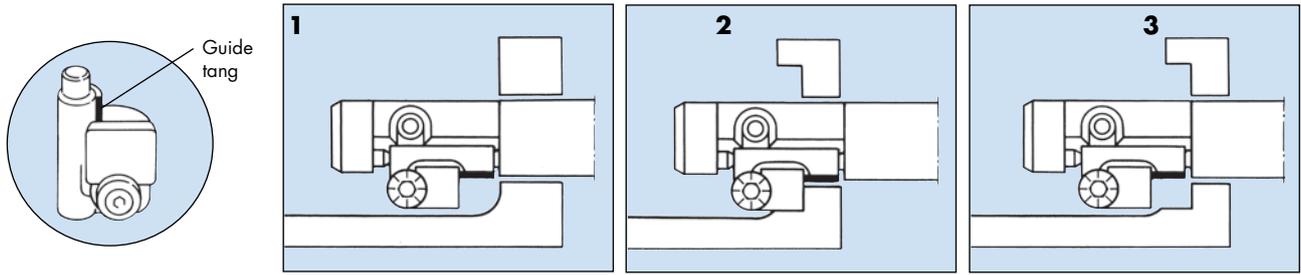
A FEW HINTS FOR SMOOTH OPERATION

- 1.** Small wings of type HSS might be magnetized during the operation. Demagnetize them if necessary.
- 2.** Use coolant. For cast iron use a few drops of thin, non-sticky oil.
- 3.** Tolerance on spotfacing diameter is approximately:

<i>Hole dia.</i>	<i>Tolerance</i>
4,5 - 9 mm	± 0,1 mm
10 - 30 mm	± 0,2 mm
31 - 69 mm	± 0,3 mm
- 4.** To improve the surface finish on the spotfaced surface, reduce the speed and feed at the end of the operation and let the tool dwell for a few seconds.
- 5.** To avoid marks in the finished hole, proceed as follows: drill the hole undersize, back spot face, ream the hole to finished size.
- 6.** Always check that the support for workpiece is strong enough to avoid any form of vibration.
- 7.** Use "coolant through" whenever possible. It has several advantages: chips break, chips are removed, keeps spindle and wing cool, prevents workpiece surface from hardening. If "coolant through" is not available we then recommend that plenty of coolant be applied as close to the cutting operation as possible.
- 8.** Ensure that screws are correctly tightened:
 - a) the pivot-screw, after having been slightly tightened, should be released about 30 degrees and then secured by the locking screw and its brass seat.
 - b) the Secodex clamping screw in the wing is *lefthand* threaded. When tightening this screw the insert will be secured firmly into the pocket made specially for this purpose in the wing. Furthermore the Secodex-screw has the form of an umbrella with a rim acting like a spring pressing hard and holding the insert. So don't forget to tighten this screw!
 - c) remaining screws. Check that they are tightened.
- 9.** Keep the cutting edge sharp, (except when operating in hard aluminium). Regrind cutting edge or change insert frequently.
- 10.** Ensure that there is space enough for the wing to swing out freely before, during or after the cutting operation.
- 11.** The tool is not designed to cut in a radial direction. If you try to use the tool as a reamer, the wing and/or spindle will break.
- 12.** Ensure that the hole in the workpiece has a *+tolerance* (i.e. is larger than the nominal diameter), as for instance H 11.
A drill that produces a *-tolerance* (smaller than nominal) should not be used.

WINGS WITH GUIDE TANG

Large spotfacing tools run at low speed. When operating in a *horizontal* position the centrifugal force acting on the wing is insufficient to hold the wing in correct working position. Therefore, spotfacing tools above 30 mm diameter have wings provided with a *guide tang*.

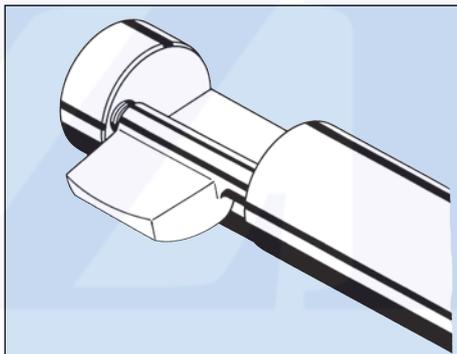


1. When cutting in a fillet the guide tang must enter the hole before the tip of insert cuts the fillet.
2. When the guide tang enters the hole it will keep the wing in its working position.
3. After spotfacing, the spindle must be retracted until the guide tang is free from the hole before the spindle can be reversed.

IMPORTANT!

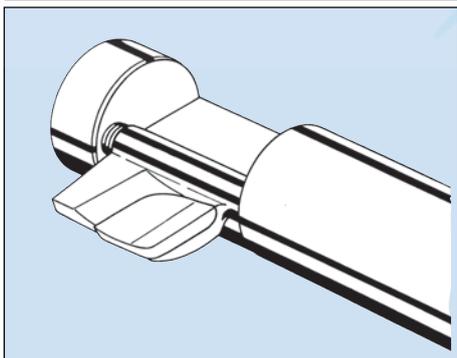
When cutting in a fillet (*interrupted cut*) with a horizontal spindle *increase speed up to 2 times* figures given in table and *reduce feed by 20–30%* (spindles 4,5–30 mm diameter only).

When operating the tools for hole size above 30 mm see instructions above.



WINGS TYPE HSS ES

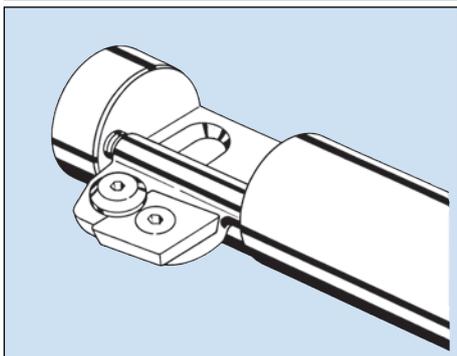
When operating conditions are too severe for the ordinary HSS wing the use of the EXTRA STRONG HSS wing is recommended. Such a wing is coded with the suffix ES; e.g. 37-037 ES.



WINGS TYPE HSS BI

Spotfacing wings size 020 and 030, normally made of HSS, can be supplied with BRAZED INSERTS grade K20 (or grade P40 for steel).

Such a wing is coded with the suffix BI; e.g. 37-037 BI.



WINGS WITH CENTER LOCK INSERTS

Heavy cutting loads in tough material such as stainless or high alloy steel make stringent demands on the clamping system. To comply with such demands, wings of size 060 or larger, which are normally fitted with square SPUN inserts, can be supplied with centerlocked inserts type SPMA. These wings are coded 38- instead of 37-; e.g. 38-120-2070.

SPECIAL HINTS FOR OPERATION IN SOME DIFFICULT MATERIALS

WORK PIECE MATERIAL

Steel: It can be a little difficult with soft steel to choose the best speed and feed. If speed is too high, vibrations might occur; if too low, material might build up on the cutting edge.

If there is a weld within the area to be spot faced and especially if there is also an interrupted cut, you might experience difficulties due to local high-hardness spots.

Stainless steel: Operating in stainless steel can cause problems similar to those described above.

Cast iron: The surface is often very hard and sometimes you will find grains of sand included in the surface. The cutting edge will quickly become blunt, which can cause the wing to break.

Titanium: Titanium is a very special material. When you have got experience, however, you should not expect difficulties.

Aluminium: Soft aluminium will give long chips.

Hard aluminium will give short chips.

RECOMMENDATIONS

Deviate from recommended figures up and down to find best result.

HSS-wings should - if possible - have brazed inserts, quality P40, (type BI). Larger wings can either have inserts with a centerlock screw (type 38-) (See page 7) or on special request be fitted with brazed inserts (quality P40).

Follow above recommendations. If they are not sufficient, ask us for chip breakers to be ground at the cutting edge of the wing or the insert. To further relieve the stress on the wing it can under certain circumstances be advisable to make the spotface in two diameter-steps.

When using HSS-wings try type BI with brazed inserts quality K20 or, when they are not available, type ES (See page 7). For larger wings use inserts quality K20.

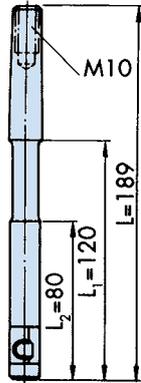
Insert quality P40 is generally recommended. For smaller wings use brazed inserts P40, where available. Otherwise wings type ES. Larger wings should have ordinary inserts P40. If necessary ask for special wings with brazed inserts.

If necessary arrange chip breaker. (See under stainless steel above).

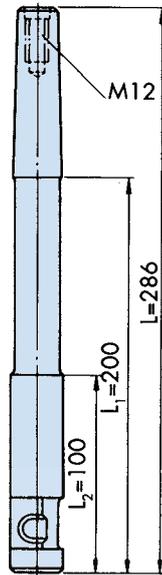
Ask us to supply wings or inserts with a chipping angle reduced from 7,5 degrees (which is our standard) to 0 degrees. It can also be useful to hone the cutting edge to obtain a small (approx 0,1 mm) negative chipping angle.

MORSE TAPER SHANKS

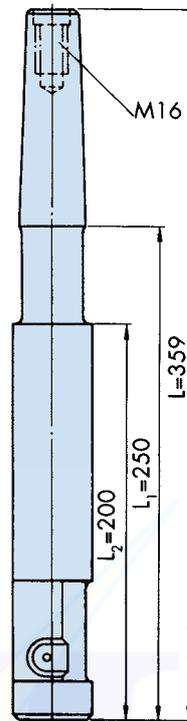
MK2
Hole size $\varnothing 10 - \varnothing 15,5$



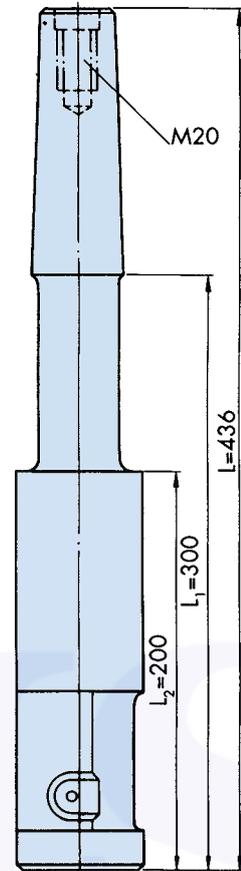
MK3
Hole size $\varnothing 16 - \varnothing 30$



MK4
Hole size $\varnothing 31 - \varnothing 43$

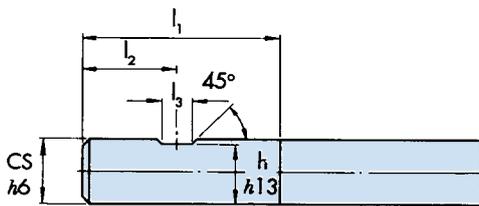


MK5
Hole size $\varnothing 44 - \varnothing 69$

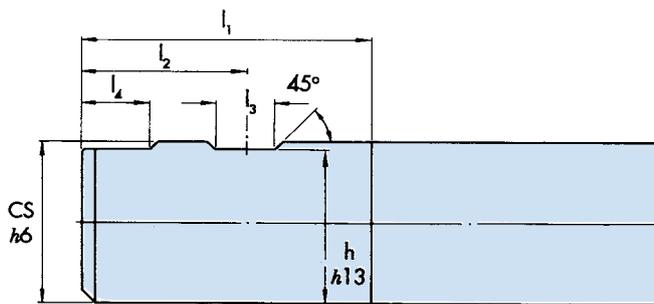


All spindles from hole size $\varnothing 10$ mm and above can be supplied with Morse Taper shank manufactured according to DIN 228A, instead of with cylindrical shank. The part number is for example 27-25-MK3.

WELDON



All spindles from hole size $\varnothing 10$ and above with cylindrical shanks are arranged for Weldon fastening according to DIN 1835B.



Shank CS	l_1	l_2	l_3	l_4	h
10	40	20	7	-	8,4
12	45	22,5	8	-	10,4
16	48	24	10	-	14,2
20	50	25	11	-	18,2
25	56	32	12	15	23,0
32	60	36	14	17	30,0
40	70	40	14	17	38,0
50	80	45	18	21	47,8

PART NUMBERING SYSTEM

Complete tool is coded 90–25/45–CS20

Prefix 90– = back spotfacing 90°

25 = hole diameter in mm

45 = facing diameter in mm

CS= cylindrical shank

20 = shank diameter in mm

Other prefixes:

45–= chamfering 45°

60–= chamfering 60°

30–= chamfering 30°

902–= front and back spotfacing

452–= front and back chamfering 45°

29–= special tool

Spindle is coded 27–25–CS20

Prefix 27– = spindle, standard or semistandard

25 = hole diameter in mm

CS = cylindrical shank

20 = shank diameter in mm

Other prefix:

29– = special spindle

Important! To front- and Backspotface with Spindle above 30 mm. Please see page 22 and 23.

Wing is coded 37–111 (standard) or

37–110–1450 (semistandard)

Prefix 37– = wing for back spotfacing 90°

Other prefixes:

34– = back chamfering

35– = front and back chamfering

36– = front and back spotfacing

38– = back spotfacing 90° with centerlock screw

39– = special wing

Wings with Centerlock Inserts

Type	Inserts - Type (K 20 or P40*)
38-061	SPMA 080312
38-062	SPMA 090308
38-063	SPMA 090308
38-091	SPMA 120308
38-101	SPMA 090308
38-102	SPMA 090308
38-111	SPMA 120308
38-121	SPMA 150408
38-131	SPMA 150408
38-132	SPMA 190412
38-141	SPMA 150408
38-142	SPMA 190412

Other types – Please request!

* K20 delivered as standard.

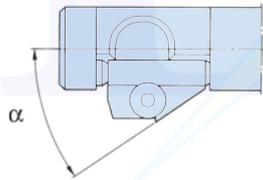
SEMI STANDARD AND SPECIAL TOOLS

In addition to the tools listed in this Catalogue we manufacture semistandard and special spindles and wings for ...

- 1.** Hole sizes up to 200 mm in diameter.
- 2.** Holes with diameters between those listed at intervals of 0,1 mm (0,05 mm for hole size $\varnothing 4,5 - \varnothing 9$ mm).
- 3.** Back spotfacing and Front/Back spotfacing at intervals of 0,1 mm in facing diameter.
- 4.** Chamfering angles other than 45° , 60° and 30° . Minimum angle is 15° .
- 5.** Special shanks.

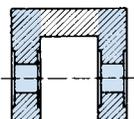
When requesting a quotation for a non-standard tool, please supply the following information ...

- a)** Hole diameter to the nearest 0,1 mm (or 0,05 mm for hole size $\varnothing 4,5 - \varnothing 9$ mm).
- b)** Facing diameter to the nearest 0,1 mm.
- c)** Operation – back spotfacing/chamfering or front and back spotfacing/chamfering.
- d)** Chamfering angle α .

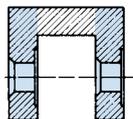


- e)** Type of shank.
- f)** Grade of carbide insert i.e. K20 for cast iron or P40 for steel.

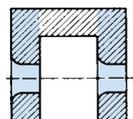
For very special or unusual applications please send a dimensioned sketch of the workpiece.



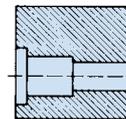
Front spot facing and back spot facing



Front spot facing and back chamfering



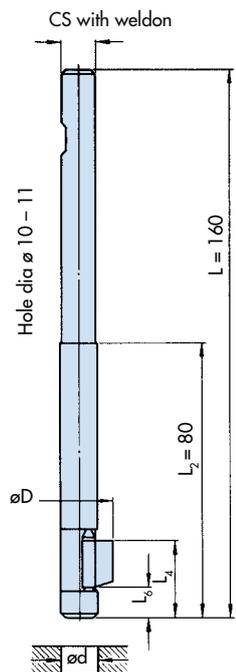
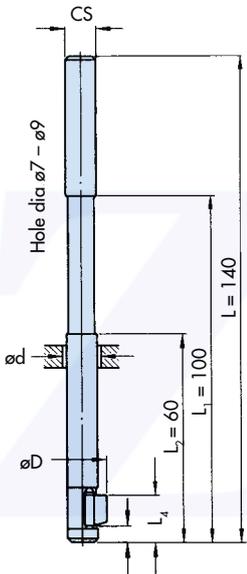
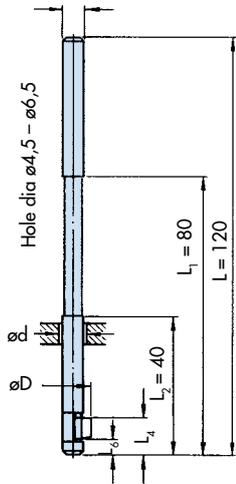
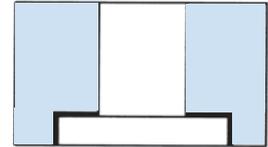
Back chamfering with radius



Front spot facing with dual diameters

BACK SPOTFACING

HOLE SIZE Ø4,5 – Ø11 mm

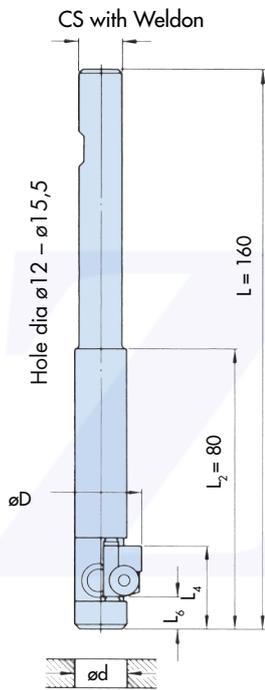


Hole dia ød	Facing dia øD	Complete tool	Spindle	Wing	Cutter/Insert	L ₄	L ₆
4,5	8	90-4,5 / 8 -CS6	27-4,5-CS6	37-011	HSS	11	5
	8,3	90-4,5 / 8,3 -CS6		-010-0315			
5,5	9	90-5,5 / 9 -CS6	27-5,5-CS6	37-011	HSS	11	5
	10	90-5,5 / 10 -CS6		-012			
	10,5	90-5,5 / 10,5 -CS6		-013			
	11	90-5,5 / 11 -CS6		-014			
	11,3	90-5,5 / 11,3 -CS6		-010-0415			
6,5	9,5	90-6,5 / 9,5 -CS6	27-6,5-CS6	37-011	HSS	11	5
	10,5	90-6,5 / 10,5 -CS6		-012			
	11	90-6,5 / 11 -CS6		-013			
	11,5	90-6,5 / 11,5 -CS6		-014			
	13	90-6,5 / 13 -CS6		-015			
	13,3	90-6,5 / 13,3 -CS6		-010-0490			

7	11,8	90-7 / 11,8 -CS8	27-7-CS8	37-021	HSS	15	5
	13,8	90-7 / 13,8 -CS8		-022			
	14,4	90-7 / 14,4 -CS8		-023			
8,4	13	90-8,4 / 13 -CS8	27-8,4-CS8	37-021	HSS	15	5
	15	90-8,4 / 15 -CS8		-022			
	15,6	90-8,4 / 15,6 -CS8		-023			
	17	90-8,4 / 17 -CS8		-024			
	18	90-8,4 / 18 -CS8		-020-0650			
	18,2	90-8,4 / 18,2 -CS8		-020-0660			
9	13,4	90-9 / 13,4 -CS8	27-9-CS8	37-021	HSS	15	5
	15	90-9 / 15 -CS8		-020-0480			
	15,4	90-9 / 15,4 -CS8		-022			
	16	90-9 / 16 -CS8		-023			
	17,4	90-9 / 17,4 -CS8		-024			
	18	90-9 / 18 -CS8		-025			
	19,6	90-9 / 19,6 -CS8		-020-0710			

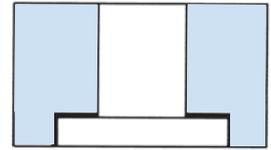
10	15,5	90-10 / 15,5 -CS10	27-10-CS10	37-031	HSS	24	10
	17	90-10 / 17 -CS10		-032			
	17,5	90-10 / 17,5 -CS10		-033			
	18	90-10 / 18 -CS10		-034			
	19	90-10 / 19 -CS10		-035			
	19,6	90-10 / 19,6 -CS10		-030-0730			
10,5	16	90-10,5 / 16 -CS10	27-10,5-CS10	37-031	HSS	24	10
	17,5	90-10,5 / 17,5 -CS10		-032			
	18	90-10,5 / 18 -CS10		-033			
	18,5	90-10,5 / 18,5 -CS10		-034			
	19,5	90-10,5 / 19,5 -CS10		-035			
	20	90-10,5 / 20 -CS10		-036			
	20,5	90-10,5 / 20,5 -CS10		-037			
	21,1	90-10,5 / 21,1 -CS10		-030-0780			
11	16,5	90-11 / 16,5 -CS10	27-11-CS10	37-031	HSS	24	10
	18	90-11 / 18 -CS10		-032			
	18,5	90-11 / 18,5 -CS10		-033			
	19	90-11 / 19 -CS10		-034			
	20	90-11 / 20 -CS10		-035			
	20,5	90-11 / 20,5 -CS10		-036			
	21	90-11 / 21 -CS10		-037			
	22,6	90-11 / 22,6 -CS10		-030-0830			

HOLE SIZE Ø12mm – Ø15,5 mm



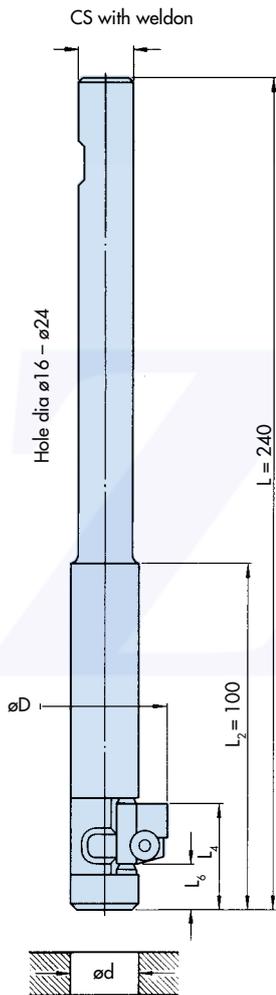
Hole dia ød	Facing dia øD	Complete tool	Spindle	Wing	Cutter/Insert	L ₄	L ₆			
12	17,5	90- 12 /17,5 -CS10	27-12-CS10	37-031	HSS	24	10			
	19	90- 12 /19 -CS10		-032						
	19,5	90- 12 /19,5 -CS10		-033						
	20	90- 12 /20 -CS10		-034						
	21	90- 12 /21 -CS10		-035						
	21,5	90- 12 /21,5 -CS10		-036						
	22	90- 12 /22 -CS10		-037						
	24	90- 12 /24 -CS10		-042						
	25,6	90- 12 /25,6 -CS10		-040-0930				080208	25	9
13	17,5	90- 13 /17,5 -CS10	27-13-CS10	37-031	HSS	24	10			
	19	90- 13 /19 -CS10		-032						
	19,5	90- 13 /19,5 -CS10		-033						
	20	90- 13 /20 -CS10		-034						
	21	90- 13 /21 -CS10		-035						
	21,5	90- 13 /21,5 -CS10		-036						
	22	90- 13 /22 -CS10		-037						
	24	90- 13 /24 -CS10		-042						
	26,6	90- 13 /26,6 -CS10		-040-0980				080208	25	9
13,5	18	90- 13,5 /18 -CS12	27-13,5-CS12	37-031	HSS	24	10			
	19,5	90- 13,5 /19,5 -CS12		-032						
	20	90- 13,5 /20 -CS12		-033						
	20,5	90- 13,5 /20,5 -CS12		-034						
	21,5	90- 13,5 /21,5 -CS12		-035						
	22	90- 13,5 /22 -CS12		-036						
	22,5	90- 13,5 /22,5 -CS12		-037						
	24	90- 13,5 /24 -CS12		-041						
	26	90- 13,5 /26 -CS12		-043				080208	25	9
28,1	90- 13,5 /28,1 -CS12	-050-1030	C-0820	23	9					
14	18,5	90- 14 /18,5 -CS12	27-14-CS12	37-031	HSS	24	10			
	20	90- 14 /20 -CS12		-032						
	20,5	90- 14 /20,5 -CS12		-033						
	21	90- 14 /21 -CS12		-034						
	22	90- 14 /22 -CS12		-035						
	22,5	90- 14 /22,5 -CS12		-036						
	23	90- 14 /23 -CS12		-037						
	25	90- 14 /25 -CS12		-042						
	27	90- 14 /27 -CS12		-044				080208	25	9
29,6	90- 14 /29,6 -CS12	-050-1080	C-0820	23	9					
15	19,5	90- 15 /19,5 -CS12	27-15-CS12	37-031	HSS	24	10			
	21	90- 15 /21 -CS12		-032						
	21,5	90- 15 /21,5 -CS12		-033						
	22	90- 15 /22 -CS12		-034						
	23	90- 15 /23 -CS12		-035						
	23,5	90- 15 /23,5 -CS12		-036						
	24	90- 15 /24 -CS12		-037						
	26	90- 15 /26 -CS12		-042				080208	25	9
	30	90- 15 /30 -CS12		-052				C-0820	23	9
32,6	90- 15 /32,6 -CS12	-050-1180	C-1000							
15,5	20	90- 15,5 /20 -C12	27-15,5-CS12	37-031	HSS	24	10			
	21,5	90- 15,5 /21,5 -CS12		-032						
	22	90- 15,5 /22 -CS12		-033						
	22,5	90- 15,5 /22,5 -CS12		-034						
	23,5	90- 15,5 /23,5 -CS12		-035						
	24	90- 15,5 /24 -CS12		-036						
	24,5	90- 15,5 /24,5 -CS12		-037						
	26	90- 15,5 /26 -CS12		-041				080208	25	9
	30	90- 15,5 /30 -CS12		-051				C-0820	23	9
34,1	90- 15,5 /34,1 -CS12	-050-1230	C-1000							

BACK SPOT FACING

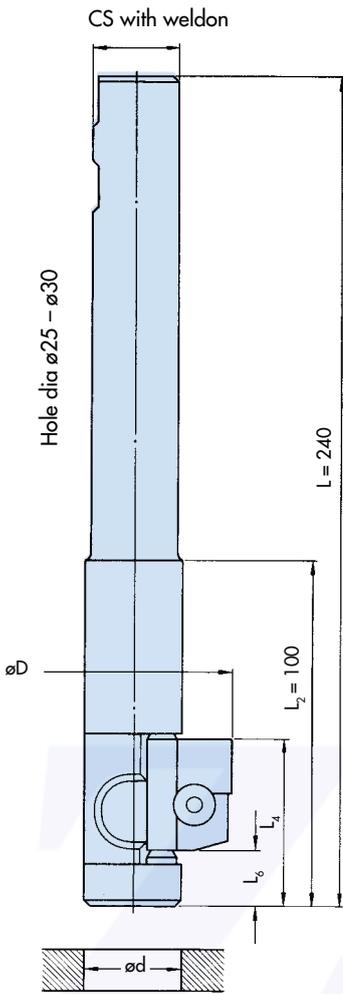


HOLE SIZE $\varnothing 16$ mm – $\varnothing 24$ mm

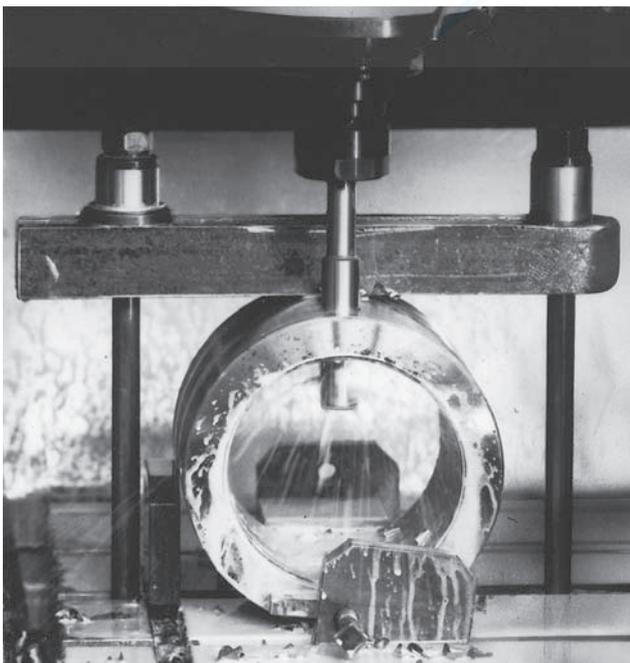
Hole dia $\varnothing d$	Facing dia $\varnothing D$	Complete tool	Spindle	Wing	Cutter/Insert	L_4	L_6
16	24	90- 16 / 24 -CS12	27-16-CS12	37-060-0750	Brazed	28	11
	26	90- 16 / 26 -CS12		-061	080208		
	30	90- 16 / 30 -CS12		-062	090308		
	33	90- 16 / 33 -CS12		-063			
	33,6	90- 16 / 33,6 -CS12		-070-1230	K-1050	28	
17	27	90- 17 / 27 -CS16	27-17-CS16	37-061	080208	28	11
	31	90- 17 / 31 -CS16		-062	090308	30	
	34	90- 17 / 34 -CS16		-063			
	36,6	90- 17 / 36.6 -CS16		-070-1330	K-1150	28	
17,5	26	90- 17.5 / 26 -CS16	27-17,5-CS16	37-060-0775	Brazed	28	11
	27,5	90- 17.5 / 27,5 -CS16		-061	080208		
	30	90- 17.5 / 30 -CS16		-060-0975		090308	
	31,5	90- 17.5 / 31.5 -CS16		-062			
	33	90- 17.5 / 33 -CS16		-060-1125	K-1150	28	
	34,5	90- 17.5 / 34,5 -CS16		-063			
	38,1	90- 17.5 / 38,1 -CS16		-070-1380			
18	28	90- 18 / 28 -CS16	27-18-CS16	37-061	080208	28	11
	32	90- 18 / 32 -CS16		-062	090308	30	
	35	90- 18 / 35 -CS16		-063			
	39,6	90- 18 / 39,6 -CS16		-070-1430	K-1250	28	
19	28	90- 19 / 28 -CS16	27-19-CS16	37-061	080208	28	11
	32	90- 19 / 32 -CS16		-062	090308	30	
	35	90- 19 / 35 -CS16		-063			
	40,6	90- 19 / 40,6 -CS16		-080-1480	K-1250	28	
20	29	90- 20 / 29 -CS16	27-20-CS16	37-061	080208	28	11
	30	90- 20 / 30 -CS16		-060-0900			
	33	90- 20 / 33 -CS16		-062	090308	30	
	36	90- 20 / 36 -CS16		-063			
	43,6	90- 20 / 43,6 -CS16		-080-1580	K-1350	28	
21	30	90- 21 / 30 -CS20	27-21-CS20	37-061	080208	28	11
	34	90- 21 / 34 -CS20		-062	090308	30	
	37	90- 21 / 37 -CS20		-063			
	46,6	90- 21 / 46,6 -CS20		-080-1680	K-1450	28	
22	30	90- 22 / 30 -CS20	27-22-CS20	37-061	080208	30	13
	33	90- 22 / 33 -CS20		-060-1000			
	34	90- 22 / 34 -CS20		-062	090308	32	
	36	90- 22 / 36 -CS20		-060-1150			
	37	90- 22 / 37 -CS20		-063	120308	33	
	40	90- 22 / 40 -CS20		-090-1350			
	41	90- 22 / 41 -CS20		-091	K-1450	30	
	47,6	90- 22 / 47,6 -CS20		-090-1730			
23	31	90- 23 / 31 -CS20	27-23-CS20	37-061	080208	30	13
	35	90- 23 / 35 -CS20		-062	090308	32	
	38	90- 23 / 38 -CS20		-063		120308	
	42	90- 23 / 42 -CS20		-091			
	50,6	90- 23 / 50,6 -CS20		-090-1830	K-1550	30	
24	32	90- 24 / 32 -CS20	27-24-CS20	37-061	080208	30	13
	36	90- 24 / 36 -CS20		-062	090308	32	
	39	90- 24 / 39 -CS20		-063			
	40	90- 24 / 40 -CS20		-090-1250	120308	33	
	43	90- 24 / 43 -CS20		-091			
	53,6	90- 24 / 53,6 -CS20		-090-1930	K-1650	30	



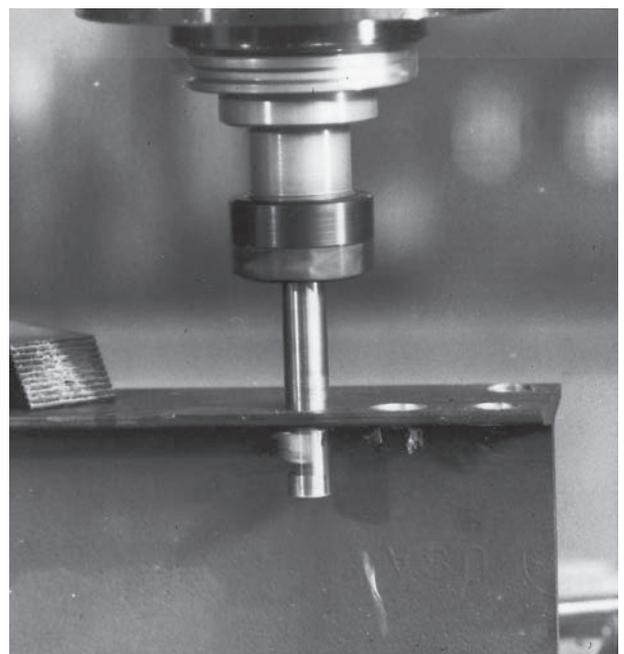
HOLE SIZE Ø25 mm – Ø30 mm



Hole dia ϕd	Facing dia ϕD	Complete tool	Spindle	Wing	Cutter/Insert	L_4	L_6
25	33	90-25/33-CS20	27-25-CS20	37-101	090308	46	15
	40	90-25/40-CS20		-102			
	45	90-25/45-CS20		-111	120308		
	50	90-25/50-CS20		-121	150412	46	
	50,4	90-25/50,4-CS20		-120-1870			
26	34	90-26/34-CS25	27-26-CS25	37-101	090308	46	15
	40	90-26/40-CS25		-100-1300			
	41	90-26/41-CS25		-102	120308	44	
	43	90-26/43-CS25		-110-1450			
	46	90-26/46-CS25		-111	150412	46	
	51	90-26/51-CS25		-121			
	53,4	90-26/53,4-CS25		-120-1970			
27	35	90-27/35-CS25	27-27-CS25	37-101	090308	46	15
	42	90-27/42-CS25		-102			
	47	90-27/47-CS25		-111	120308		
	52	90-27/52-CS25		-121	150412		
	56,4	90-27/56,4-CS25		-120-2070	190408	48	
28	36	90-28/36-CS25	27-28-CS25	37-101	090308	46	15
	43	90-28/43-CS25		-102			
	48	90-28/48-CS25		-111	120308		
	53	90-28/53-CS25		-121	150412		
	59,4	90-28/59,4-CS25		-120-2170	190408	48	
29	37	90-29/37-CS25	27-29-CS25	37-101	090308	46	15
	44	90-29/44-CS25		-102			
	49	90-29/49-CS25		-111	120308		
	54	90-29/54-CS25		-121	150412		
	62,4	90-29/62,4-CS25		-120-2270	190408	48	
30	38	90-30/38-CS25	27-30-CS25	37-101	090308	46	15
	43	90-30/43-CS25		-100-1250			
	45	90-30/45-CS25		-102	120308	44	
	46	90-30/46-CS25		-100-1400			
	50	90-30/50-CS25		-111	150412	46	
	53	90-30/53-CS25		-110-1750			
	55	90-30/55-CS25		-121			
	65,4	90-30/65,4-CS25		-120-2370	190408	48	



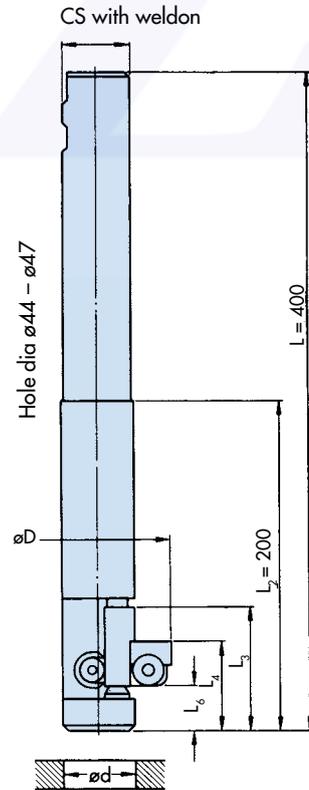
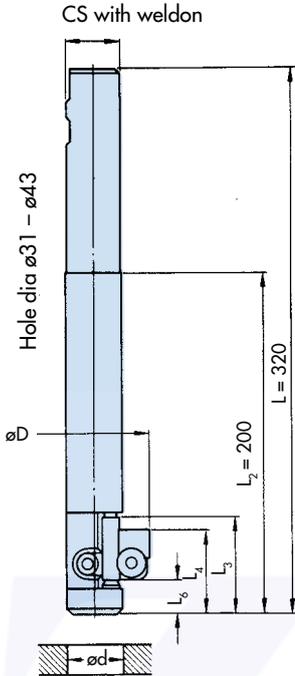
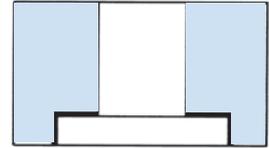
Back spotfacing with coolant through the spindle.



Back spotfacing with filleted corners.

BACK SPOT FACING

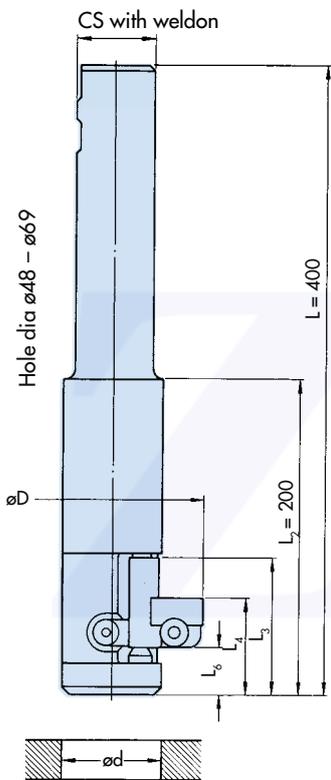
HOLE SIZE Ø31 mm – Ø47 mm



Hole dia ød	Facing dia øD	Complete tool	Spindle	Wing	Cutter/Insert	L ₃	L ₄	L ₆
31	54	90- 31 /54 -CS32	27-31-CS32	37-131	150412	58	47	21
	60	90- 31 /60 -CS32		-132	190408		50	
	62	90- 31 /62 -CS32		-130-2300				
32	55	90- 32 /55 -CS32	27-32-CS32	37-131	150412	58	47	21
	61	90- 32 /61 -CS32		-132	190408		50	
	65	90- 32 /65 -CS32		-130-2400				
33	48	90- 33 /48 -CS32	27-33-CS32	37-130-1500	090308	58	41	21
	53	90- 33 /53 -CS32		-130-1750	120308		44	
	56	90- 33 /56 -CS32		-131	150412		47	
	61	90- 33 /61 -CS32		-130-2150	190408		50	
	62	90- 33 /62 -CS32		-132				
	68	90- 33 /68 -CS32		-130-2500				
34	57	90- 34 /57 -CS32	27-34-CS32	37-131	150412	58	47	21
	63	90- 34 /63 -CS32		-132	190408		50	
	71	90- 34 /71 -CS32		-130-2600	EC 20		44	
35	58	90- 35 /58 -CS32	27-35-CS32	37-131	150412	58	47	21
	64	90- 35 /64 -CS32		-132	190408		50	
	74	90- 35 /74 -CS32		-130-2700	EC 20		44	
36	53	90- 36 /53 -CS32	27-36-CS32	37-140-1750	120308	68	51	28
	57	90- 36 /57 -CS32		-140-1950				
	63	90- 36 /63 -CS32		-141	150412		54	
	69	90- 36 /69 -CS32		-142	190408		57	
	71	90- 36 /71 -CS32		-140-2650	EC 20		51	
37	64	90- 37 /64 -CS32	27-37-CS32	37-141	150412	68	54	28
	70	90- 37 /70 -CS32		-142	190408		57	
	74	90- 37 /74 -CS32		-140-2750	EC 20		51	
38	65	90- 38 /65 -CS32	27-38-CS32	37-141	150412	68	54	28
	71	90- 38 /71 -CS32		-142	190408		57	
	77	90- 38 /77 -CS32		-140-2850	EC 25		53	
39	57	90- 39 /57 -CS32	27-39-CS32	37-140-1800	120308	68	51	28
	61	90- 39 /61 -CS32		-140-2000	120308		51	
	66	90- 39 /66 -CS32		-141	150412		54	
	71	90- 39 /71 -CS32		-140-2500	190408		57	
	72	90- 39 /72 -CS32		-142				
	80	90- 39 /80 -CS32		-140-2950	EC 25		53	
40	67	90- 40 /67 -CS32	27-40-CS32	37-141	150412	68	54	28
	73	90- 40 /73 -CS32		-142	190408		57	
	83	90- 40 /83 -CS32		-140-3050	EC 25		53	
41	68	90- 41 /68 -CS32	27-41-CS32	37-141	150412	68	54	28
	74	90- 41 /74 -CS32		-142	190408		57	
	86	90- 41 /86 -CS32		-140-3150	EC 25		53	
42	69	90- 42 /69 -CS32	27-42-CS32	37-141	150412	68	54	28
	75	90- 42 /75 -CS32		-142	190408		57	
	89	90- 42 /89 -CS32		-140-3250	EC 25		53	
43	70	90- 43 /70 -CS32	27-43-CS32	37-141	150412	68	54	28
	76	90- 43 /76 -CS32		-142	190408		57	
	92	90- 43 /92 -CS32		-140-3350	EC 25		53	
44	86	90- 44 /86 -CS40	27-44-CS40	37-151	EC 25	78	59	30
	87	90- 44 /87 -CS40		-150-3250				
45	66	90- 45 /66 -CS40	27-45-CS40	37-150-2150	150412	78	59	30
	71	90- 45 /71 -CS40		-150-2400				
	82	90- 45 /82 -CS40		-150-2950	EC 25			
	87	90- 45 /87 -CS40		-151				
	90	90- 45 /90 -CS40		-150-3350				
46	88	90- 46 /88 -CS40	27-46-CS40	37-151	EC 25	78	59	30
	93	90- 46 /93 -CS40		-150-3450				
47	89	90- 47 /89 -CS40	27-47-CS40	37-151	EC 25	78	59	30
	96	90- 47 /96 -CS40		-150-3550				

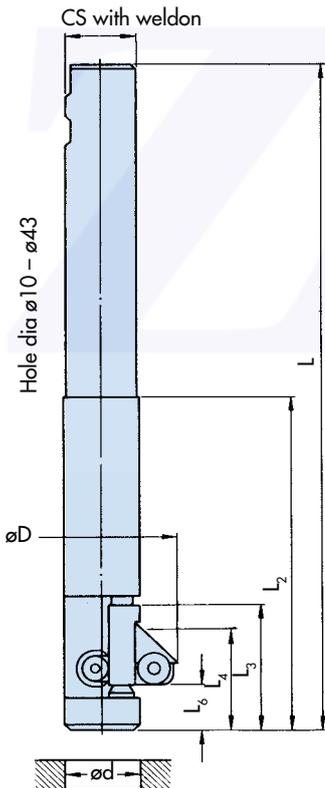
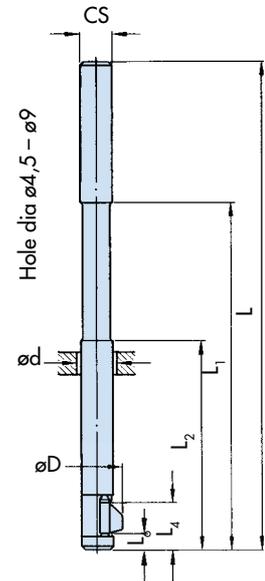
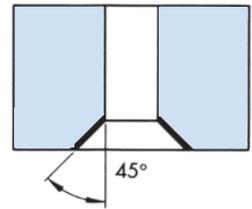
HOLE SIZE Ø49mm – Ø69 mm

Hole dia øD	Facing dia øD	Complete tool	Spindle	Wing	Cutter/Insert	L ₃	L ₄	L ₆
48	90	90- 48 /90 -CS40	27-48-CS40	37-151	EC25	78	59	30
	99	90- 48 /99 -CS40		-150-3650	EC32		63	
49	91	90- 49 /91 -CS40	27-49-CS40	37-151	EC25	78	59	30
	102	90- 49 /102 -CS40		-150-3750	EC32		63	
50	92	90- 50 /92 -CS40	27-50-CS40	37-151	EC25	78	59	30
	105	90- 50 /105 -CS40		-150-3850	EC32		63	
51	93	90- 51 /93 -CS40	27-51-CS40	37-151	EC25	78	59	30
	108	90- 51 /108 -CS40		-150-3950	EC32		63	
52	76	90- 52 /76 -CS40	27-52-CS40	37-150-2300	150412	78	59	30
	78	90- 52 /78 -CS40		-150-2400				
	94	90- 52 /94 -CS40		-151	EC25		63	
	98	90- 52 /98 -CS40		-150-3400				
111	90- 52 /111 -CS40	-150-4050	EC32					
53	95	90- 53 /95 -CS40	27-53-CS40	37-151	EC25	78	59	30
	114	90- 53 /114 -CS40		-150-4150	EC32		63	
54	94	90- 54 /94 -CS50	27-54-CS50	37-161	EC25	88	59	30
	108	90- 54 /108 -CS50		-162	EC32		63	
	109	90- 54 /109 -CS50		-160-4050				
55	95	90- 55 /95 -CS50	27-55-CS50	37-161	EC25	88	59	30
	109	90- 55 /109 -CS50		-162	EC32		63	
	112	90- 55 /112 -CS50		-160-4150				
56	96	90- 56 /96 -CS50	27-56-CS50	37-161	EC25	88	59	30
	110	90- 56 /110 -CS50		-162	EC32		63	
	115	90- 56 /115 -CS50		-160-4250				
57	97	90- 57 /97 -CS50	27-57-CS50	37-161	EC25	88	59	30
	111	90- 57 /111 -CS50		-162	EC32		63	
	118	90- 57 /118 -CS50		-160-4350				
58	98	90- 58 /98 -CS50	27-58-CS50	37-161	EC25	88	59	30
	112	90- 58 /112 -CS50		-162	EC32		63	
	121	90- 58 /121 -CS50		-160-4450				
59	99	90- 59 /99 -CS50	27-59-CS50	37-161	EC25	88	59	30
	113	90- 59 /113 -CS50		-162	EC32		63	
	124	90- 59 /124 -CS50		-160-4550				
60	100	90- 60 /100 -CS50	27-60-CS50	37-161	EC25	88	59	30
	114	90- 60 /114 -CS50		-162	EC32		63	
	127	90- 60 /127 -CS50		-160-4650				
61	101	90- 61 /101 -CS50	27-61-CS50	37-161	EC25	88	59	30
	115	90- 61 /115 -CS50		-162	EC32		63	
	130	90- 61 /130 -CS50		-160-4750				
62	102	90- 62 /102 -CS50	27-62-CS50	37-161	EC25	88	59	30
	116	90- 62 /116 -CS50		-162	EC32		63	
	133	90- 62 /133 -CS50		-160-4850				
63	103	90- 63 /103 -CS50	27-63-CS50	37-161	EC25	88	59	30
	117	90- 63 /117 -CS50		-162	EC32		63	
	136	90- 63 /136 -CS50		-160-4950				
64	104	90- 64 /104 -CS50	27-64-CS50	37-161	EC25	88	59	30
	118	90- 64 /118 -CS50		-162	EC32		63	
	139	90- 64 /139 -CS50		-160-5050				
65	105	90- 65 /105 -CS50	27-65-CS50	37-161	EC25	88	59	30
	119	90- 65 /119 -CS50		-162	EC32		63	
	142	90- 65 /142 -CS50		-160-5150				
66	106	90- 66 /106 -CS50	27-66-CS50	37-161	EC25	88	59	30
	120	90- 66 /120 -CS50		-162	EC32		63	
	145	90- 66 /145 -CS50		-160-5250				
67	107	90- 67 /107 -CS50	27-67-CS50	37-161	EC25	88	59	30
	121	90- 67 /121 -CS50		-162	EC32		63	
	146	90- 67 /146 -CS50		-160-5250				
68	108	90- 68 /108 -CS50	27-68-CS50	37-161	EC25	88	59	30
	122	90- 68 /122 -CS50		-162	EC32		63	
	147	90- 68 /147 -CS50		-160-5250				
69	109	90- 69 /109 -CS50	27-69-CS50	37-161	EC25	88	59	30
	123	90- 69 /123 -CS50		-162	EC32		63	
	148	90- 69 /148 -CS50		-160-5250				



BACK CHAMFERING 45°

HOLE SIZE Ø4,5mm – Ø43 mm



Hole dia ød	Facing dia øD	Complete tool	Spindle	Wing	Cutter/Insert	L ₃	L ₄	L ₅
4,5	8	45- 4,5 / 8 -CS6	27-4,5-CS6	34-011	HSS		11	5
5,5	9	45- 5,5 / 9 -CS6	-5,5					
6,5	9,5	45- 6,5 / 9,5 -CS6	-6,5					
7	14,4	45- 7 / 14,4 -CS8	27-7-CS8	34-023	HSS		15	5
8,4	15,6	45- 8,4 / 15,6 -CS8	-8,4					
9	16	45- 9 / 16 -CS8	-9					

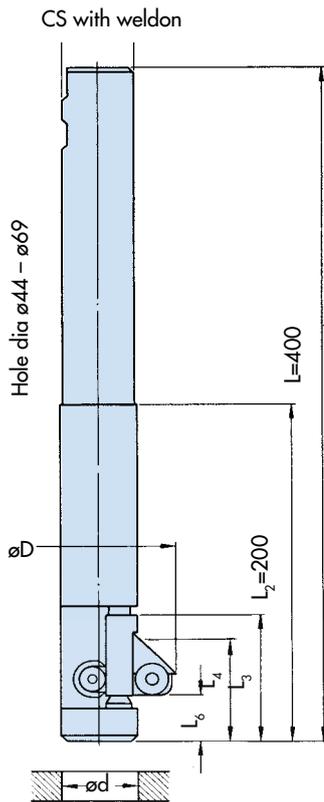
10	19	45- 10 / 19 -CS10	27-10-CS10	34-035	HSS		24	10
10,5	19,5	45- 10,5 / 19,5 -CS10	-10,5					
11	20	45- 11 / 20 -CS10	-11					
12	21	45- 12 / 21 -CS10	-12					
13	21	45- 13 / 21 -CS10	-13					
13,5	21,5	45- 13,5 / 21,5 -CS12	27-13,5-CS12					
14	22	45- 14 / 22 -CS12	-14					
15	23	45- 15 / 23 -CS12	-15					
15,5	23,5	45- 15,5 / 23,5 -CS12	-15,5					

16	33	45- 16 / 33 -CS12	27-16-CS12	34-063	090308X45		30	11
17	34	45- 17 / 34 -CS16	27-17-CS16					
17,5	34,5	45- 17,5 / 34,5 -CS16	-17,5					
18	35	45- 18 / 35 -CS16	-18					
19	35	45- 19 / 35 -CS16	-19					
20	36	45- 20 / 36 -CS16	-20					
21	37	45- 21 / 37 -CS20	27-21-CS20					
22	37	45- 22 / 37 -CS20	-22					
23	38	45- 23 / 38 -CS20	-23					
24	39	45- 24 / 39 -CS20	-24					
25	50	45- 25 / 50 -CS20	-25	34-121	150412X45		46	15
26	51	45- 26 / 51 -CS25	27-26-CS25					
27	52	45- 27 / 52 -CS25	-27					
28	53	45- 28 / 53 -CS25	-28					
29	54	45- 29 / 54 -CS25	-29					
30	55	45- 30 / 55 -CS25	-30					

31	60	45- 31 / 60 -CS32	27-31-CS32	34-132	190408X45	58	50	21
32	61	45- 32 / 61 -CS32	-32					
33	62	45- 33 / 62 -CS32	-33					
34	63	45- 34 / 63 -CS32	-34					
35	64	45- 35 / 64 -CS32	-35	34-142	190408X45	68	57	28
36	69	45- 36 / 69 -CS32	27-36-CS32					
37	70	45- 37 / 70 -CS32	-37					
38	71	45- 38 / 71 -CS32	-38					
39	72	45- 39 / 72 -CS32	-39					
40	73	45- 40 / 73 -CS32	-40					
41	74	45- 41 / 74 -CS32	-41					
42	75	45- 42 / 75 -CS32	-42					
43	76	45- 43 / 76 -CS32	-43					

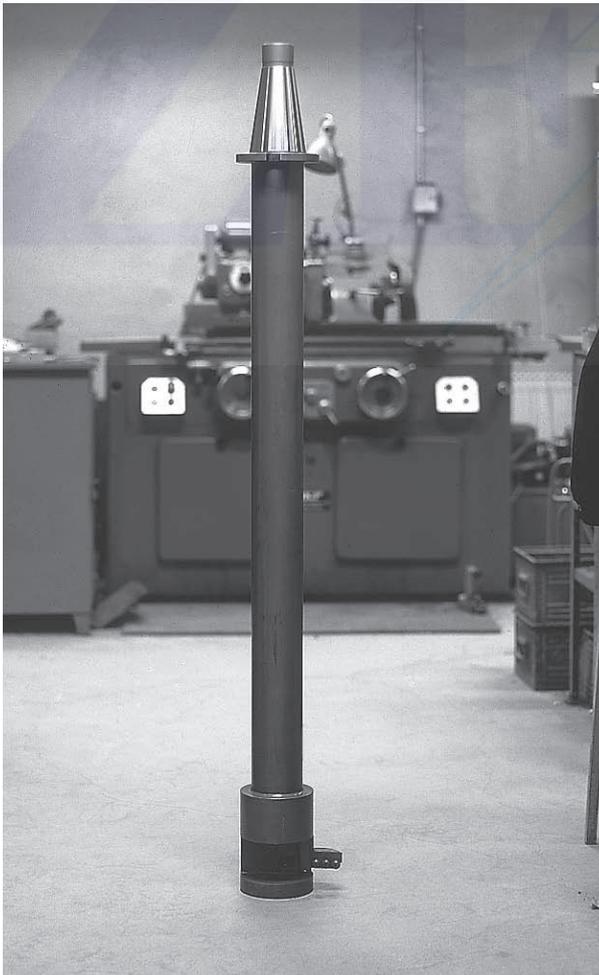
Hole dia	L	L ₁	L ₂
4,5 - 6,5	120	80	40
7 - 9	140	100	60
10 - 15,5	160	-	80
16 - 30	240	-	100
31 - 43	320	-	200

HOLE SIZE Ø44mm – Ø69 mm

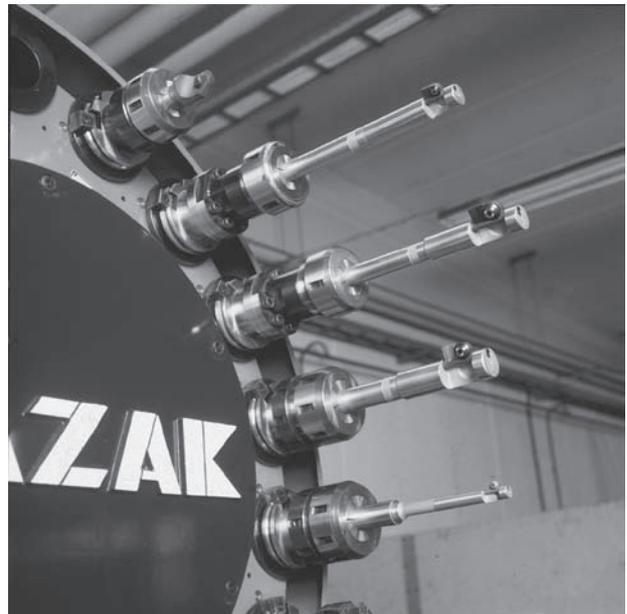


Hole dia ød	Facing dia øD	Complete tool	Spindle	Wing	Cutter/Insert	L ₃	L ₄	L ₆
44	79	45- 44 /79 -CS40	27-44-CS40	34-150	190408X45	78	63	30
45	80	45- 45 /80 -CS40	-45					
46	81	45- 46 /81 -CS40	-46					
47	82	45- 47 /82 -CS40	-47					
48	83	45- 48 /83 -CS40	-48					
49	84	45- 49 /84 -CS40	-49					
50	85	45- 50 /85 -CS40	-50					
51	86	45- 51 /86 -CS40	-51					
52	87	45- 52 /87 -CS40	-52					
53	88	45- 53 /88 -CS40	-53					

54	89	45- 54 /89 -CS50	27-54-CS50	34-160	190408X45	88	63	30
55	90	45- 55 /90 -CS50	-55					
56	91	45- 56 /91 -CS50	-56					
57	92	45- 57 /92 -CS50	-57					
58	93	45- 58 /93 -CS50	-58					
59	94	45- 59 /94 -CS50	-59					
60	95	45- 60 /95 -CS50	-60					
61	96	45- 61 /96 -CS50	-61					
62	97	45- 62 /97 -CS50	-62					
63	98	45- 63 /98 -CS50	-63					
64	99	45- 64 /99 -CS50	-64					
65	100	45- 65 /100 -CS50	-65					
66	101	45- 66 /101 -CS50	-66					
67	102	45- 67 /102 -CS50	-67					
68	103	45- 68 /103 -CS50	-68					
69	104	45- 69 /104 -CS50	-69					



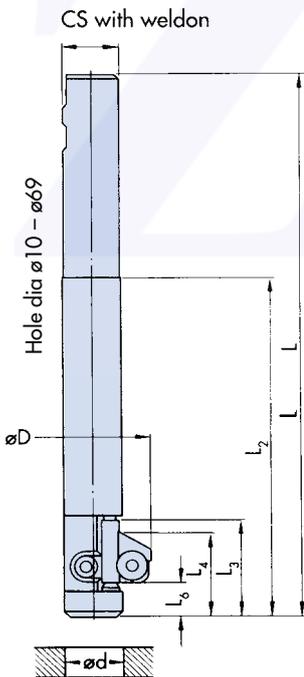
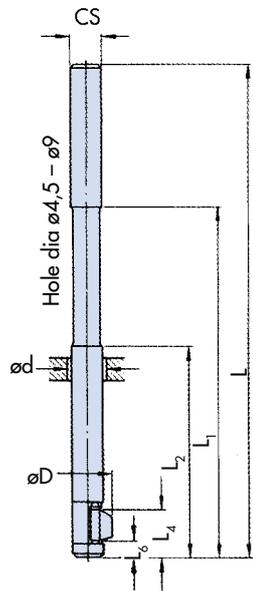
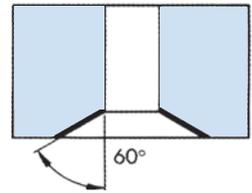
Special tool to operate in a diesel engine block.



tools in a NC-Machine.

BACK CHAMFERING 60°

HOLE SIZE Ø4,5mm – Ø69 mm

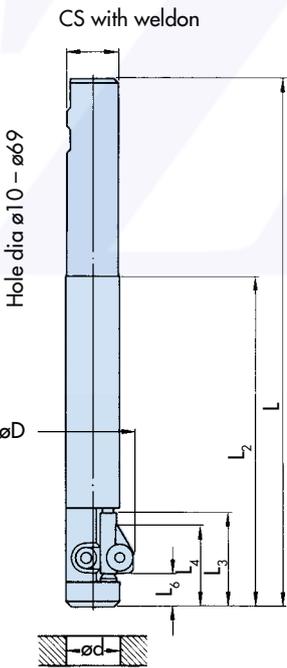
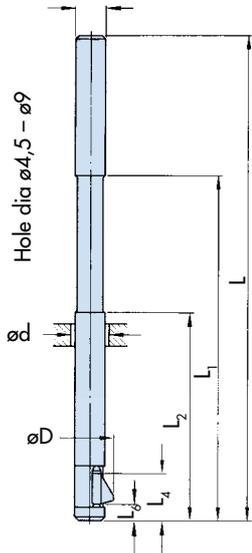
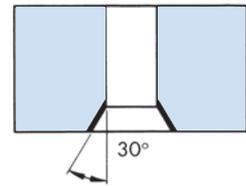


Hole dia	L	L ₁	L ₂
4,5 - 6,5	120	80	40
7 - 9	140	100	60
10 - 15,5	160		80
16 - 30	240		100
31 - 43	320		200
44 - 69	400		200

Hole dia ød	Facing dia øD	Complete tool	Spindle	Wing	Cutter/Insert	L ₃	L ₄	L ₆
4,5	8	60- 4,5 / 8 -CS6	27-4,5-CS6	34-011-60	HSS		11	5
5,5	9	60- 5,5 / 9 -CS6	-5,5					
6,5	9,5	60- 6,5 / 9,5 -CS6	-6,5					
7	14,4	60- 7 / 14,4 -CS8	27-7-CS8	34-023-60	HSS		15	5
8,4	15,6	60- 8,4 / 15,6 -CS8	-8,4					
9	16	60- 9 / 16 -CS8	-9					
10	19	60- 10 / 19 -CS10	27-10-CS10					
10,5	19,5	60- 10,5 / 19,5 -CS10	-10,5					
11	20	60- 11 / 20 -CS10	-11	34-035-60	HSS		24	10
12	21	60- 12 / 21 -CS10	-12					
13	21	60- 13 / 21 -CS10	-13					
13,5	21,5	60- 13,5 / 21,5 -CS12	27-13,5-CS12					
14	22	60- 14 / 22 -CS12	-14					
15	23	60- 15 / 23 -CS12	-15					
15,5	23,5	60- 15,5 / 23,5 -CS12	-15,5					
16	33	60- 16 / 33 -CS12	27-16-CS12					
17	34	60- 17 / 34 -CS16	27-17-CS16					
17,5	34,5	60- 17,5 / 34,5 -CS16	-17,5					
18	35	60- 18 / 35 -CS16	-18					
19	35	60- 19 / 35 -CS16	-19					
20	36	60- 20 / 36 -CS16	-20					
21	37	60- 21 / 37 -CS20	27-21-CS20					
22	37	60- 22 / 37 -CS20	-22					
23	38	60- 23 / 38 -CS20	-23					
24	39	60- 24 / 39 -CS20	-24					
25	50	60- 25 / 50 -CS20	-25	34-121-60	150412X60		46	15
26	51	60- 26 / 51 -CS25	27-26-CS25					
27	52	60- 27 / 52 -CS25	-27					
28	53	60- 28 / 53 -CS25	-28					
29	54	60- 29 / 54 -CS25	-29					
30	55	60- 30 / 55 -CS25	-30	34-132-60	190408X60	58	50	21
31	60	60- 31 / 60 -CS32	27-31-CS32					
32	61	60- 32 / 61 -CS32	-32					
33	62	60- 33 / 62 -CS32	-33					
34	63	60- 34 / 63 -CS32	-34					
35	64	60- 35 / 64 -CS32	-35					
36	69	60- 36 / 69 -CS32	27-36-CS32					
37	70	60- 37 / 70 -CS32	-37					
38	71	60- 38 / 71 -CS32	-38					
39	72	60- 39 / 72 -CS32	-39					
40	73	60- 40 / 73 -CS32	-40					
41	74	60- 41 / 74 -CS32	-41					
42	75	60- 42 / 75 -CS32	-42					
43	76	60- 43 / 76 -CS32	-43					
44	79	60- 44 / 79 -CS40	27-44-CS40	34-150-60	190408X60	78	63	30
45	80	60- 45 / 80 -CS40	-45					
46	81	60- 46 / 81 -CS40	-46					
47	82	60- 47 / 82 -CS40	-47					
48	83	60- 48 / 83 -CS40	-48					
49	84	60- 49 / 84 -CS40	-49					
50	85	60- 50 / 85 -CS40	-50					
51	86	60- 51 / 86 -CS40	-51					
52	87	60- 52 / 87 -CS40	-52					
53	88	60- 53 / 88 -CS40	-53					
54	89	60- 54 / 89 -CS50	27-54-CS50	34-160-60	190408X60	88	63	30
55	90	60- 55 / 90 -CS50	-55					
56	91	60- 56 / 91 -CS50	-56					
57	92	60- 57 / 92 -CS50	-57					
58	93	60- 58 / 93 -CS50	-58					
59	94	60- 59 / 94 -CS50	-59					
60	95	60- 60 / 95 -CS50	-60					
61	96	60- 61 / 96 -CS50	-61					
62	97	60- 62 / 97 -CS50	-62					
63	98	60- 63 / 98 -CS50	-63					
64	99	60- 64 / 99 -CS50	-64					
65	100	60- 65 / 100 -CS50	-65					
66	101	60- 66 / 101 -CS50	-66					
67	102	60- 67 / 102 -CS50	-67					
68	103	60- 68 / 103 -CS50	-68					
69	104	60- 69 / 104 -CS50	-69					

BACK CHAMFERING 30°

HOLE SIZE Ø4,5mm – Ø69

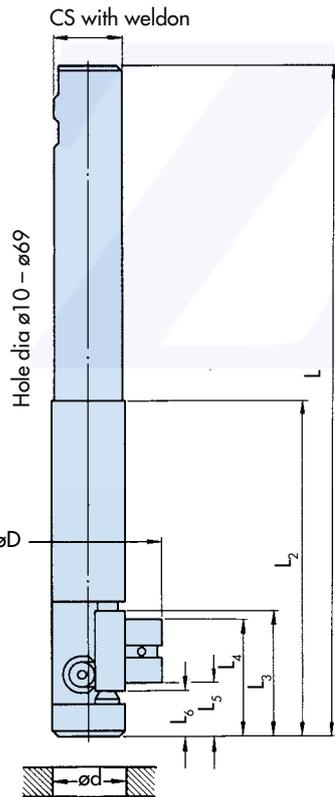
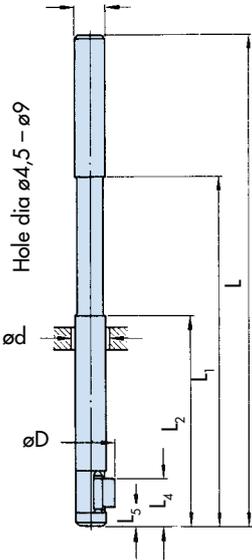
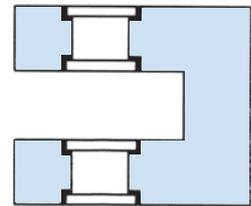


Hole dia	L	L ₁	L ₂
4,5 - 6,5	120	80	40
7 - 9	140	100	60
10 - 15,5	160		80
16 - 30	240		100
31 - 43	320		200
44 - 69	400		200

Hole dia ød	Facing dia øD	Complete tool	Spindle	Wing	Cutter/Insert	L ₃	L ₄	L ₆					
4,5	8	30- 4,5 / 8 -CS6	27-4,5-CS6	34-011-30	HSS		11	5					
5,5	9	30- 5,5 / 9 -CS6	-5,5										
6,5	9,5	30- 6,5 / 9,5 -CS6	-6,5										
7	14,4	30- 7 / 14,4 -CS8	27-7-CS8	34-023-30	HSS		15	5					
8,4	15,6	30- 8,4 / 15,6 -CS8	-8,4										
9	16	30- 9 / 16 -CS8	-9										
10	19	30- 10 / 19 -CS10	27-10-CS10	34-035-30	HSS		24	10					
10,5	19,5	30- 10,5 / 19,5 -CS10	-10,5										
11	20	30- 11 / 20 -CS10	-11										
12	21	30- 12 / 21 -CS10	-12										
13	21	30- 13 / 21 -CS10	-13										
13,5	21,5	30- 13,5 / 21,5 -CS12	27-13,5-CS12										
14	22	30- 14 / 22 -CS12	-14										
15	23	30- 15 / 23 -CS12	-15										
15,5	23,5	30- 15,5 / 23,5 -CS12	-15,5										
16	26	30- 16 / 26 -CS12	27-16-CS12						34-061-30	090308X30		30	11
17	27	30- 17 / 27 -CS16	27-17-CS16										
17,5	27,5	30- 17,5 / 27,5 -CS16	-17,5										
18	28	30- 18 / 28 -CS16	-18										
19	28	30- 19 / 28 -CS16	-19										
20	29	30- 20 / 29 -CS16	-20										
21	30	30- 21 / 30 -CS20	27-21-CS20										
22	30	30- 22 / 30 -CS20	-22										
23	31	30- 23 / 31 -CS20	-23										
24	32	30- 24 / 32 -CS20	-24										
25	40	30- 25 / 40 -CS20	27-25-CS20	34-102-30	150412X30		46	15					
26	41	30- 26 / 41 -CS25	27-26-CS25										
27	42	30- 27 / 42 -CS25	-27										
28	43	30- 28 / 43 -CS25	-28										
29	44	30- 29 / 44 -CS25	-29										
30	45	30- 30 / 45 -CS25	-30										
31	51	30- 31 / 51 -CS32	27-31-CS32						34-130-30	190408X30	58	50	21
32	52	30- 32 / 52 -CS32	-32										
33	53	30- 33 / 53 -CS32	-33										
34	54	30- 34 / 54 -CS32	-34										
35	55	30- 35 / 55 -CS32	-35										
36	56	30- 36 / 56 -CS32	27-36-CS32										
37	57	30- 37 / 57 -CS32	-37	34-140-30	190408X30	68	57	28					
38	58	30- 38 / 58 -CS32	-38										
39	59	30- 39 / 59 -CS32	-39										
40	60	30- 40 / 60 -CS32	-40										
41	61	30- 41 / 61 -CS32	-41										
42	62	30- 42 / 62 -CS32	-42										
43	63	30- 43 / 63 -CS32	-43										
44	64	30- 44 / 64 -CS40	27-44-CS40						34-150-30	190408X30	78	63	30
45	65	30- 45 / 65 -CS40	-45										
46	66	30- 46 / 66 -CS40	-46										
47	67	30- 47 / 67 -CS40	-47										
48	68	30- 48 / 68 -CS40	-48										
49	69	30- 49 / 69 -CS40	-49										
50	70	30- 50 / 70 -CS40	-50										
51	71	30- 51 / 71 -CS40	-51										
52	72	30- 52 / 72 -CS40	-52										
53	73	30- 53 / 73 -CS40	-53										
54	74	30- 54 / 74 -CS50	27-54-CS50	34-160-30	190408X30	88	63	30					
55	75	30- 55 / 75 -CS50	-55										
56	76	30- 56 / 76 -CS50	-56										
57	77	30- 57 / 77 -CS50	-57										
58	78	30- 58 / 78 -CS50	-58										
59	79	30- 59 / 79 -CS50	-59										
60	80	30- 60 / 80 -CS50	-60										
61	81	30- 61 / 81 -CS50	-61										
62	82	30- 62 / 82 -CS50	-62										
63	83	30- 63 / 83 -CS50	-63										
64	84	30- 64 / 84 -CS50	-64										
65	85	30- 65 / 85 -CS50	-65										
66	86	30- 66 / 86 -CS50	-66										
67	87	30- 67 / 87 -CS50	-67										
68	88	30- 68 / 88 -CS50	-68										
69	89	30- 69 / 89 -CS50	-69										

FRONT AND BACK SPOTFACING

HOLE SIZE Ø4,5mm – Ø69 mm

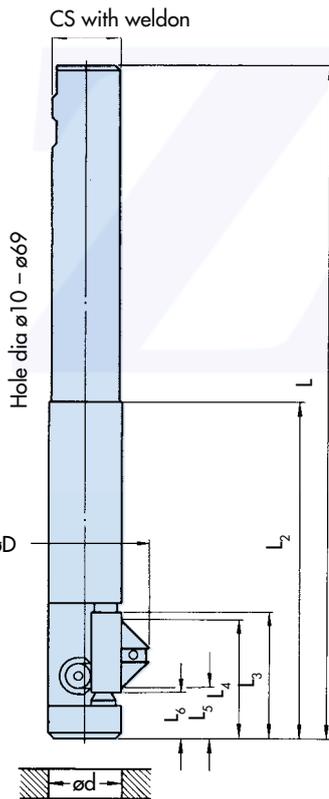
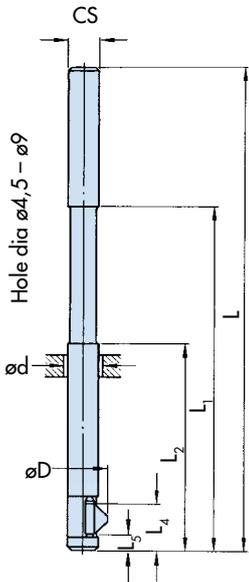
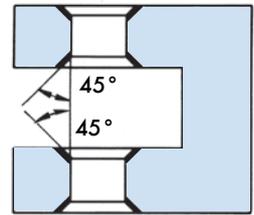


Hole dia	L	L ₁	L ₂
4,5 - 6,5	120	80	40
7 - 9	140	100	60
10 - 15,5	160		80
16 - 30	240		100
31 - 43	320		200
44 - 69	400		200

Hole dia ød	Facing dia øD	Complete tool	Spindle	Wing	Cutter/Insert	L ₃	L ₄	L ₅	L ₆
4,5	8,3	902-4,5/8,3-CS6	27-4,5-CS6	36-010-0315					
5,5	11,3	902-5,5/11,3-CS6	-5,5	-0415	HSS		11	6	
6,5	13,3	902-6,5/13,3-CS6	-6,5	-0490					
7	14,4	902-7/14,4-CS8	27-7-CS8	36-020-0530					
8,4	18,2	902-8,4/18,2-CS8	-8,4	-020-0660	HSS		14	6	
9	19,6	902-9/19,6-CS8	-9	-0710					
10	19,6	902-10/19,6-CS10	27-10-CS10	36-030-0730					
10,5	21,1	902-10,5/21,1-CS10	-10,5	-0780	HSS		24	12	
11	22,6	902-11/22,6-CS10	-11	-0830					
12	25,6	902-12/25,6-CS10	-12	-040-0930					
13	26,6	902-13/26,6-CS10	-13	-0980					
13,5	28,1	902-13,5/28,1-CS12	27-13,5-CS12	-050-1030	Brazed		23	11	
14	29,6	902-14/29,6-CS12	-14	-1080					
15	32,6	902-15/32,6-CS12	-15	-1180					
15,5	34,1	902-15,5/34,1-CS12	-15,5	-1230					
16	33,6	902-16/33,6-CS12	27-16-CS12	36-070-1230					
17	36,6	902-17/36,6-CS16	27-17-CS16	-1330					
17,5	38,1	902-17,5/38,1-CS16	-17,5	-1380					
18	39,6	902-18/39,6-CS16	-18	-1430			28	13	
19	40,6	902-19/40,6-CS16	-19	-080-1480	Brazed				
20	43,6	902-20/43,6-CS16	-20	-1580					
21	46,6	902-21/46,6-CS20	27-21-CS20	-1680					
22	47,6	902-22/47,6-CS20	-22	-090-1730					
23	50,6	902-23/50,6-CS20	-23	-1830			30	15	
24	53,6	902-24/53,6-CS20	-24	-1930					
25	50,4	902-25/50,4-CS20	27-25-CS20	36-120-1870			44	21	
26	53,4	902-26/53,4-CS25	27-26-CS25	-1970					
27	56,4	902-27/56,4-CS25	-27	-2070	Brazed		42	22	
28	59,4	902-28/59,4-CS25	-28	-2170					
29	62,4	902-29/62,4-CS25	-29	-2270					
30	65,4	902-30/65,4-CS25	-30	-2370					
31	62	902-31/62-CS32	27-31-CS32(F/B)	36-130-2300					
32	65	902-32/65-CS32	-32	-2400	Brazed		58	49	30
33	68	902-33/68-CS32	-33	-2500					
34	71	902-34/71-CS32	-34	-2600					
35	74	902-35/74-CS32	-35	-2700					
36	71	902-36/71-CS32	27-36-CS32(F/B)	36-140-2650					
37	74	902-37/74-CS32	-37	-2750					
38	77	902-38/77-CS32	-38	-2850					
39	80	902-39/80-CS32	-39	-2950	Brazed		68	59	37
40	83	902-40/83-CS32	-40	-3050					
41	86	902-41/86-CS32	-41	-3150					
42	89	902-42/89-CS32	-42	-3250					
43	92	902-43/92-CS32	-43	-3350					
44	87	902-44/87-CS40	27-44-CS40(F/B)	36-150-3250					
45	90	902-45/90-CS40	-45	-3350					
46	93	902-46/93-CS40	-46	-3450					
47	96	902-47/96-CS40	-47	-3550					
48	99	902-48/99-CS40	-48	-3650	Brazed		78	66	42
49	102	902-49/102-CS40	-49	-3750					
50	105	902-50/105-CS40	-50	-3850					
51	108	902-51/108-CS40	-51	-3950					
52	111	902-52/111-CS40	-52	-4050					
53	114	902-53/114-CS40	-53	-4150					
54	109	902-54/109-CS50	27-54-CS50(F/B)	36-160-4050					
55	112	902-55/112-CS50	-55	-4150					
56	115	902-56/115-CS50	-56	-4250					
57	118	902-57/118-CS50	-57	-4350					
58	121	902-58/121-CS50	-58	-4450					
59	124	902-59/124-CS50	-59	-4550					
60	127	902-60/127-CS50	-60	-4650					
61	130	902-61/130-CS50	-61	-4750					
62	133	902-62/133-CS50	-62	-4850	Brazed		88	71	47
63	136	902-63/136-CS50	-63	-4950					
64	139	902-64/139-CS50	-64	-5050					
65	142	902-65/142-CS50	-65	-5150					
66	145	902-66/145-CS50	-66	-5250					
67	146	902-67/146-CS50	-67	-5250					
68	147	902-68/147-CS50	-68	-5250					
69	148	902-69/148-CS50	-69	-5250					

FRONT AND BACK CHAMFERING 45°

HOLE SIZE Ø4,5mm – Ø69 mm



Hole dia	L	L ₁	L ₂
4,5 -6,5	120	80	40
7 - 9	140	100	60
10 -15,5	160		80
16 -30	240		100
31 -43	320		200
44 -69	400		200

Hole dia ød	Facing dia øD	Complete tool	Spindle	Wing	Cutter/Insert	L ₃	L ₄	L ₅	L ₆
4,5	8	452- 4,5/8 -CS6	27-4,5-CS6	35-011	HSS		11	6	
5,5	9	452- 5,5/9 -CS6	-5,5						
6,5	9,5	452- 6,5/9,5 -CS6	-6,5						
7	13,8	452- 7/13,8 -CS8	27-7-CS8	35-022	HSS		14	6	
8,4	15,0	452- 8,4/15,0 -CS8	-8,4						
9	15,4	452- 9/15,4 -CS8	-9						
10	19	452- 10/19 -CS10	27-10-CS10	35-035	HSS		24	11	
10,5	19,5	452- 10,5/19,5 -CS10	-10,5						
11	20	452- 11/20 -CS10	-11						
12	21	452- 12/21 -CS10	-12						
13	21	452- 13/21 -CS10	-13						
13,5	21,5	452- 13,5/21,5 -CS12	27-13,5-CS12						
14	22	452- 14/22 -CS12	-14						
15	23	452- 15/23 -CS12	-15						
15,5	23,5	452- 15,5/23,5 -CS12	-15,5						
16	27,8	452- 16/27,8 -CS12	27-16-CS12						
17	28,8	452- 17/28,8 -CS16	27-17-CS16						
17,5	29,3	452- 17,5/29,3 -CS16	-17,5						
18	29,8	452- 18/29,8 -CS16	-18						
19	29,8	452- 19/29,8 -CS16	-19						
20	30,8	452- 20/30,8 -CS16	-20						
21	31,8	452- 21/31,8 -CS20	27-21-CS20						
22	31,8	452- 22/31,8 -CS20	-22						
23	32,8	452- 23/32,8 -CS20	-23						
24	33,8	452- 24/33,8 -CS20	-24						
25	40	452- 25/40 -CS20	27-25-CS20	35-102	Brazed		44	18	
26	41	452- 26/41 -CS25	27-26-CS25						
27	42	452- 27/42 -CS25	-27						
28	43	452- 28/43 -CS25	-28						
29	44	452- 29/44 -CS25	-29						
30	45	452- 30/45 -CS25	-30						
31	46	452- 31/46 -CS32	27-31-CS32(F/B)	35-130	Brazed	58	51	28	21
32	47	452- 32/47 -CS32	-32						
33	48	452- 33/48 -CS32	-33						
34	49	452- 34/49 -CS32	-34						
35	50	452- 35/50 -CS32	-35						
36	51	452- 36/51 -CS32	27-36-CS32(F/B)	35-140	Brazed	68	60	37	28
37	52	452- 37/52 -CS32	-37						
38	53	452- 38/53 -CS32	-38						
39	54	452- 39/54 -CS32	-39						
40	55	452- 40/55 -CS32	-40						
41	56	452- 41/56 -CS32	-41						
42	57	452- 42/57 -CS32	-42						
43	58	452- 43/58 -CS32	-43						
44	60	452- 44/60 -CS40	27-44-CS40(F/B)	35-150	Brazed	78	69	39	30
45	61	452- 45/61 -CS40	-45						
46	62	452- 46/62 -CS40	-46						
47	63	452- 47/63 -CS40	-47						
48	64	452- 48/64 -CS40	-48						
49	65	452- 49/65 -CS40	-49						
50	66	452- 50/66 -CS40	-50						
51	67	452- 51/67 -CS40	-51						
52	68	452- 52/68 -CS40	-52						
53	69	452- 53/69 -CS40	-53						
54	82	452- 54/82 -CS50	27-54-CS50(F/B)	35-160	Brazed	88	78	40	30
55	83	452- 55/83 -CS50	-55						
56	84	452- 56/84 -CS50	-56						
57	85	452- 57/85 -CS50	-57						
58	86	452- 58/86 -CS50	-58						
59	87	452- 59/87 -CS50	-59						
60	88	452- 60/88 -CS50	-60						
61	89	452- 61/89 -CS50	-61						
62	90	452- 62/90 -CS50	-62						
63	91	452- 63/91 -CS50	-63						
64	92	452- 64/92 -CS50	-64						
65	93	452- 65/93 -CS50	-65						
66	94	452- 66/94 -CS50	-66						
67	95	452- 67/95 -CS50	-67						
68	96	452- 68/96 -CS50	-68						
69	97	452- 69/97 -CS50	-69						

COMBINATION TABLE

In this table are listed all combinations, to do various spotfaces, which are possible with spindles and backspotfacing wings listed in the metric and inch catalogues.

Spindles are specified by hole diameter and listed along the top of each table horizontally. Wings are specified by part number and located vertically along the lefthand margin of the table. The spotfacing diameters these spindles and wings will produce are located in the several columns located below the hole diameters and to the right of the wing part numbers. These spotfacing diameters are given in mm.

To locate a particular combination, first select a hole dimension from those listed at the top of the chart. Second, follow the column of numbers below the hole dimension until you locate the required spotface diameter. Third, move to the left until you find a wing part number. This is the wing that is required for the spotface diameter selected.

The spindle used for the hole selected can be found in either the metric or inch catalogues, under hole diameter.

On page 27 all Cutters/Inserts (C) are specified.



C	Hole dia. Ø	4,5	4,75	5,5	5,55	6,35	6,5
	Wing						
A	37-011	8,0	8,2	9,0	9,0	9,3	9,5
A	-010-0315	8,3	8,5	9,3	9,3	9,6	9,8
A	-010-0335		8,9	9,7	9,7	10,0	10,2
A	-012			10,0	10,0	10,3	10,
A	-013			510,5	10,5	10,8	11,
A	-014			011,0	11,0	11,3	11,
A	-010-0415			511,3	11,3	11,6	11,
A	-010-0470						8
A	-015					12,7	12,9
A	-010-0490						13,0
							13,3

C	Hole dia. Ø	7,0	7,1	7,9	8,4	8,7	9,0	9,5
	Wing							
A	37-020-0320	10,2	10,3	11,1	11,4	11,5	11,8	12,
A	-020-0380	311,4	11,5	12,3	12,6	12,7	13,0	13,
A	-021	511,8	11,9	12,7	13,0	13,1	13,4	13,
A	-020-0480	913,4	13,5	14,3	14,6	14,7	15,0	15,
A	-022	513,8	13,9	14,7	15,0	15,1	15,4	15,
A	-023	914,4	14,5	15,3	15,6	15,7	16,0	16,
A	-020-0540							5
A	-024		14,7	15,5	15,8	15,9	16,2	16,7
A	-020-0620			16,7	17,0	17,1	17,4	17,9
A	-025			17,1	17,4	17,5	17,8	18,3
A	-020-0650				17,6	17,7	18,0	18,5
A	-020-0660				18,0	18,1	18,4	18,9
A	-020-0680				18,2	18,3	18,6	19,1
A	-020-0710					18,7	19,0	19,5
A	-020-0760						19,6	20,1
								21,1

C	Hole dia. Ø	25,0	25,4	26,0	26,2	27,0	27,8	28,0	28,6	29,0	29,4	30,0
	Wing											
D	37-101	33,0	33,4	34,0	34,2	35,0	35,8	36,0	36,6	37,0	37,4	38,0
D	-100-1235	37,7	38,1	38,7	38,9	39,7	40,5	40,7	41,3	41,7	42,1	42,7
D	-100-1250	38,0	38,4	39,0	39,2	40,0	40,8	41,0	41,6	42,0	42,4	43,0
D	-100-1300	39,0	39,4	40,0	40,2	41,0	41,8	42,0	42,6	43,0	43,4	44,0
D	-102	40,0	40,4	41,0	41,2	42,0	42,8	43,0	43,6	44,0	44,4	45,0
D	-100-1400	41,0	41,4	42,0	42,2	43,0	43,8	44,0	44,6	45,0	45,4	46,0
E	-110-1450	42,0	42,4	43,0	43,2	44,0	44,8	45,0	45,6	46,0	46,4	47,0
E	-110-1550	44,0	44,4	45,0	45,2	46,0	46,8	47,0	47,6	48,0	48,4	49,0
E	-111	45,0	45,4	46,0	46,2	47,0	47,8	48,0	48,6	49,0	49,4	50,0
E	-110-1750	48,0	48,4	49,0	49,2	50,0	50,8	51,0	51,6	52,0	52,4	53,0
F	-121	50,0	50,4	51,0	51,2	52,0	52,8	53,0	53,6	54,0	54,4	55,0
F	-120-1870	50,4	50,8	51,4	51,6	52,4	53,2	53,4	54,0	54,4	54,8	55,4
F	-120-1910		51,6	52,2	52,4	53,2	54,0	54,2	54,8	55,2	55,6	56,2
F	-120-1970			53,4	53,6	54,4	55,2	55,4	56,0	56,4	56,8	57,4
F	-120-1990				54,0	54,8	55,6	55,8	56,4	56,8	57,2	57,8
G	-120-2070					56,4	57,2	57,4	58,0	58,4	58,8	59,4
G	-120-2150						58,8	59,0	59,6	60,0	60,4	61,0
G	-120-2170							59,4	60,0	60,4	60,8	61,4
G	-120-2230								61,2	61,6	62,0	62,6
G	-120-2270									62,4	62,8	63,4
G	-120-2310										63,6	64,2
G	-120-2370											65,4

C	Hole dia. Ø	30,2	31,0	31,8	32,0	32,5	33,0	33,3	34,0	34,1	34,9	35,0
	Wing											
D	37-130-1500	46,0	46,0	47,0	47,0	48,0	48,0	49,0	49,0	50,0	50,0	50,0
E	-130-1590	47,8	47,8	48,8	48,8	49,8	49,8	50,8	50,8	51,8	51,8	51,8
E	-130-1740	50,8	50,8	51,8	51,8	52,8	52,8	53,8	53,8	54,8	54,8	54,8
E	-130-1750	51,0	51,0	52,0	52,0	53,0	53,0	54,0	54,0	55,0	55,0	55,0
F	-131	54,0	54,0	55,0	55,0	56,0	56,0	57,0	57,0	58,0	58,0	58,0
F	-130-1910	54,2	54,2	55,2	55,2	56,2	56,2	57,2	57,2	58,2	58,2	58,2
G	-130-2150	59,0	59,0	60,0	60,0	61,0	61,0	62,0	62,0	63,0	63,0	63,0
G	-132	60,0	60,0	61,0	61,0	62,0	62,0	63,0	63,0	64,0	64,0	64,0
G	-130-2300	62,0	62,0	63,0	63,0	64,0	64,0	65,0	65,0	66,0	66,0	66,0
G	-130-2400			65,0	65,0	66,0	66,0	67,0	67,0	68,0	68,0	68,0
G	-130-2500					68,0	68,0	69,0	69,0	70,0	70,0	70,0
R	-130-2600							71,0	71,0	72,0	72,0	72,0
R	-130-2700									74,0	74,0	74,0

C	Hole dia. Ø	35,7	36,0	36,5	37,0	37,3	38,0	38,1	38,9	39,0	39,7	40,0	40,5	41,0	41,3	42,0	42,1	42,9	43,0	
	Wing																			
E	37-140-1750	53,0	53,0	54,0	54,0	55,0	55,0	56,0	56,0	57,0	57,0	58,0	58,0	59,0	59,0	60,0	60,0	60,0	60,0	60,0
E	-140-1790	53,8	53,8	54,8	54,8	55,8	55,8	56,8	56,8	57,8	57,8	58,8	58,8	59,8	59,8	60,8	60,8	60,8	60,8	60,8
E	-140-1800	54,0	54,0	55,0	55,0	56,0	56,0	57,0	57,0	57,0	58,0	58,0	59,0	59,0	60,0	60,0	61,0	61,0	61,0	61,0
E	-140-1915	56,3	56,3	57,3	57,3	58,3	58,3	59,3	59,3	60,3	60,3	61,3	61,3	62,3	62,3	63,3	63,3	63,3	63,3	63,3
E	-140-1950	57,0	57,0	58,0	58,0	59,0	59,0	60,0	60,0	61,0	61,0	62,0	62,0	63,0	63,0	64,0	64,0	64,0	64,0	64,0
E	-140-2000	58,0	58,0	59,0	59,0	60,0	60,0	61,0	61,0	62,0	62,0	63,0	63,0	64,0	64,0	65,0	65,0	65,0	65,0	65,0
F	-140-2145	60,9	60,9	61,9	61,9	62,9	62,9	63,9	63,9	64,9	64,9	65,9	65,9	66,9	66,9	67,9	67,9	67,9	67,9	67,9
F	-141	63,0	63,0	64,0	64,0	65,0	65,0	66,0	66,0	67,0	67,0	68,0	68,0	69,0	69,0	70,0	70,0	70,0	70,0	70,0
F	-140-2315	64,3	64,3	65,3	65,3	66,3	66,3	67,3	67,3	68,3	68,3	69,3	69,3	70,3	70,3	71,3	71,3	71,3	71,3	71,3
G	-140-2500	68,0	68,0	69,0	69,0	70,0	70,0	71,0	71,0	72,0	72,0	73,0	73,0	74,0	74,0	75,0	75,0	75,0	75,0	75,0
G	-142	69,0	69,0	70,0	70,0	71,0	71,0	72,0	72,0	73,0	73,0	74,0	74,0	75,0	75,0	76,0	76,0	76,0	76,0	76,0
R	-140-2650	71,0	71,0	72,0	72,0	73,0	73,0	74,0	74,0	75,0	75,0	76,0	76,0	77,0	77,0	78,0	78,0	78,0	78,0	78,0
R	-140-2750			74,0	74,0	75,0	75,0	76,0	76,0	77,0	77,0	78,0	78,0	79,0	79,0	80,0	80,0	80,0	80,0	80,0
S	-140-2850					77,0	77,0	78,0	78,0	79,0	79,0	80,0	80,0	81,0	81,0	82,0	82,0	82,0	82,0	82,0
S	-140-2950							80,0	80,0	81,0	81,0	82,0	82,0	83,0	83,0	84,0	84,0	84,0	84,0	84,0
S	-140-3050									83,0	83,0	84,0	84,0	85,0	85,0	86,0	86,0	86,0	86,0	86,0
S	-140-3150											86,0	86,0	87,0	87,0	88,0	88,0	88,0	88,0	88,0
S	-140-3250													89,0	89,0	90,0	90,0	90,0	90,0	90,0
S	-140-3350															92,0	92,0	92,0	92,0	92,0

C	Hole dia. Ø	43,7	44,0	44,5	45,0	45,2	46,0	46,8	47,0	47,6	48,0	48,4	49,0	49,2	50,0	50,8	51,0	51,6	52,0	52,4	53,0	
	Wing																					
F	37-150-2150	65,0	65,0	66,0	66,0	67,0	67,0	68,0	68,0	69,0	70,0	70,0	71,0	71,0	72,0	72,0	73,0	73,0	74,0	74,0	74,0	74,0
F	-150-2295	67,9	67,9	68,9	68,9	69,9	69,9	70,9	70,9	71,9	72,9	72,9	73,9	73,9	74,9	74,9	75,9	75,9	76,9	76,9	76,9	76,9
F	-150-2300	68,0	68,0	69,0	69,0	70,0	70,0	71,0	71,0	72,0	72,0	73,0	73,0	74,0	74,0	75,0	75,0	76,0	76,0	77,0	77,0	77,0
F	-150-2400	70,0	70,0	71,0	71,0	72,0	72,0	73,0	73,0	74,0	74,0	75,0	75,0	76,0	76,0	77,0	77,0	78,0	78,0	79,0	79,0	79,0
F	-150-2420	70,4	70,4	71,4	71,4	72,4	72,4	73,4	73,4	74,4	74,4	75,4	75,4	76,4	76,4	77,4	77,4	78,4	78,4	79,4	79,4	79,4
G	-150-2690	75,8	75,8	76,8	76,8	77,8	77,8	78,8	78,8	79,8	79,8	80,8	80,8	81,8	81,8	82,8	82,8	83,8	83,8	84,8	84,8	84,8
G	-150-2895	79,9	79,9	80,9	80,9	81,9	81,9	82,9	82,9	83,9	83,9	84,9	84,9	85,9	85,9	86,9	86,9	87,9	87,9	88,9	88,9	88,9
S	-150-2950	81,0	81,0	82,0	82,0	83,0	83,0	84,0	84,0	85,0	85,0	86,0	86,0	87,0	87,0	88,0	88,0	89,0	89,0	90,0	90,0	90,0
S	-151	86,0	86,0	87,0	87,0	88,0	88,0	89,0	89,0	90,0	90,0	91,0	91,0	92,0	92,0	93,0	93,0	94,0	94,0	95,0	95,0	95,0
S	-150-3250	87,0	87,0	88,0	88,0	89,0	89,0	90,0	90,0	91,0	91,0	92,0	92,0	93,0	93,0	94,0	94,0	95,0	95,0	96,0	96,0	96,0
S	-150-3350			90,0	90,0	91,0	91,0	92,0	92,0	93,0	93,0	94,0	94,0	95,0	95,0	96,0	96,0	97,0	97,0	98,0	98,0	98,0
S	-150-3400					92,0	92,0	93,0	93,0	94,0	94,0	95,0	95,0	96,0	96,0	97,0	97,0	98,0	98,0	99,0	99,0	99,0
S	-150-3450					93,0																

C	Hole dia. Ø	53,2	54,0	54,8	55,0	55,6	56,0	56,4	57,0	57,1	57,9	58,0	58,7	59,0	59,5	60,0	60,3	61,0
	Wing																	
S	37-161	94,0	94,0	95,0	95,0	96,0	96,0	97,0	97,0	98,0	98,0	98,0	99,0	99,0	100,0	100,0	101,0	101,0
T	-162	108,0	108,0	109,0	109,0	110,0	110,0	111,0	111,0	112,0	112,0	112,0	113,0	113,0	114,0	114,0	115,0	115,0
T	-160-4050	109,0	109,0	110,0	110,0	111,0	111,0	112,0	112,0	113,0	113,0	114,0	114,0	115,0	115,0	116,0	116,0	116,0
T	-160-4150			112,0	112,0	113,0	113,0	114,0	114,0	115,0	115,0	116,0	116,0	117,0	117,0	118,0	118,0	118,0
T	-160-4250					115,0	115,0	116,0	116,0	117,0	117,0	118,0	118,0	119,0	119,0	120,0	120,0	120,0
T	-160-4350							118,0	118,0	119,0	119,0	120,0	120,0	121,0	121,0	122,0	122,0	122,0
T	-160-4450								121,0	121,0	121,0	122,0	122,0	123,0	123,0	124,0	124,0	124,0
U	-160-4550												124,0	124,0	125,0	125,0	126,0	126,0
U	-160-4650														127,0	127,0	128,0	128,0
U	-160-4750																130,0	130,0

C	Hole dia. Ø	61,1	61,9	62,0	62,7	63,0	63,5	64,0	64,3	65,0	65,1	65,9	66,0	66,7	67,0	67,5	68,0	68,3	69,0
	Wing																		
S	37-161	102,0	102,0	102,0	103,0	103,0	104,0	104,0	105,0	105,0	106,0	106,0	106,0	107,0	107,0	108,0	108,0	109,0	109,0
T	-162	116,0	116,0	116,0	117,0	117,0	118,0	118,0	119,0	119,0	120,0	120,0	120,0	121,0	121,0	122,0	122,0	123,0	123,0
T	-160-4050	117,0	117,0	117,0	118,0	118,0	119,0	119,0	120,0	120,0	121,0	121,0	121,0	122,0	122,0	123,0	123,0	124,0	124,0
T	-160-4150	119,0	119,0	119,0	120,0	120,0	121,0	121,0	122,0	122,0	123,0	123,0	123,0	124,0	124,0	125,0	125,0	126,0	126,0
T	-160-4250	121,0	121,0	121,0	122,0	122,0	123,0	123,0	124,0	124,0	125,0	125,0	125,0	126,0	126,0	127,0	127,0	128,0	128,0
T	-160-4350	123,0	123,0	123,0	124,0	124,0	125,0	125,0	126,0	126,0	127,0	127,0	127,0	128,0	128,0	129,0	129,0	130,0	130,0
T	-160-4450	125,0	125,0	125,0	126,0	126,0	127,0	127,0	128,0	128,0	129,0	129,0	129,0	130,0	130,0	131,0	131,0	132,0	132,0
U	-160-4550	127,0	127,0	127,0	128,0	128,0	129,0	129,0	130,0	130,0	131,0	131,0	131,0	132,0	132,0	133,0	133,0	134,0	134,0
U	-160-4650	129,0	129,0	129,0	130,0	130,0	131,0	131,0	132,0	132,0	133,0	133,0	133,0	134,0	134,0	135,0	135,0	136,0	136,0
U	-160-4750	131,0	131,0	131,0	132,0	132,0	133,0	133,0	134,0	134,0	135,0	135,0	135,0	136,0	136,0	137,0	137,0	138,0	138,0
U	-160-4850	133,0	133,0	133,0	134,0	134,0	135,0	135,0	136,0	136,0	137,0	137,0	137,0	138,0	138,0	139,0	139,0	140,0	140,0
U	-160-4950				136,0	136,0	137,0	137,0	138,0	138,0	139,0	139,0	139,0	140,0	140,0	141,0	141,0	142,0	142,0
U	-160-5050						139,0	139,0	140,0	140,0	141,0	141,0	141,0	142,0	142,0	143,0	143,0	144,0	144,0
U	-160-5150								142,0	142,0	143,0	143,0	143,0	144,0	144,0	145,0	145,0	146,0	146,0
U	-160-5250										145,0	145,0	145,0	146,0	146,0	147,0	147,0	148,0	148,0

C	Hole dia. Ø	69,1	69,9	70,0	70,6	71,0	71,4	72,0	72,2	73,0	73,8	74,0	74,6	75,0	75,4	76,0	76,2
	Wing																
T	37-171	124,0	124,0	124,0	125,0	125,0	126,0	126,0	127,0	127,0	128,0	128,0	129,0	129,0	130,0	130,0	131,0
U	-172	140,0	140,0	140,0	141,0	141,0	142,0	142,0	143,0	143,0	144,0	144,0	145,0	145,0	146,0	146,0	147,0
U	-170-5250	141,0	141,0	141,0	142,0	142,0	143,0	143,0	144,0	144,0	145,0	145,0	146,0	146,0	147,0	147,0	148,0
U	-170-5350				144,0	144,0	145,0	145,0	146,0	146,0	147,0	147,0	148,0	148,0	149,0	149,0	150,0
U	-170-5450						147,0	147,0	148,0	148,0	149,0	149,0	150,0	150,0	151,0	151,0	152,0
U	-170-5550								150,0	150,0	151,0	151,0	152,0	152,0	153,0	153,0	154,0
U	-170-5650										153,0	153,0	154,0	154,0	155,0	155,0	156,0

Cutter/Insert (C)		
A HSS	H C-0820	O K-1450
B Brazed	I C-0900	P K-1550
C SPUN 080208	J C-1000	Q K-1650
D SPUN 090308	K K-1050	R EC20
E SPUN 120308	L K-1150	S EC25
F SPUN 150412	M K-1250	T EC32
G SPUN 190408	N K-1350	U EC40
ISO-K20 for Cast iron		ISO-P40 for Steel

FOR OPERATIONS IN YOUR NC/CNC MACHINE

TOOL

90-33/62-CS32

L3 = 58

L4 = 50

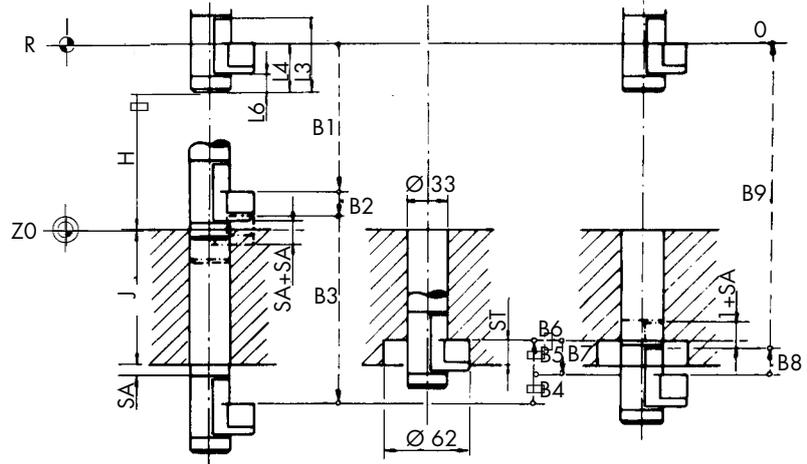
L6 = 21

H = 100

J = 70

ST = 8

SA = 5 (security distance)



MACHINE TIME

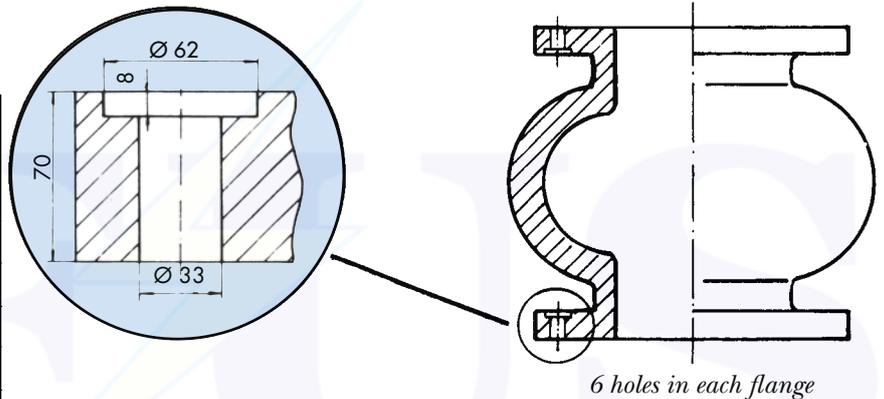
Workpiece: Flange according to drawing below

Material: Cast steel

Numbers of Components: 100

Numbers of Operation: 1200

Step	Z-Length	Feed mm/min	Time
B1	$H + L6 - SA = 116$	2000	3,5
B2	$SA + SA = 10$	65	9,2
B3	$J + (L3 - L6) = 107$	2000	3,2
B4	$SA + 4 = 9$	65	8,3
B5	$(L3 - L4) - 4 + ST = 12$	58	12,4
B6	Rotation	-	3
B7	$(L3 - L4) + 1 = 9$	65	8,3
B8	$1 + SA = 6$	65	5,6
B9	$J - ST - SA +$ $(L3 - L4) + H + L4 = 215$	2000	6,5
Tot. time			60,0



RESULT

By using the Tool in this case...

Costs were reduced by 3 600 USD

or

60 hours were saved, which can be used for the machining of other components.

COST ANALYSIS

Tool:

Conventional HSS-Tool
with manual cutter change

Tool
90-33/62-CS32

Cutter:

HSS

Carbide inserts

Cutting Speed:

25 m/min

50 m/min

Machining time:

4,0 min

1,0 min

Man and Machine costs:

60 USD/hour

60 USD/hour

Costs per spotfacing:

4 USD

1 USD

Total cost:

4800 USD

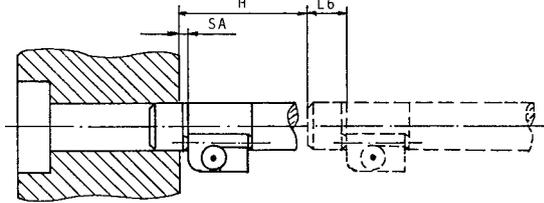
1200 USD

PROGRAMMING INSTRUCTIONS ON NEXT PAGE

**Tools up to Spindle Ø 30 mm
(without guide tang)**

1. Program - Step A1

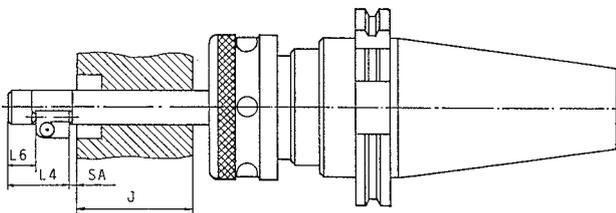
Counter-clockwise rotation at recommended speed: rapid feed until the wing is a few millimeters, security distance (SA), from the workpiece.



Rotation : Counter-clockwise
 Speed : RPM S
 Feed : Rapid F
 Formula for Z : $H + L6 - SA$ mm
 Stop at Z+ : $(L4 - L6) + SA$ Z+

3. Program - Step A3

Counter-clockwise rotation: rapid feed forward until the entire length of the wing swings completely free.



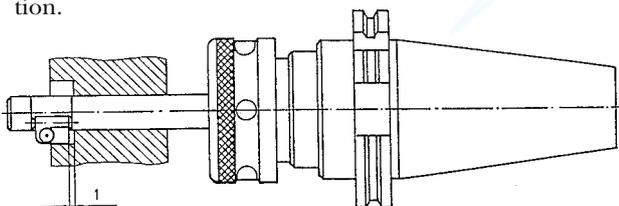
Rotation : Counter-clockwise
 Feed : Rapid F
 Formula for Z : $J + (L4 - L6)$ mm
 Stop at Z- : $-(J + SA)$ Z-

5. Program - Step A5

Stop feeding and let the tool dwell for 5 seconds.

6. Program - Step A6

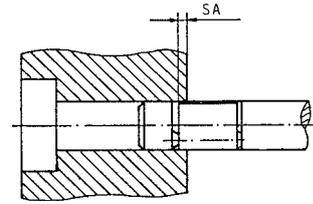
After spotfacing back the tool away until the wing swings completely free. Reverse again to counter-clockwise rotation.



Rotation : Clockwise
 Feed : Rapid F
 Distance for Z : 1 mm
 Stop at Z- : $-(J - ST + 1)$ Z-

2. Program - Step A2

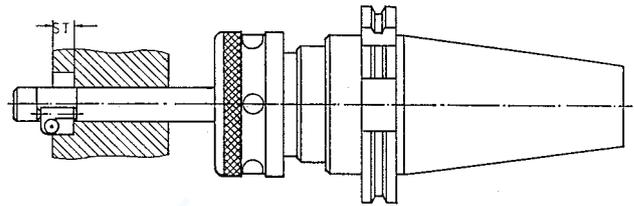
Counter-clockwise rotation: feedrate reduced to 0,2 mm per rev. until the wing has folded into the spindle recess.



Rotation : Counter-clockwise
 Feed : 0,2 mm/rev
 Feed/min : Feed x Speed F
 Formula for Z : $SA + SA$ mm
 Stop at Z+ : $(L4 - L6) - SA$ Z+

4. Program - Step A4

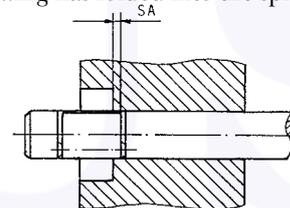
Reverse to clockwise rotation: cutting operation with feedrate according to recommendations.



Rotation : Clockwise
 Feed according to table : mm/rev
 Feed/min : Feed x Speed F
 Formula for Z : $SA + ST$ mm
 Stop at Z- : $-(J - ST)$ Z-

7 Program - Step A7

Counter-clockwise rotation: reduce feedrate to 0,2 mm per rev. until the wing has folded into the spindle recess.



Rotation : Counter-clockwise
 Feed : 0,2 mm/rev
 Feed/min : Feed x Speed F
 Formula for Z : $1 + SA$ mm
 Stop at Z- : $-(J - ST - SA)$ Z-

8. Program - Step A8

Rapid feed back to the starting point R.

Feed : Rapid F
 Formula for Z : $J - ST - SA + H + L4$ mm
 Stop at Z+ : Reference point - R Z+

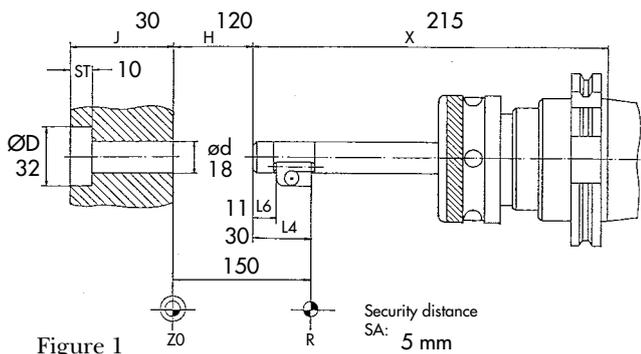


Figure 1

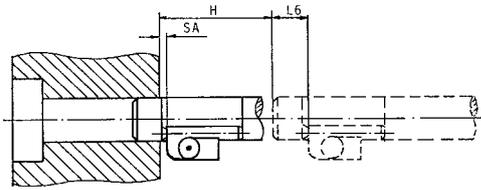
Workpiece	: Cast iron					
Speed	m/min : 40					
Speed	RPM : 320		S			
Feed	mm/rev : 0,16					
Feed/min	mm/min. : 52		F			
Step	Formula for Z	Z mm	Stop at Z	Speed RPM	Rotation	Feed
A1	$H + L6 - SA$	126	+ 24	320	Counter-clockwise	2000
A2	$SA + SA$	10	+ 14	320	Counter-clockwise	64
A3	$J + (L4 - L6)$	49	- 35	320	Counter-clockwise	2000
A4	$SA + ST$	15	- 20	320	Clockwise	52
A5	Rotation	0	- 20	320	Clockwise	stop
A6	1 mm	1	- 21	320	Clockwise	600
A7	$1 + SA$	6	- 15	320	Counter-clockwise	64
A8	$J - ST - SA + H + L4$	165	+ 150	320	Counter-clockwise	2000

Tools – Spindle, over Ø 30 mm (with guide tang)

Set workpiece 0-Point and Tool reference point R (Please see figure 1, page 29).

1. Program - Step B1

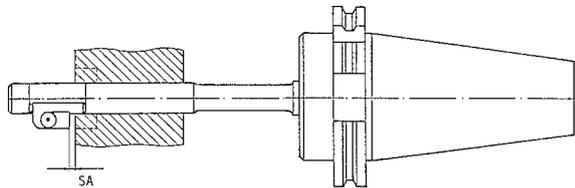
Counter-clockwise rotation at recommended speed: rapid feed until the wing is a few millimeters, security distance (SA), from the workpiece.



Rotation	: Counter-clockwise	
Speed	: RPM	S
Feed	: Rapid	F
Formula for Z-	: $H + L6 - SA$	mm
Stop at Z+	: $(L4 - L6) + SA$	Z+

3. Program - Step B3

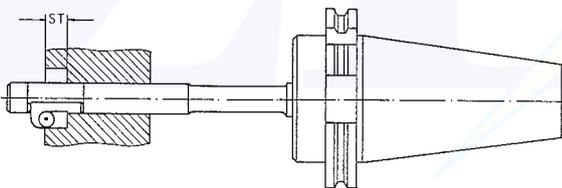
Counter-clockwise rotation: rapid feed forward until the entire length of the wing swings completely free.



Rotation	: Counter-clockwise	
Feed	: Rapid	F
Formula for Z	: $J + (L3 - L6)$	mm
Stop at Z-	: $-(J + (L3 - L4) + SA)$	Z-

5. Program - Step B5

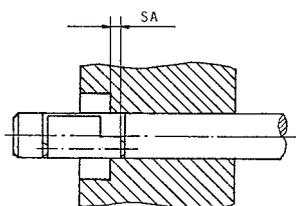
Reverse to clockwise rotation: cutting operation with feedrate according to recommendations.



Rotation	: Clockwise	
Feed according to table	: mm/rev	
Feed/min	: Feed x Speed	F
Formula for Z	: $(L3 - L4) - 4 + ST$	mm
Stop at Z-	: $-(J - ST)$	Z-

8. Program - Step B8

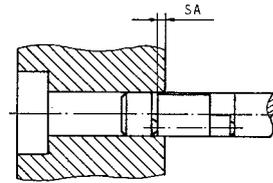
Counter-clockwise rotation: reduce feedrate 0,2 mm per rev. until the wing has folded into the spindle recess. The guide tang will close the wing.



Rotation	: Counter-clockwise	
Feed	: max. 0.2 mm/rev	
Feed/min	: Feed x Speed	F
Formula for Z	: $1 + SA$	mm
Stop at Z-	: $-(J - ST + (L3 - L4) - SA)$	Z-

2. Program - Step B2

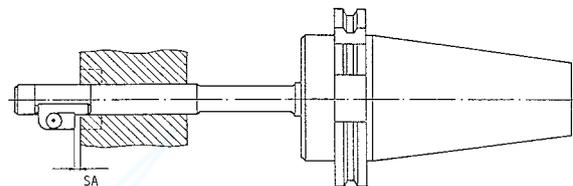
Counter-clockwise rotation: feedrate reduced to 0,2 mm per rev. until the wing has folded into the spindle recess.



Rotation	: Counter-clockwise	
Feed	: 0,2 mm/rev	
Feed/min	: Feed x Speed	F
Formula for Z	: $SA + SA$	mm
Stop at Z+	: $(L4 - L6) - SA$	Z+

4. Program - Step B4

The guide tang enters the hole and will keep the wing in its working position.



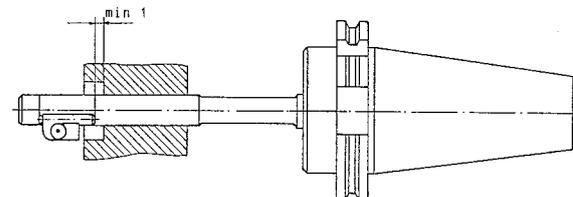
Rotation	: Clockwise	
Feed	: max. 0.2 mm/rev	
Feed/min	: Feed x Speed	
Formula for Z	: $SA + 4$	mm
Stop at Z-	: $-(J + (L3 - L4) - 4)$	Z-

6. Program - Step B6

Stop feeding and let the tool dwell for 5 seconds.

7. Program - Step B7

After spotfacing back the tool away until the wing swings completely free. Reverse again to counter-clockwise rotation.



Rotation	: Clockwise	
Feed	: Rapid	F
Formula for Z	: $(L3 - L4) + 1$	mm
Stop at Z-	: $-(J - ST + (L3 - L4) + 1)$	Z-

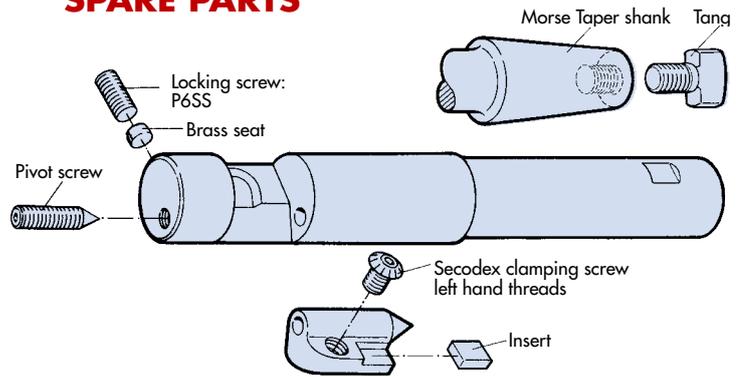
9. Program - Step B9

Rapid feed back to the starting point R.

Rotation	: Counter-clockwise	
Feed	: Rapid	F
Formula for Z	: $J - ST - SA + (L3 - L4) + H + L4$	mm
Stop at Z+	: Reference point R	Z+

SPARE PARTS

HOLE SIZE \varnothing 4,5 – \varnothing 30 mm



SPINDLE

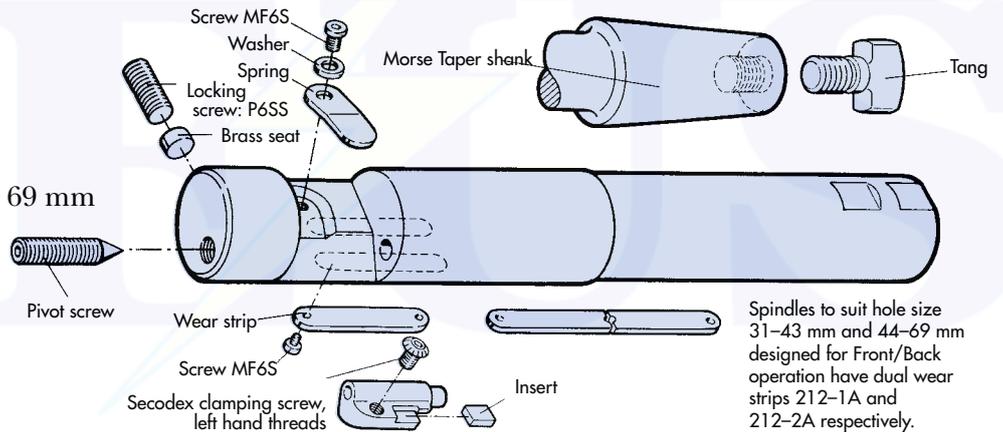
Hole dia \varnothing	Pivot screw	Allen wrench	Locking screw	Allen wrench	Brass seat \varnothing
4,5 - 6,5	211-1	0,89	M2x2,5	0,89	1,5
7 - 9	-2	1,27	M2x2,5	0,89	1,5
10 - 15,5	-3	2	M3x 4	1,5	2,2
16 - 24	-4	3	M4x 5	2	3
25 - 30	-5	5	M4x12	2	3

Hole dia \varnothing	Tang
10-15,5	MK2
16-30	MK3

WING

Spotfacing and chamfering standard and semistandard wings		Clamping screw	Allen wrench
Standard	37 -041... -061	4-631	2,5
	37 -062... -102	5-639	3
	37 -111, -121	6-635	4
Semi-standard	37 -040 -0930... -060-1000	4-631	2,5
	37 -060 -1125... -100-1400	5-639	3
	37 -110 -1450... -120-2370	6-635	4
Chamfering 45°	34 -063	5-639	3
	34 -121	6-635	4
Chamfering 60°	34 -063 -60	5-639	3
	34 -121 -60	6-635	4
Chamfering 30°	34 -061 -30	4-631	2,5
	34 -102 -30	5-639	3

HOLE SIZE \varnothing 31 – \varnothing 69 mm



Spindles to suit hole size 31-43 mm and 44-69 mm designed for Front/Back operation have dual wear strips 212-1A and 212-2A respectively.

SPINDLE

Hole dia \varnothing	Pivot screw	Allen wrench	Locking screw	Allen wrench	Brass seat \varnothing
31-35	211-6	5	M5x12	2,5	4
36-43	-7	6	M5x12	2,5	4
44-53	-8	8	M5x12	2,5	4
54-69	-8	8	M5x12	2,5	4

Hole dia \varnothing	Spring	Washer	Screw for spring	Allen wrench
31-35	213-1	214-1	M4x8	2,5
36-43	-2	-1	M4x8	2,5
44-53	-3	-2	M5x10	3
54-69	-4	-2	M5x10	3

Hole dia \varnothing	Wear strip	Screw	Allen wrench	Tang
31-35	212-1	M4x8	2,5	MK4
36-43	-1	M4x8	2,5	MK4
44-53	-2	M5x10	3	MK5
54-69	-2	M5x10	3	MK5

WING

Spotfacing and chamfering standard and semistandard wings		Clamping screw	Allen wrench
Standard	37 -131, -132	6-635	4
	37 -141, -142	6-645	4
	37 -151, -152, -162	8-649	5
Semi-standard	37 -130 -1500	5-639	3
	37 -130 -1750... -130-2700	6-635	4
	37 -140 -1750... -140-3350	6-645	4
	37 -150 -2150... -160-4450	8-649	5
Chamfering 45°	37 -160 -4550... -160-5250	2X8-649	5
	34 -132	6-635	4
	34 -142	6-645	4
Chamfering 60°	34 -150, -160	8-649	5
	34 -132 -60	6-635	4
	34 -142 -60	6-645	4
Chamfering 30°	34 -150 -60, -160-60	8-649	5
	34 -130 -30	6-635	4
	34 -140 -30	6-645	4
	34 -150 -30, -160-30	8-649	5