18012 - 18016 Graver (incision miller)

Design
With pre-sanded profile.
Applications
For machining tempered and chrome-nickel alloyed steels. For engraving letters and copy milling for contours, etc.

18012
Profile A
Quality
HSS-EW 9 Co 10 (10% cobalt).

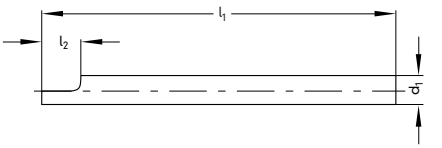
18016
Profile D 60°
Quality
Cemented carbide K 10.

HSS-E

18012

HM K10

18016



Recommended cutting speeds in m/min.			
	Graver		Reference values for
Material	Steel	Cemented carbide K 10	the relief angle
Cast iron, steel casting	50–70	60–100	-
Steel up to 900 N/mm²	40–70	120–160	15°–25°
Steel over 900 N/mm²	-	50–70	-
Brass, aluminium	200–250	200–400	35°
Plastics (Astralon, Plexiglas, Resopal, etc.)	200–300	200–600	35°
Light metal, copper, gold, silver	200–250	200–400	30°

			HSS-E	
d_1 mm	l_1 mm	l_2 mm	18012	...
2.5	40	6		101
4	60	10		102
6	80	14		103
8	90	16		104
8	125	16		105
10	125	18		106
12	125	18		107

			HM-K10	
d_1 mm	l_1 mm	l_2 mm	18016	...
3	40	3		103
4	40	4		104
4	60	4		105
6	70	6		107
8	80	8		108

18020 High-performance lathe blanks DIN 4964

HSS-E

Design
Round. Fully hardened, face-ground on all sides. Ready for use immediately after the desired cutting-edge shape has been sanded.

Quality
HSS-1.3207
(EW 9 Co 10, cobalt 10%).

18020

	HSS-E	
Ø x l mm	18020	...
4 x 100		103
5 x 100		105
6 x 100		107
8 x 80		110
8 x 100		111
8 x 160		113
10 x 80		115

	HSS-E	
Ø x l mm	18020	...
10 x 100		116
10 x 125		117
10 x 160		118
10 x 200		119
12 x 100		122
12 x 160		124
14 x 125		127

	HSS-E	
Ø x l mm	18020	...
16 x 125		131
16 x 160		132
18 x 200		135
20 x 160		138
20 x 200		139

18023 High-performance lathe blanks DIN 4964 B

HSS-E

Design
Square. Fully hardened, face-ground on all sides. Ready for use immediately after the desired cutting-edge shape has been sanded.

Quality
HSS-1.3207
(EW 9 Co 10, cobalt 10%).

18023

w x h x l mm	HSS-E 18023	...
4 x 4 x 80		102
5 x 5 x 63		103
5 x 5 x 100		105
6 x 6 x 63		106
6 x 6 x 80		107
6 x 6 x 100		108
6 x 6 x 160		110
8 x 8 x 63		111
8 x 8 x 80		112
8 x 8 x 100		113
8 x 8 x 160		115
8 x 8 x 200		116

w x h x l mm	HSS-E 18023	...
10 x 10 x 63		117
10 x 10 x 80		118
10 x 10 x 100		119
10 x 10 x 125		120
10 x 10 x 160		121
10 x 10 x 200		122
12 x 12 x 80		124
12 x 12 x 100		125
12 x 12 x 125		126
12 x 12 x 160		127
12 x 12 x 200		128
14 x 14 x 125		129

w x h x l mm	HSS-E 18023	...
14 x 14 x 200		131
16 x 16 x 100		132
16 x 16 x 125		133
16 x 16 x 160		134
16 x 16 x 200		135
20 x 20 x 125		137
20 x 20 x 160		138
20 x 20 x 200		139
25 x 25 x 160		140
25 x 25 x 200		141
25 x 25 x 250		142

18025 High-performance lathe blank DIN 4964 D

HSS-E

Design
Rectangular. Fully hardened, face-ground on all sides. Ready for use immediately after the desired cutting-edge shape has been sanded.

Quality
HSS-1.3207
(EW 9 Co 10, cobalt 10%).

18025

w x h x l mm	HSS-E 18025	...
10 x 4 x 100		101
10 x 4 x 160		102
10 x 5 x 100		104
10 x 5 x 160		105
10 x 6 x 100		107
10 x 6 x 160		108
12 x 8 x 100		110
12 x 8 x 160		111

w x h x l mm	HSS-E 18025	...
12 x 8 x 200		112
16 x 8 x 100		113
16 x 8 x 160		114
16 x 8 x 200		115
16 x 10 x 160		116
20 x 5 x 100		118
20 x 5 x 160		119
20 x 10 x 160		121

w x h x l mm	HSS-E 18025	...
20 x 10 x 200		122
20 x 12 x 160		123
20 x 12 x 200		124
25 x 16 x 200		126
32 x 16 x 200		127
40 x 10 x 200		128

18102 Cutting-off tool holder

Design
With adjustable clamp for clamping the cutter on the side.
Applications
For tappings and for grooves in outside round slots for circlips.

Note:
Large AE for direct clamping of special cutters art. no. 18110 101-106.

18102 101-102

18102 103-105

Size	b x a x l_1 mm	d mm	18102 ...
A 00	11.0 x 16 x 100	12	101
A 0	11.0 x 18 x 125	14	102
A I/II a	14.5 x 22 x 170	20	103
A III a	18.0 x 27 x 210	25	104
AE	11.0 x 18 x 125	14	105

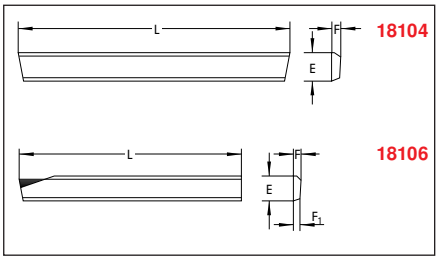
18104 - 18106 Cutting-off tools

18104
Quality
HSS, Quality class F (12% tungsten, 5% cobalt).

18106
Quality
With cemented carbide cutting plate P20.

18104

18106



E x F/F_1 x L Mm	For holder size	HSS/F 18104	...	Cemented carbide/P20 18106	...
8.0 x 2.2 x 75	A 00		101		
10.0 x 2.7 x 100	A 0		102		102
16.0 x 4/3 x 150	A I/II a		103		103
18.5 x 5/4 x 150	A III a		104		104

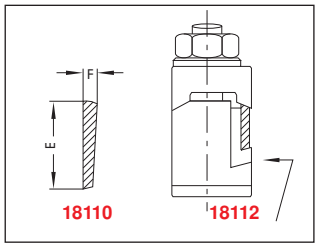
18110 - 18112 Recessing cutter and insert

18110
Recessing cutter
Applications
For circlip grooves, tolerance H11, for holder AI/IIa or AE (art. No. 18102 103 and/or 105).
Quality
HSS, Quality class F (12% tungsten, 5% cobalt).

18112
Insert

Note:
Cutters for circlip grooves A 0.9 to A 2.15 can be clamped directly in holder AE or, using this spacer piece, in holder AI/IIa. Cutters A 2.65 to A 5.15 can be mounted directly in holder AI/IIa.

18110 - 18112



Size	For ring width mm	F mm	E mm	Cutter length mm	HSS/F 18110	...	Insert 18112	...
A 0.9	0.80	0.90	11	80		101		101
A 1.1	1.00	1.10	11	80		102		
A 1.3	1.20	1.30	11	80		103		
A 1.6	1.50	1.60	11	80		104		
A 1.85	1.75	1.85	11	80		105		
A 2.15	2.00	2.15	11	80		106		
A 2.65	2.50	2.65	16	150		107		
A 3.15	3.00	3.15	16	150		108		
A 4.15	4.00	4.15	16	150		109		
A 5.15	5.00	5.15	16	150		110		

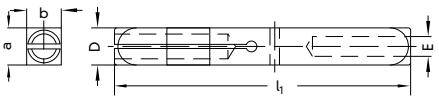
18202 Boring-tool holder

Applications
For clamping reboring shank cutters (art. no. 18209–18233). For bores from 3 mm.

18202 101
Applications
For steels: Size 01–05 standard and extended.

18202 102
Applications
For steels: Size 01–06 standard and extended. Size 01–05, shank diameter 10 mm.

18202



Size	a x b Mm	Mounting holes D + E mm	l_1 mm	Cutting edge height mm	18202	...
B 8	12 x 12	8	100	6.0		101
B 10	15 x 15	8 + 10	125	7.5		102

Lathe tools

= The specified prices are unit prices. Only sold in the specified packing units. Always specify number of units in order information.

18209 - 18210 Roughing reboring cutters

Design
Type g.
Applications
For through holes.
Quality
HSS, quality class H (11% tungsten, 10% cobalt).

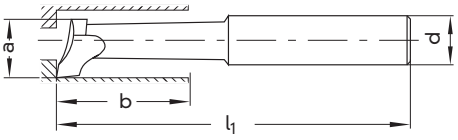
18209
Design
Standard.

18210
Design
Extended. **Total length l_1 = 125 mm.**

18209

18210

Size	a mm	l_1 mm	b mm	d mm	HSS/H 18209	...	long HSS/H 18210	...
01	3	60	20	8		101		
02	5	60	24	8		102		202
03	7	65	26	8		103		203
04	9	75	30	8		104		204
05	12	80	50	8		105		205
06	14	95	60	10		106		206



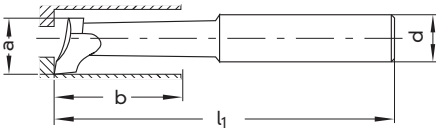
18215 - 18216 Angled reboring cutters

Design
Type f.
Applications
For blind holes.
Quality
HSS, quality class H (11% tungsten, 10% cobalt).

18215
Design
Standard.

18216
Design
Extended. **Total length l_1= 125 mm.**

18215 - 18216



Size	a mm	l_1 mm	b mm	d mm	HSS/H 18215	...	long HSS/H 18216	...
01	3	60	20	8		101		201
02	5	60	24	8		102		202
03	7	65	26	8		103		203
04	9	75	30	8		104		204
05	12	80	50	8		105		205
06	14	95	60	10		106		

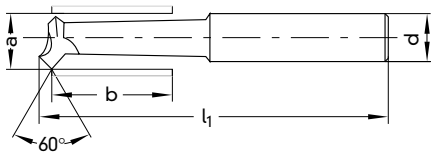
18221 - 18226 Female thread cutters

Quality
HSS, quality class H (11% tungsten, 10% cobalt).

18221
Design
Standard, for metric ISO thread 60°.

18226
Design
Standard, for Whitworth thread 55°.

18221 - 18226



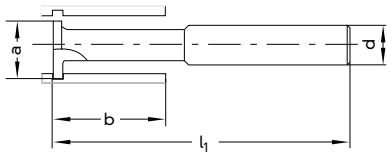
Size	a mm	l_1 mm	b mm	d mm	Pitch to mm	Pitch to TPI	60°/HSS/H 18221	...	55°/HSS/H 18226	...
01	3	60	20	8	1.0	-		101		
02	5	60	24	8	1.0	-		102		
03	7	65	26	8	1.5	16–50		103		203
04	9	75	30	8	1.5	16–50		104		204
05	12	80	50	8	2.0	12–40		105		205
06	14	95	60	10	3.0	8 - 30		106		206

18233 Internal recessing cutters

Design
Type h, standard, for groove width 1.1 mm.
Quality
HSS, quality class H (11% tungsten, 10% cobalt).

Note:
Standard recessing width 1.1 mm.

18233



Size	a mm	l_1 mm	b mm	d mm	HSS/H 18233	...
01	3	60	20	8		101
02	5	60	24	8		102
03	7	65	26	8		103
04	9	75	30	8		104
05	12	80	50	8		105
06	14	95	60	10		106

18247 Boring bars

Applications
For screwing on cutting heads
Art. no. 18301–18314. For holder art. no. 18246.

18247

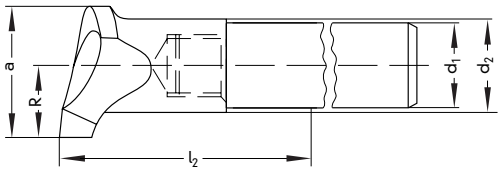
Size	For bores from mm	Cutting edge height mm	Boring bar Ø mm	Length mm	18247	...
B 1	16	10	10	180		101
B 1a	18	14	13	220		102
B 2	21	14	13	250		103
B 2a	24	20	20	275		104
B 2B	28	20	20	300		105
B 3	30	20	20	325		106

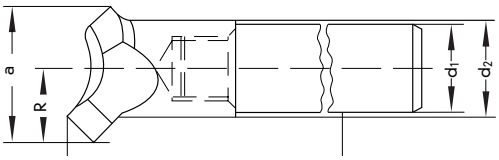
18301 - 18303 Reboring heads

Applications
For screwing onto boring bars art. no. 18247.
Quality
HSS, Quality class F (12% tungsten, 5% cobalt).

18301
Design
Type f, angled cutter for extracting blind holes and for turning and facing.

18303
Design
Type g, roughing cutter for extracting through-bores.





18301

18303

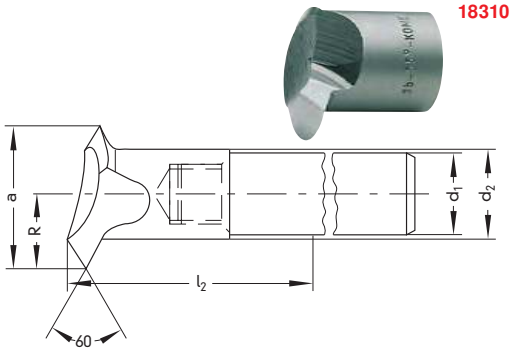
For boring bar	a for Ø mm from	l_2 mm	R mm	d_2 mm	d_1 boring bar mm	Type f/HSS/F 18301	...	Type g/HSS/F 18303	...
B 1	16	80	9.0	11.5	10		101		101
B 1a	18	85	10.3	13.5	13		102		102
B 2	21	115	12.0	16.0	13		103		103
B 2a	24	120	13.5	18.0	20		104		104
B 2B	28	140	15.5	20.2	20		105		
B 3	30	165	16.8	21.5	20		106		106

= The specified prices are unit prices. Only sold in the specified packing units. Always specify number of units in order information.

18310 Female thread cutters

Design
For a metric ISO thread 60°.
Applications
For screwing onto boring bars art. no. 18247.
Quality
HSS, Quality class F (12% tungsten, 5% cobalt).

18310



60°/HSS/F

For boring bar	a bore From mm	l_2 mm	R mm	d_2 mm	d_1 boring bar mm	Thread pitch to mm	Thread pitch to TPI	18310	...
B 1	16	80	9.0	11.5	10	4	6.5		101
B 1a	18	85	10.3	12.5	13	5	5.0		102
B 2	21	115	12.0	15.0	13	6	4.0		103
B 2a	24	120	13.5	17.0	20	7	3.5		104
B 2B	28	140	15.5	20.2	20	8	3.0		105
B 3	30	165	16.8	21.5	20	9	2.5		106

18314 Female thread cutters

Design
For trapezoidal thread.
Applications
For screwing onto boring bars art. no. 18247.
Quality
HSS, Quality class F (12% tungsten, 5% cobalt).

18314

TR/HSS/F

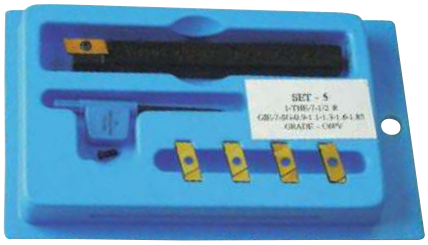
For boring bar	min. core Ø mm	Pitch mm	18314	...
B 1	16	3		101
B 1a	18	4		102
B 2	21	5		103
B 2a	24	6		104
B 3	30	8		106

18137 Grooving-tool assortment

18137 201
Design
With two cutting edges on each indexable insert for very small-scale grooving work.
Set contents:
1 holder, right, 12 x 12 x 120 mm, 1 grooving indexable insert 0.9/1.1/1.3/1.6/1.85 mm in each case. In case, incl. TX key T8.
Applications
For locking grooves.
Quality
Indexable inserts P 25 PVD/TiN-coated.

18137 501
Clamping screws for grooving-tool assortment (art. no. 18137 201), grooving-tool holder (art. no. 18130) and grooving boring bars (art. no. 18133).

18137 201



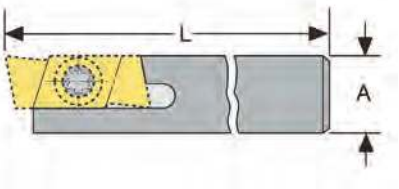
18137 501

Set contents	Size	TORX® Size		18137	...
7 pcs.	-	-	-		201
-	M 3 x 8	T 8	10 pcs.		501

18130 Grooving-tool external holder

Applications
For grooving indexable inserts art. no. 18138.

18130

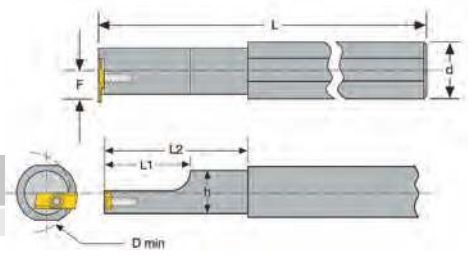


Holder designation	A mm	L mm	Right 18130	...
THE 1010	10	120		102
THE 1212	12	120		103
THE 1616	16	125		104

18133 Grooving boring bar, left

Applications
For grooving indexable inserts art. no. 18138.

18133

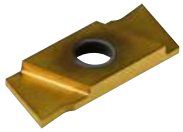


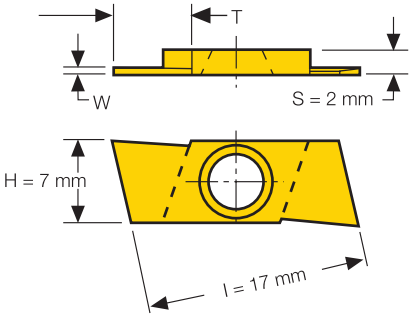
Holder designation	d mm	h mm	L mm	L_1 mm	L_2 mm	F mm	D min. mm	18133	...
THI-7-20	20	19.05	140	25	50	13.34	38.1		201

18138 Grooving indexable inserts

Applications
For locking grooves. Suitable for assortment art. no. 18137.
Quality
P 25 PVD/TiN-coated.

18138





W +0.02/0 mm	T mm		P 25/TiN 18138	...
0.50	2.54	10 pcs.		210
0.70	2.54	10 pcs.		211
0.80	2.54	10 pcs.		212
0.90	2.54	10 pcs.		213
1.10	6.00	10 pcs.		214
1.30	6.00	10 pcs.		215
1.60	6.00	10 pcs.		216
1.85	6.00	10 pcs.		217

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Dümmel WERKZEUGFABRIK

Design
Right cutting, **with internal coolant supply.**
Quality
Inserts HC8615/TiN-coated.

18320 101
Cutting-tool set mini-bore 1
Applications
For internal extraction, internal recess turning and chamfering. For internal machining from bore diameter 3mm.

18320 102
Cutting-tool set mini-bore 2
Applications
For internal recess turning. For internal machining From bore diameter 4mm.

18320 103
Cutting-tool set mini-bore 3
Applications
For internal extraction. For internal machining From bore diameter 3 mm.

18320 101

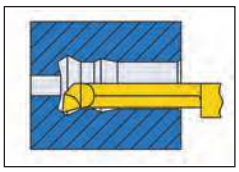
18320 102

18320 103

18320 101 mini-bore 1

Set contents	Designation	Bore Ø mm	Bore depth mm	Grooving depth mm	Grooving width mm	Fig.
1x clamp holder	676.0016-D	-	-	-	-	-
1x clamp holder	645.0016-D	-	-	-	-	-
1x T-handle wrench	111.645	-	-	-	-	-
1x cutting insert	R 050.6-22	6	22	-	-	A
1x cutting insert	R 050.5-20	5	20	-	-	A
1x cutting insert	R 060.5-20	5	20	-	-	F
1x cutting insert	R 050.4-16	4	16	-	-	A
1x cutting insert	R 050.3-16	3	16	-	-	A
1x cutting insert	R 006.0200-22	6	22	1.8	2.0	E
1x cutting insert	R 006.0150-22	6	22	1.8	1.5	E
1x cutting insert	R 005.0200-20	5	20	1.0	2.0	E
1x cutting insert	R 005.0150-20	5	20	1.0	1.5	E
1x cutting insert	R 004.0100-16	4	16	0.8	1.0	E

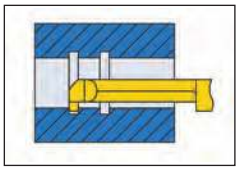
Fig. A



18320 102 mini-bore 2

Set contents	Designation	Bore Ø mm	Bore depth mm	Grooving depth mm	Grooving width mm	Fig.
1x clamp holder	676.0016-D	-	-	-	-	-
1x clamp holder	645.0016-D	-	-	-	-	-
1x T-handle wrench	111.645	-	-	-	-	-
1x cutting insert	R 006.0200-22	6	22	1.8	2.0	E
1x cutting insert	R 006.0150-22	6	22	1.8	1.5	E
1x cutting insert	R 005.0200-20	5	20	1.0	2.0	E
1x cutting insert	R 005.0150-20	5	20	1.0	1.5	E
1x cutting insert	R 004.0100-16	4	16	0.8	1.0	E

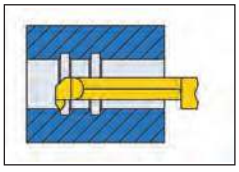
Fig. E



18320 103 mini-bore 3

Set contents	Designation	Bore Ø mm	Bore depth mm	Grooving depth mm	Grooving width mm	Fig.
1x clamp holder	676.0016-D	-	-	-	-	-
1x clamp holder	645.0016-D	-	-	-	-	-
1x T-handle wrench	111.645	-	-	-	-	-
1x cutting insert	R 050.6-22	6	22	-	-	A
1x cutting insert	R 050.5-20	5	20	-	-	A
1x cutting insert	R 050.4-16	4	16	-	-	A
1x cutting insert	R 050.3-16	3	16	-	-	A

Fig. F



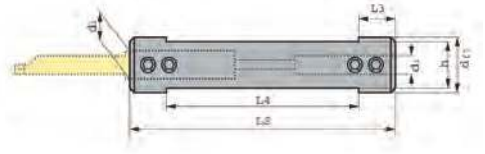
	18320 ...
mini-bore 1	101
mini-bore 2	102
mini-bore 3	103

18321 Clamp holder for system mini-bore

Dümmel WERKZEUGFABRIK

Design
Clamp holder with 2 clamping diameters. Internal coolant feed. Built-in depth stop for exact reproducibility.
Applications
For cutting inserts art. no.18322–18329.

18321



Model	For cutting insert Ø mm	Ødg6 mm	L_2 mm	L_3 mm	L_4 mm	h mm	18321	...
645.0012-D	4/5	12	75	10	55	10.3		101
645.0016-D	4/5	16	75	10	55	14.0		102
645.0020-D	4/5	20	90	10	70	18.0		103
676.0016-D	6/7	16	75	10	55	14.0		104
676.0020-D	6/7	20	90	10	70	18.0		105

18322 - 18325 Cutting inserts for system mini-bore

VHM TiN

Dümmel WERKZEUGFABRIK

Design
With straight shank and lateral clamping surface for holding in the clamp holder.
Applications
For internal extraction from bore diameter 0.6 mm.
Quality
Cemented-carbide ultra-fine grain HC8615/TiN-coated.

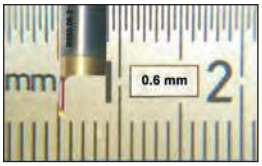
18322 101-120
Right cutting, for clamp holder 645.0012-D, 645.0016-D and 645.0020-D (art. no. 18321 101-103).

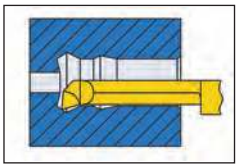
18323 101-120
Left cutting, for clamp holder 645.0012-D, 645.0016-D and 645.0020-D (art. no. 18321 101–103).

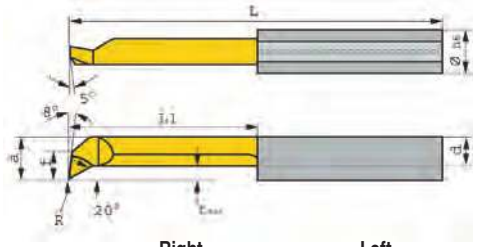
18324 101-111
Right cutting, for clamp holder 676.0016-D and 676.0020-D (art. no. 18321 104–105).

18325 101-111
Left cutting, for clamp holder 676.0016-D and 676.0020-D (art. no. 18321 104–105).

18322 - 18325







Model	Ø h6 mm	f mm	d mm	a mm	L mm	L_1 mm	t max. mm	D min. mm	R mm	Right 18322	...	Left 18323	...
R/L 050.06-2	4	-	0.4	0.5	20	2	0.08	0.6	0.04		101		101
R/L 050.06-3	4	-	0.4	0.5	20	3	0.08	0.6	0.04		102		102
R/L 050.15-5	4	-	1.15	1.3	19	5	0.1	1.5	0.05		103		103
R/L 050.15-10	4	-	1.15	1.3	24	10	0.1	1.5	0.05		104		104
R/L 050.2-5	4	-	1.5	1.7	19	5	0.1	2.0	0.05		105		105
R/L 050.2-10	4	-	1.5	1.7	24	10	0.1	2.0	0.05		106		106
R/L 050.2-15	4	-	1.5	1.7	29	15	0.1	2.0	0.05		107		107
R/L 050.3-10	4	0.6	2.3	2.6	24	10	0.2	2.8	0.1		108		108
R/L 050.3-16	4	0.6	2.3	2.6	30	16	0.2	2.8	0.1		109		109
R/L 050.3-20	4	0.6	2.3	2.6	34	20	0.2	2.8	0.1		110		110
R/L 050.4-10	4	1.5	3.0	3.5	24	10	0.3	4.0	0.1		111		111
R/L 050.4-16	4	1.5	3.0	3.5	30	16	0.3	4.0	0.1		112		112
R/L 050.4-20	4	1.5	3.0	3.5	34	20	0.3	4.0	0.1		113		113
R/L 050.4-24	4	1.5	3.0	3.5	38	24	0.3	4.0	0.1		114		114
R/L 050.5-10	5	1.9	3.8	4.4	25	10	0.5	5.0	0.15		116		116
R/L 050.5-20	5	1.9	3.8	4.4	35	20	0.5	5.0	0.15		118		118
R/L 050.5-30	5	1.9	3.8	4.4	45	30	0.5	5.0	0.15		120		120

Model	Ø h6 mm	f mm	d mm	a mm	L mm	L_1 mm	t max. mm	D min. mm	R mm	Right 18324	...	Left 18325	...
R/L 050.6-15	6	2.3	4.5	5.3	30	15	0.5	6.0	0.15		101		101
R/L 050.6-22	6	2.3	4.5	5.3	37	22	0.5	6.0	0.15		102		102
R/L 050.6-25	6	2.3	4.5	5.3	40	25	0.5	6.0	0.15		103		103
R/L 050.6-35	6	2.3	4.5	5.3	50	35	0.5	6.0	0.15		105		105
R/L 050.7-20	7	2.8	5.5	6.3	35	20	0.6	6.8	0.15		107		107
R/L 050.7-30	7	2.8	5.5	6.3	45	30	0.6	6.8	0.15		109		109
R/L 050.7-40	7	2.8	5.5	6.3	55	40	0.6	7.0	0.15		111		111

= The specified prices are unit prices. Only sold in the specified packing units. Always specify number of units in order information.

VHM TiN

Dümmel WERKZEUGFABRIK

Version
With straight shank and lateral clamping surface for holding in the clamp holder.

Applications
For internal recessing from bore diameter 4 mm.

Quality
Cemented-carbide ultra-fine grain HC8615/TiN-coated.

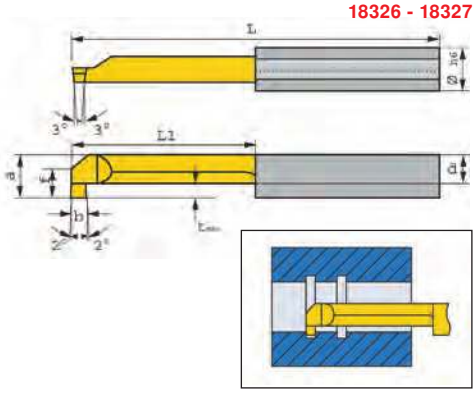
18326 101-119
Right cutting, for clamp holder 645.0012-D, 645.0016-D and 645.0020-D (art. no. 18321 101-103).

18327 101-119
Left cutting, for clamp holder 645.0012-D, 645.0016-D and 645.0020-D (art. no. 18321 101–103).

18326 127-159
Right cutting, for clamp holder 676.0016-D and 676.0020-D (art. no. 18321 104–105).

18327 127-159
Left cutting, for clamp holder 676.0016-D and 676.0020-D (art. no. 18321 104–105).

18326 - 18327



Model	Ø h6 mm	b + 0,05 mm	f mm	d mm	a mm	L mm	L_1 mm	t max. mm	D min. mm	Right 18326 ...	Left 18327 ...
R/L 004.0100-10	4	1.0	1.5	2.4	3.5	24	10	0.8	4.0	101	101
R/L 004.0100-16	4	1.0	1.5	2.4	3.5	30	16	0.8	4.0	102	102
R/L 004.0100-20	4	1.0	1.5	2.4	3.5	34	20	0.8	4.0	103	103
R/L 005.0150-10	5	1.5	1.9	3.3	4.4	25	10	1.0	5.0	110	110
R/L 005.0150-20	5	1.5	1.9	3.3	4.4	35	20	1.0	5.0	112	112
R/L 005.0150-30	5	1.5	1.9	3.3	4.4	45	30	1.0	5.0	114	114
R/L 005.0200-10	5	2.0	1.9	3.3	4.4	25	10	1.0	5.0	115	115
R/L 005.0200-20	5	2.0	1.9	3.3	4.4	35	20	1.0	5.0	117	117
R/L 005.0200-30	5	2.0	1.9	3.3	4.4	45	30	1.0	5.0	119	119
R/L 006.0150-10	6	1.5	2.3	3.4	5.3	25	10	1.8	6.0	127	127
R/L 006.0150-22	6	1.5	2.3	3.4	5.3	37	22	1.8	6.0	129	129
R/L 006.0150-30	6	1.5	2.3	3.4	5.3	45	30	1.8	6.0	131	131
R/L 006.0200-10	6	2.0	2.3	3.4	5.3	25	10	1.8	6.0	133	133
R/L 006.0200-22	6	2.0	2.3	3.4	5.3	37	22	1.8	6.0	135	135
R/L 006.0200-25	6	2.0	2.3	3.4	5.3	40	25	1.8	6.0	136	136
R/L 007.0100-15	7	1.0	2.8	3.8	6.3	30	15	2.5	6.8	139	139
R/L 007.0100-25	7	1.0	2.8	3.8	6.3	40	25	2.5	6.8	141	141
R/L 007.0100-40	7	1.0	2.8	3.8	6.3	55	40	2.5	7.0	144	144
R/L 007.0100-50	7	1.0	2.8	3.8	6.3	65	50	2.5	7.0	146	146
R/L 007.0150-15	7	1.5	2.8	3.8	6.3	30	15	2.5	6.8	148	148
R/L 007.0150-25	7	1.5	2.8	3.8	6.3	40	25	2.5	6.8	150	150
R/L 007.0150-40	7	1.5	2.8	3.8	6.3	55	40	2.5	7.0	153	153
R/L 007.0200-15	7	2.0	2.8	3.8	6.3	30	15	2.5	6.8	155	155
R/L 007.0200-25	7	2.0	2.8	3.8	6.3	40	25	2.5	6.8	157	157
R/L 007.0200-35	7	2.0	2.8	3.8	6.3	50	35	2.5	7.0	159	159

18335 - 18337 Clamp holders for system MINI-CUT

Dümmel WERKZEUGFABRIK

18335
Cemented-carbide clamp holder

18336
Steel clamp holder

Version
With internal cooling.

Applications
For recess turning, extracting and thread cutting (internal) from diameter 7.8 mm.

18335

18336

Cemented-carbide clamp holder

Designation	Ø dg6 mm	l2 mm	l1 mm	l7 mm	d1 mm	f mm	a mm	h mm	For cutting plate	t max. mm	d min. mm	clamping screw	18335 ...
608.0012.1 HM	12	21	80	48	6	4.8	7.8	11.0	R/LS08	1.0	8	M 2.6-MC	101
608.0012.2 cemented carbide	12	30	90	48	6	4.8	7.8	11.0	R/LS08	1.0	8	M 2.6-MC	102
608.0012.3 cemented carbide	12	42	100	48	6	4.8	7.8	11.0	R/LS08	1.0	8	M 2.6-MC	103
608.0012.4 HM	12	50	115	48	6	4.8	7.8	11.0	R/LS08	1.0	8	M 2.6-MC	104
611.0012.1 HM	12	29	95	60	8	6.7	10.7	10.5	R/LS11	2.3	11	M 3.5-MC	105
611.0012.2 cemented carbide	12	42	110	60	8	6.7	10.7	10.5	R/LS11	2.3	11	M 3.5-MC	106
611.0012.3 cemented carbide	12	56	120	60	8	6.7	10.7	10.5	R/LS11	2.3	11	M 3.5-MC	107
611.0012.4 cemented carbide	12	64	130	60	8	6.7	10.7	10.5	R/LS11	2.3	11	M 3.5-MC	108
614.0012.1 cemented carbide	12	34	100	609.5 x 11		9.0	13.8	10.5	R/LS14	4.0/6.5	14/17	M 4-MC	109
614.0012.2 cemented carbide	12	45	110	609.5 x 11		9.0	13.8	10.5	R/LS14	4.0/6.5	14/17	M 4-MC	110
614.0012.3 cemented carbide	12	64	130	609.5 x 11		9.0	13.8	10.5	R/LS14	4.0/6.5	14/17	M 4-MC	111
614.0016.1 cemented carbide	16	34	100	609.5 x 11		9.0	13.8	14.5	R/LS14	4.0/6.5	14/17	M 4-MC	112
614.0016.2 cemented carbide	16	45	110	609.5 x 11		9.0	13.8	14.5	R/LS14	4.0/6.5	14/17	M 4-MC	113
614.0016.3 cemented carbide	16	64	130	609.5 x 11		9.0	13.8	14.5	R/LS14	4.0/6.5	14/17	M 4-MC	114
614.0016.4 cemented carbide	16	75	145	609.5 x 11		9.0	13.8	14.5	R/LS14	4.0/6.5	14/17	M 4-MC	115
616.0012.1 cemented carbide	12	40	130	60	11	10.2	15.7	10.5	R/LS16	4.3	16	M 5-MC	116
616.0012.2 cemented carbide	12	56	130	60	11	10.2	15.7	10.5	R/LS16	4.3	16	M 5-MC	117
616.0012.3 cemented carbide	12	80	150	60	11	10.2	15.7	10.5	R/LS16	4.3	16	M 5-MC	118
616.0016.1 cemented carbide	16	40	130	60	11	10.2	15.7	14.5	R/LS16	4.3	16	M 5-MC	119
616.0016.2 cemented carbide	16	56	130	60	11	10.2	15.7	14.5	R/LS16	4.3	16	M 5-MC	120
616.0016.3 cemented carbide	16	80	150	60	11	10.2	15.7	14.5	R/LS16	4.3	16	M 5-MC	121

Steel clamp holder, short

Designation	Ø dg6 mm	l2 mm	l1 mm	d1 mm	f mm	a mm	h mm	For cutting plate	t max. mm	d min. mm	Clamping screw	18336 ...
608.0016.1 ST	16	12	80	6	4.8	7.8	15.0	R/LS08	1.0	8	M 2.6-MC	101
611.0016.2 ST	16	16	97	8	6.7	10.7	14.5	R/LS11	2.3	11	M 3.5-MC	102
614.0016.3 ST	16	18	100	9.5 x 11	9.0	13.8	14.5	R/LS14	4.0/6.5	14/17	M 4-MC	103
616.0016.3 ST	16	22	100	11	10.2	15.7	14.5	R/LS16	4.3	16	M 5-MC	104

Steel clamp holder, long

Designation	Ø dg6 mm	l2 mm	l1 mm	d1 mm	f mm	a mm	h mm	For cutting plate	t max. mm	d min. mm	Clamping screw	18336 ...
608.0016.1E.ST	16	22	90	6 x 7	4.8	7.8	15.0	R/LS08	1.0	8	M 2.6-MC	201
611.0016.2E.ST	16	29	110	8 x 9.5	6.7	10.7	14.5	R/LS11	2.3	11	M 3.5-MC	202
614.0016.3E.ST	16	38	120	9.5 x 11	9.0	13.8	14.5	R/LS14	4.0/6.5	14/17	M 4-MC	203
616.0016.3E.ST	16	42	120	11 x 13.5	10.2	15.7	14.5	R/LS16	4.3	16	M 5-MC	204

18337 101-104

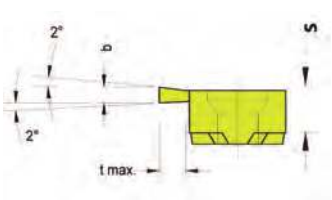
Clamping screws

Designation	18337 ...
M 2.6-MC	101
M 3.5-MC	102
M 4-MC	103
M 5-MC	104

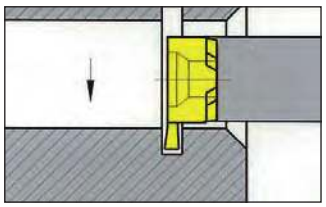
= The specified prices are unit prices. Only sold in the specified packing units. Always specify number of units in order information.

Dümmel WERKZEUGFABRIK

- **For circlip grooves**
- Cemented carbide/HC8620 TiAIN-coated



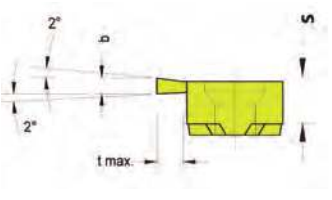
18340



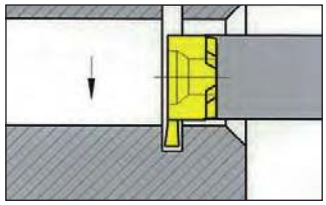
Designation	D min. mm	t max. mm	b + 0.03 mm	d mm	f mm	s mm	For clamp holder type	Right 18340 ...	Left 18340 ...
R/LS008.0070	8	1.0	0.73	6	4.8	3.3	608	101	201
R/LS008.0080	8	1.0	0.83	6	4.8	3.3	608	102	202
R/LS008.0090	8	1.0	0.93	6	4.8	3.3	608	103	203
R/LS008.0110	8	1.0	1.20	6	4.8	3.3	608	104	204
R/LS008.0130	8	1.0	1.40	6	4.8	3.3	608	105	205
R/LS008.0160	8	1.0	1.70	6	4.8	3.3	608	106	206
R/LS011.0070	11	1.2	0.73	8	6.7	4.2	611	107	207
R/LS011.0080	11	1.3	0.83	8	6.7	4.2	611	108	208
R/LS011.0090	11	1.5	0.93	8	6.7	4.2	611	109	209
R/LS011.0110	11	2.3	1.20	8	6.7	4.2	611	110	210
R/LS011.0130	11	2.3	1.40	8	6.7	4.2	611	111	211
R/LS011.0160	11	2.3	1.70	8	6.7	4.2	611	112	212
R/LS014.0070	14	1.2	0.73	9	9.0	5.3	614	113	213
R/LS014.0080	14	1.3	0.83	9	9.0	5.3	614	114	214
R/LS014.0090	14	1.5	0.93	9	9.0	5.3	614	115	215
R/LS014.0110	14	4.0	1.20	9	9.0	5.3	614	116	216
R/LS014.0130	14	4.0	1.40	9	9.0	5.3	614	117	217
R/LS014.0160	14	4.0	1.70	9	9.0	5.3	614	118	218
R/LS016.0070	16	1.2	0.73	11	10.2	5.4	616	119	219
R/LS016.0080	16	1.3	0.83	11	10.2	5.4	616	120	220
R/LS016.0090	16	1.5	0.93	11	10.2	5.4	616	121	221
R/LS016.0110	16	4.3	1.20	11	10.2	5.4	616	122	222
R/LS016.0130	16	4.3	1.40	11	10.2	5.4	616	123	223
R/LS016.0160	16	4.3	1.70	11	10.2	5.4	616	124	224

Dümmel WERKZEUGFABRIK

- Recess turning **general**
- Cemented carbide/HC8620 TiAIN-coated



18341



Designation	D min. mm	t max. mm	b + 0.03 mm	d mm	f mm	s mm	For clamp holder type	Right 18341 ...	Left 18341 ...
R/LS008.0100	8	1.0	1.0	6	4.8	3.3	608	101	201
R/LS008.0150	8	1.0	1.5	6	4.8	3.3	608	102	202
R/LS008.0200	8	1.0	2.0	6	4.8	3.3	608	103	203
R/LS011.0100	11	2.3	1.0	8	6.7	4.2	611	104	204
R/LS011.0150	11	2.3	1.5	8	6.7	4.2	611	105	205
R/LS011.0200	11	2.3	2.0	8	6.7	4.2	611	106	206
R/LS011.0250	11	2.3	2.5	8	6.7	4.2	611	107	207
R/LS011.0300	11	2.3	3.0	8	6.7	4.2	611	108	208
R/LS014.0150	14	4.0	1.5	9	9.0	5.3	614	109	209
R/LS014.0200	14	4.0	2.0	9	9.0	5.3	614	110	210
R/LS014.0250	14	4.0	2.5	9	9.0	5.3	614	111	211
R/LS014.0300	14	4.0	3.0	9	9.0	5.3	614	112	212
R/LS016.0150	16	4.3	1.5	11	10.2	5.4	616	113	213
R/LS016.0200	16	4.3	2.0	11	10.2	5.4	616	114	214
R/LS016.0250	16	4.3	2.5	11	10.2	5.4	616	115	215
R/LS016.0300	16	4.3	3.0	11	10.2	5.4	616	116	216
R/LS016.0350	16	4.3	3.5	11	10.2	5.4	616	117	217
R/LS016.0400	16	4.3	4.0	11	10.2	5.4	616	118	218

Continued

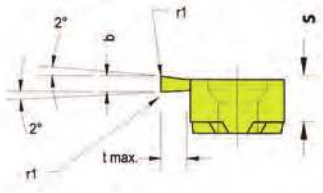
18340 - 18352 Cemented-carbide cutting plates for system MINI-CUT

VHM TiAIN

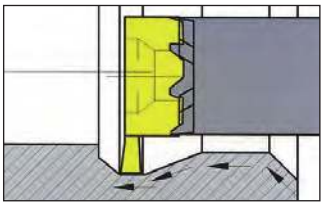
Continued

Dümmel WERKZEUGFABRIK

Finishing inserts
- Maximum cutting depth = 0.02 mm
- Cemented carbide/HC8620 TiAlN-coated

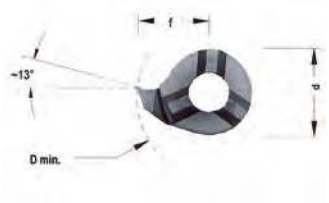


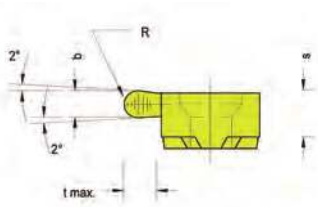
18342



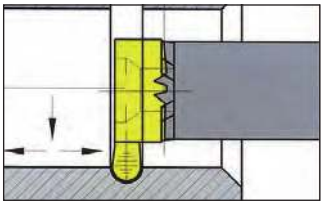
Designation	D min. mm	t max. mm	b + 0.05 mm	d mm	f mm	s mm	For clamp holder type	Right 18342 ...	Left 18342 ...
R/LS08.150.02	8	1.0	1.5	6	4.8	3.3	608	101	201
R/LS08.200.02	8	1.0	2.0	6	4.8	3.3	608	102	202
R/LS11.150.02	11	2.3	1.5	8	6.7	4.2	611	103	203
R/LS11.200.02	11	2.3	2.0	8	6.7	4.2	611	104	204
R/LS14.150.02	14	4.0	1.5	9	9.0	5.3	614	105	205
R/LS14.200.02	14	4.0	2.0	9	9.0	5.3	614	106	206
R/LS16.200.02	16	4.3	2.0	11	10.2	5.4	616	107	207

Dümmel WERKZEUGFABRIK
- full radius
- Cemented carbide/HC8620 TiAlN-coated





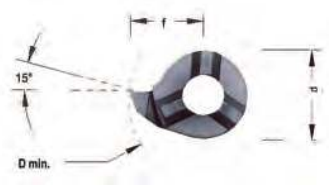
18343

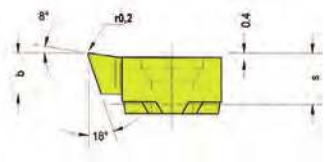


Designation	D min. mm	t max. mm	b + 0.05 mm	d mm	f mm	s mm	For clamp holder type	Right 18343 ...	Left 18343 ...
R/LS08.008R04	8	1.0	0.8	6	4.8	3.3	608	101	201
R/LS08.012R06	8	1.0	1.2	6	4.8	3.3	608	102	202
R/LS08.018R09	8	1.0	1.8	6	4.8	3.3	608	103	203
R/LS11.008R04	11	2.3	0.8	8	6.7	4.2	611	104	204
R/LS11.012R06	11	2.3	1.2	8	6.7	4.2	611	105	205
R/LS11.018R09	11	2.3	1.8	8	6.7	4.2	611	106	206
R/LS11.020R10	11	2.3	2.0	8	6.7	4.2	611	107	207
R/LS11.030R15	11	2.3	3.0	8	6.7	4.2	611	108	208
R/LS14.012R06	14	4.0	1.2	9	9.0	5.3	614	109	209
R/LS14.018R09	14	4.0	1.8	9	9.0	5.3	614	110	210
R/LS14.020R10	14	4.0	2.0	9	9.0	5.3	614	111	211
R/LS14.022R11	14	4.0	2.2	9	9.0	5.3	614	112	212
R/LS14.030R15	14	4.0	3.0	9	9.0	5.3	614	113	213
R/LS16.018R09	16	4.3	1.8	11	10.2	5.4	616	114	214
R/LS16.022R11	16	4.3	2.2	11	10.2	5.4	616	115	215
R/LS16.030R15	16	4.3	3.0	11	10.2	5.4	616	116	216
R/LS16.040R20	16	4.3	4.0	11	10.2	5.4	616	117	217

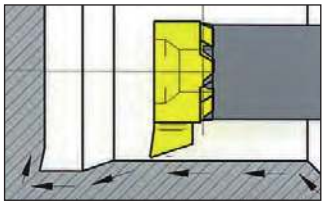
Dümmel WERKZEUGFABRIK

copy plates
- Ap max = maximum cutting depth
- Cemented carbide/HC8620 TiAlN-coated





18344



Designation	D min. mm	Ap max. mm	b mm	d mm	f mm	s mm	For clamp holder type	Right 18344 ...	Left 18344 ...
R/LS08.1846.02	7.8	0.6	3.3	6	4.65	3.5	608	101	201
R/LS11.1855.02	9.8	1.0	3.9	8	5.50	4.2	611	102	202
R/LS11.1867.02	11.0	1.0	3.9	8	6.70	4.2	611	103	203
R/LS14.1867.02	13.8	1.5	5.0	9	8.70	5.3	614	104	204
R/LS16.1897.02	15.5	1.5	5.0	11	9.70	5.4	614	105	205

Continued

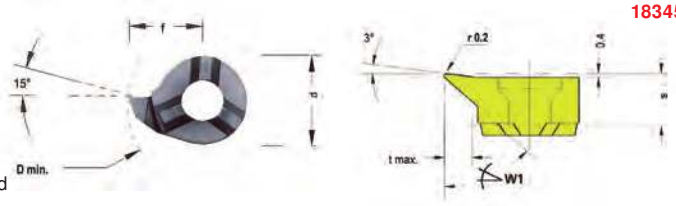
= The specified prices are unit prices. Only sold in the specified packing units. Always specify number of units in order information.

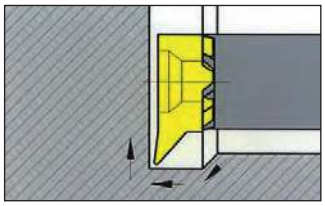
Continued

Dümmel WERKZEUGFABRIK

Relief grooving inserts
- Extraction, internal relief grooves (DIN 509)
- Ap max = maximum cutting depth
- Angle W1 = 47°
- Cemented carbide/HC8620 TiAlN-coated

18345



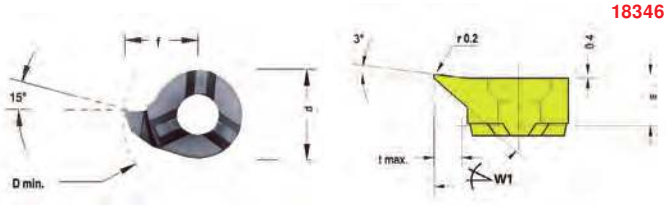


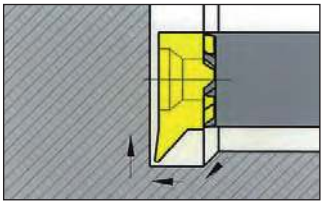
Designation	D min. mm	t max. mm	Ap max. mm	d mm	f mm	s mm	For clamp holder type	Right 18345 ...	Left 18345 ...
R/LS08.4746.02	7.8	1.2	0.4	6	4.65	3.5	608	101	201
R/LS11.4767.02	11.0	2.3	0.6	8	6.70	4.2	611	102	202
R/LS14.4787.02	13.7	3.0	0.8	9	8.70	5.3	614	103	203

Dümmel WERKZEUGFABRIK

Copy swivel plates
- Angle W1 = 30°
- Cemented carbide/HC8620 TiAlN-coated

18346



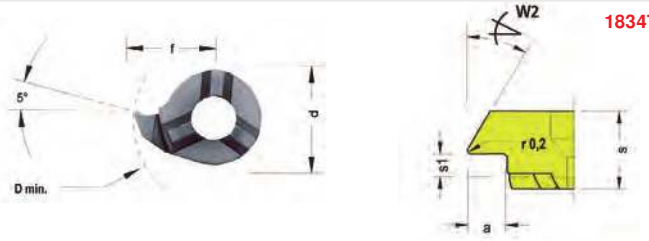


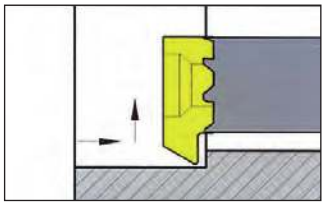
Designation	D min. mm	t max. mm	Ap max. mm	d mm	f mm	s mm	For clamp holder type	Right 18346 ...	Left 18346 ...
R/LS08.2555.02	7.8	1.2	0.4	6	4.65	3.5	608	101	201
R/LS11.2755.02	11.0	2.3	0.6	8	6.70	4.2	611	102	202
R/LS14.3555.02	13.7	4.0	0.8	9	8.70	5.3	614	103	203
R/LS16.4055.02	15.8	4.3	0.8	11	10.20	5.4	616	104	204

Dümmel WERKZEUGFABRIK

Reverse swivel plates
- Ap max = maximum cutting depth
- Angle W2 = 30°
- Cemented carbide/HC8620 TiAlN-coated

18347



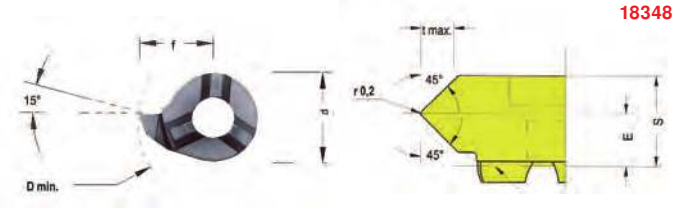


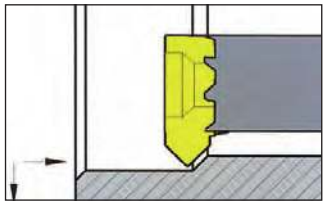
Designation	D min. mm	t max. mm	Ap max. mm	s1 mm	d mm	f mm	s mm	For clamp holder type	Right 18347 ...	Left 18347 ...
R/LS08.3046.02	7.8	1.3	0.6	1.0	6	4.65	3.5	608	101	201
R/LS11.3067.02	11.0	2.3	1.0	1.6	8	6.70	4.3	611	102	202
R/LS14.3087.02	13.8	3.5	1.5	2.4	9	8.70	5.4	614	103	203

Dümmel WERKZEUGFABRIK

Chamfer swivel plates
- Chamfering and extracting
- Ap max = maximum cutting depth
- Cemented carbide/HC8620 TiAlN-coated

18348



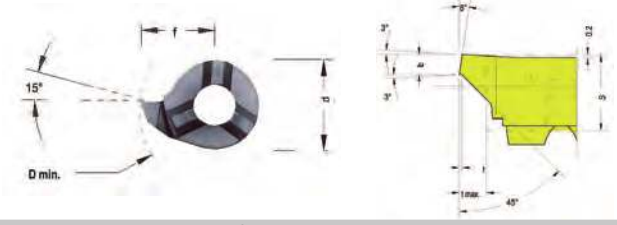


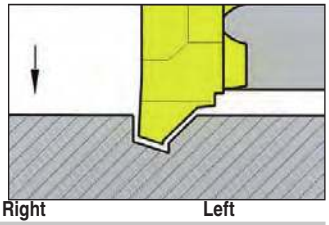
Designation	D min. mm	t max. mm	Ap max. mm	e mm	d mm	f mm	s mm	For clamp holder type	Right 18348 ...	Left 18348 ...
R/LS08.4545.02	8	1.4	0.6	1.8	6	4.8	3.5	608	101	201
R/LS11.4545.02	11	1.5	1.0	2.2	8	6.7	4.3	611	102	202
R/LS14.4545.02	14	1.5	1.2	2.8	9	9.0	5.4	614	103	203

Dümmel WERKZEUGFABRIK

Pre-cutting plates
- Pre-cutting and chamfering
- t = 0.2 mm
- Cemented carbide/HC8620 TiAlN-coated

18349





Designation	D min. mm	t max. mm	b mm	d mm	f mm	s mm	For clamp holder type	Right 18349 ...	Left 18349 ...
R/LS08.0810.45	8	1.0	1.0	6.0	4.8	3.3	608	101	201
R/LS11.0810.45	11	1.5	1.0	8.0	6.7	4.2	611	102	202
R/LS14.0815.45	14	1.5	1.0	9.0	9.0	5.3	614	103	203
R/LS16.0815.45	16	1.5	1.0	11.0	10.2	5.4	616	104	204

Continued

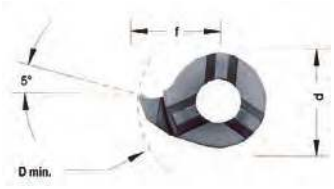
18340 - 18352 Cemented-carbide cutting plates for system MINI-CUT

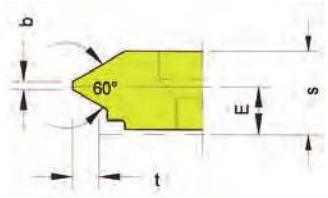
VHM TiAIN

Continued

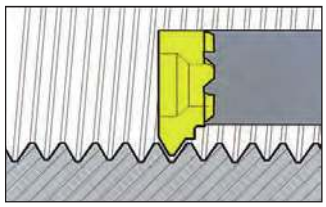
Dümmel WERKZEUGFABRIK

Thread-cutting inserts 60°
- Standard thread partial profile
- t = 0.2 mm
- Cemented carbide/HC8620 TiAIN-coated





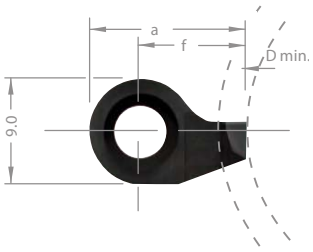
18350

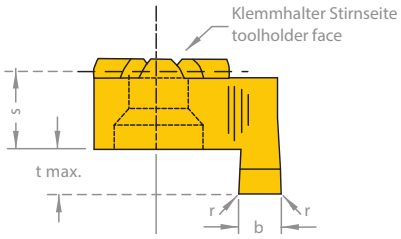


Designation	D min. mm	pitch mm	t mm	e mm	b mm	f mm	s mm	d mm	For clamp holder type	Right 18350	...	Left 18350	...
R/LS08.0815.01	8	1.5/1.75	0.95	2.25	0.18	4.8	3.5	6	608		101		201
R/LS11.1020.01	11	2.0/2.5	1.08	3.00	0.25	6.7	4.3	8	611		102		202
R/LS11.1325.01	11	2.5/3.0	1.35	3.00	0.31	6.7	4.3	8	611		103		203
R/LS14.1020.01	14	2.0/2.5	1.08	3.90	0.25	9.0	5.4	9	614		104		204
R/LS14.1325.01	14	2.5/3.0	1.35	3.65	0.31	9.0	5.4	9	614		105		205
R/LS16.1325.01	16	2.5/3.0	1.35	3.70	0.31	10.2	5.5	11	616		106		206

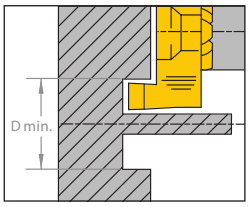
Dümmel WERKZEUGFABRIK

Axial grooving inserts
- Axial grooving past the pin
- Cemented carbide/HC8620 TiAIN-coated





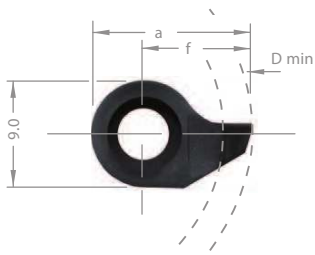
18351

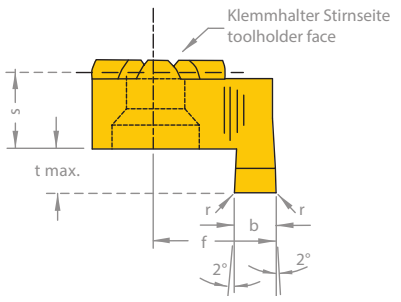


Designation	D min. mm	t max. mm	b + 0.03 mm	a mm	r mm	f mm	s mm	For clamp holder type	Right 18351	...	Left 18351	...
R/LS014.1210.00	12	1.5	1.0	11.5	-	7.0	8.3	614		101		201
R/LS014.1215.02	12	2.5	1.5	12.0	0.2	7.5	8.3	614		102		202
R/LS014.1220.02	12	3.0	2.0	12.5	0.2	8.0	8.3	614		103		203
R/LS014.1225.02	12	3.0	2.5	13.0	0.2	8.5	8.3	614		104		204
R/LS014.1230.02	12	3.0	3.0	13.5	0.2	9.0	8.3	614		105		205
R/LS014.1220.52	12	5.0	2.0	12.5	0.2	8.0	10.3	614		106		206
R/LS014.1225.52	12	5.0	2.5	13.0	0.2	8.5	10.3	614		107		207
R/LS014.1230.52	12	5.0	3.0	13.5	0.2	9.0	11.3	614		108		208

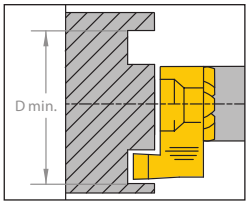
Dümmel WERKZEUGFABRIK

Axial grooving inserts
- Axial grooving
- Cemented carbide/HC8620 TiAIN-coated





18352



Designation	D min. mm	t max. mm	b + 0.03 mm	a mm	r mm	f mm	s mm	For clamp holder type	Right 18352	...	Left 18352	...
R/LS014.1410.00	14	1.5	1.0	13.5	-	9	8.3	614		101		201
R/LS014.1415.02	14	2.5	1.5	13.5	0.2	9	8.3	614		102		202
R/LS014.1420.02	14	3.0	2.0	13.5	0.2	9	8.3	614		103		203
R/LS014.1425.02	14	3.0	2.5	13.5	0.2	9	8.3	614		104		204
R/LS014.1430.02	14	3.0	3.0	13.5	0.2	9	8.3	614		105		205
R/LS014.1420.52	14	5.0	2.0	13.5	0.2	9	10.3	614		106		206
R/LS014.1425.52	14	5.0	2.5	13.5	0.2	9	10.3	614		107		207
R/LS014.1430.52	14	5.0	3.0	13.5	0.2	9	10.3	614		108		208

= The specified prices are unit prices. Only sold in the specified packing units. Always specify number of units in order information.