

**Info**

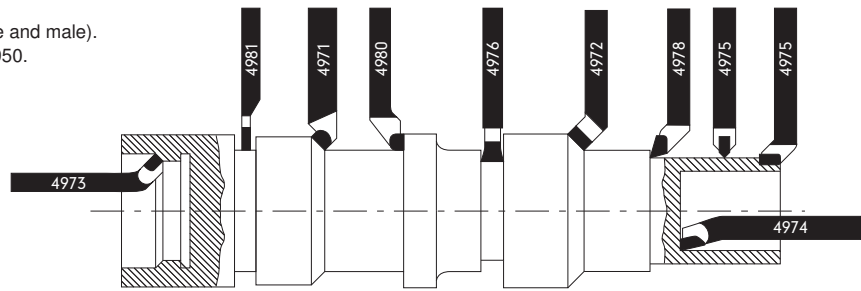
**18860-18877 Cemented-carbide lathe chisels**

**Design**

DIN 4971 to DIN 4981 and for threads (female and male).  
With soldered-on ISO cutting edges to DIN 4950.

**Quality**

Cutting edges carbide-tipped.



**18860 - 18861 Straight lathe chisel DIN 4971/ISO 1**

**18860**

**Design**

Right, angle of attack 70°.

**18861**

**Design**

Left, angle of attack 70°.

**18860**



Right			P 20	P 25/30	K 10/20
Designation	h x b x l <sub>1</sub> mm	c mm	18860	18860	18860
10q	10 x 10 x 90	4	209	216	223
12q	12 x 12 x 100	5	210	217	224
16q	16 x 16 x 110	6	211	218	225
20q	20 x 20 x 125	8	212	219	226
25q	25 x 25 x 140	10	213	220	227

Left			P 20	P 25/30	K 10/20
Designation	h x b x l <sub>1</sub> mm	c mm	18861	18861	18861
10q	10 x 10 x 90	4	209	216	223
12q	12 x 12 x 100	5	210	217	224
16q	16 x 16 x 110	6	211	218	225
20q	20 x 20 x 125	8	212	219	226
25q	25 x 25 x 140	10	213	220	227

**18862 - 18863 Bent lathe chisel DIN 4972/ISO2**

**18862**

**Design**

Right, angle of attack 45°.

**18863**

**Design**

Left, angle of attack 45°.

**18862**



Right			M 10/20	P 10	P 20	P 25/30	K 10/20
Designation	h x b x l <sub>1</sub> mm	c mm	18862	18862	18862	18862	18862
10q	10 x 10 x 90	6	202	209	216	223	230
12q	12 x 12 x 100	7	203	210	217	224	238
16q	16 x 16 x 110	8	204	211	218	225	239
20q	20 x 20 x 125	10	205	212	219	226	240
25q	25 x 25 x 140	12	206	213	220	227	241
32q	32 x 32 x 170	14			221	228	

Left			P 10	P 20	P 25/30	K 10/20
Designation	h x b x l <sub>1</sub> mm	c mm	18863	18863	18863	18863
10q	10 x 10 x 90	6	209	216	223	230
12q	12 x 12 x 100	7	210	217	224	238
16q	16 x 16 x 110	8	211	218	225	239
20q	20 x 20 x 125	10	212	219	226	240
25q	25 x 25 x 140	12	213	220	227	241
32q	32 x 32 x 170	14			228	

**18864**

**Internal lathe chisel DIN 4973/ISO 8**

**Design**

Right, angle of attack 75°.

18864



Right				M 10/20	P 10	P 20	P 25/30	K 10/20	
Designation	h x b x l, mm	c mm	For bore Ø from mm	18864	...	18864	...	18864	
10q	10 x 10 x 150	4	18		202	209	216	223	229
12q	12 x 12 x 180	5	21		203	210	217	224	230
16q	16 x 16 x 210	6	27		204	211	218	225	231
20q	20 x 20 x 250	8	34		205	212	219	226	232
25q	25 x 25 x 300	10	43		206	213	220	227	233
32q	32 x 32 x 355	12	52					228	234

**18865**

**Internal corner lathe chisel DIN 4974/ISO 9**

**Design**

Right, angle of attack 88°.

18865



Right				M 10/20	P 10	P 20	P 25/30	K 10/20	
Designation	h x b x l, mm	c mm	For bore Ø from mm	18865	...	18865	...	18865	
10q	10 x 10 x 150	4	18		202	209	216	223	237
12q	12 x 12 x 180	5	21		203	210	217	224	238
16q	16 x 16 x 210	6	27		204	211	218	225	239
20q	20 x 20 x 250	8	34		205	212	219	226	240
25q	25 x 25 x 300	10	43		206	213	220	234	241
32q	32 x 32 x 355	12	52		207		221	235	242

**18866**

**Centre lathe chisel DIN 4975**

**Design**

Angle of attack 50°.

18866



		P 10	P 20	P 25/30	K 10/20	
Designation	h x b x l, mm	18866	...	18866	...	
16h	16 x 10 x 110		209	216	223	232
20h	20 x 12 x 125		210	217	224	233
25h	25 x 16 x 140		211	218	225	234

**18867**

**Width of lathe chisel DIN 4976/ISO 4**

**Design**

Angle of attack 0°.

18867



		P 20	P 25/30	K 10/20	
Designation	h x b x l, mm	18867	...	18867	
10q	10 x 10 x 90		209	223	
12q	12 x 12 x 100		210	217	224
16q	16 x 16 x 110		211	218	225
20q	20 x 20 x 125		212	219	226
25q	25 x 25 x 140		213	220	227
32q	32 x 32 x 170		214		

**18868**

**Offset facing lathe chisel DIN 4977/ISO 5**

**Design**

Right, angle of attack 90°.

18868



Right			P 10	P 20	P 25/30	K 10/20	
Designation	h x b x l, mm	c mm	18868	...	18868	...	
16q	16 x 16 x 110	8		211	218	225	232
20q	20 x 20 x 125	10		212	219	226	233
25q	25 x 25 x 140	12			220	227	234
32q	32 x 32 x 170	16			221		242

# Cemented-carbide lathe chisels

## 18869 Offset corner lathe chisel DIN 4978/ISO 3

**Design**  
Right, angle of attack 95°.

18869



Right			M 10/20	P 10	P 20	P 25/30	K 10/20
Designation	h x b x l <sub>1</sub> mm	c mm	18869	...	18869	...	18869
16h	16 x 10 x 110	5	204	...	211	...	218
20h	20 x 12 x 125	6	205	...	212	...	219
25h	25 x 16 x 140	8	206	...	213	...	220
32h	32 x 20 x 170	10	...	...	...	...	221

## 18870 Offset corner lathe chisel DIN 4978/ISO 3

**Design**  
Left, angle of attack 95°.

18870



Left			P 20	P 25/30	K 10/20
Designation	h x b x l <sub>1</sub> mm	c mm	18870	...	18870
16h	16 x 10 x 110	5	...	...	218
20h	20 x 12 x 125	6	...	...	219
25h	25 x 16 x 140	8	...	...	220
32h	32 x 20 x 170	10	...	...	221

## 18871 - 18872 Offset side lathe chisel DIN 4980/ISO 6

**18871 Design**  
Right, angle of attack 90°.

18871



**18872 Design**  
Left, angle of attack 90°.

Right			M 10/20	P 10	P 20	P 25/30	K 10/20
Designation	h x b x l <sub>1</sub> mm	c mm	18871	...	18871	...	18871
10q	10 x 10 x 90	4	202	...	209	...	216
12q	12 x 12 x 100	5	203	...	210	...	217
16q	16 x 16 x 110	6	204	...	211	...	218
20q	20 x 20 x 125	8	205	...	212	...	219
25q	25 x 25 x 140	10	206	...	213	...	220
32q	32 x 32 x 170	12	...	...	...	...	221

Left			P 10	P 20	P 25/30	K 10/20	
Designation	h x b x l <sub>1</sub> mm	c mm	18872	...	18872	...	18872
10q	10 x 10 x 90	4	...	...	209	...	216
12q	12 x 12 x 100	5	...	...	210	...	217
16q	16 x 16 x 110	6	...	...	211	...	218
20q	20 x 20 x 125	8	...	...	212	...	219
25q	25 x 25 x 140	10	...	...	213	...	220
32q	32 x 32 x 170	12	...	...	...	...	221

## 18873 Recessing lathe chisel DIN 4981/ISO 7

**Design**  
Right.

18873



Right				M 10/20	P 10	P 20	P 25/30	K 10/20
Designation	h x b x l <sub>1</sub> mm	l <sub>2</sub> mm	b <sub>2</sub> mm	18873	...	18873	...	18873
12h	12 x 8 x 100	12	3	203	...	210	...	217
16h	16 x 10 x 110	14	4	204	...	211	...	218
20h	20 x 12 x 125	16	5	205	...	212	...	219
25h	25 x 16 x 140	20	6	206	...	213	...	220
32h	32 x 20 x 170	25	8	207	...	...	...	221

18874

## Recessing lathe chisel DIN 4981/ISO 7

Design  
Left.

18874



Left				P 10		P 20		P 25/30		K 10/20	
Designation	h x b x l <sub>1</sub> mm	l <sub>2</sub> mm	b <sub>2</sub> mm	18874	...	18874	...	18874	...	18874	...
12h	12 x 8 x 100	12	3			210		217		224	231
16h	16 x 10 x 110	14	4			211		218		225	232
20h	20 x 12 x 125	16	5			212		219		226	233
25h	25 x 16 x 140	20	6			213		220		227	234
32h	32 x 20 x 170	25	8							228	235

18875

## Male thread lathe chisel

Design  
Right, straight, 60°.

18875



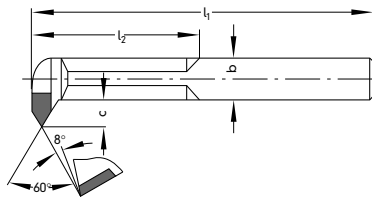
Right		P 20		K 10/20	
Designation	h x b x l <sub>1</sub> mm	18875	...	18875	...
12q	12 x 12 x 110			203	209
16q	16 x 16 x 125			204	210
20q	20 x 20 x 140			205	211
25q	25 x 25 x 160			206	212

18876

## Female thread lathe chisel

Design  
Right, bent, 60°.

18876



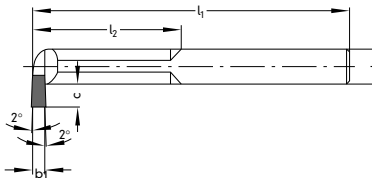
Right						P 20		K 10/20	
Designation	h x b x l <sub>1</sub> mm	c mm	l <sub>2</sub> mm	For bore Ø	From mm	18876	...	18876	...
10q	10 x 10 x 140	6	52		16			202	209
12q	12 x 12 x 160	6	56		20			203	210
16q	16 x 16 x 180	8	63		25			204	211
20q	20 x 20 x 210	10	80		32			205	212
25q	25 x 25 x 250	12	100		40			206	213

18877

## Hooked lathe chisel

Design  
Right.

18877



Right							P 20		K 10/20	
Designation	h x b x l <sub>1</sub> mm	c mm	l <sub>2</sub> mm	b <sub>1</sub> mm	For bore Ø	From mm	18877	...	18877	...
10q	10 x 10 x 140	6	52	3		16			202	209
12q	12 x 12 x 160	6	56	4		20			203	210
16q	16 x 16 x 180	8	63	5		25			204	211
20q	20 x 20 x 210	10	80	6		32			205	212
25q	25 x 25 x 250	12	100	8		40			206	213
32q	32 x 32 x 300	14	125	10		50			207	