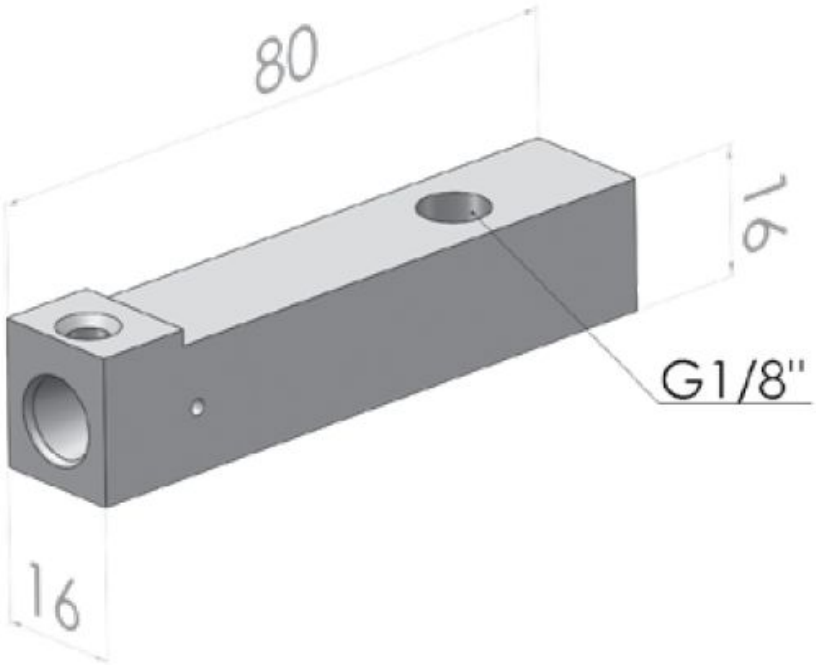
W&F

Werkzeugtechnik

HORN

Наружная обработка



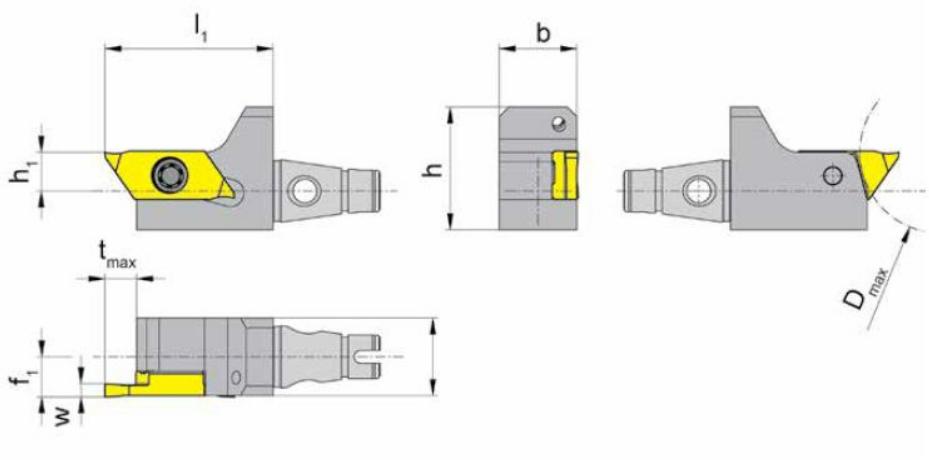
Statischer Halter 16x16VKT mit IKZ Static holder with internal cooling	
Bestellnummer Order no.	**WFMS.VKT.016.IK**

Модульные вставки

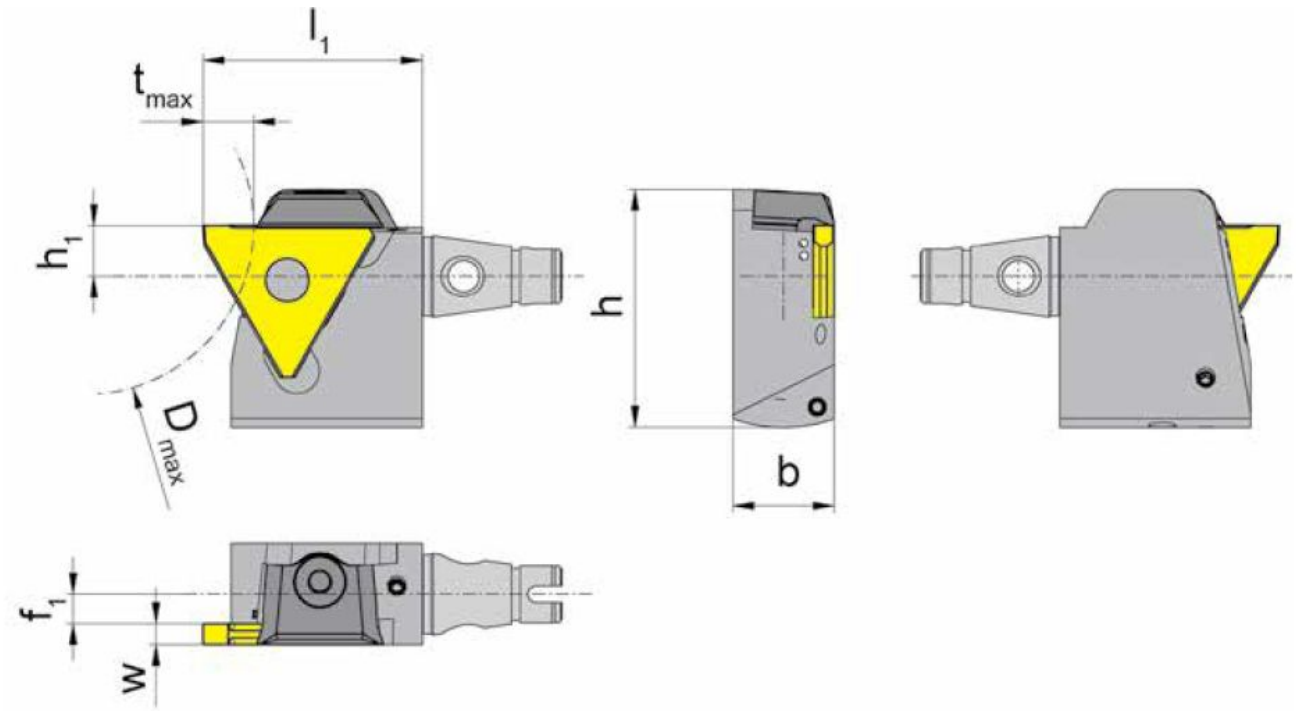
WFMS - Klemmhalter HORN H274

WFMS - Toolholder HORN H274

WG 40



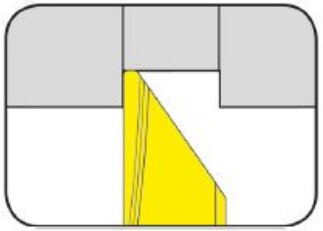
fits for holder	[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		Order no.
passend für Halter	**h**	**b**	**l1**	**h1**	**f1**	**tmax**	**Dmax**	**w**	**Größe**	**Bestellnummer**
10x10, 12x12, 1/2"x1/2"	19	12	26	6	6,2	6	25	04	01	WF.M.12.R274.2.24.IK
16x16	23	16	26	8	8,2	6	25	04	02	WF.M.16.R274.2.24.IK



fits for holder	[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		Order no.
passend für Halter	**h**	**b**	**l1**	**h1**	**f1**	**tmax**	**Dmax**	**w**	**Größe**	**Bestellnummer**
10x10, 12x12, 1/2"x1/2"	28,2	12	26	6	4,5	4	40	0,5 - 1,9	01	WF.M.12.R360.1.51.IK
10x10, 12x12, 1/2"x1/2"	28,2	12	26	6	3,5	6	40	1,9 - 2,9	02	WF.M.12.R360.2.52.IK
10x10, 12x12, 1/2"x1/2"	28,2	12	26	6	2,5	6	40	2,9 - 3,9	03	WF.M.12.R360.2.53.IK
16x16	30,2	16	26	8	6,5	4	40	0,5 - 1,9	01	WF.M.16.R360.1.51.IK
16x16	30,2	16	26	8	5,5	6	40	1,9 - 2,9	02	WF.M.16.R360.2.52.IK
16x16	30,2	16	26	8	4,5	6	40	2,9 - 3,9	03	WF.M.16.R360.2.53.IK

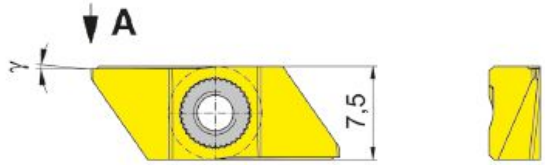
Черновая пластина

Wendeschneidplatte **S274...E**
Indexable insert



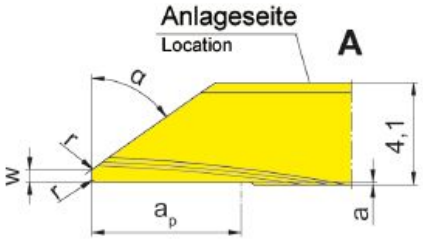
Schnitttiefe bis	Depth of cut up to	6 mm

präzisionsgeschliffen
precision ground



für Klemmhalter
for Toolholder

Typ H274...E
Type



R = rechts wie gezeichnet
R = right hand version shown

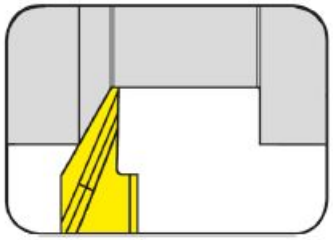
L = links spiegelbildlich
L = left hand version

Wechselgenauigkeit
Länge ± 0,015 mm
Indexability length
± 0,015 mm

Bestellnummer Part number	w	r	a	γ	a_p	α	Größe Size	TH35
R/LS274.0035.04.20.E	-	0,05	0,1	5°	4	35°	04	Δ/Δ
R/LS274.0235.04.20.E	0,2	-	0,1	5°	4	35°	04	Δ/Δ
R/LS274.0535.06.20.E	0,5	0,20	0,1	5°	6	35°	04	Δ/Δ
R/LS274.0055.04.20.E	-	0,05	0,1	5°	4	55°	04	Δ/Δ
R/LS274.0255.04.20.E	0,2	-	0,1	5°	4	55°	04	Δ/Δ
R/LS274.0555.06.20.E	0,5	0,20	0,1	5°	6	55°	04	Δ/Δ

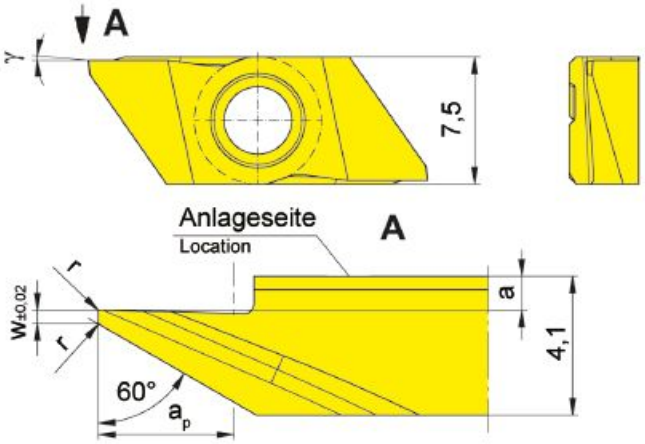
Чистовая пластина

Wendeschneidplatte **S274**
Indexable insert



Schnitttiefe bis	Depth of cut up to	6 mm

präzisionsgeschliffen
precision ground



für Klemmhalter
for Toolholder

Typ / Type
H274
KT274
KTC274
974
R76
H274KM
HC274KM

R = rechts wie gezeichnet
R = right hand version shown

L = links spiegelbildlich
L = left hand version

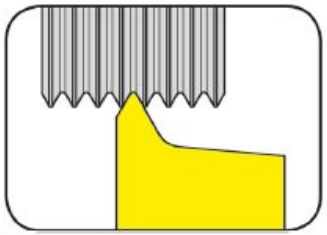
Wechselgenauigkeit
Länge ± 0,015 mm
Indexability length
± 0,015 mm

Bestellnummer Part number	w	r	a	γ	a_p	Größe Size		K10	TH35
R/LS274.0460.04.10	0,4	0,05	1,00	15°	4	04		▲/▲	▲/▲
R/LS274.0460.04.M0	0,4	0,05	1,00	0°	4	04		▲/Δ	Δ/Δ
R/LS274.0560.06.11	0,5	0,10	0,05	15°	6	04		▲/▲	▲/▲
R/LS274.0060.04.10	-	0,05	1,00	15°	4	04		▲/▲	▲/▲

Резьбовая пластина шаг 0,4

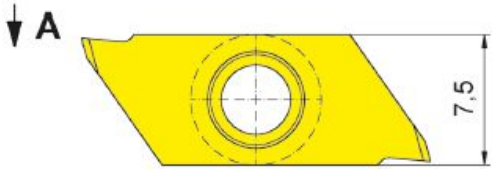
Wendeschneidplatte
Indexable insert

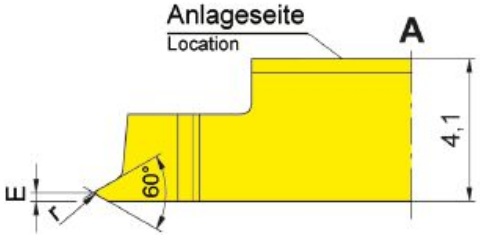
S274
Metrisches ISO-Gewinde
Metric ISO thread



Steigung	Pitch	0,25-0,4 mm

präzisionsgeschliffen
precision ground





R = rechts wie gezeichnet
R = right hand version shown

für Klemmhalter
for Toolholder

Typ Type	H274 KT274 KTC274 974 R76 H274KM HC274KM

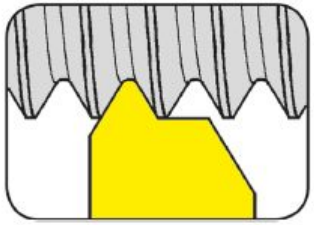
Wechselgenauigkeit
Länge ± 0,015 mm
Indexability length
± 0,015 mm

Bestellnummer Part number	P	E	r	Größe Size		TH35
RS274.0102.01	0,25	0,20	0,04	04		▲
RS274.0203.01	0,35	0,25	0,05	04		▲
RS274.0204.01	0,40	0,30	0,06	04		▲

Резьбовая пластина шаг 0,4; 0,7;0,8;1

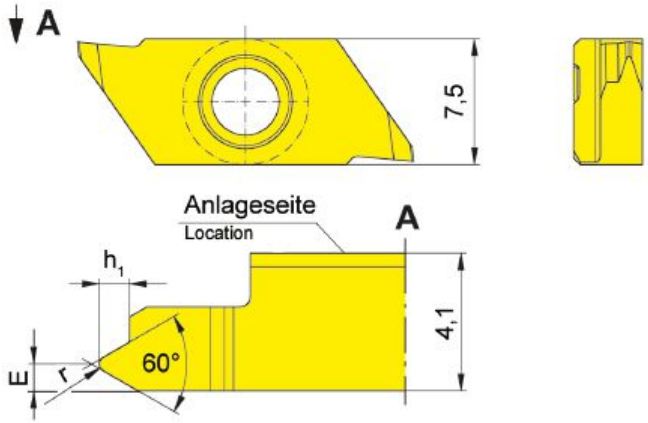
Wendeschneidplatte
Indexable insert

S274
Metrisches ISO-Gewinde
Metric ISO thread



Steigung	Pitch	0,5-1,5 mm

präzisionsgeschliffen
precision ground



für Klemmhalter
for Toolholder

Typ Type	H274 KT274 KTC274 974 R76 H274KM HC274KM

R = rechts wie gezeichnet
R = right hand version shown

L = links spiegelbildlich
L = left hand version

Wechselgenauigkeit
Länge ± 0,015 mm
Indexability length
± 0,015 mm

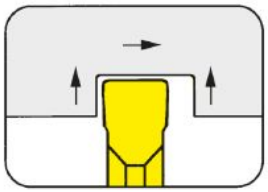
Bestellnummer Part number	P	E	r	h_1	Größe Size	TH35
R/LS274.0305.02	0,50	0,40	0,07	0,31	04	▲/Δ
R/LS274.0306.02	0,60	0,45	0,09	0,37	04	▲/Δ
R/LS274.0307.02	0,70	0,50	0,10	0,43	04	▲/Δ
R/LS274.0407.02	0,75	0,50	0,11	0,46	04	▲/▲
R/LS274.0408.02	0,80	0,55	0,12	0,49	04	▲/Δ
R/LS274.0610.02	1,00	0,60	0,14	0,61	04	▲/▲
R/LS274.0712.02	1,25	0,70	0,15	0,77	04	▲/▲
R/LS274.0915.02	1,50	0,80	0,20	0,92	04	▲/Δ

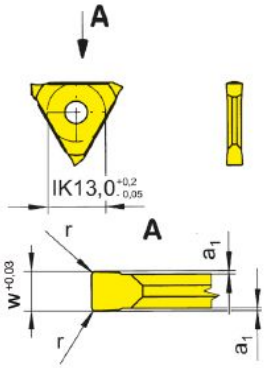
Пластина отрезная и канавочная 1,5

Wendeschneidplatte
Indexable insert

312
mit runder Spanleitstufe
with round chip breaker

Stechtiefe bis Stechbreite	Depth of groove up to Width of groove	6 mm 1-4 mm





für Klemmhalter
for Toolholder

Typ Type	309 360 361 390 369 330 360C 360TS N68 65

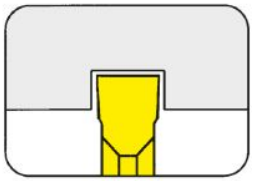
Wechselgenauigkeit
Länge ± 0,02 mm
Indexability length ± 0,02 mm

Bestellnummer Part number	w	r	a_1	Größe Size	K10	AS62	EG52	H20	P20	TF45	TI22	TI25	TN32	TN35	TN38
312.0100.02	1,0	0,2	0,10	01			Δ					▲	▲		
312.0150.02	1,5	0,2	0,25	01	Δ		Δ		▲			▲	▲	▲	
312.0200.02	2,0	0,2	0,25	02	▲		▲	▲	▲	▲	▲	▲	▲	▲	
312.0200.04	2,0	0,4	0,25	02		▲	▲	▲	▲				▲		
312.0300.02	3,0	0,2	0,25	03	Δ		▲	▲	▲			▲	▲		
312.0300.06	3,0	0,6	0,25	03			▲		▲				▲		
312.0300.08	3,0	0,8	0,25	03			▲		Δ				▲		Δ
312.0400.02	4,0	0,2	0,25	04			▲	▲	▲				▲		
312.0400.08	4,0	0,8	0,25	04			▲		Δ				▲		
312.0400.12	4,0	1,2	0,25	04			Δ		Δ						

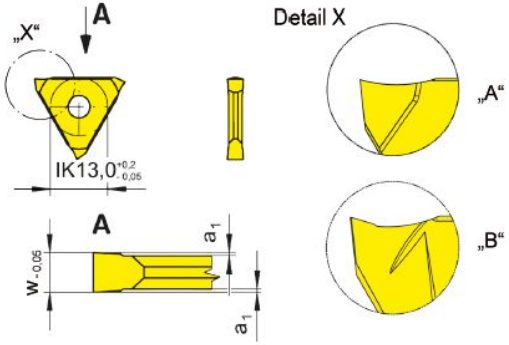
Пластина отрезная и канавочная 0,57

Wendeschneidplatte
Indexable insert

312
mit runder Spanleitstufe
with round chip breaker



Seegerringnuten Nutnennbreite Nw	Circlip grooves Width of circlip Nw	DIN 471/472 0,5-5,15 mm



Form A = komplett geschliffen
Form A = completely ground

Form B = teilgeschliffen
Form B = partially ground

für Klemmhalter
for Toolholder

Typ Type	309 360 361 390 369 330 360C 360TS N68 65

Wechselgenauigkeit
Länge ± 0,02 mm
Indexability length ± 0,02 mm

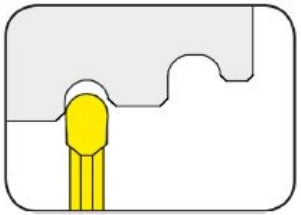
Bestellnummer Part number	w	Nw	a_1	Form Form	Größe Size	K10	MG12	EG35	EG55	EG56	H20	HS32	HS36	P20	TA45	TC92	TF45	TF46	TI25	TN32	TN35
312.0050.00	0,57	0,50	0,07	A	01	▲			▲					▲			▲	▲		▲	
312.0060.00	0,67	0,60	0,07	A	01	▲			▲					▲			▲	▲		▲	
312.0070.00	0,77	0,70	0,08	A	01	▲			▲					▲			▲	▲		▲	
312.0080.00	0,87	0,80	0,08	A	01	▲			▲					▲			▲	▲		▲	
312.0090.00	0,97	0,90	0,08	A	01	▲			▲					▲			▲	▲		▲	▲
312.0100.00	1,07	1,00	0,09	A	01	▲			▲		△			▲			▲	▲		▲	▲
312.0110.00	1,24	1,10	0,20	A	01	▲			▲			△	△	▲		▲	▲	▲		▲	
312.0130.00	1,44	1,30	0,20	A	01	▲			▲					▲		▲	▲	▲		▲	▲
312.0160.00	1,74	1,60	0,20	A	01	▲			▲					▲		▲	▲	▲		▲	▲
312.0185.00	1,99	1,85	0,20	B	01	▲	▲		▲	△	▲			▲		▲	▲	▲	▲	▲	▲
312.0215.00	2,29	2,15	0,20	B	02	▲	▲		▲		▲			▲	▲	▲	▲	▲		▲	▲
312.0265.00	2,79	2,65	0,20	B	02	▲	▲		▲		▲			▲	△	▲	▲	▲		▲	▲
312.0315.00	3,29	3,15	0,20	B	03	▲			▲		▲			▲		▲	▲	▲		▲	▲
312.0415.00	4,29	4,15	0,20	B	04	▲			▲					▲		▲	▲	▲		▲	▲
312.0515.00	5,29	5,15	0,20	B	04	▲		▲	▲		△			▲		△	▲	▲		▲	

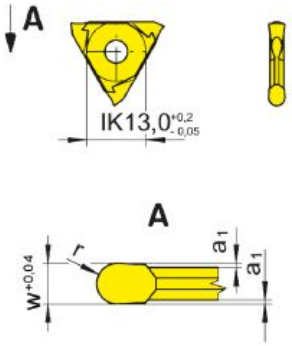
Пластина канавочная круглая 0,5; 1 ; 2

Wendeschneidplatte
Indexable insert

312
mit runder Spanleitstufe
with round chip breaker

Stechtiefe bis	Depth of groove up to	6 mm
Vollradius	Full radius	0,25-2 mm





für Klemmhalter
for Toolholder

Typ / Type: 309, 360, 361, 390, 369, 330, 360C, 360TS, N68, 65

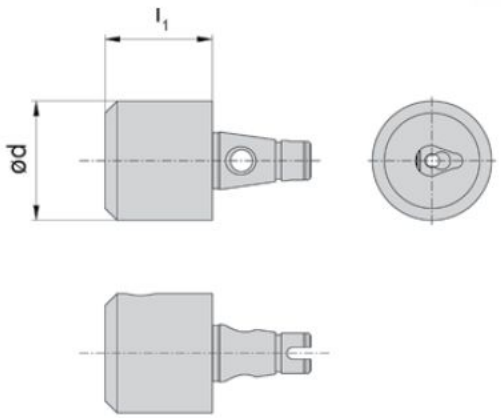
Wechselgenauigkeit
Länge ± 0,02 mm
Indexability length ± 0,02 mm

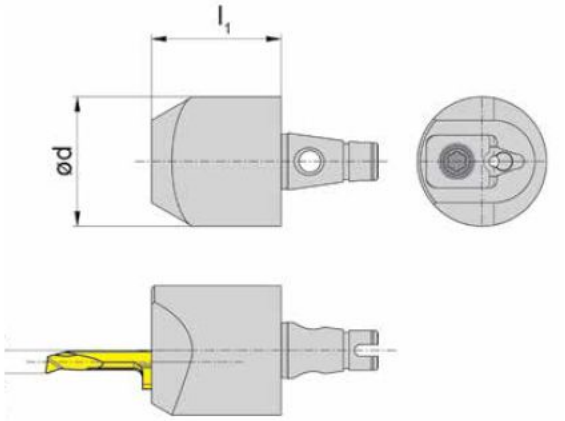
Bestellnummer Part number	w	a_1	r	Größe Size	AS45	EG35	EG55	P20	TF45	TH35	TI25	TN32	TN35
312.0050.02	0,5	0,07	0,25	01	▲	▲		▲				▲	
312.0100.05	1,0	0,09	0,50	01	▲	▲		▲		Δ		▲	Δ
312.0110.05	1,1	0,09	0,55	01	▲		Δ						
312.0120.06	1,2	0,20	0,60	01	▲		▲	▲				▲	
312.0140.07	1,4	0,20	0,70	01	▲		▲						
312.0160.08	1,6	0,25	0,80	01	▲		▲	▲				▲	
312.0180.09	1,8	0,25	0,90	01	▲		▲						
312.0200.10	2,0	0,25	1,00	01	▲		▲	▲	Δ		Δ	▲	

Внутренняя обработка

Drehhalter Rundschaft Turning holder cylindrical	
Bestellnummer Order no.	**WFMS.RS.20.065.IK**

Быстросменный модуль B105 под капли 7





fits for holder **passend für Halter**	[mm] **d**	[mm] **l1**	[mm] **f1**	[mm] ***b**	Order no. **Bestellnummer**
Ø 19,05-28	20	18	-	-	WF.M.B105.IK
Ø 19,05-28	22	30	-	-	WF.M.B110.IK
Ø 19,05-28	22	22	3,3	5,9	WF.M.B105.S.03.IK
Ø 19,05-28	22	22	3,9	6,4	WF.M.B105.S.04.IK
Ø 19,05-28	21	22	5,3	7,0	WF.M.B105.S.05.IK

*b = Schneidplattenhöhe

*b = Height of insert

Spare Parts

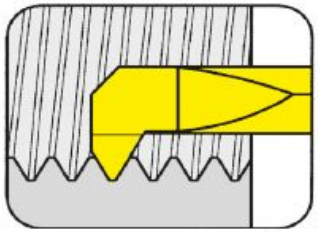
Ersatzteile

Screw **Spannschraube**	Clamp **Spannelement**	TORX PLUS Wrench **TORX PLUS-Schlüssel**	For torque specification Nm **Das Anzugsmoment der Schrauben ist Nm.**	Toolholder **Klemmhalter**
6.075T15P		T15PQ	5	WF.M.B105.IK / WF.M.B110.IK
	010.0105.03	T15PL	2	WF.M.B105.S.03.IK
	010.0105.04	T15PL	2	WF.M.B105.S.04.IK
	010.0105.05	T15PL	2	WF.M.B105.S.05.IK

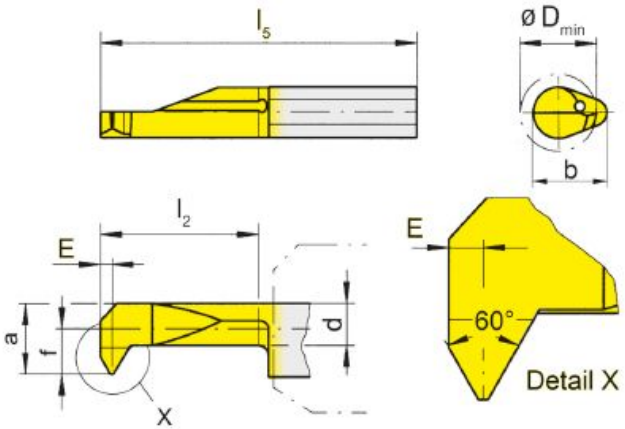
Резьбовая вставка неполного профиля шаг 0,5-0,75

Schneidplatte
Insert

105



Bohrungs-Ø ab	Bore Ø from	3,00 mm
Steigung	Pitch	P 0,50 - 0,75 mm



für Klemmhalter
for Toolholder

Typ	H105
Type	HC105
	B105
	VDI
	B105C
	B105TS
	IR105
	962
	AIH
	963
	N

R = rechts wie gezeichnet
R = right hand version shown

L = links spiegelbildlich
L = left hand version

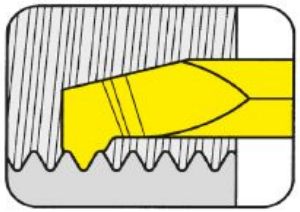
Metrisches ISO-Gewinde
Metric ISO thread

Bestellnummer Part number	P	P_{max}	E	f	a	d	b	l_2	l_5	D_{min}	EG35	TH35	TN35
R/L105.0407.2.3	0,5	0,75	0,45	1,4	2,7	2,0	5,9	15	30	3	▲/Δ		▲/Δ
R/L105.0407.1.4	0,5	0,75	0,45	1,9	3,7	2,7	6,4	10	25	4	▲/Δ		▲/Δ
R/L105.0407.2.4	0,5	0,75	0,45	1,9	3,7	2,7	6,4	15	30	4	▲/Δ		▲/Δ
R/L105.0407.3.4	0,5	0,75	0,45	1,9	3,7	2,7	6,4	20	35	4	▲/Δ		▲/Δ
R/L105.0407.2.5	0,5	0,75	0,45	2,3	4,7	3,5	7,0	15	30	5	▲/▲	▲/Δ	▲/▲
R/L105.0407.3.5	0,5	0,75	0,45	2,3	4,7	3,5	7,0	20	35	5	Δ/Δ		▲/Δ
R/L105.0407.4.5	0,5	0,75	0,45	2,3	4,7	3,5	7,0	25	40	5	▲/Δ		▲/Δ
R/L105.0407.3.6	0,5	0,75	0,45	3,3	5,7	4,7	7,0	20	35	6	▲/Δ		▲/Δ

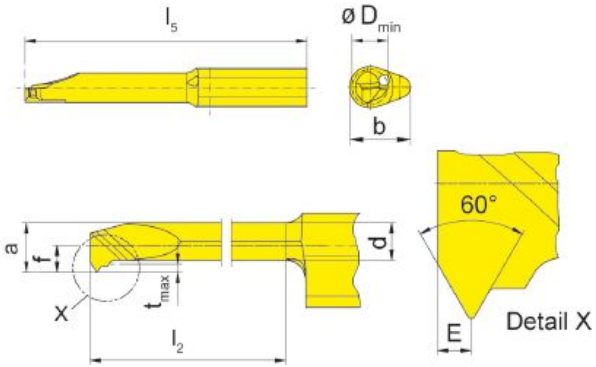
Резьбовая вставка полного профиля шаг 1 и 1.25

Schneidplatte
Insert

105



Bohrungs-Ø ab	Bore Ø from	2,40 mm
Steigung	Pitch	P 0,5 - 1,25 mm



für Klemmhalter
for Toolholder

Typ	H105
Type	HC105
	B105
	VDI
	B105C
	B105TS
	IR105
	962
	AIH
	963
	N

Metrisches ISO-Gewinde
Metric ISO thread

R = rechts wie gezeichnet
R = right hand version shown

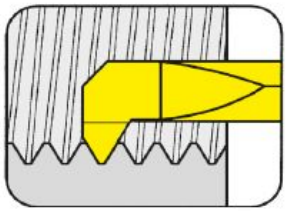
L = links spiegelbildlich
L = left hand version

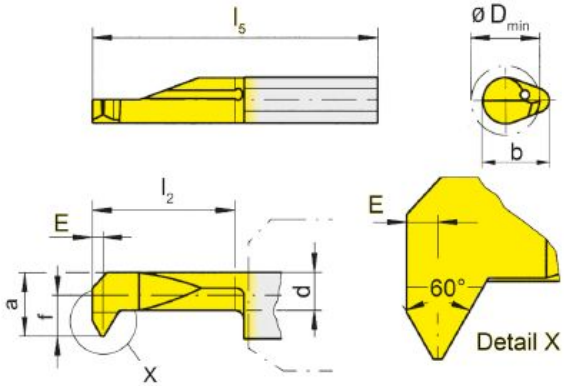
Bestellnummer Part number	P	E	f	a	d	b	l_2	l_5	D_{min}	EG35	TH35
R/L105.VPM3.2.3	0,50	0,3	1,4	2,2	1,65	5,9	9	25	2,4	▲/Δ	▲/Δ
R/L105.VPM3.4.3	0,50	0,3	1,4	2,2	1,65	5,9	16	35	2,4	▲/Δ	▲/Δ
R/L105.VPM4.2.4	0,70	0,4	1,5	2,9	2,10	6,4	15	30	3,2	▲/Δ	▲/Δ
R/L105.VPM4.3.4	0,70	0,4	1,5	2,9	2,10	6,4	20	35	3,2	▲/Δ	▲/Δ
R/L105.VPM5.2.5	0,80	0,5	2,0	3,7	2,80	7,0	15	30	4,1	▲/Δ	▲/▲
R/L105.VPM5.4.5	0,80	0,5	2,0	3,7	2,80	7,0	25	40	4,1	▲/Δ	▲/Δ
R/L105.VPM6.3.6	1,00	0,5	2,4	4,5	3,40	7,0	20	35	4,9	▲/▲	▲/▲
R/L105.VPM6.4.6	1,00	0,5	2,4	4,5	3,40	7,0	25	40	4,9	▲/Δ	▲/Δ
R/L105.VPM6.5.6	1,00	0,5	2,4	4,5	3,40	7,0	30	45	4,9	▲/Δ	▲/Δ
R/L105.VPM8.3.8	1,25	0,7	3,8	6,2	4,70	7,0	20	35	6,6	▲/Δ	▲/▲
R/L105.VPM8.5.8	1,25	0,7	3,8	6,2	4,70	7,0	30	45	6,6	▲/Δ	▲/Δ

Резьбовая вставка полного профиля шаг 1,5

Schneidplatte **105**
Insert

Bohrungs-Ø ab	Bore Ø from	4,8 mm
Steigung	Pitch	P 1,0 - 1,5 mm





für Klemmhalter
for Toolholder

Typ	H105
Type	HC105
	B105
	VDI
	B105C
	B105TS
	IR105
	962
	AIH
	963
	N

Metrisches ISO-Gewinde
Metric ISO thread

R = rechts wie gezeichnet
R = right hand version shown

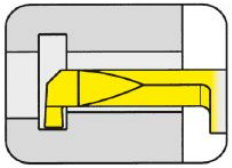
L = links spiegelbildlich
L = left hand version

Bestellnummer Part number	P	P_{max}	E	f	a	d	b	l_2	l_5	D_{min}	MG12	EG35	TF45	TH35	TI25	TN35
R/L105.0510.2.5	1,00	1,00	0,55	2,1	4,5	3,5	7	15	30	4,8	▲/Δ	▲/▲		▲/▲	Δ/x	▲/▲
R/L105.0510.3.5	1,00	1,00	0,55	2,1	4,5	3,5	7	20	35	4,8		▲/Δ				▲/Δ
R/L105.0510.4.5	1,00	1,00	0,55	2,1	4,5	3,5	7	25	40	4,8		▲/Δ				▲/▲
R/L105.0510.2.6	1,00	1,00	0,55	3,3	5,7	3,7	7	15	30	6,0		▲/▲		▲/▲		▲/▲
R/L105.0612.2.6	1,25	1,25	0,65	3,3	5,7	3,7	7	15	30	6,0	Δ/Δ	▲/▲		▲/▲		▲/▲
R/L105.0612.3.6	1,25	1,25	0,65	3,3	5,7	3,7	7	20	35	6,0		▲/Δ				▲/▲
R/L105.0612.4.6	1,25	1,25	0,65	3,3	5,7	3,7	7	25	40	6,0		▲/Δ				▲/▲
R/L105.0815.2.7	1,50	1,50	0,75	4,0	6,4	3,7	7	15	30	7,0		▲/Δ	Δ/x	▲/▲		▲/▲
R/L105.0815.3.7	1,50	1,50	0,75	4,0	6,4	3,7	7	20	35	7,0		▲/Δ				▲/▲
R/L105.0815.4.7	1,50	1,50	0,75	4,0	6,4	3,7	7	25	40	7,0		▲/Δ				▲/▲

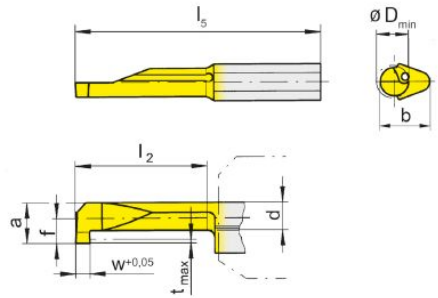
Канавка 1 и 2

Schneidplatte
Insert

105



Bohrungs-Ø ab Stechtiefe bis	Bore Ø from Depth of groove up to	6,0 mm 1,8 mm



für Klemmhalter
for Toolholder

Typ Type	H105 HC105 B105 VDI B105C B105TS IR105 962 AIH 963 N

R = rechts wie gezeichnet
R = right hand version shown

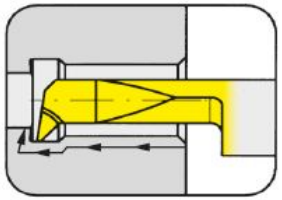
L = links spiegelbildlich
L = left hand version

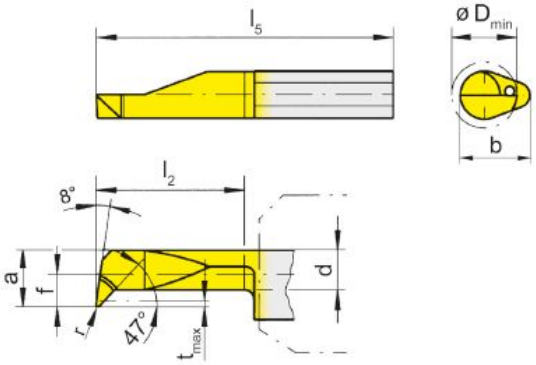
Bestellnummer Part number	w	f	a	d	b	l_2	l_5	t_{max}	D_{min}	MG12	EG35	TH35	TN35
R/L105.0100.1.6	1,0	3,3	5,7	3,7	7	10	25	1,8	6	▲/▲	▲/▲	▲/▲	▲/▲
R/L105.0150.1.6	1,5	3,3	5,7	3,7	7	10	25	1,8	6	▲/△	▲/▲	▲/△	▲/▲
R/L105.0200.1.6	2,0	3,3	5,7	3,7	7	10	25	1,8	6	▲/△	▲/△	▲/△	▲/▲
R/L105.0100.2.6	1,0	3,3	5,7	3,7	7	15	30	1,8	6	▲/△	▲/△	▲/△	▲/▲
R/L105.0150.2.6	1,5	3,3	5,7	3,7	7	15	30	1,8	6	▲/△	▲/▲	▲/△	▲/▲
R/L105.0200.2.6	2,0	3,3	5,7	3,7	7	15	30	1,8	6	▲/△	▲/▲	▲/▲	▲/▲
R/L105.0100.3.6	1,0	3,3	5,7	3,7	7	20	35	1,8	6	▲/△	▲/△	▲/△	▲/▲
R/L105.0150.3.6	1,5	3,3	5,7	3,7	7	20	35	1,8	6	▲/△	▲/△	▲/▲	▲/▲
R/L105.0200.3.6	2,0	3,3	5,7	3,7	7	20	35	1,8	6	▲/△	▲/▲	▲/△	▲/▲
R/L105.0100.4.6	1,0	3,3	5,7	3,7	7	25	40	1,8	6		▲/△	▲/△	▲/△
R/L105.0150.4.6	1,5	3,3	5,7	3,7	7	25	40	1,8	6		▲/△	▲/△	▲/▲
R/L105.0200.4.6	2,0	3,3	5,7	3,7	7	25	40	1,8	6		▲/△	▲/△	▲/▲

Проходные вставки

Schneidplatte **105**
Insert

Bohrungs-Ø ab	Bore Ø from	2,0 mm





für Klemmhalter
for Toolholder

Typ Type	H105 HC105 B105 VDI B105C B105TS IR105 962 AIH 963 N

R = rechts wie gezeichnet
R = right hand version shown

L = links spiegelbildlich
L = left hand version

Bestellnummer Part number	r	f	a	d	b	l_2	l_5	t_{max}	D_{min}	MG12	AN25	EG35	TF45	TH35	TI25	TN35
R105.4715.005.1.2	0,05	1,5	1,9	1,45	5,9	9	25	0,3	2		▲	▲				
R105.4715.005.2.2	0,05	1,5	1,9	1,45	5,9	12	30	0,3	2		▲	Δ				
R105.4713.005.1.3	0,05	1,3	2,6	2,00	5,9	10	25	0,4	3	▲	▲	▲				
R105.4713.005.2.3	0,05	1,3	2,6	2,00	5,9	15	30	0,4	3		▲	Δ				
R/L105.4719.1.4	0,15	1,9	3,7	2,90	6,4	10	25	0,6	4			Δ/Δ		▲/▲		
R/L105.4719.3.4	0,15	1,9	3,7	2,90	6,4	20	35	0,6	4	Δ/x		▲/▲	x/x	▲/▲	▲/▲	▲/▲
R/L105.4723.2.5	0,15	2,3	4,7	3,70	7,0	15	30	0,8	5			Δ/Δ		▲/▲		Δ/x
R/L105.4723.4.5	0,15	2,3	4,7	3,70	7,0	25	40	0,8	5			▲/▲		▲/▲	▲/▲	▲/▲
R/L105.4733.3.6	0,15	3,3	5,7	3,70	7,0	20	35	1,8	6			Δ/Δ		▲/▲		
R/L105.4733.5.6	0,15	3,3	5,7	3,70	7,0	30	45	1,8	6	Δ/x		▲/▲		▲/▲	Δ/Δ	▲/▲
										P	●	●	●	●	●	●

▲ ab Lager / on stock Δ 4 Wochen / 4 weeks x auf Anfrage / upon request

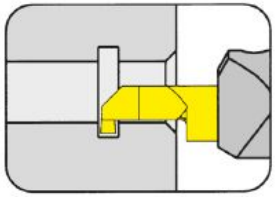
Державка для резьбовой вставки шаг 1,75 и 2,00

Einstechen und Ausdrehen
Grooving and Boring

Klemmhalter
Toolholder

B109
mit innerer Kühlmittelzufuhr
with through coolant supply

Bohrungs-Ø ab	Bore Ø from	6,0 mm
Stechtiefe bis	Depth of groove up to	2,5 mm
Stechbreite bis	Width of groove up to	2,0 mm



für Schneidplatte
for Insert

Typ 109
Type

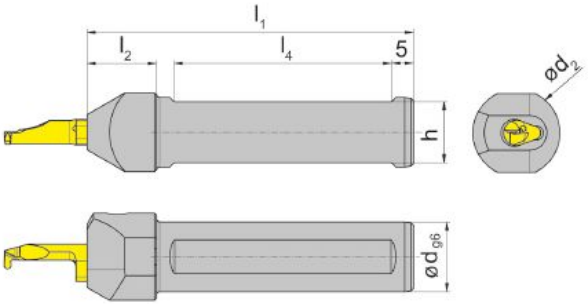


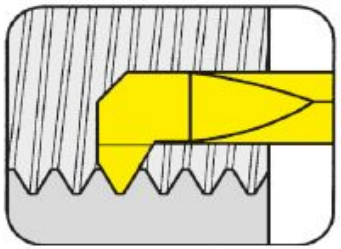
Abbildung = rechtsschneidend
Picture = right hand cutting version

Bestellnummer Part number	d	l_1	h	l_4	l_2	d_2
B109.0012.01	12	75	10	50	16	20
B109.0016.01	16	75	14	50	16	20
B109.0020.01	20	90	18	55	-	20
B109.0025.01	25	100	23	55	-	25

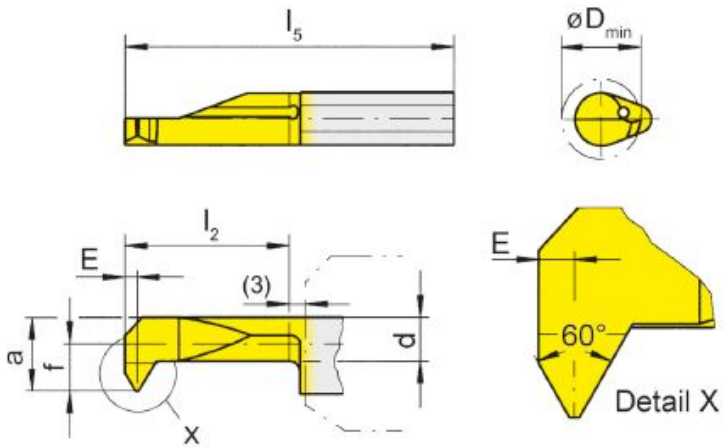
Резьбовая вставка неполного профиля шаг 1,75-2,00

Schneidplatte
Insert

109



Bohrungs-Ø ab	Bore Ø from	7 mm
Steigung	Pitch	1,5-1,75 mm



für Klemmhalter
for Toolholder

Typ B109
Type

Metrisches ISO-Gewinde
Metric ISO thread

R = rechts wie gezeichnet
R = right hand version shown

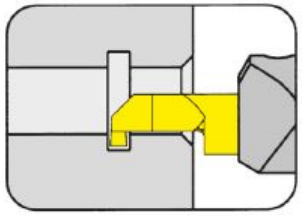
L = links spiegelbildlich
L = left hand version

Bestellnummer Part number	P	P_{max}	E	f	a	d	l_2	l_5	D_{min}	TH35
R/L109.0815.1.7	1,5	1,75	0,9	3,8	6,7	5,1	10	28	7	Δ/Δ
R/L109.0815.3.7	1,5	1,75	0,9	3,8	6,7	5,1	20	38	7	Δ/Δ
R/L109.0815.5.7	1,5	1,75	0,9	3,8	6,7	5,1	30	48	7	▲/▲

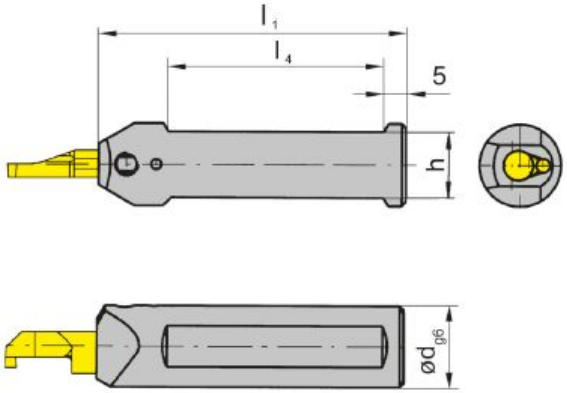
Державка для канавки 0,7 мм и как запасная для вставок B105

Klemmhalter
Toolholder

B105
mit innerer Kühlmittelzufuhr
with through coolant supply



Bohrungs-Ø ab	Bore Ø from	0,2 mm
Stechtiefe bis	Depth of groove up to	2,5 mm
Stechbreite bis	Width of groove up to	2 mm



für Schneidplatte
for Insert

Typ 105
Type

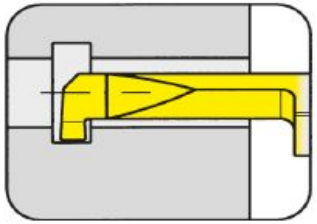
Abbildung = rechtsschneidend
Picture = right hand cutting version

Bestellnummer Part number	d	l_1	h	l_4
B105.0010.01	10	75	9	50
B105.0012.01	12	75	11	50
B105.0016.01	16	75	14	50
B105.0020.01	20	90	18	55
B105.0022.01	22	90	20	55
B105.0025.01	25	100	23	55

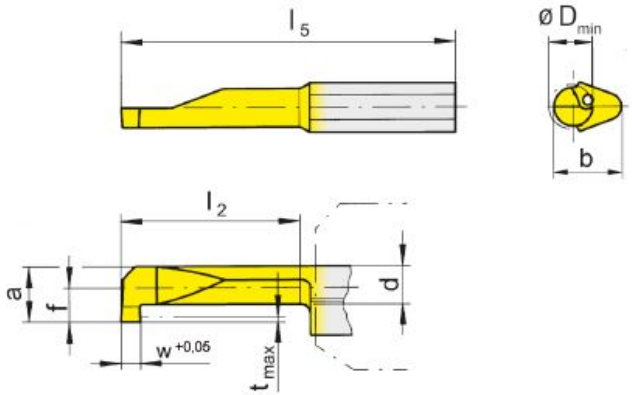
Канавка 0,7

Schneidplatte
Insert

105



Bohrungs-Ø ab Stechtiefe bis	Bore Ø from Depth of groove up to	3,0 mm 0,6 mm



für Klemmhalter
for Toolholder

Typ Type	H105 HC105 B105 VDI B105C B105TS IR105 962 AIH 963 N

R = rechts wie gezeichnet
R = right hand version shown

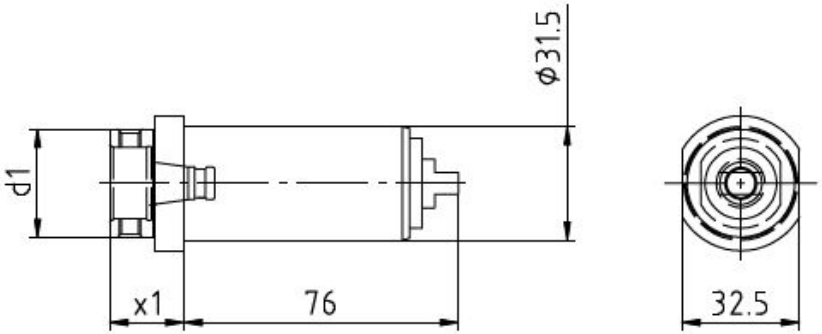
L = links spiegelbildlich
L = left hand version

Bestellnummer Part number	w	f	a	d	b	l_2	l_5	t_{max}	D_{min}	MG12	AN25	EG35	TI25
R105.0050.1.3	0,5	1,4	2,7	2,0	5,9	8	25	0,5	3		▲	Δ	
R105.0050.2.3	0,5	1,4	2,7	2,0	5,9	12	30	0,5	3	▲	▲	Δ	
R105.0050.3.3	0,5	1,4	2,7	2,0	5,9	16	35	0,5	3		▲	Δ	
R/L105.0070.1.3	0,7	1,4	2,7	1,9	5,9	8	25	0,6	3			▲/▲	▲/▲
R/L105.0070.2.3	0,7	1,4	2,7	1,9	5,9	12	30	0,6	3			▲/Δ	▲/▲
R/L105.0070.3.3	0,7	1,4	2,7	1,9	5,9	16	35	0,6	3			▲/Δ	▲/▲

DMG MORI - SPRINT

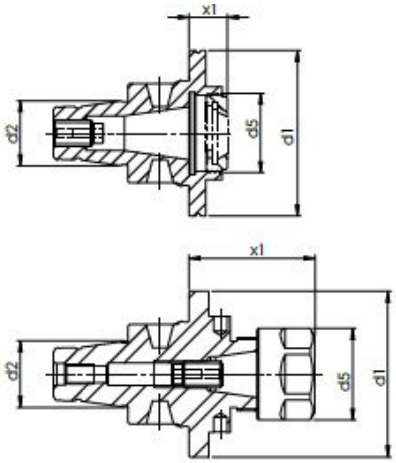
Axial Bohr- und Fräskopf
Axial drilling and milling head
Outil de perçage et de fraisage axiale

WG 35



[mm]	[mm]	Spindle Broche	[Nm]	[rpm]		Outside cooling Lubrificat. ext.	Internal cooling Lubrificat. cent.	[bar]	Order no. N° de Code
d1	**x1**	**Spindel**	**T max**	**n max**	**i**	**Aussenkühlung**	**Innenkühlung**	**p**	**Bestellnummer**
30	20,5	WFB 20-12	10	6.500	1:1				MPU.M31.B20.AA0.SP42

Passend für Maschine: suitable machines: approprié pour la machine:	Sprint 32i5 Sprint 32i8 Sprint 42 linear	Sprint 42i10 linear Speed 32i10 linear



Verwendung: Zur Aufnahme von Werkzeugen mit Zylinderschaft in Spannzangen DIN 6499.
Lieferumfang: Fräserspannfutter mit Spannmutter und Anschlagschraube.
Spannzangen: Siehe Seite 11.35

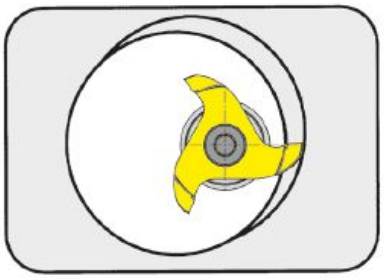
Application: To hold tools with parallel shank in collets DIN 6499
Scope of supply: Collet chucks with collet nut and adjusting screw.
Collets: See page 11.35

Application: Pour montage d'outils à queue cylindrique en pinces DIN 6499.
Livraison: Mandrins à pinces, ecrous de serrage, vis de règlage. **Pinces:** Voir page 11.35

Size Grandeur **Größe**	**Type** Type **Typ**	[mm] **d1**	[mm] **d2**	[mm] **d5**	[mm] **x1**	Order no. Nº de Code **Bestellnummer**
WFB20-12	ER20 M	30	12	28	46	WFB.220.046MINI
WFB20-12	ER20 M	30	12	28	56	WFB.220.056MINI
WFB20-12	ER20	29	12	34	36	WFB.220.036K
WFB20-12	ER25 M	30	12	35	43	WFB.225.043MINI
WFB20-12	ER25	30	12	42	43	WFB.225.043
WFB24-16	ER11 M	40	16	16	42	WFB.211.042MINI

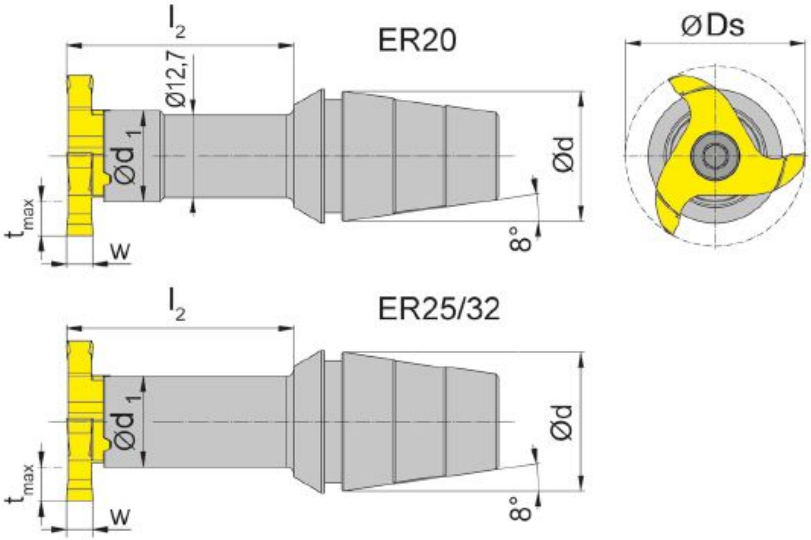
Fräserschaft
Milling shank

M328.ER



Fräserschaft für Spannzangenfutter DIN ISO 15488
Milling shanks for collet chucks DIN ISO 15488

zur Direktaufnahme für den Einsatz auf CNC-Drehmaschinen
with ER taper for CNC-lathes



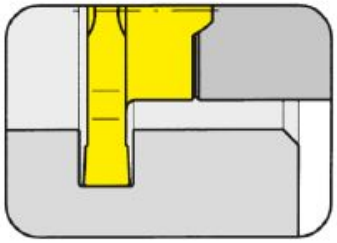
für Schneidplatte
for Insert

Typ Type	325 328 628

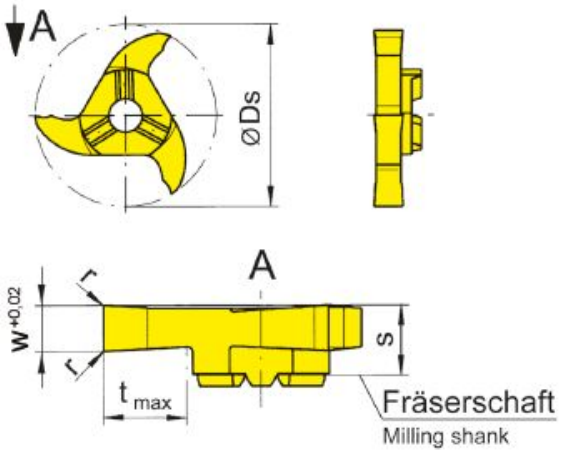
Bestellnummer Part number	d	l_2	d_1	Spannmutter Clamping nut
M328.ER20.02	20	35	14	ER20.6499/ERM20.6499
M328.ER25.02	25	35	14	ER25.6499
M328.ER32.02	32	35	14	ER32.6499

Schneidplatte
Insert

328



Nuttiefe bis	Depth of groove up to	6,5 mm
Nutbreite	Width of groove	2-10 mm
Schneidkreis-Ø	Cutting edge Ø	27,7 mm



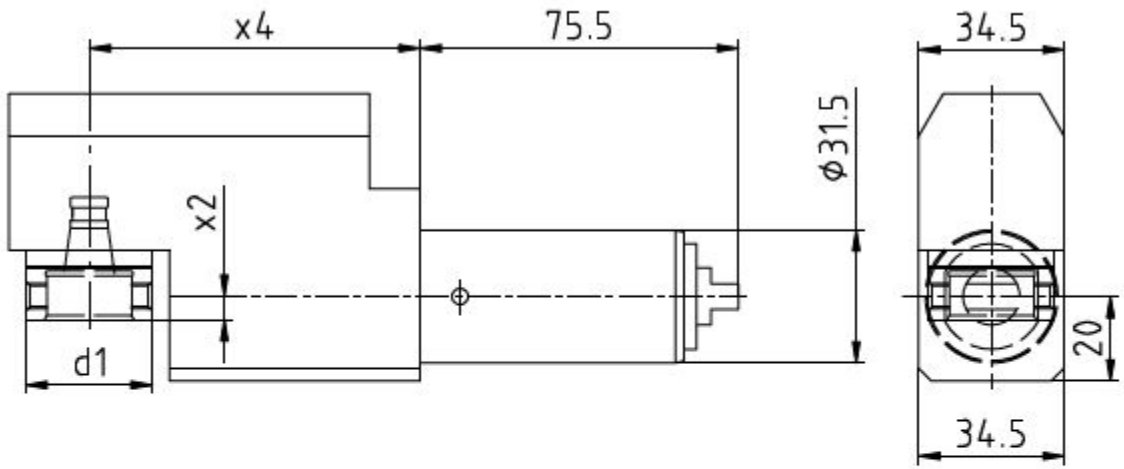
für Fräserschaft
for Milling shank

Typ	M328
Type	M328.ER
	M328.ST
	M328.M
	M332.M

Abbildung = rechtsschneidend
Picture = right hand cutting version

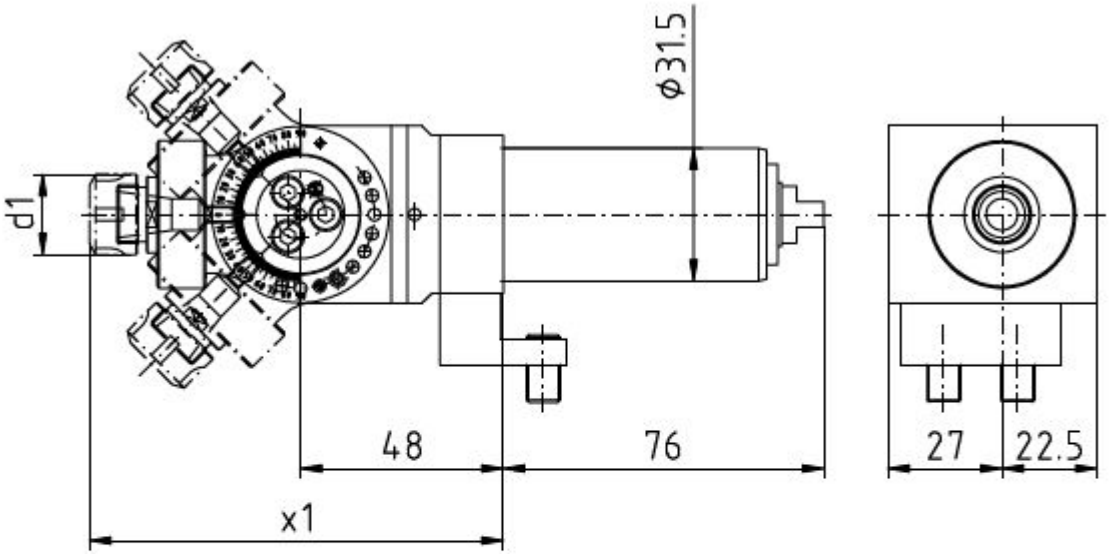
Bestellnummer Part number	Ds	t_{max}	w	s	r	Z	AS45	TN35
328.0200.00	27,7	6,5	2,0	5,7	0,2	3	▲	▲
328.0250.00	27,7	6,5	2,5	5,7	0,2	3	▲	▲
328.0300.00	27,7	6,5	3,0	5,7	0,2	3	▲	▲
328.0350.00	27,7	6,5	3,5	5,7	0,2	3	▲	▲
328.0400.00	27,7	6,5	4,0	5,7	0,2	3	▲	▲
328.0500.00	27,7	6,5	5,0	5,7	0,2	3	▲	▲
328.0600.00	27,7	6,5	6,0	7,0	0,2	3	▲	▲
328.1000.00	27,7	6,5	10,0	10,0	0,2	3	▲	▲

Дополнительная оснастка под вихревое резьбонарезние

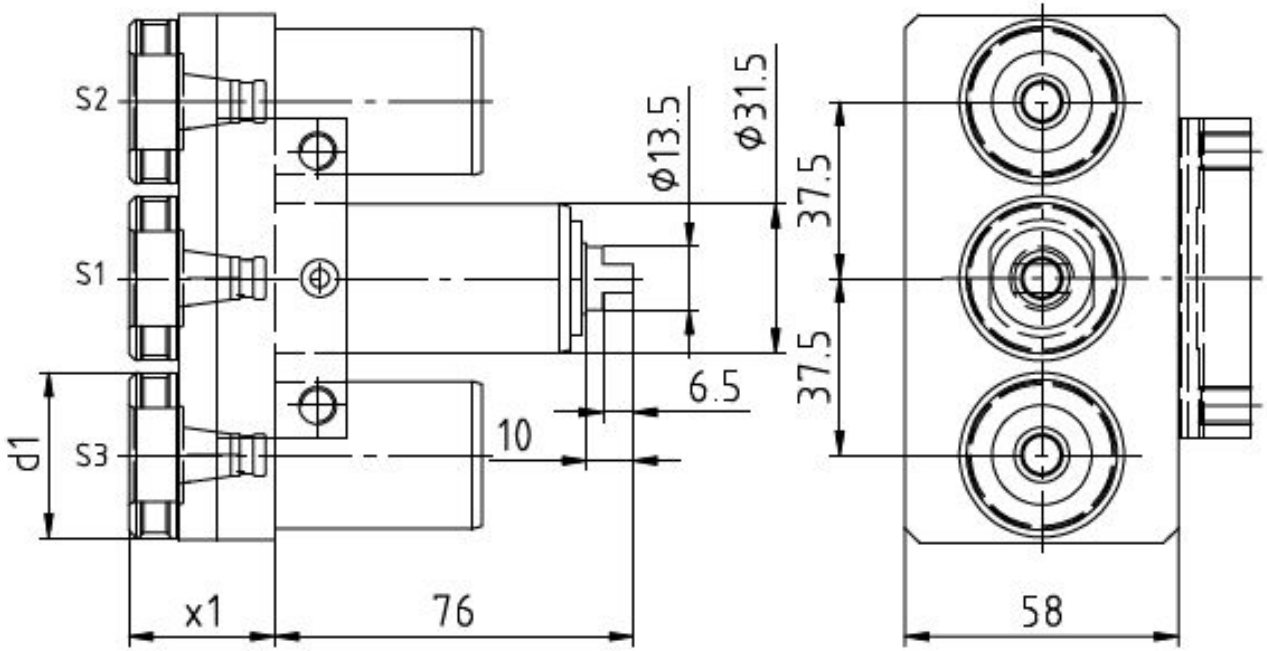


[mm]	[mm]	[mm]	Spindle Broche	[Nm]	[rpm]		Outside cooling Lubrificat. ext.	Internal cooling Lubrificat. cent.	[bar]	Order no. N° de Code
d1	**x2**	**x4**	**Spindel**	**T max**	**n max**	**i**	**Aussenkühlung**	**Innenkühlung**	**p**	**Bestellnummer**
30	5,5	78,5	WFB 20-12	3	19.500	1:3				MPU.M31.B20.ZA0.SP42RS

Поворотный блок

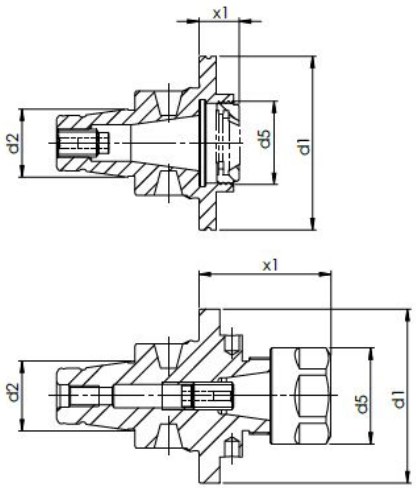


[mm]	[mm]	Spindle	[Nm]	[rpm]		Outside cooling	Internal cooling	[bar]	Order no.
		Broche				Lubrificat. ext.	Lubrificat. cent.		N° de Code
d1	**x1**	**Spindel**	**T max**	**n max**	**i**	**Aussenkühlung**	**Innenkühlung**	**p**	**Bestellnummer**
19	98	ER11	10	6.500	1:1				MPU.Z31.E11.SA0.SP42



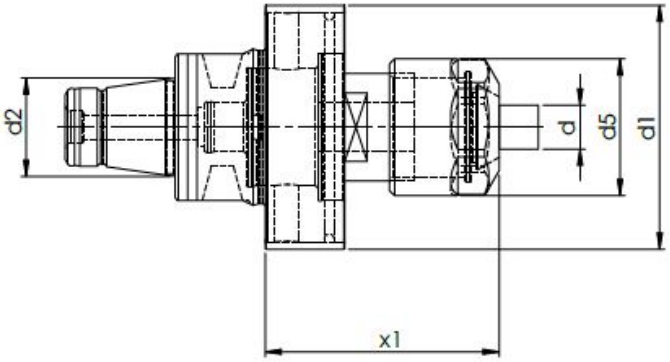
[mm]	[mm]	Spindle Broche	[Nm]	[rpm]		Outside cooling Lubrificat. ext.	Internal cooling Lubrificat. cent.	[bar]	Order no. N° de Code
d1	**x1**	**Spindel**	**T max**	**n max**	**i**	**Aussenkühlung**	**Innenkühlung**	**p**	**Bestellnummer**
35	31,5	WFB 20-12	10*	6.500*	1:1*				MPU.Z31.B20.MA0.SP42

Модульные Цанговые патроны



Size Grandeur **Größe**	**Type** Type **Typ**	[mm] **d1**	[mm] **d2**	[mm] **d5**	[mm] **x1**	Order no. N° de Code **Bestellnummer**
WFB20-12	ER8 M	30	12	12	25	WFB.208.025MINI
WFB20-12	ER8 M	30	12	12	57	WFB.208.057MINI
WFB20-12	ER11	30	12	16	25	WFB.211.025MINI
WFB20-12	ER11 A	29	12	18	10	WFB.211.A10K
WFB20-12	ER11 A	30	12	18	10	WFB.211.A10T
WFB20-12	ER11	29	12	19	25	WFB.211.025K
WFB20-12	ER11	30	12	19	25	WFB.211.025T
WFB20-12	ER11	30	12	19	45	WFB.211.045T
WFB20-12	ER16 M	30	12	22	28	WFB.216.028MINI
WFB20-12	ER16	29	12	28	28	WFB.216.028K

Модульные Цанговые патроны с подводом СОЖ



Gewindebohrer DIN374 / DIN376	Gewindebohrer DIN371	Schaft Ø D (mm)	Einstecktiefe E (mm)	Zangen-type
M6	M4	4,5	29	ER-GB
M8	M4,5 - M6	6	31	ER-GB
M10	M7	7	31	ER-GB
–	M8	8	36	ER-GB
M12	–	9	48	ER
–	M10	10	43	ER

Technische Details
Technical specifications

Spannbereich: Ø 4,5 - 10,0 mm für Gewindebohrer M4 - M12.
Range of clamping: Ø 4,5 - 10,0 mm for screw tap M4 - M12.

Längenausgleich auf Druck/Zug: 0,5 mm.
Length compensation on pressure and tension.

Kühlmitteldruck: max. 70 Bar.
Coolant pressure: max. 70 bar.

Kühlmittelzufuhr durch das Zentrum.
Coolant supply through the middle.

Size Grandeur **Größe**	**Type** Type **Typ**	[mm] **d1**	[mm] **d2**	[mm] **d5**	[mm] **x1**	Order no. N° de Code **Bestellnummer**
WFB20-12	ER11	30	12	16	32,5	WFB.G20.M8