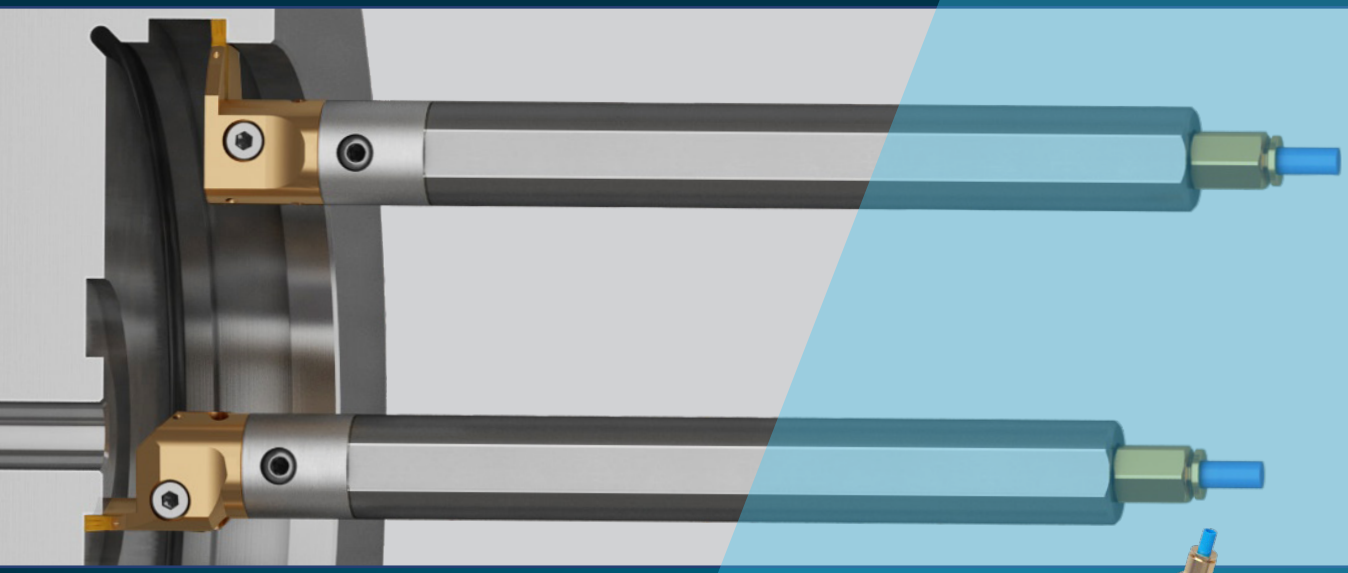
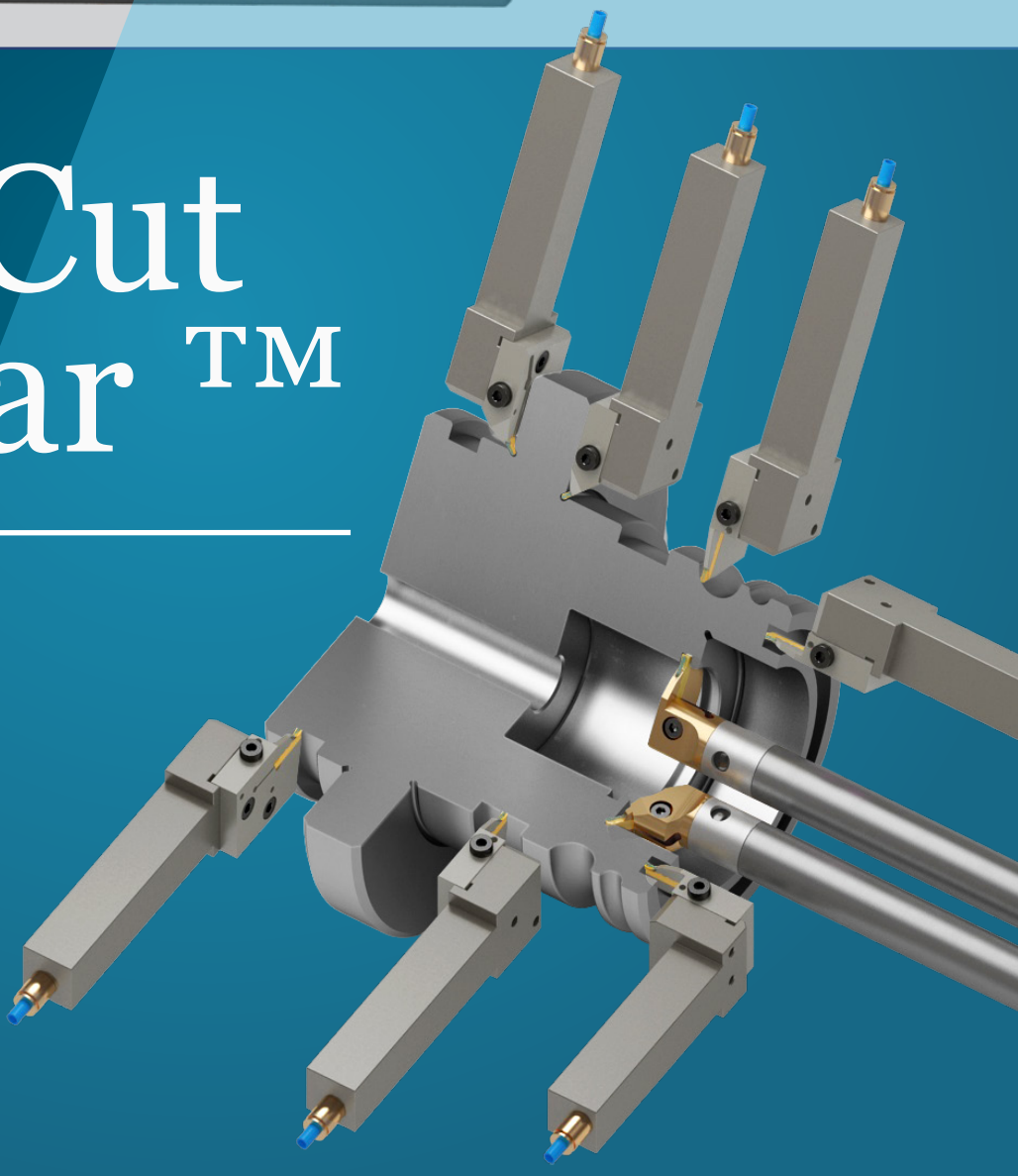
DORIAN® INTERNATIONAL TOOL



Kool Cut Modular ™



Turning, Facing & Grooving System

KOOL Cut™ Modular Turning, Facing & Grooving System-Technology

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Slot Grip Cut-off Toolholder, Blade and Insert System

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Turning & Grooving

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DNTR
Turning & Profiling

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DNTF-N
Turning & Grooving

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DNPG-N
Parting Off

Page 6

ADDN-MTR KOOL Cut™ Modular Turning and Grooving Shank, Right Hand-Straight Toolholder Style

(Inch & Metric) Page 24

ADDN-MTL KOOL Cut™ Modular Turning and Grooving Shank, Left Hand-Straight Toolholder Style

(Inch & Metric) Page 24

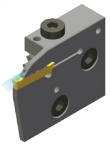
ADDN-MGR KOOL Cut™ Modular Turning and Grooving Shank, Right Hand-90° Gang Toolholder Style

(Inch & Metric) Page 25

ADDN-MGR KOOL Cut™ Modular Turning and Grooving Shank, Left Hand-90° Gang Toolholder Style

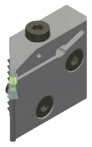
(Inch & Metric) Page 25

ADKDN-TR KOOL Cut™ Modular Turning and Grooving Cartridge, Right Hand



Page 26 - 30

ADKDN-UR KOOL Cut™ Modular 45° Grooving Cartridge, Right Hand



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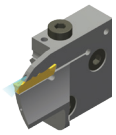
ADCDN-FR KOOL Cut™ Modular Face Grooving Cartridge, Left Hand



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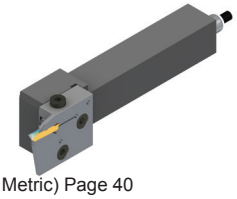
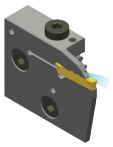
ADDN-MTR KOOL Cut™ Modular Turning and Grooving Cartridge with Right Hand-Straight Toolholder Style



(Inch & Metric) Page 40

ADKDN-TL KOOL Cut™ Modular Turning and Grooving Cartridge, Left Hand



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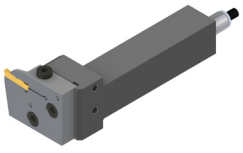
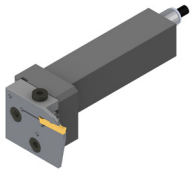
ADDN-MGR KOOL Cut™ Modular Turning and Grooving Cartridge with Right Hand-90° Gang Toolholder Style



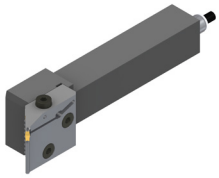
(Inch & Metric) Page 48

ADDN-MGL KOOL Cut™ Modular Turning and Grooving Cartridge with Left Hand-90° Gang Toolholder Style



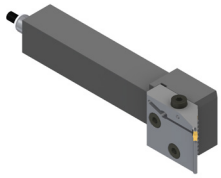
(Inch & Metric) Page 49

ADDN-MTUR KOOL Cut™ Modular 45º Grooving Cartridge with Right Hand Toolholder



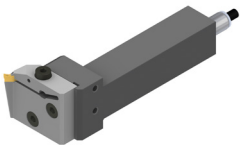
(Inch & Metric) Page 54

ADDN-MTUL KOOL Cut™ Modular 45º Grooving Cartridge with Left Hand Toolholder



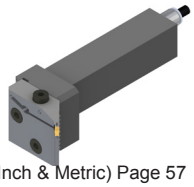
(Inch & Metric) Page 55

ADDN-MGUR KOOL Cut™ Modular 45º Grooving Cartridge with Right Hand 90º Gang Toolholder Style Shank



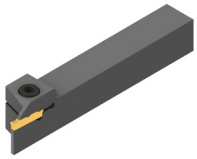
(Inch & Metric) Page 56

ADDN-MGUL KOOL Cut™ Modular 45º Grooving Cartridge with Left Hand 90º Gang Toolholder Style Shank



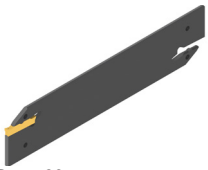
(Inch & Metric) Page 57

DETGFR/L Turning & Grooving Right Hand & Left Hand Toolholder



(Inch & Metric) Page 58

TWECOB
Twin Edge Parting Off Insert Blade



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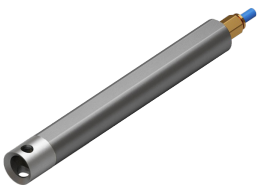
AE_MBQC KOOL Cut™
Quick Change Boring Bar Body Shank



(Inch & Metric) Page 66

DQMCH-ITR/L KOOL Cut™
Quick Change Boring and Grooving Head

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DQMCH-IUR/L KOOL Cut™
Quick Change Boring and Grooving 45º Head

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DQCNH-IFR/L KOOL Cut™
Quick Change Internal Facing and Grooving Head

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Material	Turning, Grooving & Parting Off Operation's		
	Finishing Hard & Wear Resistant	**Universal** Hard & Tough Impact & Wear Resistant	**Roughing** Tough Impact Resistant
	High Cutting Speed	Medium Cutting Speed	Low Cutting Speed

05 15 25 35 45

01 10 20 30 40 50

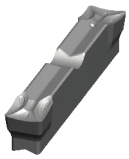
How to Choose the Best Insert for the Turning, Grooving & Parting Off Operation:

Application Peak

Application Range

Use hard & wear resistant coated insert grade with small nose radius, sharp to light honed cutting edge and small chip breaker. **Cut at a high SFM** with a small Depth of Cut (ap) and Feed Rate per Rev. (fn).
Use a tough and wear resistant grade with a medium nose radius, honed cutting edge and medium chip breaker. **Cut at a medium SFM** with a medium Depth of Cut (ap) and Feed Rate per Rev. (fn).
Use Tough coated insert grade with large nose radius, heavy honed cutting edge and large chip breaker.
Cut at a low SFM with a large Depth of Cut (ap) and high Feed Rate per Rev. (fn)

Material	Grade Specifications			Speeds and Feeds					
	Coating	ISO Grade	ANSI Grade	Carbon & Alloy Steel	Stainless Steel	Cast Iron	Aluminum & Non Ferrous	High Temp Alloy	Hardened Steel
				P	M	K	N	S	H
P Carbon & Alloy Steel	PVD TiAlN/WC/C	P30-M45 M15-M30 K15-K30	C5	Inch sfm					
DPP35RT				264- 267	99-644	198-723			
				Metric m/Min					
				80- 190	99-644	60-219			
N Aluminum & Non Ferrous	None	K15 P10 M15 N15 S15	C2-C3	Inch sfm					
DNU10GT					92.4-545	149-627	485-6355	40-290	36-69
				Metric m/Min					
					28-165	45-190	147-1925	12-88	11-21
S High Temp Alloy	PVD AlCrN	P15-P30 M10-M25 K10-K25 N10-N25	C3-C8	Inch sfm					
DUP15VT				613.8-1871	178-1023	347-1043		46-462	79-135
				Metric m/Min					
				186-567	54-310	105-316		14-140	24-41



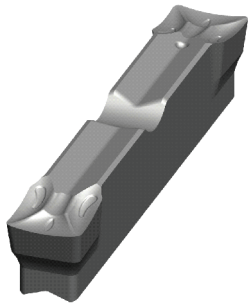
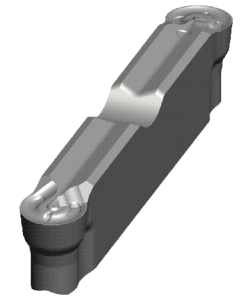
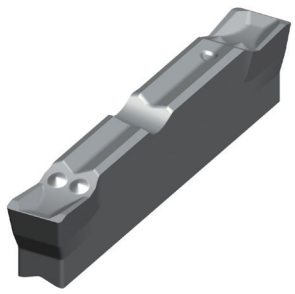
Turning, Grooving & Parting Off Insert Identification System

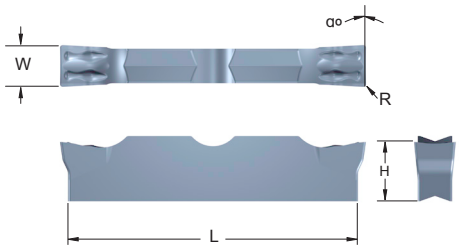
Insert Description Ex:

DNTQ-254004-3EU-N-DPP35RT

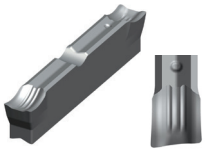
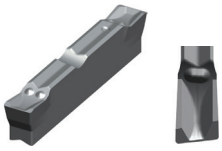
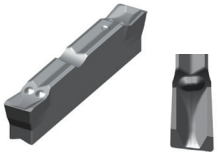
DN	T	Q	254004	3	E	U	N	DPP35RT

Insert Type	Insert Applications			Cutting Geometry				Insert Size			Material Application								Edge Preparation			Insert Operation			Cutting Direction			Insert Grade
											1			2				3										
DN	F	T	P	F	G	Q	R	L	W	R	P	M	K	M	N	S	H	U	F	E	S	F	U	R	N	R	L	
Double Cutting Edge Notched	Face Groove	Turning, Facing & Grooving	Part-Off	High Positive Rake Turning & Grooving	Negative Rake Part-Off	Universal Turning & Grooving	Radius Turning & Grooving	Insert length in Millimeter	Insert Width in Millimeter	Insert Radius in Millimeter	Carbon & Alloy Steel	Stainless Steel	Cast Iron	Stainless Steel	Aluminum and non Ferrous	High Temp Alloyed	Hardened Material	Multi Material	"F" Sharp	Honed "E+" Medium	Neg. Land & Honed Heavy Duty	Finish	Universal	Roughing	Neutral	Right Hand	Left Hand	DPP35RT DNU10GT DUP15VT

Insert	Operation	Material Application (☻ First Choice, ☺ Second Choice)
DNTQ-N Turning & Grooving 	**For Universal Turning, Face Grooving** For High Performance in Turning and Grooving Applications **No Pull-Out Safety Notch** No pull out from the Toolholder in grooving and Cut-Of operation **3 Cutting Edge** Bi-directional, Right and Left Hand Turning, and Face Grooving **3 Side Chip Control** The chip will break on turning and roll on grooving **Operations** Best for Turning, Face Grooving	Carbon Steel, Alloy Steel ☻ Stainless Steel ☻ Cast Iron ☻ Aluminum, Plastic and Non Ferrous Material ☻ High Temp Alloy ☻
DNTR Turning & Profiling 	**For Precision Turning, Grooving** Parting Off For High Performance in Turning and Grooving Applications **No Pull-Out Safety Notch** No pull out from the Toolholder in grooving and Parting Off operation **Round Cutting Edge** Bi-directional, Right and Left Hand Turning, and Face Grooving **Circular Chip Control** Good Chip Control in turning and grooving **Operations** Best for Turning, Profiling, Facing, Grooving and Under-Cut	Carbon Steel, Alloy Steel ☻ Stainless Steel ☻ Cast Iron ☻ Aluminum, Plastic and Non Ferrous Material ☻ High Temp Alloy ☻
DNTF-N Turning & Grooving 	**For Precision Turning, Grooving** Parting Off For High Performance in Turning and Grooving Applications **No Pull-Out Safety Notch** No pull out from the Toolholder in grooving and Parting Off operation **3 Sides Low Force Cutting Edge** Bi-directional, Right and Left Hand Turning, and Face Grooving **3 Side Chip Control** High Positive Rake Angle for Free Chip Flow and Low Edge Built-Up **Operations** Best for Precision Turning, Grooving and Cut-Off, Soft Materials and Thin Wall Tubing	Carbon Steel, Alloy Steel ☺ Stainless Steel ☻ Cast Iron ☺ Aluminum, Plastic and Non Ferrous Material ☻ High Temp Alloy ☻
DNPG-N Parting Off 	**For Grooving and Parting Off Applications** Strong Cutting Edge, for Grooving and Parting Off Application **No Pull-Out Safety Notch** No pull out from the Toolholder in grooving and Parting Off operation **Negative Rake Angle with Controlled Chipbreaker** High Performance and Good Chip Control in High Cutting Speed and Feed Rate **Operations** Best for Deep Grooving, and Parting Off large Diameter work pieces	Carbon Steel, Alloy Steel ☻ Stainless Steel ☻ Cast Iron ☻ Aluminum, Plastic and Non Ferrous Material High Temp Alloy



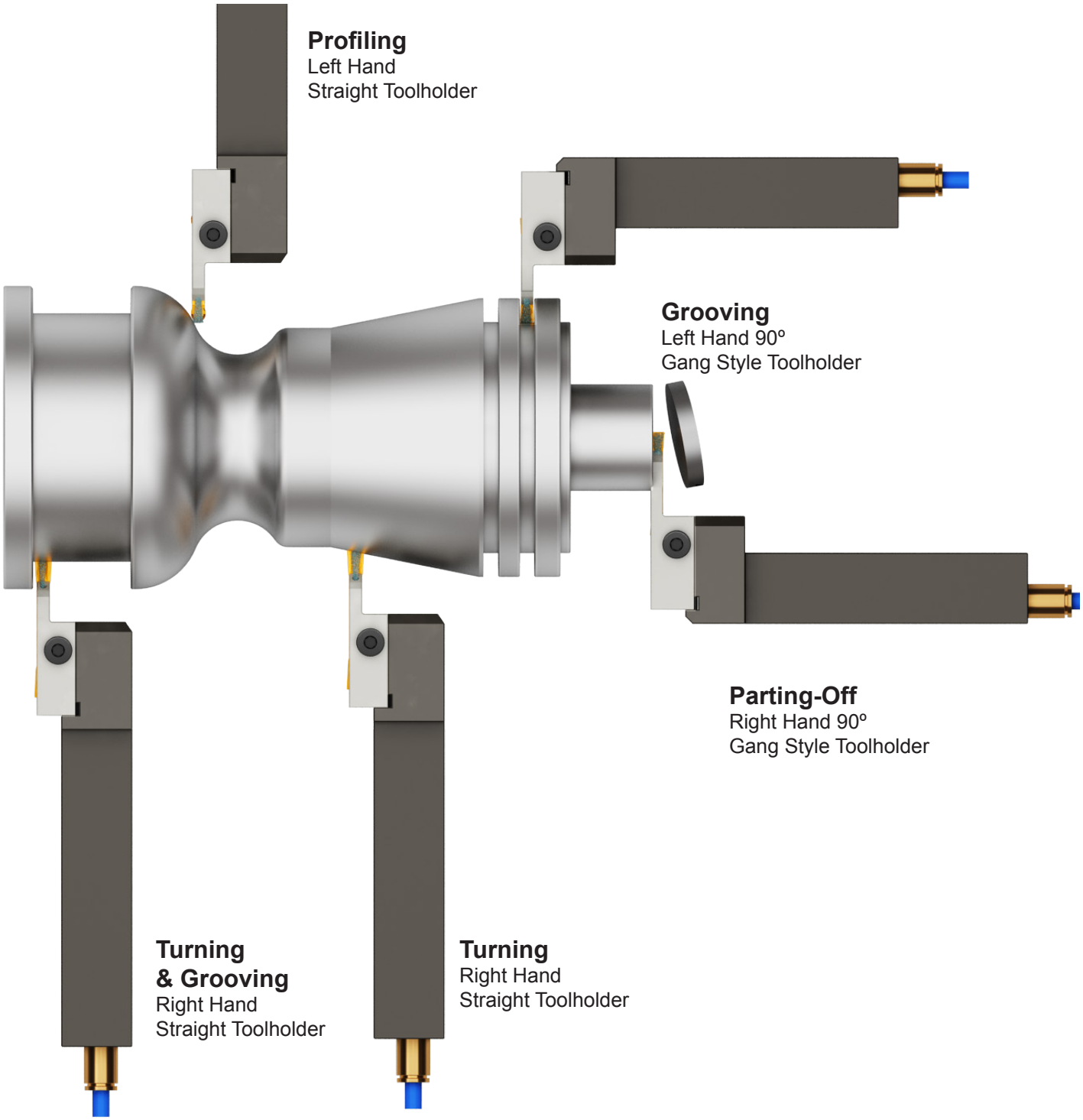
	Material	Carbon & Alloy Steel	300 & 400 Series Stainless Steel	Cast Iron, Copper/Brass	Aluminum	High Temp Alloys	Hard Steel to 58 HRC	Carbon & Alloy Steel	300 & 400 Series Stainless Steel	Cast Iron, Copper/Brass	Non Ferrous Metals & Materials	High Temp Alloys,	Hard Steel to 58 HRC
	ISO	P35			K15 N15			K10 P15 M15					
	Insert Coating	PVD TiAN/WC/W			Uncoated			PVD AlCrN					
	Insert Grade	DPP35RT			DNU10GT			DUP15VT					

Insert Style		Insert Grade	Dimensions							
Description		ISO	L	W	R	H	α°	Upc 733101-	Upc 733101-	Upc 733101-
DNTQ-N Neutral		DNTQ-222002-3EU-N	22.0	2.0	0.2	4.5		82440	82446	82452
		DNTQ-222502-3EU-N	22.0	2.5	0.2	4.5		82441	82447	82453
		DNTQ-223003-3EU-N	22.0	3.0	0.3	4.5		82442	82448	82454
		DNTQ-254004-3EU-N	25.0	4.0	0.4	4.8		82443	82449	82455
		DNTQ-255004-3EU-N	25.0	5.0	0.4	5.0		82444	82450	82456
		DNTQ-256004-3EU-N	25.0	6.0	0.4	5.0		82445	82451	82457
DNTR-N Neutral		DNTR-220210-3EU-N	22.0	2.0	1.0	4.5		82458	82463	82468
		DNTR-223015-3EU-N	22.0	3.0	1.5	4.5		82459	82464	82469
		DNTR-254020-3EU-N	25.0	4.0	2.0	4.8		82460	82465	82470
		DNTR-255025-3EU-N	25.0	5.0	2.5	5.0		82461	82466	82471
		DNTR-256030-3EU-N	25.0	6.0	3.0	5.3		82462	82467	82472
DNTF-N Neutral		DNTF-222002-2EF-N	22.0	2.0	0.2	4.5			82473	82477
		DNTF-222502-2EF-N	22.0	2.5	0.2	4.5			82474	82478
		DNTF-223002-2EF-N	22.0	3.0	0.2	4.5			82475	82479
		DNTF-254003-2EF-N	25.0	4.0	0.3	4.8			82476	82480
DNTF-R Right Hand		DNTF-222002-2EF-R	22.0	2.0	0.2	4.5	6°		82481	82484
		DNTF-223002-2EF-R	22.0	3.0	0.12	4.5	6°		82482	82485
		DNTF-254003-2EF-R	25.0	4.0	0.13	4.8	4°		82483	82486
DNTF-L Left Hand		DNTF-222002-2EF-L	22.0	2.0	0.2	4.5	6°		82487	82490
		DNTF-223002-2EF-L	22.0	3.0	0.12	4.5	6°		82488	82491
		DNTF-254003-2EF-L	25.0	4.0	0.13	4.8	4°		82489	82492
DNPG-N Neutral		DNPG-222002-1SR-N	22.0	2.0	0.2	4.5		82493		
		DNPG-223002-1SR-N	22.0	3.0	0.2	4.5		82494		
		DNPG-254003-1SR-N	25.0	4.0	0.3	4.8		82495		
DNPG-R Right Hand		DNPG-222002-1SR-R	22.0	2.0	0.2	4.5	6°	82496		
		DNPG-223002-1SR-R	22.0	3.0	0.12	4.5	6°	82497		
		DNPG-254003-1SR-R	25.0	4.0	0.13	4.8	4°	82498		
DNPG-L Left Hand		DNPG-222002-1SR-L	22.0	2.0	0.2	4.5	6°	82499		
		DNPG-223002-1SR-L	22.0	3.0	0.12	4.5	6°	82500		
		DNPG-254003-1SR-L	25.0	4.0	0.13	4.8	4°	82501		

The KOOL Cut™

Modular Turning and Grooving System

Expands the Flexibility of Multi-Operations
with the Combination of
Shanks Sizes & Cartridge Styles



Profiling
Left Hand
Straight Toolholder

Grooving
Left Hand 90°
Gang Style Toolholder

Parting-Off
Right Hand 90°
Gang Style Toolholder

Turning
& Grooving
Right Hand
Straight Toolholder

Turning
Right Hand
Straight Toolholder

The KOOL Cut™

Modular Turning and Grooving System

Built for Productivity!
Interchangeable Shanks Sizes & Cartridge Styles

- Rigidity
- Flexibility
- Precision
- Interchangeability
- Advanced Technology
- Repeatability
- Multi-Operation
- High Performance

KOOL Cut™ Modular Toolholder Shank

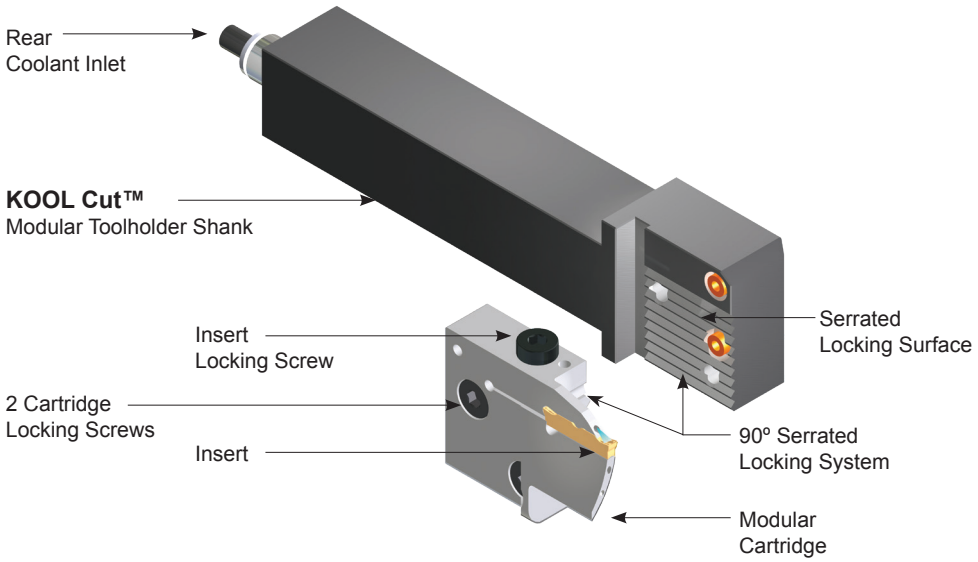
The 90° serrated wall of the Shank allows the cartridge to be locked on, with precise and repetitive accuracy, and rigidity.

Straight Toolholder Style
90° Gang Toolholder Style

3 Inch Sizes; 3/4", 1.0", 1 1/4"
3 Metric Sizes; 20mm, 25mm, 32mm

2 Cutting Direction Style:
Right Hand and Left Hand

Double Jet Coolant Inlet:
Rear Inlet and Bottom Inlet



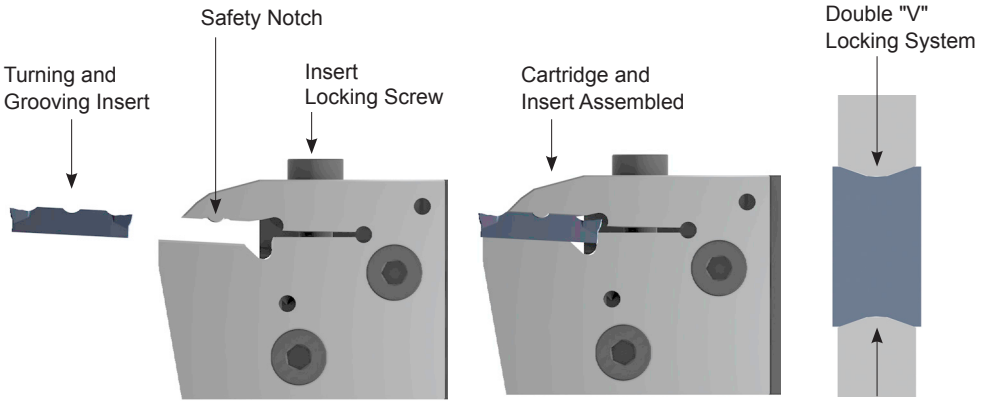
KOOL Cut™ Modular Cartridge

with the Double Jet-Coolant System Every Cartridge, fits to any Toolholder size and style

The 90° serrated wall of the Cartridge, will lock onto the toolholder shank with precise and repetitive accuracy, and rigidity

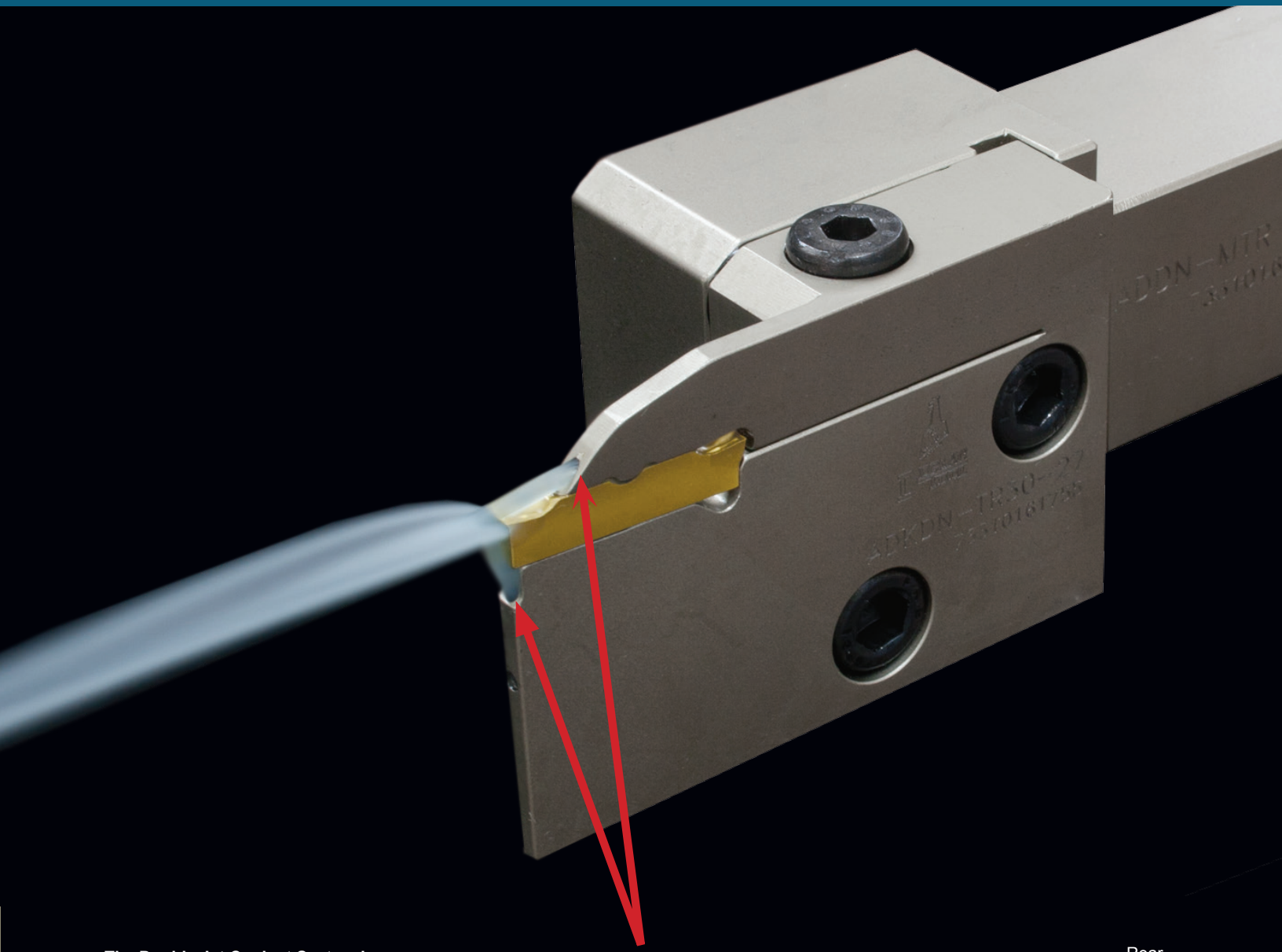
3 Cartridge Styles:
Turning and Grooving
Facing and Grooving
45° Grooving

"Safety Notch" Insert Locking System: The locking Insert Prong has a built-in Safety Notch that fits to the Notched Insert. The Safety Notch, will assure that the insert is not pulled out from the toolholder during the grooving and cut-off operation.



KOOL Cut™ Modular Shank and Cartridge Assembly:

The 90° serrated walls of the Toolholder Shank and the Cartridge, are locked together with precise and repetitive accuracy, and rigidity as a single unit. Two (2) 6mm cap screws, locks the 2 units together, allowing simple and easy replacement of cartridges.



Double Jet Coolant System

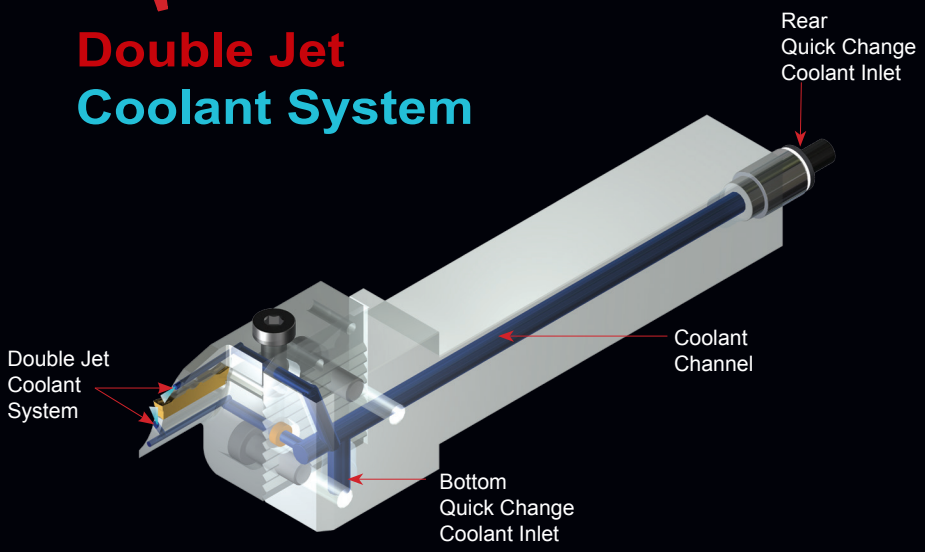
The Double Jet Coolant System is Designed with the coolant exiting from 2 outlets, above and below the insert cutting edge.

Above the insert cutting edge, the coolant is aimed precisely between the cutting edge of the insert and the chip.

Below the insert cutting edge, the coolant is aimed under the insert cutting edge and the workpiece surface.

With the combination of the 2 Coolant Jets, the friction of the cutting edge is reduced, the insert cutting edge is kept clean and at a constant temperature, reducing edge wear and chipping.

Consequently, the surface finish, work quality and tolerances are improved and the life of the insert is extended up to 100% over the conventional coolant system.



Left Hand Straight Toolholder Style
KOOL Cut™ Modular

Turning, Facing & Grooving
Shank and Cartridges

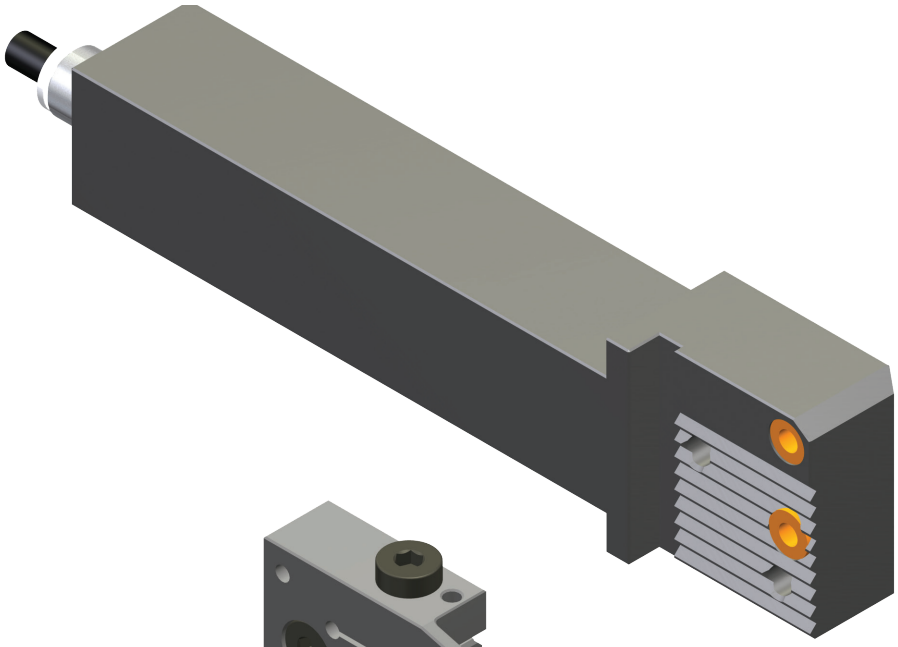
ADDN-MTL_
Left Hand Straight Toolholder Style
Modular Shank
(Page F-14)

For

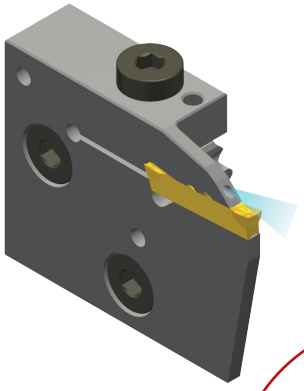
ADKDN-TL_
Left Hand Turning & Grooving Cartridge
(Page F-21)

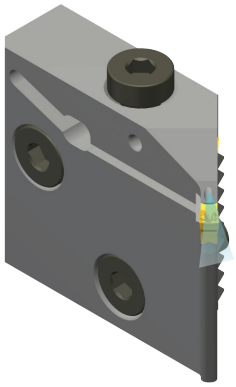
ADKDN-UL_
Left Hand 45 ° Grooving Cartridge
(Page F-21)

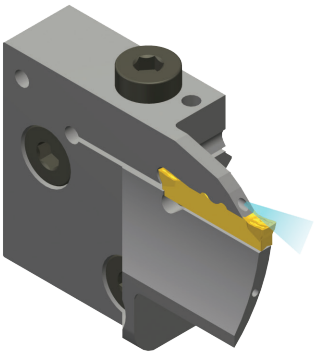
ADCDN-FL_
Left Hand Facing & Grooving Cartridge
(Page F-22, F-24, F-26, F-28)

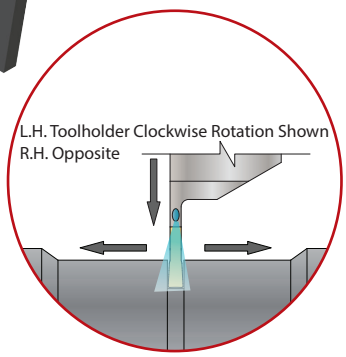


ADDN-MTL_

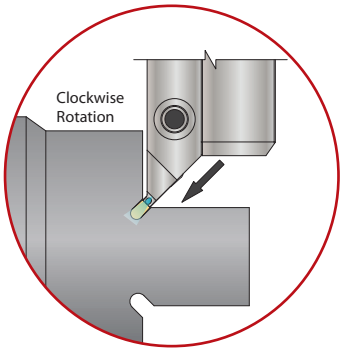




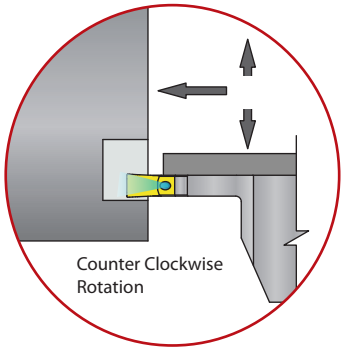




ADKDN-TL_



ADKDN-UL_

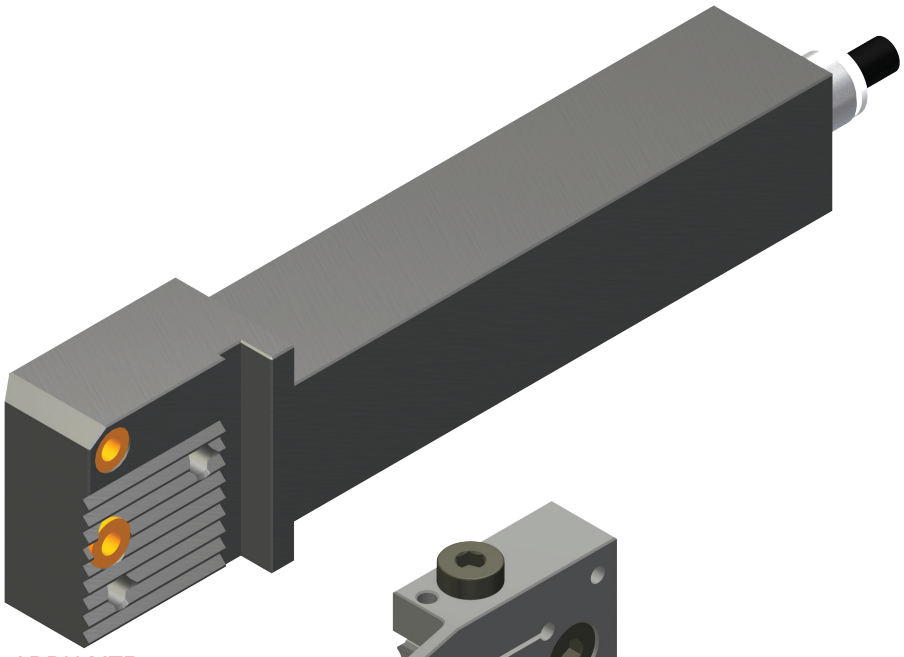


ADCDN-FL_

Note: The cartridges listed above will only work with the ADDN-MTL_ Left Hand Toolholder Style Modular Shank.

Right Hand Straight Toolholder Style KOOL Cut™ Modular

Turning, Facing & Grooving
Shank and Cartridges



ADDN-MTR_

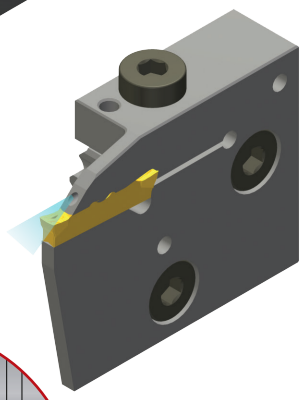
ADDN-MTR_
Right Hand Straight Toolholder Style
Modular Shank
(Page F-14)

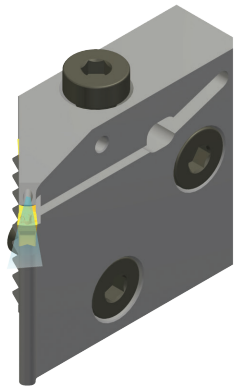
For

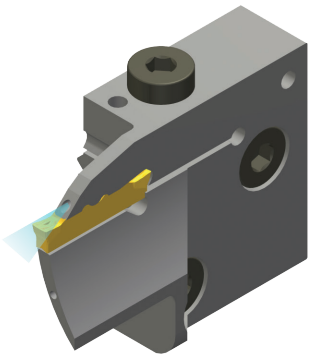
ADKDN-TR_
Right Hand Turning & Grooving Cartridge
(Page F-21)

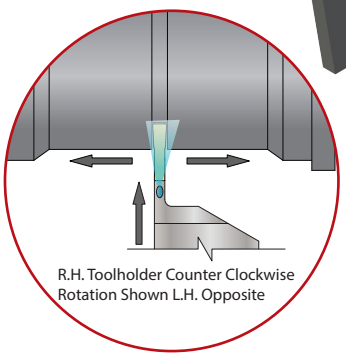
ADKDN-UR_
Right Hand 45 ° Grooving Cartridge
(Page F-21)

ADCDN-FR_
Right Hand Facing & Grooving Cartridge
(Page F-23, F-25, F-27, F-29)

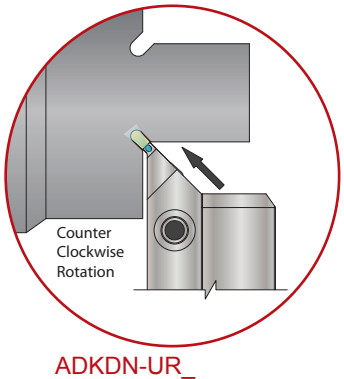




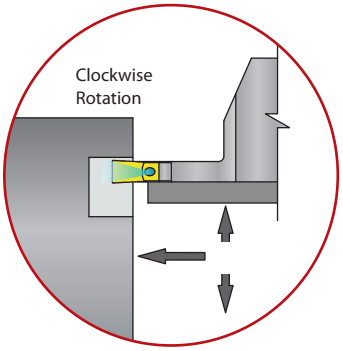




ADKDN-TR_



ADKDN-UR_



ADCDN-FR_

Note: The cartridges listed above will only work with the ADDN-MTR_ Right Hand Toolholder Style Modular Shank.

Left Hand 90º Gang Toolholder Style
KOOL Cut™ Modular
Turning, Facing & Grooving
Shank and Cartridges

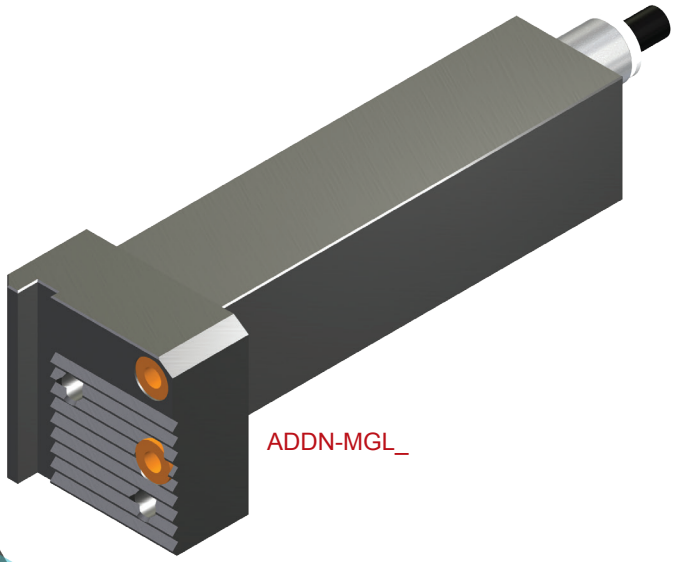
ADDN-MGL_
Left Hand
90º Gang Toolholder Style
Modular Shank
(Page F-15)

For

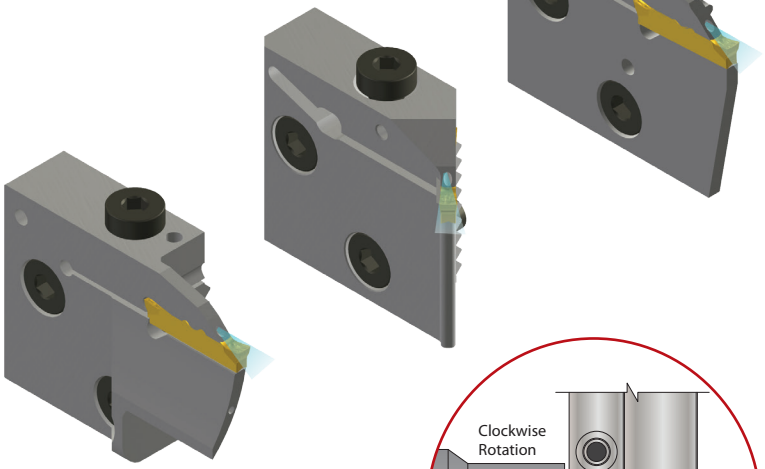
ADKDN-TL_
Left Hand
45 º Grooving Cartridge
(Page F-16 - F-20)

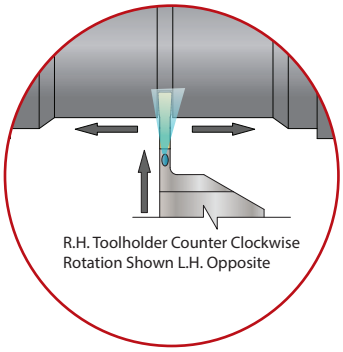
ADKDN-UL_
Left Hand
Turning & Grooving Cartridge
(Page F-21)

ADCDN-FL_
Left Hand
Facing & Grooving Cartridge
(Page F-22, F-24, F-26, F-28)

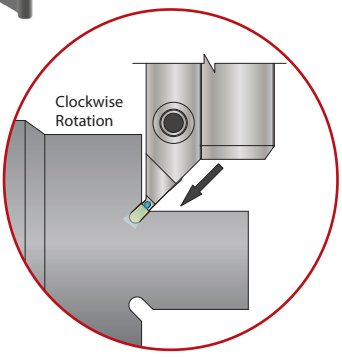


ADDN-MGL_

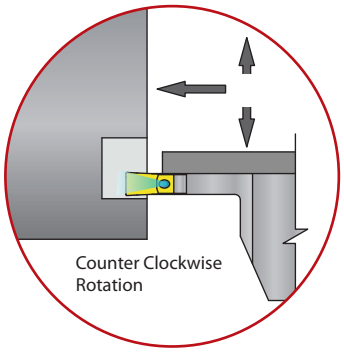




ADKDN-TL_



ADKDN-UL_



ADCDN-FL_

Note: The cartridges listed above will only work with the ADDN-MGL_ Left Hand 90º Gang Toolholder Style Modular Shank.

Right Hand 90º Gang Toolholder Style KOOL Cut™ Modular

Turning, Facing & Grooving
Shank and Cartridges

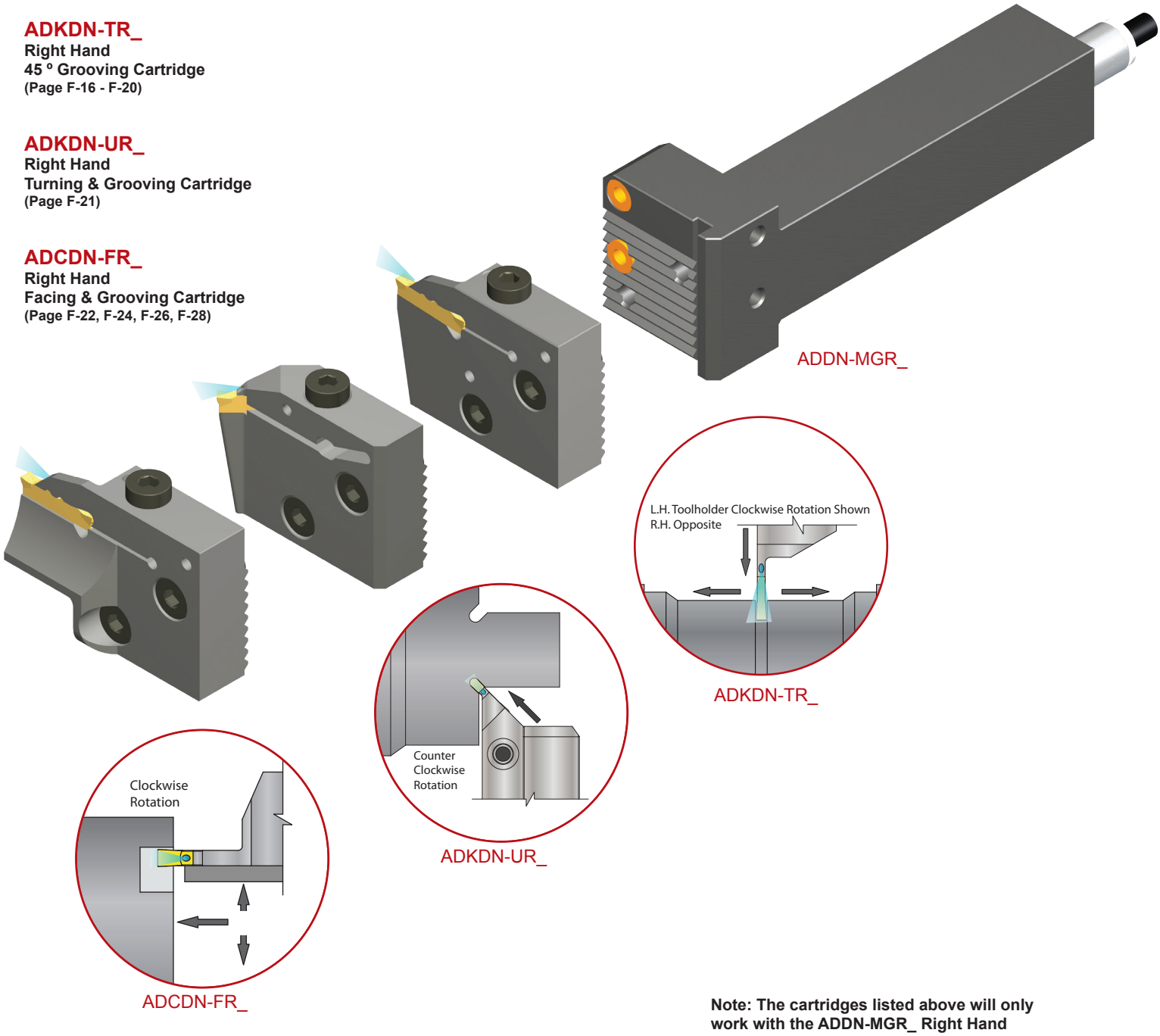
ADDN-MGR_
Right Hand
90º Gang Toolholder Style
Modular Shank
(Page F-15)

For

ADKDN-TR_
Right Hand
45 º Grooving Cartridge
(Page F-16 - F-20)

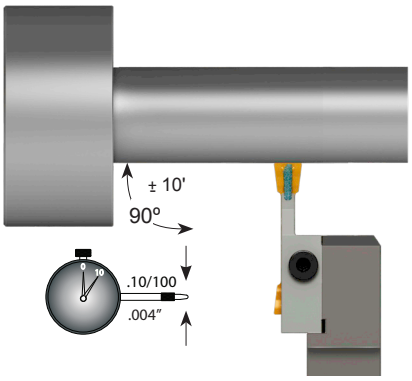
ADKDN-UR_
Right Hand
Turning & Grooving Cartridge
(Page F-21)

ADCDN-FR_
Right Hand
Facing & Grooving Cartridge
(Page F-22, F-24, F-26, F-28)



Note: The cartridges listed above will only work with the ADDN-MGR_ Right Hand 90º Gang Toolholder Style Modular Shank.

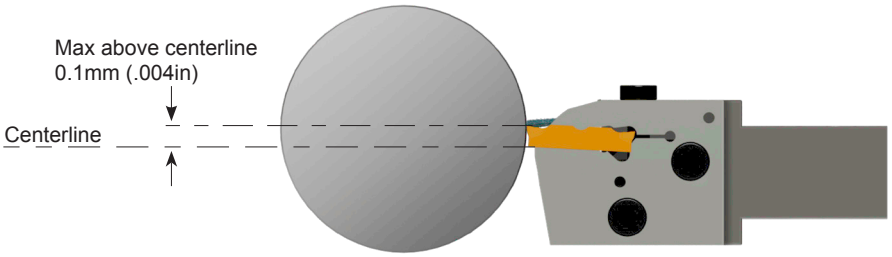
Tool Set-Up



Set the toolholder to be set-up square and perpendicular to the workpiece.

For best turning and grooving performance, surface finish and a straight and square face, the toolholder must be positioned at 90° within ± 10'

Tool Center Height

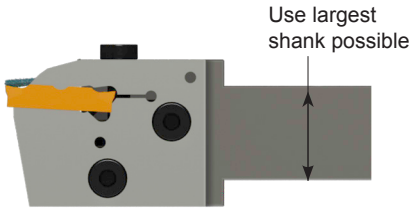


The cutting edge of the insert, should never be under the center line.

The if the insert is under the center line, it will cause vibration and cutting edge chipping.

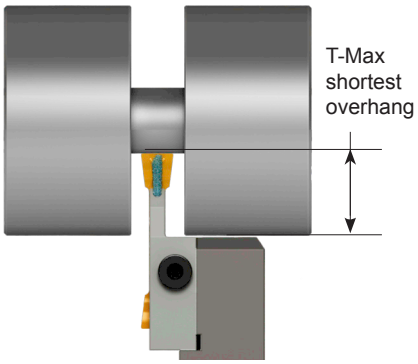
For best results set the insert .004" (0.1mm) above the center line.

Shank Size



For best turning and grooving performance, select a toolholder with the largest shank permissible, to eleminate chatter and provide rigidity.

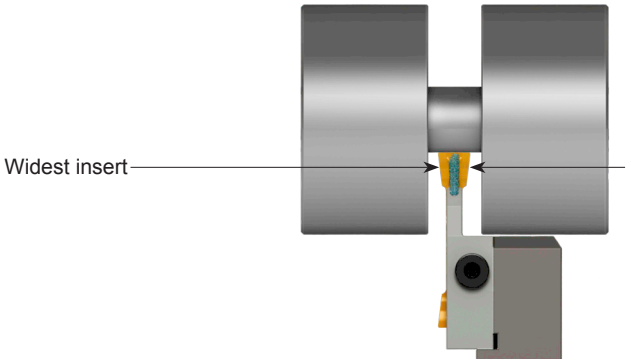
Extended "T" Depth of Cut



In Turning and grooving, rigidity is critical to achieve best cutting performance, surface finish, close tolerance and insert life.

When choosing the toolholder, always use the shortest "T" overhang possible, to avoid deflection under the cutting pressure.

Insert Width

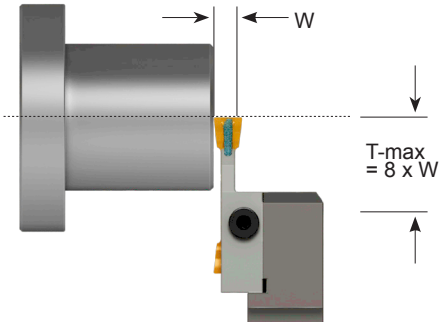


To maximize performance in turning and grooving operations choose the widest insert permissible.

A wide insert will not deflect under cutting pressure, allowing larger depth of cut, better surface finish and close tolerances.

Max.Grooving Depth

T-max



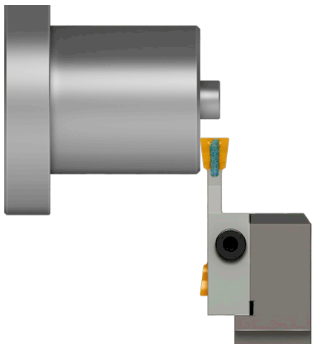
In Grooving and Parting-Off operation, for optimum results, the maximum grooving depth is directly related to the width and the geometry of the insert cutting edge.

T= For Straight Insert Cutting Edge, 8 x W (insert width)

T= For Angled Insert Cutting Edge, 6 x W (insert width)

Cutting Speed

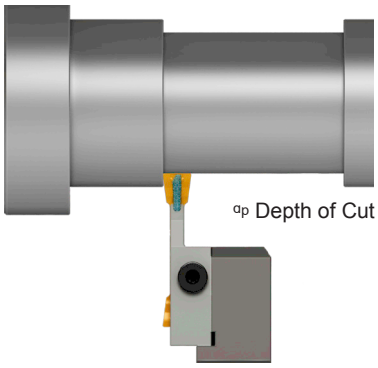
Vc



For a good surface finish, straight face and long insert life, a constant Vc must be applied, meaning as the insert approaches the center of the work piece, RPM must increase.

Depth of Cut

a_p



For best turning performance, chip control, and insert life under the best cutting condition with the shortest overhang, the depth of cut is not to exceed 50% of the width of the insert.

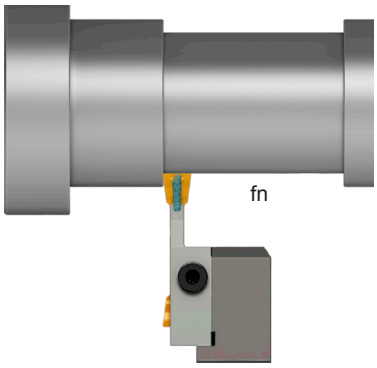
For Example:

5mm Insert	Max Depth of Cut 2.5mm
.200" Insert	Max Depth of .100"

Reduce the depth of cut with extended overhang. Vibration, insert chipping and toolholder breakage may result from an over extended tool.

Feed Rate

fn



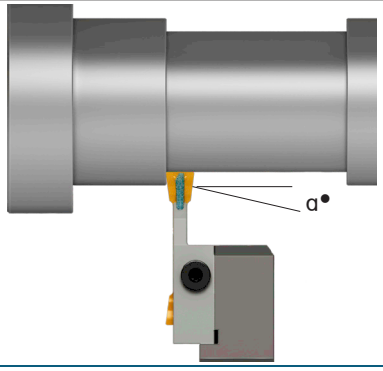
For best turning performance, chip control, and insert life under the best cutting condition with the shortest overhang, the feed rate is not to exceed 1/2 of the insert radius.

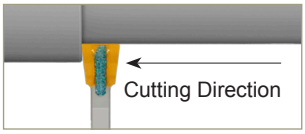
For Example:

.5mm Insert Radius	Max. Feed Rate of .25mm/rev
.020" Insert Radius	Max. Feed Rate of .010"/rev

Reduce the feed rate, with extended overhang. Vibration, insert chipping and toolholder breakage may result from an over extended tool.

Wiper

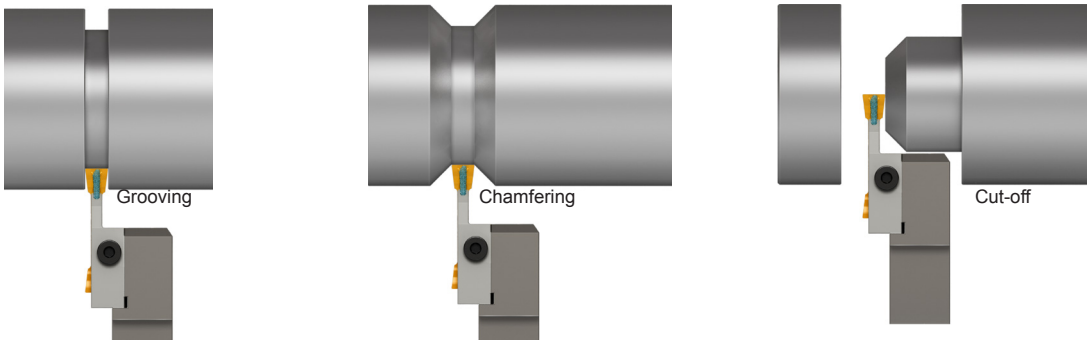




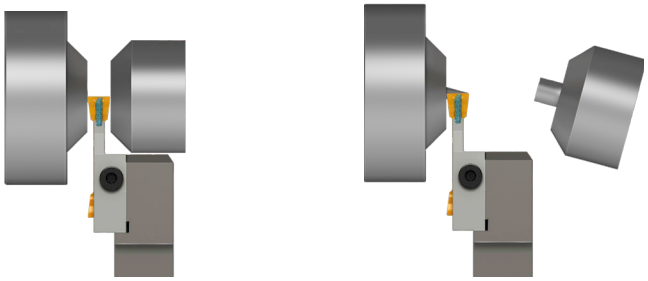
Under cutting pressure, the insert is pushed away from the cutting direction creating a relief angle on trailing side of the insert. This angle creates a Wiper action, resulting in a good surface finish.

The Wiper angle can be controlled with feed rate and depth of cut.

Multiple Operation



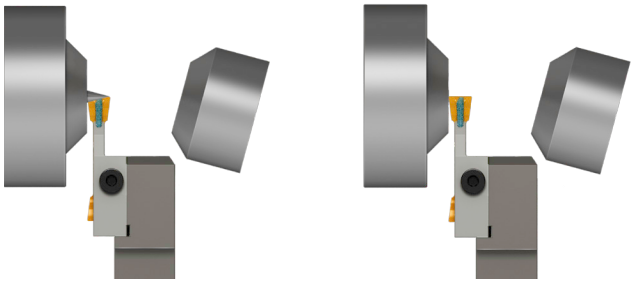
Straight Cutting Edge Insert



Use Turning and Grooving insert, with Straight Cutting Edge for fast material removal, good surface finish, deep grooving, parting-off and facing.

However, a second operation is required to remove the center tip of the workpiece when cut-off.

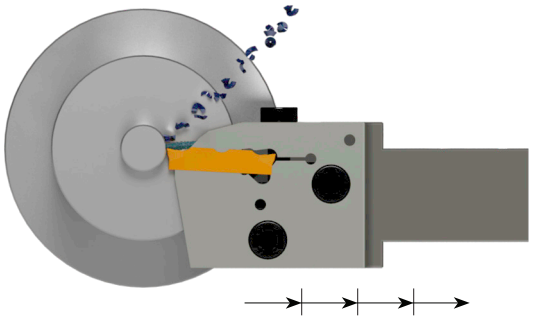
Angled Cutting Edge Face



Use Turning and Grooving insert, with Angled Cutting Edge to reduce the formation of center tip of workpiece when part-off eliminating the a secondary operations to remove the center tip.

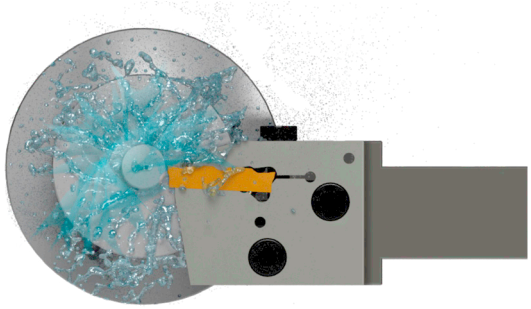
However to avoid tapered face and rough surface finish Vc and fn, has to be reduced 20% to 30% compared to full face insert.

Pecking



When machining deep groove or parting large diameter above 8 times the width of the insert, it is a good practice to use pecking method to achieve a better swarf control and avoid clogging of the groove (major cause of premature insert failure.)

Coolant



The use of coolant in turning and grooving operations is critical to achieve best performance in quality, surface finish, and insert life. High pressure coolant is recommended to cool the insert cutting edge and force the chips to evacuate away from insert to avoid any built-up edge (the major cause of premature insert failure and rough surface finish.)

Grooving and Turning Method

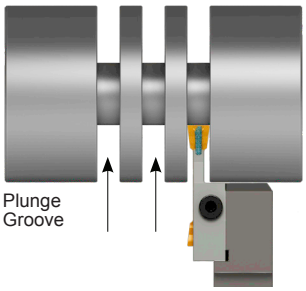
Step 1. First Groove

Set the toolholder close to starting point of the groove.

Cut the first groove above the diameter finish dimension.

Grooving and Turning Method

Step 2. Groove Roughing

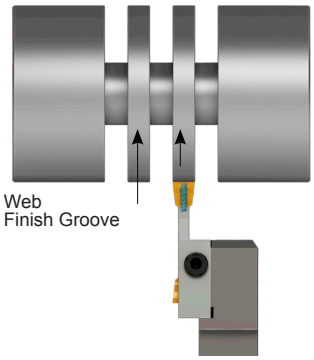


Repeat the operation in equal segments for the total length to be turned. The wall of the segment should be the width of the insert less 20%.

For Example:
5mm Insert Wall 4.5mm width
.200" Insert Wall .180" width

Grooving and Turning Method

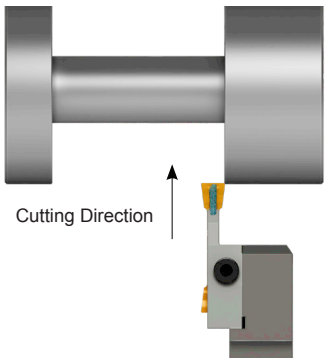
Step 3. Web Roughing



Cut the webs with the same diameter of the grooves .

Grooving and Turning Method

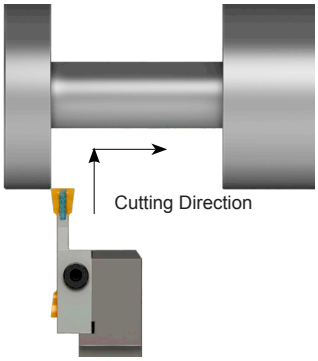
Step 4. First Finishing Cut



Face-off at finish dimension one side of the groove to the finished diameter, then retract the toolholder at 45° away from the wall.

Grooving and Turning Method

Step 5. Final Finishing Cut

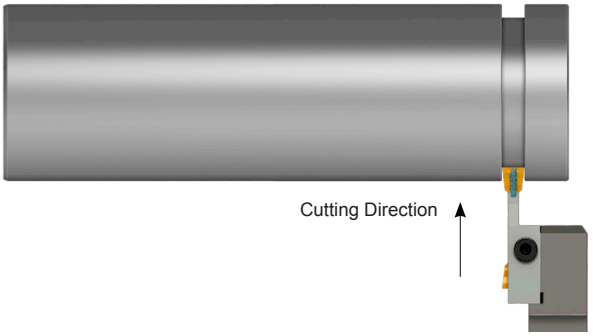


Move the toolholder on the other side of the wall of the groove, face-off to the finished diameter and continue to cut the entire surface till the other wall is reached, then retract the toolholder at 45° away from the wall.

Note: The Grooving & Turning Method is faster the than Turning and Grooving Method, however only 2 sides of the insert are used.

Turning and Grooving Method

Step 1. Starting Groove

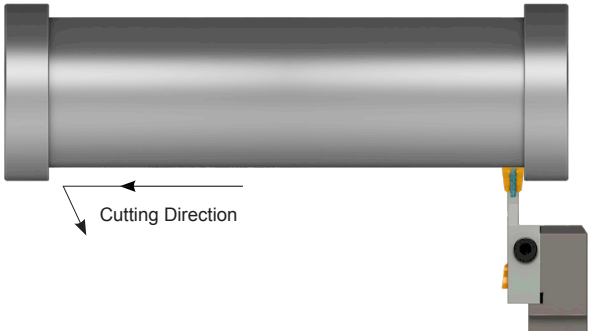


Set the toolholder close to the starting point of the groove

Cut the first groove to depth of the first roughing cutting diameter.

Turning and Grooving Method

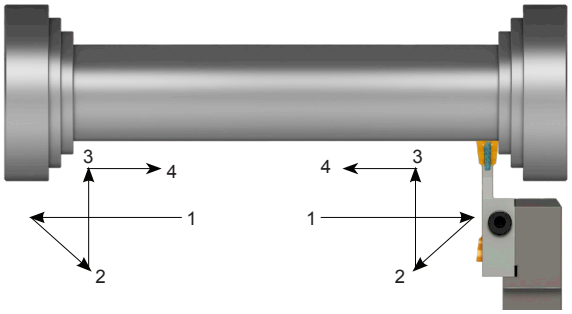
Step 2. First Turning Roughing Cut



Once the first groove is cut, feed the insert toward the other side of the workpiece. Cut till the end is reached then retract the toolholder at 45° away from the wall.

Turning and Grooving Method

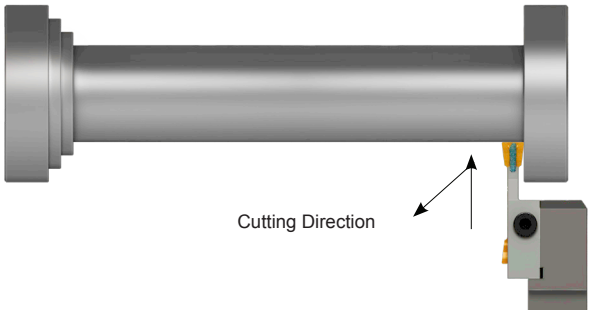
Step 3. Multi Turning Roughing Cut



After the first roughing cut, repeat the operation from side to side until the roughing operation is complete.

Turning and Grooving Method

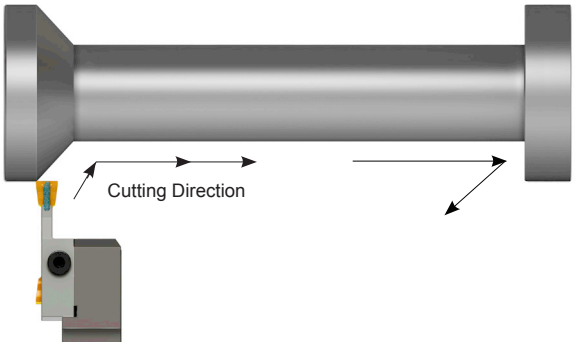
Step 4. First Finishing Cut



Face-off at finish dimension one side of the groove to the finished diameter, then retract the toolholder at 45° away from the wall.

Turning and Grooving Method

Step 5. Final Finishing Cut



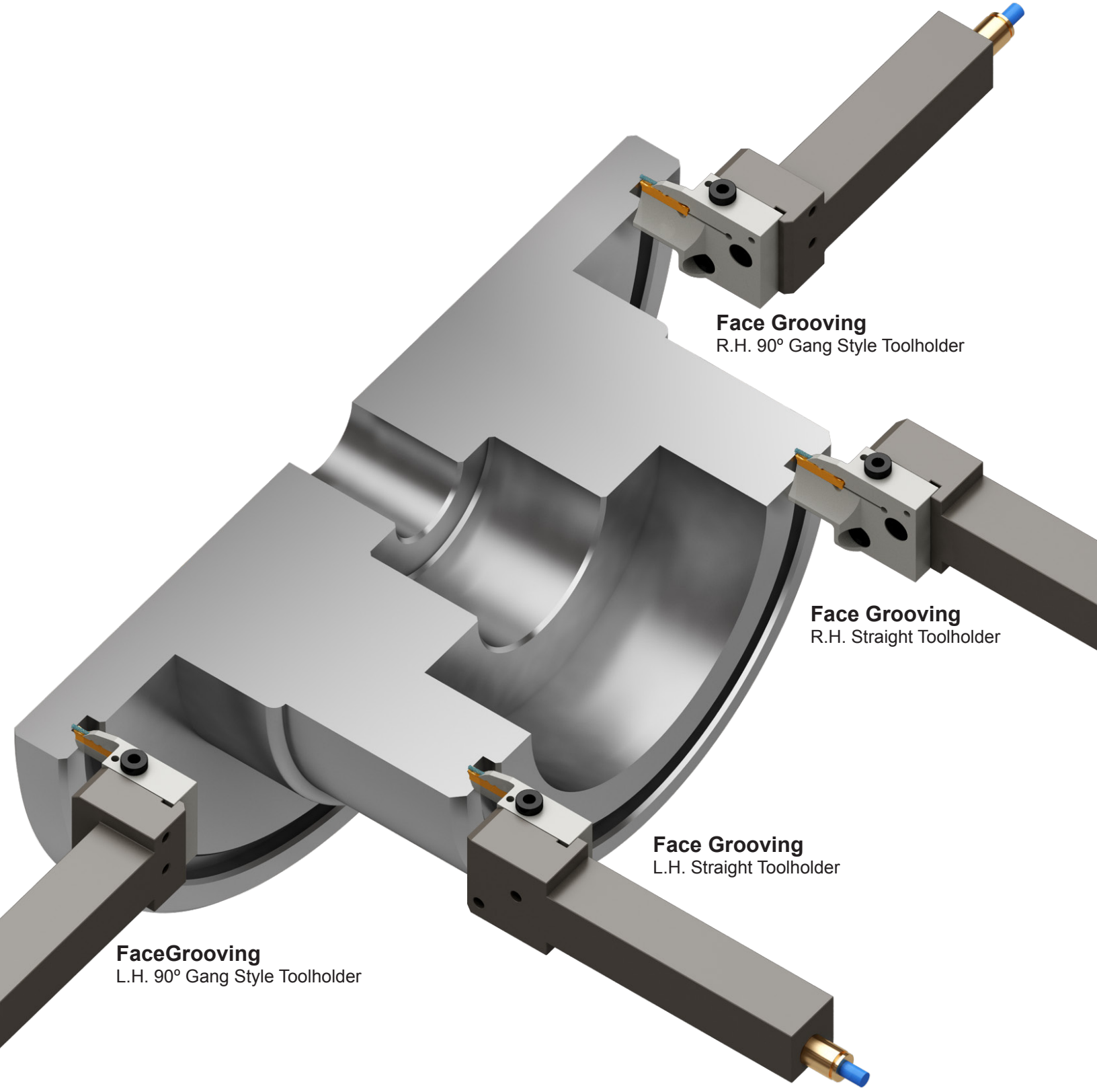
Move the toolholder on the other side of the wall of the groove, face-off to the finished diameter and continue to cut the entire surface till the other wall is reached,then retract the toolholder at 45° away from the wall.

Note: The Grooving and Turning Method, is slower than the Grooving and Turning Method, however the insert is fully utilized on all the 3 sides.

The KOOL Cut™

Modular Face Grooving System

Expands the Flexibility of Multi-Operations
with the Combination of
Shanks Sizes & Cartridge Styles



Face Grooving
R.H. 90° Gang Style Toolholder

Face Grooving
R.H. Straight Toolholder

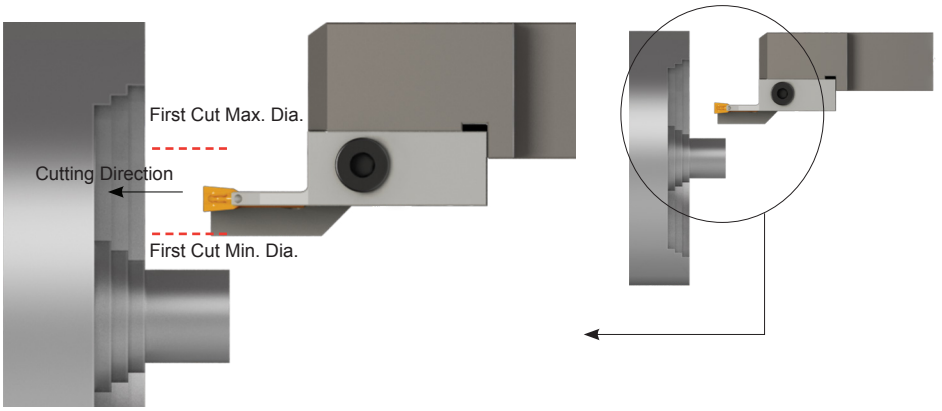
Face Grooving
L.H. Straight Toolholder

FaceGrooving
L.H. 90° Gang Style Toolholder

Face Grooving

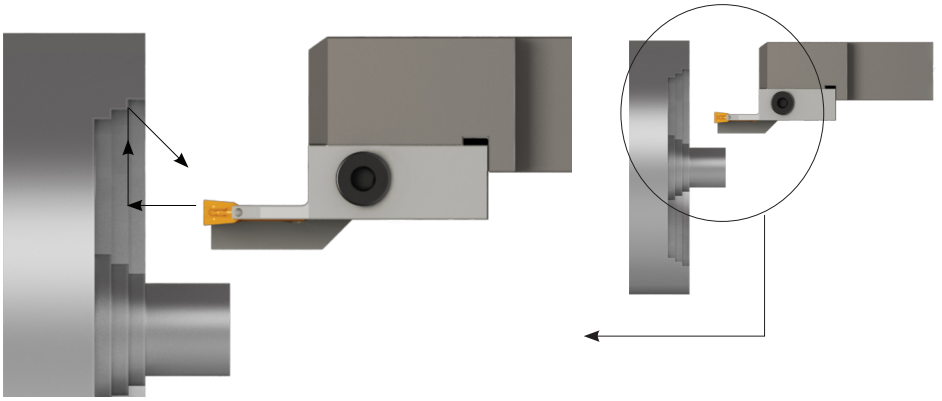
Step 1.
First Grooving Cut

Plunge to first depth of cut inside the safe first cut zone specified in the catalog for each modular toolholder.



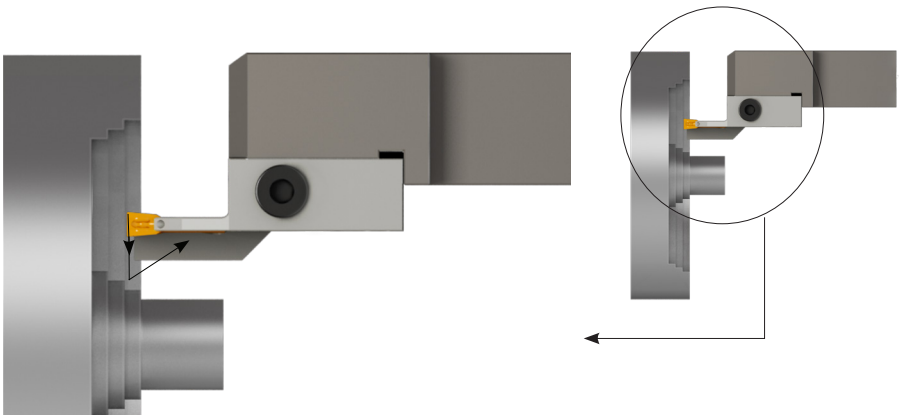
Step 2.
First Roughing Cut

Enter the safe zone and continue to cut in the opposite direction as step no 2 to cut to desired dimension. Then pull away .010" (.25mm) at a 45º angle and retract tool.



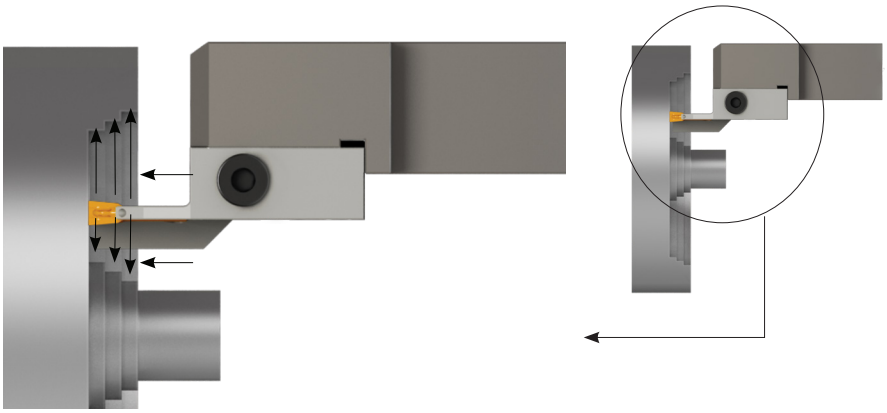
Step 3.
Second Roughing Cut

Feed across the desired dimension. Then pull away .010" (.25mm) at a 45º angle and retract tool.



Step 4.
Multi Turning Roughing Cut

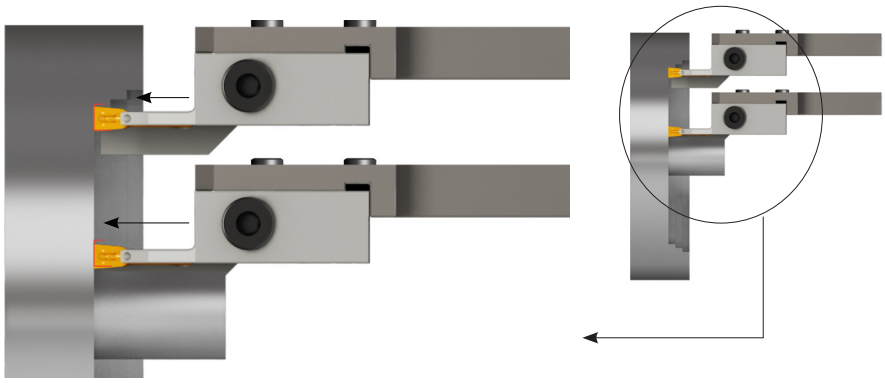
Repeat steps 1-3 until roughing is complete.



Face Grooving

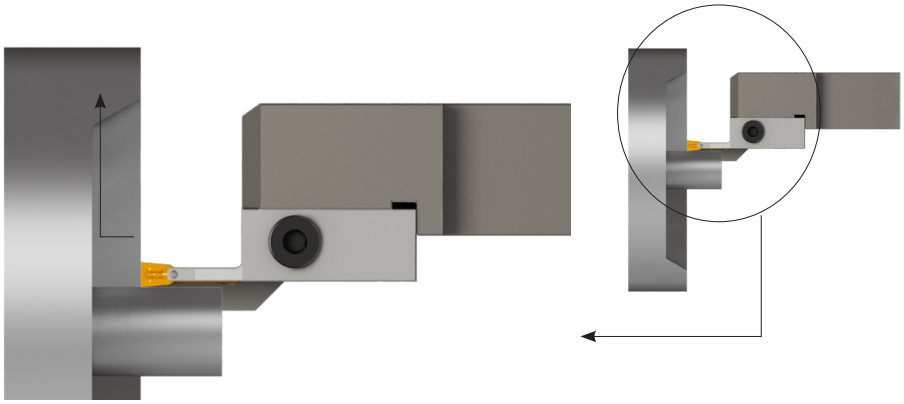
Step 5.
Finish Depth of Cut

Plunge to the finished dimension at each corner to provide a relief allowing the tool to flex into position.



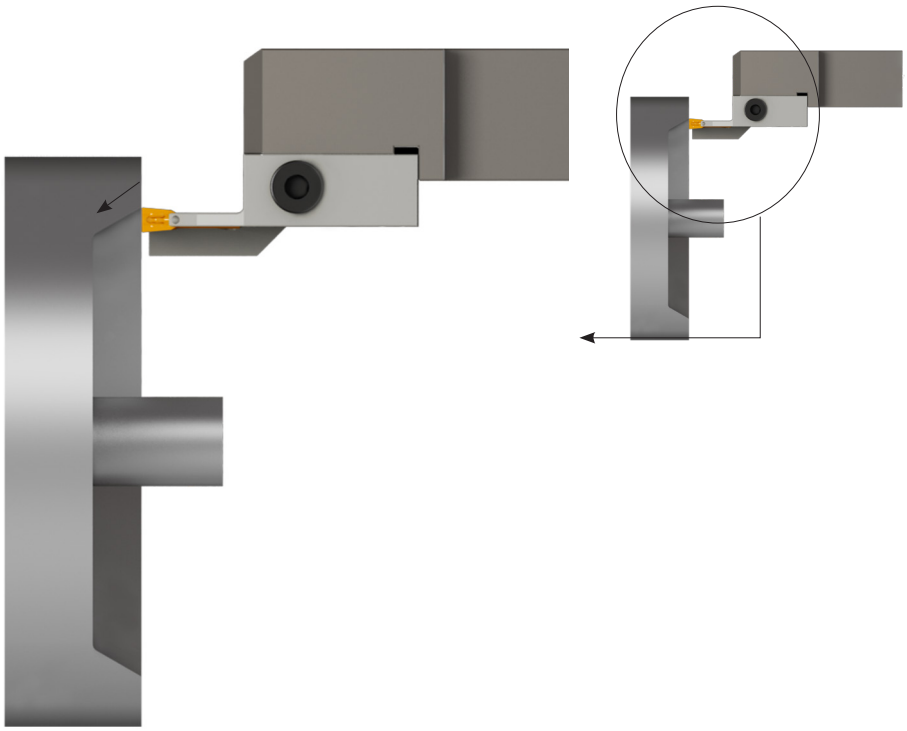
Step 6.
First Finishing Cut

Cut inner side and the bottom of the face groove.



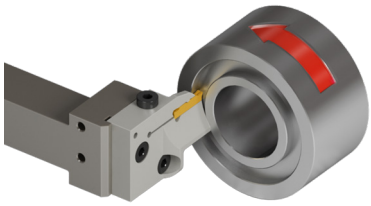
Step 7.
Final Finishing Cut

Finish outer side.

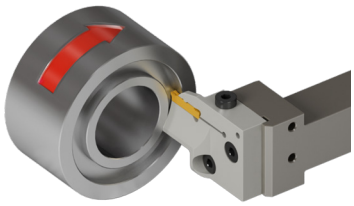


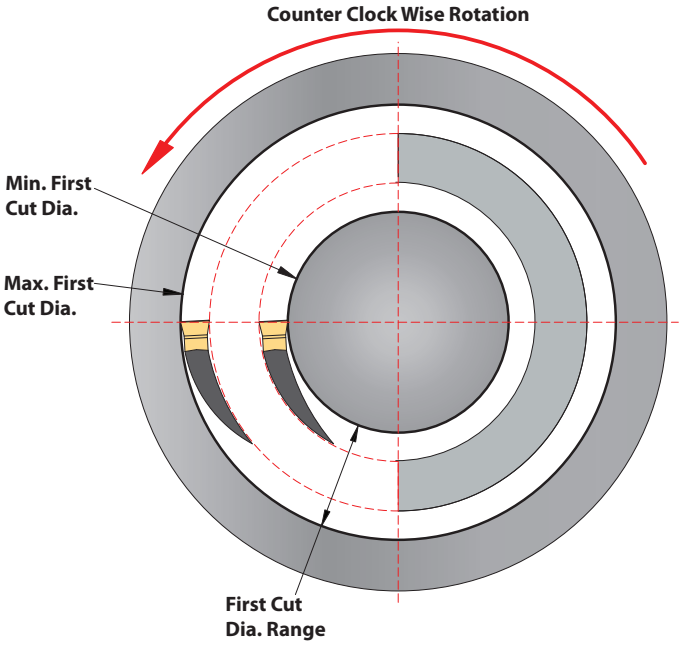
Face Turning and Grooving Cutting Direction

Left Hand Modular
90° Gang Toolholder Style
Counter clock wise rotation

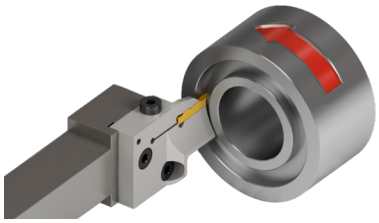


Right Hand Modular
90° Gang Toolholder Style
Clock wise rotation

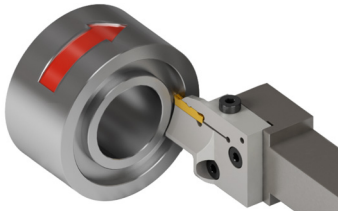




Left Hand Modular
Straight Style Toolholder
Counter clock wise rotation



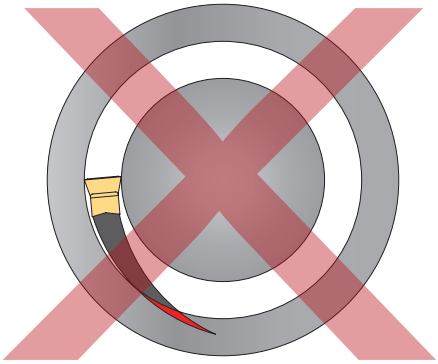
Right Hand Modular
Straight Style Toolholder
Clock wise rotation



Damage caused at the First Cut when tools are chosen incorrectly according to min. and max. Dia.

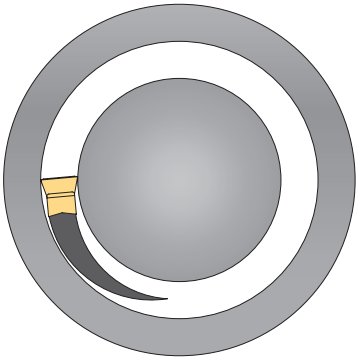
X Max. Dia. Too Small

If the Grooving Toolholder outside Anvil diameter is larger than the outer diameter, this will not execute the **First Cut** because the Anvil will interfere with the outer Diameter, damaging the part and the tool.



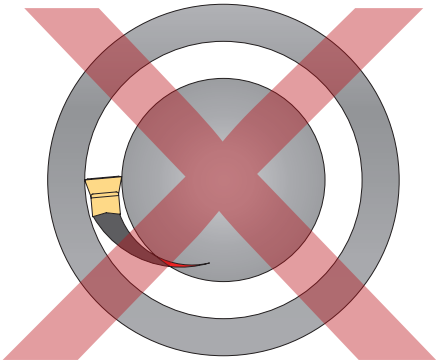
Correct First Cut Dia.

If the Grooving Toolholder outside Anvil diameter is small than the outer diameter, and Anvil inside diameter is larger than the inner diameter, the **First Cut** can be executed without interference with the matching part.

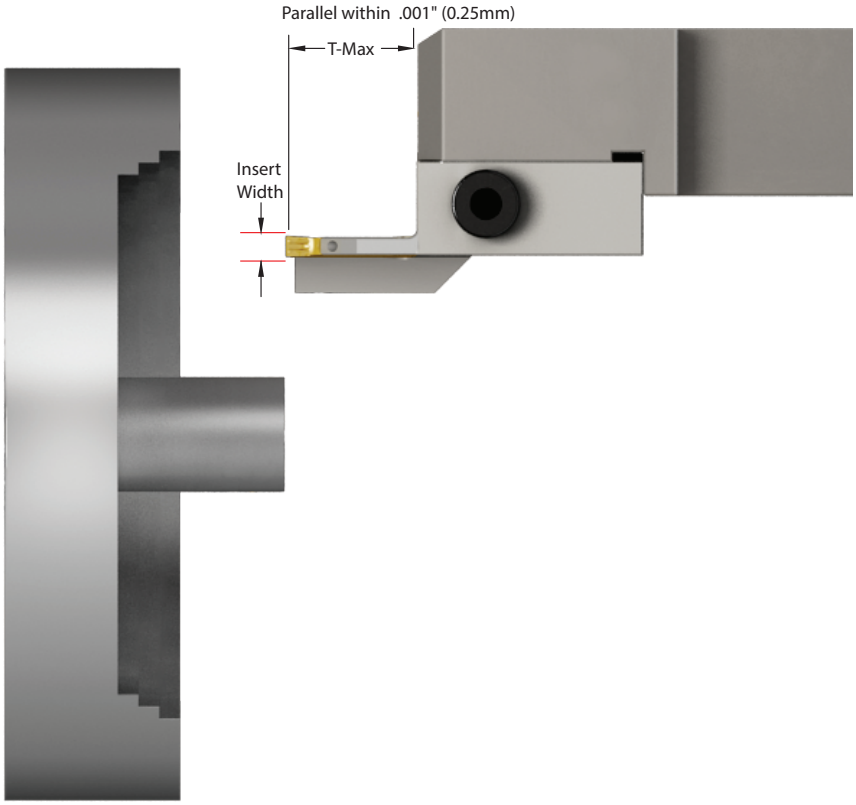


X Max. Dia. Too Large

If the Grooving Toolholder Anvil diameter is smaller than the inner diameter, this will not permit to execute the **First Cut because** the Anvil will interfere with the inner Diameter, damaging the part and the tool.



Modular Face Turning and Grooving Tool Selection



For best results choose the right tool accordingly based on the size of the face grooving to perform.

Step 1.
Use the widest insert and the largest toolholder permissible,
(for a better rate of material removal, better rigidity and surface finish.)

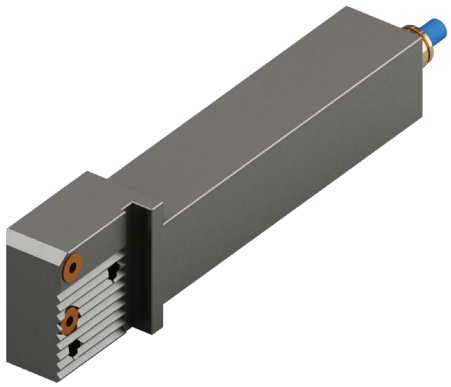
Step 2.
Use the shortest grooving tool overhang (T-Max),
(for a better rate of material removal, better rigidity and surface finish.)

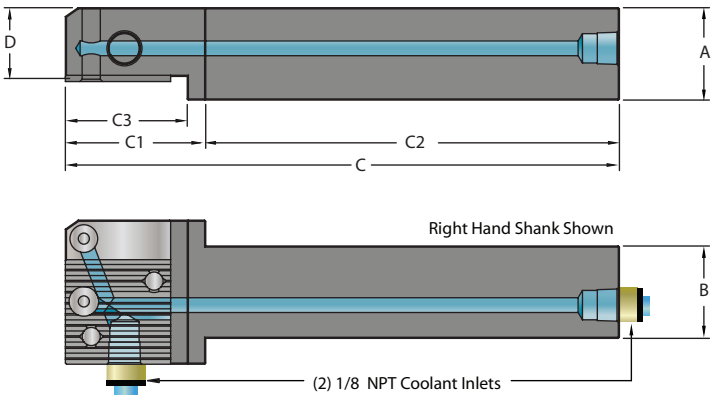
Step 3.
Use the largest grooving tool with the maximum diameter
in relation to the first grooving cut.

Step 4.
Ensure that the tool is exactly 90º to the work piece.
The difference should be no greater than 10" to achieve
straightness and reduce the tendency to cause vibration.

Step 5.
The cutting edge should be about 0,1mm over the middle,
maximum 0,08mm + 2,5% grooving width W. advantageous
in parting of small material.

KOOL Cut™ Modular Turning and Grooving Right Hand Straight Toolholder Style Shank

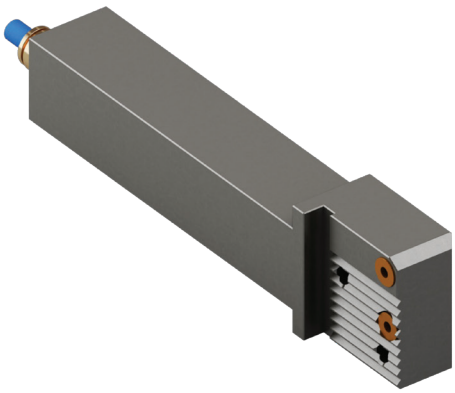


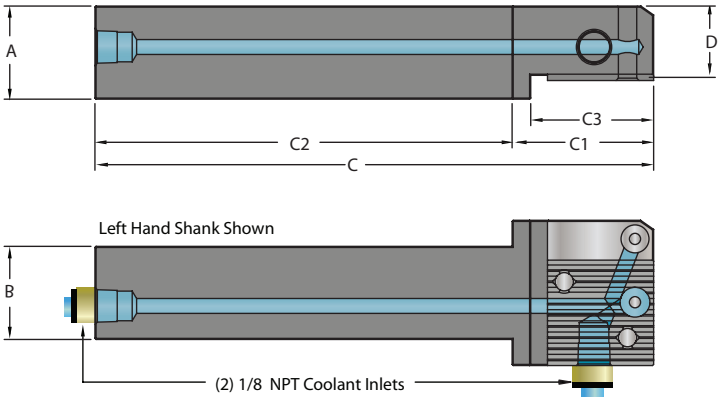


Metric R.H. Shank Description	UPC No. 733101-	Shank Size	A	B	D	C	C1	C2	C3
ADDN-MTR-2020-C	61975	20mm	20	20	15	127	38	89	33
ADDN-MTR-2525-D	61976	25mm	25	25	20	140	38	102	33
ADDN-MTR-3232-E	61977	32mm	32	32	27	152	38	114	33

Inch R.H. Shank Description	UPC No. 733101-	Shank Size	A	B	D	C	C1	C2	C3
ADDN-MTR-12-C	61987	3/4"	0.750	0.750	0.59	5.00	1.50	3.50	1.30
ADDN-MTR-16-D	61988	1"	1.000	1.000	0.79	5.50	1.50	4.00	1.30
ADDN-MTR-20-E	61989	1 1/4"	1.250	1.250	1.06	6.00	1.50	4.50	1.30

KOOL Cut™ Modular Turning and Grooving Left Hand Straight Toolholder Style Shank

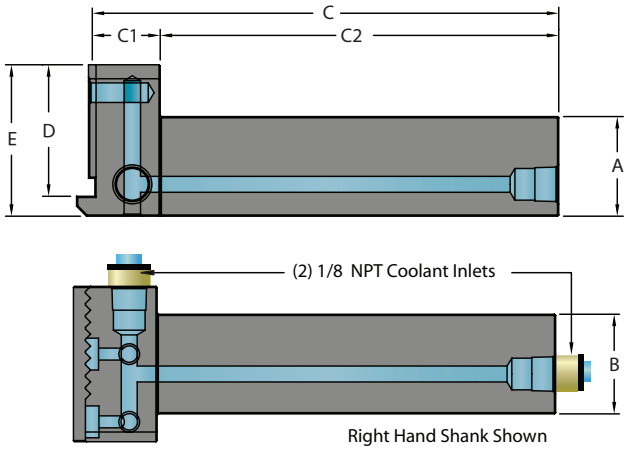




Metric L.H. Shank Description	UPC No. 733101-	Shank Size	A	B	D	C	C1	C2	C3
ADDN-MTL-2020-C	61978	20mm	20	20	15	127	38	89	33
ADDN-MTL-2525-D	61979	25mm	25	25	20	140	38	102	33
ADDN-MTL-3232-E	61980	32mm	32	32	27	152	38	114	33

Inch L.H. Shank Description	UPC No. 733101-	Shank Size	A	B	D	C	C1	C2	C3
ADDN-MTL-12-C	61990	3/4"	0.750	0.750	0.59	5.00	1.50	3.50	1.30
ADDN-MTL-16-D	61991	1"	1.000	1.000	0.79	5.50	1.50	4.00	1.30
ADDN-MTL-20-E	61992	1 1/4"	1.250	1.250	1.06	6.00	1.50	4.50	1.30

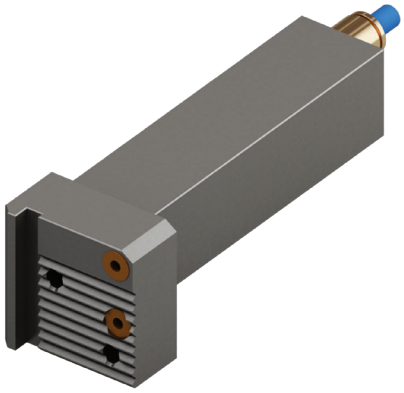
KOOL Cut™ Modular Turning and Grooving Right Hand 90° Gang Toolholder Style Shank

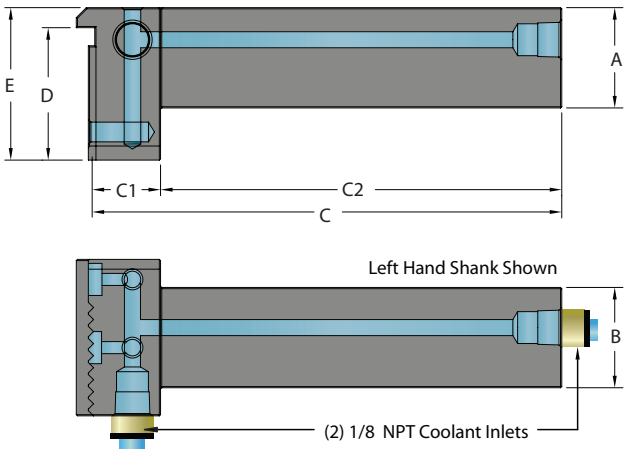


Metric R.H. Shank Description	UPC No. 733101-	Shank Size	A	B	D	E	C	C1	C2	C3
ADDN-MGR-2020-C	61984	20mm	20	20	33	38	107	18	89	33
ADDN-MGR-2525-D	61985	25mm	25	25	33	38	120	18	102	33
ADDN-MGR-3232-E	61986	32mm	32	32	33	38	132	18	114	33

Inch R.H. Shank Description	UPC No. 733101-	Shank Size	A	B	D	E	C	C1	C2	C3
ADDN-MGR-12-C	61996	3/4"	0.750	0.750	1.30	1.50	4.21	0.71	3.50	1.30
ADDN-MGR-16-D	61997	1"	1.000	1.000	1.30	1.50	4.71	0.71	4.00	1.30
ADDN-MGR-20-E	61998	1 1/4"	1.250	1.250	1.30	1.50	5.21	0.71	4.50	1.30

KOOL Cut™ Modular Turning and Grooving Left Hand 90° Gang Toolholder Style Shank



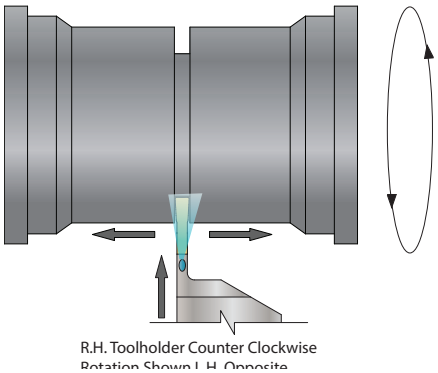


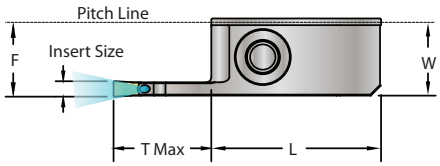
Metric L.H. Shank Description	UPC No. 733101-	Shank Size	A	B	D	E	C	C1	C2	C3
ADDN-MGL-2020-C	61981	20mm	20	20	33	38	107	18	89	33
ADDN-MGL-2525-D	61982	25mm	25	25	33	38	120	18	102	33
ADDN-MGL-3232-E	61983	32mm	32	32	33	38	132	18	114	33

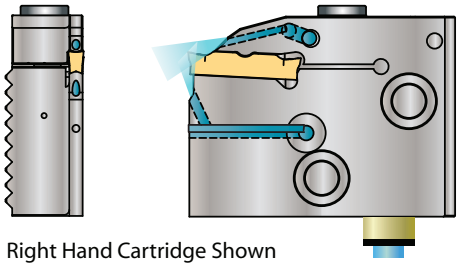
Inch L.H. Shank Description	UPC No. 733101-	Shank Size	A	B	D	E	C	C1	C2	C3
ADDN-MGL-12-C	61993	3/4"	0.750	0.750	1.30	1.50	4.21	0.71	3.50	1.30
ADDN-MGL-16-D	61994	1"	1.000	1.000	1.30	1.50	4.71	0.71	4.00	1.30
ADDN-MGL-20-E	61995	1 1/4"	1.250	1.250	1.30	1.50	5.21	0.71	4.50	1.30

KOOL Cut™ Modular Turning and Grooving Right Hand Cartridge for 2mm (.079") Insert Size

2mm (.079") Insert Size







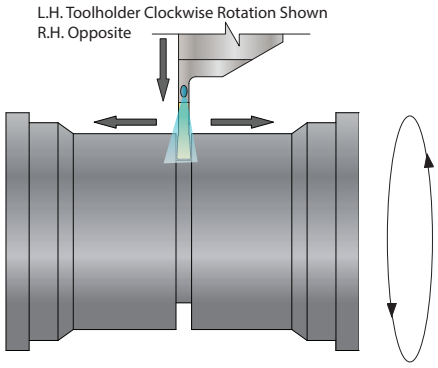
Right Hand Cartridge Shown

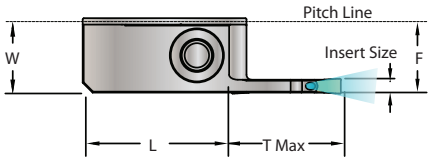
R.H. Cartridge Description	UPC No. 733101-	System	T.Max	L	F	W	Insert Size	Insert Style	Insert Lock Screw	Cartridge Lock Screw	Hex Key	Coolant Seal
ADKDN-TR20-06	61750	mm	6	33	15.2	15	2	DNTQ-222002-3EU-N DNTQ-222502-3EU-N DNTR-220210-3EU-N DNTF-222002-2EF-N DNPG-222002-1SR-N	CS-M0616	CS-M0620	HAHK-50	CS08-04
		inch	0.236	1.299	0.598	0.591	0.079					
ADKDN-TR20-12	61751	mm	12	33	15.2	15	2					
		inch	0.472	1.299	0.598	0.591	0.079					
ADKDN-TR20-18	61752	mm	18	33	15.2	15	2					
		inch	0.709	1.299	0.598	0.591	0.079					

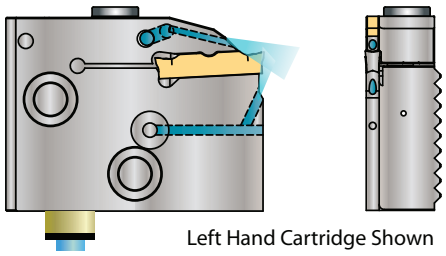
Right hand cartridge to be used with right hand shank ADDN-MTR on Page F-24 and right hand shank ADDN-MGR on Page F-25. For Turning, Grooving & Parting Off inserts see Pages F-4-F-6.

KOOL Cut™ Modular Turning and Grooving Left Hand Cartridge for 2mm (.079") Insert Size

2mm (.079") Insert Size







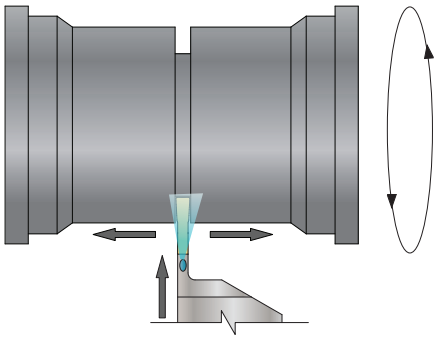
Left Hand Cartridge Shown

L.H. Cartridge Description	UPC No. 733101-	System	T.Max	L	F	W	Insert Size	Insert Style	Insert Lock Screw	Cartridge Lock Screw	Hex Key	Coolant Seal
ADKDN-TL20-06	61768	mm	6	33	15.2	15	2	DNTQ-222002-3EU-N DNTQ-222502-3EU-N DNTR-220210-3EU-N DNTF-222002-2EF-N DNPG-222002-1SR-N	CS-M0616	CS-M0620	HAHK-50	CS08-04
		inch	0.236	1.299	0.598	0.591	0.079					
ADKDN-TL20-12	61769	mm	12	33	15.2	15	2					
		inch	0.472	1.299	0.598	0.591	0.079					
ADKDN-TL20-18	61770	mm	18	33	15.2	15	2					
		inch	0.709	1.299	0.598	0.591	0.079					

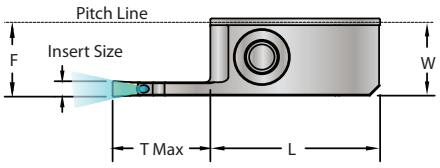
Left hand cartridge to be used with left hand shank ADDN-MTL on Page F-24 and left hand shank ADDN-MGL on Page F-25. For Turning, Grooving & Parting Off inserts see Pages F-4-F-6.

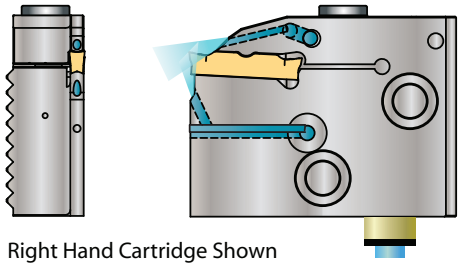
KOOL Cut™ Modular Turning and Grooving Right Hand Cartridge for 3mm (.118") Insert Size

3mm (.118") Insert Size



R.H. Toolholder Counter Clockwise Rotation Shown L.H. Opposite





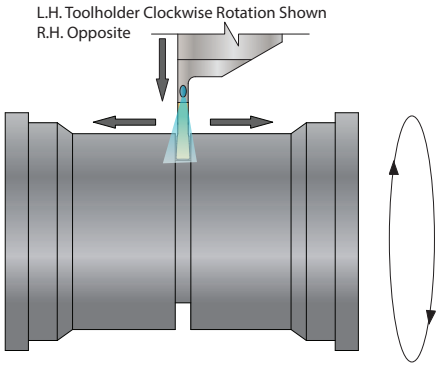
Right Hand Cartridge Shown

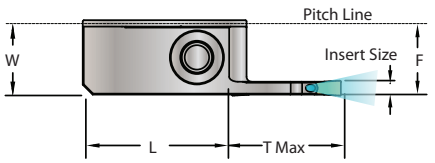
R.H. Cartridge Description	UPC No. 733101-	System	T.Max	L	F	W	Insert Size	Insert Style	Insert Lock Screw	Cartridge Lock Screw	Hex Key	Coolant Seal
ADKDN-TR30-09	61753	mm	12	33	15.4	15	3	DNTQ-254004-3EU-N	CS-M0616	CS-M0620	HAHK-50	CS08-04
		inch	0.472	1.299	0.606	0.591	0.118					
ADKDN-TR30-18	61754	mm	18	33	15.4	15	3	DNTR-254020-3EU-N DNTF-254003-2EF-N				
		inch	0.709	1.299	0.606	0.591	0.118					
ADKDN-TR30-27	61755	mm	24	33	15.4	15	3	DNPG-254003-1SR-N				
		inch	1.063	1.299	0.606	0.591	0.118					

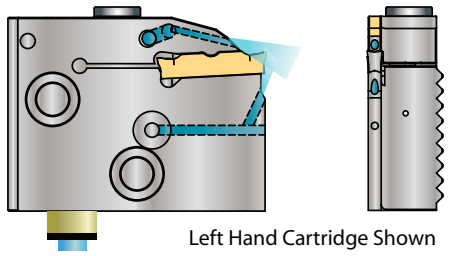
Right hand cartridge to be used with right hand shank ADDN-MTR on Page F-24 and right hand shank ADDN-MGR on Page F-25. For Turning, Grooving & Parting Off inserts see Pages F-4-F-6.

KOOL Cut™ Modular Turning and Grooving Left Hand Cartridge for 3mm (.118") Insert Size

3mm (.118") Insert Size







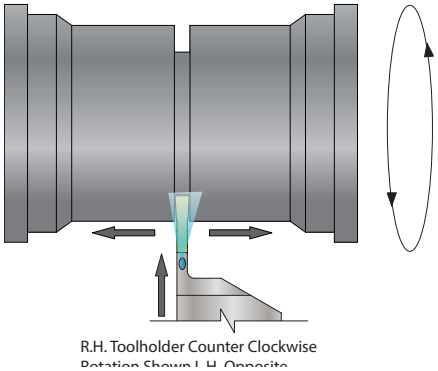
Left Hand Cartridge Shown

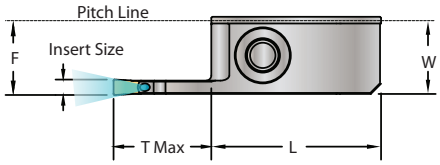
L.H. Cartridge Description	UPC No. 733101-	System	T.Max	L	F	W	Insert Size	Insert Style	Insert Lock Screw	Cartridge Lock Screw	Hex Key	Coolant Seal
ADKDN-TL30-09	61771	mm	9	33	15.3	15	3	DNTQ-254004-3EU-N	CS-M0616	CS-M0620	HAHK-50	CS08-04
		inch	0.354	1.299	0.602	0.591	0.118					
ADKDN-TL30-18	61772	mm	18	33	15.3	15	3	DNTR-254020-3EU-N DNTF-254003-2EF-N				
		inch	0.709	1.299	0.602	0.591	0.118					
ADKDN-TL30-27	61773	mm	27	33	15.3	15	3	DNPG-254003-1SR-N				
		inch	1.063	1.299	0.602	0.591	0.118					

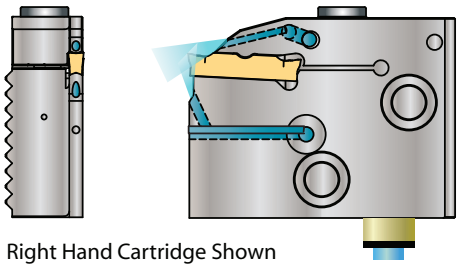
Left hand cartridge to be used with left hand shank ADDN-MTL on Page F-24 and left hand shank ADDN-MGL on Page F-25. For Turning, Grooving & Parting Off inserts see Pages F-4-F-6.

KOOL Cut™ Modular Turning and Grooving Right Hand Cartridge for 4mm (.157") Insert Size

4mm (.157") Insert Size







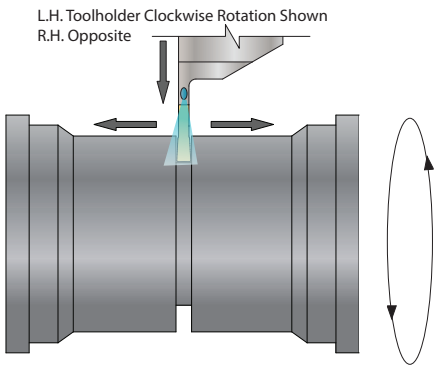
Right Hand Cartridge Shown

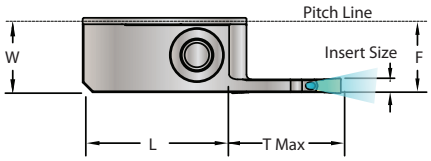
R.H. Cartridge Description	UPC No. 733101-	System	T.Max	L	F	W	Insert Size	Insert Style	Insert Lock Screw	Cartridge Lock Screw	Hex Key	Coolant Seal
ADKDN-TR40-12	61756	mm	12	33	15.4	15	4	DNTQ-254004-3EU-N DNTR-254020-3EU-N DNTF-254003-2EF-N DNPG-254003-1SR-N	CS-M0616	CS-M0620	HAHK-50	CS08-04
		inch	0.472	1.299	0.606	0.591	0.157					
ADKDN-TR40-18	61757	mm	18	33	15.4	15	4					
		inch	0.709	1.299	0.606	0.591	0.157					
ADKDN-TR40-24	61758	mm	24	33	15.4	15	4					
		inch	0.945	1.299	0.606	0.591	0.157					
ADKDN-TR40-30	61759	mm	30	33	15.4	15	4					
		inch	1.181	1.299	0.606	0.591	0.157					

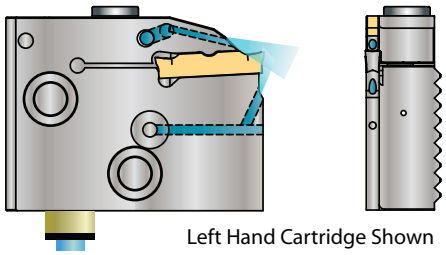
Right hand cartridge to be used with right hand shank ADDN-MTR on Page F-24 and right hand shank ADDN-MGR on Page F-25. For Turning, Grooving & Parting Off inserts see Pages F-4-F-6.

KOOL Cut™ Modular Turning and Grooving Left Hand Cartridge for 4mm (.157") Insert Size

4mm (.157") Insert Size







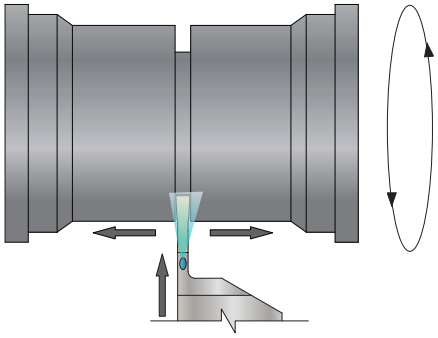
Left Hand Cartridge Shown

L.H. Cartridge Description	UPC No. 733101-	System	T.Max	L	F	W	Insert Size	Insert Style	Insert Lock Screw	Cartridge Lock Screw	Hex Key	Coolant Seal
ADKDN-TL40-12	61774	mm	12	33	15.4	15	4	DNTQ-254004-3EU-N DNTR-254020-3EU-N DNTF-254003-2EF-N DNPG-254003-1SR-N	CS-M0616	CS-M0620	HAHK-50	CS08-04
		inch	0.472	1.299	0.606	0.591	0.157					
ADKDN-TL40-18	61775	mm	18	33	15.4	15	4					
		inch	0.709	1.299	0.606	0.591	0.157					
ADKDN-TL40-24	61776	mm	24	33	15.4	15	4					
		inch	0.945	1.299	0.606	0.591	0.157					
ADKDN-TL40-30	61777	mm	30	33	15.4	15	4					
		inch	1.181	1.299	0.606	0.591	0.157					

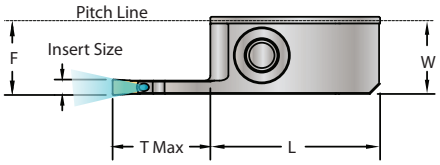
Left hand cartridge to be used with left hand shank ADDN-MTL on Page F-24 and left hand shank ADDN-MGL on Page F-25. For Turning, Grooving & Parting Off inserts see Pages F-4-F-6.

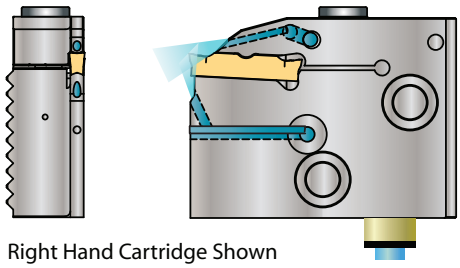
KOOL Cut™ Modular Turning and Grooving Right Hand Cartridge for 5mm (.197") Insert Size

5mm (.197") Insert Size



R.H. Toolholder Counter Clockwise
Rotation Shown L.H. Opposite





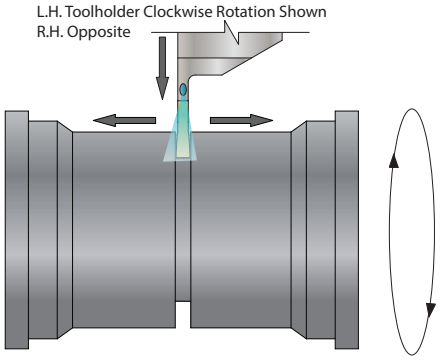
Right Hand Cartridge Shown

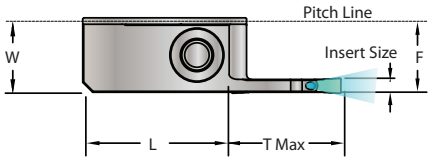
R.H. Cartridge Description	UPC No. 733101-	System	T.Max	L	F	W	Insert Size	Insert Style	Insert Lock Screw	Cartridge Lock Screw	Hex Key	Coolant Seal
ADKDN-TR50-10	61760	mm	10	33	15.5	15	5	DNTQ-255004-3EU-N DNTR-255025-3EU-N	CS-M0616	CS-M0620	HAHK-50	CS08-04
		inch	0.394	1.299	0.610	0.591	0.197					
ADKDN-TR50-15	61761	mm	15	33	15.5	15	5					
		inch	0.591	1.299	0.610	0.591	0.197					
ADKDN-TR50-25	61762	mm	25	33	15.5	15	5					
		inch	0.984	1.299	0.610	0.591	0.197					
ADKDN-TR50-40	61763	mm	40	33	15.5	15	5					
		inch	1.575	1.299	0.610	0.591	0.197					

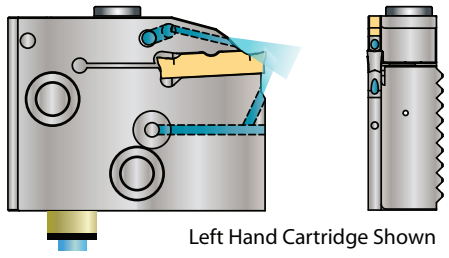
Right hand cartridge to be used with right hand shank ADDN-MTR on Page F-24 and right hand shank ADDN-MGR on Page F-25. For Turning, Grooving & Parting Off inserts see Pages F-4-F-6.

KOOL Cut™ Modular Turning and Grooving Left Hand Cartridge for 5mm (.197") Insert Size

5mm (.197") Insert Size







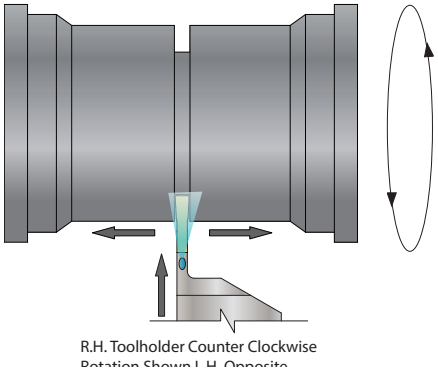
Left Hand Cartridge Shown

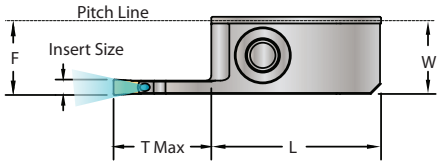
L.H. Cartridge Description	UPC No. 733101-	System	T.Max	L	F	W	Insert Size	Insert Style	Insert Lock Screw	Cartridge Lock Screw	Hex Key	Coolant Seal
ADKDN-TL50-10	61778	mm	10	33	15.5	15	5	DNTQ-255004-3EU-N DNTR-255025-3EU-N	CS-M0616	CS-M0620	HAHK-50	CS08-04
		inch	0.394	1.299	0.610	0.591	0.197					
ADKDN-TL50-15	61779	mm	15	33	15.5	15	5					
		inch	0.591	1.299	0.610	0.591	0.197					
ADKDN-TL50-25	61780	mm	25	33	15.5	15	5					
		inch	0.984	1.299	0.610	0.591	0.197					
ADKDN-TL50-40	61781	mm	40	33	15.5	15	5					
		inch	1.575	1.299	0.610	0.591	0.197					

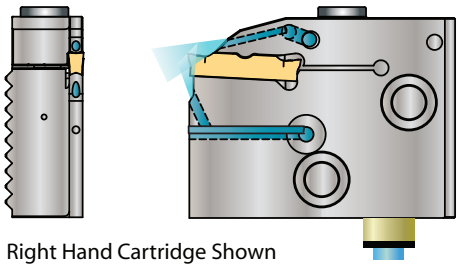
Left hand cartridge to be used with left hand shank ADDN-MTL on Page F-24 and left hand shank ADDN-MGL on Page F-25. For Turning, Grooving & Parting Off inserts see Pages F-4-F-6.

KOOL Cut™ Modular Turning and Grooving Right Hand Cartridge for 6mm (.236") Insert Size

6mm (.236") Insert Size







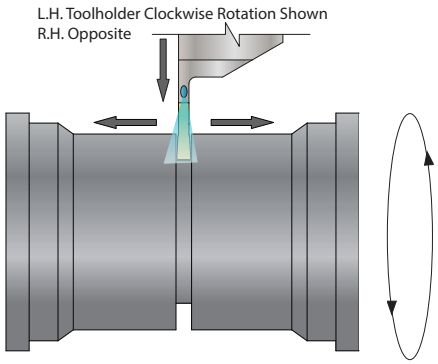
Right Hand Cartridge Shown

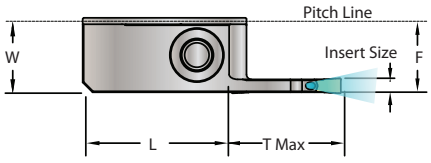
R.H. Cartridge Description	UPC No. 733101-	System	T.Max	L	F	W	Insert Size	Insert Style	Insert Lock Screw	Cartridge Lock Screw	Hex Key	Coolant Seal
ADKDN-TR60-12	61764	mm	12	33	15.5	15	6	DNTQ-256004-3EU-N DNTR-256030-3EU-N	CS-M0616	CS-M0620	HAHK-50	CS08-04
		inch	0.472	1.299	0.610	0.591	0.236					
ADKDN-TR60-18	61765	mm	18	33	15.5	15	6					
		inch	0.709	1.299	0.610	0.591	0.236					
ADKDN-TR60-30	61766	mm	30	33	15.5	15	6					
		inch	1.181	1.299	0.610	0.591	0.236					
ADKDN-TR60-48	61767	mm	48	33	15.5	15	6					
		inch	1.890	1.299	0.610	0.591	0.236					

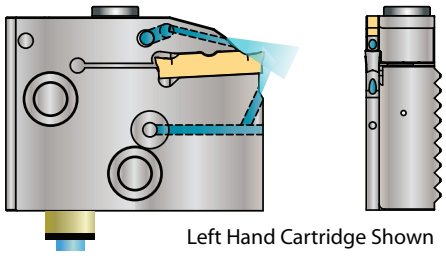
Right hand cartridge to be used with right hand shank ADDN-MTR on Page F-24 and right hand shank ADDN-MGR on Page F-25. For Turning, Grooving & Parting Off inserts see Pages F-4-F-6.

KOOL Cut™ Modular Turning and Grooving Left Hand Cartridge for 6mm (.236") Insert Size

6mm (.236") Insert Size







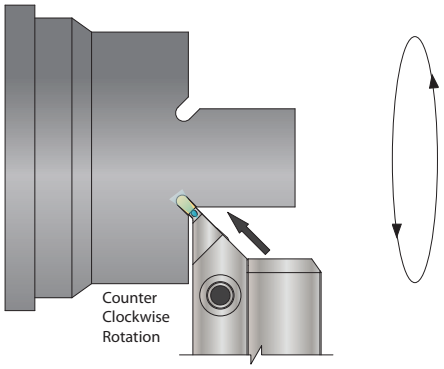
Left Hand Cartridge Shown

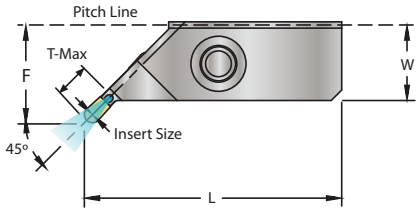
L.H. Cartridge Description	UPC No. 733101-	System	T.Max	L	F	W	Insert Size	Insert Style	Insert Lock Screw	Cartridge Lock Screw	Hex Key	Coolant Seal
ADKDN-TL60-12	61782	mm	12	33	15.5	15	6	DNTQ-256004-3EU-N DNTR-256030-3EU-N	CS-M0616	CS-M0620	HAHK-50	CS08-04
		inch	0.472	1.299	0.610	0.591	0.236					
ADKDN-TL60-18	61783	mm	18	33	15.5	15	6					
		inch	0.709	1.299	0.610	0.591	0.236					
ADKDN-TL60-30	61784	mm	30	33	15.5	15	6					
		inch	1.181	1.299	0.610	0.591	0.236					
ADKDN-TL60-48	61785	mm	48	33	15.5	15	6					
		inch	1.890	1.299	0.610	0.591	0.236					

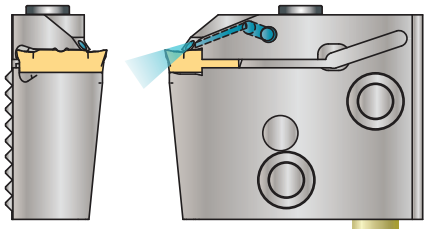
Left hand cartridge to be used with left hand shank ADDN-MTL on Page F-24 and left hand shank ADDN-MGL on Page F-25. For Turning, Grooving & Parting Off inserts see Pages F-4-F-6.

KOOL Cut™ Modular 45° Grooving Right Hand Cartridge for 2mm (.079") Insert Size

2mm (.079") Insert Size







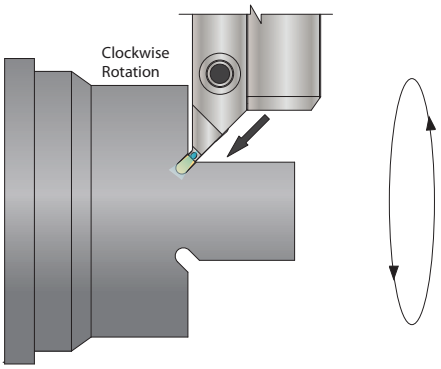
Right Hand Cartridge Shown

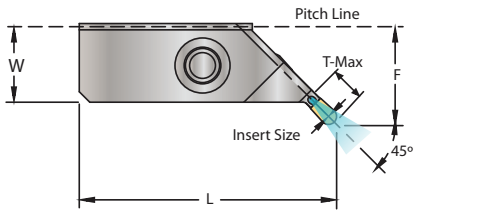
R.H. Cartridge Description	UPC No. 733101-	System	T.Max	L	F	W	Insert Size	Insert Style	Insert Lock Screw	Cartridge Lock Screw	Hex Key	Coolant Seal
ADKDN-UR20-05	61910	mm	5	33	23	15	2	DNTR-222010	CS-M0616	CS-M0620	HAHK-50	CS08-04
		inch	0.157	1.299	0.906	0.591	0.079					
ADKDN-UR30-06	61911	mm	6	33	24	15	3	DNTR-223015				
		inch	0.236	1.299	0.945	0.591	0.118					
ADKDN-UR40-08	61912	mm	8	33	26	15	4	DNTR-254020				
		inch	0.315	1.299	1.024	0.591	0.157					
ADKDN-UR50-10	61913	mm	10	33	27	15	5	DNTR-255025				
		inch	0.394	1.299	1.063	0.591	0.197					
ADKDN-UR60-12	61914	mm	12	33	28	15	6	DNTR-256030				
		inch	0.472	1.299	1.102	0.591	0.236					

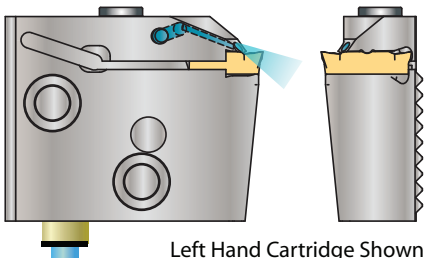
Right hand cartridge to be used with right hand shank ADDN-MTR on Page F-24 and right hand shank ADDN-MGR on Page F-25. For Turning, Grooving & Parting Off inserts see Pages F-4-F-6.

KOOL Cut™ Modular 45° Grooving Left Hand Cartridge for 2mm (.079") Insert Size

2mm (.079") Insert Size







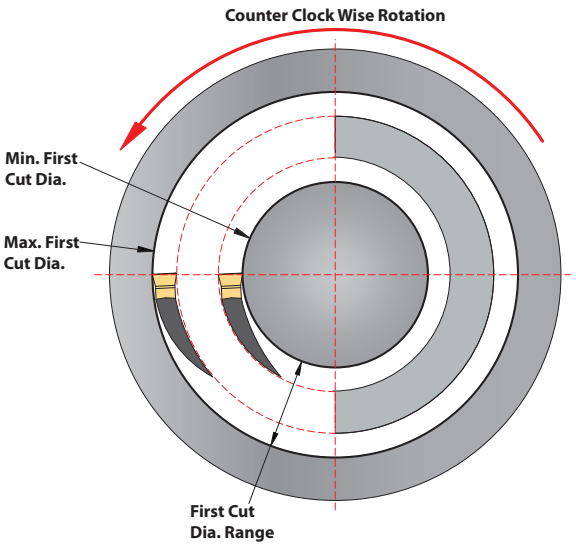
Left Hand Cartridge Shown

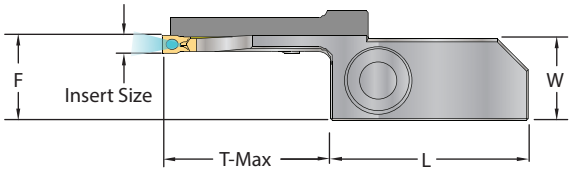
L.H. Cartridge Description	UPC No. 733101-	System	T.Max	L	F	W	Insert Size	Insert Style	Insert Lock Screw	Cartridge Lock Screw	Hex Key	Coolant Seal
ADKDN-UL20-05	61915	mm	5	33	23	15	2	DNTR-222010	CS-M0616	CS-M0620	HAHK-50	CS08-04
		inch	0.157	1.299	0.906	0.591	0.079					
ADKDN-UL30-06	61916	mm	6	33	24	15	3	DNTR-223015				
		inch	0.236	1.299	0.945	0.591	0.118					
ADKDN-UL40-08	61917	mm	8	33	26	15	4	DNTR-254020				
		inch	0.315	1.299	1.024	0.591	0.157					
ADKDN-UL50-10	61918	mm	10	33	27	15	5	DNTR-255025				
		inch	0.394	1.299	1.063	0.591	0.197					
ADKDN-UL60-12	61919	mm	12	33	28	15	6	DNTR-256030				
		inch	0.472	1.299	1.102	0.591	0.236					

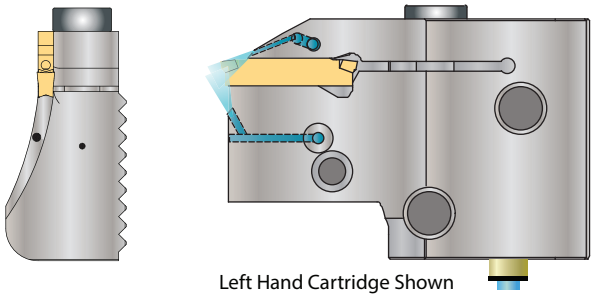
Left hand cartridge to be used with left hand shank ADDN-MTL on Page F-24 and left hand shank ADDN-MGL on Page F-25. For Turning, Grooving & Parting Off inserts see Pages F-4-F-6.

KOOL Cut™ Modular Face Grooving Left Hand Cartridge for 3mm (.118") Insert Size

3mm (.118") Insert Size





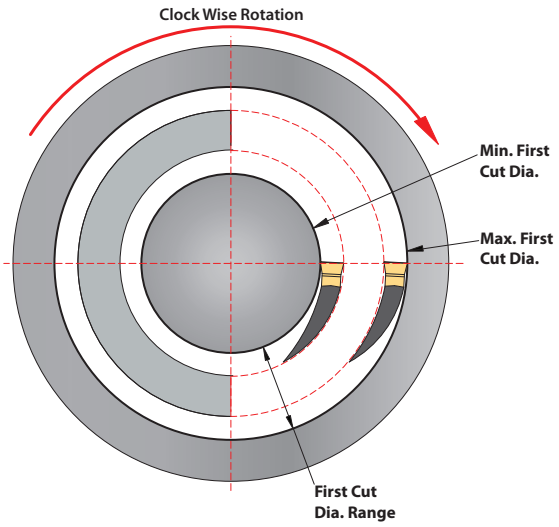


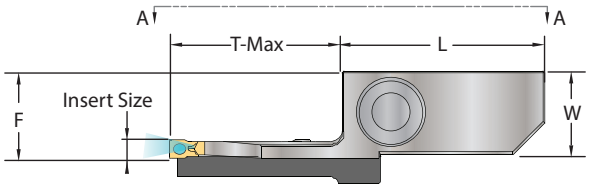
L.H. Cartridge Description	UPC No. 733101-	System	First Cut Diameter Min.	First Cut Diameter Max.	T-Max	L	F	W	Insert Size	Insert Style	Insert Lock Screw	Cartridge Lock Screw	Hex Key	Coolant Seal
T-Max 12mm (0.472")														
ADCDN-FL30-022030-12	62208	mm	22	30	12	33	16	15	3	DNTQ-223003-3EU-N DNTR-223015-3EU-N DNTF-223002-2EF-N DNPG-223002-1SR-N	CS-M0616	CS-M0620	HAHK-50	CS08-04
		inch	0.866	1.181	0.472	1.299	0.630	0.591	0.118					
ADCDN-FL30-030038-12	62209	mm	30	38	12	33	16	15	3					
		inch	1.181	1.496	0.472	1.299	0.630	0.591	0.118					
ADCDN-FL30-038048-12	62210	mm	38	48	12	33	16	15	3					
		inch	1.496	1.890	0.472	1.299	0.630	0.591	0.118					
ADCDN-FL30-048060-12	62211	mm	48	60	12	33	16	15	3					
		inch	1.890	2.362	0.472	1.299	0.630	0.591	0.118					
ADCDN-FL30-060075-12	62212	mm	60	75	12	33	16	15	3					
		inch	2.362	2.953	0.472	1.299	0.630	0.591	0.118					
ADCDN-FL30-075100-12	62213	mm	75	100	12	33	16	15	3					
		inch	2.953	3.937	0.472	1.299	0.630	0.591	0.118					
ADCDN-FL30-100200-12	62214	mm	100	200	12	33	16	15	3					
		inch	3.937	7.874	0.472	1.299	0.630	0.591	0.118					
ADCDN-FL30-200300-12	62215	mm	200	300	12	33	16	15	3					
		inch	7.874	11.811	0.472	1.299	0.630	0.591	0.118					
ADCDN-FL30-300->-12	62216	mm	300	>	12	33	16	15	3					
		inch	11.811	>	0.472	1.299	0.630	0.591	0.118					
T-Max 18mm (0.709")														
ADCDN-FL30-060075-18	62217	mm	60	75	18	33	16	15	3	DNTQ-223003-3EU-N DNTR-223015-3EU-N DNTF-223002-2EF-N DNPG-223002-1SR-N	CS-M0616	CS-M0620	HAHK-50	CS08-04
		inch	2.362	2.953	0.709	1.299	0.630	0.591	0.118					
ADCDN-FL30-075100-18	62218	mm	75	100	18	33	16	15	3					
		inch	2.953	3.937	0.709	1.299	0.630	0.591	0.118					
ADCDN-FL30-100200-18	62219	mm	100	200	18	33	16	15	3					
		inch	3.937	7.874	0.709	1.299	0.630	0.591	0.118					
ADCDN-FL30-200300-18	62220	mm	200	300	18	33	16	15	3					
		inch	7.874	11.811	0.709	1.299	0.630	0.591	0.118					
ADCDN-FL30-300->-18	62221	mm	300	>	18	33	16	15	3					
		inch	11.811	>	0.709	1.299	0.630	0.591	0.118					
T-Max 24mm (0.945")														
ADCDN-FL30-100200-24	62222	mm	100	200	24	33	16	15	3	DNTQ-223003-3EU-N DNTR-223015-3EU-N DNTF-223002-2EF-N DNPG-223002-1SR-N	CS-M0616	CS-M0620	HAHK-50	CS08-04
		inch	3.937	7.874	0.945	1.299	0.630	0.591	0.118					
ADCDN-FL30-200300-24	62223	mm	200	300	24	33	16	15	3					
		inch	7.874	11.811	0.945	1.299	0.630	0.591	0.118					
ADCDN-FL30-300->-24	62224	mm	300	>	24	33	16	15	3					
		inch	11.811	>	0.945	1.299	0.630	0.591	0.118					

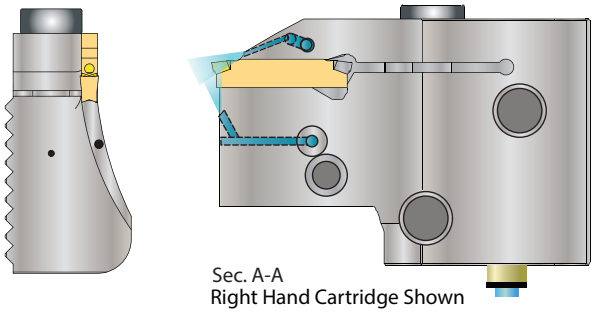
Left hand cartridge to be used with left hand shank ADDN-MTL on Page F-24 and left hand shank ADDN-MGL on Page F-25. For Turning, Grooving & Parting Off inserts see Pages F-4-F-6.

KOOL Cut™ Modular Face Grooving Right Hand Cartridge for 3mm (.118") Insert Size

3mm (.118") Insert Size





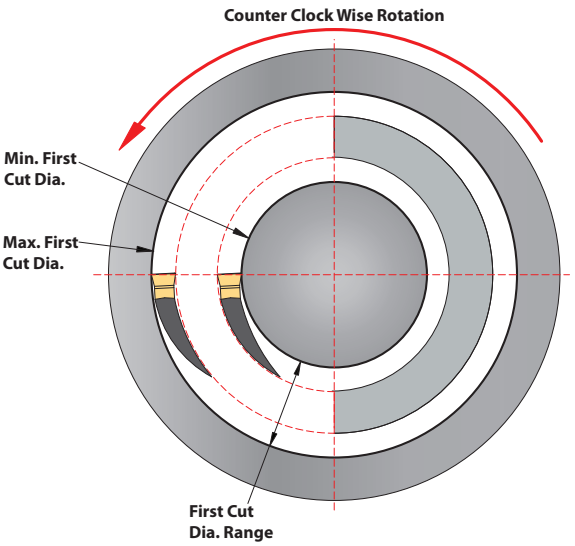


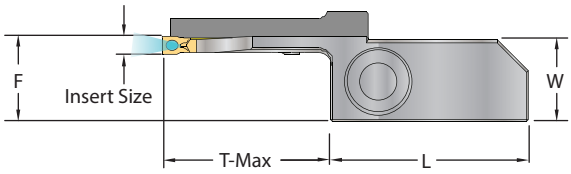
R.H. Cartridge Description	UPC No. 733101-	System	First Cut Diameter Min.	First Cut Diameter Max.	T-Max	L	F	W	Insert Size	Insert Style	Insert Lock Screw	Cartridge Lock Screw	Hex Key	Coolant Seal
T-Max 12mm (0.472")														
ADCDN-FR30-022030-12	62150	mm	22	30	12	33	16	15	3	DNTQ-223003-3EU-N DNTR-223015-3EU-N DNTF-223002-2EF-N DNPG-223002-1SR-N	CS-M0616	CS-M0620	HAHK-50	CS08-04
		inch	0.866	1.181	0.472	1.299	0.630	0.591	0.118					
ADCDN-FR30-030038-12	62151	mm	30	38	12	33	16	15	3					
		inch	1.181	1.496	0.472	1.299	0.630	0.591	0.118					
ADCDN-FR30-038048-12	62152	mm	38	48	12	33	16	15	3					
		inch	1.496	1.890	0.472	1.299	0.630	0.591	0.118					
ADCDN-FR30-048060-12	62153	mm	48	60	12	33	16	15	3					
		inch	1.890	2.362	0.472	1.299	0.630	0.591	0.118					
ADCDN-FR30-060075-12	62154	mm	60	75	12	33	16	15	3					
		inch	2.362	2.953	0.472	1.299	0.630	0.591	0.118					
ADCDN-FR30-075100-12	62155	mm	75	100	12	33	16	15	3					
		inch	2.953	3.937	0.472	1.299	0.630	0.591	0.118					
ADCDN-FR30-100200-12	62156	mm	100	200	12	33	16	15	3					
		inch	3.937	7.874	0.472	1.299	0.630	0.591	0.118					
ADCDN-FR30-200300-12	62157	mm	200	300	12	33	16	15	3					
		inch	7.874	11.811	0.472	1.299	0.630	0.591	0.118					
ADCDN-FR30-300->-12	62158	mm	300	>	12	33	16	15	3					
		inch	11.811	>	0.472	1.299	0.630	0.591	0.118					
T-Max 18mm (0.709")														
ADCDN-FR30-060075-18	62159	mm	60	75	18	33	16	15	3	DNTQ-223003-3EU-N DNTR-223015-3EU-N DNTF-223002-2EF-N DNPG-223002-1SR-N	CS-M0616	CS-M0620	HAHK-50	CS08-04
		inch	2.362	2.953	0.709	1.299	0.630	0.591	0.118					
ADCDN-FR30-075100-18	62160	mm	75	100	18	33	16	15	3					
		inch	2.953	3.937	0.709	1.299	0.630	0.591	0.118					
ADCDN-FR30-100200-18	62161	mm	100	200	18	33	16	15	3					
		inch	3.937	7.874	0.709	1.299	0.630	0.591	0.118					
ADCDN-FR30-200300-18	62162	mm	200	300	18	33	16	15	3					
		inch	7.874	11.811	0.709	1.299	0.630	0.591	0.118					
ADCDN-FR30-300->-18	62163	mm	300	>	18	33	16	15	3					
		inch	11.811	>	0.709	1.299	0.630	0.591	0.118					
T-Max 24mm (0.945")														
ADCDN-FR30-100200-24	62164	mm	100	200	24	33	16	15	3	DNTQ-223003-3EU-N DNTR-223015-3EU-N DNTF-223002-2EF-N DNPG-223002-1SR-N	CS-M0616	CS-M0620	HAHK-50	CS08-04
		inch	3.937	7.874	0.945	1.299	0.630	0.591	0.118					
ADCDN-FR30-200300-24	62165	mm	200	300	24	33	16	15	3					
		inch	7.874	11.811	0.945	1.299	0.630	0.591	0.118					
ADCDN-FR30-300->-24	62166	mm	300	>	24	33	16	15	3					
		inch	11.811	>	0.945	1.299	0.630	0.591	0.118					

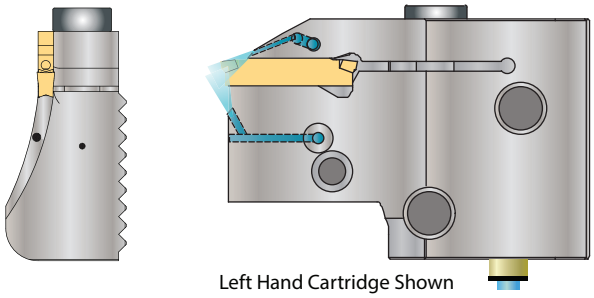
Right hand cartridge to be used with right hand shank ADDN-MTR on Page F-24 and right hand shank ADDN-MGR on Page F-25. For Turning, Grooving & Parting Off inserts see Pages F-4-F-6.

KOOL Cut™ Modular Face Grooving Left Hand Cartridge for 4mm (.157") Insert Size

4mm (.157") Insert Size





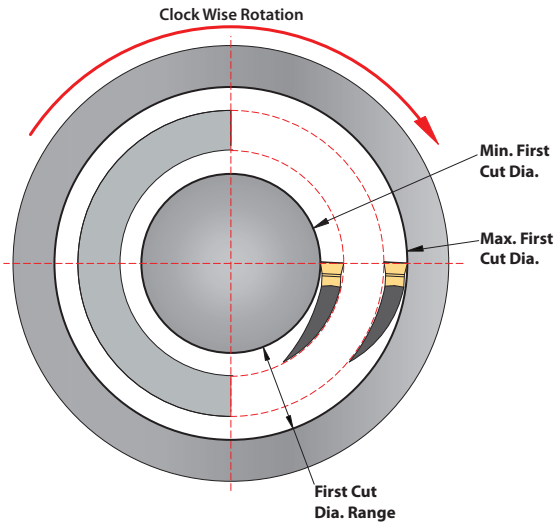


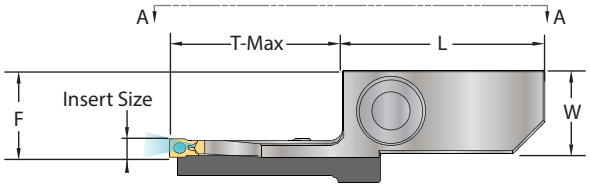
L.H. Cartridge Description	UPC No. 733101-	System	First Cut Diameter		T-Max	L	F	W	Insert			Cartridge Lock Screw	Hex Key	Coolant Seal
			Min.	Max.					Size	Style	Lock Screw			
T-Max 13mm (0.512")														
ADCDN-FL40-036048-13	62225	mm	36	48	13	33	16	15	4	DNTQ-254004-3EU-N DNTR-254020-3EU-N DNTF-254003-2EF-N DNPG-254003-1SR-N	CS-M0616	CS-M0620	HAHK-50	CS08-04
		inch	1.417	1.890	0.512	1.299	0.630	0.591	0.157					
ADCDN-FL40-048060-13	62226	mm	48	60	13	33	16	15	4					
		inch	1.890	2.362	0.512	1.299	0.630	0.591	0.157					
ADCDN-FL40-060075-13	62227	mm	60	75	13	33	16	15	4					
		inch	2.362	2.953	0.512	1.299	0.630	0.591	0.157					
ADCDN-FL40-075100-13	62228	mm	75	100	13	33	16	15	4					
		inch	2.953	3.937	0.512	1.299	0.630	0.591	0.157					
ADCDN-FL40-100200-13	62229	mm	100	200	13	33	16	15	4					
		inch	3.937	7.874	0.512	1.299	0.630	0.591	0.157					
ADCDN-FL40-200400-13	62230	mm	200	400	13	33	16	15	4					
		inch	7.874	15.748	0.512	1.299	0.630	0.591	0.157					
ADCDN-FL40-400>-13	62231	mm	400	>	13	33	16	15	4					
		inch	15.748	>	0.512	1.299	0.630	0.591	0.157					
T-Max 21mm (0.827")														
ADCDN-FL40-075100-21	62232	mm	75	100	21	33	16	15	4	DNTQ-254004-3EU-N DNTR-254020-3EU-N DNTF-254003-2EF-N DNPG-254003-1SR-N	CS-M0616	CS-M0620	HAHK-50	CS08-04
		inch	2.953	3.937	0.827	1.299	0.630	0.591	0.157					
ADCDN-FL40-100200-21	62233	mm	100	200	21	33	16	15	4					
		inch	3.937	7.874	0.827	1.299	0.630	0.591	0.157					
ADCDN-FL40-200400-21	62234	mm	200	400	21	33	16	15	4					
		inch	7.874	15.748	0.827	1.299	0.630	0.591	0.157					
ADCDN-FL40-400>-21	62235	mm	400	>	21	33	16	15	4					
		inch	15.748	>	0.827	1.299	0.630	0.591	0.157					
T-Max 28mm (1.102")														
ADCDN-FL40-100200-28	62236	mm	100	200	28	33	16	15	4	DNTQ-254004-3EU-N DNTR-254020-3EU-N DNTF-254003-2EF-N DNPG-254003-1SR-N	CS-M0616	CS-M0620	HAHK-50	CS08-04
		inch	3.937	7.874	1.102	1.299	0.630	0.591	0.157					
ADCDN-FL40-200400-28	62237	mm	200	400	28	33	16	15	4					
		inch	7.874	15.748	1.102	1.299	0.630	0.591	0.157					
ADCDN-FL40-400>-28	62238	mm	400	>	28	33	16	15	4					
		inch	15.748	>	1.102	1.299	0.630	0.591	0.157					

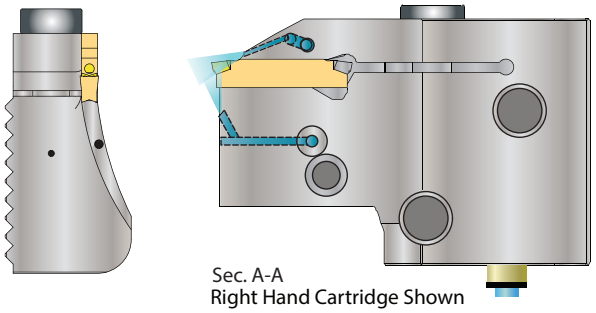
Left hand cartridge to be used with left hand shank ADDN-MTL on Page F-24 and left hand shank ADDN-MGL on Page F-25. For Turning, Grooving & Parting Off inserts see Pages F-4-F-6.

KOOL Cut™ Modular Face Grooving Right Hand Cartridge for 4mm (.157") Insert Size

4mm (.157") Insert Size





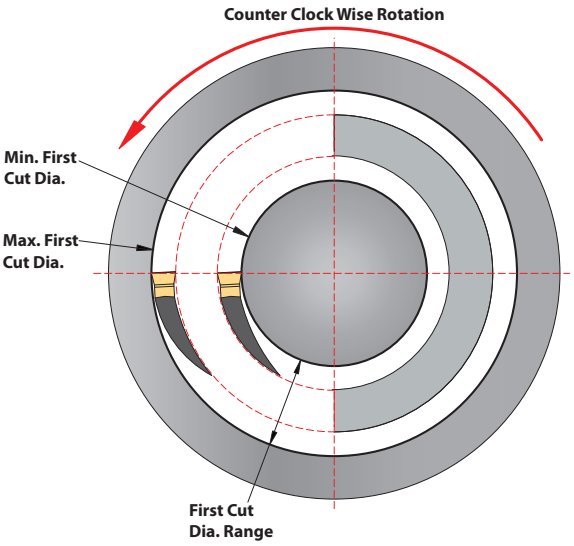


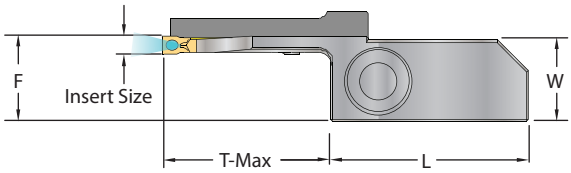
R.H. Cartridge Description	UPC No. 733101-	System	First Cut Diameter		T-Max	L	F	W	Insert			Cartridge Lock Screw	Hex Key	Coolant Seal
			Min.	Max.					Size	Style	Lock Screw			
T-Max 13mm (0.512")														
ADCDN-FR40-036048-13	62167	mm	36	48	13	33	16	15	4	DNTQ-254004-3EU-N DNTR-254020-3EU-N DNTF-254003-2EF-N DNPG-254003-1SR-N	CS-M0616	CS-M0620	HAHK-50	CS08-04
		inch	1.417	1.890	0.512	1.299	0.630	0.591	0.157					
ADCDN-FR40-048060-13	62168	mm	48	60	13	33	16	15	4					
		inch	1.890	2.362	0.512	1.299	0.630	0.591	0.157					
ADCDN-FR40-060075-13	62169	mm	60	75	13	33	16	15	4					
		inch	2.362	2.953	0.512	1.299	0.630	0.591	0.157					
ADCDN-FR40-075100-13	62170	mm	75	100	13	33	16	15	4					
		inch	2.953	3.937	0.512	1.299	0.630	0.591	0.157					
ADCDN-FRL40-100200-13	62171	mm	100	200	13	33	16	15	4					
		inch	3.937	7.874	0.512	1.299	0.630	0.591	0.157					
ADCDN-FR40-200400-13	62172	mm	200	400	13	33	16	15	4					
		inch	7.874	15.748	0.512	1.299	0.630	0.591	0.157					
ADCDN-FR40-400>-13	62173	mm	400	>	13	33	16	15	4					
		inch	15.748	>	0.512	1.299	0.630	0.591	0.157					
T-Max 21mm (0.827")														
ADCDN-FR40-075100-21	62174	mm	75	100	21	33	16	15	4	DNTQ-254004-3EU-N DNTR-254020-3EU-N DNTF-254003-2EF-N DNPG-254003-1SR-N	CS-M0616	CS-M0620	HAHK-50	CS08-04
		inch	2.953	3.937	0.827	1.299	0.630	0.591	0.157					
ADCDN-FR40-100200-21	62175	mm	100	200	21	33	16	15	4					
		inch	3.937	7.874	0.827	1.299	0.630	0.591	0.157					
ADCDN-FR40-200400-21	62176	mm	200	400	21	33	16	15	4					
		inch	7.874	15.748	0.827	1.299	0.630	0.591	0.157					
ADCDN-FR40-400>-21	62177	mm	400	>	21	33	16	15	4					
		inch	15.748	>	0.827	1.299	0.630	0.591	0.157					
T-Max 28mm (1.102")														
ADCDN-FR40-100200-28	62178	mm	100	200	28	33	16	15	4	DNTQ-254004-3EU-N DNTR-254020-3EU-N DNTF-254003-2EF-N DNPG-254003-1SR-N	CS-M0616	CS-M0620	HAHK-50	CS08-04
		inch	3.937	7.874	1.102	1.299	0.630	0.591	0.157					
ADCDN-FR40-200400-28	62179	mm	200	400	28	33	16	15	4					
		inch	7.874	15.748	1.102	1.299	0.630	0.591	0.157					
ADCDN-FR40-400>-28	62180	mm	400	>	28	33	16	15	4					
		inch	15.748	>	1.102	1.299	0.630	0.591	0.157					

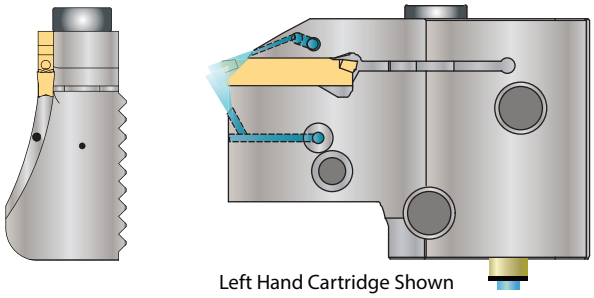
Right hand cartridge to be used with right hand shank ADDN-MTR on Page F-24 and right hand shank ADDN-MGR on Page F-25. For Turning, Grooving & Parting Off inserts see Pages F-4-F-6.

KOOL Cut™ Modular Face Grooving Left Hand Cartridge for 5mm (.197") Insert Size

5mm (.197") Insert Size







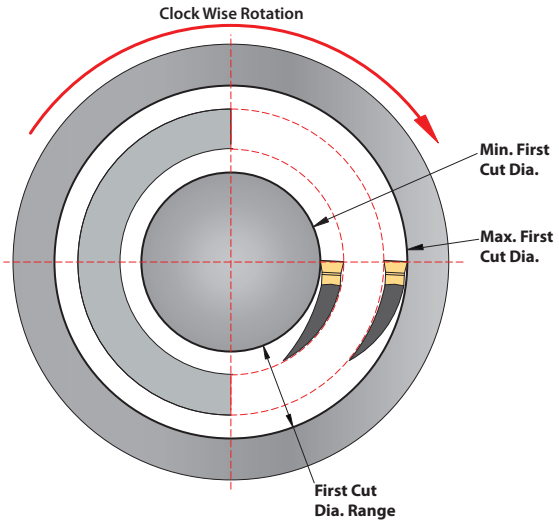
Left Hand Cartridge Shown

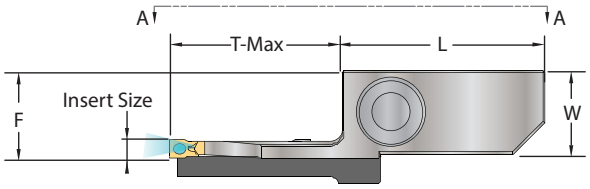
L.H. Cartridge Description	UPC No. 733101-	System	First Cut Diameter		T-Max	L	F	W	Insert			Cartridge Lock Screw	Hex Key	Coolant Seal
			Min.	Max.					Size	Style	Lock Screw			
T-Max 12mm (0.472")														
ADCDN-FL50-040055-12	62239	mm	40	55	12	33	16	15	5	DNTQ-255004-3EU-N DNTR-255025-3EU-N	CS-M0616	CS-M0620	HAHK-50	CS08-04
		inch	1.575	2.165	0.472	1.299	0.630	0.591	0.197					
ADCDN-FL50-055075-12	62240	mm	55	75	12	33	16	15	5					
		inch	2.165	2.953	0.472	1.299	0.630	0.591	0.197					
ADCDN-FL50-075120-12	62241	mm	75	120	12	33	16	15	5					
		inch	2.953	4.724	0.472	1.299	0.630	0.591	0.197					
ADCDN-FL50-120220-12	62242	mm	120	220	12	33	16	15	5					
		inch	4.724	8.661	0.472	1.299	0.630	0.591	0.197					
ADCDN-FL50-200400-12	62243	mm	200	400	12	33	16	15	5					
		inch	7.874	15.748	0.472	1.299	0.630	0.591	0.197					
ADCDN-FL50-400->-12	62244	mm	400	>	12	33	16	15	5					
		inch	15.748	>	0.472	1.299	0.630	0.591	0.197					
T-Max 22mm (0.866")														
ADCDN-FL50-075120-22	62245	mm	75	120	22	33	16	15	5	DNTQ-255004-3EU-N DNTR-255025-3EU-N	CS-M0616	CS-M0620	HAHK-50	CS08-04
		inch	2.953	4.724	0.866	1.299	0.630	0.591	0.197					
ADCDN-FL50-120220-22	62246	mm	120	220	22	33	16	15	5					
		inch	4.724	8.661	0.866	1.299	0.630	0.591	0.197					
ADCDN-FL50-200400-22	62247	mm	200	400	22	33	16	15	5					
		inch	7.874	15.748	0.866	1.299	0.630	0.591	0.197					
ADCDN-FL50-400->-22	62248	mm	400	>	22	33	16	15	5					
		inch	15.748	>	0.866	1.299	0.630	0.591	0.197					
T-Max 32mm (1.260")														
ADCDN-FL50-075120-32	62249	mm	75	120	32	33	16	15	5	DNTQ-255004-3EU-N DNTR-255025-3EU-N	CS-M0616	CS-M0620	HAHK-50	CS08-04
		inch	2.953	4.724	1.260	1.299	0.630	0.591	0.197					
ADCDN-FL50-120220-32	62250	mm	120	220	32	33	16	15	5					
		inch	4.724	8.661	1.260	1.299	0.630	0.591	0.197					
ADCDN-FL50-200400-32	62251	mm	200	400	32	33	16	15	5					
		inch	7.874	15.748	1.260	1.299	0.630	0.591	0.197					
ADCDN-FL50-400->-32	62252	mm	400	>	32	33	16	15	5					
		inch	15.748	>	1.260	1.299	0.630	0.591	0.197					

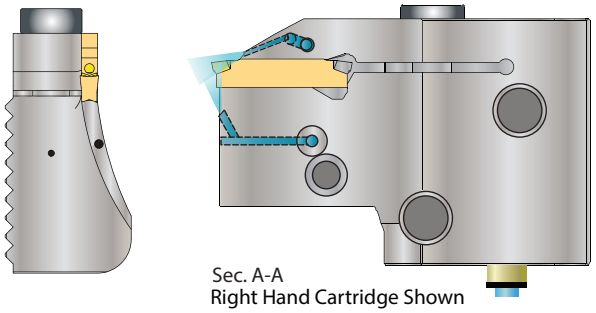
Left hand cartridge to be used with left hand shank ADDN-MTL on Page F-24 and left hand shank ADDN-MGL on Page F-25. For Turning, Grooving & Parting Off inserts see Pages F-4-F-6.

KOOL Cut™ Modular Face Grooving Right Hand Cartridge for 5mm (.197") Insert Size

5mm (.197") Insert Size





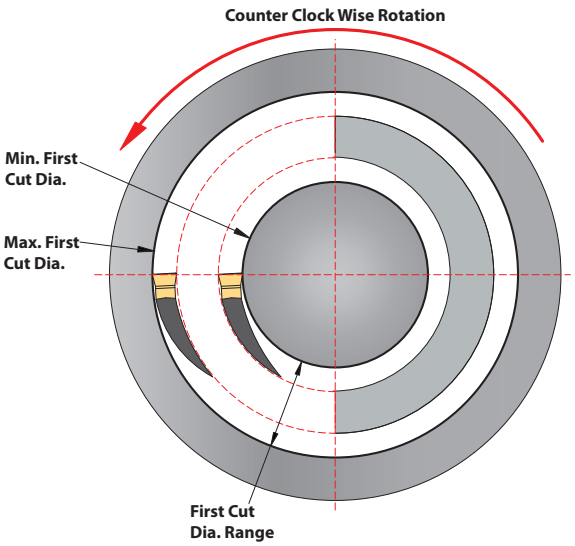


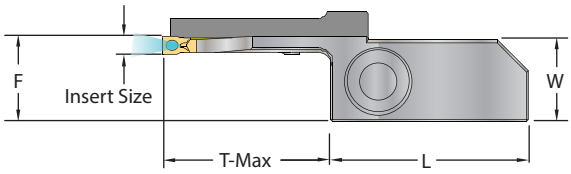
R.H. Cartridge Description	UPC No. 733101-	System	First Cut Diameter Min.	First Cut Diameter Max.	T-Max	L	F	W	Insert Size	Insert Style	Insert Lock Screw	Cartridge Lock Screw	Hex Key	Coolant Seal
T-Max 12mm (0.472")														
ADCDN-FR50-040055-12	62181	mm	40	55	12	33	16	15	5	DNTQ-255004-3EU-N DNTR-255025-3EU-N	CS-M0616	CS-M0620	HAHK-50	CS08-04
		inch	1.575	2.165	0.472	1.299	0.630	0.591	0.197					
ADCDN-FR50-055075-12	62182	mm	55	75	12	33	16	15	5					
		inch	2.165	2.953	0.472	1.299	0.630	0.591	0.197					
ADCDN-FR50-075120-12	62183	mm	75	120	12	33	16	15	5					
		inch	2.953	4.724	0.472	1.299	0.630	0.591	0.197					
ADCDN-FR50-120220-12	62184	mm	120	220	12	33	16	15	5					
		inch	4.724	8.661	0.472	1.299	0.630	0.591	0.197					
ADCDN-FR50-200400-12	62185	mm	200	400	12	33	16	15	5					
		inch	7.874	15.748	0.472	1.299	0.630	0.591	0.197					
ADCDN-FR50-400->-12	62186	mm	400	>	12	33	16	15	5					
		inch	15.748	>	0.472	1.299	0.630	0.591	0.197					
T-Max 22mm (0.866")														
ADCDN-FR50-075120-22	62187	mm	75	120	22	33	16	15	5	DNTQ-255004-3EU-N DNTR-255025-3EU-N	CS-M0616	CS-M0620	HAHK-50	CS08-04
		inch	2.953	4.724	0.866	1.299	0.630	0.591	0.197					
ADCDN-FR50-120220-22	62188	mm	120	220	22	33	16	15	5					
		inch	4.724	8.661	0.866	1.299	0.630	0.591	0.197					
ADCDN-FR50-200400-22	62189	mm	200	400	22	33	16	15	5					
		inch	7.874	15.748	0.866	1.299	0.630	0.591	0.197					
ADCDN-FR50-400->-22	62190	mm	400	>	22	33	16	15	5					
		inch	15.748	>	0.866	1.299	0.630	0.591	0.197					
T-Max 32mm (1.260")														
ADCDN-FR50-075120-32	62191	mm	75	120	32	33	16	15	5	DNTQ-255004-3EU-N DNTR-255025-3EU-N	CS-M0616	CS-M0620	HAHK-50	CS08-04
		inch	2.953	4.724	1.260	1.299	0.630	0.591	0.197					
ADCDN-FR50-120220-32	62192	mm	120	220	32	33	16	15	5					
		inch	4.724	8.661	1.260	1.299	0.630	0.591	0.197					
ADCDN-FR50-200400-32	62193	mm	200	400	32	33	16	15	5					
		inch	7.874	15.748	1.260	1.299	0.630	0.591	0.197					
ADCDN-FR50-400->-32	62194	mm	400	>	32	33	16	15	5					
		inch	15.748	>	1.260	1.299	0.630	0.591	0.197					

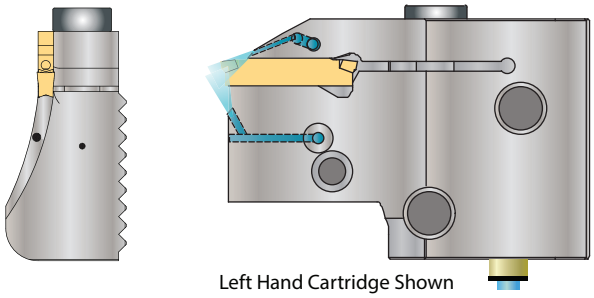
Right hand cartridge to be used with right hand shank ADDN-MTR on Page F-24 and right hand shank ADDN-MGR on Page F-25. For Turning, Grooving & Parting Off inserts see Pages F-4-F-6.

KOOL Cut™ Modular Face Grooving Left Hand Cartridge for 6mm (.236") Insert Size

6mm (.236") Insert Size





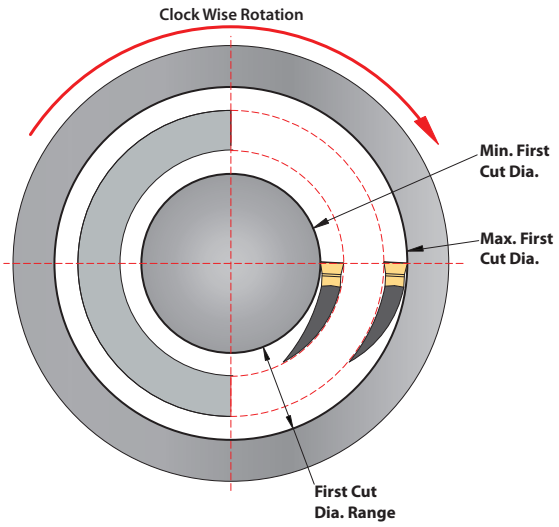

Left Hand Cartridge Shown

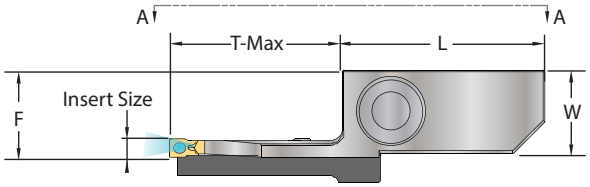
L.H. Cartridge Description	UPC No. 733101-	System	First Cut Diameter		T-Max	L	F	W	Insert			Cartridge Lock Screw	Hex Key	Coolant Seal
			Min.	Max.					Size	Style	Lock Screw			
T-Max 13mm (0.512")														
ADCDN-FL60-050075-13	62253	mm	50	75	13	33	16	15	6	DNTQ-256004-3EU-N DNTR-256030-3EU-N	CS-M0616	CS-M0620	HAHK-50	CS08-04
		inch	1.969	2.953	0.512	1.299	0.630	0.591	0.236					
ADCDN-FL60-075130-13	62254	mm	75	130	13	33	16	15	6					
		inch	2.953	5.118	0.512	1.299	0.630	0.591	0.236					
ADCDN-FL60-130300-13	62255	mm	130	300	13	33	16	15	6					
		inch	5.118	11.811	0.512	1.299	0.630	0.591	0.236					
ADCDN-FL60-300500-13	62256	mm	300	500	13	33	16	15	6					
		inch	11.811	19.685	0.512	1.299	0.630	0.591	0.236					
ADCDN-FL60-500>-13	62257	mm	500	>	13	33	16	15	6					
		inch	19.685	>	0.512	1.299	0.630	0.591	0.236					
T-Max 26mm (1.024")														
ADCDN-FL60-075130-26	62258	mm	75	130	26	33	16	15	6	DNTQ-256004-3EU-N DNTR-256030-3EU-N	CS-M0616	CS-M0620	HAHK-50	CS08-04
		inch	2.953	5.118	1.024	1.299	0.630	0.591	0.236					
ADCDN-FL60-130300-26	62259	mm	130	300	26	33	16	15	6					
		inch	5.118	11.811	1.024	1.299	0.630	0.591	0.236					
ADCDN-FL60-300500-26	62260	mm	300	500	26	33	16	15	6					
		inch	11.811	19.685	1.024	1.299	0.630	0.591	0.236					
ADCDN-FL60-500>-26	62261	mm	500	>	26	33	16	15	6					
		inch	19.685	>	1.024	1.299	0.630	0.591	0.236					
T-Max 39mm (1.535")														
ADCDN-FL60-075130-39	62262	mm	75	130	39	33	16	15	6	DNTQ-256004-3EU-N DNTR-256030-3EU-N	CS-M0616	CS-M0620	HAHK-50	CS08-04
		inch	2.953	5.118	1.535	1.299	0.630	0.591	0.236					
ADCDN-FL60-130300-39	62263	mm	130	300	39	33	16	15	6					
		inch	5.118	11.811	1.535	0.000	0.000	0.591	0.236					
ADCDN-FL60-300500-39	62264	mm	300	500	39	33	16	15	6					
		inch	11.811	19.685	1.535	1.299	0.630	0.591	0.236					
ADCDN-FL60-500>-39	62265	mm	500	>	39	33	16	15	6					
		inch	19.685	>	1.535	1.299	0.630	0.591	0.236					

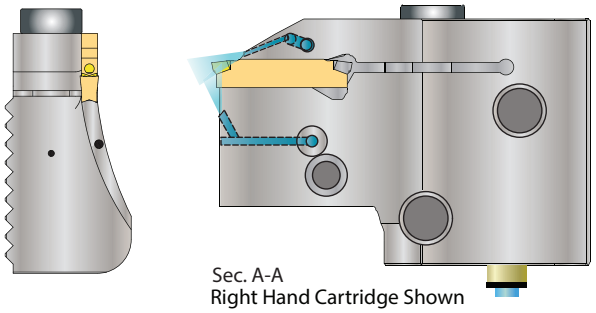
Right hand cartridge to be used with right hand shank ADDN-MTR on Page F-24 and right hand shank ADDN-MGR on Page F-25. For Turning, Grooving & Parting Off inserts see Pages F-4-F-6.

KOOL Cut™ Modular Face Grooving Right Hand Cartridge for 6mm (.236") Insert Size

6mm (.236") Insert Size





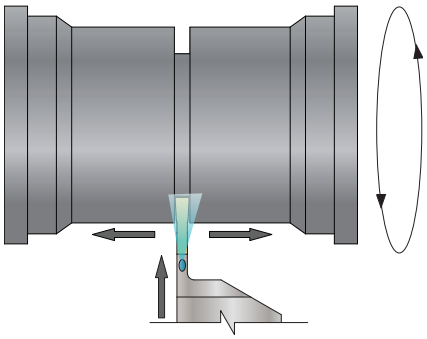


R.H. Cartridge Description	UPC No. 733101-	System	First Cut Diameter		T-Max	L	F	W	Insert			Cartridge Lock Screw	Hex Key	Coolant Seal
			Min.	Max.					Size	Style	Lock Screw			
T-Max 13mm (0.512")														
ADCDN-FR60-050075-13	62195	mm	50	75	13	33	16	15	6	DNTQ-256004-3EU-N DNTR-256030-3EU-N	CS-M0616	CS-M0620	HAHK-50	CS08-04
		inch	1.969	2.953	0.512	1.299	0.630	0.591	0.236					
ADCDN-FR60-075130-13	62196	mm	75	130	13	33	16	15	6					
		inch	2.953	5.118	0.512	1.299	0.630	0.591	0.236					
ADCDN-FL60-130300-13	62197	mm	130	300	13	33	16	15	6					
		inch	5.118	11.811	0.512	1.299	0.630	0.591	0.236					
ADCDN-FR60-300500-13	62198	mm	300	500	13	33	16	15	6					
		inch	11.811	19.685	0.512	1.299	0.630	0.591	0.236					
ADCDN-FR60-500>-13	62199	mm	500	>	13	33	16	15	6					
		inch	19.685	>	0.512	1.299	0.630	0.591	0.236					
T-Max 26mm (1.024")														
ADCDN-FR60-075130-26	62200	mm	75	130	26	33	16	15	6	DNTQ-256004-3EU-N DNTR-256030-3EU-N	CS-M0616	CS-M0620	HAHK-50	CS08-04
		inch	2.953	5.118	1.024	1.299	0.630	0.591	0.236					
ADCDN-FR60-130300-26	62201	mm	130	300	26	33	16	15	6					
		inch	5.118	11.811	1.024	1.299	0.630	0.591	0.236					
ADCDN-FR60-300500-26	62202	mm	300	500	26	33	16	15	6					
		inch	11.811	19.685	1.024	1.299	0.630	0.591	0.236					
ADCDN-FR60-500>-26	62203	mm	500	>	26	33	16	15	6					
		inch	19.685	>	1.024	1.299	0.630	0.591	0.236					
T-Max 39mm (1.535")														
ADCDN-FR60-075130-39	62204	mm	75	130	39	33	16	15	6	DNTQ-256004-3EU-N DNTR-256030-3EU-N	CS-M0616	CS-M0620	HAHK-50	CS08-04
		inch	2.953	5.118	1.535	1.299	0.630	0.591	0.236					
ADCDN-FR60-130300-39	62205	mm	130	300	39	33	16	15	6					
		inch	5.118	11.811	1.535	0.000	0.000	0.591	0.236					
ADCDN-FR60-300500-39	62206	mm	300	500	39	33	16	15	6					
		inch	11.811	19.685	1.535	1.299	0.630	0.591	0.236					
ADCDN-FR60-500>-39	62207	mm	500	>	39	33	16	15	6					
		inch	19.685	>	1.535	1.299	0.630	0.591	0.236					

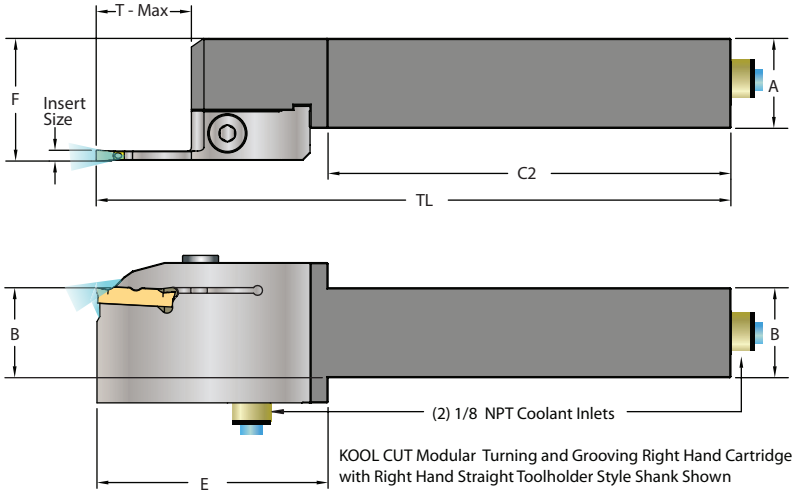
Left hand cartridge to be used with left hand shank ADDN-MTL on Page F-24 and left hand shank ADDN-MGL on Page F-25. For Turning, Grooving & Parting Off inserts see Pages F-4-F-6.

KOOL Cut™ Modular Turning & Grooving Cartridge with Right Hand Straight Toolholder Style Shank for 2mm (.079") Insert Size

2mm (.079") Insert Size



R.H. Toolholder Counter Clockwise Rotation Shown L.H. Opposite



KOOL CUT Modular Turning and Grooving Right Hand Cartridge with Right Hand Straight Toolholder Style Shank Shown

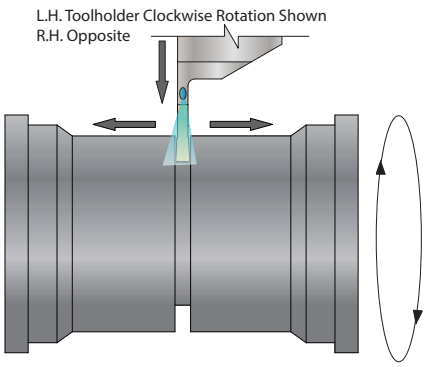
Metric R.H. Description	UPC No. 733101-	A	B	E	C2	F	TL	T-Max	Insert Size	Insert Style	Cartridge Included UPC	Cartridge Included Description	Clamp Screw	Cartridge Screw	Hex Key	Seal
ADDN-MTR-2020-C20-06	61300			44	89	30.2	133	6			61750	ADKDN-TR20-06				
ADDN-MTR-2020-C20-12	61301	20	20	50	89	30.2	139	12			61751	ADKDN-TR20-12				
ADDN-MTR-2020-C20-18	61302			56	89	30.2	145	18			61752	ADKDN-TR20-18				
ADDN-MTR-2525-D20-06	61303			44	102	35.2	146	6		DNTQ-222002-3EU-N	61750	ADKDN-TR20-06				
ADDN-MTR-2525-D20-12	61304	25	25	50	102	35.2	152	12	2	DNTQ-222502-3EU-N DNTR-220210-3EU-N	61751	ADKDN-TR20-12	CS-M0616	CS-M0620	HAHK-50	CS08-04
ADDN-MTR-2525-D20-18	61305			56	102	35.2	158	18		DNTF-222002-2EF-N	61752	ADKDN-TR20-18				
ADDN-MTR-3232-E20-06	61306			44	114	42.2	158	6		DNPG-222002-1SR-N	61750	ADKDN-TR20-06				
ADDN-MTR-3232-E20-12	61307	32	32	50	114	42.2	164	12			61751	ADKDN-TR20-12				
ADDN-MTR-3232-E20-18	61308			56	114	42.2	170	18			61752	ADKDN-TR20-18				

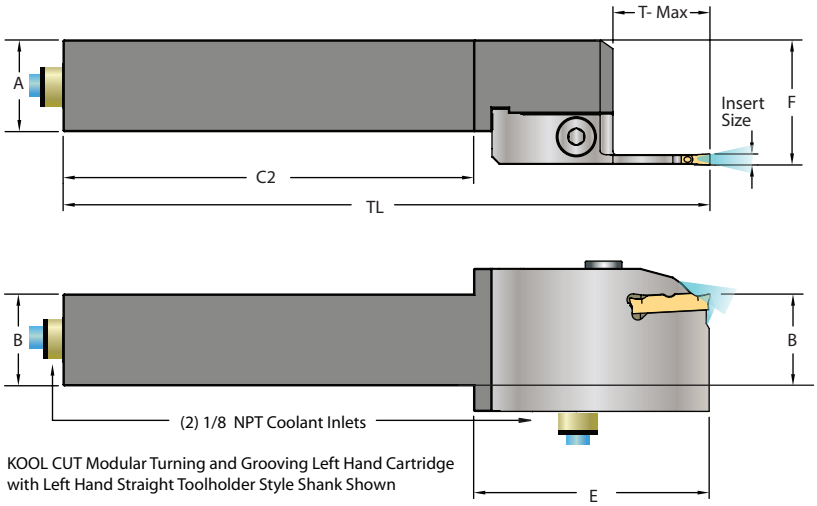
Inch R.H. Description	UPC No. 733101-	A	B	E	C2	F	TL	T-Max	Insert Size	Insert Style	Cartridge Included UPC	Cartridge Included Description	Clamp Screw	Cartridge Screw	Hex Key	Seal
ADDN-MTR-12-C20-06	61516			1.732	3.5	1.189	5.232	0.236			61750	ADKDN-TR20-06				
ADDN-MTR-12-C20-12	61517	0.75	0.75	1.969	3.5	1.189	5.469	0.472			61751	ADKDN-TR20-12				
ADDN-MTR-12-C20-18	61518			2.205	3.5	1.189	5.705	0.709			61752	ADKDN-TR20-18				
ADDN-MTR-16-D20-06	61519			1.732	4.0	1.386	5.732	0.236		DNTQ-222002-3EU-N	61750	ADKDN-TR20-06				
ADDN-MTR-16-D20-12	61520	1.00	1.00	1.969	4.0	1.386	5.969	0.472	0.079	DNTQ-222502-3EU-N DNTR-220210-3EU-N	61751	ADKDN-TR20-12	CS-M0616	CS-M0620	HAHK-50	CS08-04
ADDN-MTR-16-D20-18	61521			2.205	4.0	1.386	6.205	0.709		DNTF-222002-2EF-N	61752	ADKDN-TR20-18				
ADDN-MTR-20-E20-06	61522			1.732	4.5	1.661	6.232	0.236		DNPG-222002-1SR-N	61750	ADKDN-TR20-06				
ADDN-MTR-20-E20-12	61523	1.25	1.25	1.969	4.5	1.661	6.469	0.472			61751	ADKDN-TR20-12				
ADDN-MTR-20-E20-18	61524			2.205	4.5	1.661	6.705	0.709			61752	ADKDN-TR20-18				

For ADKDN_ Cartridge specifications see pages F-26 - F-30. For Turning, Grooving & Parting Off inserts see Pages F-4-F-6.

KOOL Cut™ Modular Turning & Grooving Cartridge with Left Hand Straight Toolholder Style Shank for 2mm (.079") Insert Size

2mm (.079") Insert Size





KOOL CUT Modular Turning and Grooving Left Hand Cartridge with Left Hand Straight Toolholder Style Shank Shown

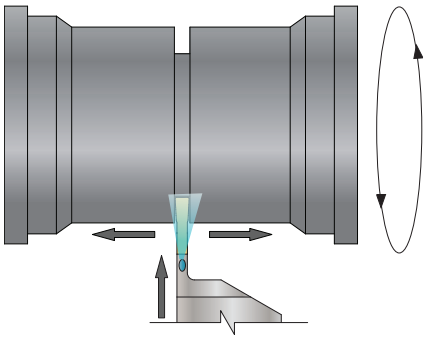
Metric L.H. Description	UPC No. 733101-	A	B	E	C2	F	TL	T-Max	Insert Size	Insert Style	Cartridge Included UPC	Cartridge Included Description	Clamp Screw	Cartridge Screw	Hex Key	Seal
ADDN-MTL-2020-C20-06	61354			44	89	30.2	133	6			61768	ADKDN-TL20-06				
ADDN-MTL-2020-C20-12	61355	20	20	50	89	30.2	139	12			61769	ADKDN-TL20-12				
ADDN-MTL-2020-C20-18	61356			56	89	30.2	145	18			61770	ADKDN-TL20-18				
ADDN-MTL-2525-D20-06	61357			44	102	35.2	146	6		DNTQ-222002-3EU-N	61768	ADKDN-TL20-06				
ADDN-MTL-2525-D20-12	61358	25	25	50	102	35.2	152	12	2	DNTQ-222502-3EU-N DNTR-220210-3EU-N	61769	ADKDN-TL20-12	CS-M0616	CS-M0620	HAHK-50	CS08-04
ADDN-MTL-2525-D20-18	61359			56	102	35.2	158	18		DNTF-222002-2EF-N	61770	ADKDN-TL20-18				
ADDN-MTL-3232-E20-06	61360			44	114	42.2	158	6		DNPG-222002-1SR-N	61768	ADKDN-TL20-06				
ADDN-MTL-3232-E20-12	61361	32	32	50	114	42.2	164	12			61769	ADKDN-TL20-12				
ADDN-MTL-3232-E20-18	61362			56	114	42.2	170	18			61770	ADKDN-TL20-18				

Inch L.H. Description	UPC No. 733101-	A	B	E	C2	F	TL	T-Max	Insert Size	Insert Style	Cartridge Included UPC	Cartridge Included Description	Clamp Screw	Cartridge Screw	Hex Key	Seal
ADDN-MTL-12-C20-06	61570			1.732	3.5	1.189	5.232	0.236			61768	ADKDN-TL20-06				
ADDN-MTL-12-C20-12	61571	0.75	0.75	1.969	3.5	1.189	5.469	0.472			61769	ADKDN-TL20-12				
ADDN-MTL-12-C20-18	61572			2.205	3.5	1.189	5.705	0.709			61770	ADKDN-TL20-18				
ADDN-MTL-16-D20-06	61573			1.732	4.0	1.386	5.732	0.236		DNTQ-222002-3EU-N	61768	ADKDN-TL20-06				
ADDN-MTL-16-D20-12	61574	1.00	1.00	1.969	4.0	1.386	5.969	0.472	0.079	DNTQ-222502-3EU-N DNTR-220210-3EU-N	61769	ADKDN-TL20-12	CS-M0616	CS-M0620	HAHK-50	CS08-04
ADDN-MTL-16-D20-18	61575			2.205	4.0	1.386	6.205	0.709		DNTF-222002-2EF-N	61770	ADKDN-TL20-18				
ADDN-MTL-20-E20-06	61576			1.732	4.5	1.661	6.232	0.236		DNPG-222002-1SR-N	61768	ADKDN-TL20-06				
ADDN-MTL-20-E20-12	61577	1.25	1.25	1.969	4.5	1.661	6.469	0.472			61769	ADKDN-TL20-12				
ADDN-MTL-20-E20-18	61578			2.205	4.5	1.661	6.705	0.709			61770	ADKDN-TL20-18				

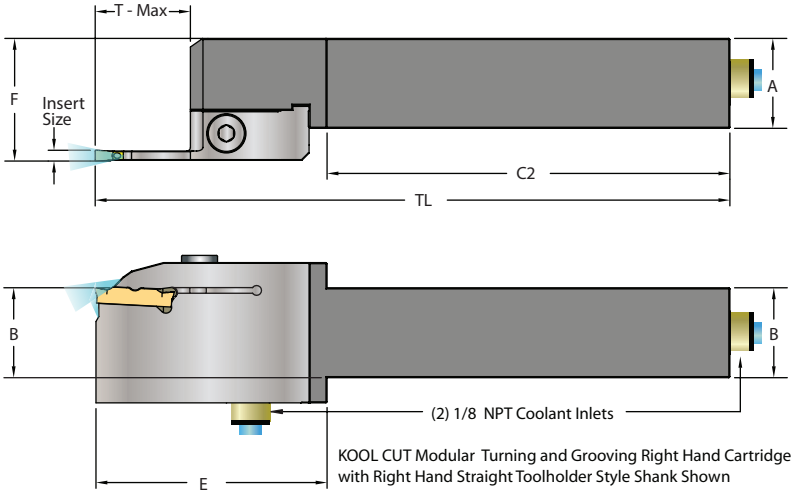
For ADKDN_ Cartridge specifications see pages F-26 - F-30. For Turning, Grooving & Parting Off inserts see Pages F-4-F-6.

KOOL Cut™ Modular Turning & Grooving Cartridge with Right Hand Straight Toolholder Style Shank for 3mm (.118") Insert Size

3mm (.118") Insert Size



R.H. Toolholder Counter Clockwise Rotation Shown L.H. Opposite



KOOL CUT Modular Turning and Grooving Right Hand Cartridge with Right Hand Straight Toolholder Style Shank Shown

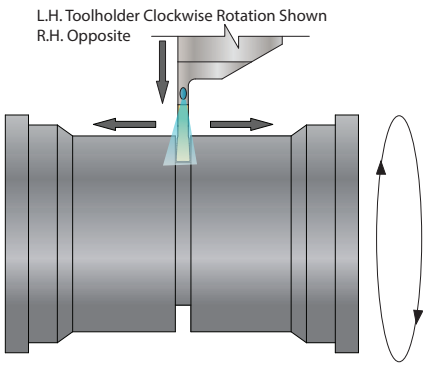
Metric R.H. Description	UPC No. 733101-	A	B	E	C2	F	TL	T-Max	Insert Size	Insert Style	Cartridge Included UPC	Cartridge Included Description	Clamp Screw	Cartridge Screw	Hex Key	Seal
ADDN-MTR-2020-C30-09	61309			47	89	30.3	136	9			61753	ADKDN-TR30-09				
ADDN-MTR-2020-C30-18	61310	20	20	56	89	30.3	145	18			61754	ADKDN-TR30-18				
ADDN-MTR-2020-C30-27	61311			65	89	30.3	154	27			61755	ADKDN-TR30-27				
ADDN-MTR--2525-D30-09	61312			47	102	35.3	149	9		DNTQ-223003-3EU-N	61753	ADKDN-TR30-09				
ADDN-MTR-2525-D30-18	61313	25	25	56	102	35.3	158	18	3	DNTR-223015-3EU-N DNTF-223002-2EF-N	61754	ADKDN-TR30-18	CS-M0616	CS-M0620	HAHK-50	CS08-04
ADDN-MTR-2525-D30-27	61314			65	102	35.3	167	27		DNPG-223002-1SR-N	61755	ADKDN-TR30-27				
ADDN-MTR-3232-E30-09	61315			47	114	42.3	161	9			61753	ADKDN-TR30-09				
ADDN-MTR-3232-E30-18	61316	32	32	56	114	42.3	170	18			61754	ADKDN-TR30-18				
ADDN-MTR-3232-E30-27	61317			65	114	42.3	179	27			61755	ADKDN-TR30-27				

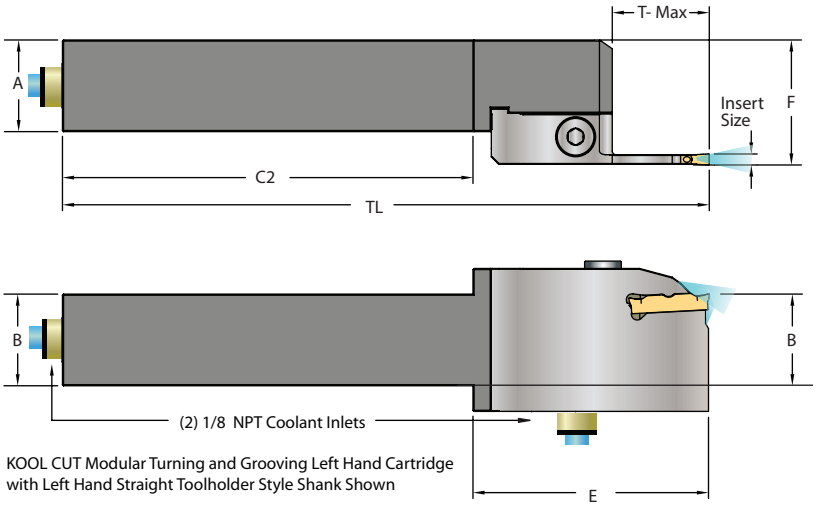
Inch R.H. Description	UPC No. 733101-	A	B	E	C2	F	TL	T-Max	Insert Size	Insert Style	Cartridge Included UPC	Cartridge Included Description	Clamp Screw	Cartridge Screw	Hex Key	Seal
ADDN-MTR-12-C30-09	61525			1.854	3.5	1.193	5.354	0.354			61753	ADKDN-TR30-09				
ADDN-MTR-12-C30-18	61526	0.75	0.75	2.209	3.5	1.193	5.709	0.709			61754	ADKDN-TR30-18				
ADDN-MTR-12-C30-27	61527			2.563	3.5	1.193	6.063	1.063			61755	ADKDN-TR30-27				
ADDN-MTR-16-D30-09	61528			1.854	4.0	1.390	5.854	0.354		DNTQ-223003-3EU-N	61753	ADKDN-TR30-09				
ADDN-MTR-16-D30-18	61529	1.00	1.00	2.209	4.0	1.390	6.209	0.709	0.118	DNTR-223015-3EU-N DNTF-223002-2EF-N	61754	ADKDN-TR30-18	CS-M0616	CS-M0620	HAHK-50	CS08-04
ADDN-MTR-16-D30-27	61530			2.563	4.0	1.390	6.563	1.063		DNPG-223002-1SR-N	61755	ADKDN-TR30-27				
ADDN-MTR-20-E30-09	61531			1.854	4.5	1.665	6.354	0.354			61753	ADKDN-TR30-09				
ADDN-MTR-20-E30-18	61532	1.25	1.25	2.209	4.5	1.665	6.709	0.709			61754	ADKDN-TR30-18				
ADDN-MTR-20-E30-27	61533			2.563	4.5	1.665	7.063	1.063			61755	ADKDN-TR30-27				

For ADKDN_ Cartridge specifications see pages F-26 - F-30. For Turning, Grooving & Parting Off inserts see Pages F-4-F-6.

KOOL Cut™ Modular Turning & Grooving Cartridge with Left Hand Straight Toolholder Style Shank for 3mm (.118") Insert Size

3mm (.118") Insert Size





KOOL CUT Modular Turning and Grooving Left Hand Cartridge with Left Hand Straight Toolholder Style Shank Shown

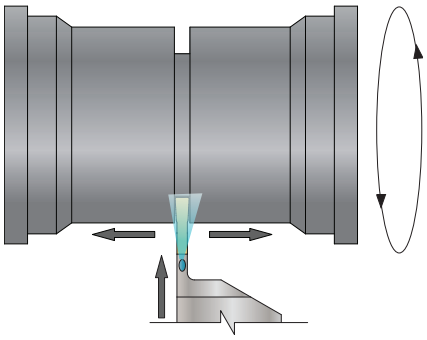
Metric L.H. Description	UPC No. 733101-	A	B	E	C2	F	TL	T-Max	Insert Size	Insert Style	Cartridge Included UPC	Cartridge Included Description	Clamp Screw	Cartridge Screw	Hex Key	Seal
ADDN-MTL-2020-C30-09	61363			47	89	30.3	136	9			61771	ADKDN-TL30-09				
ADDN-MTL-2020-C30-18	61364	20	20	56	89	30.3	145	18			61772	ADKDN-TL30-18				
ADDN-MTL-2020-C30-27	61365			65	89	30.3	154	27			61773	ADKDN-TL30-27				
ADDN-MTL-2525-D30-09	61366			47	102	35.3	149	9		DNTQ-223003-3EU-N	61771	ADKDN-TL30-09				
ADDN-MTL-2525-D30-18	61367	25	25	56	102	35.3	158	18	3	DNTR-223015-3EU-N DNTF-223002-2EF-N	61772	ADKDN-TL30-18	CS-M0616	CS-M0620	HAHK-50	CS08-04
ADDN-MTL-2525-D30-27	61368			65	102	35.3	167	27		DNPG-223002-1SR-N	61773	ADKDN-TL30-27				
ADDN-MTL-3232-E30-09	61369			47	114	42.3	161	9			61771	ADKDN-TL30-09				
ADDN-MTL-3232-E30-18	61370	32	32	56	114	42.3	170	18			61772	ADKDN-TL30-18				
ADDN-MTL-3232-E30-27	61371			65	114	42.3	179	27			61773	ADKDN-TL30-27				

Inch L.H. Description	UPC No. 733101-	A	B	E	C2	F	TL	T-Max	Insert Size	Insert Style	Cartridge Included UPC	Cartridge Included Description	Clamp Screw	Cartridge Screw	Hex Key	Seal
ADDN-MTL-12-C30-09	61579			1.854	3.5	1.193	5.354	0.354			61771	ADKDN-TL30-09				
ADDN-MTL-12-C30-18	61580	0.75	0.75	2.209	3.5	1.193	5.709	0.709			61772	ADKDN-TL30-18				
ADDN-MTL-12-C30-27	61581			2.563	3.5	1.193	6.063	1.063			61773	ADKDN-TL30-27				
ADDN-MTL-16-D30-09	61582			1.854	4.0	1.390	5.854	0.354		DNTQ-223003-3EU-N	61771	ADKDN-TL30-09				
ADDN-MTL-16-D30-18	61583	1.00	1.00	2.209	4.0	1.390	6.209	0.709	0.118	DNTR-223015-3EU-N DNTF-223002-2EF-N	61772	ADKDN-TL30-18	CS-M0616	CS-M0620	HAHK-50	CS08-04
ADDN-MTL-16-D30-27	61584			2.563	4.0	1.390	6.563	1.063		DNPG-223002-1SR-N	61773	ADKDN-TL30-27				
ADDN-MTL-20-E30-09	61585			1.854	4.5	1.665	6.354	0.354			61771	ADKDN-TL30-09				
ADDN-MTL-20-E30-18	61586	1.25	1.25	2.209	4.5	1.665	6.709	0.709			61772	ADKDN-TL30-18				
ADDN-MTL-20-E30-27	61587			2.563	4.5	1.665	7.063	1.063			61773	ADKDN-TL30-27				

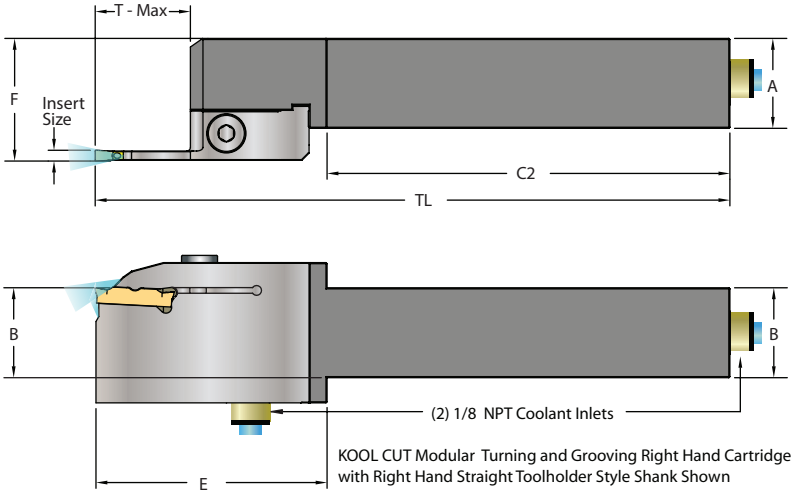
For ADKDN_ Cartridge specifications see pages F-26 - F-30. For Turning, Grooving & Parting Off inserts see Pages F-4-F-6.

KOOL Cut™ Modular Turning & Grooving Cartridge with Right Hand Straight Toolholder Style Shank for 4mm (.157") Insert Size

4mm (.157") Insert Size



R.H. Toolholder Counter Clockwise Rotation Shown L.H. Opposite



KOOL CUT Modular Turning and Grooving Right Hand Cartridge with Right Hand Straight Toolholder Style Shank Shown

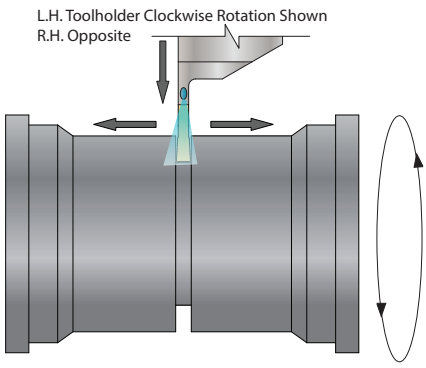
Metric R.H. Description	UPC No. 733101-	A	B	E	C2	F	TL	T-Max	Insert Size	Insert Style	Cartridge Included UPC	Cartridge Included Description	Clamp Screw	Cartridge Screw	Hex Key	Seal
ADDN-MTR-2020-C40-12	61318	20	20	56	89	30.4	139	12	4	DNTQ-254004-3EU-N DNTR-254020-3EU-N DNTF-254003-2EF-N DNPG-254003-1SR-N	61756	ADKDN-TR40-12	CS-M0616	CS-M0620	HAHK-50	CS08-04
ADDN-MTR-2020-C40-18	61319			56	89	30.4	145	18			61757	ADKDN-TR40-18				
ADDN-MTR-2020-C40-24	61320			62	89	30.4	151	24			61758	ADKDN-TR40-24				
ADDN-MTR-2020-C40-30	61321			74	89	30.4	163	30			61759	ADKDN-TR40-30				
ADDN-MTR-2525-D40-12	61322	25	25	56	102	35.4	152	12			61756	ADKDN-TR40-12				
ADDN-MTR-2525-D40-18	61323			56	102	35.4	158	18			61757	ADKDN-TR40-18				
ADDN-MTR-2525-D40-24	61324			62	102	35.4	164	24			61758	ADKDN-TR40-24				
ADDN-MTR-2525-D40-30	61325			74	102	35.4	176	30			61759	ADKDN-TR40-30				
ADDN-MTR-3232-E40-12	61326	32	32	56	114	42.4	164	12			61756	ADKDN-TR40-12				
ADDN-MTR-3232-E40-18	61327			56	114	42.4	170	18			61757	ADKDN-TR40-18				
ADDN-MTR-3232-E40-24	61328			62	114	42.4	176	24			61758	ADKDN-TR40-24				
ADDN-MTR-3232-E40-30	61329			74	114	42.4	188	30			61759	ADKDN-TR40-30				

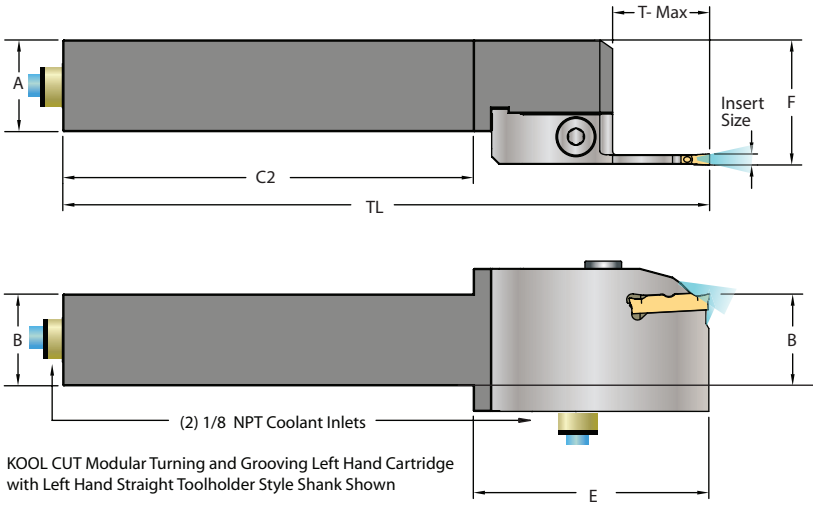
Inch R.H. Description	UPC No. 733101-	A	B	E	C2	F	TL	T-Max	Insert Size	Insert Style	Cartridge Included UPC	Cartridge Included Description	Clamp Screw	Cartridge Screw	Hex Key	Seal
ADDN-MTR-12-C40-12	61534	0.75	0.75	1.972	3.5	1.197	5.472	0.472	0.157	DNTQ-254004-3EU-N DNTR-254020-3EU-N DNTF-254003-2EF-N DNPG-254003-1SR-N	61756	ADKDN-TR40-12	CS-M0616	CS-M0620	HAHK-50	CS08-04
ADDN-MTR-12-C40-18	61535			2.209	3.5	1.197	5.709	0.709			61757	ADKDN-TR40-18				
ADDN-MTR-12-C40-24	61536			2.445	3.5	1.197	5.945	0.945			61758	ADKDN-TR40-24				
ADDN-MTR-12-C40-30	61537			2.771	3.5	1.197	6.417	1.180			61759	ADKDN-TR40-30				
ADDN-MTR-16-D40-12	61538	1.00	1.00	1.972	4.0	1.394	5.472	0.472			61756	ADKDN-TR40-12				
ADDN-MTR-16-D40-18	61539			2.209	4.0	1.394	5.709	0.709			61757	ADKDN-TR40-18				
ADDN-MTR-16-D40-24	61540			2.445	4.0	1.394	5.945	0.945			61758	ADKDN-TR40-24				
ADDN-MTR-16-D40-30	61541			2.771	4.0	1.394	6.417	1.180			61759	ADKDN-TR40-30				
ADDN-MTR-20-E40-12	61542	1.25	1.25	1.972	4.5	1.669	5.472	0.472			61756	ADKDN-TR40-12				
ADDN-MTR-20-E40-18	61543			2.209	4.5	1.669	5.709	0.709			61757	ADKDN-TR40-18				
ADDN-MTR-20-E40-24	61544			2.445	4.5	1.669	5.945	0.945			61758	ADKDN-TR40-24				
ADDN-MTR-20-E40-30	61545			2.771	4.5	1.669	6.417	1.180			61759	ADKDN-TR40-30				

For ADKDN_ Cartridge specifications see pages F-26 - F-30. For Turning, Grooving & Parting Off inserts see Pages F-4-F-6.

KOOL Cut™ Modular Turning & Grooving Cartridge with Left Hand Straight Toolholder Style Shank for 4mm (.157") Insert Size

4mm (.157") Insert Size





KOOL CUT Modular Turning and Grooving Left Hand Cartridge with Left Hand Straight Toolholder Style Shank Shown

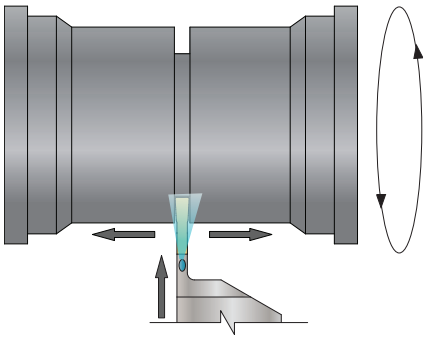
Metric L.H. Description	UPC No. 733101-	A	B	E	C2	F	TL	T-Max	Insert Size	Insert Style	Cartridge Included UPC	Cartridge Included Description	Clamp Screw	Cartridge Screw	Hex Key	Seal
ADDN-MTL-2020-C40-12	61372	20	20	56	89	30.4	139	12	4	DNTQ-254004-3EU-N DNTR-254020-3EU-N DNTF-254003-2EF-N DNPG-254003-1SR-N	61774	ADKDN-TL40-12	CS-M0616	CS-M0620	HAHK-50	CS08-04
ADDN-MTL-2020-C40-18	61373			56	89	30.4	145	18			61775	ADKDN-TL40-18				
ADDN-MTL-2020-C40-24	61374			62	89	30.4	151	24			61776	ADKDN-TL40-24				
ADDN-MTL-2020-C40-30	61375			74	89	30.4	163	30			61777	ADKDN-TL40-30				
ADDN-MTL-2525-D40-12	61376	25	25	56	102	35.4	152	12			61774	ADKDN-TL40-12				
ADDN-MTL-2525-D40-18	61377			56	102	35.4	158	18			61775	ADKDN-TL40-18				
ADDN-MTL-2525-D40-24	61378			62	102	35.4	164	24			61776	ADKDN-TL40-24				
ADDN-MTL-2525-D40-30	61379			74	102	35.4	176	30			61777	ADKDN-TL40-30				
ADDN-MTL-3232-E40-12	61380	32	32	56	114	42.4	164	12			61774	ADKDN-TL40-12				
ADDN-MTL-3232-E40-18	61381			56	114	42.4	170	18			61775	ADKDN-TL40-18				
ADDN-MTL-3232-E40-24	61382			62	114	42.4	176	24			61776	ADKDN-TL40-24				
ADDN-MTL-3232-E40-30	61383			74	114	42.4	188	30			61777	ADKDN-TL40-30				

Inch L.H. Description	UPC No. 733101-	A	B	E	C2	F	TL	T-Max	Insert Size	Insert Style	Cartridge Included UPC	Cartridge Included Description	Clamp Screw	Cartridge Screw	Hex Key	Seal
ADDN-MTL-12-C40-12	61588	0.75	0.75	1.972	3.5	1.197	5.472	0.472	0.157	DNTQ-254004-3EU-N DNTR-254020-3EU-N DNTF-254003-2EF-N DNPG-254003-1SR-N	61774	ADKDN-TL40-12	CS-M0616	CS-M0620	HAHK-50	CS08-04
ADDN-MTL-12-C40-18	61589			2.209	3.5	1.197	5.709	0.709			61775	ADKDN-TL40-18				
ADDN-MTL-12-C40-24	61590			2.445	3.5	1.197	5.945	0.945			61776	ADKDN-TL40-24				
ADDN-MTL-12-C40-30	61591			2.771	3.5	1.197	6.417	1.180			61777	ADKDN-TL40-30				
ADDN-MTL-16-D40-12	61592	1.00	1.00	1.972	4.0	1.394	5.472	0.472			61774	ADKDN-TL40-12				
ADDN-MTL-16-D40-18	61593			2.209	4.0	1.394	5.709	0.709			61775	ADKDN-TL40-18				
ADDN-MTL-16-D40-24	61594			2.445	4.0	1.394	5.945	0.945			61776	ADKDN-TL40-24				
ADDN-MTL-16-D40-30	61595			2.771	4.0	1.394	6.417	1.180			61777	ADKDN-TL40-30				
ADDN-MTL-20-E40-12	61596	1.25	1.25	1.972	4.5	1.669	5.472	0.472			61774	ADKDN-TL40-12				
ADDN-MTL-20-E40-18	61597			2.209	4.5	1.669	5.709	0.709			61775	ADKDN-TL40-18				
ADDN-MTL-20-E40-24	61598			2.445	4.5	1.669	5.945	0.945			61776	ADKDN-TL40-24				
ADDN-MTL-20-E40-30	61599			2.771	4.5	1.669	6.417	1.180			61777	ADKDN-TL40-30				

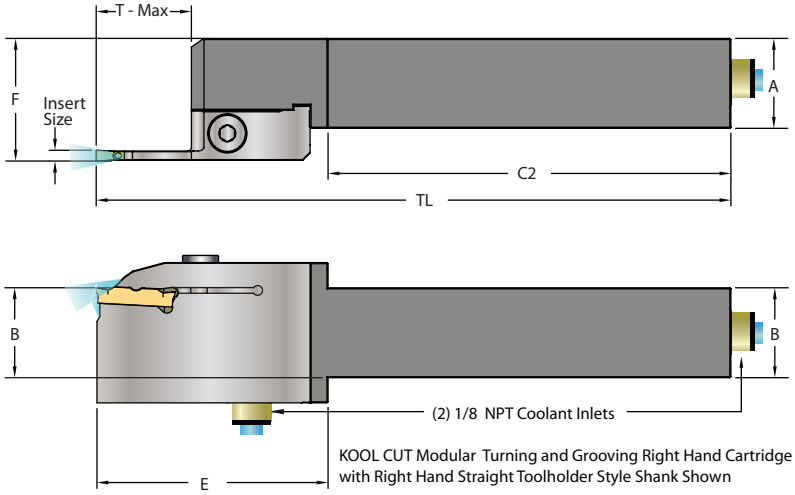
For ADKDN_ Cartridge specifications see pages F-26 - F-30. For Turning, Grooving & Parting Off inserts see Pages F-4-F-6.

KOOL Cut™ Modular Turning & Grooving Cartridge with Right Hand Straight Toolholder Style Shank for 5mm (.197") Insert Size

5mm (.197") Insert Size



R.H. Toolholder Counter Clockwise Rotation Shown L.H. Opposite



KOOL CUT Modular Turning and Grooving Right Hand Cartridge with Right Hand Straight Toolholder Style Shank Shown

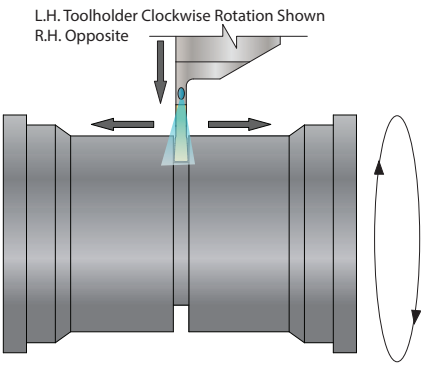
Metric R.H. Description	UPC No. 733101-	A	B	E	C2	F	TL	T-Max	Insert Size	Insert Style	Cartridge Included UPC	Cartridge Included Description	Clamp Screw	Cartridge Screw	Hex Key	Seal
ADDN-MTR-2020-C50-10	61330	20	20	48	89	30.4	137	10	5	DNTQ-255004-3EU-N DNTR-255025-3EU-N	61760	ADKDN-TR50-10	CS-M0616	CS-M0620	HAHK-50	CS08-04
ADDN-MTR-2020-C50-15	61331			53	89	30.4	142	15			61761	ADKDN-TR50-15				
ADDN-MTR-2020-C50-25	61332			63	89	30.4	152	25			61762	ADKDN-TR50-25				
ADDN-MTR-2020-C50-40	61333			83	89	30.4	172	45			61763	ADKDN-TR50-40				
ADDN-MTR-2525-D50-10	61334	25	25	48	102	35.4	150	10			61760	ADKDN-TR50-10				
ADDN-MTR-2525-D50-15	61335			53	102	35.4	155	15			61761	ADKDN-TR50-15				
ADDN-MTR-2525-D50-25	61336			63	102	35.4	165	25			61762	ADKDN-TR50-25				
ADDN-MTR-2525-D50-40	61337			83	102	35.4	185	45			61763	ADKDN-TR50-40				
ADDN-MTR-3232-E50-10	61338	32	32	48	114	42.4	162	10			61760	ADKDN-TR50-10				
ADDN-MTR-3232-E50-15	61339			53	114	42.4	167	15			61761	ADKDN-TR50-15				
ADDN-MTR-3232-E50-25	61340			63	114	42.4	177	25			61762	ADKDN-TR50-25				
ADDN-MTR-3232-E50-40	61341			83	114	42.4	197	45			61763	ADKDN-TR50-40				

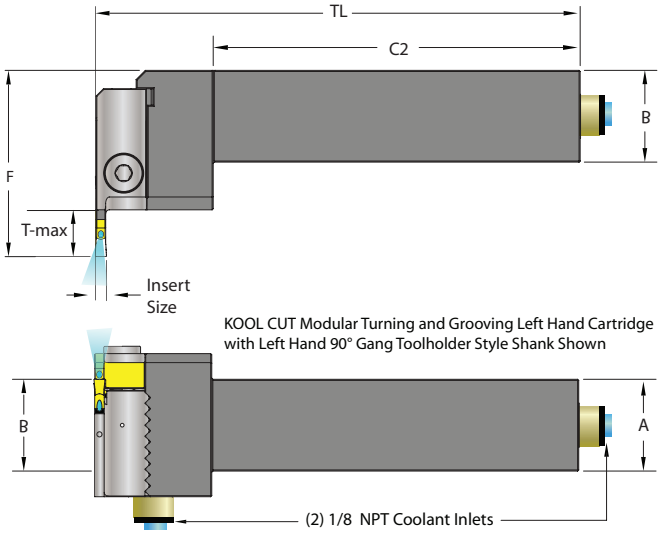
Inch R.H. Description	UPC No. 733101-	A	B	E	C2	F	TL	T-Max	Insert Size	Insert Style	Cartridge Included UPC	Cartridge Included Description	Clamp Screw	Cartridge Screw	Hex Key	Seal
ADDN-MTR-12-C50-10	61546	0.75	0.75	1.894	3.5	1.197	5.394	0.394	0.197	DNTQ-255004-3EU-N DNTR-255025-3EU-N	61760	ADKDN-TR50-10	CS-M0616	CS-M0620	HAHK-50	CS08-04
ADDN-MTR-12-C50-15	61547			2.091	3.5	1.197	5.591	0.591			61761	ADKDN-TR50-15				
ADDN-MTR-12-C50-25	61548			2.484	3.5	1.197	5.984	0.984			61762	ADKDN-TR50-25				
ADDN-MTR-12-C50-40	61549			3.272	3.5	1.197	6.772	1.772			61763	ADKDN-TR50-40				
ADDN-MTR-16-D50-10	61550	1.00	1.00	1.894	4.0	1.394	5.394	0.394			61760	ADKDN-TR50-10				
ADDN-MTR-16-D50-15	61551			2.091	4.0	1.394	5.591	0.591			61761	ADKDN-TR50-15				
ADDN-MTR-16-D50-25	61552			2.484	4.0	1.394	5.984	0.984			61762	ADKDN-TR50-25				
ADDN-MTR-16-D50-40	61553			3.272	4.0	1.394	6.772	1.772			61763	ADKDN-TR50-40				
ADDN-MTR-20-E50-10	61554	1.25	1.25	1.894	4.5	1.669	5.394	0.394			61760	ADKDN-TR50-10				
ADDN-MTR-20-E50-15	61555			2.091	4.5	1.669	5.591	0.591			61761	ADKDN-TR50-15				
ADDN-MTR-20-E50-25	61556			2.484	4.5	1.669	5.984	0.984			61762	ADKDN-TR50-25				
ADDN-MTR-20-E50-40	61557			3.272	4.5	1.669	6.772	1.772			61763	ADKDN-TR50-40				

For ADKDN_ Cartridge specifications see pages F-26 - F-30. For Turning, Grooving & Parting Off inserts see Pages F-4-F-6.

KOOL Cut™ Modular Turning & Grooving Cartridge with Left Hand 90° Gang Toolholder Style Shank for 4mm (.157") Insert Size

4mm (.157") Insert Size





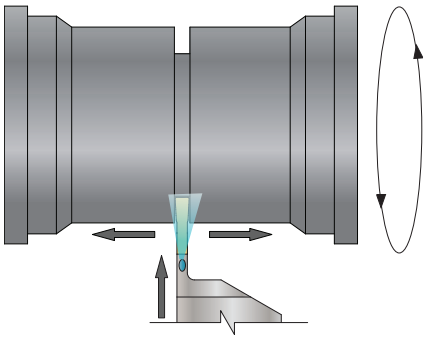
Metric L.H. Description	UPC No. 733101-	A	B	C2	F	TL	T-Max	Insert Size	Insert Style	Cartridge Included UPC	Cartridge Included Description	Clamp Screw	Cartridge Screw	Hex Key	Seal
ADDN-MGL-2020-C40-12	61480				50		12			61774	ADKDN-TL40-12				
ADDN-MGL-2020-C40-18	61481				56		18			61775	ADKDN-TL40-18				
ADDN-MGL-2020-C40-24	61482	20	20	89	62	122	24			61776	ADKDN-TL40-24				
ADDN-MGL-2020-C40-30	61483				74		30			61777	ADKDN-TL40-30				
ADDN-MGL-2525-D40-12	61484				50		12		DNTQ-254004-3EU-N	61774	ADKDN-TL40-12				
ADDN-MGL-2525-D40-18	61485				56		18		DNTR-254020-3EU-N	61775	ADKDN-TL40-18				
ADDN-MGL-2525-D40-24	61486	25	25	102	62	135	24	4	DNTF-254003-2EF-N	61776	ADKDN-TL40-24	CS-M0616	CS-M0620	HAHK-50	CS08-04
ADDN-MGL-2525-D40-30	61487				74		30		DNPG-254003-1SR-N	61777	ADKDN-TL40-30				
ADDN-MGL-3232-E40-12	61488				50		12			61774	ADKDN-TL40-12				
ADDN-MGL-3232-E40-18	61489				56		18			61775	ADKDN-TL40-18				
ADDN-MGL-3232-E40-24	61490	32	32	114	62	147	24			61776	ADKDN-TL40-24				
ADDN-MGL-3232-E40-30	61491				74		30			61777	ADKDN-TL40-30				

Inch L.H. Description	UPC No. 733101-	A	B	C2	F	TL	T-Max	Insert Size	Insert Style	Cartridge Included UPC	Cartridge Included Description	Clamp Screw	Cartridge Screw	Hex Key	Seal
ADDN-MGL-12-C40-12	61696				1.969		0.472			61774	ADKDN-TL40-12				
ADDN-MGL-12-C40-18	61697				2.205		0.709			61775	ADKDN-TL40-18				
ADDN-MGL-12-C40-24	61698	0.75	0.75	3.5	2.441	4.80	0.945			61776	ADKDN-TL40-24				
ADDN-MGL-12-C40-30	61699				2.913		1.180			61777	ADKDN-TL40-30				
ADDN-MGL-16-D40-12	61700				1.969		0.472		DNTQ-254004-3EU-N	61774	ADKDN-TL40-12				
ADDN-MGL-16-D40-18	61701				2.205		0.709		DNTR-254020-3EU-N	61775	ADKDN-TL40-18				
ADDN-MGL-16-D40-24	61702	1.00	1.00	4.0	2.441	5.30	0.945	0.157	DNTF-254003-2EF-N	61776	ADKDN-TL40-24	CS-M0616	CS-M0620	HAHK-50	CS08-04
ADDN-MGL-16-D40-30	61703				2.913		1.180		DNPG-254003-1SR-N	61777	ADKDN-TL40-30				
ADDN-MGL-20-E40-12	61704				1.969		0.472			61774	ADKDN-TL40-12				
ADDN-MGL-20-C40-18	61705				2.205		0.709			61775	ADKDN-TL40-18				
ADDN-MGL-20-E40-24	61706	1.25	1.25	4.5	2.441	5.80	0.945			61776	ADKDN-TL40-24				
ADDN-MGL-20-E40-30	61707				2.913		1.180			61777	ADKDN-TL40-30				

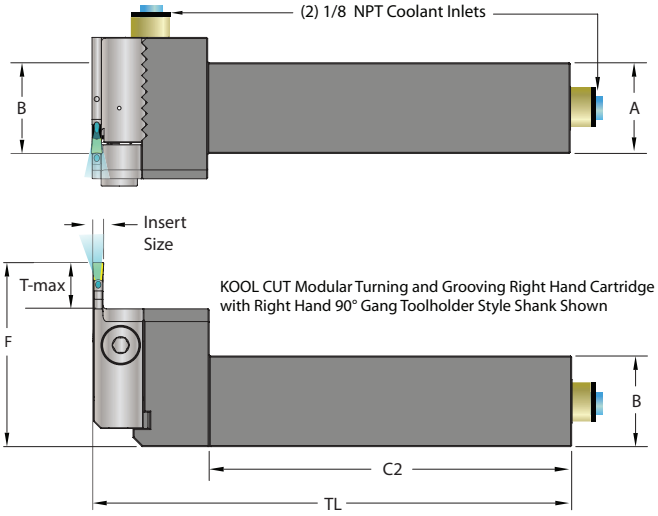
For ADKDN_ Cartridge specifications see pages F-26 - F-30. For Turning, Grooving & Parting Off inserts see Pages F-4-F-6.

KOOL Cut™ Modular Turning & Grooving Cartridge with Right Hand 90° Gang Toolholder Style Shank for 5mm (.197") Insert Size

5mm (.197") Insert Size



R.H. Toolholder Counter Clockwise Rotation Shown L.H. Opposite



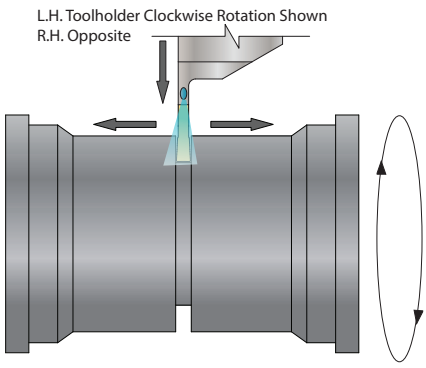
Metric R.H. Description	UPC No. 733101-	A	B	C2	F	TL	T-Max	Insert Size	Insert Style	Cartridge Included UPC	Cartridge Included Description	Clamp Screw	Cartridge Screw	Hex Key	Seal
ADDN-MGR-2020-C50-10	61438	20	20	89	53	122	15	5	DNTQ-255004-3EU-N DNTR-255025-3EU-N	61760	ADKDN-TR50-10	CS-M0616	CS-M0620	HAHK-50	CS08-04
ADDN-MGR-2020-C50-15	61439				53		15			61761	ADKDN-TR50-15				
ADDN-MGR-2020-C50-25	61440				63		25			61762	ADKDN-TR50-25				
ADDN-MGR-2020-C50-40	61441				83		45			61763	ADKDN-TR50-40				
ADDN-MGR-2525-D50-10	61442	25	25	102	48	135	10			61760	ADKDN-TR50-10				
ADDN-MGR-2525-D50-15	61443				53		15			61761	ADKDN-TR50-15				
ADDN-MGR-2525-D50-25	61444				63		25			61762	ADKDN-TR50-25				
ADDN-MGR-2525-D50-40	61445				83		45			61763	ADKDN-TR50-40				
ADDN-MGR-3232-E50-10	61446	32	32	114	48	147	10			61760	ADKDN-TR50-10				
ADDN-MGR-3232-E50-15	61447				53		15			61761	ADKDN-TR50-15				
ADDN-MGR-3232-E50-25	61448				63		25			61762	ADKDN-TR50-25				
ADDN-MGR-3232-E50-40	61449				83		45			61763	ADKDN-TR50-40				

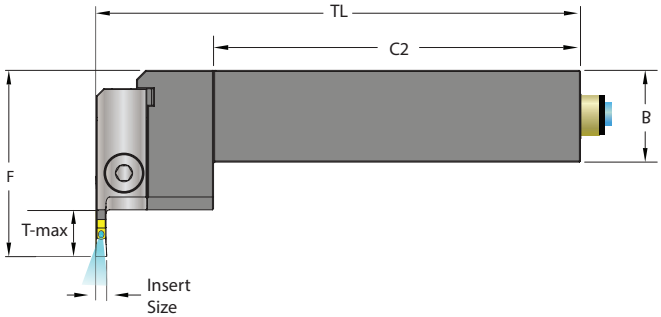
Inch R.H. Description	UPC No. 733101-	A	B	C2	F	TL	T-Max	Insert Size	Insert Style	Cartridge Included UPC	Cartridge Included Description	Clamp Screw	Cartridge Screw	Hex Key	Seal
ADDN-MGR-12-C50-10	61654	0.75	0.75	3.5	2.087	4.80	0.591	0.197	DNTQ-255004-3EU-N DNTR-255025-3EU-N	61760	ADKDN-TR50-10	CS-M0616	CS-M0620	HAHK-50	CS08-04
ADDN-MGR-12-C50-15	61655				2.087		0.591			61761	ADKDN-TR50-15				
ADDN-MGR-12-C50-25	61656				2.480		0.984			61762	ADKDN-TR50-25				
ADDN-MGR-12-C50-40	61657				3.268		1.772			61763	ADKDN-TR50-40				
ADDN-MGR-16-D50-10	61658	1.00	1.00	4.0	1.890	5.30	0.394			61760	ADKDN-TR50-10				
ADDN-MGR-16-D50-15	61659				2.087		0.591			61761	ADKDN-TR50-15				
ADDN-MGR-16-D50-25	61660				2.480		0.984			61762	ADKDN-TR50-25				
ADDN-MGR-16-D50-40	61661				3.268		1.772			61763	ADKDN-TR50-40				
ADDN-MGR-20-E50-10	61662	1.25	1.25	4.5	1.890	5.80	0.394			61760	ADKDN-TR50-10				
ADDN-MGR-20-E50-15	61663				2.087		0.591			61761	ADKDN-TR50-15				
ADDN-MGR-20-E50-25	61664				2.480		0.984			61762	ADKDN-TR50-25				
ADDN-MGR-20-E50-40	61665				3.268		1.772			61763	ADKDN-TR50-40				

For ADKDN_ Cartridge specifications see pages F-26 - F-30. For Turning, Grooving & Parting Off inserts see Pages F-4-F-6.

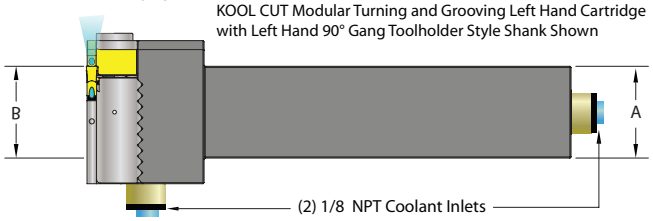
KOOL Cut™ Modular Turning & Grooving Cartridge with Left Hand 90° Gang Toolholder Style Shank for 5mm (.197") Insert Size

5mm (.197") Insert Size





KOOL CUT Modular Turning and Grooving Left Hand Cartridge with Left Hand 90° Gang Toolholder Style Shank Shown



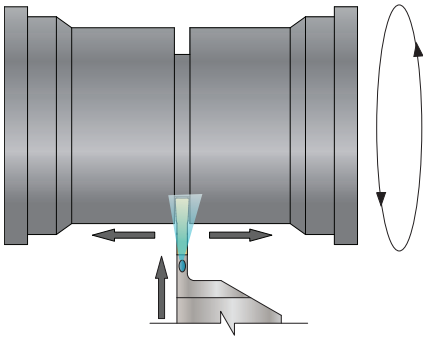
Metric L.H. Description	UPC No. 733101-	A	B	C2	F	TL	T-Max	Insert Size	Insert Style	Cartridge Included UPC	Cartridge Included Description	Clamp Screw	Cartridge Screw	Hex Key	Seal
ADDN-MGL-2020-C50-10	61492	20	20	89	53	122	15	5	DNTQ-255004-3EU-N DNTR-255025-3EU-N	61778	ADKDN-TL50-10	CS-M0616	CS-M0620	HAHK-50	CS08-04
ADDN-MGL-2020-C50-15	61493				53		15			61779	ADKDN-TL50-15				
ADDN-MGL-2020-C50-25	61494				63		25			61780	ADKDN-TL50-25				
ADDN-MGL-2020-C50-40	61495				83		45			61781	ADKDN-TL50-40				
ADDN-MGL-2525-D50-10	61496	25	25	102	48	135	10			61778	ADKDN-TL50-10				
ADDN-MGL-2525-D50-15	61497				53		15			61779	ADKDN-TL50-15				
ADDN-MGL-2525-D50-25	61498				63		25			61780	ADKDN-TL50-25				
ADDN-MGL-2525-D50-40	61499				83		45			61781	ADKDN-TL50-40				
ADDN-MGL-3232-E50-10	61500	32	32	114	48	147	10			61778	ADKDN-TL50-10				
ADDN-MGL-3232-E50-15	61501				53		15			61779	ADKDN-TL50-15				
ADDN-MGL-3232-E50-25	61502				63		25			61780	ADKDN-TL50-25				
ADDN-MGL-3232-E50-40	61503				83		45			61781	ADKDN-TL50-40				

Inch L.H. Description	UPC No. 733101-	A	B	C2	F	TL	T-Max	Insert Size	Insert Style	Cartridge Included UPC	Cartridge Included Description	Clamp Screw	Cartridge Screw	Hex Key	Seal
ADDN-MGL-12-C50-10	61708	0.75	0.75	3.5	2.087	4.80	0.591	0.197	DNTQ-255004-3EU-N DNTR-255025-3EU-N	61778	ADKDN-TL50-10	CS-M0616	CS-M0620	HAHK-50	CS08-04
ADDN-MGL-12-C50-15	61709				2.087		0.591			61779	ADKDN-TL50-15				
ADDN-MGL-12-C50-25	61710				2.480		0.984			61780	ADKDN-TL50-25				
ADDN-MGL-12-C50-40	61711				3.268		1.772			61781	ADKDN-TL50-40				
ADDN-MGL-16-D50-10	61712	1.00	1.00	4.0	1.890	5.30	0.394			61778	ADKDN-TL50-10				
ADDN-MGL-16-D50-15	61713				2.087		0.591			61779	ADKDN-TL50-15				
ADDN-MGL-16-D50-25	61714				2.480		0.984			61780	ADKDN-TL50-25				
ADDN-MGL-16-D50-40	61715				3.268		1.772			61781	ADKDN-TL50-40				
ADDN-MGL-20-E50-10	61716	1.25	1.25	4.5	1.890	5.80	0.394			61778	ADKDN-TL50-10				
ADDN-MGL-20-E50-15	61717				2.087		0.591			61779	ADKDN-TL50-15				
ADDN-MGL-20-E50-25	61718				2.480		0.984			61780	ADKDN-TL50-25				
ADDN-MGL-20-E50-40	61719				3.268		1.772			61781	ADKDN-TL50-40				

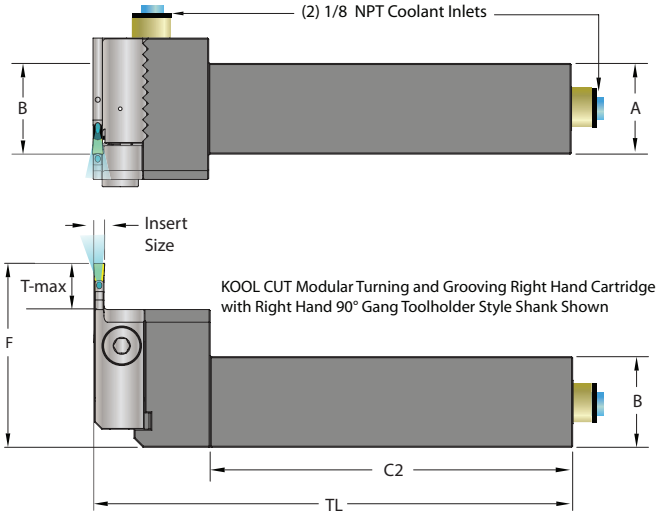
For ADKDN_ Cartridge specifications see pages F-26 - F-30. For Turning, Grooving & Parting Off inserts see Pages F-4-F-6.

KOOL Cut™ Modular Turning & Grooving Cartridge with Right Hand 90° Gang Toolholder Style Shank for 6mm (.236") Insert Size

6mm (.236") Insert Size



R.H. Toolholder Counter Clockwise Rotation Shown L.H. Opposite



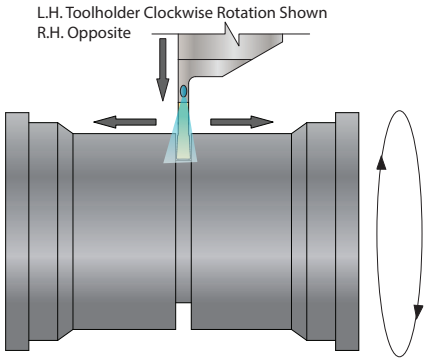
Metric R.H. Description	UPC No. 733101-	A	B	C2	F	TL	T-Max	Insert Size	Insert Style	Cartridge Included UPC	Cartridge Included Description	Clamp Screw	Cartridge Screw	Hex Key	Seal
ADDN-MGR-2020-C60-12	61450	20	20	89	50	122	12	6	DNTQ-256004-3EU-N DNTR-256030-3EU-N	61764	ADKDN-TR60-12	CS-M0616	CS-M0620	HAHK-50	CS08-04
ADDN-MGR-2020-C60-18	61451				56		18			61765	ADKDN-TR60-18				
ADDN-MGR-2020-C60-30	61452				68		30			61766	ADKDN-TR60-30				
ADDN-MGR-2020-C60-48	61453				86		48			61767	ADKDN-TR60-48				
ADDN-MGR-2525-D60-12	61454	25	25	102	50	135	12			61764	ADKDN-TR60-12				
ADDN-MGR-2525-D60-18	61455				56		18			61765	ADKDN-TR60-18				
ADDN-MGR-2525-D60-30	61456				68		30			61766	ADKDN-TR60-30				
ADDN-MGR-2525-D60-48	61457				86		48			61767	ADKDN-TR60-48				
ADDN-MGR-3232-E60-12	61458	32	32	114	50	147	12			61764	ADKDN-TR60-12				
ADDN-MGR-3232-E60-18	61459				56		18			61765	ADKDN-TR60-18				
ADDN-MGR-3232-E60-30	61460				68		30			61766	ADKDN-TR60-30				
ADDN-MGR-3232-E60-48	61461				86		48			61767	ADKDN-TR60-48				

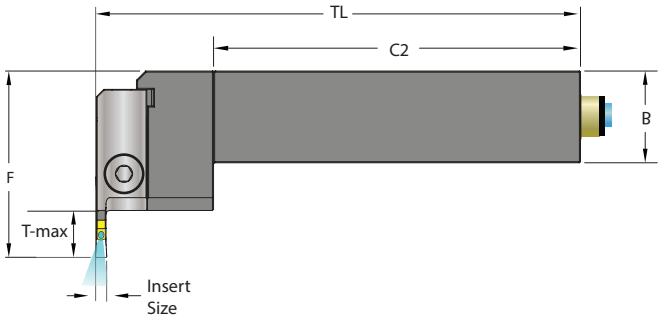
Inch R.H. Description	UPC No. 733101-	A	B	C2	F	TL	T-Max	Insert Size	Insert Style	Cartridge Included UPC	Cartridge Included Description	Clamp Screw	Cartridge Screw	Hex Key	Seal
ADDN-MGR-12-C60-12	61666	0.75	0.75	3.5	1.969	4.80	0.472	0.236	DNTQ-256004-3EU-N DNTR-256030-3EU-N	61764	ADKDN-TR60-12	CS-M0616	CS-M0620	HAHK-50	CS08-04
ADDN-MGR-12-C60-18	61667				2.205		0.709			61765	ADKDN-TR60-18				
ADDN-MGR-12-C60-30	61668				2.677		1.181			61766	ADKDN-TR60-30				
ADDN-MGR-12-C60-48	61669				3.386		1.890			61767	ADKDN-TR60-48				
ADDN-MGR-16-D60-12	61670	1.00	1.00	4.0	1.969	5.30	0.472			61764	ADKDN-TR60-12				
ADDN-MGR-16-D60-18	61671				2.205		0.709			61765	ADKDN-TR60-18				
ADDN-MGR-16-D60-30	61672				2.677		1.181			61766	ADKDN-TR60-30				
ADDN-MGR-16-D60-48	61673				3.386		1.890			61767	ADKDN-TR60-48				
ADDN-MGR-20-E60-12	61674	1.25	1.25	4.5	1.969	5.80	0.472			61764	ADKDN-TR60-12				
ADDN-MGR-20-E60-18	61675				2.205		0.709			61765	ADKDN-TR60-18				
ADDN-MGR-20-E60-30	61676				2.677		1.181			61766	ADKDN-TR60-30				
ADDN-MGR-20-E60-48	61677				3.386		1.890			61767	ADKDN-TR60-48				

For ADKDN_ Cartridge specifications see pages F-26 - F-30. For Turning, Grooving & Parting Off inserts see Pages F-4-F-6.

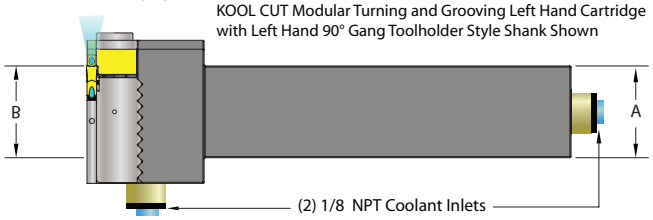
KOOL Cut™ Modular Turning & Grooving Cartridge with Left Hand 90° Gang Toolholder Style Shank for 6mm (.236") Insert Size

6mm (.236") Insert Size





KOOL CUT Modular Turning and Grooving Left Hand Cartridge with Left Hand 90° Gang Toolholder Style Shank Shown



Metric L.H. Description	UPC No. 733101-	A	B	C2	F	TL	T-Max	Insert Size	Insert Style	Cartridge Included UPC	Cartridge Included Description	Clamp Screw	Cartridge Screw	Hex Key	Seal
ADDN-MGL-2020-C60-12	61504	20	20	89	50	122	12	6	DNTQ-256004-3EU-N DNTR-256030-3EU-N	61782	ADKDN-TL60-12	CS-M0616	CS-M0620	HAHK-50	CS08-04
ADDN-MGL-2020-C60-18	61505				56		18			61783	ADKDN-TL60-18				
ADDN-MGL-2020-C60-30	61506				68		30			61784	ADKDN-TL60-30				
ADDN-MGL-2020-C60-48	61507				86		48			61785	ADKDN-TL60-48				
ADDN-MGL-2525-D60-12	61508	25	25	102	50	135	12			61782	ADKDN-TL60-12				
ADDN-MGL-2525-D60-18	61509				56		18			61783	ADKDN-TL60-18				
ADDN-MGL-2525-D60-30	61510				68		30			61784	ADKDN-TL60-30				
ADDN-MGL-2525-D60-48	61511				86		48			61785	ADKDN-TL60-48				
ADDN-MGL-3232-E60-12	61512	32	32	114	50	147	12			61782	ADKDN-TL60-12				
ADDN-MGL-3232-E60-18	61513				56		18			61783	ADKDN-TL60-18				
ADDN-MGL-3232-E60-30	61514				68		30			61784	ADKDN-TL60-30				
ADDN-MGL-3232-E60-48	61515				86		48			61785	ADKDN-TL60-48				

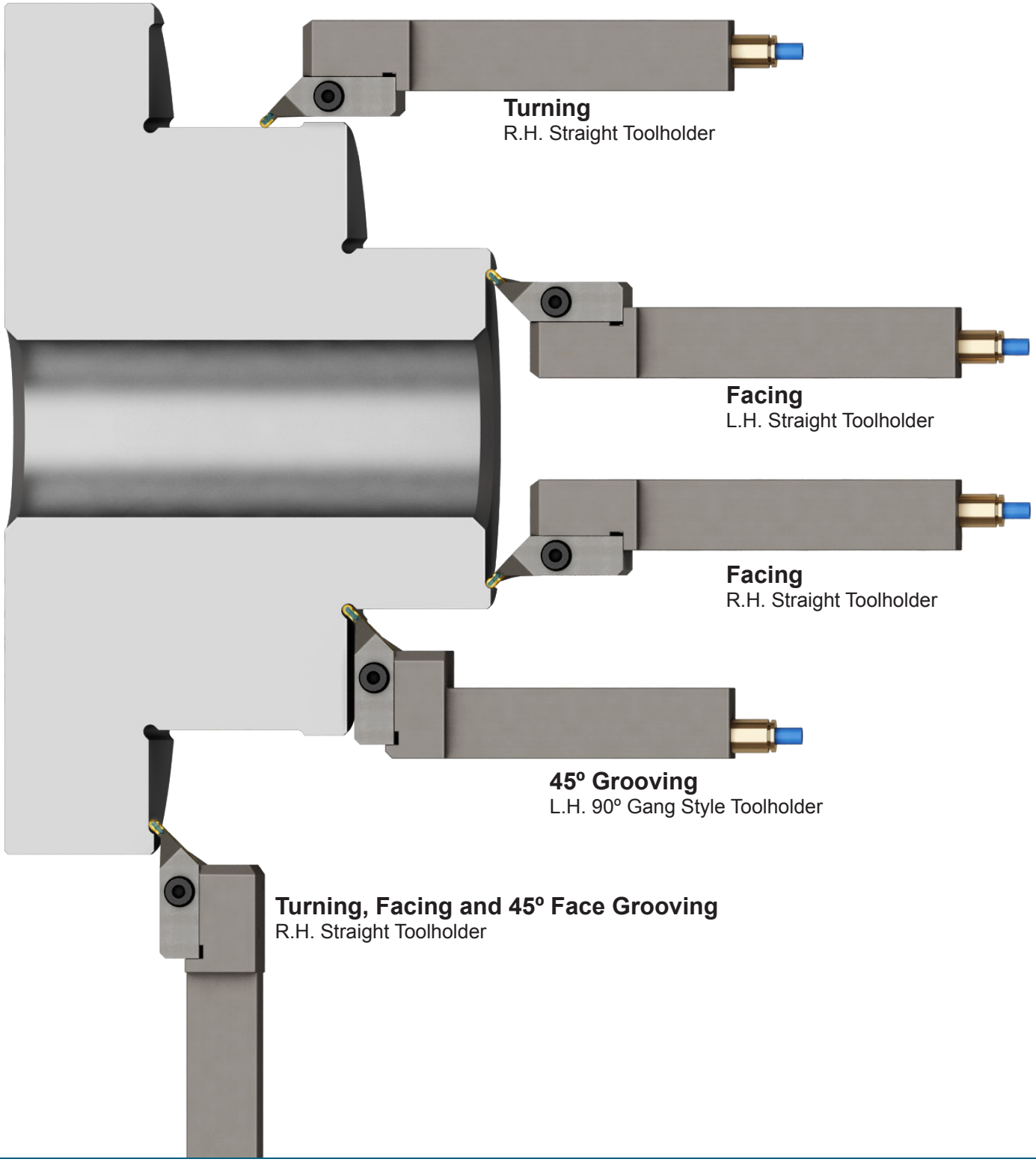
Inch L.H. Description	UPC No. 733101-	A	B	C2	F	TL	T-Max	Insert Size	Insert Style	Cartridge Included UPC	Cartridge Included Description	Clamp Screw	Cartridge Screw	Hex Key	Seal
ADDN-MGL-12-C60-12	61720	0.75	0.75	3.5	1.969	4.80	0.472	0.236	DNTQ-256004-3EU-N DNTR-256030-3EU-N	61782	ADKDN-TL60-12	CS-M0616	CS-M0620	HAHK-50	CS08-04
ADDN-MGL-12-C60-18	61721				2.205		0.709			61783	ADKDN-TL60-18				
ADDN-MGL-12-C60-30	61722				2.677		1.181			61784	ADKDN-TL60-30				
ADDN-MGL-12-C60-48	61723				3.386		1.890			61785	ADKDN-TL60-48				
ADDN-MGL-16-D60-12	61724	1.00	1.00	4.0	1.969	5.30	0.472			61782	ADKDN-TL60-12				
ADDN-MGL-16-D60-18	61725				2.205		0.709			61783	ADKDN-TL60-18				
ADDN-MGL-16-D60-30	61726				2.677		1.181			61784	ADKDN-TL60-30				
ADDN-MGL-16-D60-48	61727				3.386		1.890			61785	ADKDN-TL60-48				
ADDN-MGL-20-E60-12	61728	1.25	1.25	4.5	1.969	5.80	0.472			61782	ADKDN-TL60-12				
ADDN-MGL-20-E60-18	61729				2.205		0.709			61783	ADKDN-TL60-18				
ADDN-MGL-20-E60-30	61730				2.677		1.181			61784	ADKDN-TL60-30				
ADDN-MGL-20-E60-48	61731				3.386		1.890			61785	ADKDN-TL60-48				

For ADKDN_ Cartridge specifications see pages F-26 - F-30. For Turning, Grooving & Parting Off inserts see Pages F-4-F-6.

The KOOL Cut™

Modular 45° Turning and Grooving System

Expands the Flexibility of Multi-Operations with the Combination of Shanks Sizes & Cartridge Styles



Turning
R.H. Straight Toolholder

Facing
L.H. Straight Toolholder

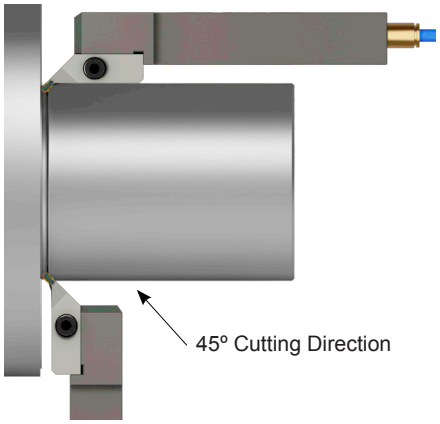
Facing
R.H. Straight Toolholder

45º Grooving
L.H. 90º Gang Style Toolholder

Turning, Facing and 45º Face Grooving
R.H. Straight Toolholder

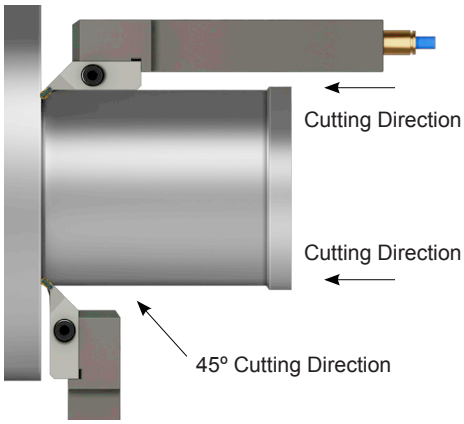
45° Grooving System-Multi Operation

45 º Grooving



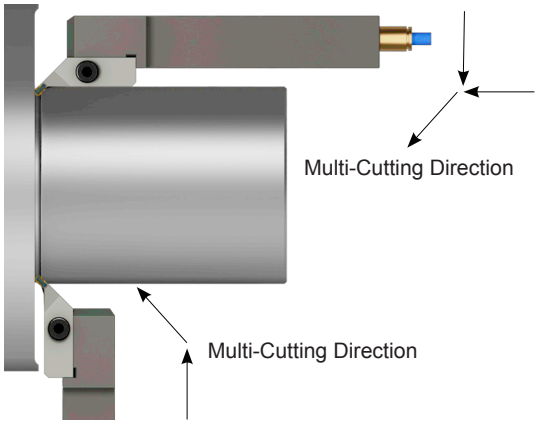
Grooving Maximum depth of Cut,
1 x Insert Diameter

Turning & 45 º Grooving



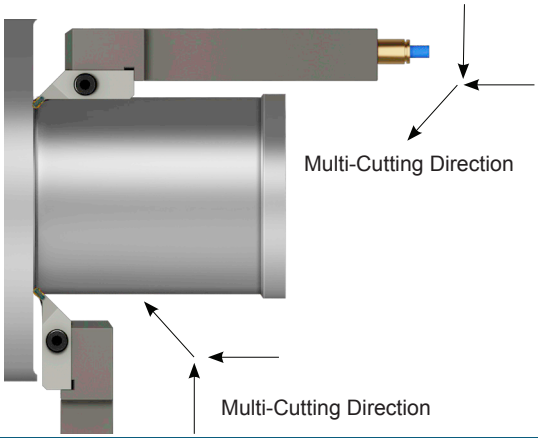
Turning Maximum depth of Cut,
2 x Insert Diameter

Facing & 45 º Grooving



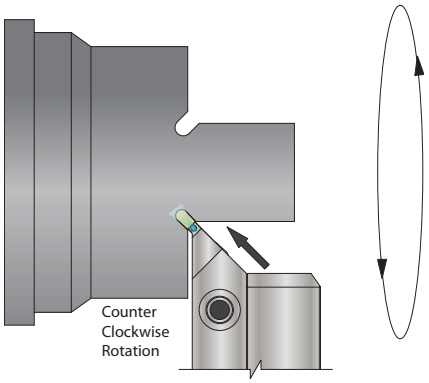
Facing Maximum depth of Cut,
2 x Insert Diameter

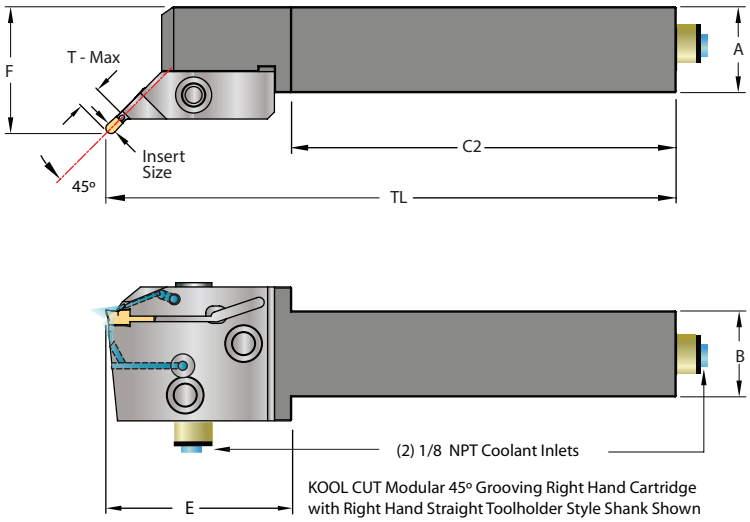
Turning, Facing & 45 º Grooving



Turning and Facing Maximum depth of Cut,
2 x Insert Diameter

KOOL Cut™ Modular 45º Grooving Cartridge with Right Hand Straight Toolholder Style Shank



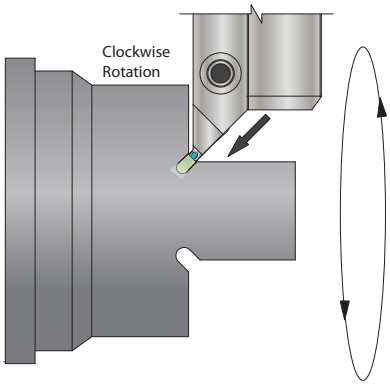


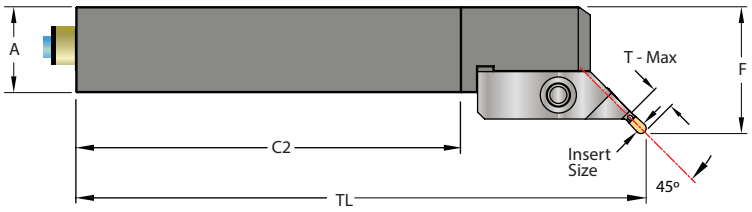
Metric R.H. Description	UPC No. 733101-	A	B	E	C2	F	TL	T-Max	Insert Size	Insert Style	Cartridge Included UPC	Cartridge Included Description	Clamp Screw	Cartridge Screw	Hex Key	Seal
ADDN-MTUR-2020-C20-05	62000	20	20	55	89	38	144									
ADDN-MTUR-2525-D20-05	62001	25	25	55	102	43	157	5	2	DNTR-220210-3EU-N	61910	ADKDN-UR20-05				
ADDN-MTUR-3232-E20-05	62002	32	32	55	114	50	169									
ADDN-MTUR-2020-C30-06	62003	20	20	56	89	39	145									
ADDN-MTUR-2525-D30-06	62004	25	25	56	102	44	158	6	3	DNTR-223015-3EU-N	61911	ADKDN-UR30-06				
ADDN-MTUR-3232-E30-06	62005	32	32	56	114	51	170									
ADDN-MTUR-2020-C40-08	62006	20	20	57	89	41	146									
ADDN-MTUR-2525-D40-08	62007	25	25	57	102	46	159	8	4	DNTR-254020-3EU-N	61912	ADKDN-UR40-08	CS-M0616	CS-M0620	HAHK-50	CS08-04
ADDN-MTUR-3232-E40-08	62008	32	32	57	114	53	171									
ADDN-MTUR-2020-C50-10	62039	20	20	58	89	42	147									
ADDN-MTUR-2525-C50-10	62040	25	25	58	102	47	160	10	5	DNTR-255025-3EU-N	61913	ADKDN-UR50-10				
ADDN-MTUR-3232-C50-10	62041	32	32	58	114	54	172									
ADDN-MTUR-2020-C60-12	62012	20	20	59	89	43	148									
ADDN-MTUR-2525-D60-12	62013	25	25	59	102	48	161	12	6	DNTR-256030-3EU-N	61914	ADKDN-UR60-12				
ADDN-MTUR-3232-E60-12	62014	32	32	59	114	55	173									

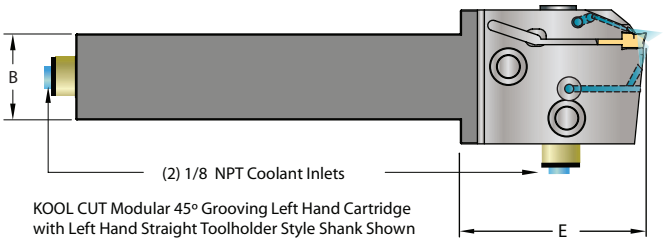
Inch R.H. Description	UPC No. 733101-	A	B	E	C2	F	TL	T-Max	Insert Size	Insert Style	Cartridge Included UPC	Cartridge Included Description	Clamp Screw	Cartridge Screw	Hex Key	Seal
ADDN-MTUR-12-C20-05	62060	0.75	0.75	2.283	3.50	1.496	5.67									
ADDN-MTUR-16-D20-05	62061	1.00	1.00	2.283	4.00	1.693	6.18	0.197	0.079	DNTR-220210-3EU-N	61910	ADKDN-UR20-05				
ADDN-MTUR-20-E20-05	62062	1.25	1.25	2.283	4.50	1.969	6.65									
ADDN-MTUR-12-C30-06	62063	0.75	0.75	2.205	3.50	1.535	5.71									
ADDN-MTUR-16-D30-06	62064	1.00	1.00	2.205	4.00	1.732	6.22	0.236	0.118	DNTR-223015-3EU-N	61911	ADKDN-UR30-06				
ADDN-MTUR-20-E30-06	62065	1.25	1.25	2.205	4.50	2.008	6.69									
ADDN-MTUR-12-C40-08	62066	0.75	0.75	2.244	3.50	1.614	5.75									
ADDN-MTUR-16-D40-08	62067	1.00	1.00	2.244	4.00	1.811	6.26	0.315	0.157	DNTR-254020-3EU-N	61912	ADKDN-UR40-08	CS-M0616	CS-M0620	HAHK-50	CS08-04
ADDN-MTUR-20-E40-08	62068	1.25	1.25	2.244	4.50	2.087	6.73									
ADDN-MTUR-12-C50-10	62069	0.75	0.75	2.283	3.50	1.654	5.79									
ADDN-MTUR-16-D50-10	62070	1.00	1.00	2.283	4.00	1.850	6.30	0.394	0.197	DNTR-255025-3EU-N	61913	ADKDN-UR50-10				
ADDN-MTUR-20-E50-10	62071	1.25	1.25	2.283	4.50	2.126	6.77									
ADDN-MTUR-12-C60-12	62072	0.75	0.75	2.323	3.50	1.693	5.83									
ADDN-MTUR-16-D60-12	62073	1.00	1.00	2.323	4.00	1.890	6.34	0.472	0.236	DNTR-256030-3EU-N	61914	ADKDN-UR60-12				
ADDN-MTUR-20-E60-12	62074	1.25	1.25	2.323	4.50	2.165	6.81									

For ADKDN_ Cartridge specifications see pages F-26 - F-30. For Turning, Grooving & Parting Off inserts see Pages F-4-F-6.

KOOL Cut™ Modular 45º Grooving Cartridge with Left Hand Straight Toolholder Style Shank







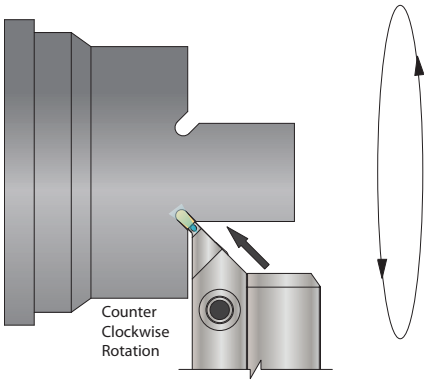
KOOL CUT Modular 45º Grooving Left Hand Cartridge with Left Hand Straight Toolholder Style Shank Shown

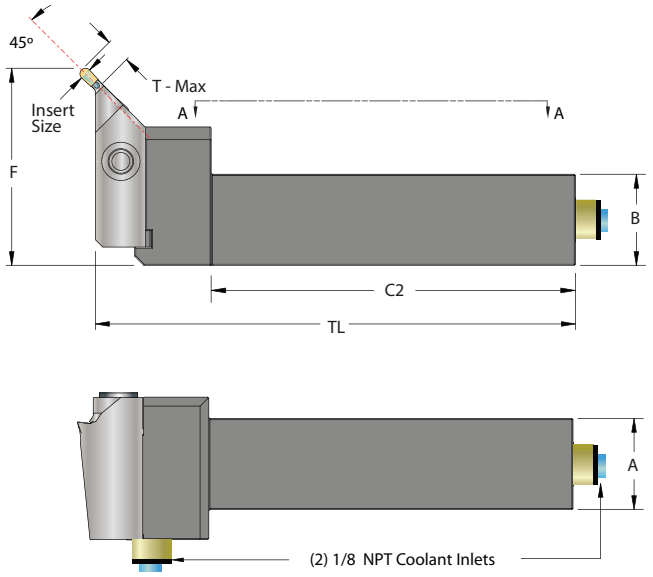
Metric L.H. Description	UPC No. 733101-	A	B	E	C2	F	TL	T-Max	Insert Size	Insert Style	Cartridge Included UPC	Cartridge Included Description	Clamp Screw	Cartridge Screw	Hex Key	Seal
ADDN-MTUL-2020-C20-05	62015	20	20	55	89	38	144									
ADDN-MTUL-2525-D20-05	62016	25	25	55	102	43	157	5	2	DNTR-220210-3EU-N	61915	ADKDN-UL20-05				
ADDN-MTUL-3232-E20-05	62017	32	32	55	114	50	169									
ADDN-MTUL-2020-C30-06	62018	20	20	56	89	39	145									
ADDN-MTUL-2525-D30-06	62019	25	25	56	102	44	158	6	3	DNTR-223015-3EU-N	61916	ADKDN-UL30-06				
ADDN-MTUL-3232-E30-06	62020	32	32	56	114	51	170									
ADDN-MTUL-2020-C40-08	62021	20	20	57	89	41	146									
ADDN-MTUL-2525-D40-08	62022	25	25	57	102	46	159	8	4	DNTR-254020-3EU-N	61917	ADKDN-UL40-08	CS-M0616	CS-M0620	HAHK-50	CS08-04
ADDN-MTUL-3232-E40-08	62023	32	32	57	114	53	171									
ADDN-MTUL-2020-C50-10	62024	20	20	58	89	42	147									
ADDN-MTUL-2525-C50-10	62025	25	25	58	102	47	160	10	5	DNTR-255025-3EU-N	61918	ADKDN-UL50-10				
ADDN-MTUL-3232-C50-10	62026	32	32	58	114	54	172									
ADDN-MTUL-2020-C60-12	62027	20	20	59	89	43	148									
ADDN-MTUL-2525-D60-12	62028	25	25	59	102	48	161	12	6	DNTR-256030-3EU-N	61919	ADKDN-UL60-12				
ADDN-MTUL-3232-E60-12	62029	32	32	59	114	55	173									

Inch L.H. Description	UPC No. 733101-	A	B	E	C2	F	TL	T-Max	Insert Size	Insert Style	Cartridge Included UPC	Cartridge Included Description	Clamp Screw	Cartridge Screw	Hex Key	Seal
ADDN-MTUL-12-C20-05	62075	0.75	0.75	2.283	3.5	1.496	5.67									
ADDN-MTUL-16-D20-05	62076	1.00	1.00	2.283	4.0	1.693	6.18	0.197	0.079	DNTR-220210-3EU-N	61915	ADKDN-UL20-05				
ADDN-MTUL-20-E20-05	62077	1.25	1.25	2.283	4.5	1.969	6.65									
ADDN-MTUL-12-C30-06	62078	0.75	0.75	2.205	3.5	1.535	5.71									
ADDN-MTUL-16-D30-06	62079	1.00	1.00	2.205	4.0	1.732	6.22	0.236	0.118	DNTR-223015-3EU-N	61916	ADKDN-UL30-06				
ADDN-MTUL-20-E30-06	62080	1.25	1.25	2.205	4.5	2.008	6.69									
ADDN-MTUL-12-C40-08	62081	0.75	0.75	2.244	3.5	1.614	5.75									
ADDN-MTUL-16-D40-08	62082	1.00	1.00	2.244	4.0	1.811	6.26	0.315	0.157	DNTR-254020-3EU-N	61917	ADKDN-UL40-08	CS-M0616	CS-M0620	HAHK-50	CS08-04
ADDN-MTUL-20-E40-08	62083	1.25	1.25	2.244	4.5	2.087	6.73									
ADDN-MTUL-12-C50-10	62084	0.75	0.75	2.283	3.5	1.654	5.79									
ADDN-MTUL-16-D50-10	62085	1.00	1.00	2.283	4.0	1.850	6.30	0.394	0.197	DNTR-255025-3EU-N	61918	ADKDN-UL50-10				
ADDN-MTUL-20-E50-10	62086	1.25	1.25	2.283	4.5	2.126	6.77									
ADDN-MTUL-12-C60-12	62087	0.75	0.75	2.323	3.5	1.693	5.83									
ADDN-MTUL-16-D60-12	62088	1.00	1.00	2.323	4.0	1.890	6.34	0.472	0.236	DNTR-256030-3EU-N	61919	ADKDN-UL60-12				
ADDN-MTUL-20-E60-12	62089	1.25	1.25	2.323	4.5	2.165	6.81									

For ADKDN_ Cartridge specifications see pages F-26 - F-30. For Turning, Grooving & Parting Off inserts see Pages F-4-F-6.

KOOL Cut™ Modular 45º Grooving Cartridge with Right Hand 90º Gang Toolholder Style Shank



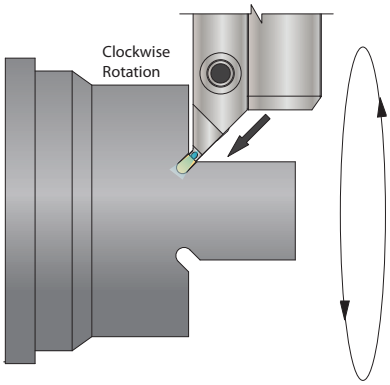


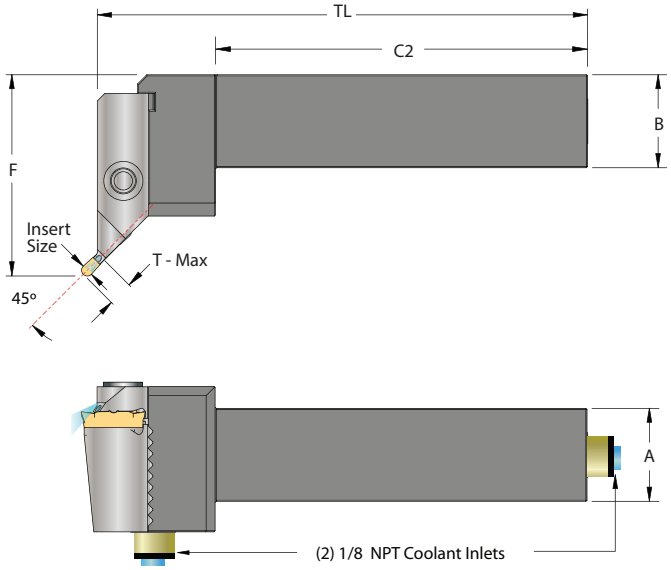
Metric R.H. Description	UPC No. 733101-	A	B	E	C2	F	TL	T-Max	Insert Size	Insert Style	Cartridge Included UPC	Cartridge Included Description	Clamp Screw	Cartridge Screw	Hex Key	Seal
ADDN-MGUR-2020-C20-05	62030	20	20	41	89	55	130									
ADDN-MGUR-2525-D20-05	62031	25	25	41	102	55	143	5	2	DNTR-220210-3EU-N	61910	ADKDN-UR20-05				
ADDN-MGUR-3232-E20-05	62032	32	32	41	114	55	155									
ADDN-MGUR-2020-C30-06	62033	20	20	42	89	56	131									
ADDN-MGUR-2525-D30-06	62034	25	25	42	102	56	144	6	3	DNTR-223015-3EU-N	61911	ADKDN-UR30-06				
ADDN-MGUR-3232-E30-06	62035	32	32	42	114	56	156									
ADDN-MGUR-2020-C40-08	62036	20	20	44	89	57	133									
ADDN-MGUR-2525-D40-08	62037	25	25	44	102	57	146	8	4	DNTR-254020-3EU-N	61912	ADKDN-UR40-08	CS-M0616	CS-M0620	HAHK-50	CS08-04
ADDN-MGUR-3232-E40-08	62038	32	32	44	114	57	158									
ADDN-MGUR-2020-C50-10	62039	20	20	45	89	58	134									
ADDN-MGUR-2525-C50-10	62040	25	25	45	102	58	147	10	5	DNTR-255025-3EU-N	61913	ADKDN-UR50-10				
ADDN-MGUR-3232-C50-10	62041	32	32	45	114	58	159									
ADDN-MGUR-2020-C60-12	62042	20	20	46	89	59	135									
ADDN-MGUR-2525-D60-12	62043	25	25	46	102	59	148	12	6	DNTR-256030-3EU-N	61914	ADKDN-UR60-12				
ADDN-MGUR-3232-E60-12	62044	32	32	46	114	59	160									

Inch R.H. Description	UPC No. 733101-	A	B	E	C2	F	TL	T-Max	Insert Size	Insert Style	Cartridge Included UPC	Cartridge Included Description	Clamp Screw	Cartridge Screw	Hex Key	Seal
ADDN-MGUR-12-C20-05	62090	0.75	0.75	1.61	3.50	2.165	5.12									
ADDN-MGUR-16-D20-05	62091	1.00	1.00	1.61	4.00	2.165	5.63	0.197	0.079	DNTR-220210-3EU-N	61910	ADKDN-UR20-05				
ADDN-MGUR-20-E20-05	62092	1.25	1.25	1.61	4.50	2.165	6.10									
ADDN-MGUR-12-C30-06	62093	0.75	0.75	1.65	3.50	2.205	5.16									
ADDN-MGUR-16-D30-06	62094	1.00	1.00	1.65	4.00	2.205	5.67	0.236	0.118	DNTR-223015-3EU-N	61911	ADKDN-UR30-06				
ADDN-MGUR-20-E30-06	62095	1.25	1.25	1.65	4.50	2.205	6.14									
ADDN-MGUR-12-C40-08	62096	0.75	0.75	1.73	3.50	2.244	5.24									
ADDN-MGUR-16-D40-08	62097	1.00	1.00	1.73	4.00	2.244	5.75	0.315	0.157	DNTR-254020-3EU-N	61912	ADKDN-UR40-08	CS-M0616	CS-M0620	HAHK-50	CS08-04
ADDN-MGUR-20-E40-08	62098	1.25	1.25	1.73	4.50	2.244	6.22									
ADDN-MGUR-12-C50-10	62099	0.75	0.75	1.77	3.50	2.283	5.28									
ADDN-MGUR-16-D50-10	62100	1.00	1.00	1.77	4.00	2.283	5.79	0.394	0.197	DNTR-255025-3EU-N	61913	ADKDN-UR50-10				
ADDN-MGUR-20-E50-10	62101	1.25	1.25	1.77	4.50	2.283	6.26									
ADDN-MGUR-12-C60-12	62102	0.75	0.75	1.81	3.50	2.323	5.31									
ADDN-MGUR-16-D60-12	62103	1.00	1.00	1.81	4.00	2.323	5.83	0.472	0.236	DNTR-256030-3EU-N	61914	ADKDN-UR60-12				
ADDN-MGUR-20-E60-12	62104	1.25	1.25	1.81	4.50	2.323	6.30									

For ADKDN_ Cartridge specifications see pages F-26 - F-30. For Turning, Grooving & Parting Off inserts see Pages F-4-F-6.

KOOL Cut™ Modular 45º Grooving Cartridge with Left Hand 90º Gang Toolholder Style Shank



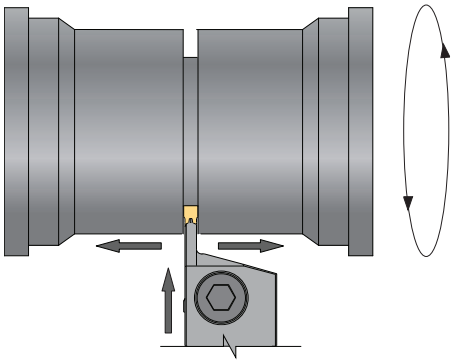


Metric L.H. Description	UPC No. 733101-	A	B	E	C2	F	TL	T-Max	Insert Size	Insert Style	Cartridge Included UPC	Cartridge Included Description	Clamp Screw	Cartridge Screw	Hex Key	Seal
ADDN-MGUL-2020-C20-05	62045	20	20	41	89	55	130									
ADDN-MGUL-2525-D20-05	62046	25	25	41	102	55	143	5	2	DNTR-220210-3EU-N	61915	ADKDN-UL20-05				
ADDN-MGUL-3232-E20-05	62047	32	32	41	114	55	155									
ADDN-MGUL-2020-C30-06	62048	20	20	42	89	56	131									
ADDN-MGUL-2525-D30-06	62049	25	25	42	102	56	144	6	3	DNTR-223015-3EU-N	61916	ADKDN-UL30-06				
ADDN-MGUL-3232-E30-06	62050	32	32	42	114	56	156									
ADDN-MGUL-2020-C40-08	62051	20	20	44	89	57	133									
ADDN-MGUL-2525-D40-08	62052	25	25	44	102	57	146	8	4	DNTR-254020-3EU-N	61917	ADKDN-UL40-08	CS-M0616	CS-M0620	HAHK-50	CS08-04
ADDN-MGUL-3232-E40-08	62053	32	32	44	114	57	158									
ADDN-MGUL-2020-C50-10	62054	20	20	45	89	58	134									
ADDN-MGUL-2525-C50-10	62055	25	25	45	102	58	147	10	5	DNTR-255025-3EU-N	61918	ADKDN-UL50-10				
ADDN-MGUL-3232-C50-10	62056	32	32	45	114	58	159									
ADDN-MGUL-2020-C60-12	62057	20	20	46	89	59	135									
ADDN-MGUL-2525-D60-12	62058	25	25	46	102	59	148	12	6	DNTR-256030-3EU-N	61919	ADKDN-UL60-12				
ADDN-MGUL-3232-E60-12	62059	32	32	46	114	59	160									

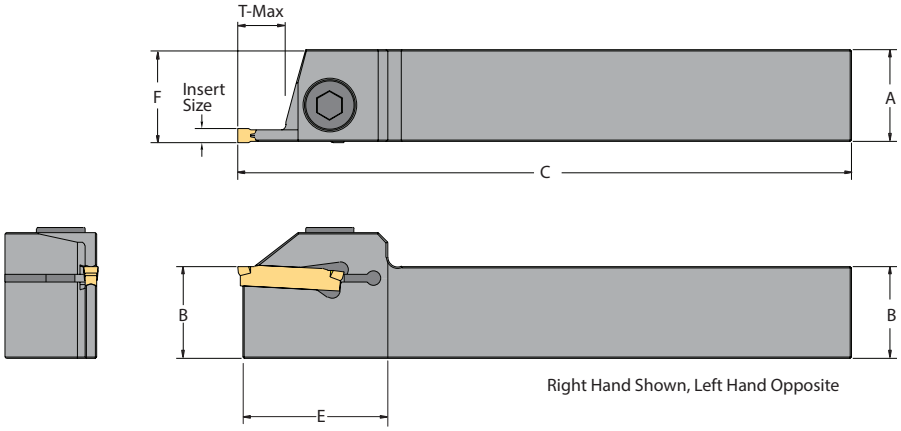
Inch L.H. Description	UPC No. 733101-	A	B	E	C2	F	TL	T-Max	Insert Size	Insert Style	Cartridge Included UPC	Cartridge Included Description	Clamp Screw	Cartridge Screw	Hex Key	Seal
ADDN-MGUL-12-C20-05	62105	0.75	0.75	1.61	3.50	2.165	5.12									
ADDN-MGUL-16-D20-05	62106	1.00	1.00	1.61	4.00	2.165	5.63	0.197	0.079	DNTR-220210-3EU-N	61915	ADKDN-UL20-05				
ADDN-MGUL-20-E20-05	62107	1.25	1.25	1.61	4.50	2.165	6.10									
ADDN-MGUL-12-C30-06	62108	0.75	0.75	1.65	3.50	2.205	5.16									
ADDN-MGUL-16-D30-06	62109	1.00	1.00	1.65	4.00	2.205	5.67	0.236	0.118	DNTR-223015-3EU-N	61916	ADKDN-UL30-06				
ADDN-MGUL-20-E30-06	62110	1.25	1.25	1.65	4.50	2.205	6.14									
ADDN-MGUL-12-C40-08	62111	0.75	0.75	1.73	3.50	2.244	5.24									
ADDN-MGUL-16-D40-08	62112	1.00	1.00	1.73	4.00	2.244	5.75	0.315	0.157	DNTR-254020-3EU-N	61917	ADKDN-UL40-08	CS-M0616	CS-M0620	HAHK-50	CS08-04
ADDN-MGUL-20-E40-08	62113	1.25	1.25	1.73	4.50	2.244	6.22									
ADDN-MGUL-12-C50-10	62114	0.75	0.75	1.77	3.50	2.283	5.28									
ADDN-MGUL-16-D50-10	62115	1.00	1.00	1.77	4.00	2.283	5.79	0.394	0.197	DNTR-255025-3EU-N	61918	ADKDN-UL50-10				
ADDN-MGUL-20-E50-10	62116	1.25	1.25	1.77	4.50	2.283	6.26									
ADDN-MGUL-12-C60-12	62117	0.75	0.75	1.81	3.50	2.323	5.31									
ADDN-MGUL-16-D60-12	62118	1.00	1.00	1.81	4.00	2.323	5.83	0.472	0.236	DNTR-256030-3EU-N	61919	ADKDN-UL60-12				
ADDN-MGUL-20-E60-12	62119	1.25	1.25	1.81	4.50	2.323	6.30									

For ADKDN_ Cartridge specifications see pages F-26 - F-30. For Turning, Grooving & Parting Off inserts see Pages F-4-F-6.

Turning & Grooving Right Hand & Left Hand Toolholder



Right Hand Shown, Left Hand Opposite



Right Hand Shown, Left Hand Opposite

2mm / 2.5mm Insert Size

Metric R.H. Description	UPC No. 733101-	**Metric** L.H. Description	UPC No. 733101-	A	B	L	H	F	T-Max	Insert Size	Insert Style	Insert Lock Screw	Insert Hex Key
DETGFR 1616 H20-06	63690	DETGFL 1616 H20-06	63691						6				
DETGFR 1616 H20-12	63720	DETGFL 1616 H20-12	63721	16	16	100	16	16.2	12				
DETGFR 1616 H20-18	63750	DETGFL 1616 H20-18	63751						18		DNTQ-222002-3EU-N		
DETGFR 2020 K20-06	63694	DETGFL 2020 K20-06	63695						6		DNTQ-222502-3EU-N		
DETGFR 2020 K20-12	63724	DETGFL 2020 K20-12	63725	20	20	125	20	20.3	12	2	DNTR-220210-3EU-N	CS-0616	AKR-50
DETGFR 2020 K20-18	63754	DETGFL 2020 K20-18	63755						18	2.5	DNTF-222002-2EF-N		
DETGFR 2525 M20-06	63702	DETGFL 2525 M20-06	63703						6		DNPG-222002-1SR-N		
DETGFR 2525 M20-12	63732	DETGFL 2525 M20-12	63733	25	25	150	25	25.3	12				
DETGFR 2525 M20-18	63762	DETGFL 2525 M20-18	63763						18				

.079" / .098" Insert Size

Inch R.H. Description	UPC No. 733101-	**Inch** L.H. Description	UPC No. 733101-	A	B	L	H	F	T-Max	Insert Size	Insert Style	Insert Lock Screw	Insert Hex Key
DETGFR 10-20B-06	63600	DETGFL 10-20B-06	63601						0.236				
DETGFR 10-20B-12	63630	DETGFL 10-20B-12	63631	0.625	0.625	4.50	0.625	0.633	0.472				
DETGFR 10-20B-18	63660	DETGFL 10-20B-18	63661						0.709		DNTQ-222002-3EU-N		
DETGFR 12-20C-06	63604	DETGFL 12-20C-06	63605						0.236		DNTQ-222502-3EU-N		
DETGFR 12-20C-12	63634	DETGFL 12-20C-12	63635	0.750	0.750	5.00	0.750	0.762	0.472	0.079	DNTR-220210-3EU-N	CS-0616	AKR-50
DETGFR 12-20C-18	63664	DETGFL 12-20C-18	63665						0.709	0.980	DNTF-222002-2EF-N		
DETGFR 16-20D-06	63612	DETGFL 16-20D-06	63613						0.236		DNPG-222002-1SR-N		
DETGFR 16-20D-12	63642	DETGFL 16-20D-12	63643	1.000	1.000	6.00	1.000	1.012	0.472				
DETGFR 16-20D-18	63672	DETGFL 16-20D-18	63673						0.709				

For Turning, Grooving & Parting Off inserts see Pages F-4-F-6.

Turning & Grooving Right Hand & Left Hand Toolholder

3mm Insert Size

Metric R.H. Description	UPC No. 733101-	**Metric** L.H. Description	UPC No. 733101-	A	B	L	H	F	T-Max	Insert Size	Insert Style	Insert Lock Screw	Insert Hex Key
DETGFR 1616 H30-09	63692	DETGFL 1616 H30-09	63693	16	16	100	16	16.2	9	3	DNTQ-223003-3EU-N DNTR-223015-3EU-N DNTF-223002-2EF-N DNPG-223002-1SR-N	CS-0616	AKR-50
DETGFR 1616 H30-15	63722	DETGFL 1616 H30-15	63723						14				
DETGFR 1616 H30-21	63752	DETGFL 1616 H30-21	63753						20				
DETGFR 2020 K30-09	63696	DETGFL 2020 K30-09	63697	20	20	125	20	20.3	9				
DETGFR 2020 K30-15	63726	DETGFL 2020 K30-15	63727						14				
DETGFR 2020 K30-21	63756	DETGFL 2020 K30-21	63757						20				
DETGFR 2525 M30-09	63704	DETGFL 2525 M30-09	63705	25	25	150	25	25.3	9				
DETGFR 2525 M30-15	63734	DETGFL 2525 M30-15	63735						14				
DETGFR 2525 M30-21	63764	DETGFL 2525 M30-21	63765						20				
DETGFR 2532 P30-09	63712	DETGFL 2532 P30-09	63713	25	32	170	32	25.3	9				
DETGFR 2532 P30-15	63742	DETGFL 2532 P30-15	63743						14				
DETGFR 2532 P30-21	63772	DETGFL 2532 P30-21	63773						20				

.118" Insert Size

Inch R.H. Description	UPC No. 733101-	**Inch** L.H. Description	UPC No. 733101-	A	B	L	H	F	T-Max	Insert Size	Insert Style	Insert Lock Screw	Insert Hex Key
DETGFR 10-30B-09	63602	DETGFL 10-30B-09	63603	0.625	0.625	4.50	0.625	0.633	0.354	0.118	DNTQ-223003-3EU-N DNTR-223015-3EU-N DNTF-223002-2EF-N DNPG-223002-1SR-N	CS-0616	AKR-50
DETGFR 10-30B-15	63632	DETGFL 10-30B-15	63633						0.591				
DETGFR 10-30B-21	63662	DETGFL 10-30B-21	63663						0.787				
DETGFR 12-30C-09	63606	DETGFL 12-30C-09	63607	0.750	0.750	5.00	0.750	0.762	0.354				
DETGFR 12-30C-15	63636	DETGFL 12-30C-15	63637						0.591				
DETGFR 12-30C-21	63666	DETGFL 12-30C-21	63667						0.787				
DETGFR 16-30D-09	63614	DETGFL 16-30D-09	63615	1.000	1.000	6.00	1.000	1.012	0.354				
DETGFR 16-30D-15	63644	DETGFL 16-30D-15	63645						0.591				
DETGFR 16-30D-21	63674	DETGFL 16-30D-21	63675						0.787				
DETGFR 85-30D-09	63622	DETGFL 85-30D-09	63623	1.000	1.250	7.00	1.250	1.012	0.354				
DETGFR 85-30D-15	63652	DETGFL 85-30D-15	63653						0.591				
DETGFR 85-30D-21	63682	DETGFL 85-30D-20	63683						0.787				

For Turning, Grooving & Parting Off inserts see Pages F-4-F-6.

4mm Insert Size

Metric R.H. Description	UPC No. 733101-	**Metric** L.H. Description	UPC No. 733101-	A	B	L	H	F	T-Max	Insert Size	Insert Style	Insert Lock Screw	Insert Hex Key
DETGFR 2020 K40-12	63698	DETGFL 2020 K40-12	63699	20	20	125	20	20.3	12	4	DNTQ-254004-3EU-N DNTR-254020-3EU-N DNTF-254003-2EF-N DNPG-254003-1SR-N	CS-0616	AKR-50
DETGFR 2020 K40-18	63728	DETGFL 2020 K40-18	63729						18				
DETGFR 2020 K40-24	63758	DETGFL 2020 K40-24	63759						24				
DETGFR 2525 M40-12	63706	DETGFL 2525 M40-12	63707	25	25	150	25	25.3	12				
DETGFR 2525 M40-18	63736	DETGFL 2525 M40-18	63737						18				
DETGFR 2525 M40-24	63766	DETGFL 2525 M40-24	63767						24				
DETGFR 2532 P40-12	63714	DETGFL 2532 P40-12	63715	25	32	170	32	25.3	12				
DETGFR 2532 P40-18	63744	DETGFL 2532 P40-18	63745						18				
DETGFR 2532 P40-24	63774	DETGFL 2532 P40-24	63775						24				

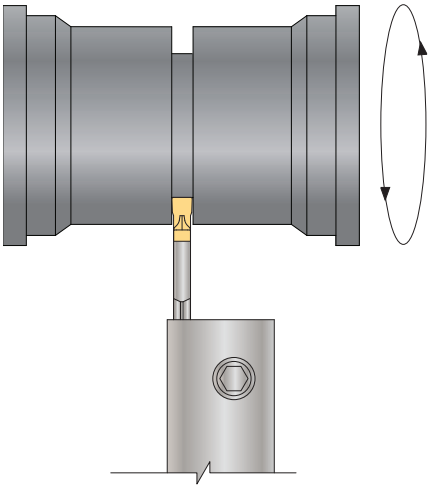
.157" Insert Size

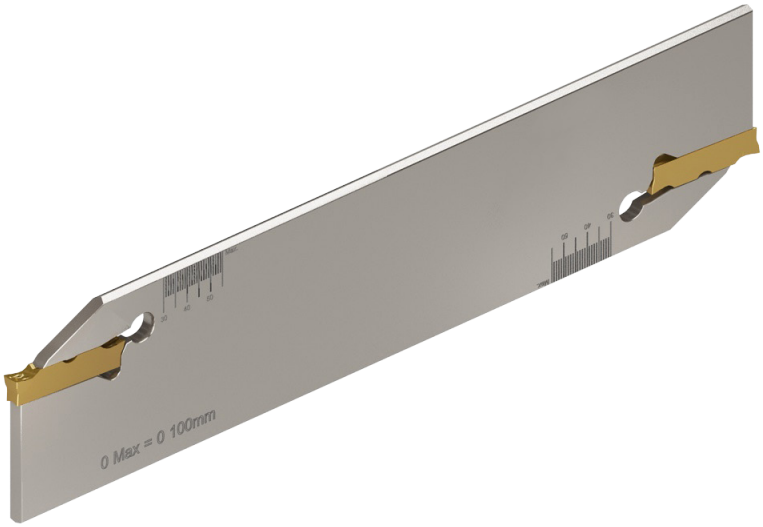
Inch R.H. Description	UPC No. 733101-	**Inch** L.H. Description	UPC No. 733101-	A	B	L	H	F	T-Max	Insert Size	Insert Style	Insert Lock Screw	Insert Hex Key
DETGFR 12-040C-12	63608	DETGFL 12-040C-12	63609	0.750	0.750	5.00	0.750	0.762	0.354	.157	DNTQ-254004-3EU-N DNTR-254020-3EU-N DNTF-254003-2EF-N DNPG-254003-1SR-N	CS-0616	AKR-50
DETGFR 12-040C-18	63638	DETGFL 12-040C-18	63639						0.709				
DETGFR 12-040C-24	63668	DETGFL 12-040C-24	63669						0.945				
DETGFR 16-040D-12	63616	DETGFL 16-040D-12	63617	1.000	1.000	6.00	1.000	1.012	0.354				
DETGFR 16-040D-18	63646	DETGFL 16-040D-18	63647						0.709				
DETGFR 16-040D-24	63676	DETGFL 16-040D-24	63677						0.945				
DETGFR 85-040D-12	63624	DETGFL 85-040D-12	63625	1.000	1.250	7.00	1.250	1.012	0.354				
DETGFR 85-040D-18	63654	DETGFL 85-040D-18	63655						0.709				
DETGFR 85-040D-24	63684	DETGFL 85-040D-24	63685						0.945				

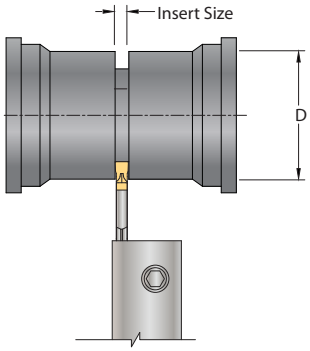
For Turning, Grooving & Parting Off inserts see Pages F-4-F-6.

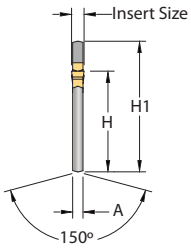
Twin Edge Parting Off Insert Blade

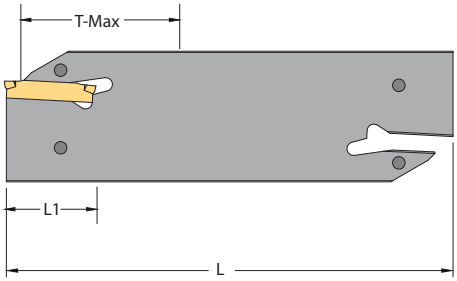
- Multi Advanced Cutting Features
- Twin Insert Cutting Edge
- Twin Insert Blade Seat
- Precise and Rigid Insert Locking System
- Easy Insert mounting and removal
- Industry Standard Blade size
- Fits to Standard Parting Off Blade Toolholder Blocks
- Adjustable Extended T-Max











Blades Description	UPC No. 733101-	System	A	D	H	L	H1	L1	T.Max	Insert Size	Insert Style
TWECOB-DNTF-26-20	61965	mm	1.57	52	21.40	110.00	26.00	22.00	27.5	2	DNTF 222002
		inch	.063	2.0	0.843	4.331	1.024	0.866	1.082	0.079	
TWECOB-DNTF-26-30	61966	mm	2.39	78	21.40	110.00	26.00	22.00	38.5	3	DNTF 223003
		inch	.094	3.1	0.843	4.331	1.024	0.866	1.515	0.118	
TWECOB-DNTF-26-40	61967	mm	3.18	84	21.40	110.00	26.00	25.00	38.5	4	DNTF 254004
		inch	.125	2.5	0.843	4.331	1.024	0.984	1.515	0.157	
TWECOB-DNTF-32-20	61968	mm	1.57	58	25.00	150.00	32.00	22.00	37.5	2	DNTF 222002
		inch	.063	2.7	0.984	5.906	1.260	0.866	1.476	0.079	
TWECOB-DNTF-32-30	61969	mm	2.39	90	25.00	150.00	32.00	22.00	52.5	3	DNTF 223003
		inch	.094	3.5	0.984	5.906	1.260	0.866	2.066	0.118	
TWECOB-DNTF-32-40	61970	mm	3.18	100	25.00	150.00	32.00	25.00	25.0	4	DNTF 254004
		inch	.125	3.9	0.984	5.906	1.260	0.984	0.984	0.157	
TWECOB-DNTF-32-50	61971	mm	3.96	120	25.00	150.00	32.00	25.00	25.0	5	DNTF 255004
		inch	.156	4.7	0.984	5.906	1.260	0.984	0.984	0.197	
TWECOB-DNTF-32-60	61972	mm	5.16	140	25.00	150.00	32.00	25.00	25.0	6	DNTF 256004
		inch	.203	5.5	0.984	5.906	1.260	0.984	0.984	0.236	

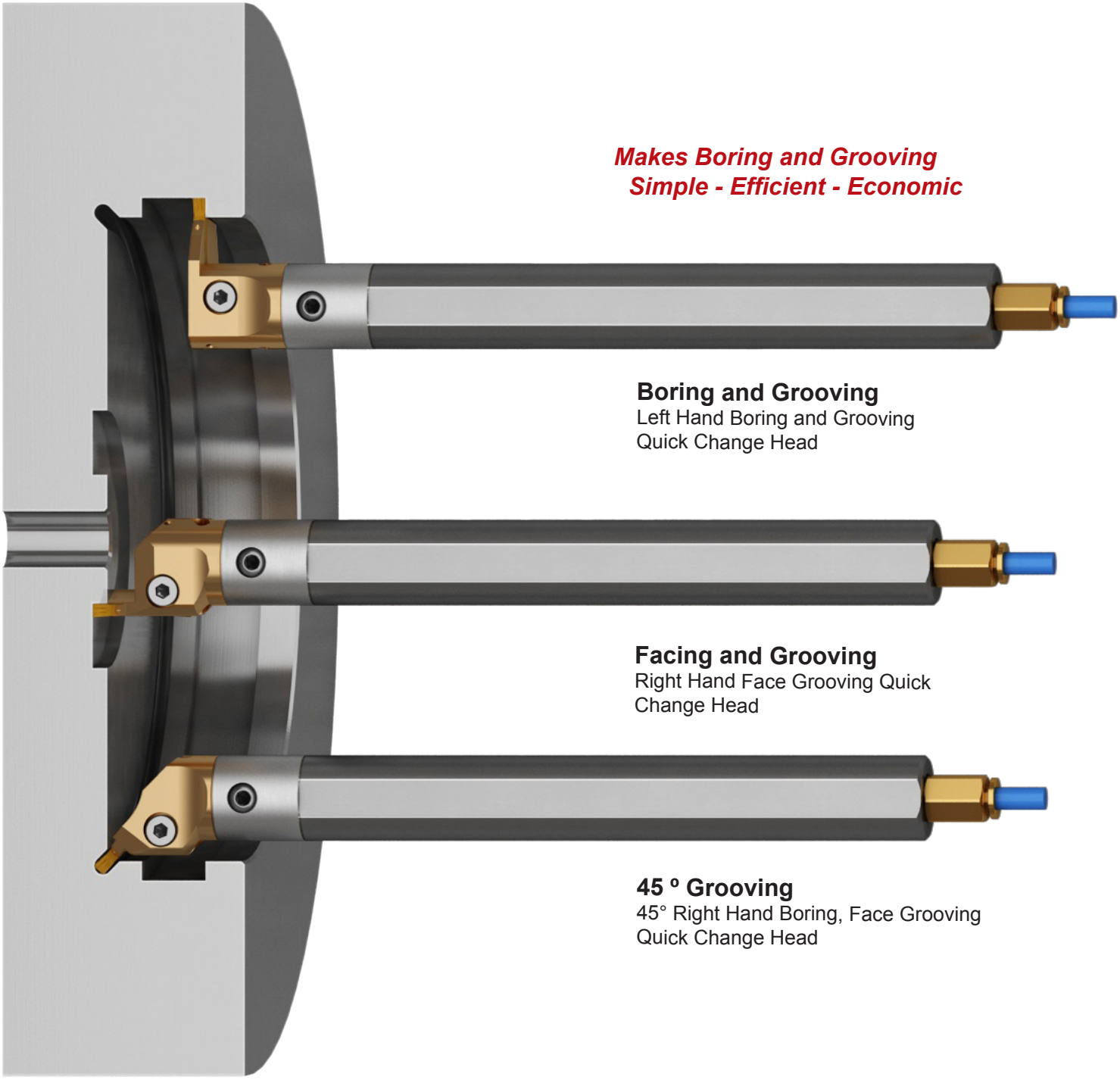
For Turning, Grooving & Parting Off inserts see Pages F-4-F-6.

Note: When the cutting depth exceeds the length of the cutting insert, the rear cutting edge of the insert penetrates in to the cutting slot. The contact of the rear cutting edge with the faces of the piecework may create tool marks. To minimize the toll marks, the blade must be placed exactly at 90° of the piecework.

The KOOL Cut™

Quick Change Boring & Grooving System

Expands the Flexibility of Multi-Operations
with the Combination of
Steel and Carbide Boring Bar Sizes
And Interchangeable Head Styles



Makes Boring and Grooving
Simple - Efficient - Economic

Boring and Grooving
Left Hand Boring and Grooving
Quick Change Head

Facing and Grooving
Right Hand Face Grooving Quick
Change Head

45 º Grooving
45° Right Hand Boring, Face Grooving
Quick Change Head

The KOOL Cut™

Quick Change Boring & Grooving System

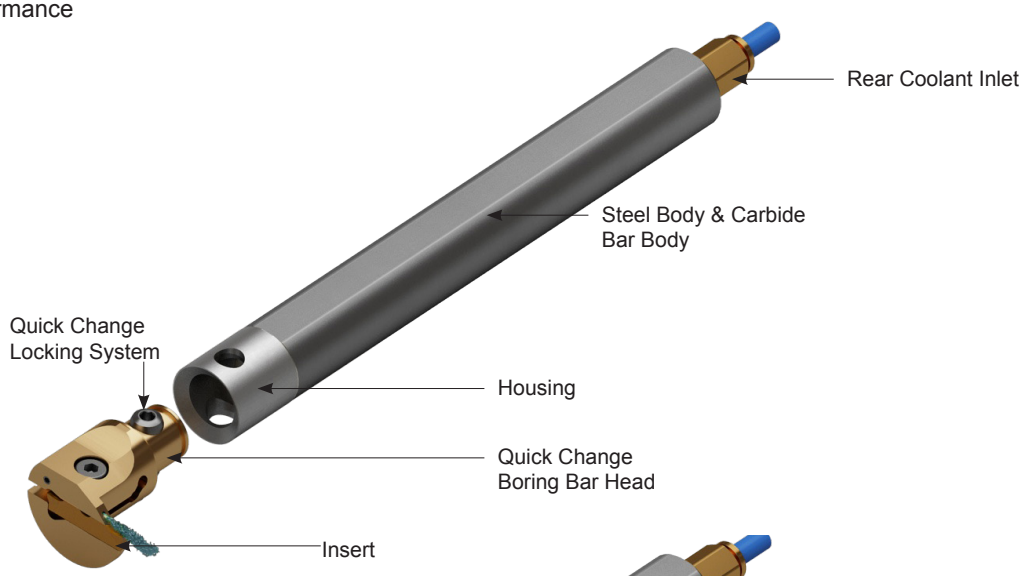
Built for Productivity!

Interchangeable Steel and Carbide Boring Bar Sizes & Quick Change Head Styles

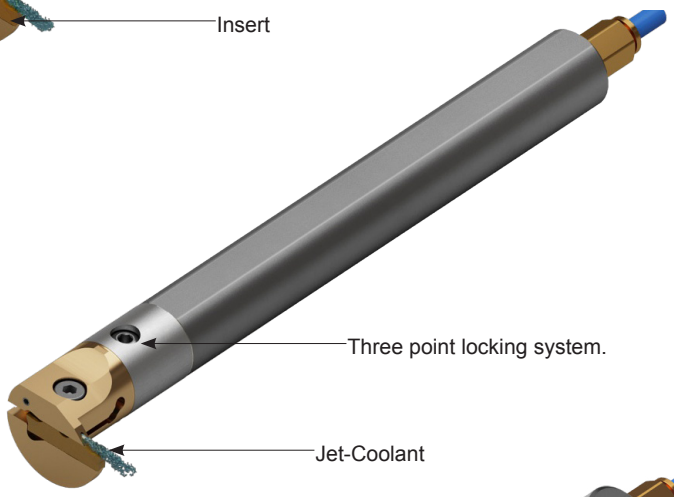
- Rigidity
- Flexibility
- Precision
- Interchangeability
- Advanced Technology
- Repeatability
- Multi-Operation
- High Performance

The KOOL Cut™ Quick Change Boring Bar Body;
Expands the flexibility for multi boring operation with precise and repetitive accuracy, and rigidity.

Bi Directional
Right Hand and Left Hand

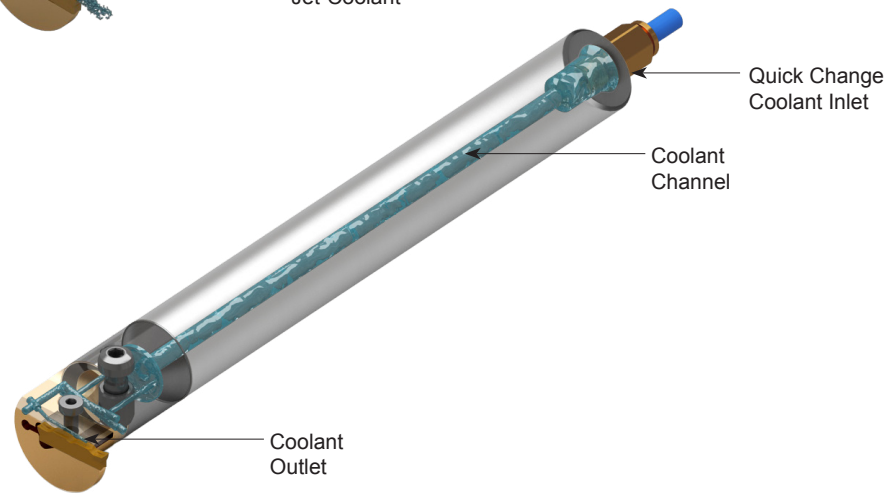


The KOOL Cut™ Quick Change Boring Bar Head with Jet-Coolant;
Made of heat treated alloy steel, TiN coated. Locks into the body of the Quick Change boring bar with a Three Point Locking System. The locking system will expand surface contact for maximum locking rigidity and precise interchangeability.



The KOOL Cut™ Quick Change Thru Coolant System;
Coolant is connected on the Coolant Inlet located on the rear end of the Boring Bar Body, The Coolant will travel thru the Boring Bar Body, and exit above the cutting edge of the insert.

The coolant is precisely aimed onto the cutting edge of the insert. The Insert is kept at constant Temperature, and chips are removed from the cutting edge and flushed out from the bore. With the constant insert Temperature, clean cutting edge, and chip free bore, the work quality is increased, and the insert life is increased up to 200%



The KOOL Cut™

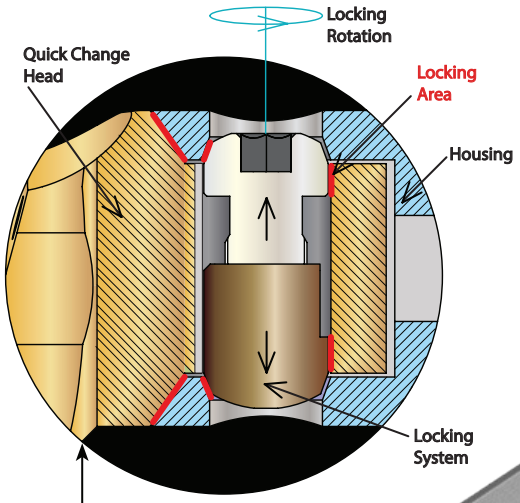
Quick Change Boring & Grooving System

SIMPLE – PRECISE – RIGID

To simplify deep hole boring With expandable capabilities of multi boring applications.

Three Point Locking System

Locks the Quick Change Head to the Boring Bar **Housing** by turning the two piece double head tapered locking screw. The screw will expand, forcing the head against the tapered holes. This tension pushes the body of the Quick Change Head into the Boring Bar **Housing**, causing the tapered shoulder of the Quick Change Head to pull against the inner taper of the Boring Bar **Housing**. Powering the locking screw will cause both heads of the screw to lock 180° simultaneously. This locking angle forces the Quick Change Head to align symmetrically at 90° with the Boring Bar **Housing**. The **expanding, pushing and pulling** mechanical forces result in **Three Point Locking System.**

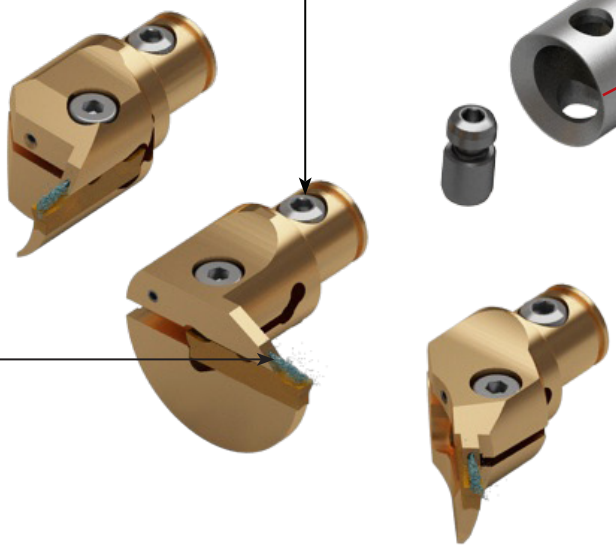


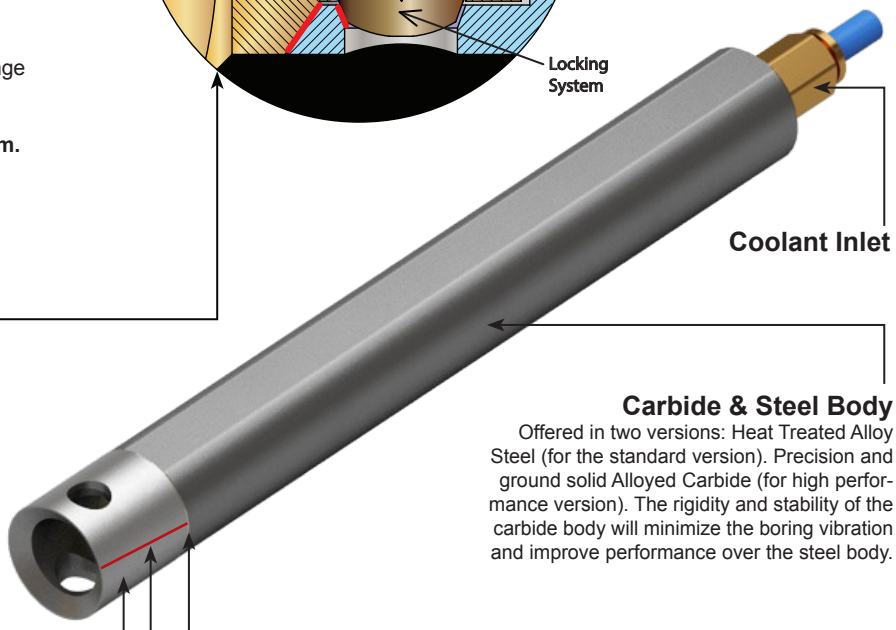
Boring Bar Sizes

Inch Sizes; 3/4", 1.0", 1 1/4"
Metric Sizes; 20mm, 25mm, 32mm

Boring Heads

Positive and Threading
DNTQ Inserts





Coolant Inlet

Carbide & Steel Body

Offered in two versions: Heat Treated Alloy Steel (for the standard version). Precision and ground solid Alloyed Carbide (for high performance version). The rigidity and stability of the carbide body will minimize the boring vibration and improve performance over the steel body.

Brazed Connection

The Quick Change Housing and the Carbide Boring Bar Body are silver brazed. The combination of right alloy and thickness of the silver braze makes the brazing strong and unbreakable, but flexible under interrupt cuts.

Center Line

For center gage reference.

Housing

Made of heat treated alloy steel and is precisely machined and brazed on to the Carbide Boring Bar Body.

Jet-Stream™ Thru Coolant Quick Change Heads

Made of heat treated alloy steel, TiN coated. The cylindrical body and the tapered shoulder of the Quick Change Head locks precisely into the boring bar body housing. The Three Point Locking System will expand surface contact for maximum locking rigidity and precise interchangeability. The Jet Stream thru coolant system will enhance performance, keeping the insert at constant temperature clean and undamaged cutting edge, and will remove chips from the bore while machining.

Boring and Grooving Operation Set-Up

Step 1.
Bar Set up

For best performance and to eleminate chatter in boring and grooving operation; Select a boring bar with the largest diameter permissible.

Extend the boring bar the shortest diameter possible

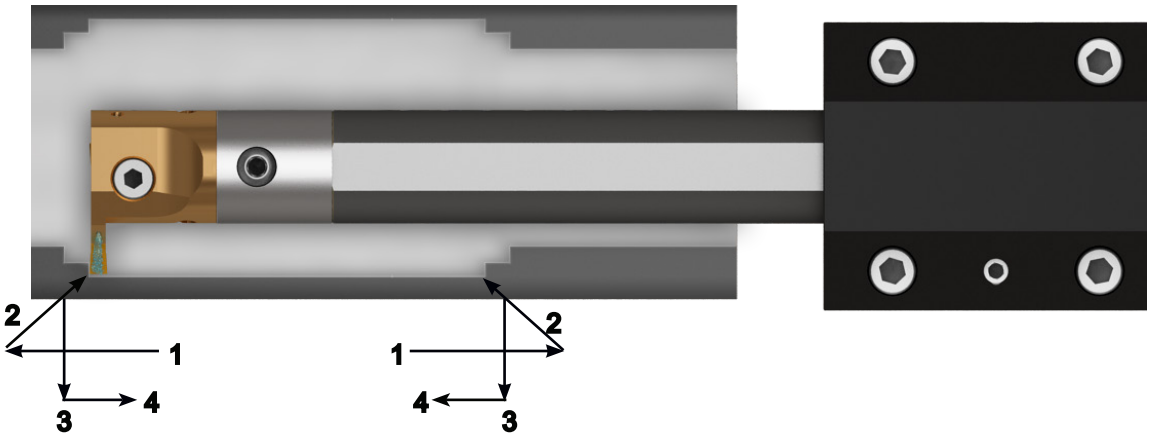
Use the narrowest insert possible

Step 2.
Roughing

Cut the first groove to the depth of the first roughing cutting diameter.

The feed the insert toward the other side of the workpiece. Cut till the end, then retract the insert at the 45° away from the wall.

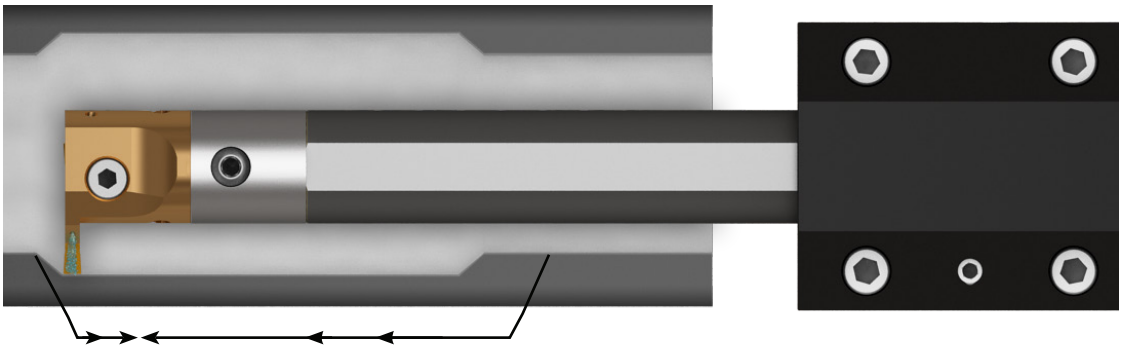
Repeat the operation, till the roughing operation is complete.



Step 3.
Finishing

Face-Off at finish dimension, one side of the groove to the finished diameter.

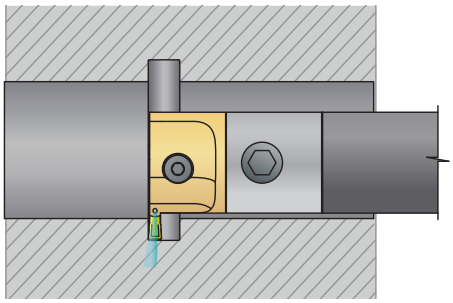
Retract the insert at 45° away from the wall and move to the other side of the groove. Face-Off to the finish diameter and continue to cut till the other wall is reached, than retract the insert at 45°.



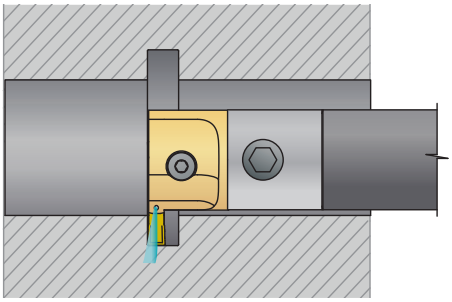
The KOOL Cut™

Quick Change Boring & Grooving System

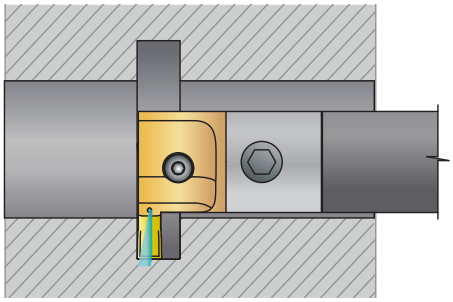
Expands the Flexibility of Multi-Operations



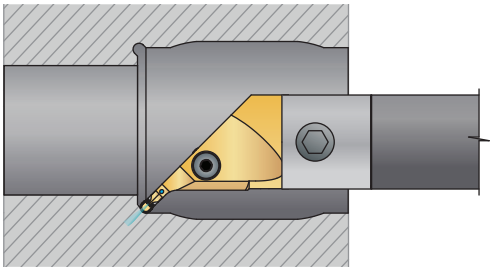
Boring and Grooving 2mm (.079") Insert Size



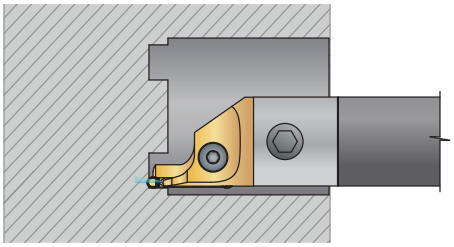
Boring and Grooving 3mm (.118") Insert Size



Boring and Grooving 4mm (.157") Insert Size



Boring, Profiling and Grooving 45º

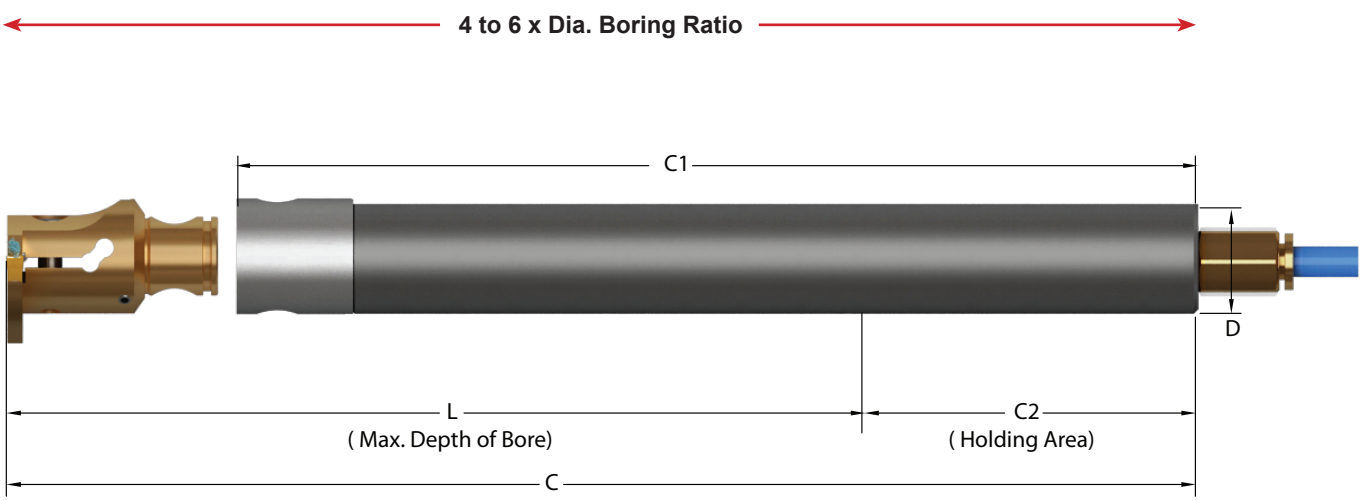


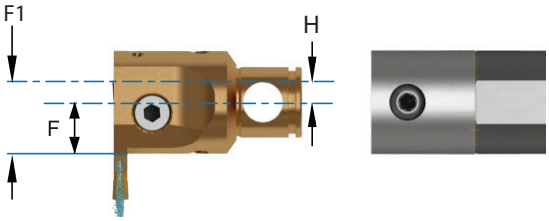
Facing and Face Grooving

One Quick Change Body

Five Interchangeable Heads

KOOL Cut™ Quick Change Modular Steel & Carbide Thru Coolant Boring & Grooving Shank





F1* = F + H
Min Bore = B + (H x 2)*

**For reference only
(for Head specifications see pages C-89 - C-94)
Note: **F** is the Tool Head Centerline
F1 is the Boring Bar Body Centerline

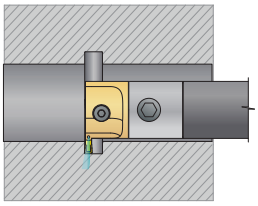
Inch Steel Bar Description	UPC No. 733101- Neutral	Boring Ratio	Steel Body D	C	C1	L	C2	H	F1*	Min. Bore B**	Modular Head* CBBB	Coolant Bore Dia.	Coolant Attachment Thread
A12I-R-4-MBQC	60215	4 x Dia.	0.750	8.00	7.160	3.00	3.00	0	F1=F+H	MB+B+(HxH2)	DQMH-12-_	0.157	1/8"-27NTP
A16I-R-4-MBQC	60216		1.000	8.00	7.160	4.00	4.00	0.125				0.157	
A20I-S-4-MBQC	60217		1.250	10.00	9.160	5.00	5.00	0.250				0.197	

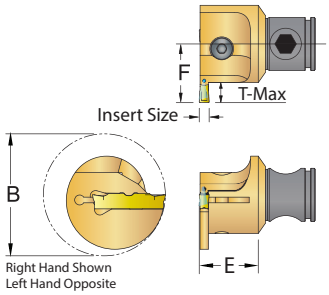
Metric Steel Bar Description	UPC No. 733101- Neutral	Boring Ratio	Steel Body D	C	C1	L	C2	H	F1*	Min. Bore B**	Modular Head* CBBB	Coolant Bore Dia.	Coolant Attachment Thread
A20M-R-4-MBQC	60218	4 x Dia.	20	203	182	80	80	0	F1=F+H	MB+B+(HxH2)	DQMH-12-_	4	1/8"-27NTP
A25M-R-4-MBQC	60219		25	203	182	100	100	5				4	
A32M-S-4-MBQC	60220		32	254	233	128	128	10				5	

Inch Carbide Bar Description	UPC No. 733101- Neutral	Boring Ratio	Carbide Body D	C	C1	L	C2	H	F1*	Min. Bore B**	Modular Head* CBBB	Coolant Bore Dia.	Coolant Attachment Thread
AE12I-Q-6-MBQC	60200	6 x Dia.	0.750	7.146	6.306	4.50	3.00	0	F1=F+H	MB+B+(HxH2)	DQMH-12-_	0.157	1/8"-27NTP
AE12I-S-6-MBQC	60201		0.750	10.146	9.306	4.50	3.00	0				0.157	
AE16I-R-6-MBQC	60202		1.000	8.101	7.261	6.00	4.00	0.125				0.197	
AE16I-T-6-MBQC	60203		1.000	12.10	11.261	6.00	4.00	0.125				0.197	
AE20I-U-6-MBQC	60204		1.250	14.00	13.160	7.50	5.00	0.250				0.197	

Metric Carbide Bar Description	UPC No. 733101- Neutral	Boring Ratio	Carbide Body D	C	C1	L	C2	H	F1*	Min. Bore B**	Modular Head* CBBB	Coolant Bore Dia.	Coolant Attachment Thread
AE20M-Q-6-MBQC	60205	6 x Dia.	20	180	158.70	120	80	0	F1=F+H	MB+B+(HxH2)	DQMH-12-_	4	1/8"-27NTP
AE20M-S-6-MBQC	60206		20	250	228.65	120	80	0				4	
AE25M-R-6-MBQC	60207		25	200	178.70	150	100	5				5	
AE25M-T-6-MBQC	60208		25	300	278.70	150	100	5				5	
AE32M-U-6-MBQC	60209		32	350	328.66	192	128	10				5	

KOOL Cut™ Quick Change Boring and Grooving Head - 2mm (.079") Insert Size

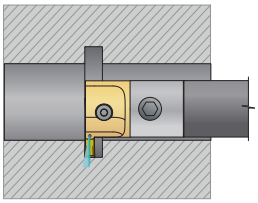


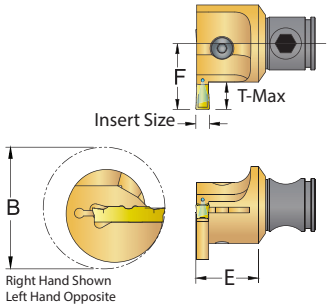


For Turning, Grooving & Parting Off inserts see Pages F-4-F-6.

Head Description	UPC No. 733101- R.H.	L.H.	System	B Min. Dia.	W	F	T-Max	Modular Head	Bar Diameter	Insert Size	Insert Style	Insert Lock Screw	Insert Key	Coolant Seal
DQCMH-ITR/L20-04	61925	61938	mm	31	21.34	16	4	20	20	2	DNTF 222010	CS-M0516	HAHK-50	CS08-04
			inch	1.183	0.840	0.611	0.157	0.750	0.750	.079				
DQCMH-ITR/L20-08	61926	61939	mm	35	21.34	20	8	20	25	2				
			inch	1.341	0.840	0.769	0.315	0.750	1.00	.079				
DQCMH-ITR/L20-12	61927	61940	mm	39	21.34	24	12	20	32	2				
			inch	1.498	0.840	0.926	0.472	0.750	1.25	.079				

KOOL Cut™ Quick Change Boring and Grooving Head - 3mm (.118") Insert Size

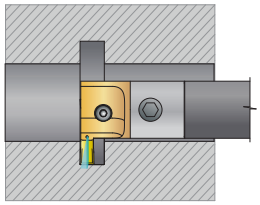


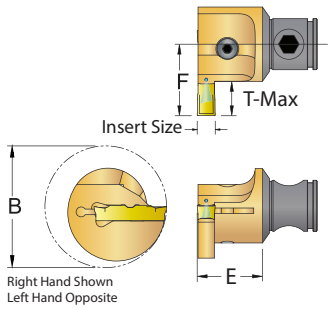


For Turning, Grooving & Parting Off inserts see Pages F-4-F-6.

Head Description	UPC No. 733101- R.H.	L.H.	System	B Min. Dia.	W	F	T-Max	Modular Head	Bar Diameter	Insert Size	Insert Style	Insert Lock Screw	Insert Key	Coolant Seal
DQCMH-ITR/L30-06	61928	61941	mm	33	21.34	18	6	20	20	3	DNTF 223015	CS-M0516	HAHK-50	CS08-04
			inch	1.262	0.840	0.690	0.236	0.750	0.750	.118				
DQCMH-ITR/L30-12	61929	61942	mm	39	21.34	24	12	20	25	3				
			inch	1.498	0.840	0.926	0.472	0.750	1.00	.118				
DQCMH-ITR/L30-15	61930	61943	mm	42	21.34	27	15	20	32	3				
			inch	1.616	0.840	1.044	0.590	0.750	1.25	.118				

KOOL Cut™ Quick Change Boring and Grooving Head - 4mm (.157") Insert Size

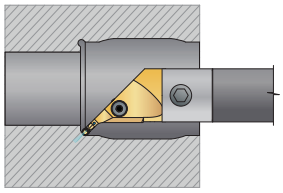


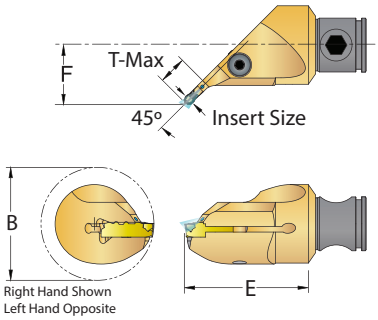


For Turning, Grooving & Parting Off inserts see Pages F-4-F-6.

Head Description	UPC No. 733101- R.H.	L.H.	System	B Min. Dia.	W	F	T-Max	Modular Head	Bar Diameter	Insert Size	Insert Style	Insert Lock Screw	Insert Key	Coolant Seal
DQCMH-ITR/L40-08	61931	61944	mm	35	21.34	20	8	20	20	4	DNTF 245020	CS-M0516	HAHK-50	CS08-04
			inch	1.341	0.840	0.769	0.315	0.750	0.750	.157				
DQCMH-ITR/L40-12	61932	61945	mm	39	21.34	24	12	20	25	4				
			inch	1.498	0.840	0.926	0.472	0.750	1.00	.157				
DQCMH-ITR/L40-16	61933	61946	mm	43	21.34	28	16	20	32	4				
			inch	1.656	0.840	1.084	0.630	0.750	1.25	.157				

KOOL Cut™ Quick Change Boring and Grooving 45º Head - 2mm (.079"), 3mm (.118"), 4mm (.157") Insert Size

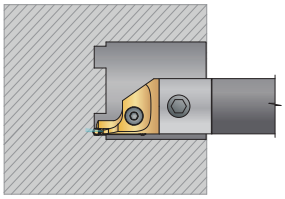


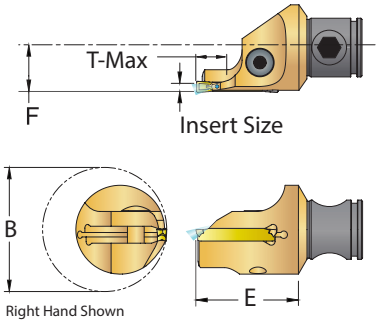


For Turning, Grooving & Parting Off inserts see Pages F-4-F-6.

Head Description	UPC No. 733101- R.H.	L.H.	System	B Min. Dia.	W	F	T-Max	Modular Head	Bar Diameter	Insert Size	Insert Style	Insert Lock Screw	Insert Key	Coolant Seal
DQCMH-IUR/L20-04	61951	61954	mm	31	21.34	16	4	20	20	2	DNTF 222010	CS-M0516	HAHK-50	CS08-04
			inch	1.183	0.840	0.611	0.157	0.750	0.750	.079				
DQCMH-IUR/L30-06	61952	61955	mm	33	21.34	18	6	20	20	3	DNTF 223015			
			inch	1.262	0.840	0.690	0.236	0.750	0.750	.118				
DQCMH-IUR/L40-08	61953	61956	mm	35	21.34	20	8	20	20	4	DNTF 245020			
			inch	1.341	0.840	0.769	0.315	0.750	0.750	.157				

KOOL Cut™ Quick Change Internal Face Grooving Head - 3mm (.118") Insert Size



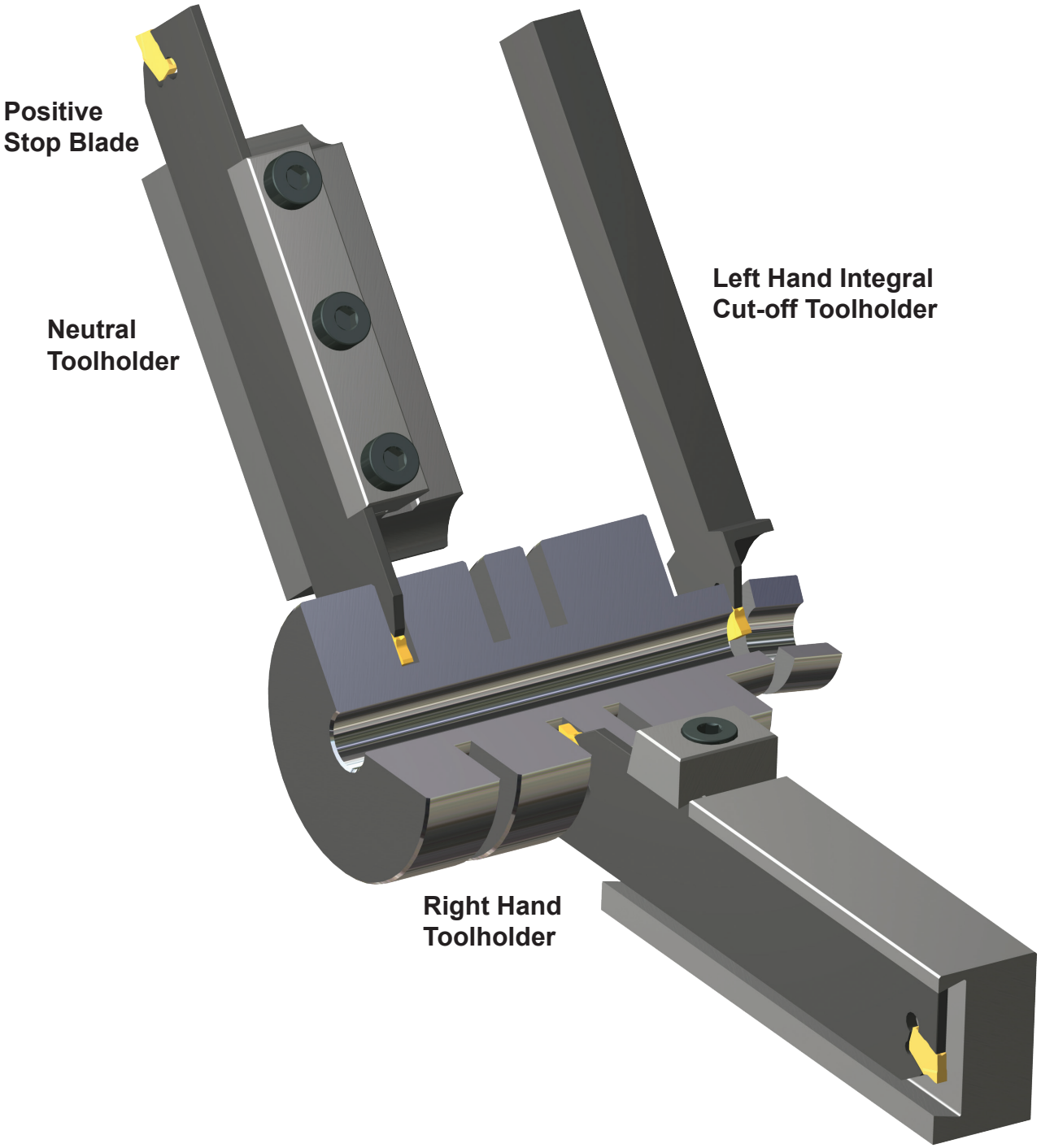


For Turning, Grooving & Parting Off inserts see Pages F-4-F-6.

Head Description	UPC No. 733101- R.H.	L.H.	System	B Dia. Min.	B Dia. Max.	W	F	T-Max	Modular Head	Bar Diameter	Insert Size	Insert Style	Insert Lock Screw	Insert Key	Coolant Seal
DQCNH-IFR/L30-025038-10	61957	61961	mm	25	39	21.34	12	10	20	20	3	DNTF 223015	CS-M0516	HAHK-50	CS08-04
			inch	0.984	1.535	0.840	0.848	0.394	0.750	0.750	.118				
DQCNH-IFR/L30-038060-10	61958	61962	mm	37	60	21.34	12	10	20	20	3				
			inch	1.457	2.362	0.840	0.848	0.394	0.750	0.750	.118				
DQCNH-IFR/L30-060100-10	61959	61963	mm	59	101	21.34	12	10	20	20	3				
			inch	2.323	3.976	0.840	0.848	0.394	0.750	0.750	.118				
DQCNH-IFR/L30-100200-10	61960	61964	mm	99	200	21.34	12	10	20	25	3				
			inch	3.898	7.874	0.840	0.848	0.394	0.750	1.00	.118				

Slot Grip Cut-Off Toolholder & Insert

Cut-Off & Grooving System

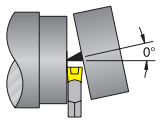


Material

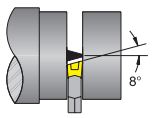
Recommended Surface Speed per Minute - Feet (m)/min - sfm (Vc)

Material	Dorian Insert Grade	DK25		DP25		DASK25		DC656	
	Insert Coating	Uncoated		Uncoated		PVD Coated		CVD Coated	
		High (Vc)		Medium (Vc)		High (Vc)		High (Vc)	
		SFM Inch	m/Min Metric	SFM Inch	m/Min Metric	SFM Inch	m/Min Metric	SFM Inch	m/Min Metric
Free Machining Low Carbon Steel									
Low Carbon and Free Machining Steel		-	-	430-690	131-210	-	-	540-870	165-265
Carbon Steel, Alloy Steel and Tool Steel <35 HRC		-	-	360-490	110-149	-	-	450-630	137-192
Carbon Steel, Alloy Steel and Tool Steel >35 HRC		-	-	195-390	59-119	-	-	285-505	87-154
Martensitic - Ferretic, 400 Series and PH Stainless Steel		-	-	440-740	134-226	-	-	560-935	171-285
Stainless Steel									
Stainless Steel Austenitic 200 and 300 Series		380-425	116-130	-	-	640-740	195-225	-	-
Cast Iron									
Gray Cast Iron 135-270 BHN		360-425	110-130	-	-	620-740	189-225	-	-
Gray Cast Iron 275-450 BHN		330-380	101-116	-	-	575-655	175-200	-	-
Ductile Cast Iron		295-245	90-75	-	-	510-590	155-180	-	-
Aluminum Alloys									
Free Machining Aluminum, Low Silicon Aluminum <12.2%, Magnesium 50-90 BHN		500-2000	152-610	-	-	600-2500	183-762	-	-
High Silicon Aluminum Alloy >12..2%		-	-	-	-	-	-	-	-
Copper Brass, Bronze, Zinc, Lead Alloys, Magnesium 90-150 BHN		250-700	76-214	-	-	400-1000	122-305	-	-
Carbon and Graphite 270-400 BHN Nylon, Plastics, Rubbers, Phenolics and Resins		400-1500	122-458	-	-	400-1500	122-458	-	-
High Temp Alloy									
Cobalt Base High Temp Alloys 150-425 BHN		80-150	24-46	-	-	100-300	31-91	-	-
Iron Base High Temp Alloys 135-320 BHN		80-150	24-26	-	-	100-300	31-91	-	-
Nickel Base High Temp Alloys 140-300 BHN		30-100	9-31	-	-	50-225	15-69	-	-
Nickel Base High Temp Alloys 300-475 BHN		30-100	9-31	-	-	50-225	15-69	-	-
Titanium and Titanium Alloys 100-475 BHN		90-200	27-61	-	-	125-300	38-91	-	-

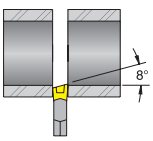
Applications	Cut-off & Grooving Solid Bars & Tubing	Cut-off Solid Bars and Tubing
Insert	SGTN	SGTL..8 / SGTL..8
Lead Angle	0°	8°
Optimum Feed Rate	Maximum Usage	Average Usage
Maximum Flatness of the Cut Surface	Maximum Usage	Average Usage
Maximum Chip Control	Maximum Usage	Average Usage
Ultimate Cutting Edge Strength	least Usage	Above Average Usage
Minimum Burr	Least Usage	Above Average Usage
Ratio of: Depth of Cut / Width of Cut	Maximum Usage	Average Usage



Solid bar cut-off with SGTN insert

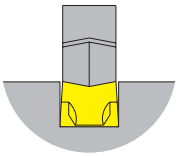


Solid bar cut-off (soft materials) with SGTR insert



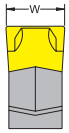
Tubing cut-off with SGTR insert

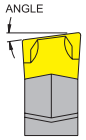
Cut-Off & Grooving Inserts are Designed for use with standard cut-off inserts and standard cut-off blade holders. The insert's cutting edge location repeats accurately and as a result prevents insert splitting under heavy feed and shock loads. The blade and insert geometry permits free chip flow, minimizing insert breakage due to chip build-up.

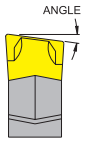


Material	Carbon & Alloy Steel	300 & 400 Series Stainless Steel	Carbon & Alloy Steel	300 & 400 Series Stainless Steel	Cast Iron, Copper/Brass	Aluminum	High Temp Alloys	Hard Steel to 58 HRC	Carbon & Alloy Steel	300 & 400 Series Stainless Steel	Cast Iron, Copper/Brass	Non Ferrous Metals & Materials	High Temp Alloys	Hard Steel to 58 HRC
ANSI Insert Grade	P25		P35			K25 N25			K25 P15 M15					
Insert Coating	Uncoated		CVD Coated			Uncoated			PVD Coated					

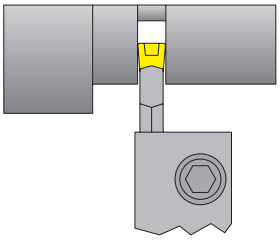
Insert Grade		Dimensions				DP25	DC656	DK25	DASK25B
Description	ANSI	Insert Size mm	Lead Angle	Width + .05 inch	Width + .05 mm	Upc 733101-	Upc 733101-	Upc 733101-	Upc 733101-
SGTN Neutral	SGTN-2	2	0°	.087	2	82221	82222	82220	82223
	SGTN-2.4	2.4	0	.094	2.4	82305	82306	82304	82307
	SGTN-3	3	0°	.122	3	82225	82226	82224	82227
	SGTN-4	4	0°	.161	4	82229	82230	82228	82231
	SGTN-4.8	4.8	0	.189	4.8	82317	82318	82316	82319
	SGTN-5	5	0°	.201	5	82233	82234	82232	82235
	SGTN-6	6	0°	.252	6	82237	82238	82236	82239
	SGTN-8	8	0°	.315	8	82241	82242	82240	82243
	SGTN-9	9	0°	.378	9	82245	82246	82244	82247
SGTR Right Hand	SGTR-2-8	2	8°	.087	2	82249	82250	82248	82251
	SGTR-2.4-8	2.4	8	.094	2.4	82309	82310	82308	82311
	SGTR-3-8	3	8°	.122	3	82253	82254	82252	82255
	SGTR-4-8	4	8°	.161	4	82257	82258	82256	82259
	SGTR-4.8-8	4.8	8	.189	4.8	82321	82322	82320	82323
	SGTR-5-8	5	8°	.201	5	82261	82262	82260	82263
	SGTR-6-8	6	8°	.252	6	82265	82266	82264	82267
	SGTR-8-8	8	8°	.315	8	82269	82270	82268	82271
	SGTR-9-8	9	8°	.378	9	82273	82274	82272	82275
SGTL Left Hand	SGTL-2-8	2	8°	.087	2	82277	82278	82276	82279
	SGTL-2.4-8	2.4	8	.094	2.4	82313	82314	82312	82315
	SGTL-3-8	3	8°	.122	3	82281	82282	82280	82283
	SGTL-4-8	4	8°	.161	4	82285	82286	82284	82287
	SGTL-4.8-8	4.8	8	.189	4.8	82325	82326	82324	82327
	SGTL-5-8	5	8°	.201	5	82289	82290	82288	82291
	SGTL-6-8	6	8°	.252	6	82293	82294	82292	82295
	SGTL-8-8	8	8°	.315	8	82297	82298	82296	82299
	SGTL-9-8	9	8°	.378	9	82301	82302	82300	82303

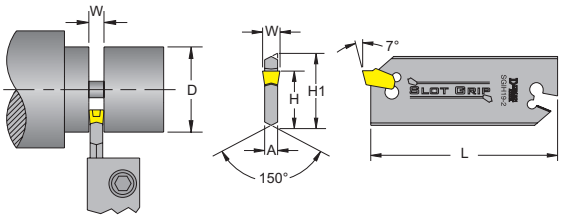






Slot Grip Positive Stop Blades for Cut-Off & Grooving SGTN Inserts





SLOT GRIP

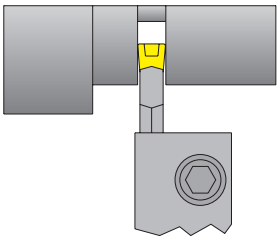
Designed for use with standard cut-off inserts and standard cut-off blade holders. The insert's cutting edge location repeats accurately and as a result prevents insert splitting under heavy feed and shock loads. The blade and insert geometry allows free chip flow, minimizing insert breakage due to chip build-up.

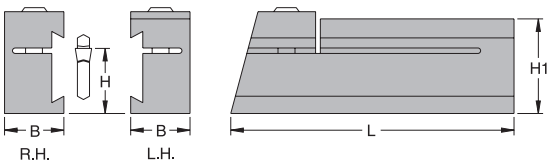
Improved design featuring a "Positive Stop". Inserts are securely held in Slot Grip Positive Stop Blades by a tapered locking system featuring a "Positive Stop" that prevents insert drift and the blade pocket from spreading once the insert is firmly in place.

Inch Description	UPC No. 733101-	Insert Used	W in	W mm	D Max in	D Max mm	A in	A mm	L in	L mm	H in	H mm	H 1 in	H 1 mm
SGIH19-2	62950	SGT(N/R/L)-2	.087	2	1.57	39,9	.063	1,57	3.38	85,9	.618	15,7	0.75	19,1
SGIH26-2	62951	SGT(N/R/L)-2	.087	2	2.00	50,8	.063	1,57						
SGIH26-3	62952	SGT(N/R/L)-3	.122	3	3.00	76,2	.094	2,39	4.33	110,0	.842	21,4	1.02	25,9
SGIH26-4	62953	SGT(N/R/L)-4	.161	4	3.15	80,0	.125	3,18						
SGIH32-3	62956	SGT(N/R/L)-3	.122	3	3.94	100,0	.094	2.39						
SGIH32-4	62957	SGT(N/RL)-4	.161	4	3.94	100,0	.125	3.18						
SGIH32-5	62958	SGT(N/R/L)-5	.201	5	4.71	119,6	.156	3,96						
SGIH32-6	62959	SGT(N/R/L)-6	.252	6	4.72	119,9	.203	5,16	5.90	149.9	.984	25,0	1.25	31,8
SGIH32-8	62960	SGT(N/R/L)-8	.315	8	5.51	140,0	.268	6,81						
SGIH32-9	62961	SGT(N/R/L)-9	.378	9	5.51	140,0	.312	7,92						

For Slot Grip Cut Off inserts see Pages F-78-F-79.

SGTB R/L Toolholder for Cut-Off SGIH blades



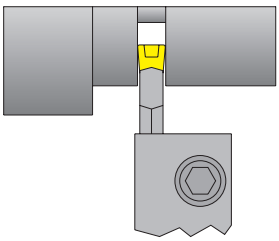


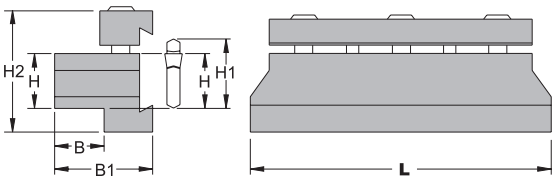
Simple block design accommodates Slot Grip and competitive blade systems. Unique wedge clamp provides firm seating for light and heavy duty cut-off and grooving operations. One piece design for additional cost savings. Also, facilitates installation to many CNC machining centers. Slot Grip Cut-Off toolholders come in a broad selection of sizes.

Inch Description	UPC No. 733101- R.H.	L.H.	H	H1	B	L	Blade Used	Screw used
SGTBR/L19-2	62990	62991	0.750	1.00	.750	4.00	SGIH19-2	ASHCSFP-060-100-025-MA
SGTBR/L25,4-6	62992	62993	1.00	1.25	.781	4.75	SGIH26-2 Thru SGIH26-6	ASHCSFP-060-100-030-MA

For Slot Grip Cut Off inserts see Pages F-78-F-79.

SGTBN Neutral Hand Cut-Off Toolholder for Cut-Off SGIH blades



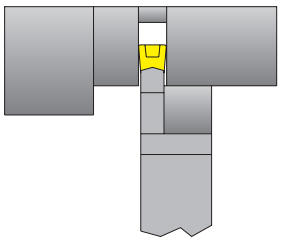


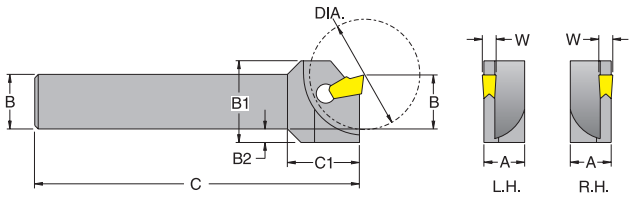
The two piece clamp style of this tool provides a precise and rigid blade locking and easy mounting of the tool into CNC turrets. Simple block design accommodates Slot Grip and competitive blade systems. Slot Grip Cut-Off toolholders come in a broad selection of shank sizes.

Inch Description	UPC No. 733101- Neutral	H	H1	H2	B	B1	L	Blade Used	Screw used
SGTBN12,7-2	62970	0.500	0.750	1.375	0.500	1.000	3.00	SGIH19-2	ASHCSFP-050-080-025-MA
SGTBN16-2	62971	0.625	0.750	1.375	0.625	1.000	3.00		
SGTBN16-5	62972	0.625	1.020	1.750	0.625	1.250	3.50	SGIH26-2 Thru SGIH26-6	ASHCSFP-060-100-030-MA
SGTBN19-5	62973	0.750	1.020	2.000	0.750	1.375	3.50		
SGTBN19-6	62974	0.750	1.250	2.000	0.750	1.375	4.50	SGIH32-3 Thru SGIH32-9	ASHCSFP-060-100-030-MA
SGTBN25,4-6	62975	1.000	1.250	2.125	0.875	1.500	4.50		
SGTBN31,8-6	62976	1.250	1.250	2.375	1.125	1.750	4.50		
SGTBN38,1-6	62977	1.500	1.250	2.875	1.625	2.250	4.50		

For Slot Grip Cut Off inserts see Pages F-78-F-79.

SGTH R/L Cut-Off Toolholder for Cut-Off SGTN inserts



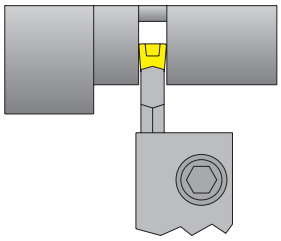


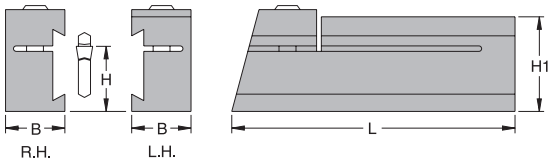
The square shank design of the Cut-Off toolholder ensures a precise center line of the insert with respect to the center of the work-piece, when the toolholder is mounted directly on the CNC turret. Inserts are securely held in Slot Grip blades by a tapered locking system. No additional clamping devices are required. Slot Grip Cut-Off toolholders come in a broad selection of shank sizes.

Inch Description	UPC No. 733101- R.H.	L.H.	A	B	B1	B2	C	C1	Max. Dia	W	Insert used
SGTHR/L-9,5-2	63000	63001	.375	0.375	0.750	.187	3.375	0.703	1.109	.087 & 0.93	SGTN/R/L-2-2,4
SGTHR/L-12,7-2	63002	63003	.391	0.500	0.828	.156	4.328	0.703	1.172	.087 & 0.93	
SGTHR/L-16-2	63004	63005	.391	0.625	0.750	-	4.328	0.703	1.172	.087 & 0.93	
SGTHR/L-19-2	63006	63007	.469	0.750	0.937	-	4.328	0.781	1.266	.087 & 0.93	
SGTHR/L-19,5-3	63008	63009	.375	0.375	0.750	.187	3.375	0.703	1.109	.120	SGTN/R/L-3
SGTHR/L-12,7-3	63010	63011	.391	0.500	0.828	.237	4.328	0.828	1.266	.120	
SGTHR/L-16-3	63012	63013	.469	0.625	0.937	.156	4.328	0.781	1.266	.120	
SGTHR/L-19-3	63014	63015	.469	0.750	0.937	-	4.328	0.828	1.406	.120	
SGTHR/L-25,4-3	63016	63017	.984	1.000	1.187	-	5.875	0.984	2.062	.120	
SGTHR/L-16-4	63018	63019	.469	0.625	0.937	.156	4.328	0.828	1.328	.160	SGTN/R/L-4
SGTHR/L-19-4	63020	63021	.469	0.750	0.937	-	4.328	0.906	1.531	.160	
SGTHR/L-25,4-4	63022	63023	.984	1.000	1.187	-	5.875	1.187	2.500	.160	
SGTHR/L-19-5	63024	63025	.469	0.750	0.937	-	4.328	0.906	1.531	.187 & .200	SGTN/R/L-4,8-5
SGTHR/L-25,4-5	63026	63027	.984	1.000	1.187	-	5.875	1.600	3.000	.187 & .200	

For Slot Grip Cut Off inserts see Pages F-78-F-79.

SGTB R/L Toolholder for Cut-Off SGIH blades



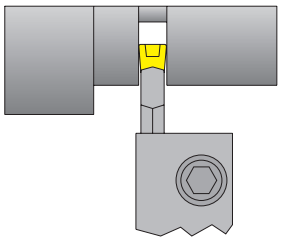


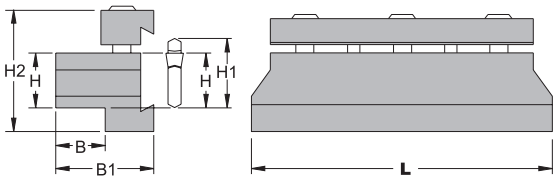
Simple block design accommodates Slot Grip and competitive blade systems. Unique wedge clamp provides firm seating for light and heavy duty cut-off and grooving operations. One piece design for additional cost savings. Also, facilitates installation to many CNC machining centers. Slot Grip Cut-Off toolholders come in a broad selection of sizes.

Metric Description	UPC No. 733101- R.H.	L.H.	H	H1	B	L	Blade Used	Screw used
SGTBR/L20-2	62294	62295	20,0	25,4	19,1	101,6	SGIH19-2	ASHCSFP-060-100-025-MA
SGTBR/L25-6	62296	62297	25,0	31,8	15,5	120,7	SGIH26-2 Thru SGIH26-6	ASHCSFP-060-100-030-MA

For Slot Grip Cut Off inserts see Pages F-78-F-79.

SGTBN Neutral Hand Cut-Off Toolholder for Cut-Off SGIH blades



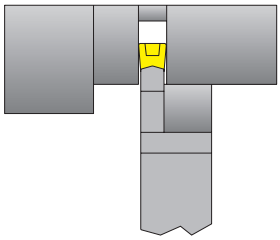


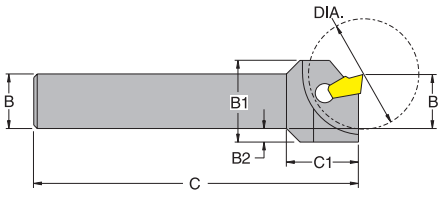
The two piece clamp style of this tool provides a precise and rigid blade locking and easy mounting of the tool into CNC turrets. Simple block design accommodates Slot Grip and competitive blade systems. Slot Grip Cut-Off toolholders come in a broad selection of shank sizes.

Metric Description	UPC No. 733101- Neutral	H	H1	H2	B	B1	L	Blade Used	Screw used
SGTBN12-2	62978	12,0	19,1	34,9	12,7	25,4	76,20	SGIH19-2	ASHCSFP-050-080-025-MA
SGTBN16-2	62971	16,0	19,1	34,9	15,9	25,4	76,20		
SGTBN16-5	62972	16,0	25,9	44,5	15,9	31,8	88,90	SGIH26-2 Thru SGIH26-6	ASHCSFP-060-100-030-MA
SGTBN20-5	62979	20,0	25,9	50,8	19,1	34,9	88,90		
SGTBN20-6	62980	20,0	31,8	50,8	19,1	34,9	114,3	SGIH32-3 Thru SGIH32-9	ASHCSFP-060-100-030-MA
SGTBN25-6	62981	25,0	31,8	54,0	22,2	38,1	114,3		
SGTBN32-6	62982	32,0	31,8	60,3	28,6	44,5	114,3		
SGTBN40-6	62983	40,0	31,8	73,0	41,3	57,2	114,3		

For Slot Grip Cut Off inserts see Pages F-78-F-79.

SGTH R/L Cut-Off Toolholder for Cut-Off SGTN inserts





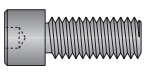
The square shank design of the Cut-Off toolholder ensures a precise center line of the insert with respect to the center of the work-piece, when the toolholder is mounted directly on the CNC turret. Inserts are securely held in Slot Grip blades by a tapered locking system. No additional clamping devices are required. Slot Grip Cut-Off toolholders come in a broad selection of shank sizes.

Metric Description	UPC No. 733101- R.H.	L.H.	A	B	B1	B2	C	C1	Max. Dia	W	Insert used
SGTHR/L-10-2	63028	63029	9,50	10,0	19,1	4,7	85,0	17,9	28,2	2 & 2,4	SGTN/R/L-2-2,4
SGTHR/L-12-2	63030	63031	9,90	12,0	19,1	4,0	109,9	17,9	29,8	3	
SGTHR/L-16-2	63032	63033	9,90	16,0	19,1	-	109,9	17,9	29,8		
SGTHR/L-20-2	63034	63035	11,9	20,0	23,8	-	109,9	19,8	32,2		
SGTHR/L-10-3	63036	63037	9,50	10,0	19,1	4,7	85,70	17,9	28,2		SGTN/R/L-3
SGTHR/L-12-3	63038	63039	9,90	12,0	21,0	5,9	109,9	21,0	32,2		
SGTHR/L-16-3	63040	63041	11,9	16,0	23,8	4,0	109,9	19,8	32,2		
SGTHR/L-20-3	63042	63043	11,9	20,0	23,8	-	109,9	21,0	35,7		
SGTHR/L-25-3	63044	63045	25,0	25,0	30,1	-	149,2	25,0	52,4		
SGTHR/L-16-4	63046	63047	11,9	16,0	23,8	4,0	109,9	21,0	33,7	4	SGTN/R/L-4
SGTHR/L-20-4	63048	63049	11,9	20,0	23,8	-	109,9	23,0	38,9		
SGTHR/L-25-4	63050	63051	25,0	25,0	30,1	-	149,2	30,1	63,5		
SGTHR/L-20-5	63052	63053	11,9	20,0	23,8	-	109,9	23,0	38,9	4,8 & 5	SGTN/R/L-4,8-5
SGTHR/L-25-5	63054	63055	25,0	25,0	30,1	-	149,2	33,7	76,2		

For Slot Grip Cut Off inserts see Pages F-78-F-79.

Cut-Off & Grooving Spare Parts

Blade Lock Screw



Description	Part No. 733101-	Length	Thread	Hex Wrench Size	PKG.
ASHCSFP-050-080-025-MA	90913	25	M5XO.8	4mm	10
ASHCSFP-060-100-025-MA	90914	25	M6X1.0	5mm	10
ASHCSFP-060-080-030-MA	90916	32	M6X1.0	5mm	10
ASHCSFP-060-100-040-MA	90918	40	M6X1.0	5mm	10

Notes