

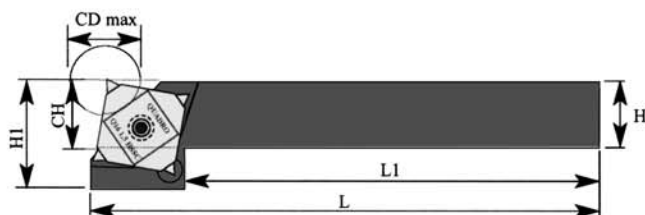
Premier

Manufacturers of Precision Ground Cutting Tools



Parting-Off
Quadro
e - Catalogue

Type Q16 HSSC system



NOTE: Toolholders are supplied with screw and key

Insert pocket 2 (Left)

Insert pocket 1 (Right)



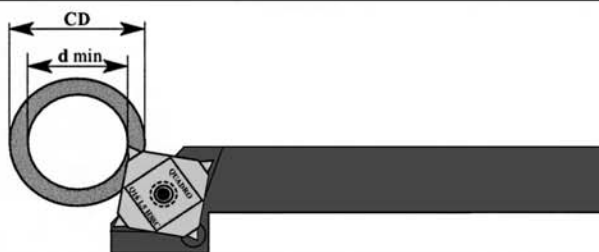
Toolholder

Part Number	H	Bh	CH	L	L1	H1	CD max.	Insert	Spare parts for the Quadro® Q16 system		
									Description	Part number	Number per Holder
GEX1012K Q16	10		10						Screw for Q16 insert Key for T9-M3 screw	T9 - M3 CQ - T9	1 1
GEX1212K Q16	12		12								
GEX1412K Q16	14	12	14	125	106	25	13	Q16			
GEX1612K Q16	16		16								
GEX2012K Q16	20		20								

Inserts TiN coated high speed steel

Image	CW +0,02	S +0,05	CD max.	Part Number				
	0,7	16	13	Q16 0,7 HSSC				
	0,8			Q16 0,8 HSSC				
	0,9			Q16 0,9 HSSC				
	1,0			Q16 1,0 HSSC				
	1,2			Q16 1,2 HSSC				
	1,5			Q16 1,5 HSSC				
	1,2	16	13	6°	Q16 R6 1,2 HSSC			
	1,5			6°	Q16 R6 1,5 HSSC			
	1,2			12°	Q16 R12 1,2 HSSC			
	1,5			12°	Q16 R12 1,5 HSSC			
				1,2	16	13	6°	Q16 L6 1,2 HSSC
				1,5			6°	Q16 L6 1,5 HSSC
1,2		12°	Q16 L12 1,2 HSSC					
1,5		12°	Q16 L12 1,5 HSSC					

TUBE CUTTING DATE

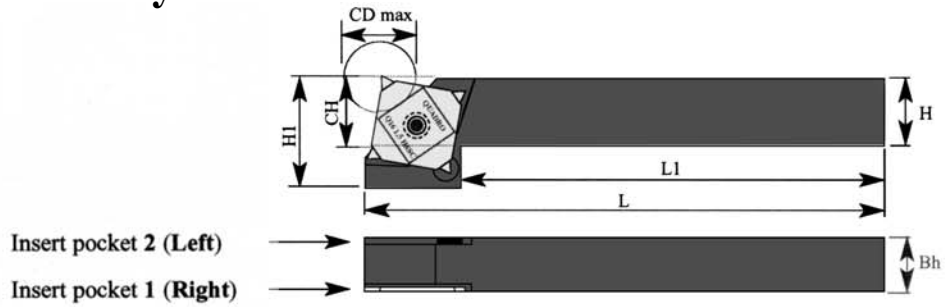


CD	d min.
50	47,2
40	36,6
30	25,2
25	19,0
20	11,8
16	5,0
13	0

For current stock availability, refer to our latest price list

Type Q25 / Q40 HSSC system

NOTE: Toolholders are supplied with screw and key.



Toolholder

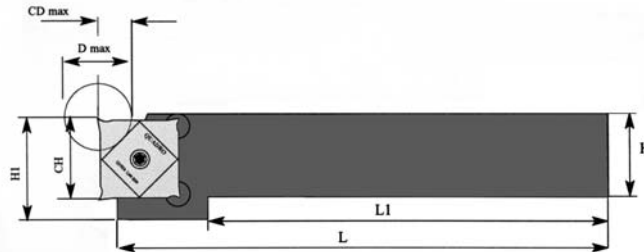
Ordering code Holder	H	Bh	CH	L	L1	HI	CD max. Insert	SPARE PARTS		TUBE CUTTING DATE	CD	d min.
								Insert Screw	Screw Key			
GEX1216M Q25	12		12								50	43,4
GEX1416M Q25	14		14						40		31,2	
GEX1616M Q25	16	16	16	150	125	32	20	Q25	30		16,4	
GEX2016M Q25	20	16	20						25		8,4	
GEX2516M Q25	25	25	25						20		0	
GEX3216M Q25	32	32	32						16		0	
GEX2020M Q40	20	20	20	200	145	55	20	Q40			13	0
GEX2525M Q40	25	25	25									

Inserts TiN coated high speed steel

			CW	S	CD	Part number		
			+0,02	+0,05	max.			
			1,0				Q25 1,0 HSSC	
			1,5				Q25 1,5 HSSC	
			2,0	25	20		Q25 2,0 HSSC	
			2,5				Q25 2,5 HSSC	
3,0			Q25 3,0 HSSC					
			CW	S	CD	Part number		
			+0,02	+0,05	max.		R H	
			1,0		6°		Q25 R6 1,0 HSSC	
			1,5		6°		Q25 R6 1,5 HSSC	
			2,0	25	20		6°	Q25 R6 2,0 HSSC
			2,5		6°		Q25 R6 2,5 HSSC	
			3,0		6°		Q25 R6 3,0 HSSC	
			1,5	25	20		12°	Q25 R12 1,5 HSSC
2,0		12°	Q25 R12 2,0 HSSC					
			CW	S	CD	Part number		
			+0,02	+0,05	max.		L H	
			1,0		6°		Q25 L6 1,0 HSSC	
			1,5		6°		Q25 L6 1,5 HSSC	
			2,0	25	20		6°	Q25 L6 2,0 HSSC
			2,5		6°		Q25 L6 2,5 HSSC	
			3,0		6°		Q25 L6 3,0 HSSC	
			1,5	25	20		12°	Q25 L12 1,5 HSSC
2,0		12°	Q25 L12 2,0 HSSC					
			CW	S	CD	Part number		
			+0,02	+0,05	max.			
2,0	40	20	Q40 2,0 HSSC					

For current stock availability, refer to our latest price list

Type Q16 HM system



Toolholder

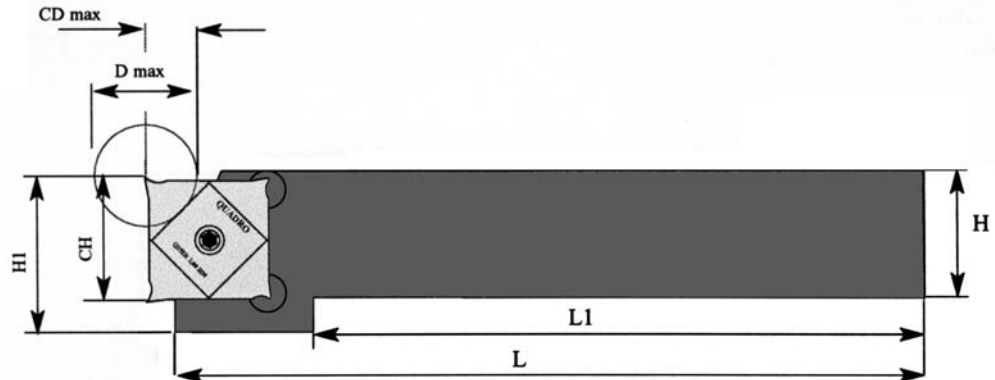
Part number	H	Bh	CH	L	L1	H1	Insert	Spare parts for the Quadro® Q16 system		
								Description	Part number	Number per Hold
GEX1010K Q16 HM	10	10	10	125	110	20	Q16	Screw for Q16 insert Key for T9-M3 screw	T9 - M3 CQ - T9	1 1
GEX1212K Q16 HM	12	12	12	125	110	20				
GEX1616K Q16 HM	16	16	16	125	110	20				
GEX2016K Q16 HM	20	16	20	125		20				
GEX2020K Q16 HM	20	20	20	125		20				
GEX2525K Q16 HM	25	25	25	125		20				

Inserts TiCN coated carbide

Insert for precision parting-off	Part number	CW-0,05	Circlip max.	CD max.
		Q16ER 0,50 HM P30TCN	0,57 mm	0,4
Q16ER 0,60 HM P30TCN		0,67 mm	0,5	3,00
Q16ER 0,70 HM P30TCN		0,77 mm	0,6	3,00
Q16ER 0,80 HM P30TCN		0,87 mm	0,7	6,50
Q16ER 0,90 HM P30TCN		0,97 mm	0,8	6,50
Q16ER 1,00 HM P30TCN		1,07 mm	0,9	6,50
Q16ER 1,10 HM P30TCN		1,24 mm	1,0	6,50
Q16ER 1,30 HM P30TCN		1,44 mm	1,2	6,50
Q16ER 1,60 HM P30TCN		1,74 mm	1,5	6,50
Q16ER 1,85 HM P30TCN		1,99 mm	1,75	6,50
Q16ER 2,15 HM P30TCN		2,29 mm	2,0	6,50
Q16ER 2,65 HM P30TCN		2,79 mm	2,5	6,50
Q16ER 3,15 HM P30TCN		3,29 mm	3,0	6,50
Q16ER 4,15 HMP30TCN		4,29 mm	4,0	6,50
Q16ER 5,15 HMP30TCN	5,29 mm	5,0	6,50	

For current stock availability, refer to our latest price list

Type Q25 HM system



Toolholder

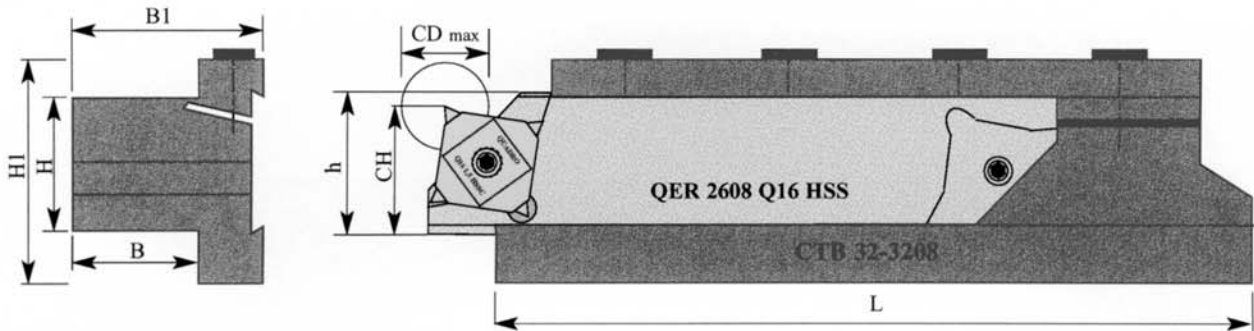
Part number	H	Bh	CH	L	L1	H1	Insert	Spare parts for the Quadro® Q25 system		
								Description	Ordering Code	Number per Holder
GEX1616M Q25 HM	16	16	16	150	125	32	Q25	Screw for Q25 insert Key for T15 - M3 screw	T15 - M5 CQ - T15	1 1
GEX1620M Q25 HM	16	20	16	150	125	32				
GEX2020M Q25 HM	20	20	20	150	125	32				
GEX2520M Q25 HM	25	20	25	150	125	32				
GEX2525M Q25 HM	25	25	25	150	125	32				
GEX3220M Q25 HM	32	20	32	150	32					

Inserts TiCN coated carbide

Insert for precision parting-off	Part number	CW -0,05	CD
	<p>Technical drawing of a TiCN coated carbide insert. The drawing shows a side view with dimension CW (width) and a top view with dimension S (side length). The insert is diamond-shaped with a circular hole in the center and the word 'QUADRO' and 'Q25ER 1,9 HM' printed on it.</p>	Q25ER 1,00 HM P30TCN	1,00 mm.
Q25ER 1,50 HM P30TCN		1,50 mm.	10
Q25ER 2,00 HM P30TCN		2,00 mm.	10
Q25ER 2,50 HM P30TCN		2,50 mm.	10
Q25ER 3,00 HM P30TCN		3,00 mm.	10
Q25ER 3,50 HM P30TCN		3,50 mm.	10
Q25ER 4,00 HM P30TCN		4,00 mm.	10
Q25ER 4,15 HM P30TCN		4,29 mm.	10
Q25ER 5,00 HM P30TCN		5,00 mm.	10
Q25ER 5,15 HM P30TCN		5,29 mm.	10

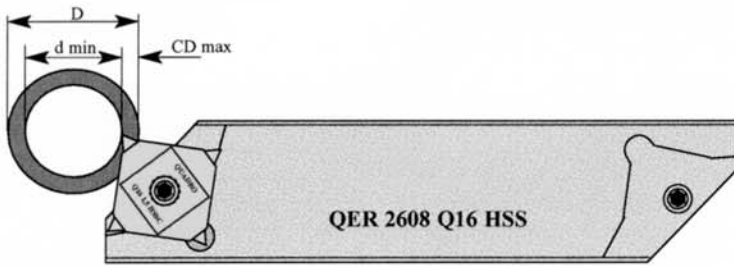
For current stock availability, refer to our latest price list

Type Q16 / Q25 blades and blocks



Holder Q16 Part number	h	H	B	L	H1	B1
CTB16 2608	26	16	16	76	38	30
CTB20 2608	26	20	19	87	38	33

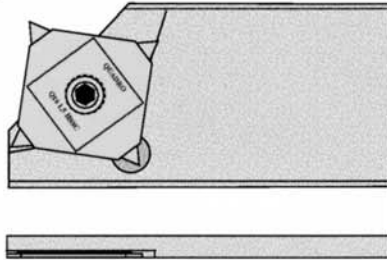
Holder Q25 Part number	h	H	B	L	H1	B1
CTB25 3208	32	25	22	120	48	38
CTB32 3208	32	32	28,5	120	48	44,5



CD max	Q16 HSS dmin	Q16 HM dmin	Q25 HSS dmin	Q25 HM dmin
12,5	0	0	0	0
20	12,5	12,5	0	0
25	19	19	10	10
30	25	25	16	16
40	36	36	32	32
50	47	47	44	44
75	73	73	71	71
100			97	97
125			123	123

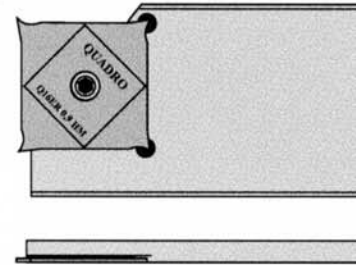
Quadro[®] HSS support blade

NOTE: Supportblades are supplied with screw and key. For inserts, see page



Quadro[®] HM support blade

NOTE: Supportblades are supplied with screw and key. For inserts, see page



HSS support blade Part number	CH	h	CW	L	HM support blade Part number
QER 2608 Q16 HSS	21,4	26	8	110	QER 2608 Q16 HM
QEL 2608 Q16 HSS	21,4	26	8	110	QEL 2608 Q16 HM
QER/L 2608 Q16 HSS	21,4	26	8	110	QER/L 2608 Q16 HM
QER 3208 Q25 HSS	32	32	8	150	QER 3208 Q25 HM
QEL 3208 Q25 HSS	32	32	8	150	QEL 3208 Q25 HM
QER/L 3208 Q25 HSS	32	32	8	150	QER/L 3208 Q25 HM

SPARE PARTS FOR QUADRO[®] SYSTEM

Part number	Description	Number per support blade
T9 - M3	Screw for Q16 insert	2
CQ - T9	Key for T9-M3 screw	1
T15 - M5	Screw for Q25 insert	2
CQ - T15	Key for T15-M5 screw	1

Technical Information - Speeds & Feeds

INSERTS WITH 0° FRONT ANGLE

These inserts can be used as RH inserts as well as LH inserts.

ATENTION!
These inserts can only be used as **LH** insert in insert pocket (2) (see drawing of toolholder)

INSERTS WITH 6° OR 12° FRONT ANGLE

ATENTION!
These inserts can only be used as **RH** insert in insert pocket (1) (see drawing of toolholder)

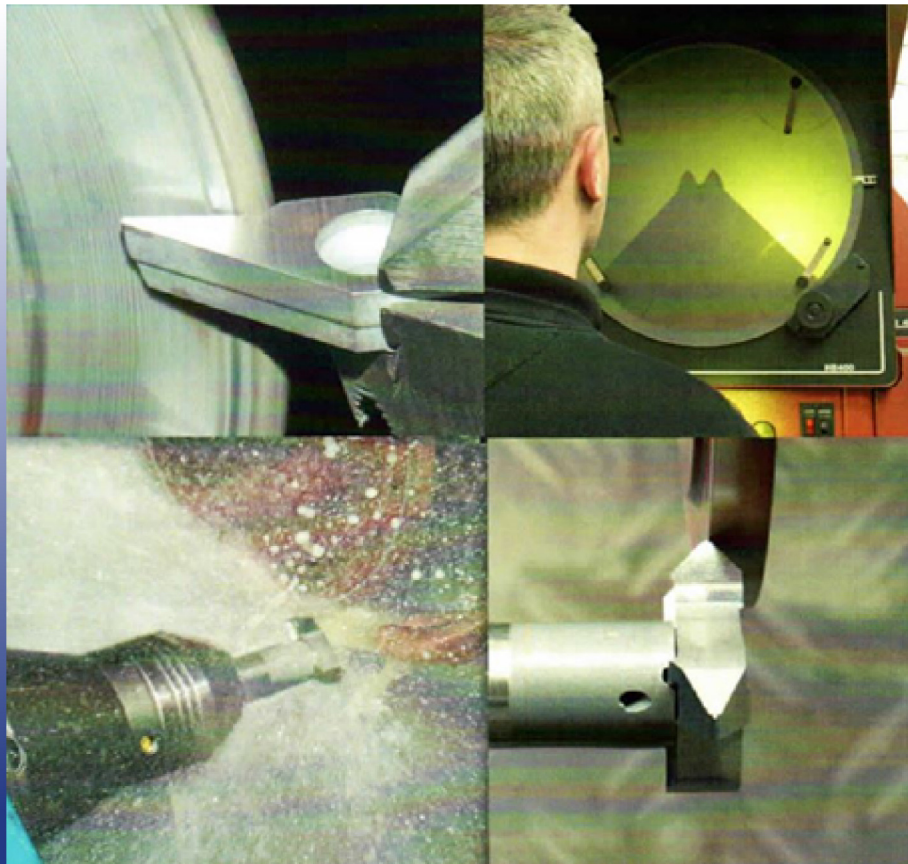
CUTTING SPEEDS & FEEDS

Material	Cutting speed m/min	Feed mm/rev (Cutting width)						
		0,7~0,9	1,0	1,2	1,5	2,0	2,5	3,0
Unalloyed steel	40 ~ 60	0,05~0,8	0,08~0,1	0,08~0,1	0,1~0,15	0,1~0,2	0,1~0,2	0,1~0,25
Alloyed steel	30 ~ 50	0,04~0,5	0,04~0,06	0,05~0,06	0,05~0,1	0,08~0,15	0,1~0,18	0,1~0,2
Heat resistand steel	30 ~ 40	0,04~0,5	0,04~0,06	0,05~0,06	0,05~0,1	0,08~0,15	0,1~0,18	0,1~0,2
Stainless steel	30 ~ 40	0,04~0,5	0,05~0,06	0,05~0,06	0,05~0,1	0,08~0,15	0,1~0,18	0,1~0,2
Cast iron	20 ~ 30	0,04~0,5	0,05~0,06	0,05~0,06	0,05~0,1	0,08~0,15	0,1~0,18	0,1~0,2
Non-Ferrous materials	~ 150	~0,15	~0,2	~0,2	~0,25	~0,25	~0,25	~0,3

Values are based on a cutting edge lifetime of 15 minutes.



Manufacturers of Precision Ground Cutting Tools



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