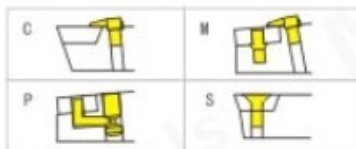


H O B B Y V Ě C Í

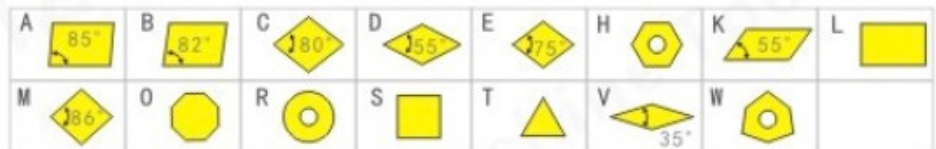
System značení soustružnických nožů (ENG original).

M	C	L	N	R		2	5	2	5	M	1	2	*
1	2	3	4	5		6	7	8	9	10	11	12	13
S	16	Q			S	C	L	C	R	0	9	18	*
14	15	10			1	2	3	4	5	11	12	16	13

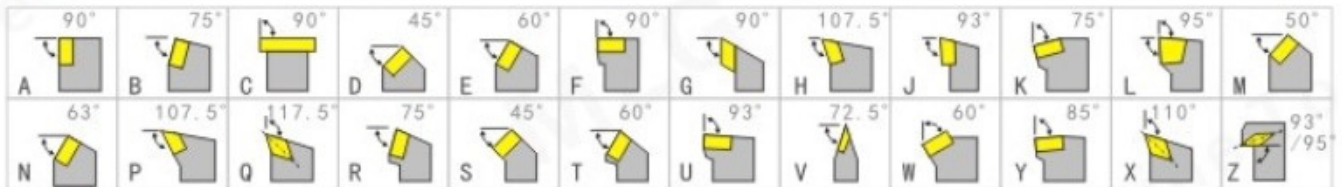
1 Clamping system



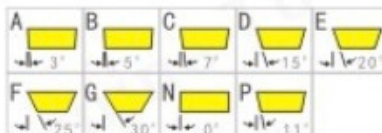
2 Insert shape



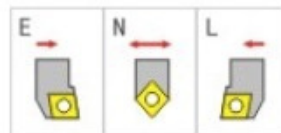
3 Cutting edge angle



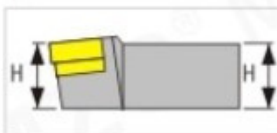
4 Insert relief angle



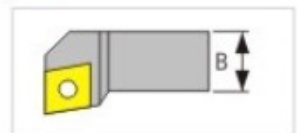
5 Hand of tool



6/7 Shank Height



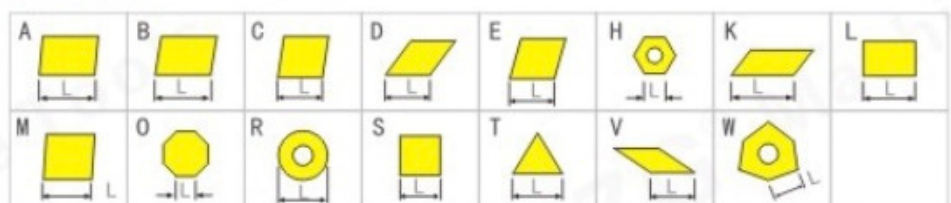
8/9 Shank width



10 Toolholder length

			L
A	32	N	160
B	40	P	170
C	50	Q	180
D	60	R	200
E	70	S	250
F	80	T	300
G	90	U	350
H	100	V	400
J	110	W	450
K	125	Y	500
L	140	X	SPECIAL
M	150		

11/12 Insert size



14 SHANK

s= Steel shank
A=Steel shank+oilant hole
B=Steelshank+device anti-vibration
C=Cemented carbide shank with steel head
D=Steel shank+device anti-vibration+coolant hole
E=Cemented carbide shank with steel head+coolant hole
F=Cemented carbide shank with steel head+device anti-vibration
G=Cemented carbide shank with steel head+device anti-vibration+coolant hole
H=Heavy metal shank
J=Heavy metal shank+coolant hole

13 Special code

INSERTS	R-S
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15 Shank diameter

16 Minimum processing diameter



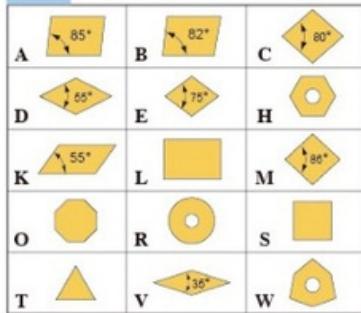
HOBBYVĚCI

System značení břitových destiček (ENG original).

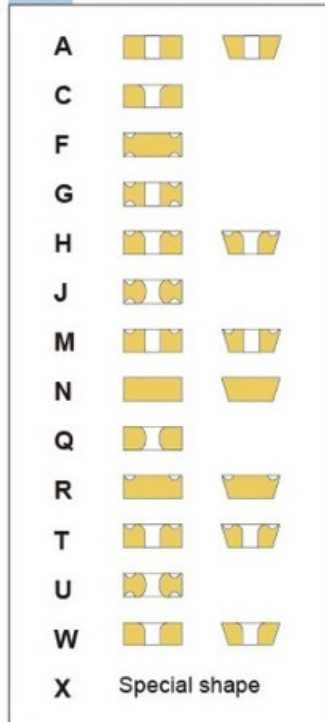
C	N	M	G
1	2	3	4

12	04	08	(E)	(N)	(MR)
5	6	7	8	9	10

1 SHAPE INSERT



4 INSERT FEATURES



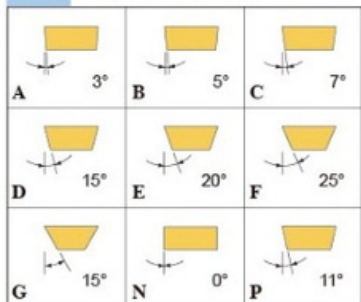
6 TIP THICKNESS

Index	S(mm)
01	1.59
T1	1.98
02	2.38
03	3.18
T3	3.97
04	4.76
05	5.56
06	6.35
07	7.94
09	9.52

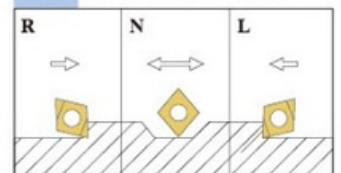
8 CUTTING EDGE

- E Rounded
- F Sharp
- T Chamfered
- S Chamfers and rounded

2 CLEARANCE ANGLE



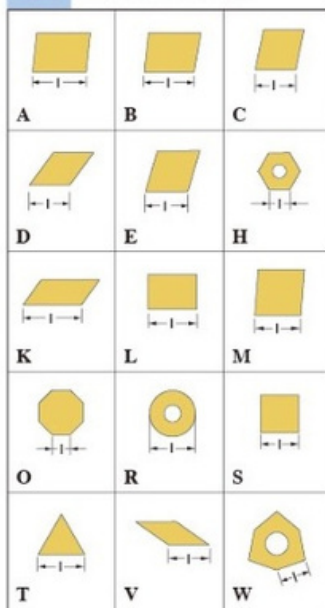
9 CUTTING DIRECTION



3 TOLERANCES CLASS

	Tolerance		
	d±	m±	s±
A	0.025	0.005	0.025
C	0.025	0.013	0.025
E	0.025	0.025	0.025
F	0.013	0.005	0.025
G	0.025	0.025	0.05-0.13
H	0.013	0.013	0.025
J	0.05-0.15	0.005	0.025
K	0.05-0.15	0.013	0.025
L	0.05-0.15	0.025	0.025
M	0.05-0.15	0.08-0.2	0.05-0.13
N	0.05-0.15	0.08-0.2	0.025
U	0.08-0.25	0.13-0.38	0.13

5 EDGE LENGTH



7 CORNER RADIUS

Index	S(mm)
02	0.2
04	0.4
08	0.8
12	1.2
16	1.6
24	2.4
00	0

00: Round insert (inch)
MO: Round insert (meter)

10 MANUFACTURE'S TYPE DESIGNATION

Chip breaker design

