



Modular grooving system

Maintain flexibility in your production operations



– EN –



ZCC Cutting Tools Europe GmbH

your Partner \ your Value

The Company

Zhuzhou Cemented Carbide Cutting Tools Co., Ltd. (**ZCC-CT**), based in Zhuzhou, China, is the largest Chinese manufacturer of carbide tools. It is also a key company of China Tungsten High-Tech Material Co. Ltd. part of the China Minmetals Corporation.

Since its founding in 1953, ZCC Cutting Tools Co., Ltd. has grown to become one of the world's leading carbide manufacturers with more than 2,000 employees by using the latest technologies and employing highly skilled personnel. The company continuously modernises production technologies and expands its production capacities to enable the company's ongoing growth. As part of Minmetals Corporation, ZCC-CT is able to cover the entire value chain of modern carbide tool production itself, from raw material extraction through to the coated end product and all associated intermediate steps.

By drawing on the latest in European production technology, the company offers products that consistently meet the highest quality standards. Our extensive product range includes carbide/solid carbide, cermet, CBN, PCD and ceramic inserts, carbide tools, tool holders, milling bodies and the accompanying tool systems. All products are consistently produced to accepted international standards, including ISO, DIN, ANSI, JIS and BSI. In addition, ZCC-CT offers customised solutions and special carbide products built to individual specifications.

ZCC-CT invests heavily in research and development. The associated investments go beyond that of most competitors. ZCC Cutting Tools' excellently trained engineers, scientists and a competent, international team, research the necessary fundamentals. These form the basis for the ongoing development of new products and the improvement of existing ones.

The company continuously introduces improvements in quality to meet the customers' ever-increasing demands for new and innovative products and to maximise the benefit of each individual

customer. Both production and administration in China are subject to the ISO 9001:2008 standard, while environmental management is subject to the requirements set out in ISO 14001:2004.

The foundation of the European headquarters of ZCC-CT, **ZCC Cutting Tools Europe GmbH** and the European central warehouse, both located in Düsseldorf (Germany), dates back to 2003. Today, all European countries as well as the adjacent markets are served from there.

The quality management system of ZCC Cutting Tools Europe GmbH is certified in the area of 'distribution and logistics of metal-working tools' in accordance with ISO 9001:2008.

The Test and Demonstration Centre is available for optimizing customer processes according to individual requirements.

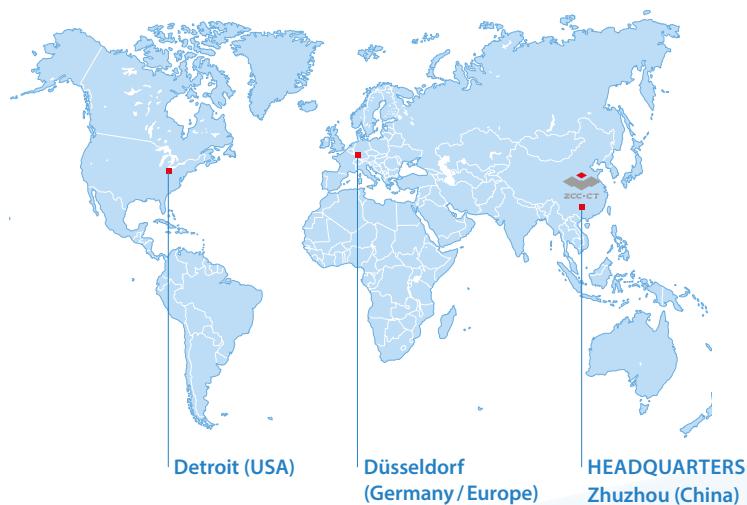
External sales staff and distribution partners in Europe work hand in hand to support customers across the region. Our friendly ZCC-CT application engineers are also available to support you with their expertise and experience by phone, e-mail or in person at your production facility.

The entire field and office sales force is available to answer enquiries from clients across Europe in their native language. Together with employees from the logistics team and with the help of a sophisticated service system, they ensure that all orders are delivered as quickly as possible to you. Branch offices in France and Great Britain add to additional regional proximity to customers.

ZCC Cutting Tools Europe GmbH and all of our employees are there for you and have your back as a competent partner for all matters concerning machining production. This is how we define 'your partner – your value'.



Member of Minmetals Group



Modular grooving system

Tool holder

VDI – B1 and B4	A4
VDI – B2 and B3	A5
VDI – C1 and C4	A6
HSK-A	A7
PSC	A8

Parting & grooving /Turning

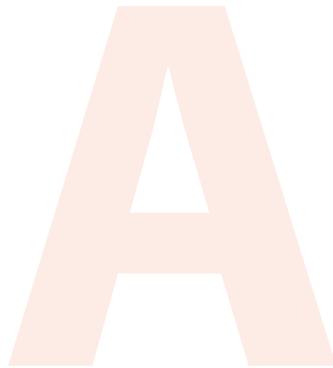
Advantages of system and mechanical design	A10–A11
Base cartridge	A12
Primary cartridge	A13
Inserts (single sided / double sided)	A14–A16

Parting & grooving (a, max. 40 mm)

Advantages of system and mechanical design	A18–A19
Base cartridge	A20
Primary cartridge	A21
Inserts (single sided)	A22–A23

Technical Information

Tool orientation	A24
Tool overall length	A25



A

Turning

B

Milling

C

Drilling

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Modular grooving system

VDI – B1 and B4

A

Tool holder VDI – B1 and B4

Turning

B

Milling

C

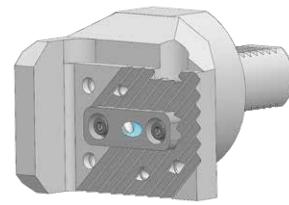
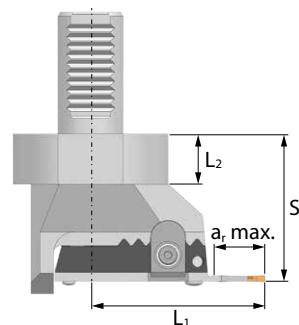
Drilling

D

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Article	VDI	Stock	Tool arrangement	Dimensions [mm]		Base cartridge
				L ₂		
ZF.0.1.1.1.A	VDI25	●	B1 and B4	18		ZF.1.1.L.**
ZF.0.1.2.1.A	VDI30	●	B1 and B4	22		ZF.1.1.L.**
ZF.0.1.3.1.A	VDI40	●	B1 and B4	22		ZF.1.1.L.**
ZF.0.1.4.1.A	VDI50	●	B1 and B4	30		ZF.1.1.L.**

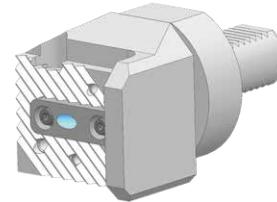
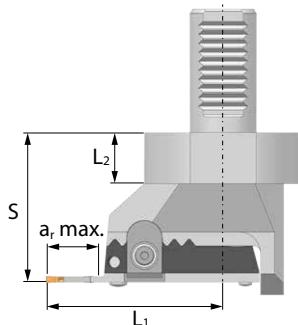
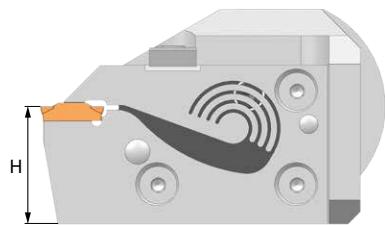
● Ex stock ○ On demand

Spare parts

	Article	Stock
	Clamp	●

Tool holder**VDI – B2 and B3****A**

Turning



Article	VDI	Stock	Tool arrangement	Dimensions [mm]		Base cartridge
				L ₂		
ZF.0.1.2.A	VDI25	○	B2 and B3	18		ZF.1.1.R.**
ZF.0.1.2.2.A	VDI30	○	B2 and B3	22		ZF.1.1.R.**
ZF.0.1.3.2.A	VDI40	○	B2 and B3	22		ZF.1.1.R.**
ZF.0.1.4.2.A	VDI50	○	B2 and B3	30		ZF.1.1.R.**

● Ex stock ○ On demand

B

Milling

C

Drilling

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E**Spare parts**

	Article	Stock
	Clamp	ZF.0.C.0

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Modular grooving system

VDI – C1 and C4

A

Tool holder VDI – C1 and C4

Turning

B

Milling

C

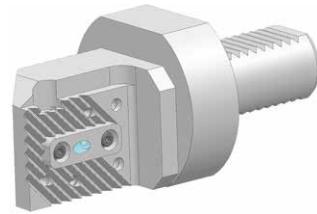
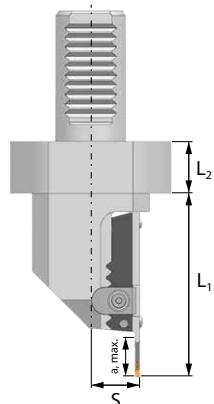
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Article	VDI	Stock	Tool arrangement	Dimensions [mm]	
				L ₂	Base cartridge
ZF.0.1.3.A	VDI25	●	C1 and C4	18	ZF.1.1.R.**
ZF.0.1.2.3.A	VDI30	●	C1 and C4	22	ZF.1.1.R.**
ZF.0.1.3.3.A	VDI40	●	C1 and C4	22	ZF.1.1.R.**
ZF.0.1.4.3.A	VDI50	●	C1 and C4	30	ZF.1.1.R.**

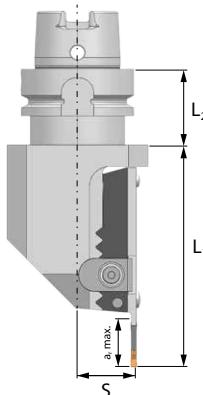
● Ex stock ○ On demand

Spare parts

	Article	Stock
	ZF.0.C.0	●

Tool holder

HSK-A



Article	HSK-A	Stock		Dimensions [mm]		Base cartridge
		R	L	L ₂		
ZF.0.2.1.0.A.R/L	HSK-A 32	○	○	36		ZF.1.1.R/L.**
ZF.0.2.2.0.A.R/L	HSK-A 40	●	●	36		ZF.1.1.R/L.**
ZF.0.2.3.0.A.R/L	HSK-A 63	●	●	42		ZF.1.1.R/L.**
ZF.0.2.4.0.A.R/L	HSK-A 80	○	○	42		ZF.1.1.R/L.**
ZF.0.2.5.0.A.R/L	HSK-A 100	○	○	45		ZF.1.1.R/L.**

● Ex stock ○ On demand

A

Turning

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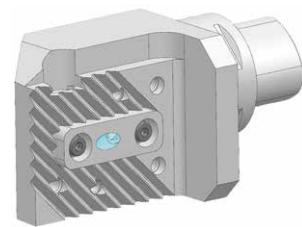
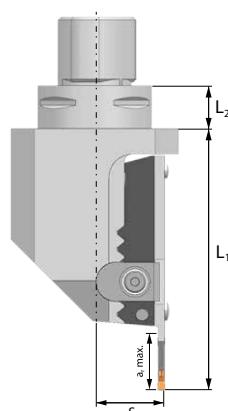
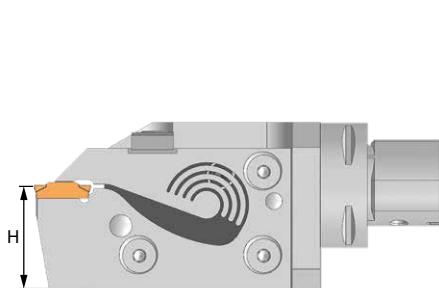
Spare parts

	Article	Stock
	Clamp	ZF.0.C.0

Modular grooving system PSC

A

Tool holder PSC



Turning

B

Milling

C

Drilling

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Spare parts

	Article	Stock
	ZF.O.C.0	●

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zFLEX®

Parting & grooving / Turning



Modular grooving system

Parting & grooving / Turning
Advantages of system and mechanical design

The tool holder is compatible with all primary cartridges, meaning it can be used in any grooving operation

Interlocking system ensures the tool holder and cartridge **fit together seamlessly**

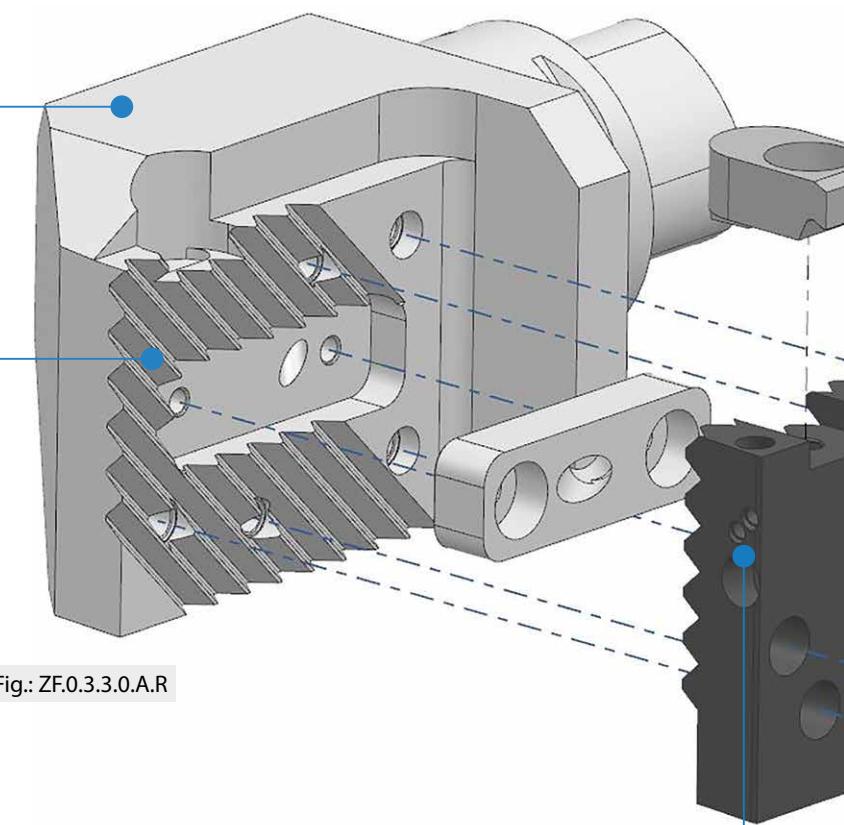


Fig.: ZF.0.3.3.0.A.R

ELI (External Like Internal) coolant supply system



ASSEMBLY INSTRUCTIONS

SCAN QR CODE AND
WATCH ON YOUTUBE

Take off with zFlex: Easy assembly – the key to success

YOUR BENEFITS

- Gain **flexibility** and **save time** in production
- Only one tool holder needed which keep costs down
- **Minimal wear and tear** on spare parts thanks to rugged design of tool system
- ELI coolant supply as an low-cost alternative to internal cooling
- Clamping function with **no plastic deformation**

Fig.: ZF.1.1.R.EC

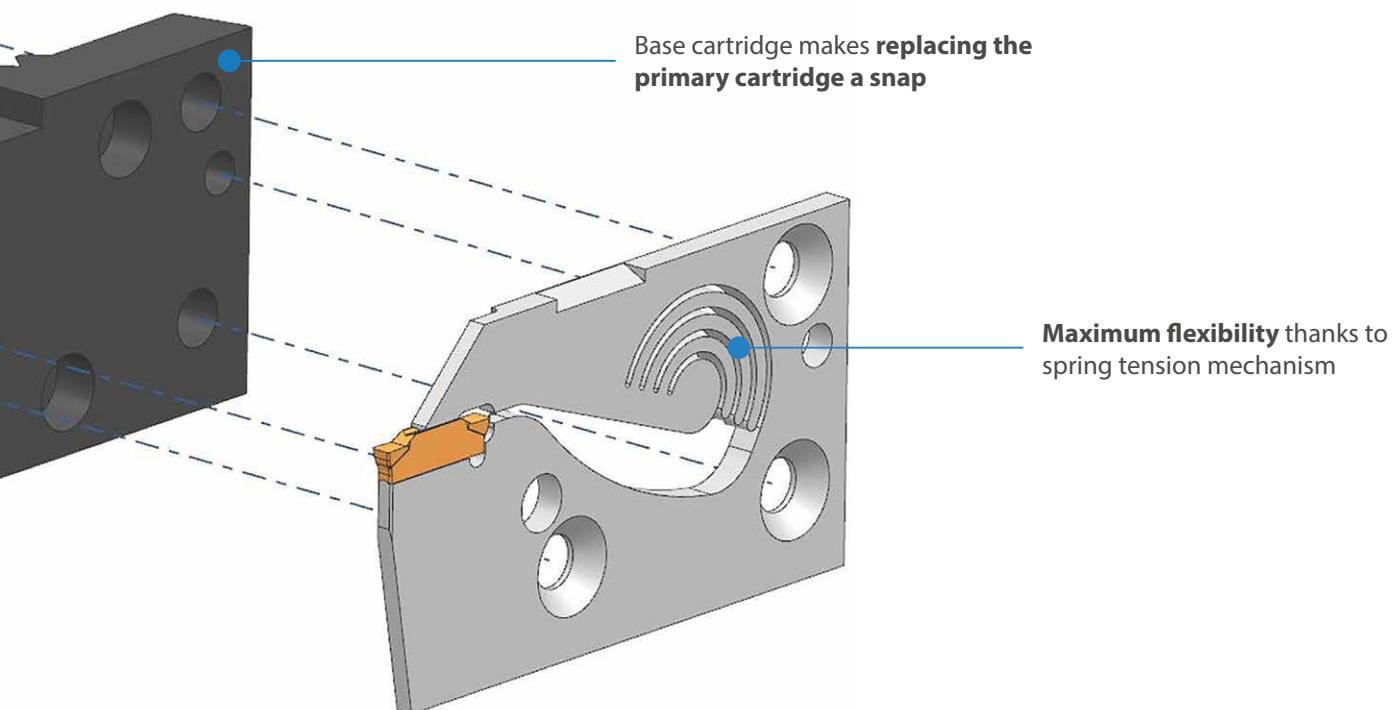


Fig.: ZF.2.1.F.R23.EC

Modular grooving system

Base cartridge

A

Base cartridge (Parting & grooving / Turning)

Turning

B

Milling

C

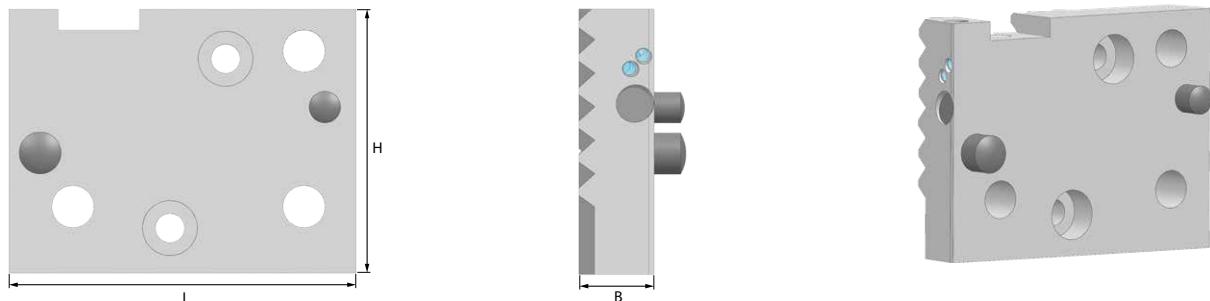
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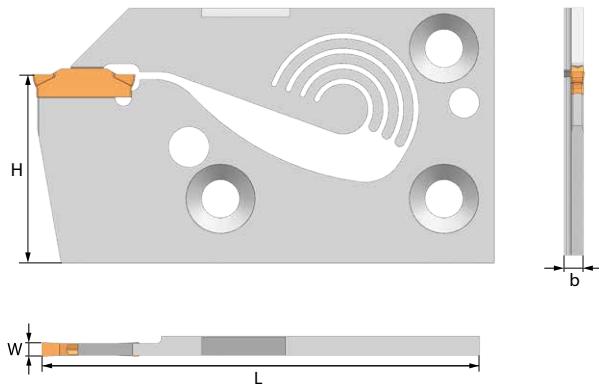
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Article	*	Stock		Dimensions [mm]		
		R	L	B	L	H
ZF.1.R/L.EC	ext.	●	●	11,25	66,5	50,5

● Ex stock ○ On demand

Spare parts			
	Article	Stock	
	Screw	ZF.1.M5x25	●
	Seal	ZF.1.S.0	●
	Wrench	WH40L	●

Primary cartridge (Parting & grooving /Turning)

Article	*	Stock		Dimensions [mm]					Insert
		R	L	W	H	a _r max.	L	b	
ZF.2.1.A.R/L17.EC	ext.	●	●	1,5	37,4	17	85,5	4,0	Z*AD01502
ZF.2.1.B.R/L17.EC	ext.	●	●	2,0	37,4	17	85,5	4,0	Z*BD02002
ZF.2.1.E.R/L23.EC	ext.	●	●	2,5	37,4	23	91,5	4,0	Z*ED02502
ZF.2.1.F.R/L23.EC	ext.	●	●	3,0	37,4	23	91,5	4,0	Z*FD0303
ZF.2.1.G.R/L27.EC	ext.	●	●	4,0	37,4	27	95,5	3,3	Z*GD0404
ZF.2.1.H.R/L27.EC	ext.	●	●	5,0	37,4	27	95,5	4,3	Z*HD0504
ZF.2.1.K.R/L27.EC	ext.	●	●	6,0	37,4	27	95,5	5,3	Z*KD0608
ZF.2.1.L.R/L31.EC	ext.	●	●	8,0	37,4	31	99,5	6,3	Z*LD0808

● Ex stock ○ On demand

Spare parts		
	Article	Stock
	Screw	ZF.2.M6x28
	Wrench	WH40L

A

Turning

B

Milling

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Modular grooving system

Inserts (single sided / double sided)

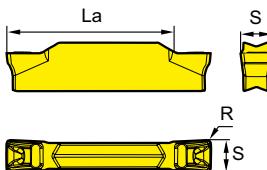
A

Turning

Parting inserts

- Ideal machining conditions
- Normal machining conditions
- ✖ Unfavourable machining conditions

Parting & grooving insert (double sided)



	HC ¹ (CVD)	HC ¹ (PVD)	HW
P			
M			
K			
N			
S			
H			

B

Milling

Double cutting edge

ISO	S	R±0,1	La max	f			
	ZTBD02002-MM	2,0	0,2	13	0,02-0,07		
	ZTED02503-MM	2,5	0,3	17	0,03-0,1	●	
	ZTFD0303-MM	3,0	0,3	17	0,04-0,13	●	
	ZTGD0404-MM	4,0	0,4	22	0,06-0,18	●	
	ZTHD0504-MM	5,0	0,4	22	0,08-0,23	●	
	ZTKD0608-MM	6,0	0,8	22	0,12-0,27	●	
	ZTLD0808-MM	8,0	0,8	28	0,13-0,29	● ○	

● Ex stock ○ On demand

HC¹ Coated carbide
HW Uncoated carbide

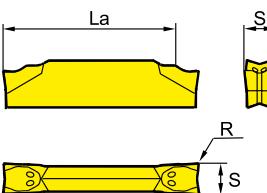
C

Drilling

- Ideal machining conditions
- Normal machining conditions
- ✖ Unfavourable machining conditions

Parting inserts

Parting & grooving insert (double sided)



	HC ¹ (CVD)	HC ¹ (PVD)	HW
P	✖ ✖		
M			
K			
N			
S		✖ ✖	
H			

D

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Double cutting edge

ISO	S±0,10	R±0,1	La max	f	VBC252 YBC251		
	ZPED02502-MG	2,5	0,2	17	0,03-0,1	●	
	ZPFD0302-MG	3,0	0,2	17	0,04-0,13	●	● ● ●
	ZPGD0402-MG	4,0	0,2	22	0,07-0,18	●	● ● ● ○
	ZPHD0503-MG	5,0	0,3	22	0,1-0,24	●	● ● ●
	ZPKD0604-MG	6,0	0,4	22	0,12-0,29	○	● ● ●

● Ex stock ○ On demand

HC¹ Coated carbide
HW Uncoated carbide

- Ideal machining conditions
- Normal machining conditions
- Unfavourable machining conditions

Parting inserts

Parting & grooving insert (double sided)							HC ¹ (CVD)	HC ¹ (PVD)	HW
ISO	L	S	θ	R	La max	f	YBC252	YB9320	YBG202 YBG302
ZPED02502-MG-6L	20,0	2,35	6°	0,2	17	0,03-0,08			
ZPED02502-MG-6R	20,0	2,35	6°	0,2	17	0,03-0,08			
ZPED02502-MG-15L	20,0	2,35	15°	0,2	17	0,03-0,05			
ZPED02502-MG-15R	20,0	2,35	15°	0,2	17	0,03-0,05			
ZPFD0302-MG-6L	20,0	2,85	6°	0,2	17	0,04-0,1			
ZPFD0302-MG-6R	20,0	2,85	6°	0,2	17	0,04-0,1			
ZPFD0302-MG-15L	20,0	2,85	15°	0,2	17	0,04-0,08			
ZPFD0302-MG-15R	20,0	2,85	15°	0,3	17	0,04-0,08			

● Ex stock ○ On demand

HC¹ Coated carbide
HW Uncoated carbide

Parting inserts

Parting & grooving insert (single sided)						HC ¹ (CVD)	HC ¹ (PVD)	HW
ISO	L ± 0,1	R ± 0,1	S ± 0,1	θ	f	YB9320		
ZPES02502-MG-6L	19,9	0,2	2,5	6°	0,03-0,08			
ZPES02502-MG-6R	19,9	0,2	2,5	6°	0,03-0,08			
ZPFS0302-MG-6L	19,9	0,2	3	6°	0,04-0,1			
ZPFS0302-MG-6R	19,9	0,2	3	6°	0,04-0,1			

● Ex stock ○ On demand

HC¹ Coated carbide
HW Uncoated carbide

A

Turning

B

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Modular grooving system

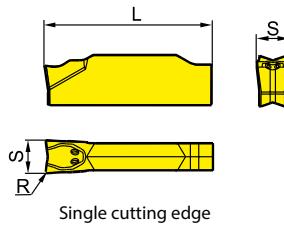
Inserts (single sided / double sided)

A

Turning

Parting inserts

Parting & grooving insert (single sided)



Single cutting edge

- Ideal machining conditions
- Normal machining conditions
- Unfavourable machining conditions

B

Milling

	ISO	L±0,1	R±0,1	S±0,10	f	YBC251	YB9320 YBG202 YBG302	YD201
	ZPES02502-MG	19,9	0,2	2,5	0,03-0,1		● ●	
	ZPFS0302-MG	19,9	0,2	3	0,04-0,13	●	● ●	
	ZPGS0402-MG	19,9	0,2	4	0,07-0,18	○	● ●	○
	ZPGS0402-MG-25	24,6	0,2	4	0,07-0,18		○	
	ZPHS0503-MG	19,9	0,3	5	0,1-0,24		○ ●	
	ZPHS0503-MG-25	24,6	0,3	5	0,1-0,24		○	
	ZPKS0604-MG	19,9	0,4	6	0,12-0,29		● ●	
	ZPKS0604-MG-25	24,6	0,4	6	0,12-0,29		○	

● Ex stock ○ On demand

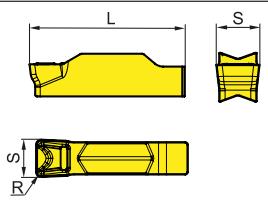
HC¹ Coated carbide
HW Uncoated carbide

C

Drilling

Parting inserts

Parting & grooving insert (single sided)



- Ideal machining conditions
- Normal machining conditions
- Unfavourable machining conditions

D

Technical Information

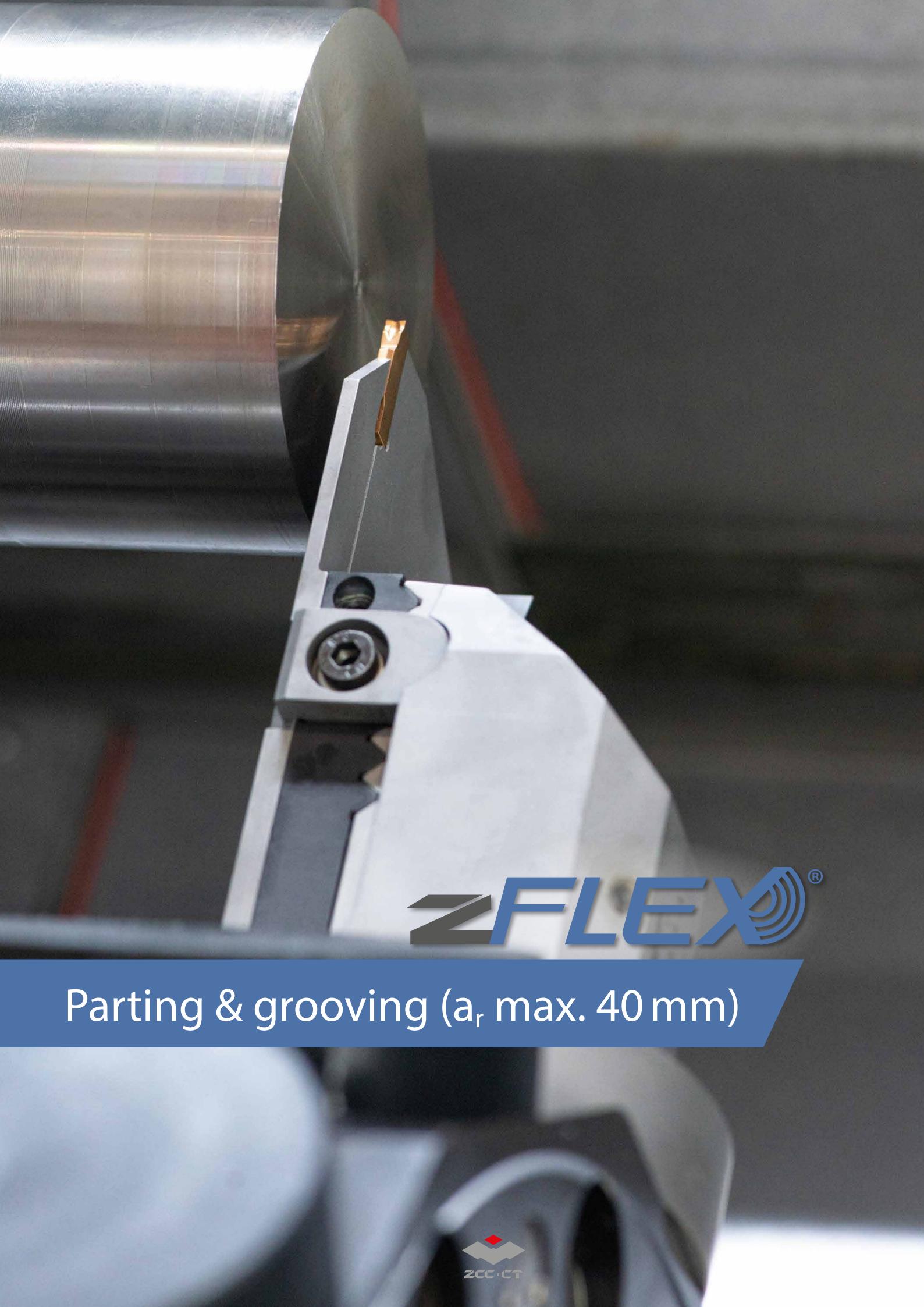
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	ISO	L±0,1	R±0,1	S±0,10	f	YB9320
	ZTES02503-MM	19,9	0,3	2,5	0,03-0,1	○
	ZTFS0303-MM	19,9	0,3	3	0,04-0,13	○
	ZTGS0404-MM-25	24,6	0,4	4	0,06-0,18	○
	ZTHS0504-MM-25	24,6	0,4	5	0,08-0,23	○
	ZTKS0608-MM-25	24,6	0,8	6	0,12-0,27	○

● Ex stock ○ On demand

HC¹ Coated carbide
HW Uncoated carbide



zFLEX®

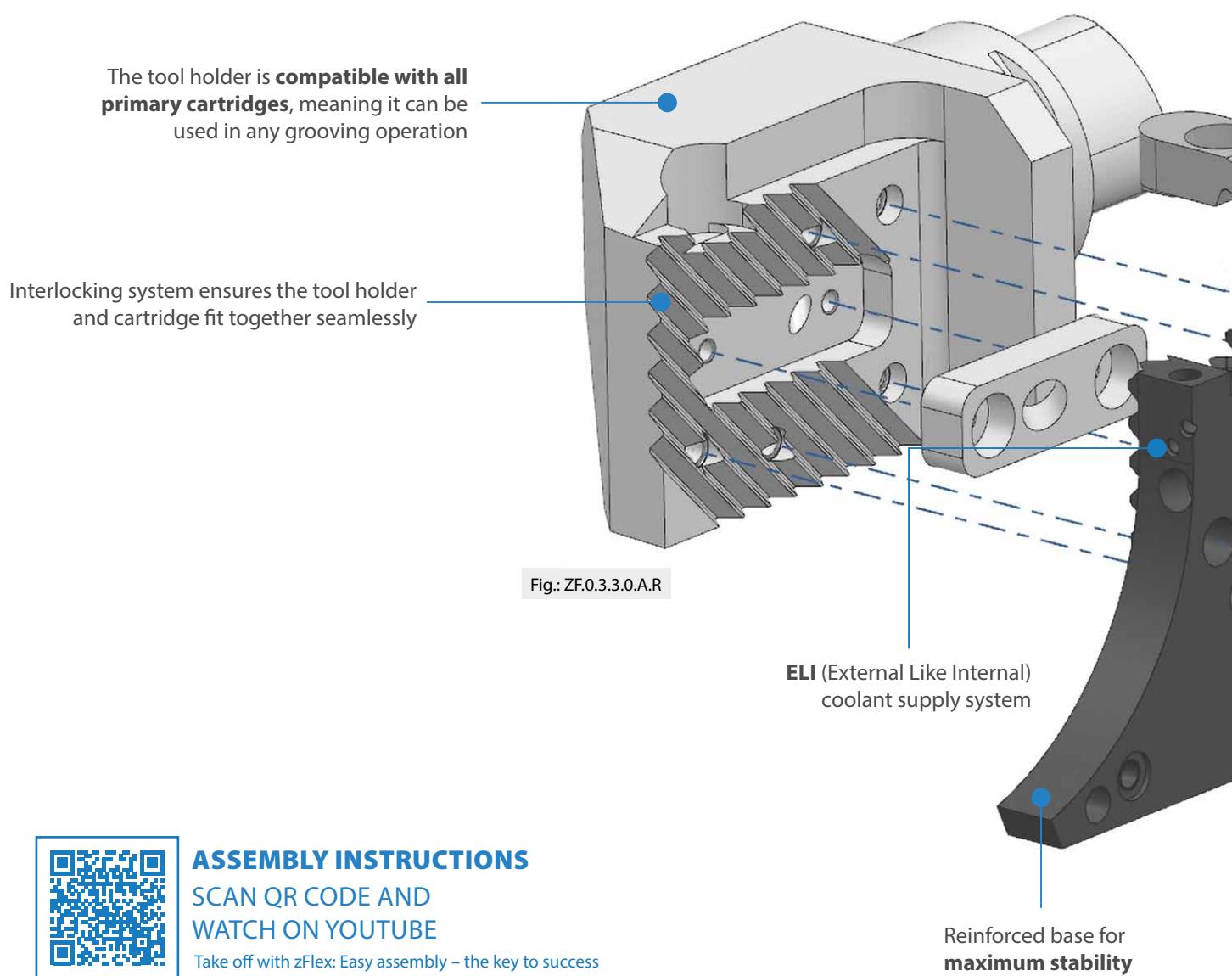
Parting & grooving (a_r max. 40 mm)



Modular grooving system

Parting & grooving (a_r max. 40 mm)

Advantages of system and mechanical design



ASSEMBLY INSTRUCTIONS

SCAN QR CODE AND
WATCH ON YOUTUBE

Take off with zFlex: Easy assembly – the key to success

YOUR BENEFITS

- With **strengthened base and primary cartridges** for parting operations up to Ø 80 mm
- **Flat, smooth results** thanks to high system rigidity
- Gain flexibility and save time in production
- **Minimal wear and tear** on spare parts thanks to rugged design of tool system
- ELI coolant supply as an low-cost alternative to internal cooling
- Spring tension **minimises plastic deformation** of the clamping finger

Fig.: ZF.1.2.R.EC

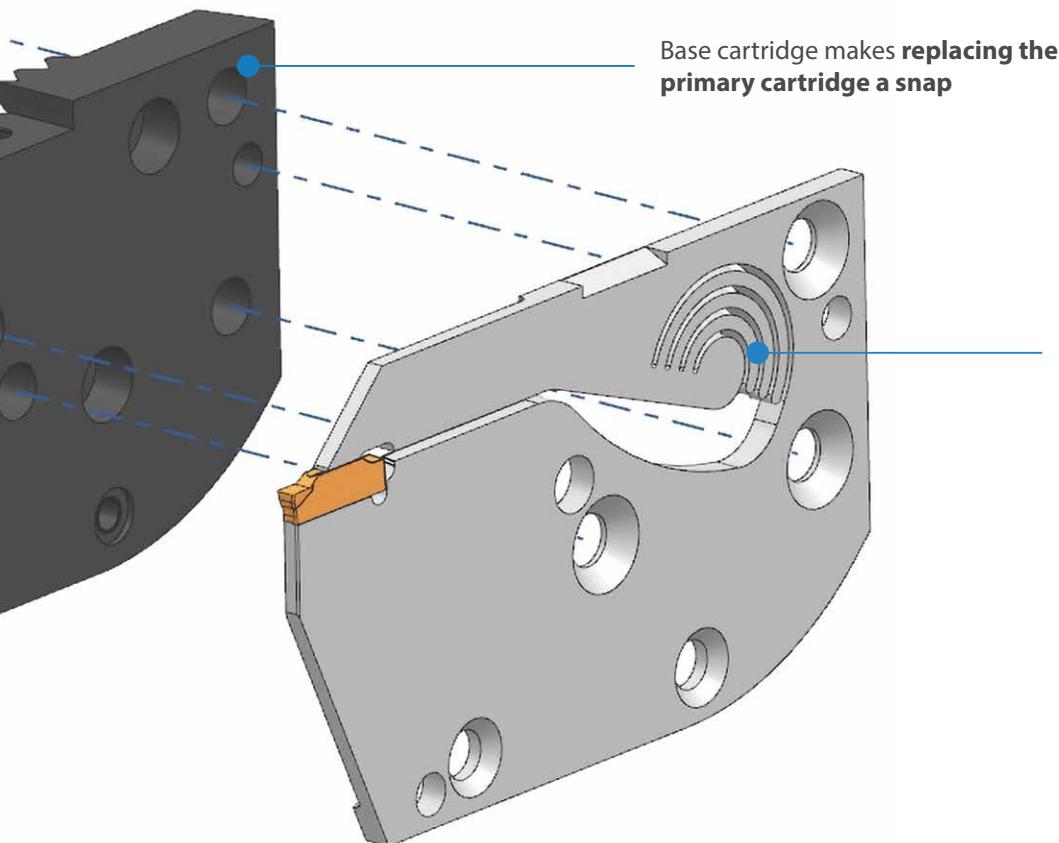


Fig.: ZF.2.2.F.R80.EC

Modular grooving system

Base cartridge

A

Base cartridge (Parting & grooving (a, max. 40 mm))

Turning

B

Milling

C

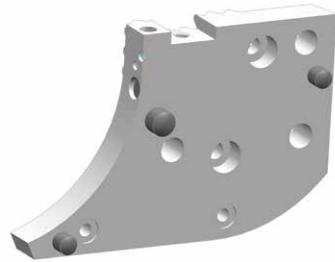
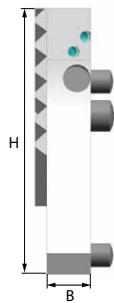
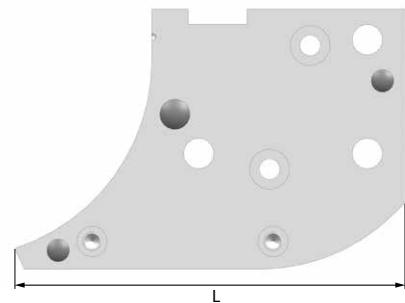
Drilling

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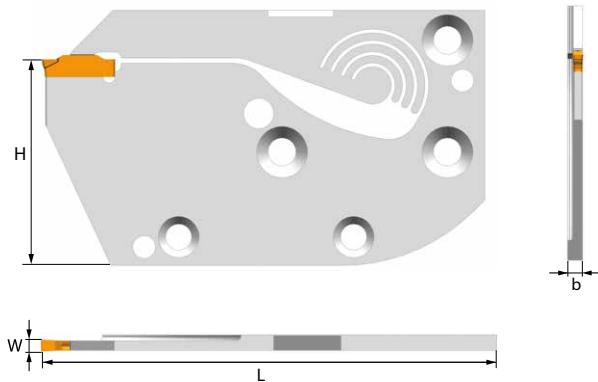
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Article	*	Stock		Dimensions [mm]		
		R	L	B	L	H
ZF.1.2.R/L.EC	ext.	●	●	14,25	102,5	68

● Ex stock ○ On demand

Spare parts			
	Article	Stock	
	Screw	ZF.1.M5x25	●
	Seal	ZF.1.S.0	●
	Wrench	WH40L	●

Primary cartridge (Parting & grooving (a_r max. 40 mm))

Article	*	Stock		Dimensions [mm]					Insert
		R	L	W	H	a _r max.	L	b	
ZF.2.2.B.R/L80.EC	ext.	●	●	2,0	37,4	80	118,5	4,0	Z*BS02002
ZF.2.2.E.R/L80.EC	ext.	●	●	2,5	37,4	80	118,5	4,0	Z*ES02502
ZF.2.2.F.R/L80.EC	ext.	●	●	3,0	37,4	80	118,5	4,0	Z*FS0303

● Ex stock ○ On demand

Spare parts			
	Article	Stock	
	Screw	ZF.2.M6x28	●
	Screw	ZF.2.M5x12	●
	Pin	ZF.2.D6x13	●
	Pin	ZF.2.D8x13	●
	Wrench	WH40L	●

A

Turning

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Modular grooving system

Inserts (single sided)

A

Parting inserts

- Ideal machining conditions
- Normal machining conditions
- Unfavourable machining conditions

Turning

B

Milling

C

Drilling

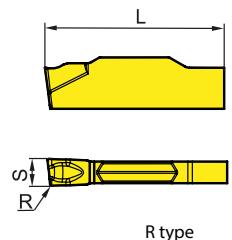
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Parting & grooving insert (single sided)



	HC ¹ (CVD)	HC ¹ (PVD)	HW
P			
M			
K			
N			
S			
H			

ISO

L ±0,1

R ±0,1

S ±0,1

θ

f

YB9320



ZPES02502-MG-6L

19,9

0,2

2,5

6°

0,03-0,08

●

ZPES02502-MG-6R

19,9

0,2

2,5

6°

0,03-0,08

●

ZPFS0302-MG-6L

19,9

0,2

3

6°

0,04-0,1

●

ZPFS0302-MG-6R

19,9

0,2

3

6°

0,04-0,1

●

● Ex stock ○ On demand

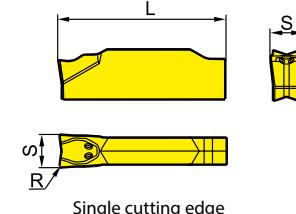
HC¹ Coated carbide

HW Uncoated carbide

Parting inserts

- Ideal machining conditions
- Normal machining conditions
- Unfavourable machining conditions

Parting & grooving insert (single sided)



	HC ¹ (CVD)	HC ¹ (PVD)	HW
P	●	● ● ●	
M		● ● ●	
K			
N			
S		● ●	
H			

ISO

L ±0,1

R ±0,1

S ±0,10

f

YBC251

YB9320

YBG202
YBG302

YD201



ZPES02502-MG

19,9

0,2

2,5

0,03-0,1

●

●

ZPFS0302-MG

19,9

0,2

3

0,04-0,13

●

●

ZPGS0402-MG

19,9

0,2

4

0,07-0,18

○

●

ZPGS0402-MG-25

24,6

0,2

4

0,07-0,18

●

ZPHS0503-MG

19,9

0,3

5

0,1-0,24

○

●

ZPHS0503-MG-25

24,6

0,3

5

0,1-0,24

●

●

ZPKS0604-MG

19,9

0,4

6

0,12-0,29

●

●

ZPKS0604-MG-25

24,6

0,4

6

0,12-0,29

●

● Ex stock ○ On demand

HC¹ Coated carbide

HW Uncoated carbide

- Ideal machining conditions
- Normal machining conditions
- Unfavourable machining conditions

Parting inserts

Parting & grooving insert (single sided)					HC ¹ (CVD)	HC ¹ (PVD)	HW
	P						
	M						
	K						
	N						
	S						
	H						
ISO	L±0,1	R±0,1	S±0,10	f			YB9320
	ZTES02503-MM	19,9	0,3	2,5	0,03-0,1		
	ZTFS0303-MM	19,9	0,3	3	0,04-0,13		
	ZTGS0404-MM-25	24,6	0,4	4	0,06-0,18		
	ZTHS0504-MM-25	24,6	0,4	5	0,08-0,23		
	ZTKS0608-MM-25	24,6	0,8	6	0,12-0,27		

● Ex stock ○ On demand

HC¹ Coated carbide
HW Uncoated carbide

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Tool orientation, VDI base adapter

A

Turning

B

Milling

C

Drilling

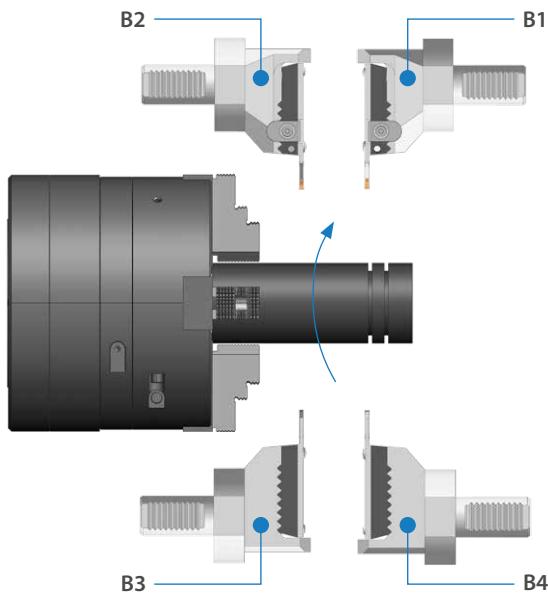
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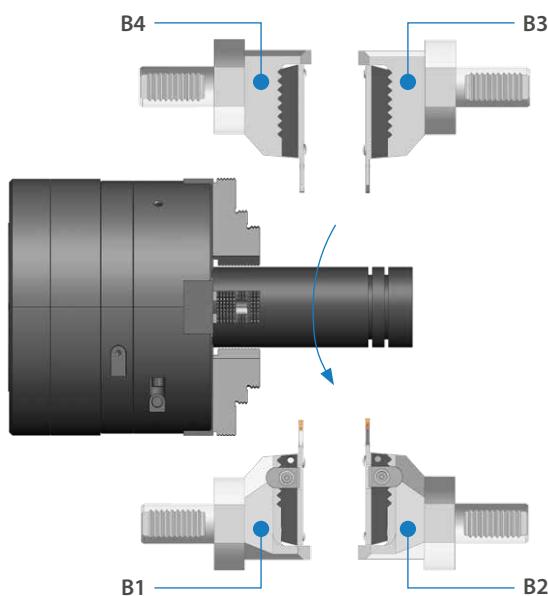
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Radial tool orientation if spindle rotates **left**



Radial tool orientation if spindle rotates **right**

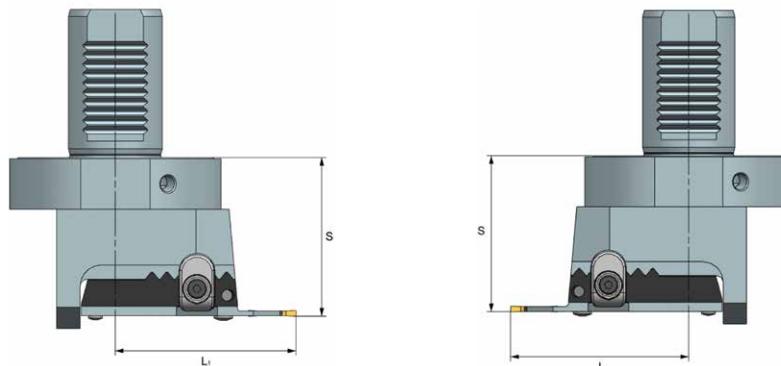


Tool overall length

VDI-B1/B4 | VDI-B2/B3

	L_1	S
ZF.2.1.A.R/L17.EC	71 mm	67,3 mm
ZF.2.1.B.R/L17.EC	71 mm	67,5 mm
ZF.2.1.E.R/L23.EC	77 mm	67,6 mm
ZF.2.1.F.R/L23.EC	77 mm	67,6 mm
ZF.2.1.G.R/L27.EC	81 mm	67 mm
ZF.2.1.H.R/L27.EC	81 mm	68 mm
ZF.2.1.K.R/L27.EC	81 mm	69 mm
ZF.2.1.L.R/L31.EC	85 mm	70,5 mm
ZF.2.2.B.R/L80.EC	104 mm	67,5 mm
ZF.2.2.E.R/L80.EC	104 mm	67,6 mm
ZF.2.2.F.R/L80.EC	104 mm	67,6 mm

VDI-B1/B4 | VDI-B2/B3



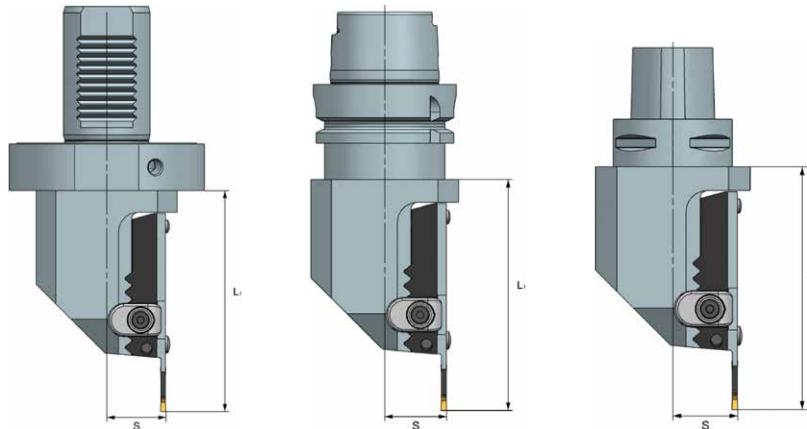
VDI-C1/C4 | HSK-A | PSC

	L_1	S
ZF.2.1.A.R/L17.EC	96 mm	27,0 mm
ZF.2.1.B.R/L17.EC	96 mm	27,2 mm
ZF.2.1.E.R/L23.EC	102 mm	27,3 mm
ZF.2.1.F.R/L23.EC	102 mm	27,3 mm
ZF.2.1.G.R/L27.EC	106 mm	26,7 mm
ZF.2.1.H.R/L27.EC	106 mm	27,7 mm
ZF.2.1.K.R/L27.EC	106 mm	28,7 mm
ZF.2.1.L.R/L31.EC	110 mm	30,2 mm
ZF.2.2.B.R/L80.EC	129 mm	27,2 mm
ZF.2.2.E.R/L80.EC	129 mm	27,3 mm
ZF.2.2.F.R/L80.EC	129 mm	27,3 mm

VDI-C1/C4

HSK-A

PSC



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Modular grooving system

Tool overall length

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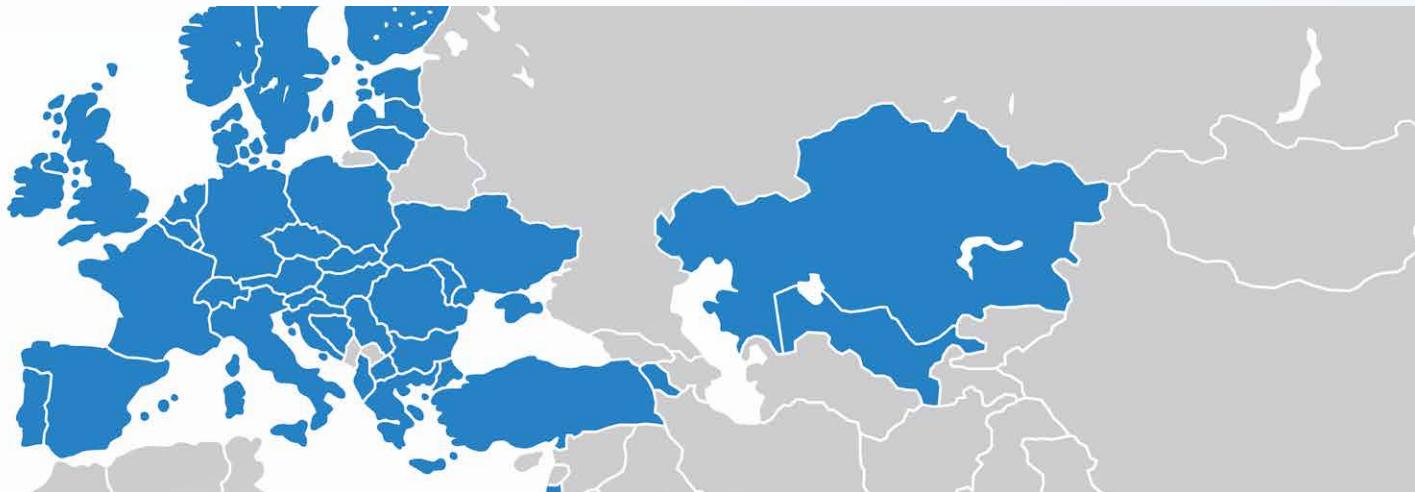
Notes

The ZFLEX logo is prominently displayed in the center of the page. The word "ZFLEX" is written in a bold, sans-serif font, with each letter having a thick stroke. To the right of the "X" in "ZFLEX" is a registered trademark symbol (®). Behind the text, there is a large, faint graphic element consisting of concentric arcs that suggest motion or a wave pattern.





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