Efficient parting & grooving

Discover the accurate solution from ZCC Cutting Tools Europe

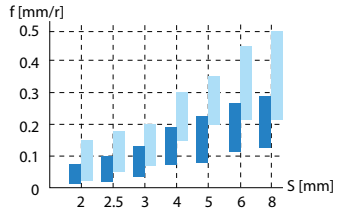
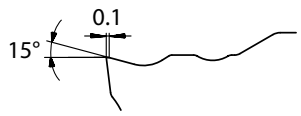
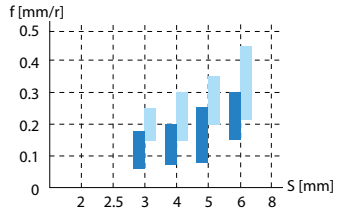
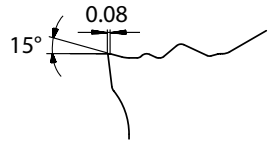
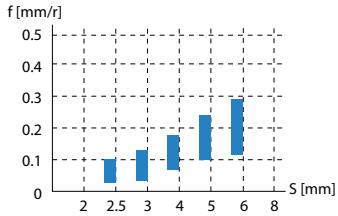
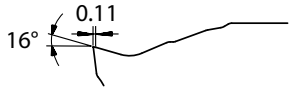
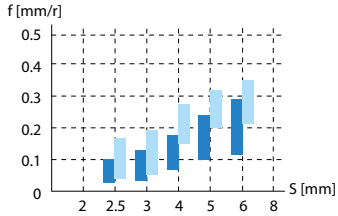
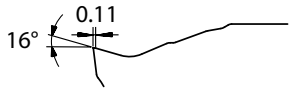
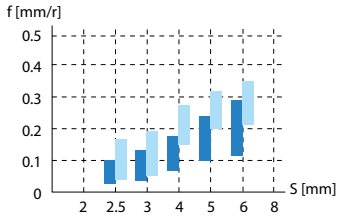
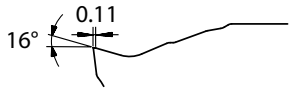
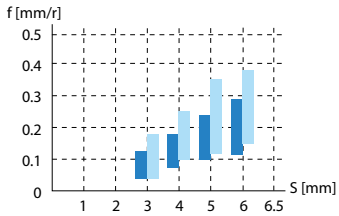
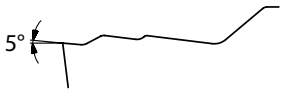
– EN –

ZCC Cutting Tools Europe GmbH

your Partner \ your Value

Modular grooving system zFlex

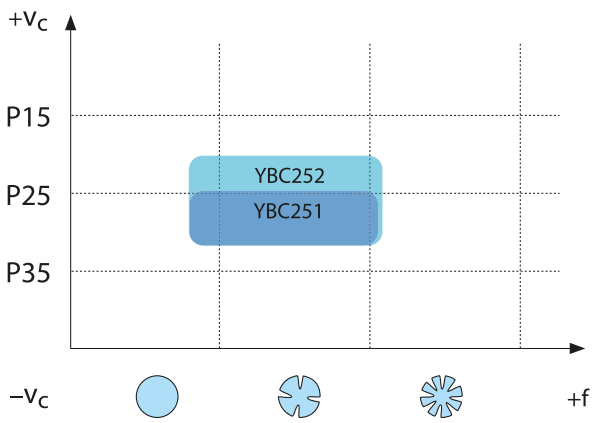
Maintain flexibility in your production operations

Chip breaker	Application	P	M	K	N	S	H	Feed	Cutting edge design
ZT****-MM	Parting & grooving ✔	✔	✔	✔		✔			
	Turning ✔								S = 4 mm
ZT****-MU	Parting & grooving ✔	✔	✔	✔		✔			
	Turning ✔								S = 4 mm
ZP****-MG	Parting & grooving ✔	✔	✔	✔		✔			
	Turning –								S = 4 mm
ZT****-MG	Parting & grooving ✔	✔	✔	✔		✔			
	Turning ✔								S = 4 mm
ZR****-MG	Parting & grooving ✔	✔	✔	✔		✔			Round profile 
	Turning ✔								S = 4 mm
ZR****-EG	Parting & grooving ✔	✔	✔		✔	✔			Round profile 
	Turning ✔								S = 4 mm

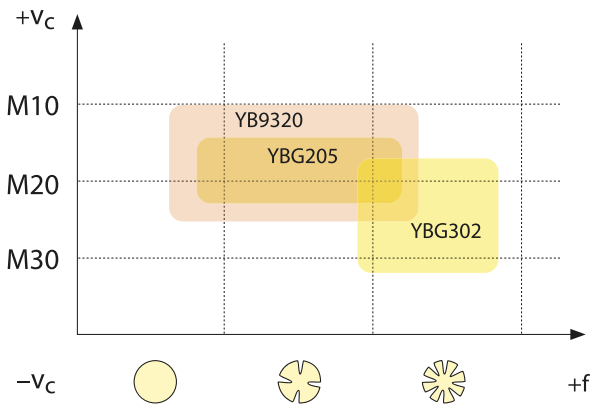
✔ Very suitable ✔ Suitable

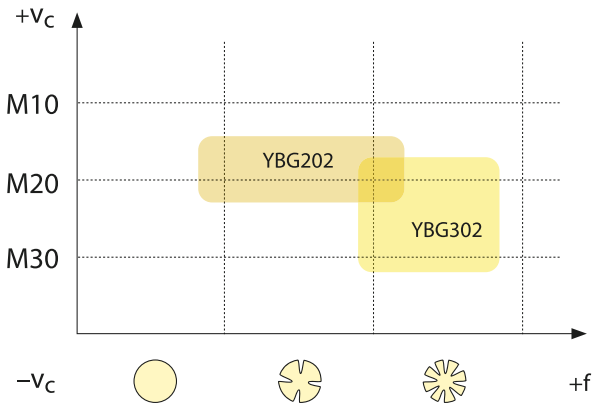
Parting & grooving
Turning

CVD coated carbide grades for steel

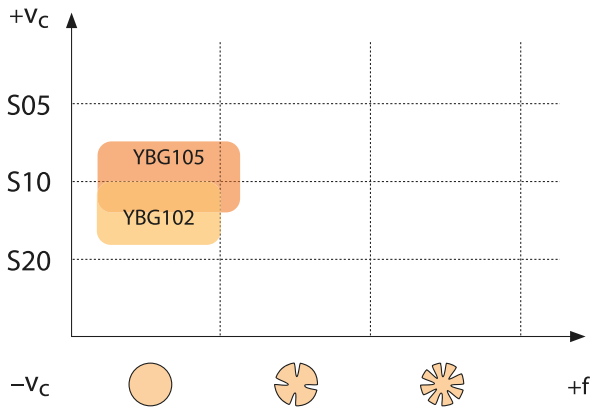


PVD coated carbide grades for stainless steel

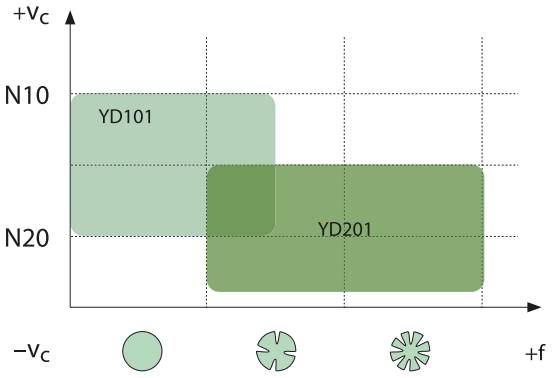




PVD coated carbide grades for superalloys



Carbide grades for non-ferrous metals



ZP G D 04 04 – M U

1	2	3	4	5		6	7

Application	
Code	Description
ZP	Parting
ZT	Grooving & turning
ZR	Form turning

1

Insert seat size [mm]	
Groove width	
Code	Description
B	2,0
E	2,5
F	3,0
G	4,0
H	5,0
K	6,0
L	8,0

2

No. of cutting edges	
Code	Description
S	Single
D	Double

3

Insert thickness S [mm]	
Code	S
02	2,0
025	2,5
03	3,0
04	4,0
05	5,0
06	6,0
08	8,0

4

Nose radius r [mm]	
Code	r
02	0,2
03	0,3
04	0,4
08	0,8

5

Tolerance class [mm]	
Code	Description
M	±0,13
E	±0,025

6

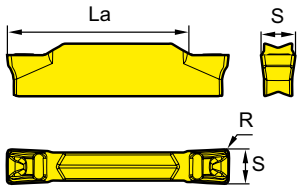
Chip breaker	
Code	Description
G	General chip breaker
F	Special chip breaker
M	Straight edge
U	Universal chip breaker

7

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

Parting inserts

Parting & grooving insert (double sided)



Double cutting edge

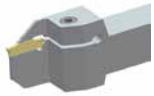
	HC¹ (CVD)						HC¹ (PVD)						HW	
P	⊛	⊛						⊛	⊛	⊛	⊛			
M								⊛	⊛	⊛	⊛			
K														
N													●	⊛
S							●	●	⊛	⊛	⊛			
H														

	ISO	R±0.1	La *max*	S	f	YBC252	YBC251	YBG105	YBG102	YB9320	YBG205	YBG202	YBG302	YD101	YD201
	ZTBD02002-MM	0.2	13	2	0,02-0,07					●	●		○		
	ZTED02503-MM	0.3	17	2.5	0,03-0,1					●					
	ZTFD0303-MM	0.3	17	3	0,04-0,13					●					
	ZTGD0404-MM	0.4	22	4	0,06-0,18					●					
	ZTHD0504-MM	0.4	22	5	0,08-0,23					●					
	ZTKD0608-MM	0.8	22	6	0,12-0,27					●					
	ZTLD0808-MM	0.8	28	8	0,13-0,29	○				●	○				

● Ex stock ○ On demand

HC¹ Coated carbide
HW Uncoated carbide

Tool holders

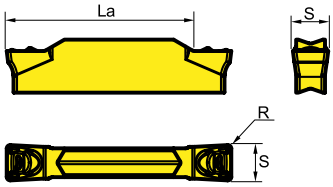
QE*D*R/L	QE*D*R/L-DGC	QE*D*R/L-DGSC	QE*D*R/L-SC
			
A17	A19	A21	A22

zFLEX®
Do you already know our innovative modular grooving system **zFlex**?

Parting inserts

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

Parting & grooving insert (double sided)



Double cutting edge

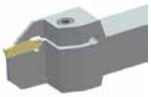
	HC[1] (CVD)						HC[1] (PVD)						HW		
P	⊛	⊛						⊛	⊛	⊛	⊛				
M								⊛	⊛	⊛	⊛				
K															
N													●	⊛	
S							●	●	⊛	⊛	⊛				
H															

	ISO	R±0.1	La *max*	S±0.10	f	YBC252	YBC251	YBG105	YBG102	YB9320	YBG205	YBG202	YBG302	YD101	YD201
	ZTFD0302-MU	0,2	17	3	0,06-0,18					●					
	ZTFD0303-MU	0,3	17	3	0,06-0,18					●					
	ZTGD0402-MU	0,2	22	4	0,08-0,20					●					
	ZTGD0404-MU	0,4	22	4	0,08-0,20					●					
	ZTHD0504-MU	0,4	22	5	0,09-0,25					●					
	ZTHD0508-MU	0,8	22	5	0,09-0,25					●					
	ZTKD0604-MU	0,4	22	6	0,15-0,30					○					
	ZTKD0608-MU	0,8	22	6	0,15-0,30					○					

● Ex stock ○ On demand

HC[1] Coated carbide
HW Uncoated carbide

Tool holders

QE*D*R/L	QE*D*R/L-DGC	QE*D*R/L-DGSC	QE*D*R/L-SC
			
A17	A19	A21	A22

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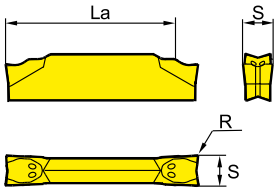
- Ideal machining conditions
- Normal machining conditions
- Unfavourable machining conditions

Parting inserts

Parting & grooving insert (double sided)



Double cutting edge

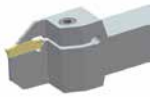
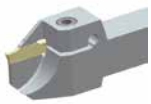
	HC[1] (CVD)				HC[1] (PVD)						HW	
P												
M												
K												
N												
S												
H												

	ISO	R±0.1	La *max*	S±0.10	f	YBC252	YBC251				YBG105	YBG102	YB9320	YBG205	YBG202	YBG302		YD101	YD201
	ZPED02502-MG	0.2	17	2.5	0,03-0,1		●						●		○	●			
	ZPFD0302-MG	0.2	17	3	0,04-0,13	●	●						●		○	●			
	ZPGD0402-MG	0.2	22	4	0,07-0,18		●						●			●			○
	ZPHD0503-MG	0.3	22	5	0,1-0,24										○	●			
	ZPKD0604-MG	0.4	22	6	0,12-0,29	○									○	●			

● Ex stock ○ On demand

HC[1] Coated carbide
HW Uncoated carbide

Tool holders

QE*D*R/L	QE*D*R/L-DGC	QE*D*R/L-DGSC	QE*D*R/L-SC
			
A17	A19	A21	A22

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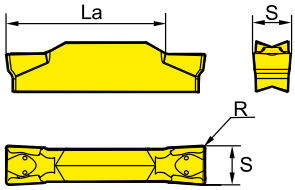
Parting inserts

- ● Ideal machining conditions
- ❁ Normal machining conditions
- ❁ Unfavourable machining conditions

Parting & grooving insert (double sided)



Double cutting edge

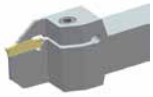
	HC¹ (CVD)						HC¹ (PVD)						HW	
P	❁	❁							❁	❁	❁	❁		
M									❁	❁	❁	❁		
K														
N													●	❁
S							●	●	❁	❁	❁			
H														

	ISO	R±0.1	La *max*	S±0.10	f	YBC252	YBC251					YBG105	YBG102	YB9320	YBG205	YBG202	YBG302		YD101	YD201
	ZTED02503-MG		17	2,5	0,03-0,11											○	●			
	ZTFD0303-MG		17	3	0,04-0,14								○		●	●	●			
	ZTGD0402-MG		22	4	0,07-0,2															
	ZTGD0404-MG		22	4	0,07-0,2		●								●	○	●		●	
	ZTHD0504-MG		22	5	0,10-0,25										●	○	●			
	ZTKD0604-MG		22	6	0,13-0,30									○	●					
	ZTKD0608-MG		22	6	0,13-0,30								○	●		○	●			

● Ex stock ○ On demand

HC¹ Coated carbide
HW Uncoated carbide

Tool holders

QE*D*R/L	QE*D*R/L-DGC	QE*D*R/L-DGSC	QE*D*R/L-SC
			
A17	A19	A21	A22

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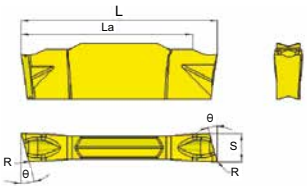
- Ideal machining conditions
- Normal machining conditions
- Unfavourable machining conditions

Parting inserts

Parting & grooving insert (double sided)



Right hand style

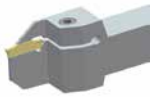
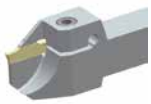
	HC[1] (CVD)				HC[1] (PVD)						HW	
P	✱	✱				✱	✱	✱	✱			
M						✱	✱	✱	✱			
K												
N											●	✱
S					●	●	✱	✱	✱			
H												

	ISO	La *max*	L	S	θ	R	f	YBC252	YBC251	YBG105	YBG102	YB9320	YBG205	YBG202	YBG302	YD101	YD201
	ZPED02502-MG-6L	17	20	2.35	6°	0.2	0,03-0,08								●		
	ZPED02502-MG-6R	17	20	2.35	6°	0.2	0,03-0,08					●			●		
	ZPED02502-MG-15L	17	20	2.35	15°	0.2	0,03-0,05								○		
	ZPED02502-MG-15R	17	20	2.35	15°	0.2	0,03-0,05							○	○		
	ZPFD0302-MG-6L	17	20	2.85	6°	0.2	0,04-0,1					●		○	●		
	ZPFD0302-MG-6R	17	20	2.85	6°	0.2	0,04-0,1					●		○	○		
	ZPFD0302-MG-15L	17	20	2.85	15°	0.2	0,04-0,08							○	○		
	ZPFD0302-MG-15R	17	20	2.85	15°	0.3	0,04-0,08					●			○		

● Ex stock ○ On demand

HC[1] Coated carbide
HW Uncoated carbide

Tools holders

QE*D*R/L	QE*D*R/L-DGC	QE*D*R/L-DGSC	QE*D*R/L-SC
			
A17	A19	A21	A22

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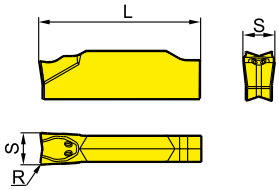
Parting inserts

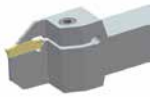
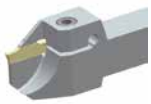
- ● Ideal machining conditions
- ⊛ Normal machining conditions
- ⊛ Unfavourable machining conditions

Parting & grooving insert (single sided)		HC[1] (CVD)					HC[1] (PVD)							HW		
 Single cutting edge	P	⊛	⊛						⊛	⊛	⊛	⊛				
	M								⊛	⊛	⊛	⊛				
	K															
	N													●	⊛	
	S						●	●	⊛	⊛	⊛					
	H															
ISO	R±0.1	S±0.10	f	YBC252	YBC251		YBG105	YBG102	YB9320	YBG205	YBG202	YBG302		YD101	YD201	
ZPES02502-MG	0.2	2.5	0,03-0,1						○		○	●				
ZPFS0302-MG	0.2	3	0,04-0,13		●				●			●				
ZPGS0402-MG-25	0.2	4	0,07-0,18						●							
ZPHS0503-MG-25	0.3	5	0,1-0,24						●							
ZPKS0604-MG-25	0.4	6	0,12-0,29						●							

● Ex stock ○ On demand
Single sided inserts only for parting blades

HC[1] Coated carbide
HW Uncoated carbide

Tool holders

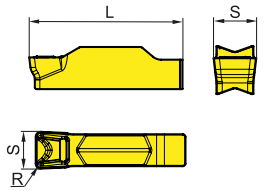
QE*D*R/L	QE*D*R/L-DGC	QE*D*R/L-DGSC	QE*D*R/L-SC
			
A17	A19	A21	A22

zFLEX®
Do you already know our innovative modular grooving system **zFlex**?

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

Parting inserts

Parting & grooving insert (single sided)



Single cutting edge

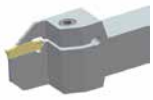
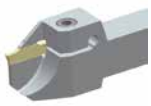
	HC[1] (CVD)				HC[1] (PVD)						HW	
P	⊛	⊛				⊛	⊛	⊛	⊛			
M						⊛	⊛	⊛	⊛			
K												
N											●	⊛
S					○	○	⊛	⊛	⊛			
H												

	ISO	R±0.1	L	S±0.10	f	YBC252	YBC251	YBG105	YBG102	YB9320	YBG205	YBG202	YBG302	YD101	YD201
	ZTES02503-MM	0.3	19.9	2.5	0,03-0,1					●					
	ZTFS0303-MM	0.3	19.9	3	0,04-0,13					●					
	ZTGS0404-MM-25	0.4	24.6	4	0,06-0,18					●					
	ZTHS0504-MM-25	0.4	24.6	5	0,08-0,23					●					
	ZTKS0608-MM-25	0.8	24.6	6	0,12-0,27					●					

● Ex stock ○ On demand

HC[1] Coated carbide
HW Uncoated carbide

Tool holders

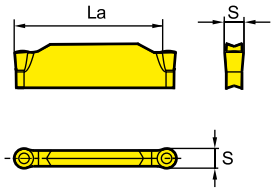
QE*D*R/L	QE*D*R/L-DGC	QE*D*R/L-DGSC	QE*D*R/L-SC
			
A17	A19	A21	A22

zFLEX®
Do you already know our innovative modular grooving system **zFlex**?

Parting inserts

- ● Ideal machining conditions
- ⊛ Normal machining conditions
- ⊛ Unfavourable machining conditions

Parting & grooving insert (double sided)



Double cutting edge

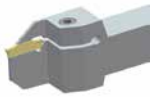
	HC¹ (CVD)						HC¹ (PVD)						HW	
P	⊛	⊛							⊛	⊛	⊛	⊛		
M									⊛	⊛	⊛	⊛		
K														
N													●	⊛
S							●	●	⊛	⊛	⊛			
H														

	ISO	La *max*	S±0.10	f	YBC252	YBC251				YBG105	YBG102	YB9320	YBG205	YBG202	YBG302		YD101	YD201
	ZRED025-MG	17.5	2.5	0,03-0,11										○	●			
	ZRFD03-MG	17	3	0,04-0,14								●			●			
	ZRGD04-MG	21	4	0,07-0,2		○							●	○	●			
	ZRHD05-MG	20	5	0,1-0,24										○	●		○	
	ZRKD06-MG	19	6	0,12-0,29										○	●			

● Ex stock ○ On demand

HC¹ Coated carbide
HW Uncoated carbide

Tool holders

QE*D*R/L	QE*D*R/L-DGC	QE*D*R/L-DGSC	QE*D*R/L-SC
			
A17	A19	A21	A22

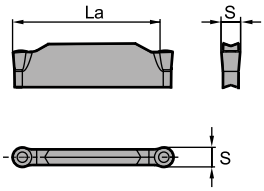
zFLEX®

Do you already know our innovative modular grooving system **zFlex**?

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

Parting inserts

Parting & grooving insert (double sided)



Double cutting edge

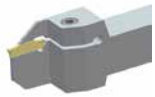
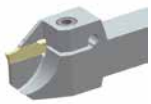
	HC[1] (CVD)				HC[1] (PVD)						HW	
P	⊛	⊛				⊛	⊛	⊛	⊛			
M						⊛	⊛	⊛	⊛			
K												
N											●	⊛
S					●	●	⊛	⊛	⊛			
H												

	ISO	La *max*	S±0.025	f	YBC252	YBC251	YBG105	YBG102	YB9320	YBG205	YBG202	YBG302	YD101	YD201
	ZRFD03-EG	17	3	0,04-0,14					●			○		
	ZRGD04-EG	21	4	0,07-0,2					●					
	ZRHD05-EG	20	5	0,1-0,24					●			○		
	ZRKD06-EG	19	6	0,12-0,29					○					

● Ex stock ○ On demand

HC[1] Coated carbide
HW Uncoated carbide

Tool holders

QE*D*R/L	QE*D*R/L-DGC	QE*D*R/L-DGSC	QE*D*R/L-SC
			
A17	A19	A21	A22

zFLEX®
Do you already know our innovative modular grooving system **zFlex**?

External tool holders

Q	F	G	D	2525	R	22	(S)	C	–	(130)	(H)
1	2	3	4	5	6	7	8	9		10	11

1 Holder for parting & grooving

2 Application

Code	Description
E	External machining
F	Axial machining

3 Insert seat size [mm]

Holder/cutting width

Code	Description
A	1,5
B	2,0
E	2,5
F	3,0
G	4,0
H	5,0
K	6,0
L	8,0

4 No. of cutting edges

Code	Description
S	Single
D	Double

5 Cross section of holder [mm] x [mm]

6 Type

Code	Description
R	Right
L	Left
N	Right and left

7 Max. cutting depth [mm]

8 Serie

Code	Description
S	Swiss turning holder
DG	Cut-off holder for greater grooving depths with reinforcement
DGS	Cut-off holder for greater grooving depths without reinforcement

9 With internal cooling

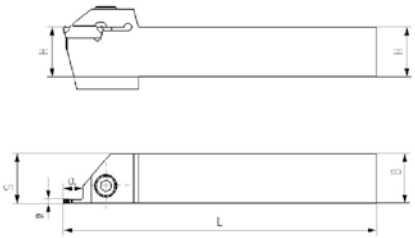
10 Min. diameter of work piece for first axial grooving [mm]

11 Cutting head

Code	Description
H	0°
L	90°

Parting & grooving tool holder (external)

QE**R/L



Article	✻	Stock		Dimensions [mm]					Inserts
		R	L	HxB	L	S	W	ar_{max}	
QEBD1616R/L04		○	○	16x16	150	16.17	2	4	Z*BD**
QEBD2020R/L07		○	○	20x20	150	20.17	2	7	Z*BD**
QEED1616R/L10		●	●	16x16	125	15	2.5	10	Z*ED**
QEED1616R/L17		●	●	16x16	125	15	2.5	17	Z*ED**
QEED2020R/L17		●	●	20x20	125	19	2.5	17	Z*ED**
QEED2020R/L10		●	●	20x20	150	10	2.5	10	Z*ED**
QEED2525R/L10		●	●	25x25	150	19	2.5	10	Z*ED**
QEED2525R/L17		●	●	25x25	150	19	2.5	17	Z*ED**
QEFD1616R/L10		●	●	16x16	125	14.8	3	10	Z*FD**
QEFD1616R/L17		●	●	16x16	125	14.8	3	17	Z*FD**
QEFD2020R/L10		●	●	20x20	125	18.8	3	10	Z*FD**
QEFD2020R/L17		●	●	20x20	125	18.8	3	17	Z*FD**
QEFD2525R/L10		●	●	25x25	150	23.8	3	10	Z*FD**
QEFD2525R/L17		●	●	25x25	150	23.8	3	17	Z*FD**
QEGD2020R/L13		●	●	20x20	140	18.5	4	13	Z*GD**
QEGD2020R/L22		●	●	20x20	140	18.5	4	22	Z*GD**
QEGD2525R/L13		●	●	25x25	150	23.5	4	13	Z*GD**
QEGD2525R/L22		●	●	25x25	150	23.5	4	22	Z*GD**
QEGD3232R/L13		●	●	32x32	170	30.5	4	13	Z*GD**
QEGD3232R/L22		●	●	32x32	170	30.5	4	22	Z*GD**
QEHD2525R/L13		●	●	25x25	150	23	5	13	Z*HD**
QEHD2525R/L22		●	●	25x25	150	23	5	22	Z*HD**
QEHD3232R/L13		●	●	32x32	170	30	5	13	Z*HD**
QEHD3232R/L22		●	●	32x32	170	30	5	22	Z*HD**
QEKD2525R/L13		●	●	25x25	150	22.6	6	13	Z*KD**
QEKD2525R/L22		●	●	25x25	150	22.6	6	22	Z*KD**
QEKD3232R/L13		●	●	32x32	170	29.6	6	13	Z*KD**
QEKD3232R/L22		●	●	32x32	170	29.6	6	22	Z*KD**

● Ex stock ○ On demand

✻ With internal cooling

You can find our **axial grooving tools** in our Main Catalogue from page A434 to A442. Simply scan the QR code.

Parting & grooving tool holder (external)

Spare parts

	Insert	Z*BD**	Z*ED**	Z*ED**	Z*FD**	Z*FD**	Z*GD**	Z*HD**	Z*KD**
	H	16-20	16	20-32	16	20-32	20-32	20-32	20-32
	Screw	GB70-85-M5×16 (4.0 Nm)	GB70-85-M5×20 (4.0 Nm)	GB70-85-M6×20 (7.0 Nm)	GB70-85-M5×20 (4.0 Nm)	GB70-85-M6×20 (7.0 Nm)	GB70-85-M6×20 (7.0 Nm)	GB70-85-M6×20 (7.0 Nm)	GB70-85-M6×20 (7.0 Nm)
	Wrench	WH40L	WH40L	WH50L	WH40L	WH50L	WH50L	WH50L	WH50L

Insert

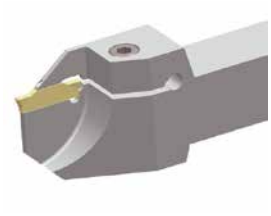
A7	A8	A9	A10	A11	A12

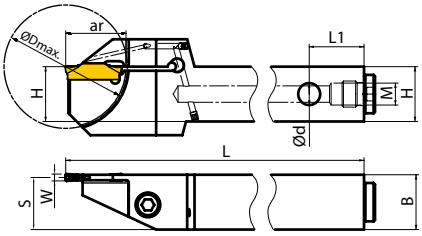
A13	A14	A15

You can find our **axial grooving tools** in our Main Catalogue from page A434 to A442. Simply scan the QR code.

Parting & grooving tool holder (external)

QE**R/L-DGC





Article	✻	Stock R	Stock L	Dimensions [mm] HxB	ød	L	S	L_1	W	ar_{max}	ØDmax	M	Inserts
QEBD1616R/L20-DGC	✻	○	○	16x16	G1/8	96	15	20	2	20	40	G1/8	Z*BD**
QEBD1616R/L30-DGC	✻	●	●	16x16	G1/8	105	15	20	2	30	60	G1/8	Z*BD**
QEBD2020R/L20-DGC	✻	○	○	20x20	G1/8	111	19	20	2	20	40	G1/8	Z*BD**
QEBD2020R/L30-DGC	✻	●	●	20x20	G1/8	120	19	20	2	30	60	G1/8	Z*BD**
QEBD2525R/L20-DGC	✻	○	○	25x25	G1/8	126	24	20	2	20	40	G1/8	Z*BD**
QEBD2525R/L30-DGC	✻	●	●	25x25	G1/8	135	24	20	2	30	60	G1/8	Z*BD**
QEED1616R/L20-DGC	✻	○	○	16x16	G1/8	96	14.75	20	2.5	20	40	G1/8	Z*ED**
QEED1616R/L30-DGC	✻	●	●	16x16	G1/8	105	14.75	20	2.5	30	60	G1/8	Z*ED**
QEED2020R/L20-DGC	✻	○	○	20x20	G1/8	111	18.75	20	2.5	20	40	G1/8	Z*ED**
QEED2020R/L30-DGC	✻	●	○	20x20	G1/8	120	18.75	20	2.5	30	60	G1/8	Z*ED**
QEED2525R/L20-DGC	✻	○	○	25x25	G1/8	126	23.75	20	2.5	20	40	G1/8	Z*ED**
QEED2525R/L30-DGC	✻	○	○	25x25	G1/8	135	23.75	20	2.5	30	60	G1/8	Z*ED**
QEFD1616R/L20-DGC	✻	○	○	16x16	G1/8	96	14.5	20	3	20	40	G1/8	Z*FD**
QEFD1616R/L30-DGC	✻	●	●	16x16	G1/8	105	14.5	20	3	30	60	G1/8	Z*FD**
QEFD2020R/L20-DGC	✻	○	○	20x20	G1/8	111	18.5	20	3	20	40	G1/8	Z*FD**
QEFD2020R/L30-DGC	✻	●	●	20x20	G1/8	120	18.5	20	3	30	60	G1/8	Z*FD**
QEFD2525R/L20-DGC	✻	○	○	25x25	G1/8	126	23.5	20	3	20	40	G1/8	Z*FD**
QEFD2525R/L30-DGC	✻	○	○	25x25	G1/8	135	23.5	20	3	30	60	G1/8	Z*FD**
QEGD1616R/L20-DGC	✻	○	○	16x16	G1/8	96	14	20	4	20	40	G1/8	Z*GD**
QEGD1616R/L30-DGC	✻	●	●	16x16	G1/8	105	14	20	4	30	60	G1/8	Z*GD**
QEGD2020R/L20-DGC	✻	○	○	20x20	G1/8	111	18	20	4	20	40	G1/8	Z*GD**
QEGD2020R/L30-DGC	✻	○	○	20x20	G1/8	120	18	20	4	30	60	G1/8	Z*GD**
QEGD2525R/L20-DGC	✻	○	○	25x25	G1/8	126	23	20	4	20	40	G1/8	Z*GD**
QEGD2525R/L30-DGC	✻	○	○	25x25	G1/8	135	23	20	4	30	60	G1/8	Z*GD**

● Ex stock ○ On demand

✻ With internal cooling

Spare parts

	Insert	Z*BD**	Z*ED**	Z*FD**	Z*GD**
	H	16-25	16-25	16-25	20-25
	Grub screw	PT1/8x4	PT1/8x4	PT1/8x4	PT1/8x4
	Screw	GB70-85-M5×20 (4.0 Nm)	GB70-85-M5×20 (4.0 Nm)	GB70-85-M5×20 (4.0 Nm)	GB70-85-M5×20 (4.0 Nm)
	Wrench	WH40L	WH40L	WH40L	WH40L
	Wrench	WH50L	WH50L	WH50L	WH50L

Parting & grooving tool holder (external)

Insert

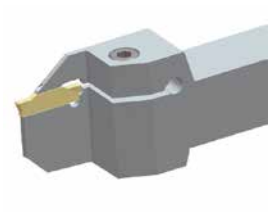
A7	A8	A9	A10	A11	A12

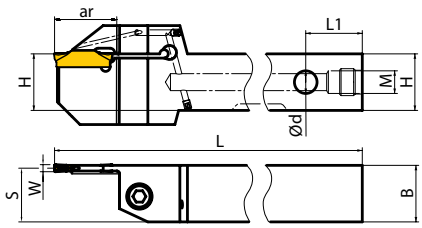
A13	A14	A15

You can find our **axial grooving tools** in our Main Catalogue from page A434 to A442. Simply scan the QR code.

Parting & grooving tool holder (external)

QE**R/L-DGSC





Article	✻	Stock		Dimensions [mm]								Inserts
		R	L	HxB	ød	L	S	L_1	W	ar_{max}	M	
QEED1616R/L30-DGSC	✻	●	●	16x16	G1/8	105	14.75	20	2.5	30	G1/8	Z*ED**
QEED2020R/L30-DGSC	✻	●	○	20x20	G1/8	120	18.75	20	2.5	30	G1/8	Z*ED**
QEED2525R/L30-DGSC	✻	○	○	25x25	G1/8	135	23.75	20	2.5	30	G1/8	Z*ED**
QEFD1616R/L30-DGSC	✻	●	●	16x16	G1/8	105	14.5	20	3	30	G1/8	Z*FD**
QEFD2020R/L30-DGSC	✻	○	○	20x20	G1/8	120	18.5	20	3	30	G1/8	Z*FD**
QEFD2525R/L30-DGSC	✻	○	○	25x25	G1/8	135	23.5	20	3	30	G1/8	Z*FD**
QEGD1616R/L30-DGSC	✻	○	○	16x16	G1/8	105	14	20	4	30	G1/8	Z*GD**
QEGD2020R/L30-DGSC	✻	○	○	20x20	G1/8	120	18	20	4	30	G1/8	Z*GD**
QEGD2525R/L30-DGSC	✻	○	○	25x25	G1/8	135	23	20	4	30	G1/8	Z*GD**
QEHD2525R/L30-DGSC	✻	○	○	25x25	G1/8	135	22.5	20	5	30	G1/8	Z*HD**
QEKD2525R/L30-DGSC	✻	○	○	25x25	G1/8	135	22	20	6	30	G1/8	Z*KD**

● Ex stock ○ On demand

✻ With internal cooling

Spare parts

	Insert	**Z*ED****	**Z*FD****	**Z*GD****	**Z*HD****	**Z*KD****
	H	**16-25**	**16-25**	**20-25**	**20-25**	**20-25**
	Grub screw	PT1/8x4	PT1/8x4	PT1/8x4	PT1/8x4	PT1/8x4
	Screw	GB70-85-M5×20 (4.0 Nm)	GB70-85-M5×20 (4.0 Nm)	GB70-85-M5×20 (4.0 Nm)	GB70-85-M6×20 (7.0 Nm)	GB70-85-M6×20 (7.0 Nm)
	Wrench	WH40L	WH40L	WH40L	WH50L	WH50L
	Wrench	WH50L	WH50L	WH50L	WH50L	WH50L

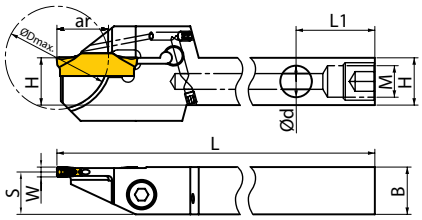
Insert

A7	A8	A9	A10	A11	A12

A13	A14	A15

Parting & grooving tool holder (external)

QE**R/L-SC



Article	✻	Stock R	Stock L	Dimensions [mm] HxB	ød	L	S	L_1	W	ar_{max}	ØDmax	M	Inserts
QEAD1010R/L10-SC	✻	○	○	10x10	G1/16	125	9	20	1.5	10	20	G1/16	Z*AD**
QEAD1212R/L13-SC	✻	○	○	12x12	G1/8	125	12	20	1.5	13	26	G1/8	Z*AD**
QEAD1616R/L13-SC	✻	○	○	16x16	G1/8	125	15	20	1.5	13	26	G1/8	Z*AD**
QEAD2020R/L13-SC	✻	○	○	20x20	G1/8	125	19	20	1.5	13	26	G1/8	Z*AD**
QEBD1010R/L10-SC	✻	○	○	10x10	G1/16	110	9	20	2	10	20	G1/16	Z*BD**
QEBD1212R/L13-SC	✻	●	●	12x12	G1/8	110	11	20	2	13	26	G1/8	Z*BD**
QEBD1616R/L13-SC	✻	●	●	16x16	G1/8	110	15	20	2	13	26	G1/8	Z*BD**
QEBD2020R/L13-SC	✻	○	○	20x20	G1/8	110	19	20	2	13	26	G1/8	Z*BD**
QEED1010R/L10-SC	✻	○	○	10x10	G1/16	110	8.75	20	2.5	10	20	G1/16	Z*ED**
QEED1212R/L13-SC	✻	●	●	12x12	G1/8	110	10.75	20	2.5	13	26	G1/8	Z*ED**
QEED1616R/L17-SC	✻	●	●	16x16	G1/8	110	14.75	20	2.5	17	34	G1/8	Z*ED**
QEED2020R/L17-SC	✻	●	●	20x20	G1/8	110	18.75	20	2.5	17	34	G1/8	Z*ED**
QEFD1212R/L13-SC	✻	●	●	12x12	G1/8	110	10.5	20	3	13	26	G1/8	Z*FD**
QEFD1616R/L17-SC	✻	●	●	16x16	G1/8	110	14.5	20	3	17	34	G1/8	Z*FD**
QEFD2020R/L22-SC	✻	●	●	20x20	G1/8	110	18.5	20	3	22	44	G1/8	Z*FD**

● Ex stock ○ On demand

✻ With internal cooling

Spare parts

	Insert	Z*AD**	Z*AD**	Z*AD**	Z*AD**	Z*BD**	Z*BD**	Z*BD**	Z*ED**	Z*ED**	Z*ED**	Z*FD**	Z*FD**
	H	10	12	16	20	10	12	16-20	10	12	16-20	12	16-20
	Grub screw	PT1/16x6	PT1/8x4	PT1/8x4	PT1/8x4	PT1/16x6	PT1/8x4	PT1/8x4	PT1/16x6	PT1/8x4	PT1/8x4	PT1/8x4	PT1/8x4
	Screw	GB70-85-M4×12 (2.6 Nm)	GB70-85-M4×12 (2.6 Nm)	GB70-85-M4×14	GB70-85-M4×18	GB70-85-M4×12 (2.6 Nm)	GB70-85-M4×12 (2.6 Nm)	GB70-85-M6×20 (7.0 Nm)	GB70-85-M4×12 (2.6 Nm)	GB70-85-M4×12 (2.6 Nm)	GB70-85-M6×20 (7.0 Nm)	GB70-85-M4×12 (2.6 Nm)	GB70-85-M5×20 (4.0 Nm)
	Wrench	WH30L	WH30L	WH30L	WH30L	WH30L	WH30L	WH40L	WH30L	WH30L	WH40L	WH30L	WH40L
	Wrench	WH40L	WH50L	WH50L	WH50L	WH40L	WH50L	WH50L	WH40L	WH50L	WH50L	WH50L	WH50L

Parting & grooving tool holder (external)

Insert

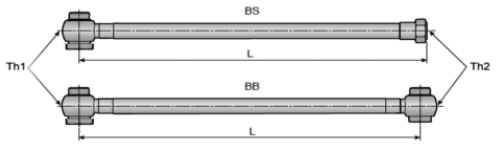
A7	A8	A9	A10	A11	A12

A13	A14	A15

You can find our **axial grooving tools** in our Main Catalogue from page A434 to A442. Simply scan the QR code.

Accessoires

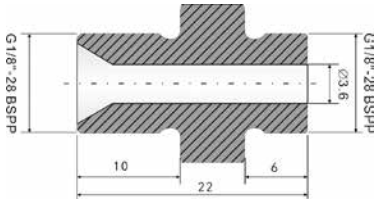
Coolant hose



Article	Dimensions [mm]			Stock
	L	Th1	Th2	
HOSE G1/8-7/16/200BS	200	G1/8"-28 BSPP	G1/8"-28 BSPP	○
HOSE G1/8-7/16/300BS	300	G1/8"-28 BSPP	G1/8"-28 BSPP	○
HOSE G1/8-7/16/200BB	200	G1/8"-28 BSPP	G1/8"-28 BSPP	○
HOSE G1/8-7/16/300BB	300	G1/8"-28 BSPP	G1/8"-28 BSPP	○

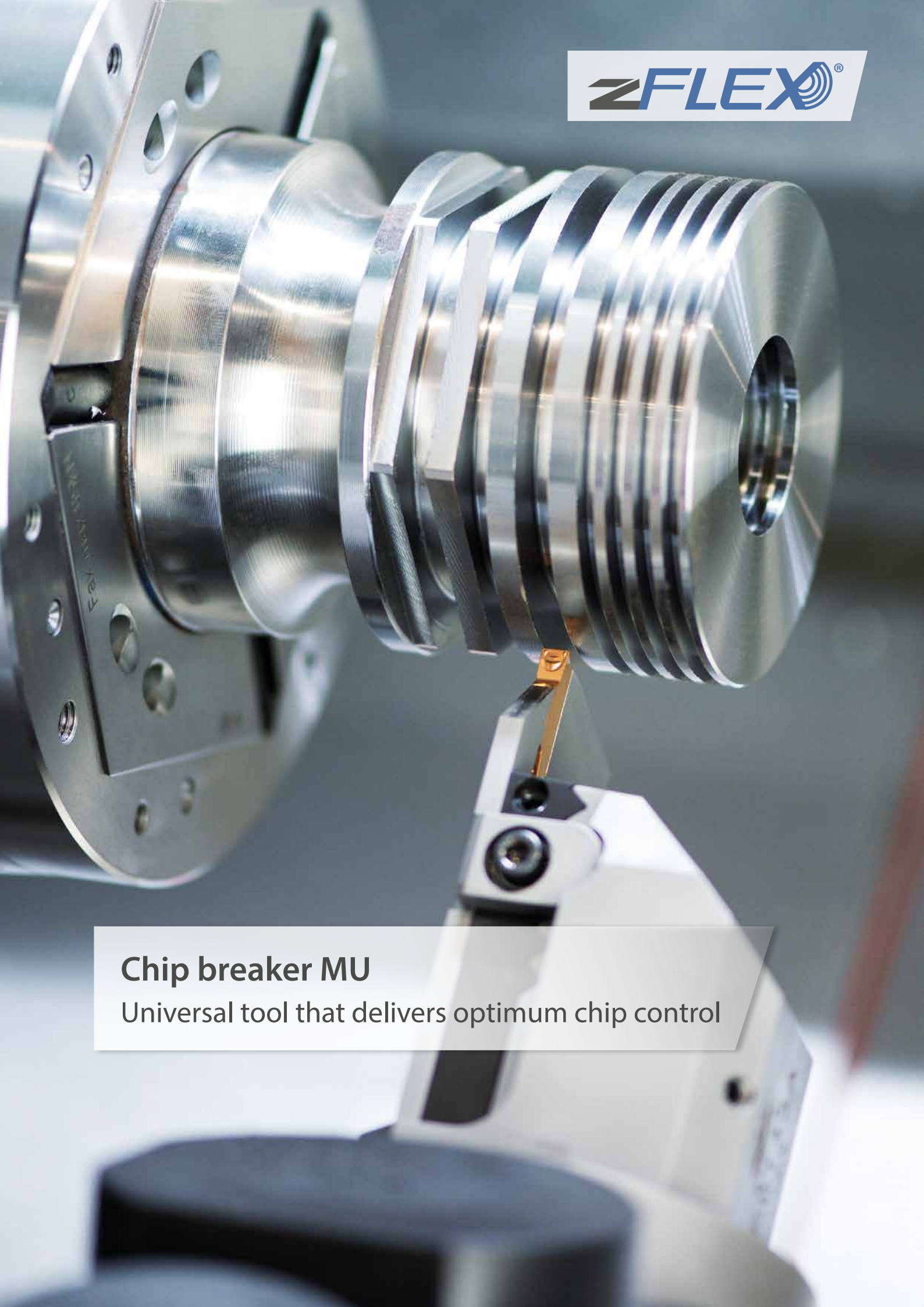
● Ex stock ○ On demand

Coolant connection



Article	Stock
NIPPLE G1/8- G1/8	○

● Ex stock ○ On demand



Chip breaker MU

Universal tool that delivers optimum chip control

Parting & grooving inserts

Material group		Composition / structure / heat treatment		Brinell hardness HB	Machining group	Starting values for cutting speed vc [m/min]		
						HC (CVD)	HC (PVD)	
						YBC252	YBG102	YBG105
P	Unalloyed steel	approx. 0,15 % C	annealed	125	1	190		
		approx. 0,45 % C	annealed	190	2	175		
		approx. 0,45 % C	tempered	250	3	145		
		approx. 0,75 % C	annealed	270	4	140		
		approx. 0,75 % C	tempered	300	5	135		
	Low-alloyed steel		annealed	180	6	170		
			tempered	275	7	125		
			tempered	300	8	115		
			tempered	350	9	105		
	High-alloyed steel and high-alloyed tool steel		annealed	200	10	125		
			hardened and tempered	325	11	95		
M	Stainless steel	ferritic/martensitic	annealed	200	12	165	165	170
		martensitic	tempered	240	13	135	135	140
		austenitic	quench hardened	180	14	155	155	160
		austenitic-ferritic		230	15	135	135	140
K	Grey cast iron	perlitic/ferritic		180	16	240		
		perlitic (martensitic)		260	17	185		
	Cast iron with spheroidal graphite	ferritic		160	18	220		
		perlitic		250	19	165		
	Malleable cast iron	ferritic		130	20	175		
		perlitic		230	21	165		
N	Aluminium wrought alloys	cannot be hardened		60	22			
		hardenable	hardened	100	23			
	Cast aluminium alloys	≤ 12% Si, cannot be hardened		75	24			
		≤ 12% Si, hardenable	hardened	90	25			
		> 12% Si, cannot be hardened		130	26			
	Copper and copper alloys (bronze/brass)	machining steel, PB> 1%		110	27			
		CuZn, CuSnZn		90	28			
		CuSn, Pb-free copper, electrolytic copper		100	29			
S	Heat-resistant alloys	Fe-based alloys	annealed	200	30		95	100
			hardened	280	31		50	50
		Ni or Co bass	annealed	250	32		80	80
			hardened	350	33		70	70
			cast	320	34		70	70
	Titanium alloys	pure titanium		R_m 400	35		145	150
		α and β alloys	hardened	R_m 1050	36		50	50
H	Hardened steel		hardened and tempered	55 HRC	37			
			hardened and tempered	60 HRC	38			
	Hard cast iron		cast	400	39			
	Hardened cast iron		hardened and tempered	55 HRC	40			
X	Non-metallic materials	Thermoplasts			41			
		Thermosetting plastics			42			
		Plastic, glass-fibre reinforced GFRP			43			
		Plastic, carbon fibre reinforced CFRP			44			
		Graphite			45			
		Wood			46			

Note: The given cutting values are guide values, which were determined under ideal conditions.
The values have to be adapted in individual cases.
For examples of material for cutting tool groups view page D11.

	Starting values for cutting speed vc [m/min]						
	HC (PVD)				HW		
	YB9320	YBG202	YBG205	YBG302	YD101	YD201	
	190	190	190	185			
	175	175	175	170			
	145	145	145	140			
	140	140	140	135			
	135	135	135	130			
	170	170	170	165			
	125	125	125	125			
	115	115	115	115			
	105	105	105	105			
	125	125	125	125			
	95	95	95	95			
	165	165	165	160			
	135	135	135	130			
	155	155	155	150			
	135	135	135	130			
	240	240	240	235			
	185	185	185	180			
	220	220	220	215			
	165	165	165	160			
	175	175	175	170			
	165	165	165	160			
					800	760	
					600	570	
					320	305	
					240	230	
					160	155	
					160	155	
					600	570	
					200	190	
	95	95	95	95	70	65	
	50	50	50	50	35	35	
	80	80	80	75	60	60	
	70	70	70	65	50	50	
	70	70	70	65	50	50	
	145	145	145	140	105	100	
	50	50	50	50	35	35	

HC Coated carbide
HW Uncoated carbide, main component (WC)

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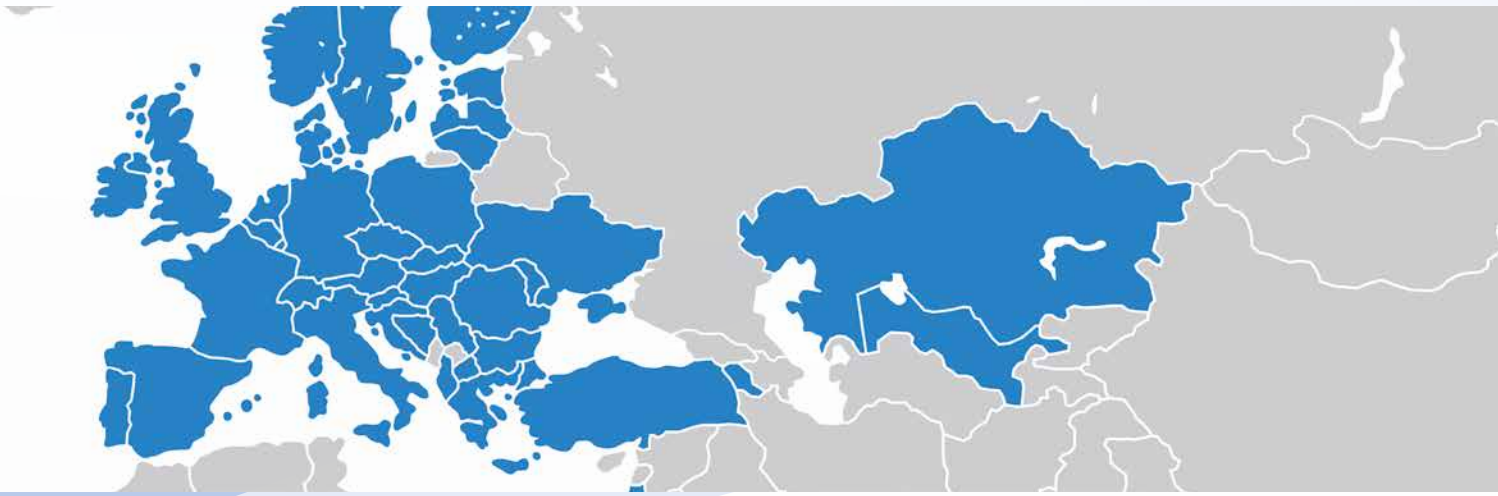
Efficient parting & grooving

Discover the accurate solution from ZCC Cutting Tools Europe



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