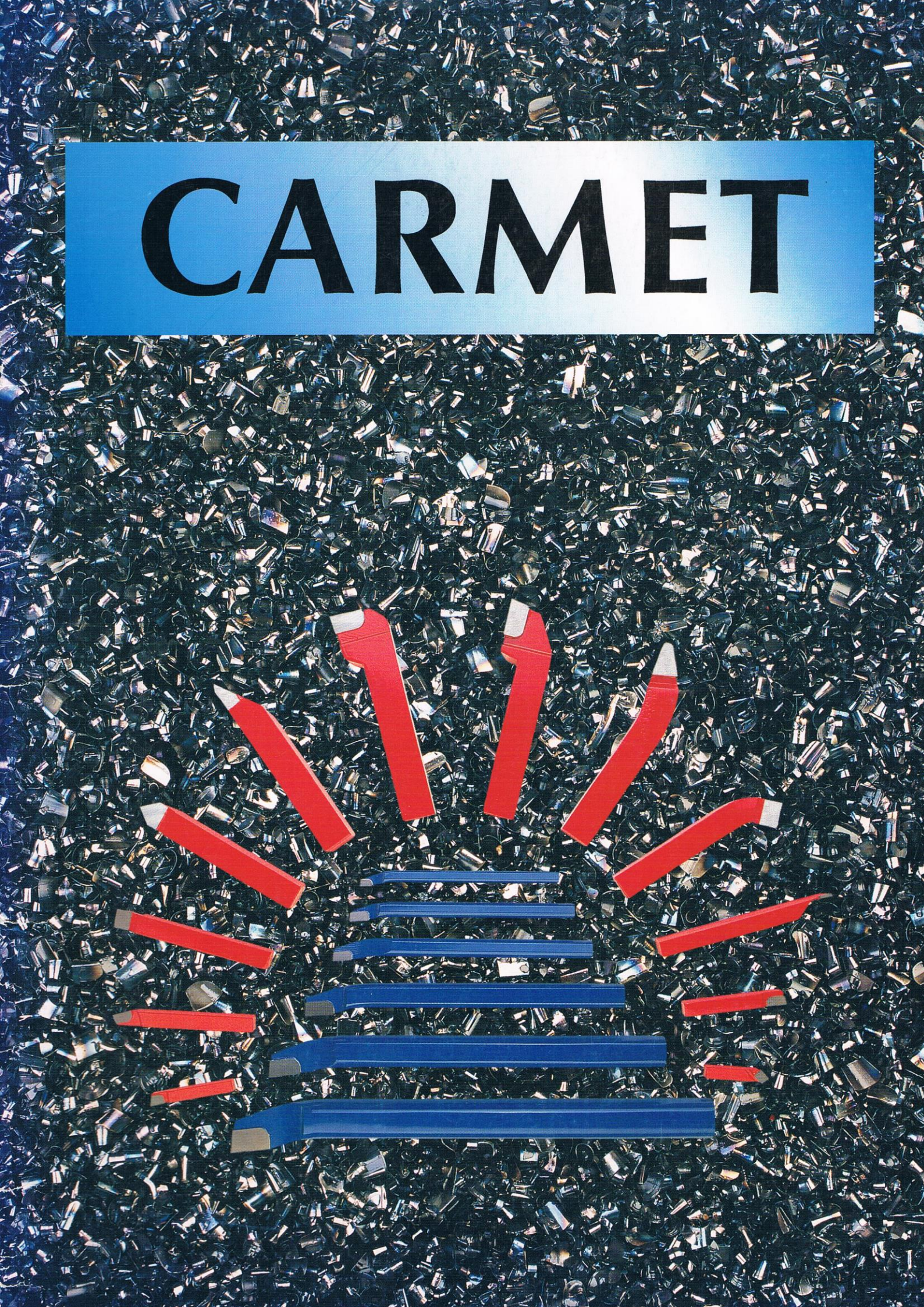
CARMET



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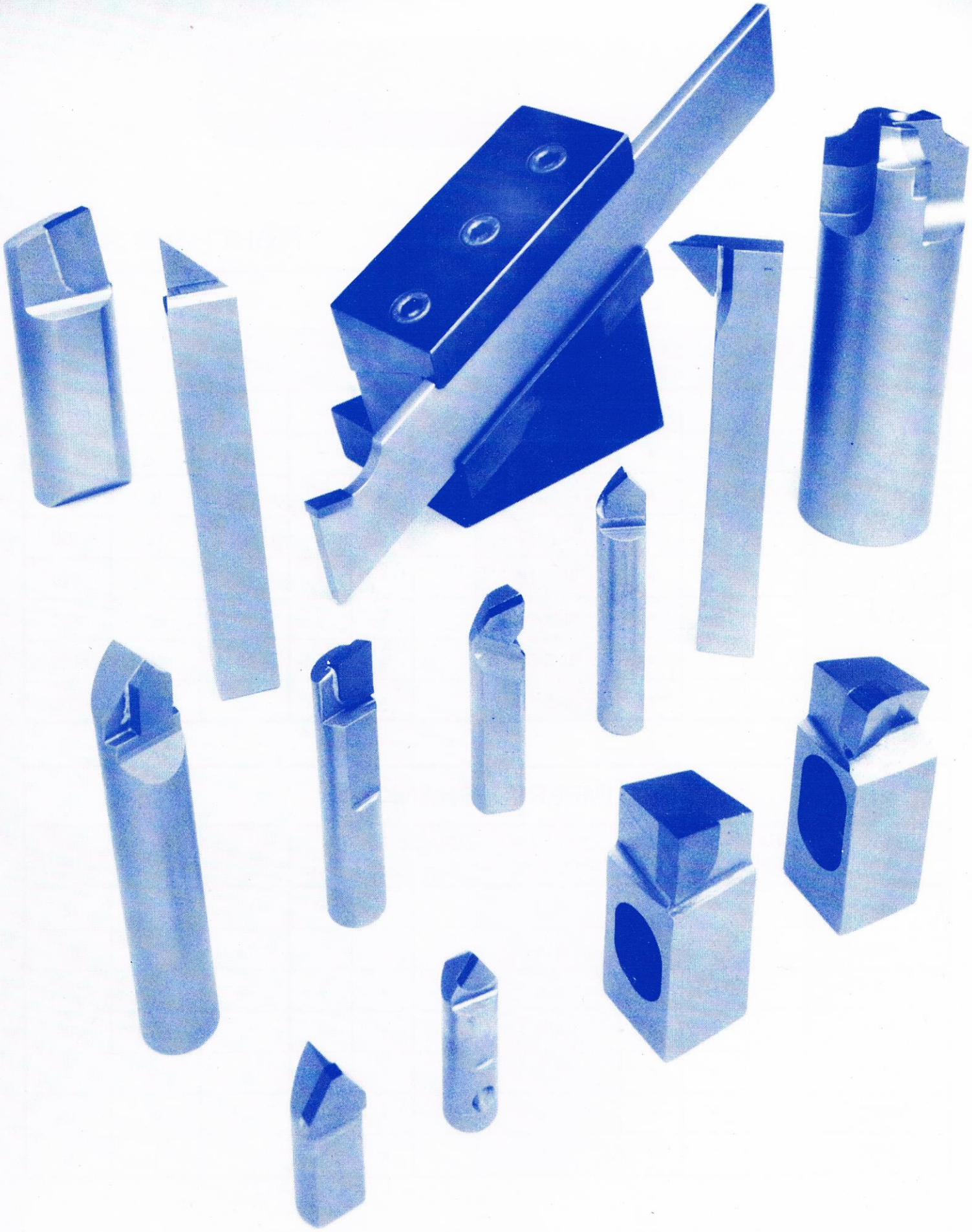


BRAZED TOOLS

STYLE A
90° STRAIGHT

RIGHT HAND SHOWN

METRIC SHANKS

RIGHT HAND TOOL No.	GRADES STOCKED K10	K20	P30	LEFT HAND TOOL No.	GRADES STOCKED K10	K20	P30	WIDTH	HEIGHT	LENGTH
AR0606		•	•	AL0606		•	•	6	6	50
AR0808		•	•	AL0808		•	•	8	8	55
AR1010	•	•	•	AL1010	•	•	•	10	10	90
AR1212		•	•	AL1212		•	•	12	12	100
AR1616		•	•	AL1616		•	•	16	16	110
AR2020		•	•	AL2020		•	•	20	20	125
AR2525		•	•	AL2525		•	•	25	25	160
AR3232		•	•	AL3232		•	•	32	32	200

IMPERIAL SHANKS

RIGHT HAND TOOL No.	GRADES STOCKED K10	K20	P30	LEFT HAND TOOL No.	GRADES STOCKED K10	K20	P30	WIDTH	HEIGHT	LENGTH
AR4		•	•	AL4		•	•	1/4	1/4	2
AR5				AL5				5/16	5/16	2 1/4
AR6		•	•	AL6	•	•	•	3/8	3/8	2 1/2
AR8		•	•	AL8		•	•	1/2	1/2	3 1/2
AR10		•	•	AL10		•	•	5/8	5/8	4
AR12		•	•	AL12		•	•	3/4	3/4	4 1/2
AR16		•	•	AL16		•	•	1	1	6

BRAZED TOOLS

STYLE B
75° APPROACH

RIGHT HAND SHOWN

METRIC SHANKS

RIGHT HAND TOOL No.	GRADES STOCKED K10	K20	P30	LEFT HAND TOOL No.	GRADES STOCKED K10	K20	P30	WIDTH	HEIGHT	LENGTH
BR1010		•	•	BL1010		•	•	10	10	90
BR1212		•	•	BL1212		•	•	12	12	100
BR1616		•	•	BL1616		•	•	16	16	110
BR2020		•	•	BL2020		•	•	20	20	125
BR2525		•	•	BL2525		•	•	25	25	160
BR3232		•	•	BL3232		•	•	32	32	200

IMPERIAL SHANKS

RIGHT HAND TOOL No.	GRADES STOCKED K10	K20	P30	LEFT HAND TOOL No.	GRADES STOCKED K10	K20	P30	WIDTH	HEIGHT	LENGTH
BR6				BL6				⅜	⅜	2½
BR8				BL8				½	½	3½
BR10				BL10				⅝	⅝	4
BR12				BL12				¾	¾	4½
BR16				BL16				1	1	6

BRAZED TOOLS

STYLE C
BROADNOSE RECESSING

METRIC SHANKS

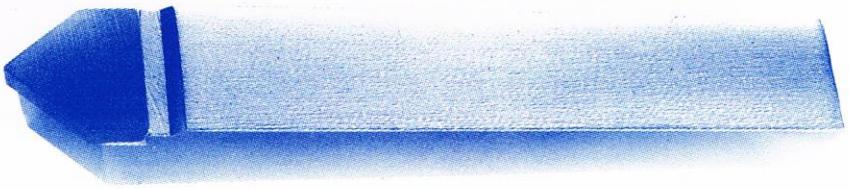
TOOL No. TOP RAKE	GRADES STOCKED K10	K20	P30	TOOL NO. NEUTRAL	GRADES STOCKED K10	K20	P30	WIDTH	HEIGHT	LENGTH
C0606		•	•	C0606N				6	6	50
C0808		•	•	C0808N				8	8	55
C1010	•	•	•	C1010N		•		10	10	90
C1212		•	•	C1212N		•		12	12	100
C1616		•	•	C1616N		•		16	16	110
C2020		•	•	C2020N		•		20	20	125
C2525		•	•	C2525N				25	25	160
C3232		•	•	C3232N				32	32	200

IMPERIAL SHANKS

TOOL No. TOP RAKE	GRADES STOCKED K10	K20	P30	TOOL No. NEUTRAL	GRADES STOCKED K10	K20	P30	WIDTH	HEIGHT	LENGTH
C4				C4N				¼	¼	2
C5				C5N				5/16	5/16	2¼
C6				C6N				⅜	⅜	2½
C8				C8N				½	½	3½
C10				C10N				⅝	⅝	4
C12				C12N				¾	¾	4½
C16				C16N				1	1	6

BRAZED TOOLS

STYLE D
80° POINTED NOSE



MACHINES BOTH DIRECTIONS

METRIC SHANKS

TOOL No.	GRADES STOCKED K10	K20	P30	WIDTH	HEIGHT	LENGTH
D0606	•	•	•	6	6	50
D0808		•	•	8	8	55
D1010		•	•	10	10	90
D1212		•	•	12	12	100
D1616		•	•	16	16	110
D2020		•	•	20	20	125
D2525		•	•	25	25	160

IMPERIAL SHANKS

TOOL No.	GRADES STOCKED K10	K20	P30	WIDTH	HEIGHT	LENGTH
D4				1/4	1/4	2
D5				5/16	5/16	2 1/4
D6				3/8	3/8	2 1/2
D8				1/2	1/2	3 1/2
D10				5/8	5/8	4
D12				3/4	3/4	4 1/2
D16				1	1	6

BRAZED TOOLS

STYLE E
THREADING
ERN-60°
ERW-55°

RIGHT HAND SHOWN

METRIC SHANKS

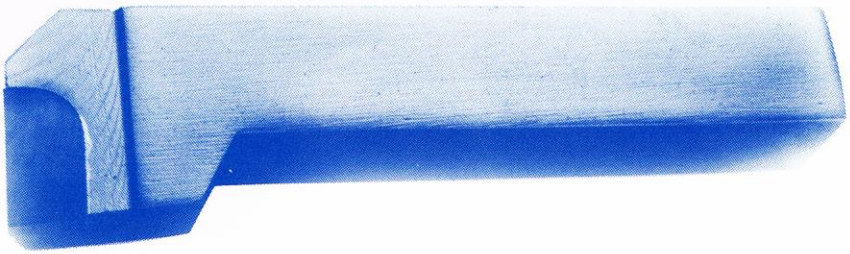
RIGHT HAND TOOL No.	GRADES STOCKED			LEFT HAND TOOL No.	GRADES STOCKED			WIDTH	HEIGHT	LENGTH
	K10	K20	P30		K10	K20	P30			
ERN1010		•	•	ELN1010		•	•	10	10	90
ERN1212		•	•	ELN1212		•	•	12	12	100
ERN1616		•	•	ELN1616				16	16	110
ERN2020		•	•	ELN2020				20	20	125
ERN2025		•	•	ELN2025				20	25	160
ERW1010		•	•	ELW1010		•	•	10	10	90
ERW1212		•	•	ELW1212		•	•	12	12	100
ERW1616		•	•	ELW1616				16	16	110
ERW2020		•	•	ELW2020				20	20	125
ERW2025		•	•	ELW2025				20	25	160

IMPERIAL SHANKS

RIGHT HAND TOOL No.	GRADES STOCKED			LEFT HAND TOOL No.	GRADES STOCKED			WIDTH	HEIGHT	LENGTH
	K10	K20	P30		K10	K20	P30			
ERN6				ELN6				⅜	⅜	2½
ERN8				ELN8				½	½	3½
ERN10				ELN10				⅝	⅝	4
ERN12				ELN12				¾	¾	4½
ERN64				ELN64				¾	1	6
ERW6				ELW6				⅜	⅜	2½
ERW8				ELW8				½	½	3½
ERW10				ELW10				⅝	⅝	4
ERW12				ELW12				¾	¾	4½
ERW64				ELW64				¾	1	6

BRAZED TOOLS

STYLE F
OFFSET FACING



RIGHT HAND SHOWN

METRIC SHANKS

RIGHT HAND TOOL No.	GRADES STOCKED			LEFT HAND TOOL No.	GRADES STOCKED			WIDTH	HEIGHT	LENGTH
	K10	K20	P30		K10	K20	P30			
FR1010		•	•	FL1010		•	•	10	10	90
FR1212		•	•	FL1212		•	•	12	12	100
FR1616		•	•	FL1616		•	•	16	16	110
FR2020		•	•	FL2020		•	•	20	20	125
FR2525		•	•	FL2525		•	•	25	25	160

IMPERIAL SHANKS

RIGHT HAND TOOL No.	GRADES STOCKED			LEFT HAND TOOL No.	GRADES STOCKED			WIDTH	HEIGHT	LENGTH
	K10	K20	P30		K10	K20	P30			
FR6				FL6				⅜	⅜	2½
FR8				FL8				½	½	3½
FR10				FL10				⅝	⅝	4
FR12				FL12				¾	¾	4½
FR16				FL16				1	1	6

BRAZED TOOLS

STYLE G
90° OFFSET

RIGHT HAND SHOWN

METRIC SHANKS

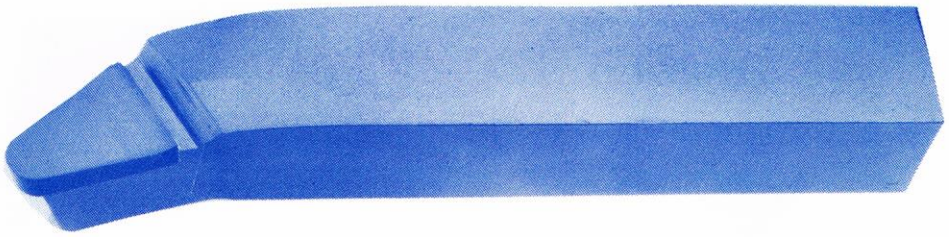
RIGHT HAND TOOL No.	GRADES STOCKED			LEFT HAND TOOL No.	GRADES STOCKED			WIDTH	HEIGHT	LENGTH
	K10	K20	P30		K10	K20	P30			
GR1010		•	•	GL1010		•	•	10	10	90
GR1212		•	•	GL1212		•	•	12	12	100
GR1616		•	•	GL1616		•	•	16	16	110
GR2020		•	•	GL2020		•	•	20	20	125
GR2525		•	•	GL2525		•	•	25	25	160
GR3232		•	•	GL3232		•	•	32	32	200

IMPERIAL SHANKS

RIGHT HAND TOOL No.	GRADES STOCKED			LEFT HAND TOOL No.	GRADES STOCKED			WIDTH	HEIGHT	LENGTH
	K10	K20	P30		K10	K20	P30			
GR6				GL6				⅜	⅜	2½
GR8				GL8				½	½	3½
GR10				GL10				⅝	⅝	4
GR12				GL12				¾	¾	4½
GR16				GL16				1	1	6

BRAZED TOOLS

STYLE H
30° CRANKED &
STRAIGHT ROUND NOSE



RIGHT HAND SHOWN

METRIC SHANKS

RIGHT HAND TOOL No.	GRADES STOCKED			CENTRE TOOL No.	GRADES STOCKED			LEFT HAND TOOL No.	GRADES STOCKED		
	K10	K20	P30		K10	K20	P30		K10	K20	P30
HR1010		•	•	HC1010		•	•	HL1010		•	•
HR1212		•	•	HC1212		•	•	HL1212		•	•
HR1616		•	•	HC1616		•	•	HL1616		•	•
HR2020		•	•	HC2020		•	•	HL2020		•	•
HR2525		•	•	HC2525		•	•	HL2525		•	•

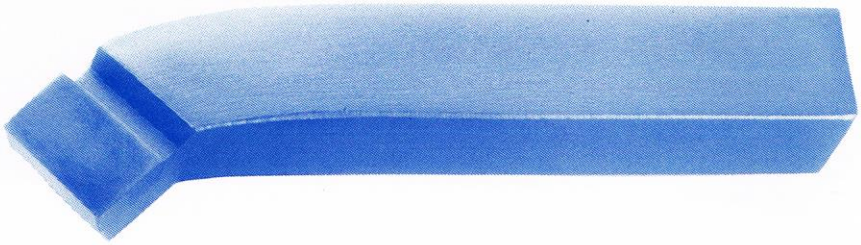
IMPERIAL SHANKS

RIGHT HAND TOOL No.	GRADES STOCKED			CENTRE TOOL No.	GRADES STOCKED			LEFT HAND TOOL No.	GRADES STOCKED		
	K10	K20	P30		K10	K20	P30		K10	K20	P30
HR6				HC6				HL6			
HR8				HC8				HL8			
HR10				HC10				HL10			
HR12				HC12				HL12			
HR16				HC16				HL16			

SHANK SIZES NOMINAL AS PER STYLE A.

BRAZED TOOLS

STYLE J
45° CRANKED



RIGHT HAND SHOWN

METRIC SHANKS

RIGHT HAND TOOL No.	GRADES STOCKED			LEFT HAND TOOL No.	GRADES STOCKED			WIDTH	HEIGHT	LENGTH
	K10	K20	P30		K10	K20	P30			
JR1010		•	•	JL1010		•	•	10	10	90
JR1212		•	•	JL1212		•	•	12	12	100
JR1616		•	•	JL1616		•	•	16	16	110
JR2020		•	•	JL2020		•	•	20	20	125
JR2525		•	•	JL2525		•	•	25	25	160

IMPERIAL SHANKS

RIGHT HAND TOOL No.	GRADES STOCKED			LEFT HAND TOOL No.	GRADES STOCKED			WIDTH	HEIGHT	LENGTH
	K10	K20	P30		K10	K20	P30			
JR6				JL6				⅜	⅜	2½
JR8				JL8				½	½	3½
JR10				JL10				⅝	⅝	4
JR12				JL12				¾	¾	4½
JR16				JL16				1	1	6

BRAZED TOOLS

STYLE KB GROOVING

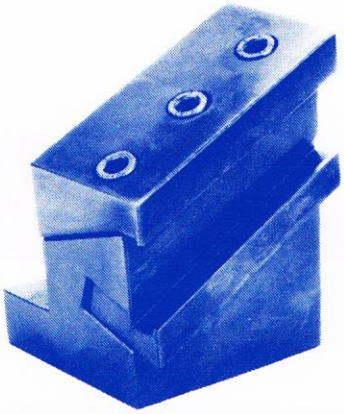
METRIC SHANKS							
TOOL No.	GRADES STOCKED			TIP WIDTH	WIDTH	HEIGHT	LENGTH
	K10	K20	P30				
KB1016-25		•	•	2.5mm	10	16	110
KB1016-30		•	•	3.0mm	10	16	110
KB1016-40		•	•	4.0mm	10	16	110
KB1220-30		•	•	3.0mm	12	20	125
KB1220-40		•	•	4.0mm	12	20	125
KB1625-40		•	•	4.0mm	16	25	140
KB1625-50		•	•	5.0mm	16	25	140
KB1625-60		•	•	6.0mm	16	25	140

STYLE K PARTING

METRIC SHANKS							
TOOL No.	GRADES STOCKED			TIP WIDTH	WIDTH	HEIGHT	LENGTH
	K10	K20	P30				
K1016-25		•	•	2.5mm	10	16	110
K1220-30		•	•	3.0mm	12	20	125
K1625-40		•	•	4.0mm	16	25	140
K1625-50		•	•	5.0mm	16	25	140

BRAZED TOOLS

STYLE KT HOLDERS



METRIC HOLDERS		
TOOL NUMBER	STOCKED	CENTRE HEIGHT
KT1212	•	SUITS 12mm CENTRE HEIGHT
KT1616	•	SUITS 16mm CENTRE HEIGHT
KT2020	•	SUITS 20mm CENTRE HEIGHT
KT2525	•	SUITS 25mm CENTRE HEIGHT

STYLE KT BLADES

PARTING BLADES TO SUIT ABOVE HOLDERS					
TOOL No.	GRADES STOCKED K10	K20	P30	TIP WIDTH	MAX. PARTING DIA.
KT30		•	•	3.0mm	115mm
KT40		•	•	4.0mm	115mm
KT50		•	•	5.0mm	115mm
KT60		•	•	6.0mm	120mm

STYLE KT CA BLADES

CAMSHAFT UNDERCUTTING BLADES TO SUIT ABOVE HOLDERS					
TOOL No.	GRADES STOCKED K10	K20	P30	TIP WIDTH	TIP RADIUS
KT CA		•		5.0mm	2.5mm

BRAZED TOOLS

STYLE L
BORING
HELD AT 90°
90° APPROACH

RIGHT HAND SHOWN

METRIC SHANKS

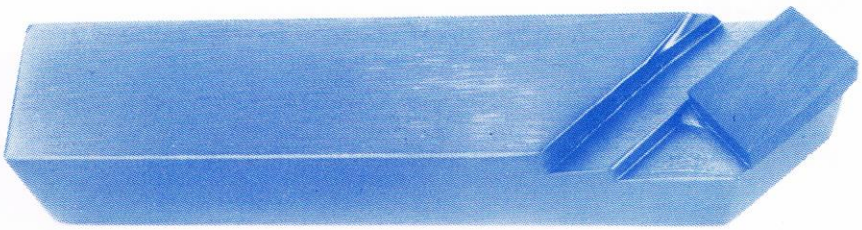
RIGHT HAND TOOL No.	GRADES STOCKED			LEFT HAND TOOL No.	GRADES STOCKED			WIDTH	HEIGHT	LENGTH
	K10	K20	P30		K10	K20	P30			
LR0606		•	•	LL0606		•	•	6	6	30
LR0808		•	•	LL0808		•	•	8	8	40
LR1010		•	•	LL1010		•	•	10	10	50
LR1212		•	•	LL1212		•	•	12	12	60
LR1616		•	•	LL1616		•	•	16	16	90
LR2020		•	•	LL2020		•	•	20	20	100

IMPERIAL SHANKS

RIGHT HAND TOOL No.	GRADES STOCKED			LEFT HAND TOOL No.	GRADES STOCKED			WIDTH	HEIGHT	LENGTH
	K10	K20	P30		K10	K20	P30			
LR4				LL4				1/4	1/4	1 1/4
LR5				LL5				5/16	5/16	1 1/2
LR6		•	•	LL6				3/8	3/8	1 3/4
LR8		•	•	LL8				1/2	1/2	2 1/2
LR10				LL10				5/8	5/8	3
LR12			•	LL12			•	3/4	3/4	3 1/2

BRAZED TOOLS

STYLE M
BORING
HELD AT 45°
90° APPROACH



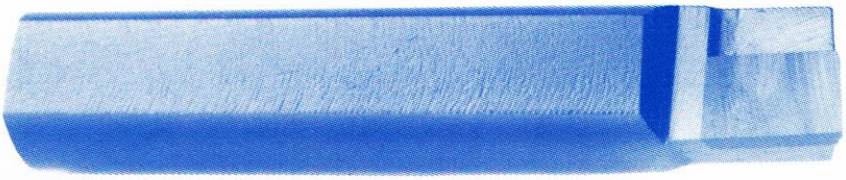
RIGHT HAND SHOWN

METRIC SHANKS										
RIGHT HAND TOOL No.	GRADES STOCKED			LEFT HAND TOOL No.	GRADES STOCKED			WIDTH	HEIGHT	LENGTH
	K10	K20	P30		K10	K20	P30			
MR0606		•	•	ML0606			•	6	6	30
MR0808		•	•	ML0808			•	8	8	40
MR1010	•	•	•	ML1010			•	10	10	50
MR1212		•	•	ML1212			•	12	12	60
MR1616		•	•	ML1616				16	16	90
MR2020		•	•	ML2020			•	20	20	100

IMPERIAL SHANKS										
RIGHT HAND TOOL No.	GRADES STOCKED			LEFT HAND TOOL No.	GRADES STOCKED			WIDTH	HEIGHT	LENGTH
	K10	K20	P30		K10	K20	P30			
MR4				ML4				1/4	1/4	1 1/4
MR5				ML5				5/16	5/16	1 1/2
MR6		•	•	ML6				3/8	3/8	1 3/4
MR8		•	•	ML8				1/2	1/2	2 1/2
MR10				ML10				5/8	5/8	3
MR12				ML12				3/4	3/4	3 1/2

BRAZED TOOLS

STYLE N
BORING
HELD AT 90°
90° APPROACH



RIGHT HAND SHOWN

METRIC SHANKS

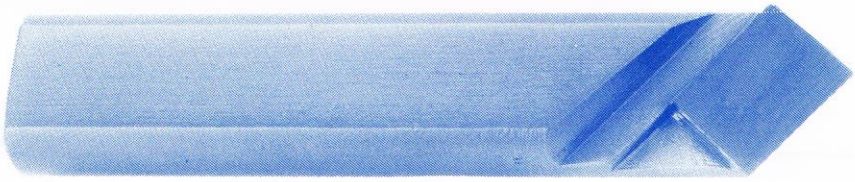
RIGHT HAND TOOL No.	GRADES STOCKED K10	K20	P30	LEFT HAND TOOL No.	GRADES STOCKED K10	K20	P30	DIAMETER	LENGTH
NR0006	•	•	•	NL0006				6	30
NR0008	•	•	•	NL0008		•	•	8	40
NR0010	•	•	•	NL0010	•	•	•	10	50
NR0012	•	•	•	NL0012		•	•	12	60
NR0016		•	•	NL0016			•	16	90
NR0020	•	•	•	NL0020				20	100
NR0006L				NL0006L				6	70
NR0008L		•	•	NL0008L		•	•	8	80
NR0010L		•	•	NL0010L		•	•	10	100
NR0012L		•	•	NL0012L		•	•	12	120

IMPERIAL SHANKS

RIGHT HAND TOOL No.	GRADES STOCKED K10	K20	P30	LEFT HAND TOOL No.	GRADES STOCKED K10	K20	P30	DIAMETER	LENGTH
NR4	•			NL4				¼	1¼
NR5			•	NL5			•	5/16	1½
NR6		•	•	NL6		•	•	⅜	1¾
NR8		•	•	NL8		•	•	½	2½
NR10	•	•	•	NL10			•	⅝	3
NR12			•	NL12				¾	3½
NR4L				NL4L				¼	2¾
NR5L				NL5L				5/16	3¼
NR6L		•	•	NL6L		•	•	⅜	4
NR8L		•	•	NL8L		•	•	½	5

BRAZED TOOLS

STYLE P
BORING
HELD AT 45°
90° APPROACH



RIGHT HAND SHOWN

METRIC SHANKS

RIGHT HAND TOOL No.	GRADES STOCKED K10	K20	P30	LEFT HAND TOOL No.	GRADES STOCKED K10	K20	P30	DIAMETER	LENGTH
PR0006				PL0006				6	30
PR0008	•	•	•	PL0008		•	•	8	40
PR0010	•	•	•	PL0010	•	•	•	10	50
PR0012	•	•	•	PL0012		•	•	12	60
PR0016		•	•	PL0016				16	90
PR0020	•	•	•	PL0020				20	100

IMPERIAL SHANKS

RIGHT HAND TOOL No.	GRADES STOCKED K10	K20	P30	LEFT HAND TOOL No.	GRADES STOCKED K10	K20	P30	DIAMETER	LENGTH
PR4	•	•	•	PL4	•			¼	1¼
PR5			•	PL5			•	5/16	1½
PR6		•	•	PL6		•	•	⅜	1¾
PR8		•	•	PL8		•	•	½	2½
PR10				PL10				⅝	3
PR12			•	PL12				¾	3½

BRAZED TOOLS

STYLE R
BORING
HELD AT 90°
75° APPROACH

RIGHT HAND SHOWN

METRIC SHANKS

RIGHT HAND TOOL No.	GRADES STOCKED K10	K20	P30	LEFT HAND TOOL No.	GRADES STOCKED K10	K20	P30	DIAMETER	LENGTH
RR0006				RL0006				6	30
RR0008		•	•	RL0008		•	•	8	40
RR0010		•	•	RL0010		•	•	10	50
RR0012		•	•	RL0012		•	•	12	60
RR0016				RL0016				16	90
RR0020				RL0020				20	100
RR0006L				RL0006L				6	70
RR0008L		•	•	RL0008L		•	•	8	80
RR0010L		•	•	RL0010L		•	•	10	100
RR0012L		•	•	RL0012L		•	•	12	120

IMPERIAL SHANKS

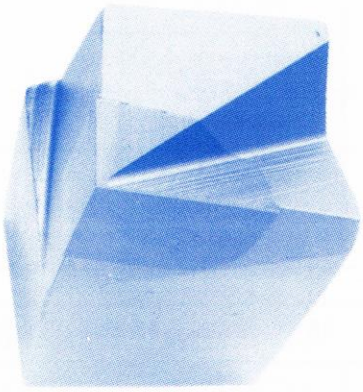
RIGHT HAND TOOL No.	GRADES STOCKED K10	K20	P30	LEFT HAND TOOL No.	GRADES STOCKED K10	K20	P30	DIAMETER	LENGTH
RR4				RL4				1/4	1 1/4
RR5				RL5				5/16	1 1/2
RR6		•	•	RL6		•	•	3/8	1 3/4
RR8		•	•	RL8		•	•	1/2	2 1/2
RR10				RL10				5/8	3
RR12				RL12				3/4	3 1/2
RR4L				RL4L				1/4	2 3/4
RR5L				RL5L				5/16	3 1/4
RR6L		•	•	RL6L		•	•	3/8	4
RR8L		•	•	RL8L		•	•	1/2	5

BRAZED TOOLS

STYLE RA
CHIPSTREAM
ROLLER BOX TOOL

METRIC SHANKS						
TOOL No.	GRADES STOCKED			WIDTH	HEIGHT	LENGTH
	K10	K20	P30			
RA1620			•	16	20	57
RA2025			•	20	25	67

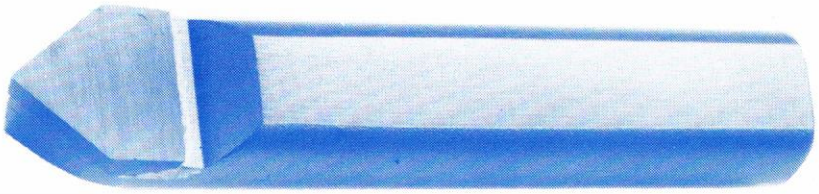
STYLE RB
ROLLER BOX TOOL



METRIC SHANKS						
TOOL No.	GRADES STOCKED			WIDTH	HEIGHT	LENGTH
	K10	K20	P30			
RB1012			•	10	12	75
RB1016			•	10	16	75
RB1220			•	12	20	110
RB1622			•	16	22	110

BRAZED TOOLS

STYLE S
BORING
HELD AT 90°
50° APPROACH



MACHINES BOTH DIRECTIONS

METRIC SHANKS					
TOOL No.	GRADES STOCKED K10	K20	P30	DIAMETER	LENGTH
S0006				6	30
S0008		•	•	8	40
S0010		•	•	10	50
S0012		•	•	12	60
S0016				16	90
S0020				20	100
S0006L				6	70
S0008L		•	•	8	80
S0010L		•	•	10	100
S0012L		•	•	12	120

IMPERIAL SHANKS					
TOOL No.	GRADES STOCKED K10	K20	P30	DIAMETER	LENGTH
S4				1/4	1 1/4
S5				5/16	1 1/2
S6		•	•	3/8	1 3/4
S8		•	•	1/2	2 1/2
S10				5/8	3
S12				3/4	3 1/2
S4L				1/4	2 3/4
S5L				5/16	3 1/4
S6L		•	•	3/8	4
S8L		•	•	1/2	5

BRAZED TOOLS

STYLE T
BORING

METRIC SHANKS						
TOOL No.	GRADES STOCKED			DIAMETER	LENGTH	MIN. BORE
	K10	K20	P30			
T0008		•	•	8	125	11.5
T0010		•	•	10	140	15
T0012		•	•	12	160	18.5
T0016		•	•	16	200	24
T0020		•	•	20	250	31
T0025		•	•	25	300	39

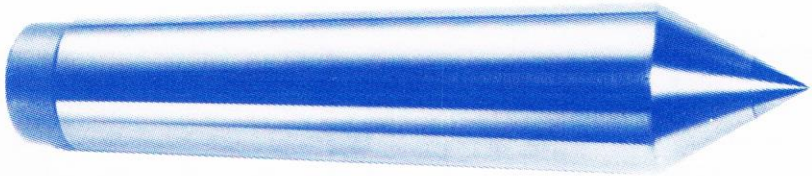
IMPERIAL SHANKS						
TOOL No.	GRADES STOCKED			DIAMETER	LENGTH	MIN. BORE
	K10	K20	P30			
T5				5/16	5	7/16
T6				3/8	6	9/16
T8				1/2	7	3/4
T10				5/8	8	15/16
T12				3/4	10	1 3/16
T16				1	12	1 9/16

BRAZED TOOLS

STYLE V
PULLEY GROOVING

METRIC SHANKS							
TOOL No.	GRADES STOCKED K10	K20	P30	WIDTH	HEIGHT	LENGTH	DIAMETER RANGE
VA34		•	•	16	25	160	65-135
VA36		•	•	16	25	160	Non Standard
VA38		•	•	16	25	160	135- ∞
VB34		•	•	20	25	160	115-175
VB36		•	•	20	25	160	Non Standard
VB38		•	•	20	25	160	175- ∞
VC34		•		25	25	160	175-200
VC36		•		25	25	160	200-300
VC38		•		25	25	160	300- ∞

DEAD
CENTRES



CARBIDE TIPPED DEAD CENTRES			
TOOL No.	STOCKED	CARBIDE DIAMETER	INCLUDED ANGLE
2MT	•	8	60°
3MT	•	10	60°
4MT	•	12	60°
5MT	•	14	60°

BRAZED TOOLS

16mm Suits VHU36
25mm Suits VHU56

NAREX BORING

RIGHT HAND SHOWN

RIGHT HAND TOOL No.	GRADES STOCKED K10	K20	P30	LEFT HAND TOOL No.	GRADES STOCKED K10	K20	P30	DIAMETER	LENGTH
R16 NAREX			•	L16 NAREX			•	16	51
R25 NAREX			•	L25 NAREX			•	25	77

AUTOMOTIVE BRAZED TOOLS

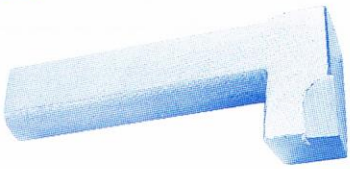
BERCO BORING

FLAT ON SIDE

DIA.	L	TOOL No.	GRADES STOCKED K10	K20	P30
10	51	BERCO	•		

DIA.	L	TOOL No.	GRADES STOCKED K10	K20	P30
10	57	BE6R		•	

VAN NORMAN BORING



DIA.	L	TOOL No.	GRADES STOCKED K10	K20	P30
3/8	31/32	777S	•		

DIA.	L	TOOL No.	GRADES STOCKED K10	K20	P30
3/8	1 3/4	BH6		•	

ROTTLER BORING

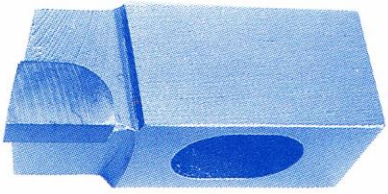
DIA.	L	TOOL No.	GRADES STOCKED K10	K20	P30
11/32	1 11/16	ROTTLER	•		

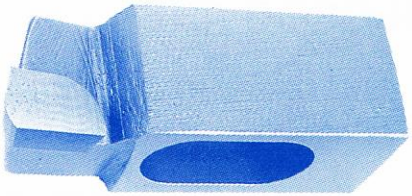
WAIDA BORING

DIA.	L	TOOL No.	GRADES STOCKED K10	K20	P30
8	30	H2	•		

AUTOMOTIVE BRAZED TOOLS

ROBBI MILLING

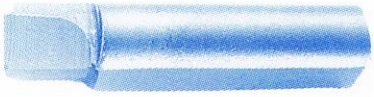




CAST IRON MILLING						
T	W	L	TOOL No.	GRADES STOCKED K10	K20	P30
16	16	43	427	•		

ALUMINIUM MILLING						
T	W	L	TOOL No.	GRADES STOCKED K10	K20	P30
16	16	46	446	•		

ROBBI SURFACING



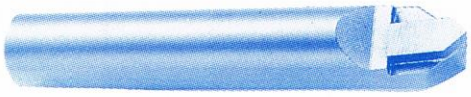
FLAT ON SIDE

DIA.	L	TOOL No.	GRADES STOCKED K10	K20	P30
10	41	433	•		

ROBBI BORING

DIA.	L	TOOL No.	GRADES STOCKED K10	K20	P30
10	51	419	•		
10	71	420	•		

COMEC TOOLS



RIGHT HAND SHOWN

DIA.	L	TOOL No.	GRADES STOCKED K10	K20	P30
12	55	C4-12		•	
12	70	002958		•	

DIA.	L	TOOL No.	GRADES STOCKED K10	K20	P30
10	45	C2-60L-10		•	
10	45	C2-60R-10		•	

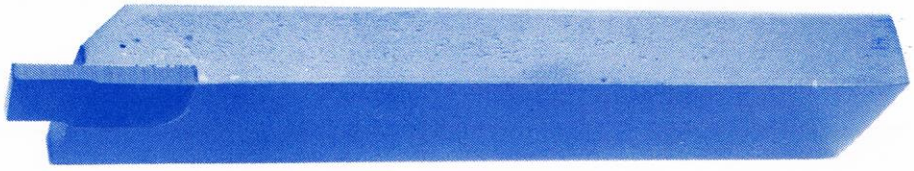
CARL LARSSON TOOLS

T	W	L	TOOL No.	GRADES STOCKED K10	K20	P30
4	6	14	CL14	•		

T	W	L	TOOL No.	GRADES STOCKED K10	K20	P30
4	6	20	CL20	•		

AUTOMOTIVE BRAZED TOOLS

STYLE KA
PISTON GROOVING



METRIC SHANKS							
TOOL No.	GRADES STOCKED			TIP WIDTH	WIDTH	HEIGHT	LENGTH
	K10	K20	P30				
KA1016-150		•		1.50mm	10	16	110
KA1016-175		•		1.75mm	10	16	110
KA1016-200		•		2.00mm	10	16	110
KA1016-250		•		2.50mm	10	16	110
KA1016-300		•		3.00mm	10	16	110
KA1016-400		•		4.00mm	10	16	110
KA1016-464		•		1/16	10	16	110
KA1016-664		•		3/32	10	16	110
KA1016-864		•		1/8	10	16	110
KA1220-150		•		1.50mm	12	20	125
KA1220-175		•		1.75mm	12	20	125
KA1220-200		•		2.00mm	12	20	125
KA1220-250		•		2.50mm	12	20	125
KA1220-300		•		3.00mm	12	20	125
KA1220-400		•		4.00mm	12	20	125
KA1220-464		•		1/16	12	20	125
KA1220-664		•		3/32	12	20	125
KA1220-864		•		1/8	12	20	125

AUTOMOTIVE BRAZED TOOLS

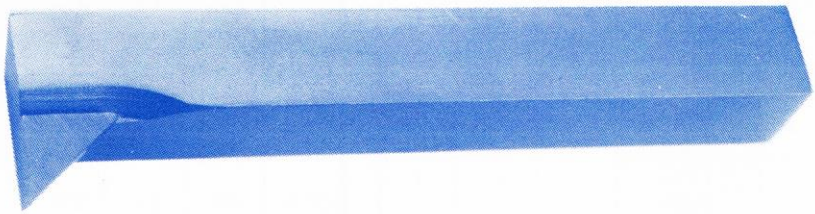
STYLE BD
BRAKE DRUM

RIGHT HAND SHOWN

METRIC SHANKS										
RIGHT HAND TOOL No.	GRADES STOCKED			LEFT HAND TOOL No.	GRADES STOCKED			WIDTH	HEIGHT	LENGTH
	K10	K20	P30		K10	K20	P30			
BDR1010		•		BDL1010		•		10	10	90
BDR1212		•		BDL1212		•		12	12	100
BDR1616				BDL1616				16	16	110
BDR1616-30				BDL1616-30				16	16	110

IMPERIAL SHANKS										
RIGHT HAND TOOL No.	GRADES STOCKED			LEFT HAND TOOL No.	GRADES STOCKED			WIDTH	HEIGHT	LENGTH
	K10	K20	P30		K10	K20	P30			
BDR6				BDL6				⅜	⅜	2½
BDR8		•		BDL8		•		½	½	3½
BDR10				BDL10				⅝	⅝	4
BDR10-30				BDL10-30				⅝	⅝	4

STYLE DT
BRAKE DISC



RIGHT HAND SHOWN

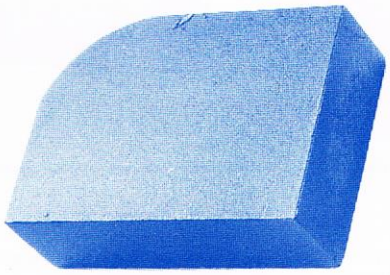
METRIC SHANKS										
RIGHT HAND TOOL No.	GRADES STOCKED			LEFT HAND TOOL No.	GRADES STOCKED			WIDTH	HEIGHT	LENGTH
	K10	K20	P30		K10	K20	P30			
DTR1212		•		DTL1212		•		12	12	100

BLANKS

STYLE 1000

T	W	L	R	BLANK No.	GRADES STOCKED K10	K20	P30
1/16	1/8	5/8	1/8	1010 2010		•	•
	3/16	1/4	1/8	1020 2020	• •	• •	• •
	1/4	1/4	1/8	1025 2025		•	
	1/4	5/16	1/8	1030 2030	• •	• •	• •
3/32	1/8	3/4	1/8	1035 2035		•	•
	3/16	5/16	1/8	1040 2040	•	• •	• •
	3/16	1/2	1/8	1050 2050		• •	• •
	1/4	3/8	1/8	1060 2060	• •	• •	• •
	1/4	1/2	1/8	1070 2070		• •	• •
	5/16	3/8	3/16	1080 2080	• •	• •	• •
	3/8	3/8	3/16	1090 2090	•	• •	• •
	3/8	1/2	3/16	1100 2100		• •	
	7/16	1/2	1/4	1105 2105		•	•
1/8	3/16	3/4	1/8	1110 2110		•	•
	1/4	1/2	1/8	1120 2120		• •	• •
	1/4	5/8	1/8	1130 2130		•	•
	1/4	3/4	1/8	1140 2140		•	•
	5/16	7/16	3/16	1150 2150	•	• •	• •
	5/16	1/2	3/16	1160 2160		•	•

STYLE 2000



T	W	L	R	BLANK No.	GRADES STOCKED K10	K20	P30
1/8	5/16	5/8	3/16	1170 2170		•	•
	3/8	1/2	3/16	1180 2180	•	• •	• •
	3/8	3/4	3/16	1190 2190		• •	• •
	1/2	1/2	1/4	1200 2200		•	•
	1/2	3/4	1/4	1210 2210		•	•
	3/4	3/4	1/4	1215 2215		•	
5/32	3/8	9/16	3/16	1220 2220		• •	• •
	3/8	3/4	3/16	1230 2230			
	5/8	5/8	1/4	1240 2240			
3/16	5/16	7/16	3/16	1250 2250		• •	• •
	5/16	5/8	3/16	1260 2260		•	
	3/8	1/2	3/16	1270 2270		•	
	3/8	5/8	3/16	1280 2280		•	•
	3/8	3/4	3/16	1290 2290		•	
	7/16	5/8	1/4	1300 2300	•	• •	• •
	7/16	13/16	1/4	1310 2310		•	
	1/2	1/2	1/4	1320 2320		•	
	1/2	3/4	1/4	1330 2330	•	•	•
	3/4	3/4	1/4	1340 2340		•	•

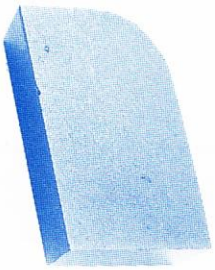
BLANKS

STYLE 0000

STYLE 1000

STYLE 3000

STYLE 4000



T	W	L	R	BLANK No.	GRADES STOCKED K10	K20	P30
1/4	3/8	9/16	—	0350 1350			
	3/8	3/4	3/16	0360 1360 3360 4360		•	•
	7/16	5/8	—	0370 1370			•
	1/2	3/4	1/4	0380 1380 3380 4380			
	9/16	1	1/4	0390 1390 3390 4390	•	•	•
	5/8	5/8	—	0400 1400			
	3/4	3/4	—	0405 1405			
	3/4	1	—	0410 1410		•	•
	1	1	—	0415 1415			
5/16	7/16	5/8	—	0420 1420			
	7/16	15/16	1/4	0430 1430 3430 4430			
	1/2	3/4	1/4	0440 1440 3440 4440			•

T	W	L	R	BLANK No.	GRADES STOCKED K10	K20	P30
5/16	1/2	1	—	0450 1450			
	5/8	1	1/4	0460 1460 3460 4460			
	3/4	3/4	—	0470 1470			
	3/4	1	—	0475 1475			
	3/4	1¼	—	0480 1480	•		•
3/8	1/2	3/4	—	0490 1490			
	1/2	1	—	0500 1500			
	5/8	1	1/4	0510 1510 3510 4510			
	5/8	1¼	—	0515 1515			
	3/4	1¼	—	0520 1520			
	3/4	1½	—	0525 1525			
1/2	3/4	1	—	0530 1530			
	3/4	1¼	—	0540 1540			
	3/4	1½	—	0550 1550			

BLANKS

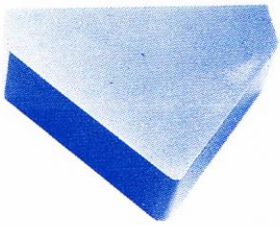
STYLE P3000

T	W	L	R	BLANK No.	GRADES STOCKED K10	K20	P30
3/32	3/16	5/16	1/8	P3040	•	•	•
				P4040	•	•	•
3/32	1/4	1/2	1/8	P3070	•	•	•
				P4070	•	•	•
1/8	5/16	5/8	3/16	P3170	•	•	•
				P4170	•	•	•

STYLE P4000

T	W	L	R	BLANK No.	GRADES STOCKED K10	K20	P30
5/32	3/8	3/4	3/16	P3230	•	•	•
				P4230	•	•	•
3/16	7/16	13/16	1/4	P3310	•	•	•
				P4310	•	•	•
1/4	9/16	1	1/4	P3390		•	•
				P4390		•	•

STYLE 5000



T	W	L	F	BLANK No.	GRADES STOCKED K10	K20	P30
1/16	1/4	5/16	1/8	5030	•	•	•
3/32	5/16	3/8	5/32	5080	•	•	•
3/32	3/8	1/2	3/16	5100	•	•	•
3/32	7/16	1/2	7/32	5105			

T	W	L	F	BLANK No.	GRADES STOCKED K10	K20	P30
1/8	1/2	1/2	1/4	5200	•	•	•
5/32	5/8	5/8	5/16	5240		•	•
3/16	3/4	3/4	3/8	5340		•	•
1/4	1	3/4	1/2	5410		•	•

STYLE 7000

T	W	L	F	BLANK No.	GRADES STOCKED K10	K20	P30
3/32	1/4	3/8	1/16	7060		•	•
1/8	5/16	1/2	3/32	7160			

T	W	L	F	BLANK No.	GRADES STOCKED K10	K20	P30
1/8	5/16	5/8	1/8	7170		•	•
5/32	3/8	3/4	5/32	7230		•	•

BLANKS

STYLE D

T	W	L	BLANK No.	GRADES STOCKED K10	K20	P30
3	3	8	D3		•	•
4	4	10	D4		•	•

T	W	L	BLANK No.	GRADES STOCKED K10	K20	P30
5	5	12	D5		•	•
6	6	14	D6		•	•

STYLE G

T	W	L	R	BLANK No.	GRADES STOCKED K10	K20	P30
4	8	12	1	G8		•	•
4	10	14	1.5	G10		•	•
5	12	17	2.5	G12		•	•

T	W	L	R	BLANK No.	GRADES STOCKED K10	K20	P30
6	16	20	3.5	G16		•	•
6	20	24	4.5	G20		•	•
8	25	28	6	G25		•	•

STYLE PG

T	W	L	F	X	BLANK No.	GRADES STOCKED K10	K20	P30
8	16	25	5.0	34°	PGA-104		•	•
8	16	25	4.2	38°	PGA-108		•	
8	19	29	7.2	34°	PGB-204		•	•

T	W	L	F	X	BLANK No.	GRADES STOCKED K10	K20	P30
8	19	29	6.4	38°	PGB-208		•	
8	25	38	10.2	34°	PGC-304		•	
8	25	38	9.1	38°	PGC-308		•	

BLANKS

STYLE RT REAMER BLADES

T	W	L	R	BLANK No.	GRADES STOCKED K10	K20	P30
.026	3/64	1/2	1/4	RT-0 RRT-0			
.040	1/16	1/2	1/4	RT-1 RRT-1			
.057	3/32	1/2	1/4	RT-2 RRT-2			
.057	3/32	5/8	1/4	RT-3 RRT-3			
.075	1/8	3/4	1/4	RT-4 RRT-4		•	
.090	5/32	7/8	1/4	RT-5 RRT-5			

STYLE RRT REAMER BLADES

T	W	L	R	BLANK No.	GRADES STOCKED K10	K20	P30
.106	3/16	7/8	5/16	RT-6 RRT-6			
.075	13/64	3/4	5/16	RT-7 RRT-7		•	
.075	17/64	3/4	3/8	RT-8 RRT-8			
.075	5/16	3/4	3/8	RT-9 RRT-9		•	
.075	3/8	3/4	3/8	RT-10 RRT-10		•	
.057	3/32	7/8	1/4	RT-11 RRT-11			

STYLE SS SQUARE SOLID CARBIDE

A	B	C	TOOL No.	GRADES STOCKED K10	K20	P30
3/16	3/16	1 1/4	SS-610			•
1/4	1/4	1 1/4	SS-810			•
5/16	5/16	1 1/2	SS-1012			•
3/8	3/8	1 3/4	SS-1214			•

STYLE SR ROUND SOLID CARBIDE

D	L	TOOL No.	GRADES STOCKED K10	K20	P30
1/8	1	SR-48			
3/16	1 1/8	SR-69			
1/4	1 1/4	SR-810			•
5/16	1 1/4	SR-1010			

BLANKS

STYLE STB

T	W	L	BLANK No.	GRADES STOCKED K10	K20	P30
1/32	1/16	1	STB-12		•	
3/64	3/32	13/16	STB-13A			
	3/32	1	STB-13		•	•
1/16	1/8	1	STB-24A		•	
	1/8	1¼	STB-24C			
	1/8	3	STB-24B			
	3/16	1	STB-26A		•	
	3/16	3	STB-26C		•	
	1/4	1	STB-28A		•	
	1/4	1¼	STB-28B		•	
	1/4	3	STB-28D		•	
3/32	1/8	5	STB-34			
	3/16	1⅛	STB-36			
	3/16	1¼	STB-36A			
	1/4	1	STB-38A			
	1/4	1½	STB-38B			•
	1/4	5	STB-38D			
	5/16	2	STB-310A		•	
	5/16	3	STB-310B			
	5/16	5	STB-310C			
	3/8	5	STB-312			
	1/2	6	STB-316			
	5/8	6	STB-320		•	
	3/4	6	STB-324		•	
	1	6	STB-332		•	
1/8	3/16	6	STB-46			
	1/4	1	STB-48A		•	
	1/4	1¼	STB-48B		•	
	1/4	2¼	STB-48C		•	
	1/4	6	STB-48E		•	

T	W	L	BLANK No.	GRADES STOCKED K10	K20	P30
1/8	5/16	1½	STB-410A			
	5/16	6	STB-410			
	3/8	1	STB-412D		•	
	3/8	2	STB-412A			
	3/8	3	STB-412B			
	3/8	6	STB-412C			
	3/8	1	STB-416A		•	
	1/2	1½	STB-416B			
	1/2	3	STB-416C			
	1/2	6	STB-416		•	•
	5/8	6	STB-420		•	
	3/4	6	STB-424		•	
	1	6	STB-432		•	
3/16	1/4	3	STB-68A		•	
	1/4	6	STB-68	•		
	5/16	6	STB-610		•	
	3/8	3	STB-612A			
	3/8	6	STB-612			
	1/2	3	STB-616A			
	1/2	6	STB-616			
	5/8	3	STB-620A		•	
	5/89	6	STB-620			
1/4	3/87	3	STB-812A			
	3/8	6	STB-812			
	1/2	3	STB-816A			
	1/2	6	STB-816			
	5/8	3	STB-820A			
	5/8	6	STB-820			
	3/4	3	STB-824A		•	
	3/4	6	STB-824			

STANDARD GRADES FOR BRAZED TOOLS

P30 STEEL GRADE	LIGHT MACHINING TO HEAVY ROUGHING OVER A BROAD RANGE OF PLAIN CARBON, ALLOY, FREE MACHINING, TOOL STEELS AND 400/500 SERIES STAINLESS STEELS.
K10 CAST IRON GRADE	LIGHT TO MEDIUM MACHINING OF CAST IRON, COPPER, BRASS, ALUMINIUM, HIGH TEMPERATURE ALLOYS, FIBREGLASS, WOOD AND PLASTICS.
K20 CAST IRON GRADE	MEDIUM TO HEAVY MACHINING OF CAST IRON, COPPER, BRASS, ALUMINIUM, HIGH TEMPERATURE ALLOYS, FIBREGLASS, WOOD, PLASTICS AND 200/300 SERIES STAINLESS STEEL.

TROUBLE SHOOTING

PROBLEM	CORRECTION
BREAKAGE	FEED RATE TOO HIGH DULL TOOL SHARPENING WITH TOO MUCH SIDE CLEARANCE SHARPENING WITH TOO MUCH END CLEARANCE SHARPENING WITH TOO MUCH TOP RAKE NOSE RADIUS TOO SMALL EXCESSIVE VIBRATION - CHECK WORK, MACHINE OR TOOL TOOL DEFLECTION - REDUCE OVERHANG
FLANK WEAR	EXCESSIVE SPEED MATERIAL TOO HARD FOR CURRENT WORKING CONDITIONS INADEQUATE CUTTING FLUID
CRATERING	EXCESSIVE SPEED EXCESSIVE FEED TOO LITTLE TOP RAKE
ROUGH FINISH	FEED RATE TOO HIGH SPEED TOO LOW DULL TOOL WRONG COOLANT FOR WORK MATERIAL
FEED RATE MUST NOT EXCEED 2/3 OF NOSE RADIUS	

SPEED CHART FOR BRAZED TOOLS

WORKPIECE DIAMETER IN MILLEMETRES	ALUMINIUM	MILD STEEL, CAST IRON	LOW CARBON ALLOY STEEL	HIGH CARBON ALLOY STEEL	TOOL STEEL (ANNEALED)
6	16,000	5,500	4,200	3,200	2,400
8	12,000	4,000	3,200	2,400	1,800
10	9,500	3,200	2,500	1,900	1,430
12	8,000	2,600	2,100	1,600	1,200
16	6,000	2,000	1,600	1,200	900
20	4,800	1,600	1,300	950	720
25	3,800	1,300	1,000	760	570
35	2,700	900	720	550	400
50	1,900	640	500	380	290
70	1,350	450	360	270	200
100	950	320	250	190	140
150	650	210	170	125	95
200	480	160	130	95	70
500	190	65	50	38	28
	REVOLUTIONS PER MINUTE				