



Material	Vc uncoated [m/min]	Vc coated [m/min]	Uncoated	Coated	Rec. Coating*
Steel < 700 N/mm ²	120	155	☐	☒	Tisi (BQ)
Steel > 700 N/mm ²	95	120	-	☒	Tisi (BQ)
Stainless steel	60	85	☐	☒	Tisi (BQ)
Cast iron	70	120	☐	☒	Tisi (BQ)
Copper	155	190	☐	☒	Solo (DA)
Brass - Bronze	170	230	☒	☐	Solo (DA)
Aluminium	240	420	☐	☒	Solo (DA)
Gold - Silver	170	215	☒	☒	Solo (DA)
Platinum - Palladium	-	40	-	☐	Solo (DA)
Superalloys	-	50	-	☒	Trio (PO)
Titanium	50	70	☒	☒	RICO (ZB)

not adapted - adapted ☐ highly adapted ☒

Tolerances $d_1 < D \rightarrow d_1: 0/-0.02$ $l_2: +0.2/0$
 $d_1 > D \rightarrow d_1: -0.05/-0.10$ $d_2: 0/-0.1$
 $d_1 = D \rightarrow d_1: -0.05/-0.10$ $e: +0.01/-0.01$

D: h5

Available
uncoated or coated



Z3-9



λ
0°

γ
6-15°

CARB



Art. n°	d_1	e^*	$d_{2\text{ mini}}$	l_2	D	L	Z	Uncoat. Price
117Hd4.00e#.#Z#	4	0.5-4.0	3	3	6	56	3/6	
117Hd6.00e#.#Z#	6	0.5-6.0	3	4	6	56	3/6	
117Hd8.00e#.#Z#	8	0.5-6.0	4	5	8	61	6	
117Hd10.00e#.#Z#	10	1.0-8.0	6	5	10	70	6	
117Hd12.00e#.#Z#	12	1.0-10.0	7	6	12	80	6	
117Hd16.00e#.#Z#	16	1.0-10.0	10	8	16	88	6/9	
117Hd20.00e#.#Z#	20	1.0-10.0	10	8	20	100	6/9	

* e : available thickness: every 0.1 mm

* Prices for coatings: contact us!

To order a coated tool, add the 2-letter coating code to the article number

☐ Order ☐ Quotation request

Dimensions : d_1 : _____ e : _____ d_2 : _____ l_2 : _____ D : _____ L : _____ Z : ☐ 3 ☐ 6 ☐ 9		Coating : ☐ Uncoated ☐ Coated* : _____	
Cut : ☐ right cut ☐ left cut	Machined material : _____	Quantity : _____	Order No : _____
Company's stamp & date : _____		Contact person : _____	

* Without information, the most suitable coating will be applied.