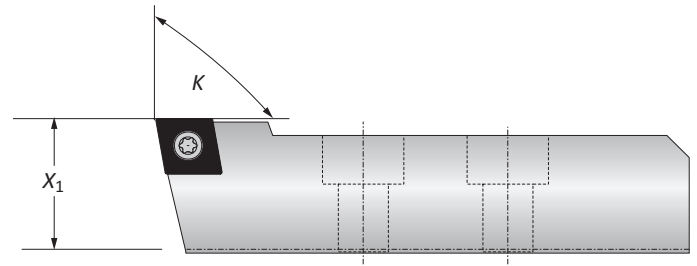


Insert Holders for Rough Machining

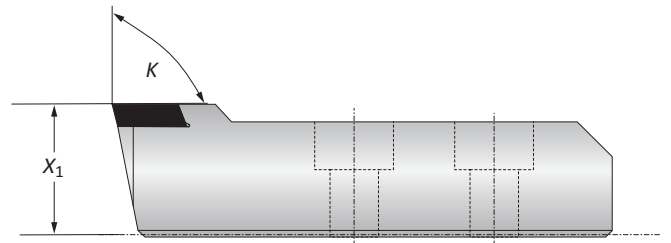
90° Insert Holders

Insert Holder		Weight	ISO Code	Insert Form	Part No.
K	X ₁				
m	90° 30.00	0.60 (kg)	CC..09T3..	103	149090
	90° 30.00	0.60 (kg)	CC..1204..	104	149099
	90° 29.30	0.60 (kg)	CC..1204..	104	149083
	90° 30.00	0.60 (kg)	CC..1605..	105	149093



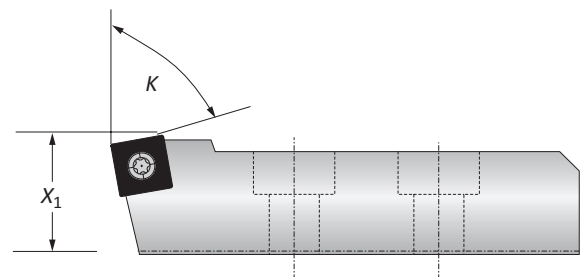
90° Tangential Insert Holders

Insert Holder		Weight	ISO Code	Insert Form	Part No.
K	X ₁				
m	90° 30.00	0.60 (kg)	Tangential	05	149010
	90° 29.30	0.60 (kg)	Tangential	05	149020



80° Insert Holders

Insert Holder		Weight	ISO Code	Insert Form	Part No.
K	X ₁				
m	80° 30.00	0.60 (kg)	SC..1204..	113	149089
	80° 30.00	0.60 (kg)	SC..150512	114	149094
	80° 30.00	0.60 (kg)	SN..1506..	134	149096



Key on B10-G: 1

B10-M: 12-13

B10-G: 22-25

B10-G: 16-19

B10-H

B10: VI-VII

m = Metric (mm)

Inserts sold separately

WARNING Exceeding weight capacity for machine tool spindle and tool changer can cause machine damage and/or serious injury. To prevent:

- Consult machine tool builder for machine's weight limitations.
- Refer to example on page B10-M: 11 for calculating tool assembly weight
- Factory technical assistance is also available for specific applications through our Application Engineering department. *email: engineering.eu@alliedmachine.com*

WARNING Tool failure can cause serious injury. To prevent:

- Do not exceed recommended 10xD length-to-diameter ratio or exceed 4 total components (including shank)
- When using Alu-Line® components, do not exceed recommended 5xD length-to-diameter ratio
- When using tool steel components, do not exceed recommended 6xD length-to-diameter ratio
- When using heavy metal components, do not exceed recommended 8xD length-to-diameter ratio
- When using a carbide shank, do not exceed recommended 9xD length-to-diameter ratio
- When using a NOVI^{TECH} module, do not exceed recommended 10xD length-to-diameter ratio
- Refer to examples on pages B10-M: 8-10 for calculating length-to-diameter ratio
- Factory technical assistance is available for your specific applications through our Application Engineering department. *email: engineering.eu@alliedmachine.com*

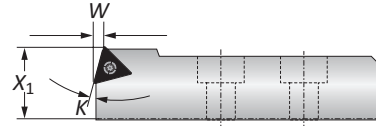
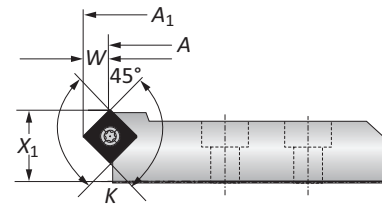
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Insert Holders for Rough Machining | Boring Range Examples

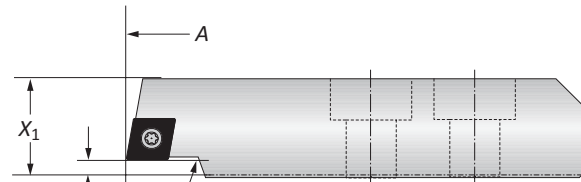
Chamfering Insert Holders

m	Insert Holder				Weight	ISO Code	Insert Form	Part No.
	K	X ₁	A / A ₁	W				
	15°	30.00	+7.00	4.00	0.60 (kg)	TC..16T3..	163	201065
	20°	30.00	+9.00	5.30	0.60 (kg)	TC..16T3..	163	201025
	30°	30.00	+14.00	7.70	0.60 (kg)	TC..16T3..	163	201075
	45°	30.00	+20.00	9.90	0.60 (kg)	SC..1505..	114	201015



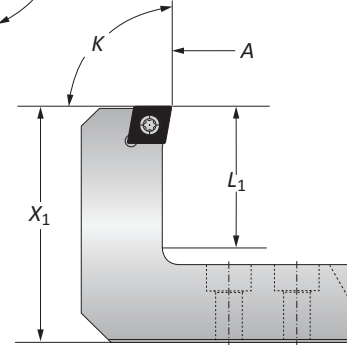
Back-Boring Insert Holders

m	Insert Holder				Weight	ISO Code	Insert Form	Part No.
	K	X ₁	X ₂	A				
	90°	30.00	5.00	+40.00	0.80 (kg)	CC..1204..	104	251010
	90°	30.00	5.00	+75.00	0.90 (kg)	CC..1204..	104	251011



OD Turning Insert Holders

m	Insert Holder				Weight	ISO Code	Insert Form	Part No.
	K	X ₁	L ₁	A				
	90°	90.00	62.00	-50.00	1.00 (kg)	CC..1204..	104	149040

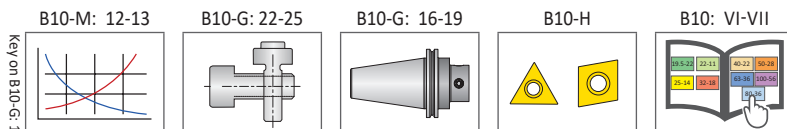


Boring Range Examples

m	Serrated Slide		Insert Holder		Total Bore Range
	Part No.	Bore Range	Part No.	Modified Bore Range	
		349051	200.00 - 280.00	201065	
	349051	200.00 - 280.00	251010	+40.00	240.00 - 320.00
	349051	200.00 - 280.00	149040	-50.00	150.00 - 230.00

NOTE: Boring range for serrated slides or base slides are found on pg. B10-G: 4 - 7

NOTE: Additional insert holders available upon request



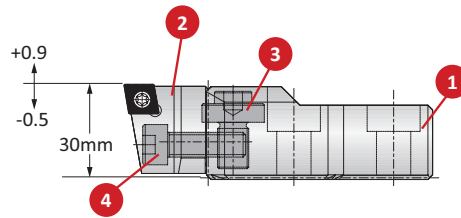
m = Metric (mm)

Inserts sold separately

WARNING Exceeding weight capacity for machine tool spindle and tool changer can cause machine damage and/or serious injury. To prevent:
 -Consult machine tool builder for machine's weight limitations.
 -Refer to example on page B10-M: 11 for calculating tool assembly weight
 Factory technical assistance is also available for specific applications through our Application Engineering department. *email: engineering.eu@alliedmachine.com*

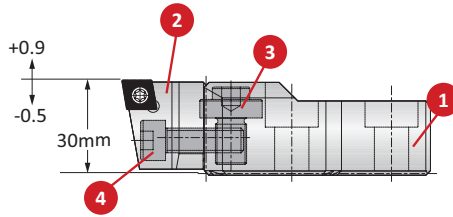
WARNING Tool failure can cause serious injury. To prevent:
 -Do not exceed recommended 10xD length-to-diameter ratio or exceed 4 total components (including shank)
 -When using Alu-Line® components, do not exceed recommended 5xD length-to-diameter ratio
 -When using tool steel components, do not exceed recommended 6xD length-to-diameter ratio
 -When using heavy metal components, do not exceed recommended 8xD length-to-diameter ratio
 -When using a carbide shank, do not exceed recommended 9xD length-to-diameter ratio
 -When using a NOVITECH module, do not exceed recommended 10xD length-to-diameter ratio
 -Refer to examples on pages B10-M: 8-10 for calculating length-to-diameter ratio
 Factory technical assistance is available for your specific applications through our Application Engineering department. *email: engineering.eu@alliedmachine.com*

Insert Holders for Height Adjustments and Axial Grooving



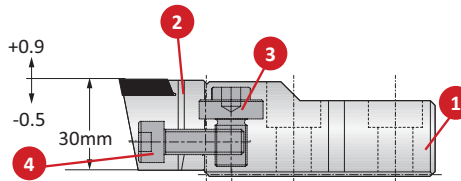
Insert Form 103

Boring Range	1 Support		2 Insert Holder		3 Adjusting Screw		4 Fixing Screw	
	Part No.	Insert Form	Part No.	Part No.	Service Key	Part No.	Service Key	
200.00 - 3255.00	149055	103	149058	315355	s6 / B	070369	s6 / B	



Insert Form 104

Boring Range	1 Support		2 Insert Holder		3 Adjusting Screw		4 Fixing Screw	
	Part No.	Insert Form	Part No.	Part No.	Service Key	Part No.	Service Key	
200.00 - 3255.00	149055	104	149056	315355	s6 / B	070369	s6 / B	

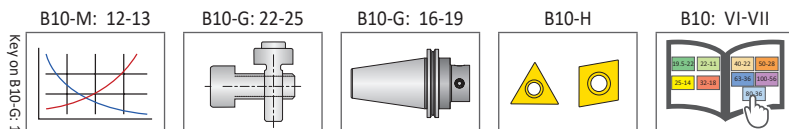
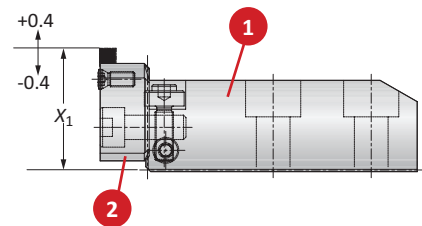


Insert Form 05

Boring Range	1 Support		2 Insert Holder		3 Adjusting Screw		4 Fixing Screw	
	Part No.	Insert Form	Part No.	Part No.	Service Key	Part No.	Service Key	
200.00 - 3255.00	149055	05	149085	315355	s6 / B	070369	s6 / B	

Insert Holder for Axial Grooving

Insert Holder	1 Support	2 Insert Holder		
X_1	Part No.	Part No.	Weight	Insert Form
40.00	226014	226031	0.30 (kg)	304



m = Metric (mm)

Inserts sold separately

WARNING Exceeding weight capacity for machine tool spindle and tool changer can cause machine damage and/or serious injury. To prevent:

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-Refer to example on page B10-M: 11 for calculating tool assembly weight

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WARNING Tool failure can cause serious injury. To prevent:

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-When using Alu-Line® components, do not exceed recommended 5xD length-to-diameter ratio

-When using tool steel components, do not exceed recommended 6xD length-to-diameter ratio

-When using heavy metal components, do not exceed recommended 8xD length-to-diameter ratio

-When using a carbide shank, do not exceed recommended 9xD length-to-diameter ratio

-When using a NOVITECH module, do not exceed recommended 10xD length-to-diameter ratio

-Refer to examples on pages B10-M: 8-10 for calculating length-to-diameter ratio

Factory technical assistance is available for your specific applications through our Application Engineering department. [email: engineering.eu@alliedmachine.com](mailto:engineering.eu@alliedmachine.com)

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