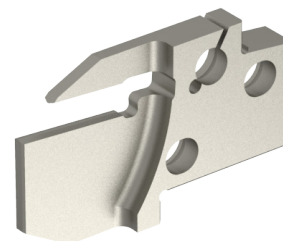
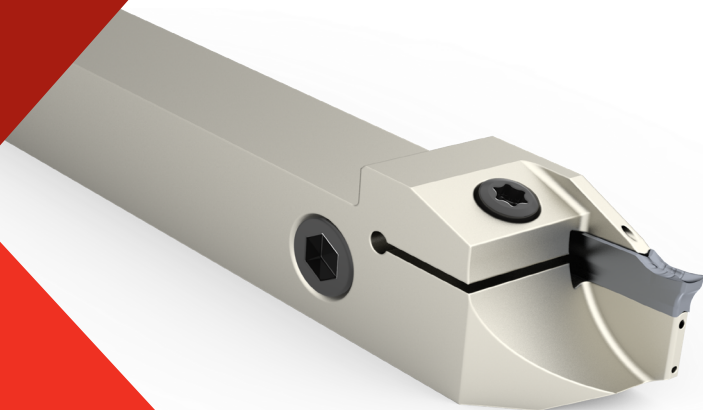


EN
2024



GROOVING

Cutting Tool Solutions

masam.en






Founded in 2001, MASAM, s.r.o. has over 20 years of experience in the development and production of custom cutting tools, tool reconditioning and coating, as well as precision CNC machining for various industrial applications.


Driven by a culture of professional development and technological leadership, MASAM invests continuously in machine upgrades, R&D, and dual-education partnerships with local technical schools. Its strategic goal is to expand capacity, enter new market segments, and exceed the expectations of industrial clients worldwide.

 **Headquarters**
Vráble, Slovakia

Facts and figures


1 production sites 

1 00 000 tools sharpened and produced annually 

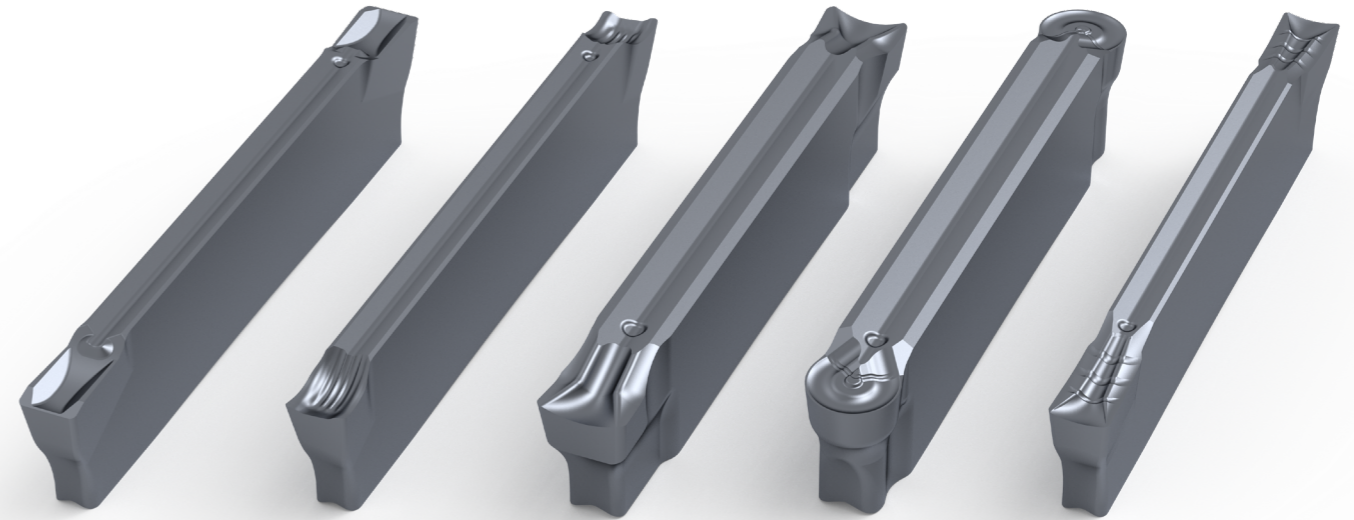
10 countries in which we are active 

70 employees 

in-house design and development department 

strong focus on custom manufacturing 

Cutting geometries

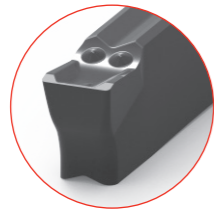


UD/UJ



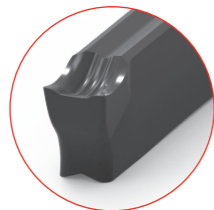
UPP-Medium cutting

- ▲ Insert with narrow negative chamfer
- ▲ Suitable for all steel materials with high strength
- ▲ Suitable for all applications
- ▲ For steel and grey cast iron



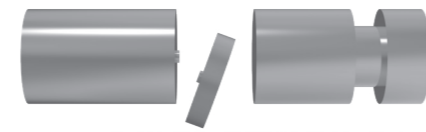
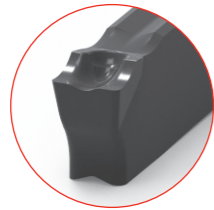
UUP-Very soft cutting

- ▲ Excellent cutting chipbreaker with low cutting forces
- ▲ For low or medium strength materials
- ▲ Particularly suitable for parting off tubes and thin-walled work pieces
- ▲ High cutting edge stability
- ▲ Excellent chip control also with low feed
- ▲ Low built up edge



UMP-Stainless und super alloys

- ▲ Especially for stainless steel
- ▲ Problem solver for steel machining



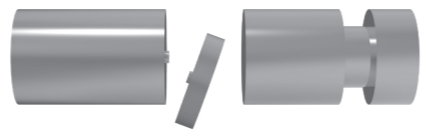
Parting

Grooving



Parting

Grooving



Parting

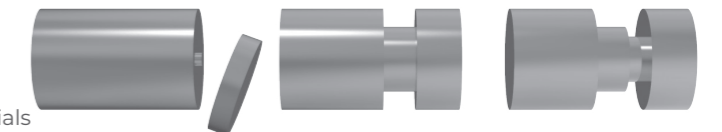
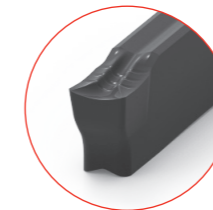
Grooving

UD/UJ



UUT-Grooving and Turning

- ▲ For grooving and turning
- ▲ Suitable for all steel and stainless steel materials
- ▲ Very good chip control



Parting

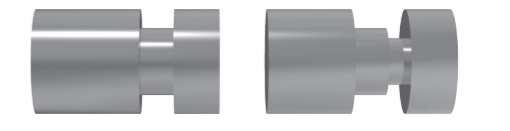
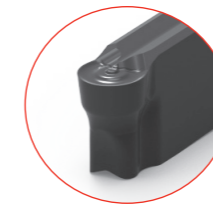
Grooving

Turning



UPR-Radius grooves

- ▲ Insert for radius grooves
- ▲ For copy turning
- ▲ Suitable for all steel and cast iron materials



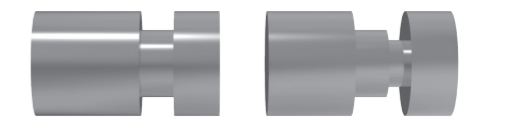
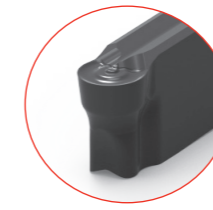
Grooving

Turning



UMR-General application and Turning

- ▲ Especially for stainless steel materials



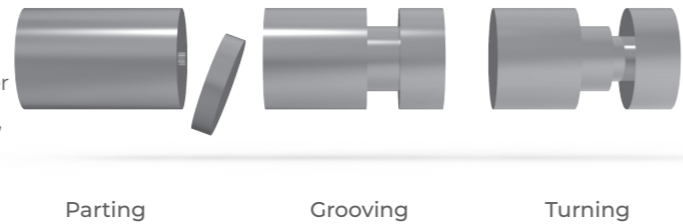
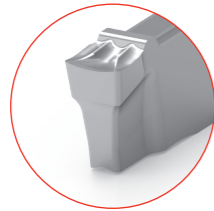
Grooving

Turning

UD/UJ

■ UNT-Non ferrous metals

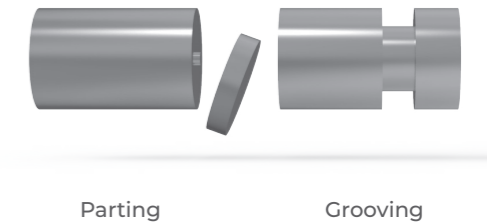
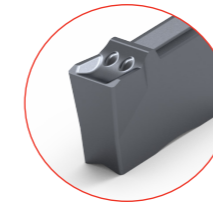
- ▲ Insert with highly positive cutting chipbreaker and sharp cutting edge
- ▲ Extra-smooth rake face through "microfinish"
- ▲ Reduced built-up edge



US

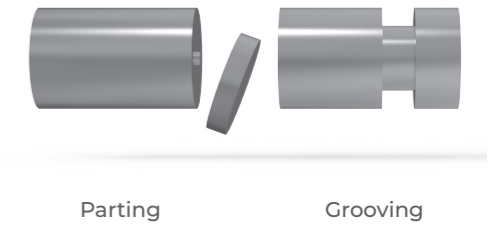
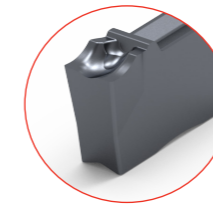
■ ■ UPP-Medium cutting

- ▲ Insert with narrow negative chamfer
- ▲ Suitable for all steel materials with high strength
- ▲ Suitable for all applications
- ▲ For steel and grey cast iron



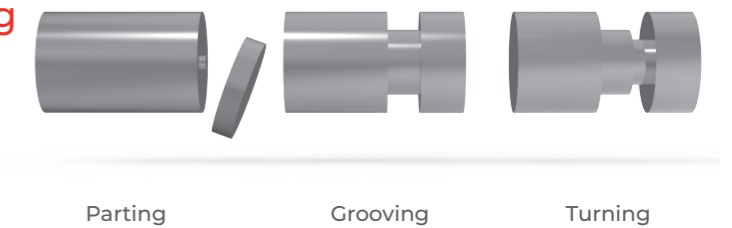
■ ■ UMP-Stainless and super alloys

- ▲ Especially for stainless steel
- ▲ Problem solver for steel machining



■ ■ UUT-Grooving and Turning

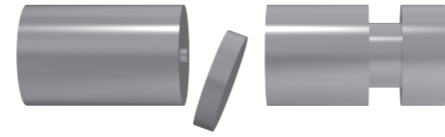
- ▲ For grooving and turning
- ▲ Suitable for all steel and cast iron materials
- ▲ Very good chip control



US

■ UNT–Non ferrous metals

- ▲ Insert with highly positive cutting chipbreaker and sharp cutting edge
- ▲ Extra-smooth rake face through “microfinish”
- ▲ Reduced built-up edge



Parting

Grooving

■ ■ UPR–General application and Turning

- ▲ Insert for radius grooves
- ▲ For copy turning
- ▲ Suitable for all steel and cast iron materials



Grooving

Turning

NEW

■ UMR–General application and Turning

- ▲ Especially for stainless steel materials



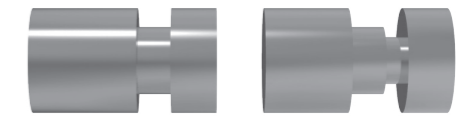
Grooving

Turning

UA

■ ■ UUT–Grooving and Turning

- ▲ For grooving and turning
- ▲ Suitable for all steel and stainless steel materials
- ▲ Very good chip control

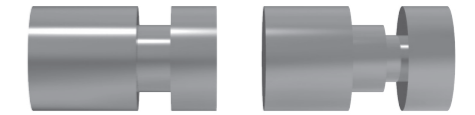


Grooving

Turning

■ ■ UPR–General application and Turning

- ▲ Insert for radius grooves
- ▲ For copy turning
- ▲ Suitable for all steel and cast iron materials



Grooving

Turning

Application

UD/UJ/UA

Material Group	Choice chipbreaker		Grades	
	First choice	First choice	Higher wear resistance	Higher toughness
Steel	UPP-UUP	MUP13	MUCP32	MUPP34
	UUT-UPR	MUP13		
Stainless steel	UMP-UUP - UUT-UMR	MUP13		MUPP34
Cast iron	UPP	MUP13	MUCP32	MUPP34
	UPR	MUP13		
Exotic	UMP	MUPP34		
Non-ferrous metals	UNT	MUN15-		

US

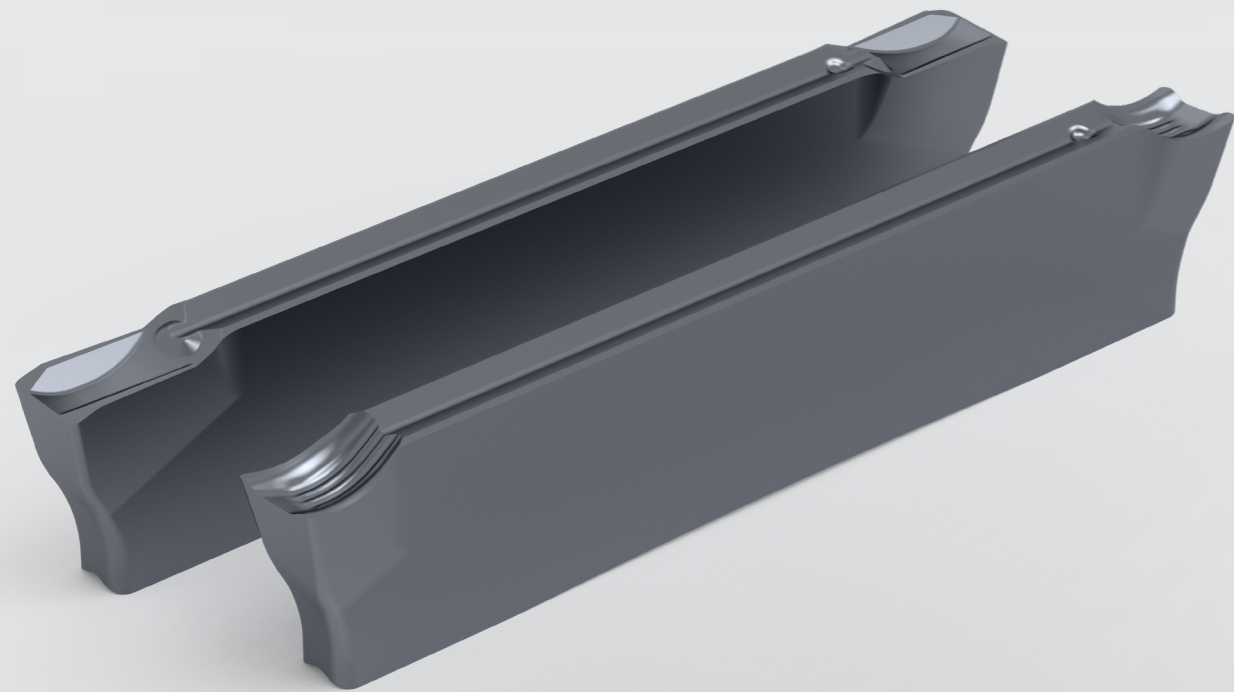
Material Group	Choice chipbreaker		Grades	
	First choice	First choice	Higher wear resistance	Higher toughness
Steel	UPP-UUT-UPR	MUP13	MUCP32	MUPP34
Stainless steel	UMP-UMR	MUP13		MUPP34
Cast iron	UPP-UUT	MUP13		MUPP34
Non-ferrous metals	UNT	MUN15-		

Inserts



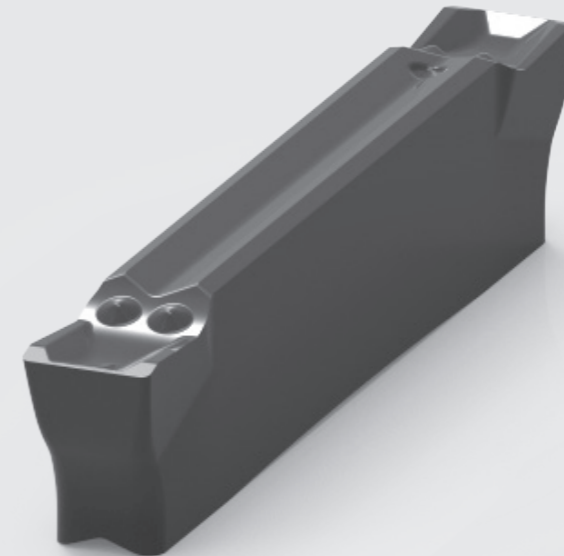
UD

Double-sided
















UPP

1.5-8



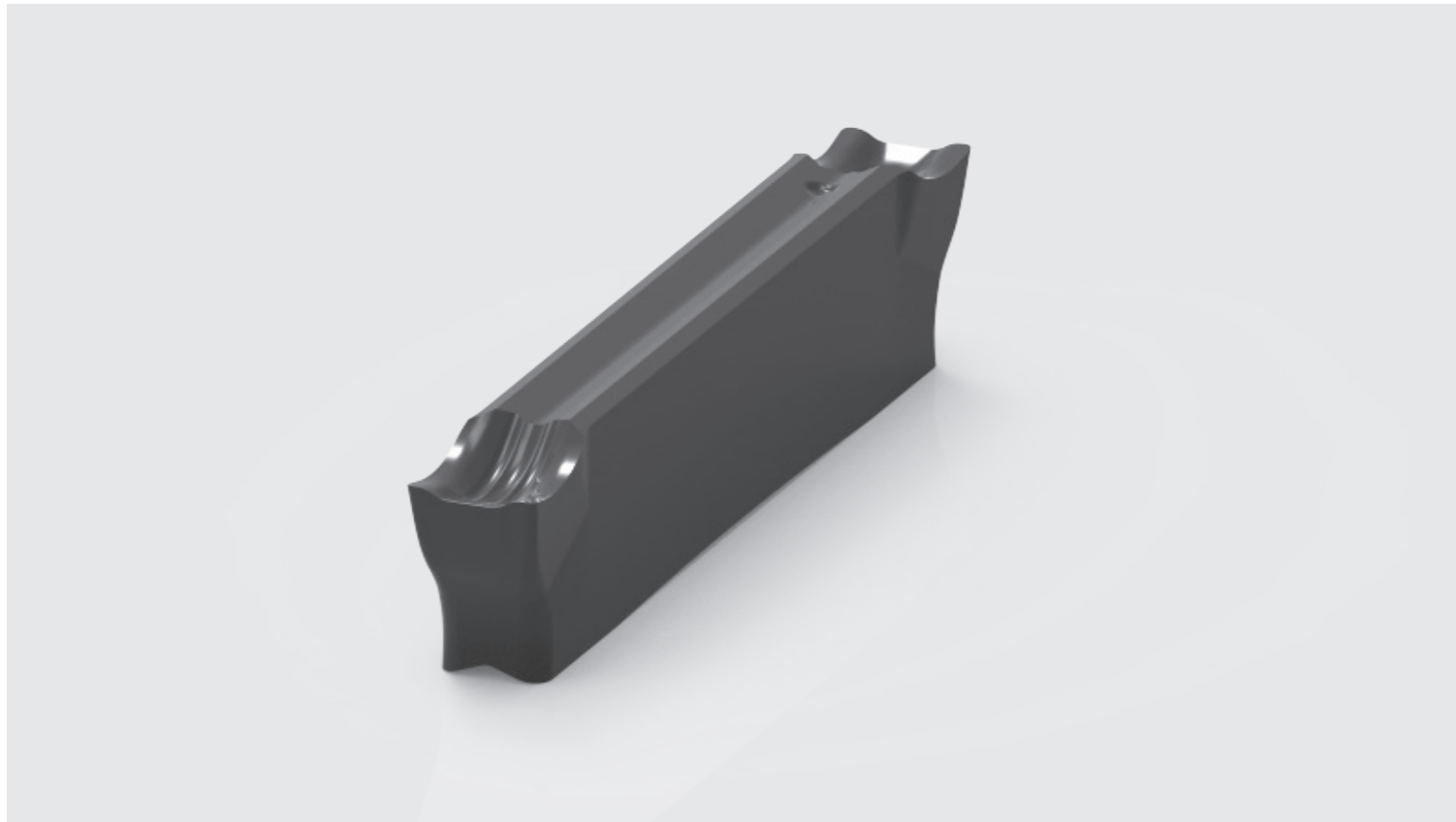
UD-UPP

Insert	NEW	Designation	Available
1.5		UD24-N-15.015N-T-UPP MUCP32	○
		UD24-N-15.015N-T-UPP MUP13	●
		UD24-N-15.015N-T-UPP MUPP34	●
2.0		UD24-L-20.015P-T-UPP MUCP32	○
		UD24-L-20.015P-T-UPP MUP13	●
		UD24-L-20.015P-T-UPP MUPP34	●
		UD24-N-20.02N-T-UPP MUCP32	●
		UD24-N-20.02N-T-UPP MUP13	●
		UD24-N-20.02N-T-UPP MUPP34	●
	UD24-R-20.015P-T-UPP MUCP32	○	
	UD24-R-20.015P-T-UPP MUP13	●	
	UD24-R-20.015P-T-UPP MUPP34	●	
3.0		UD24-L-30.02P-T-UPP MUCP32	○
		UD24-L-30.02P-T-UPP MUP13	●
		UD24-L-30.02P-T-UPP MUPP34	●
		UD24-N-30.02N-T-UPP MUCP32	●
		UD24-N-30.02N-T-UPP MUP13	●
		UD24-N-30.02N-T-UPP MUPP34	●
	UD24-R-30.02P-T-UPP MUCP32	○	
	UD24-R-30.02P-T-UPP MUP13	●	
	UD24-R-30.02P-T-UPP MUPP34	●	

Insert	Designation	Available	
	UD24-L-40.03P-T-UPP MUCP32	○	
	UD24-L-40.03P-T-UPP MUP13	●	
	UD24-L-40.03P-T-UPP MUPP34	●	
4.0		UD24-N-40.03N-T-UPP MUCP32	●
		UD24-N-40.03N-T-UPP MUP13	●
		UD24-N-40.03N-T-UPP MUPP34	●
	UD24-R-40.03P-T-UPP MUCP32	○	
	UD24-R-40.03P-T-UPP MUP13	●	
	UD24-R-40.03P-T-UPP MUPP34	●	
5.0		UD24-N-50.04N-T-UPP MUCP32	●
		UD24-N-50.04N-T-UPP MUP13	●
		UD24-N-50.04N-T-UPP MUPP34	●
6.0		UD24-N-60.04N-T-UPP MUCP32	○
		UD24-N-60.04N-T-UPP MUP13	●
		UD24-N-60.04N-T-UPP MUPP34	●
8.0		UD35-N-80.08N-T-UPP MUP13	●

UUP

2-5



UD - UUP





Insert	Designation	Available
	UD24-L-20.015P-T-UUP MUCP32	○
	UD24-L-20.015P-T-UUP MUP13	●
	UD24-L-20.015P-T-UUP MUPP34	●
2.0	UD24-N-20.02N-T-UUP MUCP32	○
	UD24-N-20.02N-T-UUP MUP13	●
	UD24-N-20.02N-T-UUP MUPP34	●
	UD24-R-20.015P-T-UUP MUCP32	○
	UD24-R-20.015P-T-UUP MUP13	●
	UD24-R-20.015P-T-UUP MUPP34	●
3.0	UD24-L-30.02P-T-UUP MUCP32	○
	UD24-L-30.02P-T-UUP MUP13	●
	UD24-L-30.02P-T-UUP MUPP34	●
	UD24-N-30.02N-T-UUP MUCP32	○
	UD24-N-30.02N-T-UUP MUP13	●
	UD24-N-30.02N-T-UUP MUPP34	●
	UD24-R-30.02P-T-UUP MUCP32	○
	UD24-R-30.02P-T-UUP MUP13	●
	UD24-R-30.02P-T-UUP MUPP34	●
4.0	UD24-L-40.03P-T-UUP MUCP32	○
	UD24-L-40.03P-T-UUP MUP13	●
	UD24-L-40.03P-T-UUP MUPP34	●
	UD24-N-40.03N-T-UUP MUCP32	○
	UD24-N-40.03N-T-UUP MUP13	●
	UD24-N-40.03N-T-UUP MUPP34	●
	UD24-R-40.03P-T-UUP MUCP32	○
	UD24-R-40.03P-T-UUP MUP13	●
	UD24-R-40.03P-T-UUP MUPP34	●
5.0	UD24-N-50.04N-T-UUP MUCP32	○
	UD24-N-50.04N-T-UUP MUP13	○
	UD24-N-50.04N-T-UUP MUPP34	●

UMP

1.5-6



UD - UMP

Insert	Designation	Available
1.5 	UD24-N-15.015N-T-UMP MUCP32	●
	UD24-N-15.015N-T-UMP MUP13	●
	UD24-N-15.015N-T-UMP MUPP34	●
2.0 	UD24-L-20.015P-T-UMP MUCP32	○
	UD24-L-20.015P-T-UMP MUP13	●
	UD24-L-20.015P-T-UMP MUPP34	●
	UD24-N-20.02N-T-UMP MUCP32	○
	UD24-N-20.02N-T-UMP MUP13	●
	UD24-N-20.02N-T-UMP MUPP34	●
2.0 	UD24-R-20.015P-T-UMP MUCP32	○
	UD24-R-20.015P-T-UMP MUP13	●
	UD24-R-20.015P-T-UMP MUPP34	●
3.0 	UD24-L-30.02P-T-UMP MUCP32	○
	UD24-L-30.02P-T-UMP MUP13	●
	UD24-L-30.02P-T-UMP MUPP34	●
	UD24-N-30.02N-T-UMP MUCP32	○
	UD24-N-30.02N-T-UMP MUP13	●
	UD24-N-30.02N-T-UMP MUPP34	●
	UD24-R-30.02P-T-UMP MUCP32	○
	UD24-R-30.02P-T-UMP MUP13	●
	UD24-R-30.02P-T-UMP MUPP34	●







Insert	Designation	Available
4.0	UD24-L-40.03P-T-UMP MUCP32	○
	UD24-L-40.03P-T-UMP MUP13	●
	UD24-L-40.03P-T-UMP MUPP34	●
	UD24-N-40.04N-T-UMP MUCP32	○
	UD24-N-40.04N-T-UMP MUP13	●
	UD24-N-40.04N-T-UMP MUPP34	●
	UD24-R-40.03P-T-UMP MUCP32	○
	UD24-R-40.03P-T-UMP MUP13	●
	UD24-R-40.03P-T-UMP MUPP34	●
5.0	UD24-N-50.04N-T-UMP MUCP32	○
	UD24-N-50.04N-T-UMP MUP13	●
	UD24-N-50.04N-T-UMP MUPP34	●
6.0	UD24-N-60.04N-T-UMP MUCP32	○
	UD24-N-60.04N-T-UMP MUP13	●
	UD24-N-60.04N-T-UMP MUPP34	●




UUT

2-6



UD - UUT

Insert	Designation	Available
	UD24-L-20.02P-T-UUT MUCP32	○
	UD24-L-20.02P-T-UUT MUP13	●
	UD24-L-20.02P-T-UUT MUPP34	●
2.0 	UD24-N-20.02N-T-UUT MUCP32	○
	UD24-N-20.02N-T-UUT MUP13	●
	UD24-N-20.02N-T-UUT MUPP34	●
	UD24-R-20.02P-T-UUT MUCP32	○
	UD24-R-20.02P-T-UUT MUP13	●
	UD24-R-20.02P-T-UUT MUPP34	●
	UD24-L-30.02P-T-UUT MUCP32	○
	UD24-L-30.02P-T-UUT MUP13	●
	UD24-L-30.02P-T-UUT MUPP34	●
3.0 	UD24-N-30.03N-T-UUT MUCP32	○
	UD24-N-30.03N-T-UUT MUP13	●
	UD24-N-30.03N-T-UUT MUPP34	●
	UD24-R-30.02P-T-UUT MUCP32	○
	UD24-R-30.02P-T-UUT MUP13	●
	UD24-R-30.02P-T-UUT MUPP34	●






Insert	Designation	Available
4.0 	UD24-N-40.04N-T-UUT MUCP32	●
	UD24-N-40.04N-T-UUT MUP13	●
	UD24-N-40.04N-T-UUT MUPP34	●
5.0 	UD24-N-50.04N-T-UUT MUCP32	○
	UD24-N-50.04N-T-UUT MUP13	●
	UD24-N-50.04N-T-UUT MUPP34	●
6.0 	UD24-N-60.04N-T-UUT MUCP32	○
	UD24-N-60.04N-T-UUT MUP13	●
	UD24-N-60.04N-T-UUT MUPP34	●

UPR

2-6



UD – UPR

Insert	Designation	Available
2.0 	UD24-N-20.00N-R-UPR MUCP32	○
	UD24-N-20.00N-R-UPR MUP13	●
	UD24-N-20.00N-R-UPR MUPP34	●
3.0 	UD24-N-30.00N-R-UPR MUCP32	●
	UD24-N-30.00N-R-UPR MUP13	●
	UD24-N-30.00N-R-UPR MUPP34	●
4.0 	UD24-N-40.00N-R-UPR MUCP32	●
	UD24-N-40.00N-R-UPR MUP13	●
	UD24-N-40.00N-R-UPR MUPP34	●
5.0 	UD24-N-50.00N-R-UPR MUCP32	○
	UD24-N-50.00N-R-UPR MUP13	●
	UD24-N-50.00N-R-UPR MUPP34	●
6.0 	UD24-N-60.00N-R-UPR MUCP32	○
	UD24-N-60.00N-R-UPR MUP13	●
	UD24-N-60.00N-R-UPR MUPP34	●

UMR

2-6



UD – UMR


Insert	Designation	Available
2.0 	UD24-N-20.00N-R-UMR MUP13	●
3.0 	UD24-N-30.00N-R-UMR MUP13	●
4.0 	UD24-N-40.00N-R-UMR MUP13	●
5.0 	UD24-N-50.00N-R-UMR MUP13	●
6.0 	UD24-N-60.00N-R-UMR MUP13	●

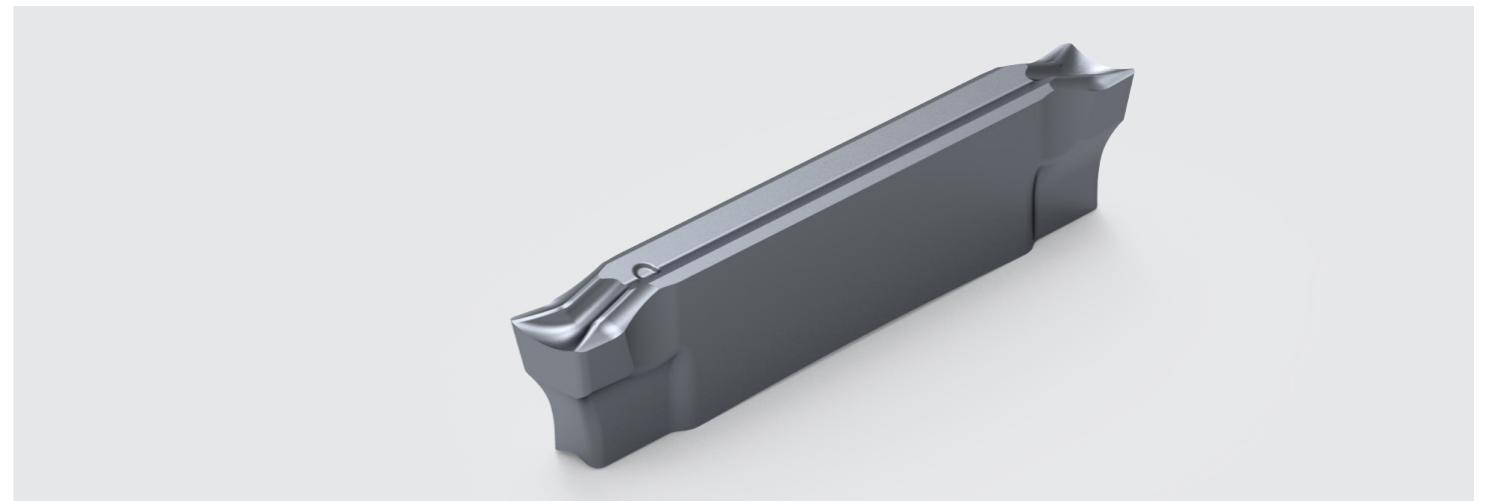
UNT

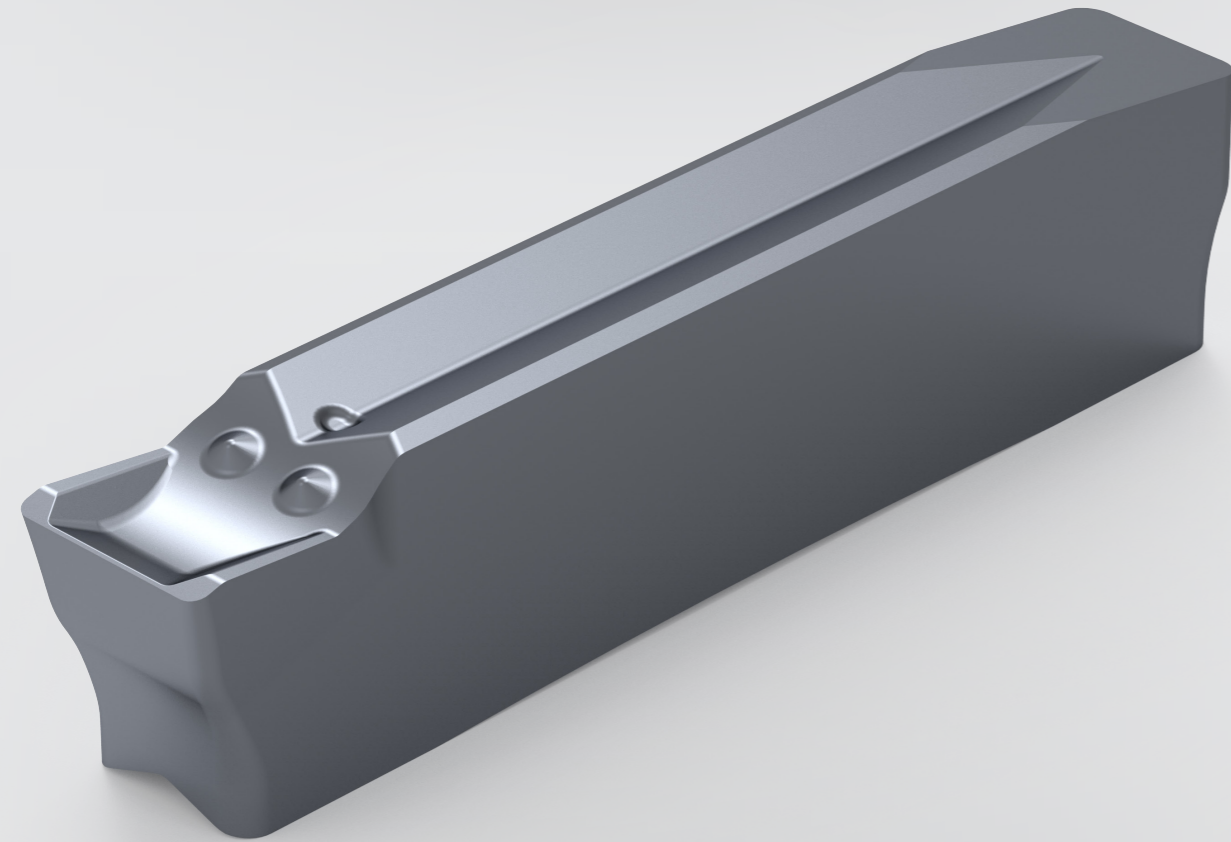
2-6



UD – UNT

Insert	Designation	Available
	UD24-N-20.02N-T-UNT MUN15-	●
	UD24-N-30.03N-T-UNT MUN15-	●
	UD24-N-40.04N-T-UNT MUN15-	●
	UD24-N-50.04N-T-UNT MUN15-	●
	UD24-N-60.05N-T-UNT MUN15-	●





UJ

Single-sided

UPP

2-4

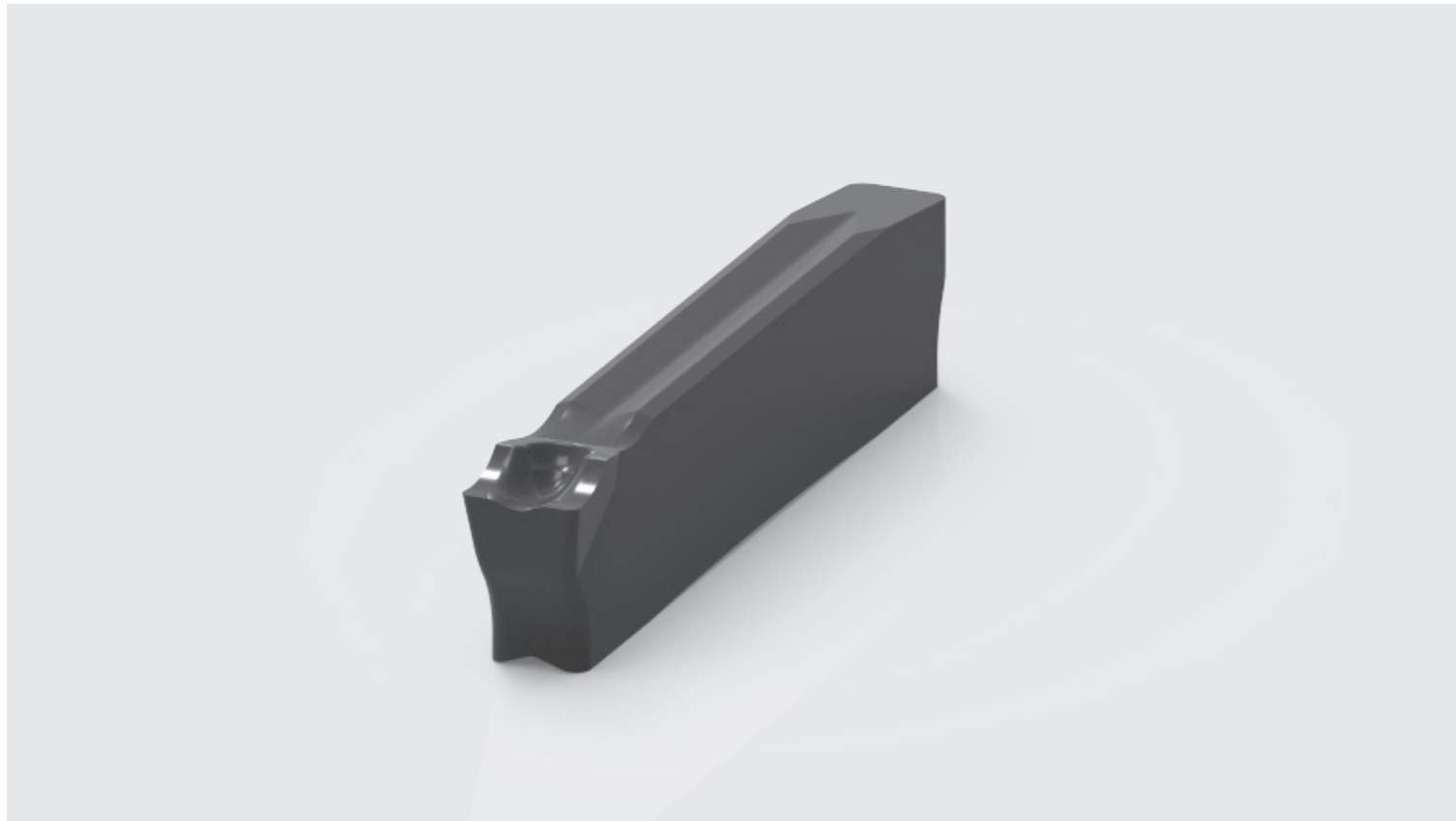


UJ - UPP




Insert	Designation	Available
2.0 	UJ24-N-20.02N-T-UPP MUCP32	○
	UJ24-N-20.02N-T-UPP MUP13	●
	UJ24-N-20.02N-T-UPP MUPP34	●
3.0 	UJ24-L-30.02P-T-UPP MUCP32	○
	UJ24-L-30.02P-T-UPP MUP13	●
	UJ24-L-30.02P-T-UPP MUPP34	●
3.0 	UJ24-N-30.02N-T-UPP MUCP32	○
	UJ24-N-30.02N-T-UPP MUP13	●
	UJ24-N-30.02N-T-UPP MUPP34	●
3.0 	UJ24-R-30.02P-T-UPP MUCP32	○
	UJ24-R-30.02P-T-UPP MUP13	●
	UJ24-R-30.02P-T-UPP MUPP34	●
4.0 	UJ24-N-40.03N-T-UPP MUCP32	○
	UJ24-N-40.03N-T-UPP MUP13	●
	UJ24-N-40.03N-T-UPP MUPP34	●

UMP

2-4

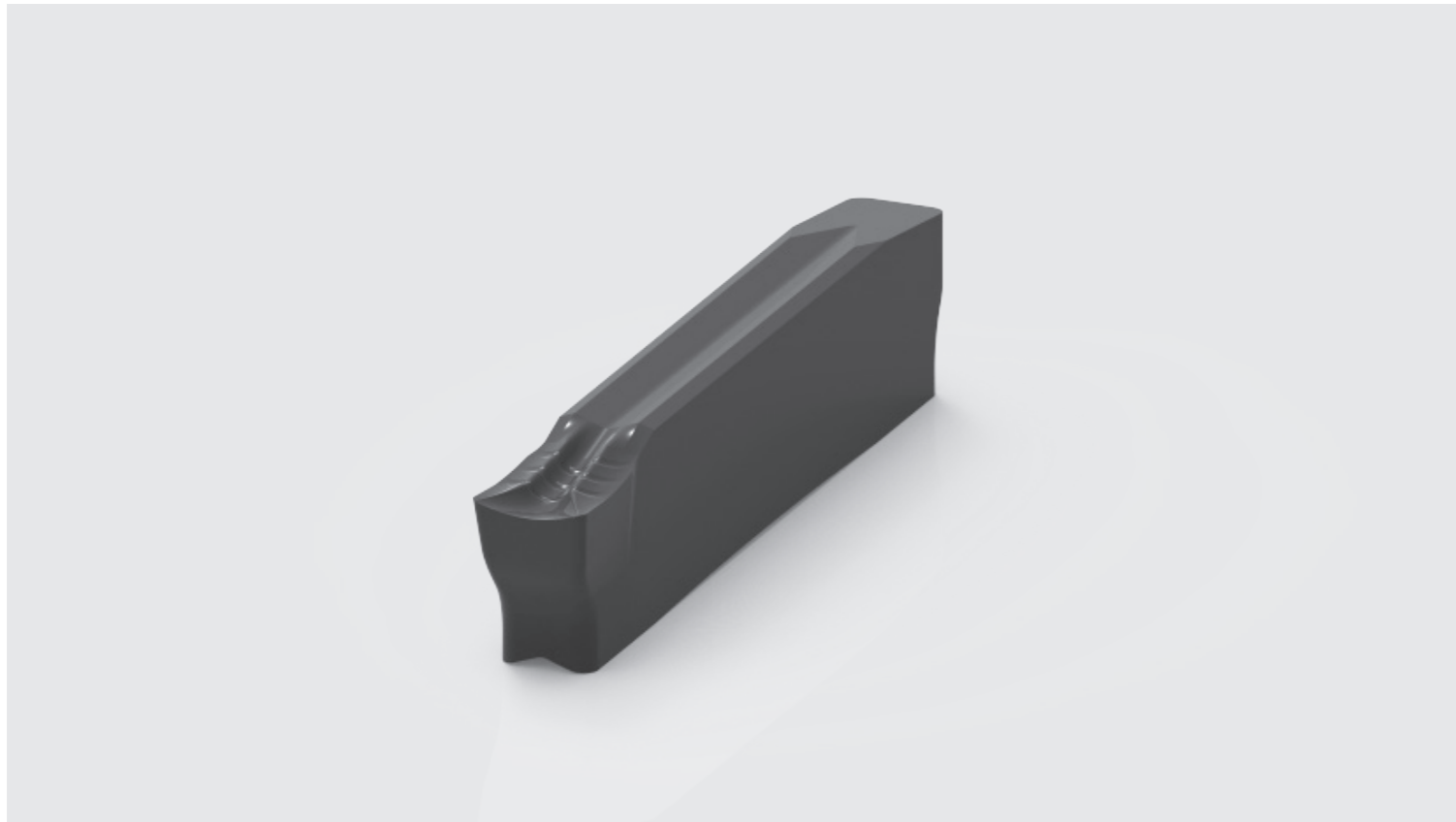


UJ - UMP




Insert	Designation	Available
2.0 	UJ24-N-20.02N-T-UMP MUCP32	○
	UJ24-N-20.02N-T-UMP MUP13	●
	UJ24-N-20.02N-T-UMP MUPP34	●
3.0 	UJ24-N-30.03N-T-UMP MUCP32	○
	UJ24-N-30.03N-T-UMP MUP13	●
	UJ24-N-30.03N-T-UMP MUPP34	●
4.0 	UJ24-N-40.04N-T-UMP MUCP32	○
	UJ24-N-40.04N-T-UMP MUP13	●
	UJ24-N-40.04N-T-UMP MUPP34	●

UUT

2-4



UJ – UUT


Insert	Designation	Available
2.0 	UJ24-N-20.02N-T-UUT MUCP32	○
	UJ24-N-20.02N-T-UUT MUP13	●
	UJ24-N-20.02N-T-UUT MUPP34	●
3.0 	UJ24-N-30.03N-T-UUTMUCP32	○
	UJ24-N-30.03N-T-UUT MUP13	●
	UJ24-N-30.03N-T-UUT MUPP34	●
4.0 	UJ24-N-40.04N-T-UUT MUCP32	○
	UJ24-N-40.04N-T-UUT	●
	UJ24-N-40.04N-T-UUT MUPP34	●

UNT



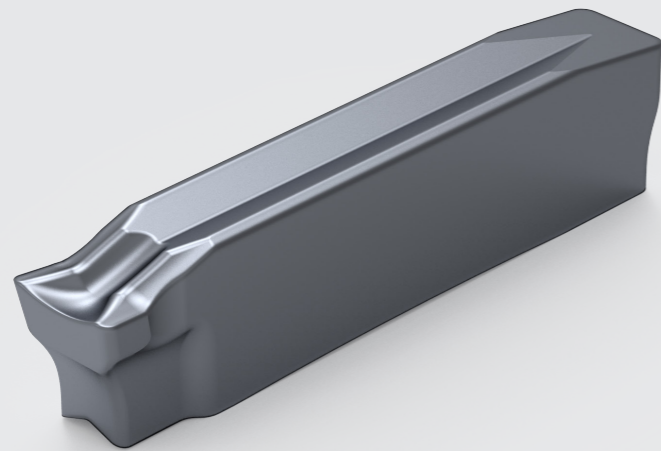
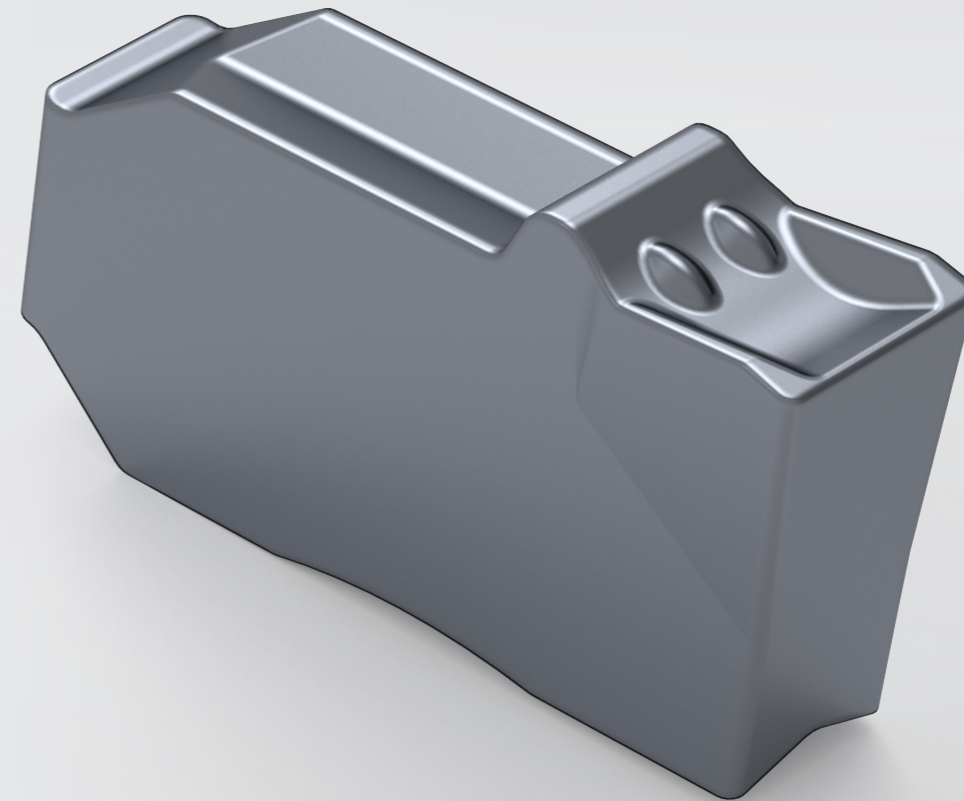
2-6

UJ - UNT

Insert	Designation	Available
2.0	UJ24-N-20.02N-T-UNT MUN15-	●
3.0	UJ24-N-30.03N-T-UNT MUN15-	●
4.0 	UJ24-N-40.04N-T-UNT MUN15-	●
5.0	UJ24-N-50.04N-T-UNT MUN15-	●
6.0	UJ24-N-60.05N-T-UNT MUN15-	●

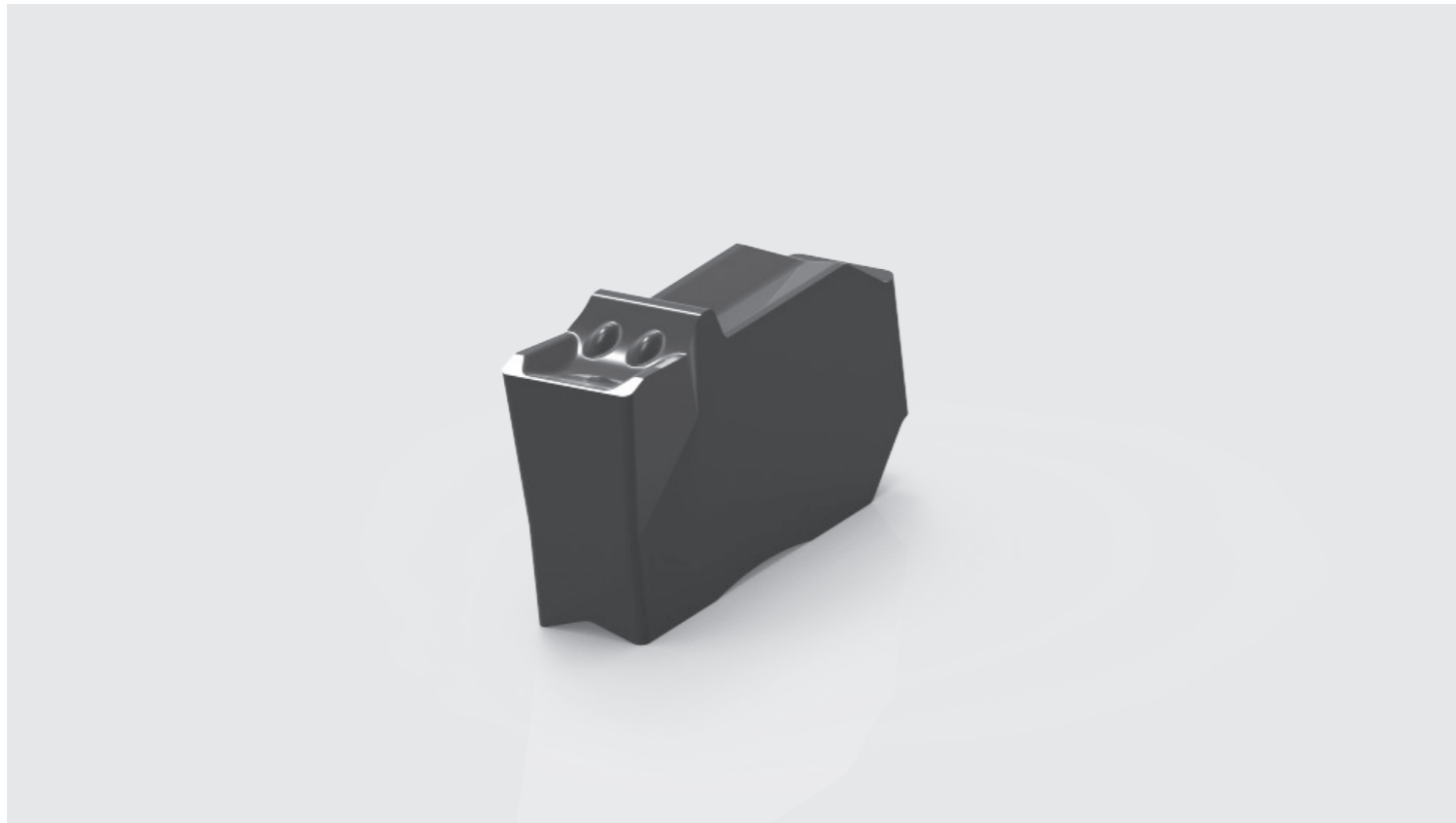
US

Small size insert







UPP

2-6



US - UPP






Insert	Designation	Available
2.0 	US-N-20.02N-T-UPR MUCP32	○
	US-N-20.02N-T-UPR MUP13	●
	US-N-20.02N-T-UPR MUPP34	●
3.0 	US-N-30.02N-T-UPP MUCP32	●
	US-N-30.02N-T-UPP MUP13	●
	US-N-30.02N-T-UPP MUPP34	●
4.0 	US-N-40.03N-T-UPP MUCP32	○
	US-N-40.03N-T-UPP MUP13	●
	US-N-40.03N-T-UPP MUPP34	●
5.0 	US-N-50.03N-T-UPP MUP13	○
	US-N-50.03N-T-UPP MUCP32	●
	US-N-50.03N-T-UPP MUPP34	●
6.0 	US-N-60.04N-T-UPP MUCP32	○
	US-N-60.04N-T-UPP MUP13	●
	US-N-60.04N-T-UPP MUPP34	●

UUT

2-6



US - UUT






Insert	Designation	Available
2.0 	US-N-20.02N-T-UUT MUCP32	○
	US-N-20.02N-T-UUT MUP13	●
	US-N-20.02N-T-UUT MUPP34	●
3.0 	US-N-30.03N-T-UUT MUCP32	○
	US-N-30.03N-T-UUT MUP13	●
	US-N-30.03N-T-UUT MUPP34	●
4.0 	US-N-40.04N-T-UUT MUCP32	○
	US-N-40.04N-T-UUT MUP13	●
	US-N-40.04N-T-UUT MUPP34	●
5.0 	US-N-50.04N-T-UUT MUCP32	○
	US-N-50.04N-T-UUT MUP13	●
	US-N-50.04N-T-UUT MUPP34	●
6.0 	US-N-60.05N-T-UUT MUCP32	○
	US-N-60.05N-T-UUT MUP13	●
	US-N-60.05N-T-UUT MUPP34	●

UMP

2-6



US - UMP

Insert	Designation	Available
2.0 	US-N-20.02N-T-UMP MUCP32	○
	US-N-20.02N-T-UMP MUP13	●
	US-N-20.02N-T-UMP MUPP34	●
3.0 	US-N-30.02N-T-UMP MUCP32	○
	US-N-30.02N-T-UMP MUP13	●
	US-N-30.02N-T-UMP MUPP34	●
4.0 	US-N-40.04N-T-UMP MUCP32	○
	US-N-40.04N-T-UMP MUP13	●
	US-N-40.04N-T-UMP MUPP34	●
5.0 	US-N-50.04N-T-UMP MUCP32	○
	US-N-50.04N-T-UMP MUP13	●
	US-N-50.04N-T-UMP MUPP34	●
6.0 	US-N-60.04N-T-UMP MUCP32	○
	US-N-60.04N-T-UMP MUP13	●
	US-N-60.04N-T-UMP MUPP34	●

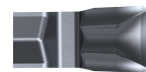
UNT

2-6



US - UNT

Insert	Designation	Available
2.0	US-N-20.02N-T-UNT MUN15-	●
3.0	US-N-30.03N-T-UNT MUN15-	●
4.0	US-N-40.04N-T-UNT MUN15-	●
5.0	US-N-50.04N-T-UNT MUN15-	●
6.0	US-N-60.04N-T-UNT MUN15-	●



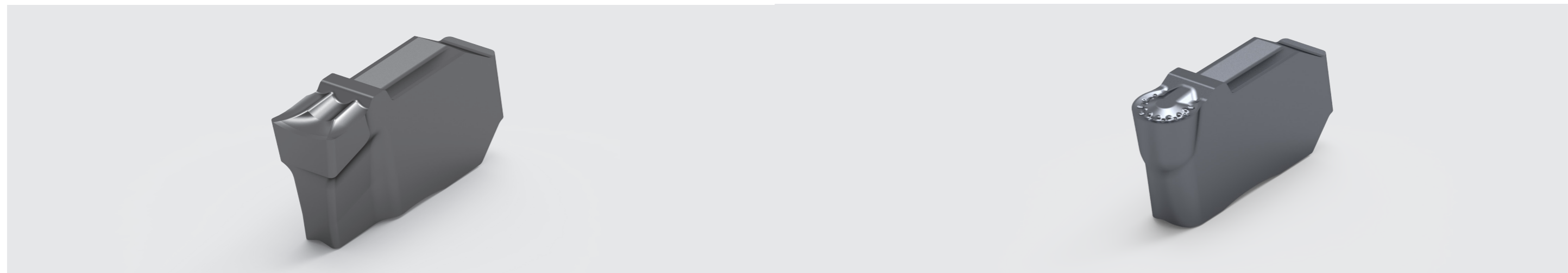
UPR

2-6



US - UPR

Insert	Designation	Available
2.0	US-N-20.00N-R-UPR MUP13	●
3.0	US-N-30.00N-R-UPR MUP13	●
4.0	US-N-40.00N-R-UPR MUP13	●
5.0	US-N-50.00N-R-UPR MUP13	●
6.0	US-N-60.00N-R-UPR MUP13	●



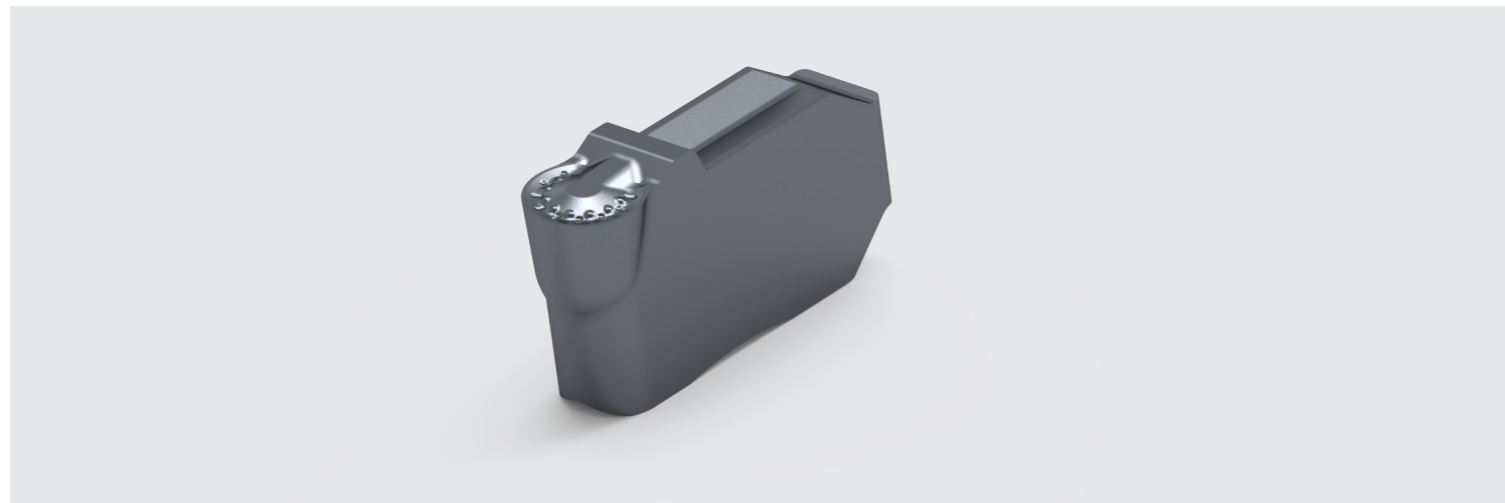
UMR

2-6



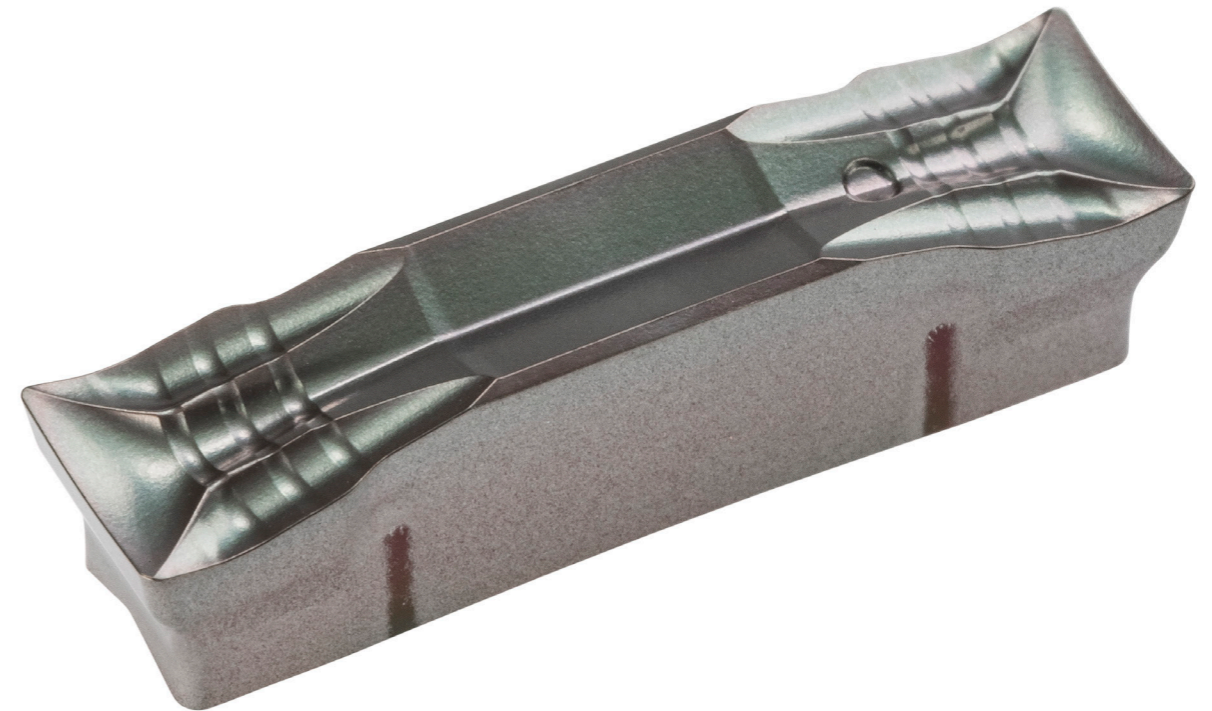
US - UMR

Insert	Designation	Available
2.0	US-N-20.00N-R-UMR MUP13	●
3.0	US-N-30.00N-R-UMR MUP13	●
4.0	US-N-40.00N-R-UMR MUP13	●
5.0	US-N-50.00N-R-UMR MUP13	●
6.0	US-N-60.00N-R-UMR MUP13	●



UA

Axial grooving






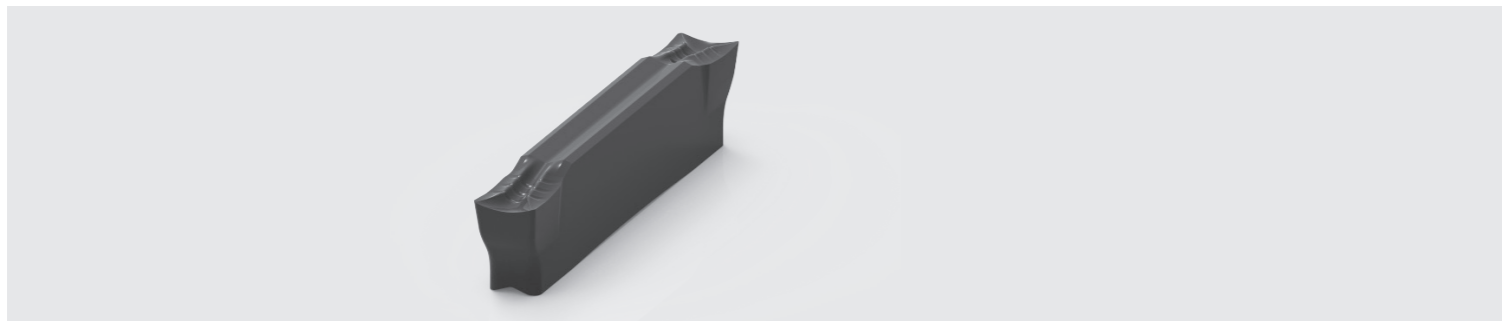
UUT

3-5



UA - UUT

Insert	Designation	Available
3.0 	UA24-N-30.03N-T-UUT MUCP32	○
	UA24-N-30.03N-T-UUT MUP13	●
	UA24-N-30.03N-T-UUT MUPP34	●
4.0 	UA24-N-40.04N-T-UUT MUCP32	○
	UA24-N-40.04N-T-UUT MUP13	●
	UA24-N-40.04N-T-UUT MUPP34	●
5.0 	UA24-N-50.04N-T-UUT MUCP32	●
	UA24-N-50.04N-T-UUT MUP13	●
	UA24-N-50.04N-T-UUT MUPP34	●





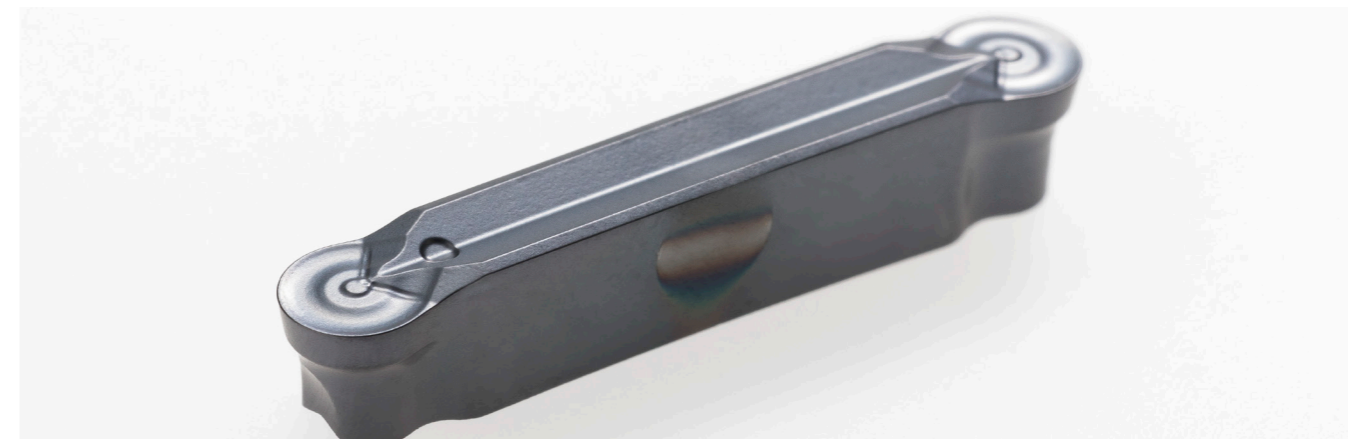
UPR

3-4

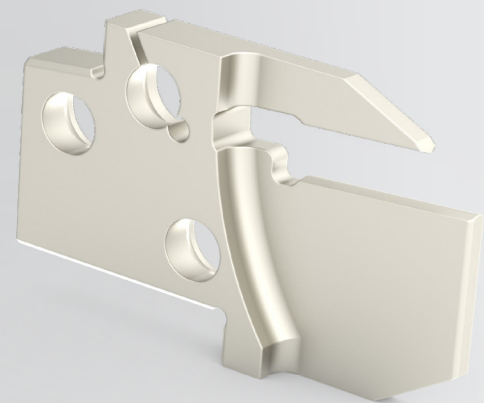


UA - UPR

Insert	Designation	Available
3.0 	UA24-N-30.00N-R-UPR MUCP32	●
	UA24-N-30.00N-R-UPR MUP13	●
	UA24-N-30.00N-R-UPR MUPP34	●
4.0 	UA24-N-40.00N-R-UPR MUCP32	●
	UA24-N-40.00N-R-UPR MUP13	●
	UA24-N-40.00N-R-UPR MUPP34	●



Tools



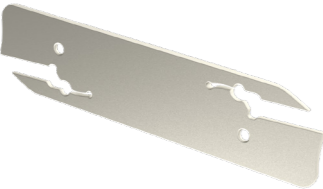
Blade


UJ/UD



Monoblocks

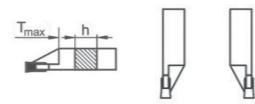
UJ/UD

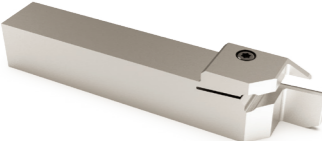
Blades	Designation	T _{max} [mm]	Available
	UP-L2602-UJ2402	25	●
	UP-L3202-UJ2402	25	●
	UP-R2602-UJ2402	25	●
	UP-R3202-UJ2402	25	●
	UP-N2602-UJ2402	25	●
	UP-N3202-UJ2402	25	●
	UP-N2603-UJ2403	35	●
	UP-N3203-UJ2403	50	●
	UP-N2604-UJ2404	35	●
	UP-N3204-UJ2404	50	●
	UP-N3205-UJ2405	60	●
	UP-N3206-UJ2406	60	●

Spare parts *	Designation	Available
	GK-2-3 (2 and 3 mm)	●
	GK-4-5-6-5-6 (4, 5 and 6 mm)	●

For information on how to use the system go to page 98.





Tool	Designation	T _{max} [mm]	h	Available
	UDM-EL12-UD24-02-K-13	13	12	L ●
	UDM-ER12-UD24-02-K-13	13	12	R ●
	UDM-EL16-UD24-02-K-13	13	16	L ●
	UDM-ER16-UD24-02-K-13	13	16	R ●
	UDM-EL20-UD24-02-K-13	13	20	L ●
	UDM-ER20-UD24-02-K-13	13	20	R ●
	UDM-EL12-UD24-015-K-23	23	12	L ●
	UDM-ER12-UD24-015-K-23	23	12	R ●
	UDM-EL16-UD24-015-K-23	23	16	L ●
	UDM-ER16-UD24-015-K-23	23	16	R ●

Spare parts

Designation

Key T15

Key T20

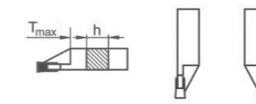
Key SW4

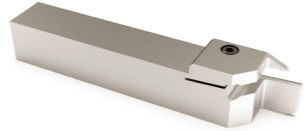
M3.5X14,0/T15 (for h=12)

M4.0X16/T20 (for h=16)

M4.0X18/T20 (for h=20)

M5.0X20



Tool	Designation	T _{max} [mm]	h	Available
	UDM-EL12-UD24-03-K-13	13	12	L ●
	UDM-ER12-UD24-03-K-13	13	12	R ●
	UDM-EL16-UD24-03-K-13	13	16	L ●
	UDM-ER16-UD24-03-K-13	13	16	R ●
	UDM-EL20-UD24-03-K-13	13	20	L ●
	UDM-ER20-UD24-03-K-13	13	20	R ●
	UDM-EL25-UD24-03-K-13	13	25	L ●
	UDM-ER25-UD24-03-K-13	13	25	R ●
	UDM-EL16-UD24-03-K-25	25	16	L ●
	UDM-ER16-UD24-03-K-25	25	16	R ●
	UDM-EL20-UD24-03-K-25	25	20	L ●
	UDM-ER20-UD24-03-K-25	25	20	R ●
	UDM-EL25-UD24-03-K-25	25	25	L ●
	UDM-ER25-UD24-03-K-25	25	25	R ●
	UDM-EL32-UD24-03-P-25	25	32	L ●
	UDM-ER32-UD24-03-P-25	25	32	R ●
	UDM-EL40-UD24-03-S-25	25	40	L ●
	UDM-ER40-UD24-03-S-25	25	40	R ●

Spare parts

Designation

Key T15

Key T20

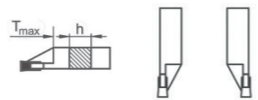
M3.5X14.0/T15 (for h=12)

M4.0X16/T20 (for h=16)

M4.0X18/T20 (for h=20/25)

Blades UJ/UD

with internal cooling



Tool	Designation	T _{max} [mm]	h		Available
	UDM-EL16-UD24-04-K-25	25	16	L	●
	UDM-ER16-UD24-04-K-25	25	16	R	●
	UDM-EL20-UD24-04-K-25	25	20	L	●
	UDM-ER20-UD24-04-K-25	25	20	R	●
	UDM-EL25-UD24-04-K-25	25	25	L	●
	UDM-ER25-UD24-04-K-25	25	25	R	●
	UDM-EL32-UD24-04-P-25	25	32	L	●
	UDM-ER32-UD24-04-P-25	25	32	R	●
	UDM-EL40-UD24-04-S-25	25	40	L	●
	UDM-ER40-UD24-04-S-25	25	40	R	●
	UDM-EL20-UD24-05-M-25	25	20	L	●
	UDM-ER20-UD24-05-M-25	25	20	R	●
	UDM-EL25-UD24-05-M-25	25	25	L	●
	UDM-ER25-UD24-05-M-25	25	25	R	●
	UDM-EL20-UD24-06-M-25	25	20	L	●
	UDM-ER20-UD24-06-M-25	25	20	R	●
	UDM-EL25-UD24-06-M-25	25	25	L	●
	UDM-ER25-UD24-06-M-25	25	25	R	●
	UDM-EL25-UD35-08-P-32	32	25	L	●
	UDM-ER25-UD35-08-P-32	32	25	R	●
	UDM-EL32-UD35-08-P-32	32	32	L	●
	UDM-ER32-UD35-08-P-32	32	32	R	●

Spare parts



Designation

Key T20



M4.0X16 T20 (for h=16)

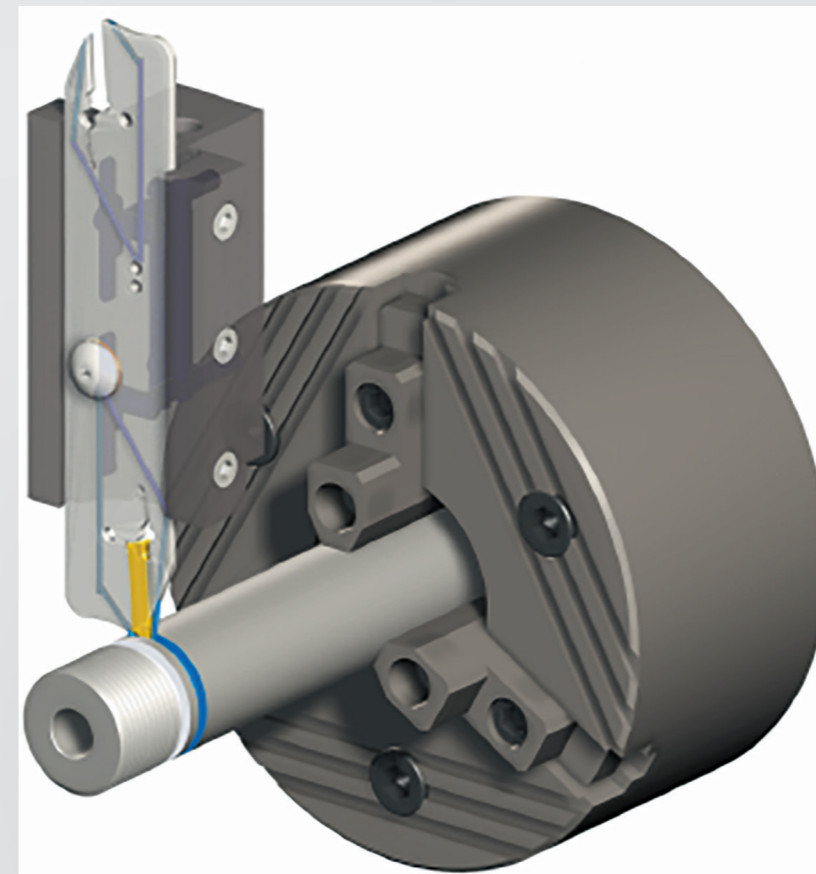














M4.0X18/T20 (for h=20/25)







Key SW5

M6.0X20



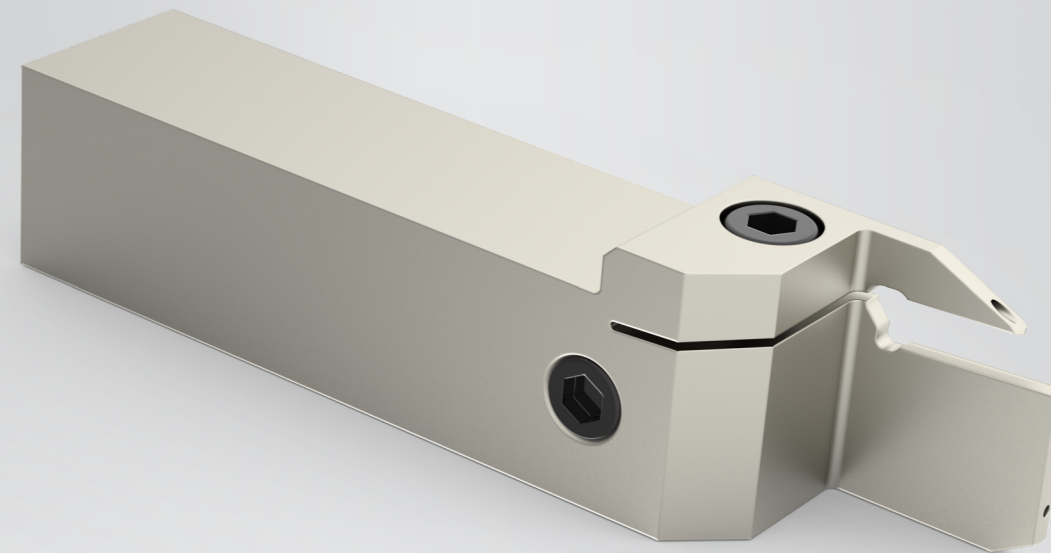
Blades	Designation	T _{max} [mm]	Available
	UP-L2602-UJ2402-C	25	●
	UP-L3202-UJ2402-C	25	●
	UP-R2602-UJ2402-C	25	●
	UP-R3202-UJ2402-C	25	●
	UP-N2602-UJ2402-C	25	●
	UP-N3202-UJ2402-C	25	●
	UP-N2603-UJ2403-C	35	●
	UP-N3203-UJ2403-C	50	●
	UP-N2604-UJ2404-C	35	●
	UP-N3204-UJ2404-C	50	●
	UP-N3205-UJ2405-C	60	●
	UP-N3206-UJ2406-C	60	●

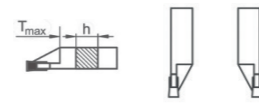
Spare parts	Designation
	Key T15 58MM
	Coolant screw plug M4X3

Spare parts *	Designation
	GK-2-3 (2 and 3 mm)
	GK-4-5-6-5-6 (4, 5 and 6 mm)

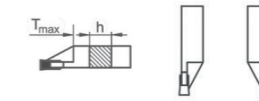
Monoblocks UJ/UD

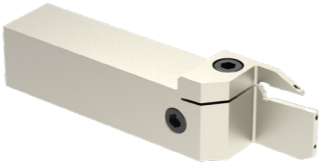
with internal cooling





Tool	Designation	T _{max} [mm]	h		Available
	UDM-EL12-UD24-03-K-13-C	13	12	L	●
	UDM-ER12-UD24-03-K-13-C	13	12	R	●
	UDM-EL16-UD24-02-K-13-C	13	16	L	●
	UDM-ER16-UD24-02-K-13-C	13	16	R	●
	UDM-EL20-UD24-02-K-13-C	13	20	L	●
	UDM-ER20-UD24-02-K-13-C	13	20	R	●
	UDM-EL16-UD24-03-K-25-C	25	16	L	●
	UDM-ER16-UD24-03-K-25-C	25	16	R	●
	UDM-EL20-UD24-03-K-25-C	25	20	L	●
	UDM-ER20-UD24-03-K-25-C	25	20	R	●
	UDM-EL25-UD24-03-K-25-C	25	25	L	●
	UDM-ER25-UD24-03-K-25-C	25	25	R	●
	UDM-EL16-UD24-04-K-25-C	25	16	L	●
	UDM-ER16-UD24-04-K-25-C	25	16	R	●
	UDM-EL20-UD24-04-K-25-C	25	20	L	●
	UDM-ER20-UD24-04-K-25-C	25	20	R	●
	UDM-EL25-UD24-04-K-25-C	25	25	L	●
	UDM-ER25-UD24-04-K-25-C	25	25	R	●
	UDM-EL32-UD24-03-P-25-C	25	32	L	●
	UDM-ER32-UD24-03-P-25-C	25	32	R	●
	UDM-EL32-UD24-04-P-25-C	25	32	L	●
	UDM-ER32-UD24-04-P-25-C	25	32	R	●
	UDM-EL40-UD24-03-S-25-C	25	40	L	●
	UDM-ER40-UD24-03-S-25-C	25	40	R	●
	UDM-EL40-UD24-04-S-25-C	25	40	L	●
	UDM-ER40-UD24-04-S-25-C	25	40	R	●



Tool	Designation	T _{max} [mm]	h		Available
	UDM-EL20-UD24-05-K-C-25	25	20	L	●
	UDM-ER20-UD24-05-K-C-25	25	20	R	●
	UDM-EL20-UD24-06-K-C-25	25	20	L	●
	UDM-ER20-UD24-06-K-C-25	25	20	R	●
	UDM-EL25-UD24-05-M-25-C	25	25	L	●
	UDM-ER25-UD24-05-M-25-C	25	25	R	●
	UDM-EL25-UD24-06-M-25-C	25	25	L	●
	UDM-ER25-UD24-06-M-25-C	25	25	R	●
	UDM-EL40-UD35-08-S-C-32	32	40	L	●
	UDM-ER40-UD35-08-S-C-32	32	40	R	●

Spare parts

Designation



Key SW5



M6.0x20



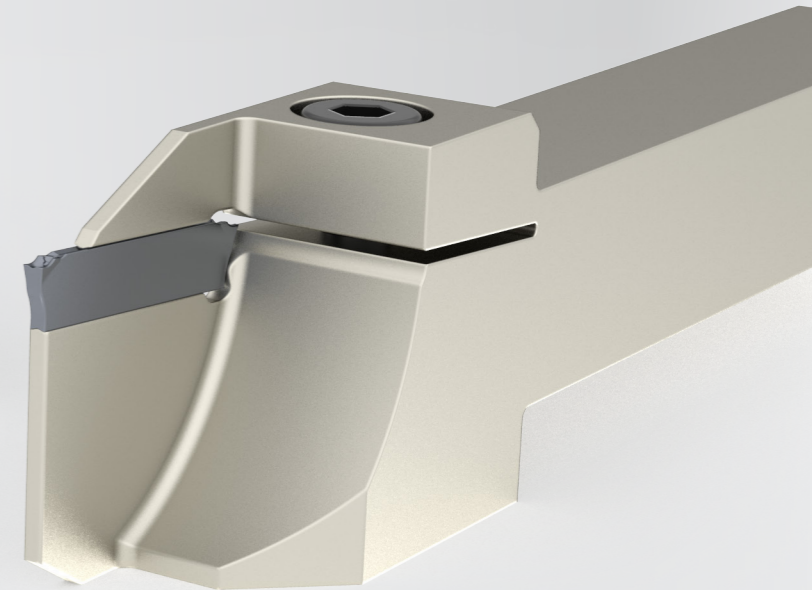
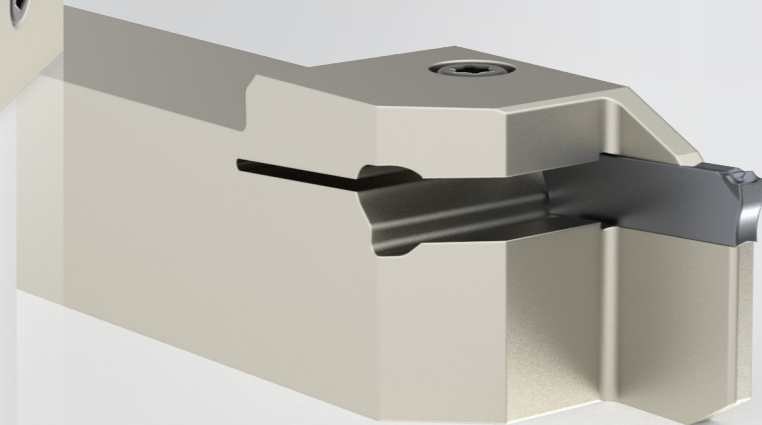
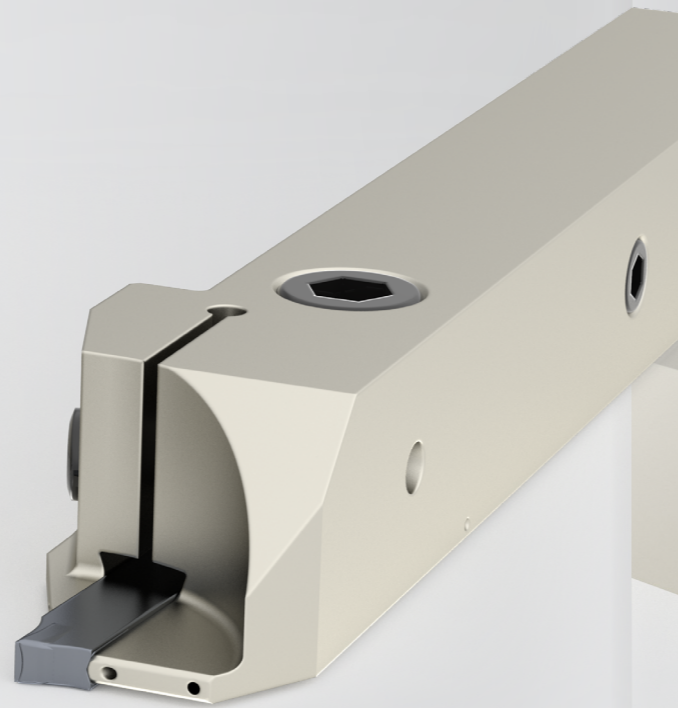
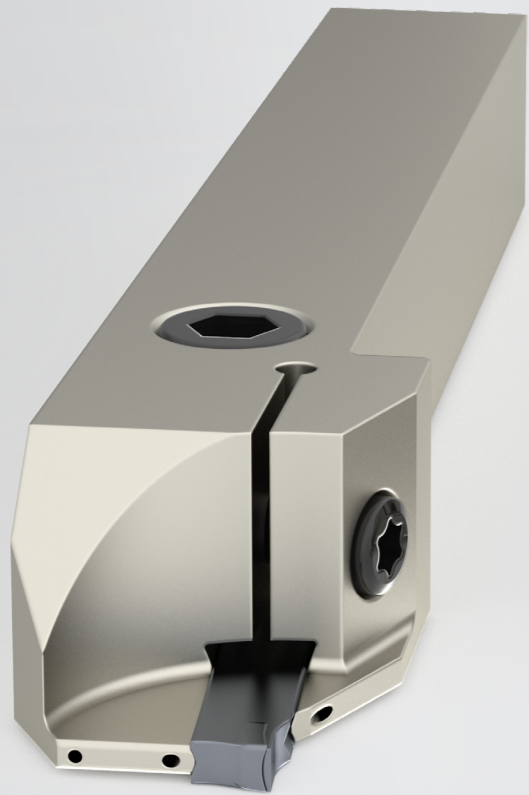
M6x6 DIN 913

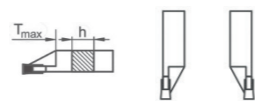


G1/8 DIN 913

Monoblocks UJ/UD



- R (reinforced)





Tool	Designation	T _{max} [mm]	h		Available
	UDM-EL12-UD24-02-K-13-R	13	12	L	●
	UDM-ER12-UD24-02-K-13-R	13		R	●
	UDM-EL16-UD24-02-K-13-R	13	16	L	●
	UDM-ER16-UD24-02-K-13-R	13		R	●
	UDM-EL12-UD24-02-K-21-R	21	12	L	●
	UDM-ER12-UD24-02-K-21-R	21		R	●
	UDM-EL16-UD24-02-K-21-R	21	16	L	●
	UDM-ER16-UD24-02-K-21-R	21		R	●

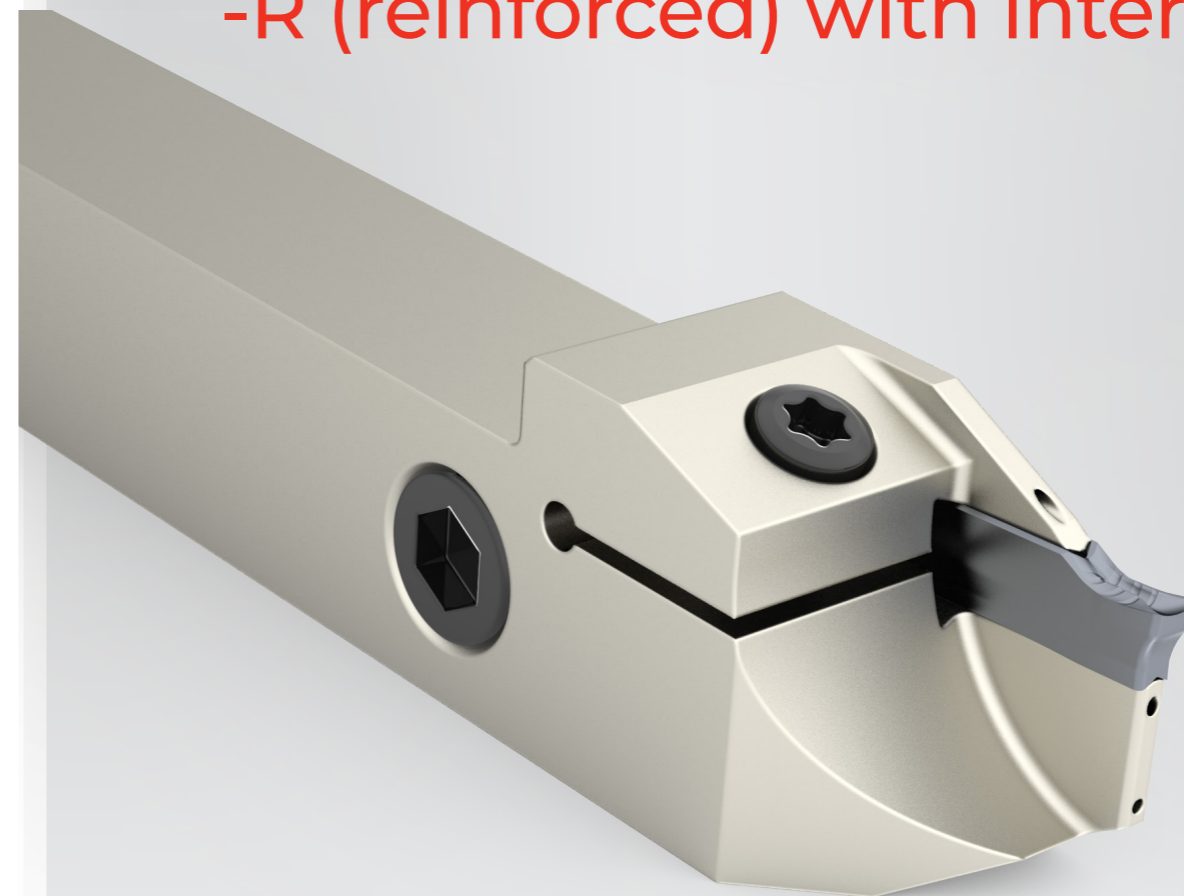


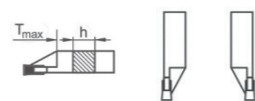
Spare parts	Designation
	Key T15
	M4.0X14/T15

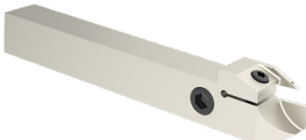
● available from stock, ○ available upon request
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Monoblocks UJ/UD

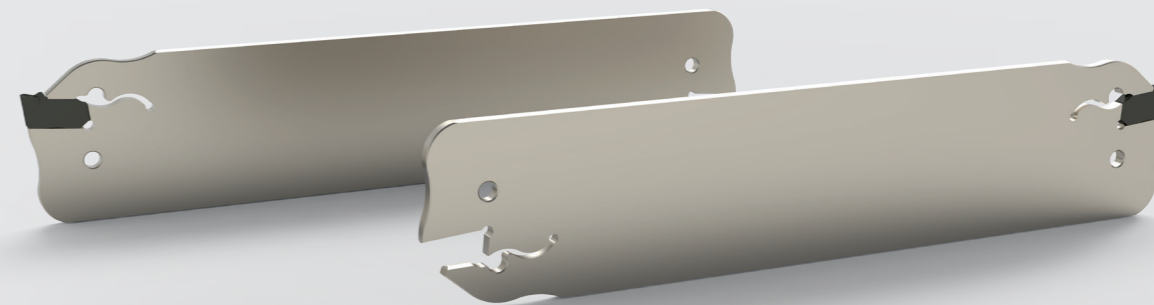
-R (reinforced) with internal cooling





Tool	Designation	T _{max} [mm]	h		Available
	UDM-EL12-UD24-02-K-13-R-C	13	12	L	●
	UDM-ER12-UD24-02-K-13-R-C	13	12	R	●
	UDM-EL16-UD24-02-K-13-R-C	13	16	L	●
	UDM-ER16-UD24-02-K-13-R-C	13	16	R	●
	UDM-EL16-UD24-02-K-21-R-C	21	16	L	●
	UDM-ER16-UD24-02-K-21-R-C	21	16	R	●
	UDM-EL12-UD24-03-K-13-R-C	13	12	L	●
	UDM-ER12-UD24-03-K-13-R-C	13	12	R	●
	UDM-EL16-UD24-03-K-13-R-C	13	16	L	●
	UDM-ER16-UD24-03-K-13-R-C	13	16	R	●
	UDM-EL16-UD24-03-K-21-R-C	21	16	L	●
	UDM-ER16-UD24-03-K-21-R-C	21	16	R	●

Blades US



Spare parts



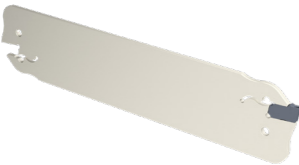
Designation

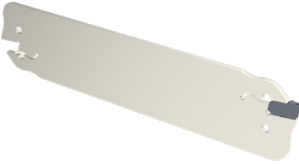
Key T15


M4.0X14/T15

M6.0X6.0 DIN 913

G1/8 DIN 913

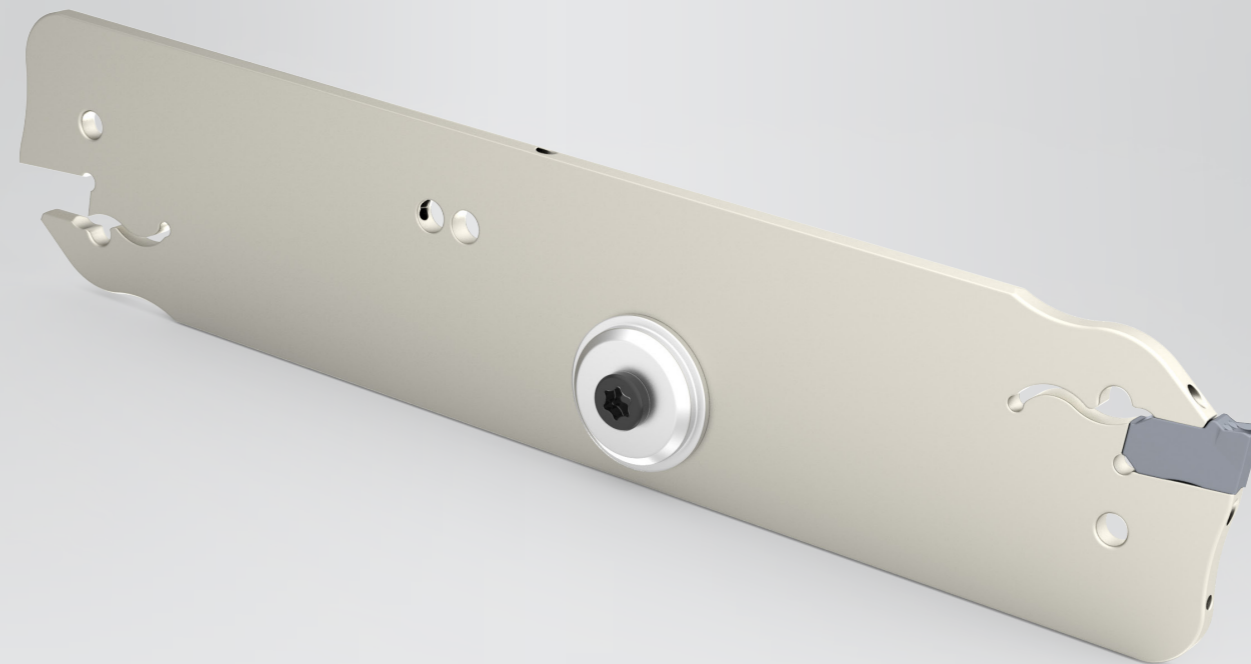
Blades	Designation	T _{max} [mm]	Available
	UP-R2602-US02	25	●
	UP-L2602-US02	25	●
	UP-R3202-US02	25	●
	UP-L3202-US02	25	●
	UP-N2603-US03	35	●
	UP-N3203-US03	50	●









Blades	Designation	T _{max} [mm]	Available
	UP-N2604-US04	40	●
	UP-N3204-US04	50	●
	UP-N3205-US05	55	●
	UP-N3206-US06	60	●



Spare parts *	Designation
	GK-2-3 (2 and 3 mm)
	GK-4-5-6-5-6 (4, 5 and 6 mm)



Blades US

with internal cooling

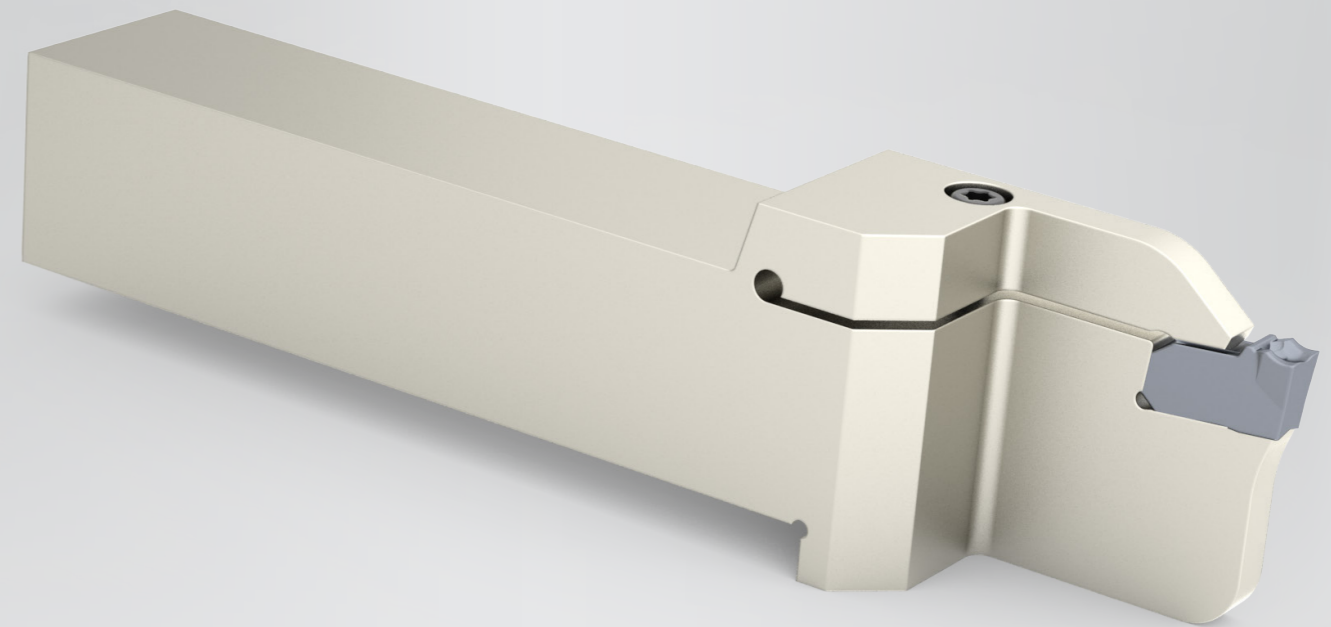


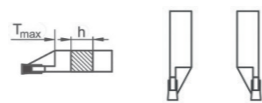
Blades	Designation	T _{max} [mm]	Available
	UP-L2602-US02-C	25	●
	UP-L3202-US02-C	25	●
	UP-R2602-US02-C	25	●
	UP-R3202-US02-C	25	●
	UP-N2603-US03-C	35	●
	UP-N3203-US03-C	50	●
	UP-N2604-US04-C	40	●
	UP-N3204-US04-C	50	●

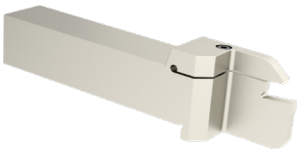
Spare parts	Designation
	Key T15 58 MM
	Coolant screw plug M4X3

Spare parts *	Designation
	GK-2-3 (2 and 3 mm)
	GK-4-5-6-5-6 (4, 5 and 6 mm)

Monoblocks US





Tool	Designation	T _{max} [mm]	h		Available
	UDM-EL16-US02-K-20	20	16	L	●
	UDM-ER20-US02-K-20	20	16	R	●
	UDM-EL16-US03-K-20	20	16	L	●
	UDM-ER20-US03-K-20	20	16	R	●
	UDM-EL20-US02-K-20	20	20	L	●
	UDM-ER20-US02-K-20	20	20	R	●
	UDM-EL20-US03-K-20	20	20	L	●
	UDM-ER20-US03-K-20	20	20	R	●
	UDM-EL20-US04-K-25	25	20	L	●
	UDM-ER20-US04-K-25	25	20	R	●
	UDM-EL20-US05-K-25	25	20	L	●
	UDM-ER20-US05-K-25	25	20	R	●
	UDM-EL20-US06-K-25	25	20	L	●
	UDM-ER20-US06-K-25	25	20	R	●
	UDM-EL25-US03-M-20	20	25	L	●
	UDM-ER25-US03-M-20	20	25	R	●
	UDM-EL25-US04-M-25	25	25	L	●
	UDM-ER25-US04-M-25	25	25	R	●
	UDM-EL25-US05-M-25	25	25	L	●
	UDM-ER25-US05-M-25	25	25	R	●
UDM-EL25-US06-M-32	32	25	L	●	
UDM-ER25-US06-M-32	32	25	R	●	

Spare parts

Designation

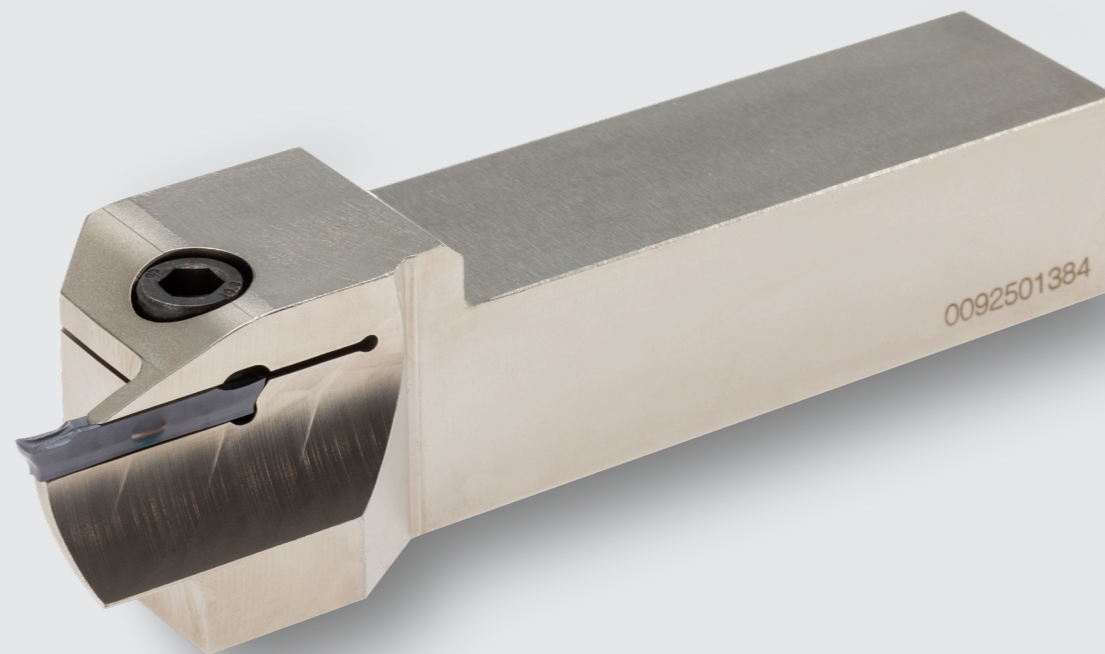


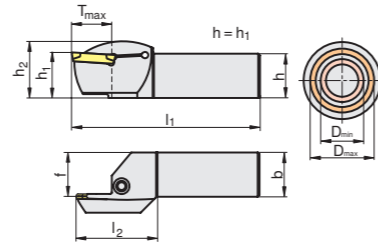
Key T20



M4.0X18/T20

Monoblocks UA



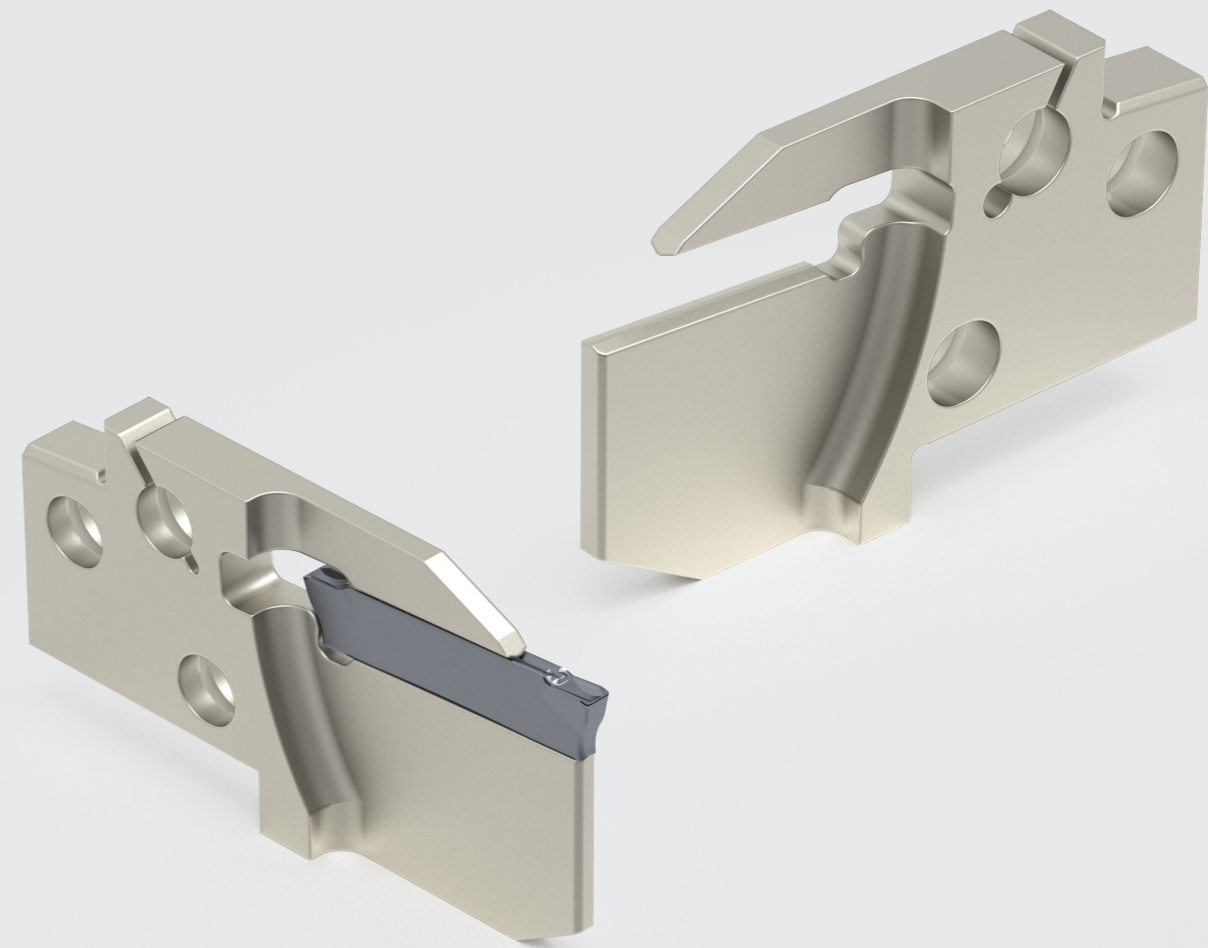


Designation	s [mm]	T _{max} [mm]	D _{min} [mm]	D _{max} [mm]	h = h ₁ [mm]	h ₂ [mm]	b [mm]	l ₁ [mm]	l ₂ [mm]	f [mm]	Available
UDM-AR25-UA03-K-40-50-13	3	13	40	50	25	33	25	125	39.7	24.3	●
UDM-AR25-UA03-K-50-60-13	3	13	50	60	25	33	25	125	39.7	24.3	●
UDM-AR25-UA03-K-60-75-13	3	13	60	75	25	33	25	125	39.7	24.3	●
UDM-AR25-UA03-K-75-100-13	3	13	75	100	25	33	25	125	39.7	24.3	●
UDM-AR25-UA03-K-100-140-13	3	13	100	140	25	33	25	125	39.7	24.3	●
UDM-AR25-UA03-K-140-200-13	3	13	140	200	25	33	25	125	39.7	24.3	●
UDM-AL25-UA03-K-40-50-13	3	13	40	50	25	33	25	125	39.7	24.3	●
UDM-AL25-UA03-K-50-60-13	3	13	50	60	25	33	25	125	39.7	24.3	●
UDM-AL25-UA03-K-60-75-13	3	13	60	75	25	33	25	125	39.7	24.3	●
UDM-AL25-UA03-K-75-100-13	3	13	75	100	25	33	25	125	39.7	24.3	●
UDM-AL25-UA03-K-100-140-13	3	13	100	140	25	33	25	125	39.7	24.3	●
UDM-AL25-UA03-K-140-200-13	3	13	140	200	25	33	25	125	39.7	24.3	●
UDM-AR25-UA04-K-40-50-13	4	13	40	50	25	33	25	125	39.7	24.3	●
UDM-AR25-UA04-K-50-60-13	4	13	50	60	25	33	25	125	39.7	24.3	●
UDM-AR25-UA04-K-60-75-13	4	13	60	75	25	33	25	125	39.7	24.3	●
UDM-AR25-UA04-K-75-100-13	4	13	75	100	25	33	25	125	39.7	24.3	●
UDM-AR25-UA04-K-100-140-13	4	13	100	140	25	33	25	125	39.7	24.3	●
UDM-AR25-UA04-K-140-200-13	4	13	140	200	25	33	25	125	39.7	24.3	●
UDM-AL25-UA04-K-40-50-13	4	13	40	50	25	33	25	125	39.7	24.3	●
UDM-AL25-UA04-K-50-60-13	4	13	50	60	25	33	25	125	39.7	24.3	●
UDM-AL25-UA04-K-60-75-13	4	13	60	75	25	33	25	125	39.7	24.3	●
UDM-AL25-UA04-K-75-100-13	4	13	75	100	25	33	25	125	39.7	24.3	●
UDM-AL25-UA04-K-100-140-13	4	13	100	140	25	33	25	125	39.7	24.3	●
UDM-AL25-UA04-K-140-200-13	4	13	140	200	25	33	25	125	39.7	24.3	●
GMAR-25-UA05-M-20-45-60	5	20	45	60	25	33	25	150	39	23.3	●
GMAR-25-UA05-M-20-60-75	5	20	60	75	25	33	25	150	39	23.3	●
GMAR-25-UA05-M-28-75-100	5	28	75	100	25	33	25	150	47	23.3	●
GMAR-25-UA05-M-28-100-180	5	28	100	180	25	33	25	150	47	23.3	●
GMAR-25-UA05-M-32-180-400	5	32	180	400	25	33	25	150	51	23.3	●
GMAL-25-UA05-M-20-45-60	5	20	45	60	25	33	25	150	39	23.3	●
GMAL-25-UA05-M-20-60-75	5	20	60	75	25	33	25	150	39	23.3	●
GMAL-25-UA05-M-28-75-100	5	28	75	100	25	33	25	150	47	23.3	●
GMAL-25-UA05-M-28-100-180	5	28	100	180	25	33	25	150	47	23.3	●
GMAL-25-UA05-M-32-180-400	5	32	180	400	25	33	25	150	51	23.3	●

● available from stock, ○ available upon request
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NEW

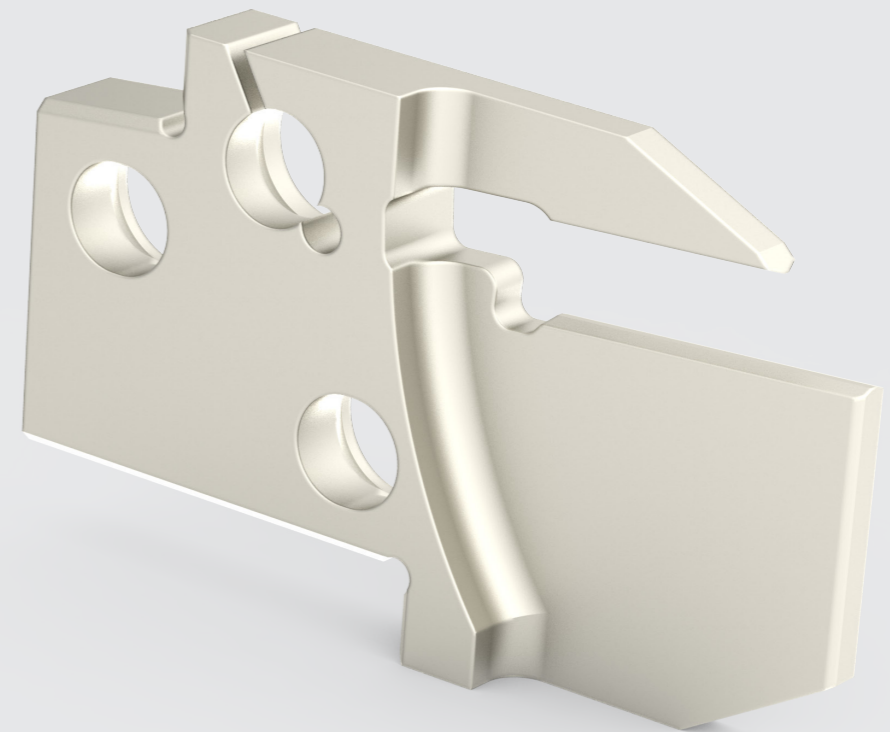
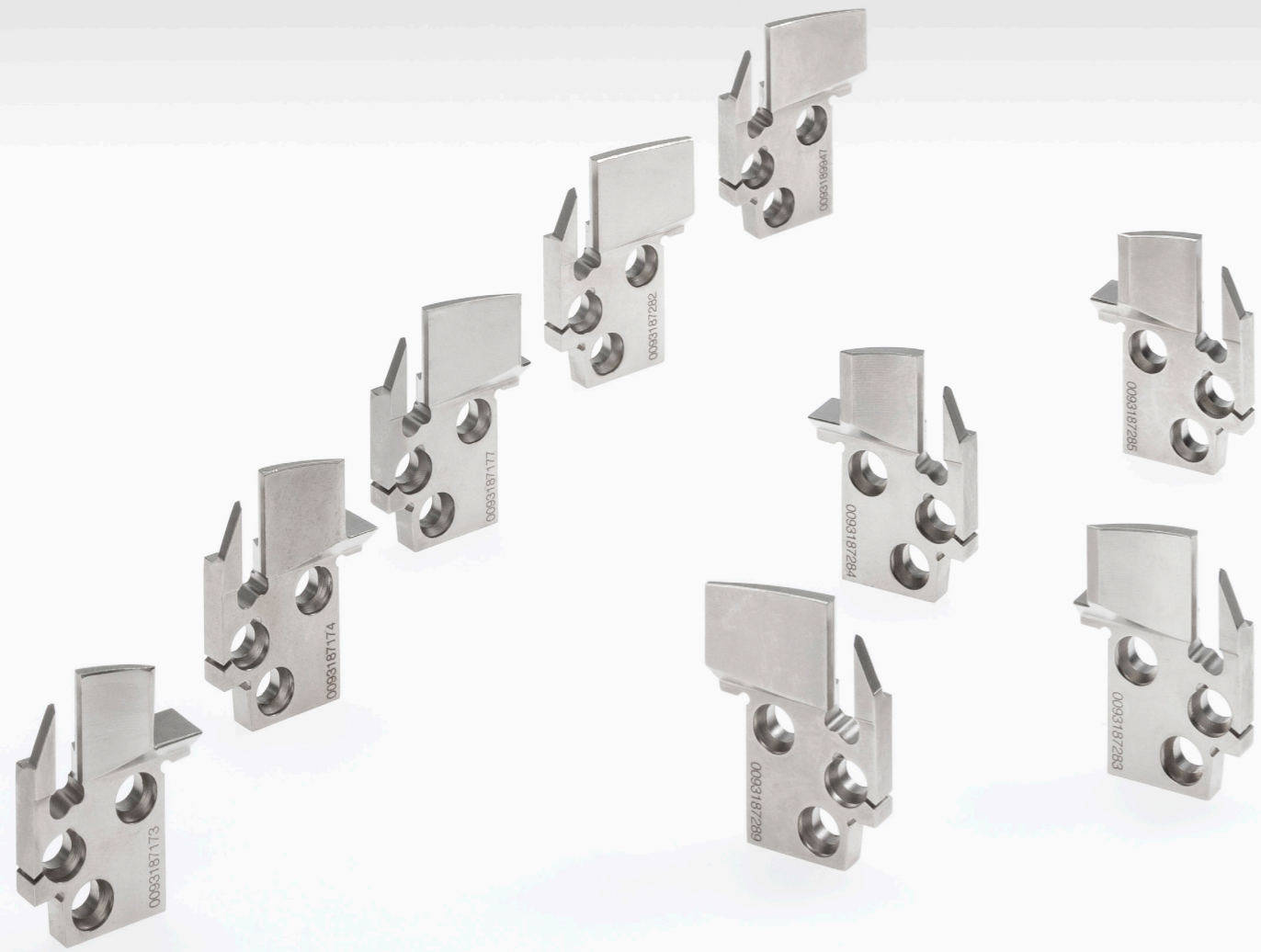
Module

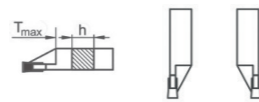


NEW

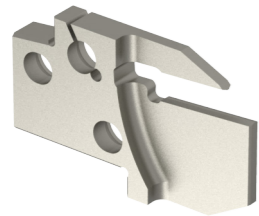
Module UJ/UD

Radial



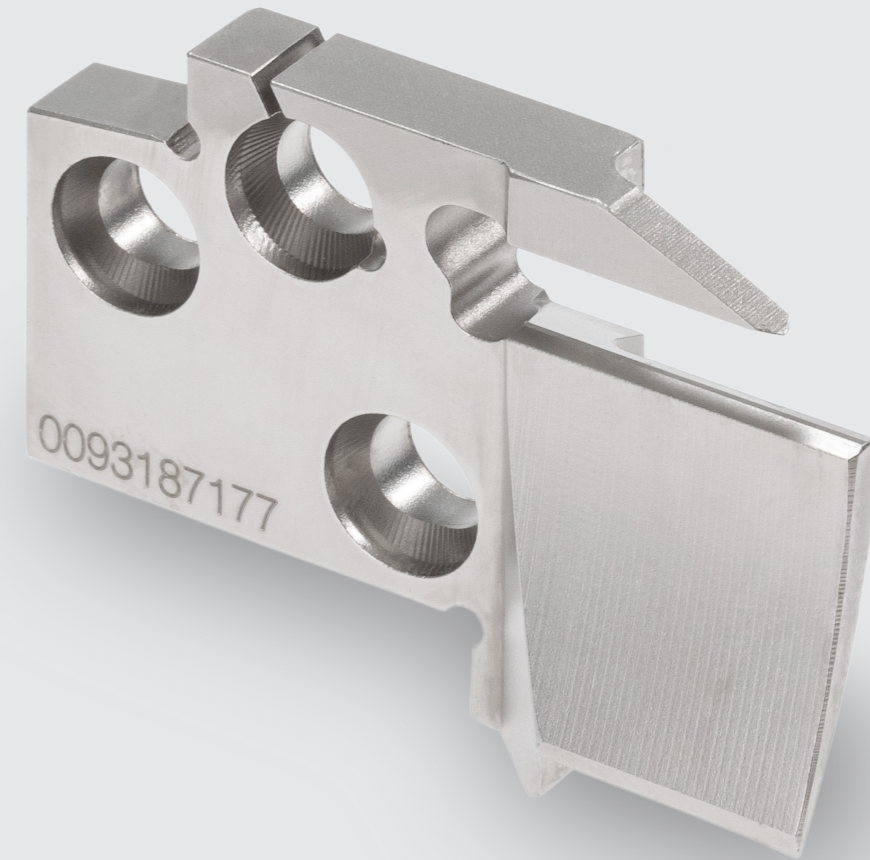


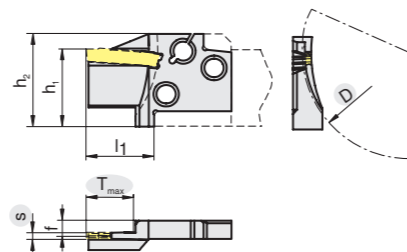
Tool	Designation	T _{max} [mm]	h		Available
	UM-EL2002-UJ24-02-25	25	20	L	●
	UM-ER2002-UJ24-02-25	25	20	R	●
	UM-EL2003-UJ24-03-25	25	20	L	●
	UM-ER2003-UJ24-03-25	25	20	R	●
	UM-EL2004-UJ24-04-25	25	20	L	●
	UM-ER2004-UJ24-04-25	25	20	R	●
	UM-EL2005-UJ24-05-25	25	20	L	●
	UM-ER2005-UJ24-05-25	25	20	R	●
	UM-EL2006-UJ24-06-25	25	20	L	●
	UM-ER2006-UJ24-06-25	25	20	R	●
	UM-EL2502-UJ24-02-25	25	25	L	●
	UM-ER2502-UJ24-02-25	25	25	R	●
	UM-EL2503-UJ24-03-25	25	25	L	●
	UM-ER2503-UJ24-03-25	25	25	R	●
	UM-EL2504-UJ24-04-25	25	25	L	●
	UM-ER2504-UJ24-04-25	25 <td 25	R	●	
	UM-EL2505-UJ24-05-25	25	25	L	●
	UM-ER2505-UJ24-05-25	25	25	R	●
	UM-EL2506-UJ24-06-25	25	25	L	●
	UM-ER2506-UJ24-06-25	25	25	R	●



Module UA

Axial

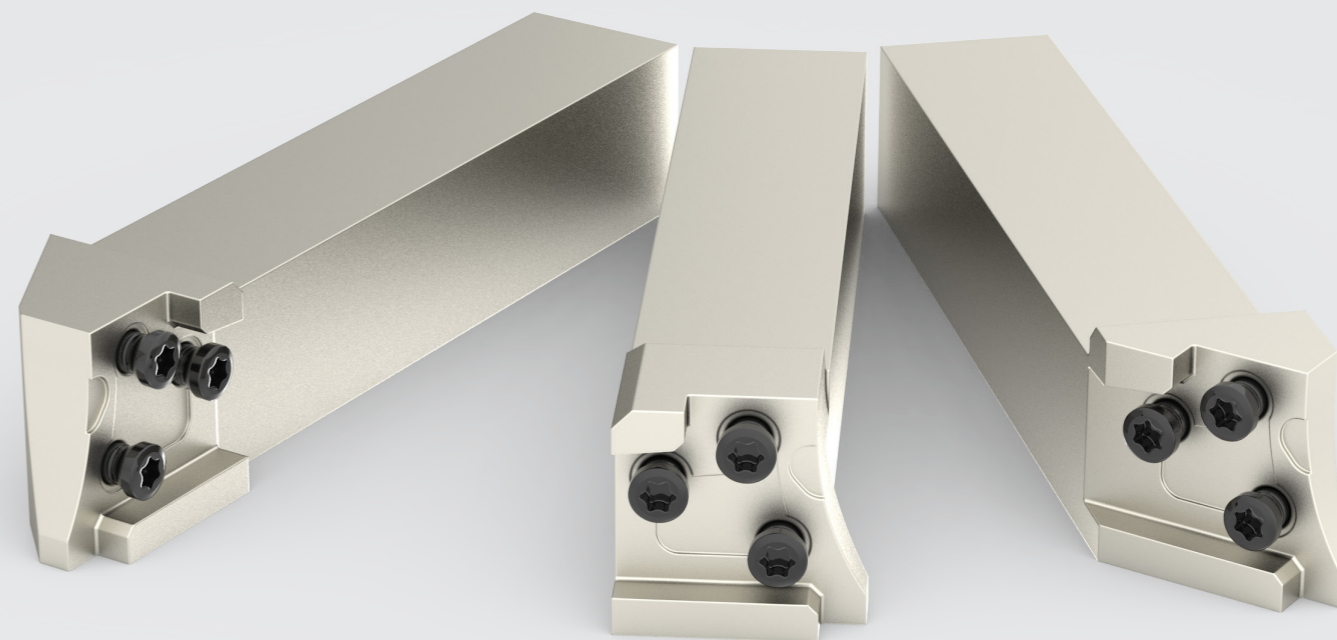






NEW

Module Holder

Designation	s [mm]	T _{max} [mm]	D _{min} [mm]	D _{max} [mm]	h = h ₁ [mm]	h ₂ [mm]	l ₁ [mm]	f [mm]	Available
UM-AR2503-UA24-03-40-50-15	3	15	40	50	25	30	22	4.9	●
UM-AR2503-UA24-03-50-60-15	3	15	50	60	25	30	22	4.9	●
UM-AR2503-UA24-03-60-75-15	3	15	60	75	25	30	22	4.9	●
UM-AR2503-UA24-03-75-100-15	3	15	75	100	25	30	22	4.9	●
UM-AR2503-UA24-03-100-140-15	3	15	100	140	25	30	22	4.9	●
UM-AR2503-UA24-03-140-200-15	3	15	140	200	25	30	22	4.9	●
UM-AL2503-UA24-03-40-50-15	3	15	40	50	25	30	22	4.9	●
UM-AL2503-UA24-03-50-60-15	3	15	50	60	25	30	22	4.9	●
UM-AL2503-UA24-03-60-75-15	3	15	60	75	25	30	22	4.9	●
UM-AL2503-UA24-03-75-100-15	3	15	75	100	25	30	22	4.9	●
UM-AL2503-UA24-03-100-140-15	3	15	100	140	25	30	22	4.9	●
UM-AL2503-UA24-03-140-200-15	3	15	140	200	25	30	22	4.9	●
UM-AR2504-UA24-04-40-50-15	4	15	40	50	25	30	22	4.4	●
UM-AR2504-UA24-04-50-60-15	4	15	50	60	25	30	22	4.4	●
UM-AR2504-UA24-04-60-75-15	4	15	60	75	25	30	22	4.4	●
UM-AR2504-UA24-04-75-100-15	4	15	75	100	25	30	22	4.4	●
UM-AR2504-UA24-04-100-140-15	4	15	100	140	25	30	22	4.4	●
UM-AR2504-UA24-04-140-200-15	4	15	140	200	25	30	22	4.4	●
UM-AL2504-UA24-04-40-50-15	4	15	40	50	25	30	22	4.4	●
UM-AL2504-UA24-04-50-60-15	4	15	50	60	25	30	22	4.4	●
UM-AL2504-UA24-04-60-75-15	4	15	60	75	25	30	22	4.4	●
UM-AL2504-UA24-04-75-100-15	4	15	75	100	25	30	22	4.4	●
UM-AL2504-UA24-04-100-140-15	4	15	100	140	25	30	22	4.4	●
UM-AL2504-UA24-04-140-200-15	4	15	140	200	25	30	22	4.4	●



Tool	Designation	s	Module Radial	Module axial	Available
	UM-EDL-M-2020-J-00	0	GEML-20		●
	UM-EDR-M-2020-J-00	0	GEMR-20		●
	UM-EDL-M-2020-J-45	45	GEMR-20		●
	UM-EDR-M-2020-J-45	45	GEML-20		●
	UM-EDL-M-2020-J-90	90	GEML-20		●
	UM-EDR-M-2020-J-90	90	GEMR-20		●
	UM-EDL-M-2525-L-00	0	GEML-25	UAML-25	●
	UM-EDR-M-2525-L-00	0	GEMR-25	UAMR-25	●
	UM-EDL-M-2525-L-45	45	GEMR-25	UAMR-25	●
	UM-EDR-M-2525-L-45	45	GEML-25	UAML-25	●
	UM-EDL-M-2525-L-90	90	GEMR-25	UAMR-25	●
	UM-EDR-M-2525-L-90	90	GEML-25	UAML-25	●

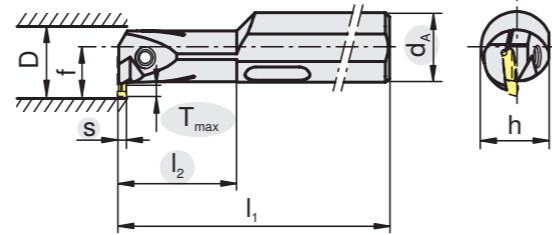
Spare parts	Designation
	Key T15
	Key T20
	M4.0X11/T15
	M4.0X14/T15
	M5.0X13.5/T20
	M5.0X18/T20

● available from stock, Oavailable upon request
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NEW

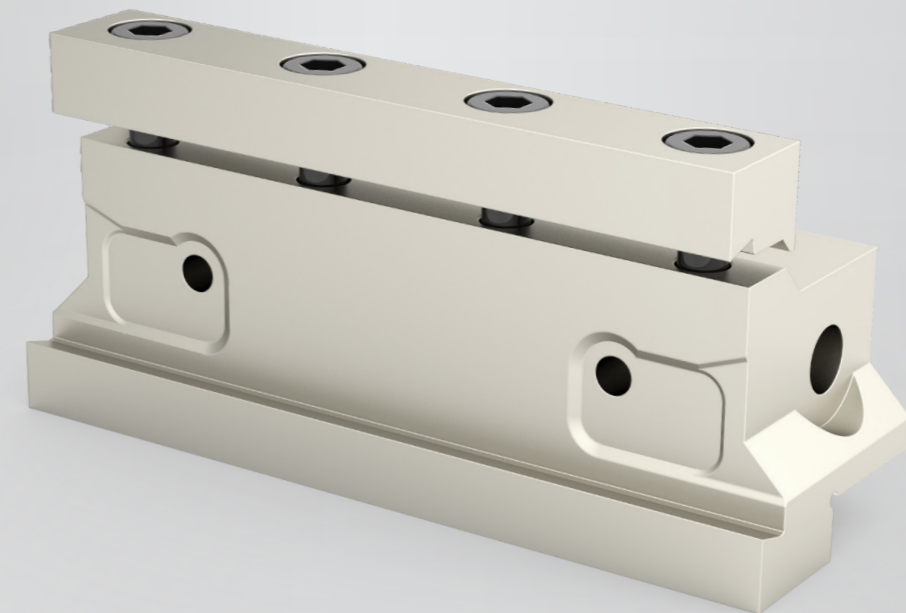
Boring Bars





Clamping block

Designation	d_A [mm]	T_{max} [mm]	s [mm]	h [mm]	f [mm]	l_1 [mm]	l_2 [mm]	D_{min} [mm]	Available
UDM-IR25-UD24-02-C-08	25	8	2	24.4	21	200	52	32	●
UDM-IR25-UD24-03-C-09	25	9	3	24.5	22	200	52	32	●
UDM-IR32-UD24-03-C-11	32	11	3	31	27.5	250	64	42	●
UDM-IR32-UD24-04-C-11	32	11	4	31	27.5	250	64	42	●
UDM-IR40-UD24-04-C-12	40	12	4	38.5	32.5	300	80	53	●
UDM-IR40-UD24-05-C-12	40	12	5	38.5	32.5	300	80	53	●
UDM-IL25-UD24-02-C-08	25	8	2	24.4	21	200	52	32	●
UDM-IL25-UD24-03-C-09	25	9	3	24.5	22	200	52	32	●
UDM-IL32-UD24-03-C-11	32	11	3	31	27.5	250	64	42	●
UDM-IL32-UD24-04-C-11	32	11	4	31	27.5	250	64	42	●
UDM-IL40-UD24-04-C-12	40	12	4	38.5	32.5	300	80	53	●
UDM-IL40-UD24-05-C-12	40	12	5	38.5	32.5	300	80	53	●



Spare parts



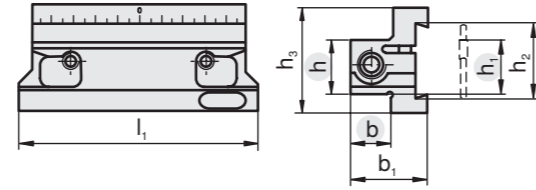
Designation

Key T20

M5.0X18/T20


M4.0X4.0 DIN 913

SCB



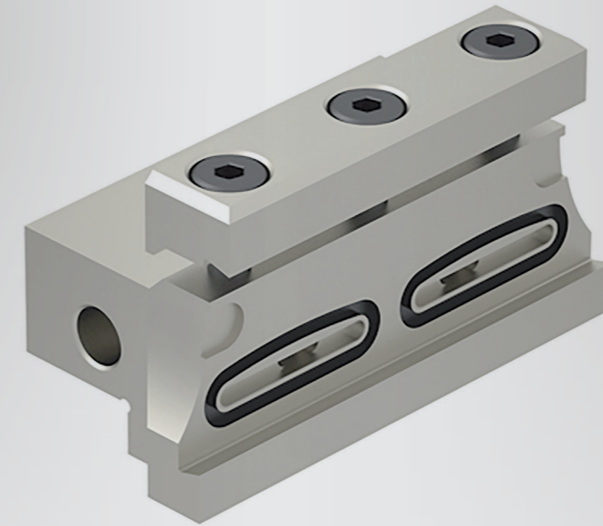
Designation	Material	h_2 [mm]	h [mm]	h_1 [mm]	h_3 [mm]	l_1 [mm]	b [mm]	b_1 [mm]	For blade	Available
UB-UP26-2020	12279141	26	20	20	43	90	20	37	GBN...26...	●
UB-UP32-2520	12279142	32	25	25	49	110	20	38	GBN...32...	●

Spare part for clamping block without cooling

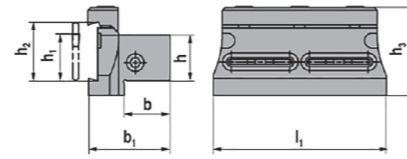
Spare parts	Designation
	Clamping screw M6.0x25

Clamping block

with internal cooling



Range

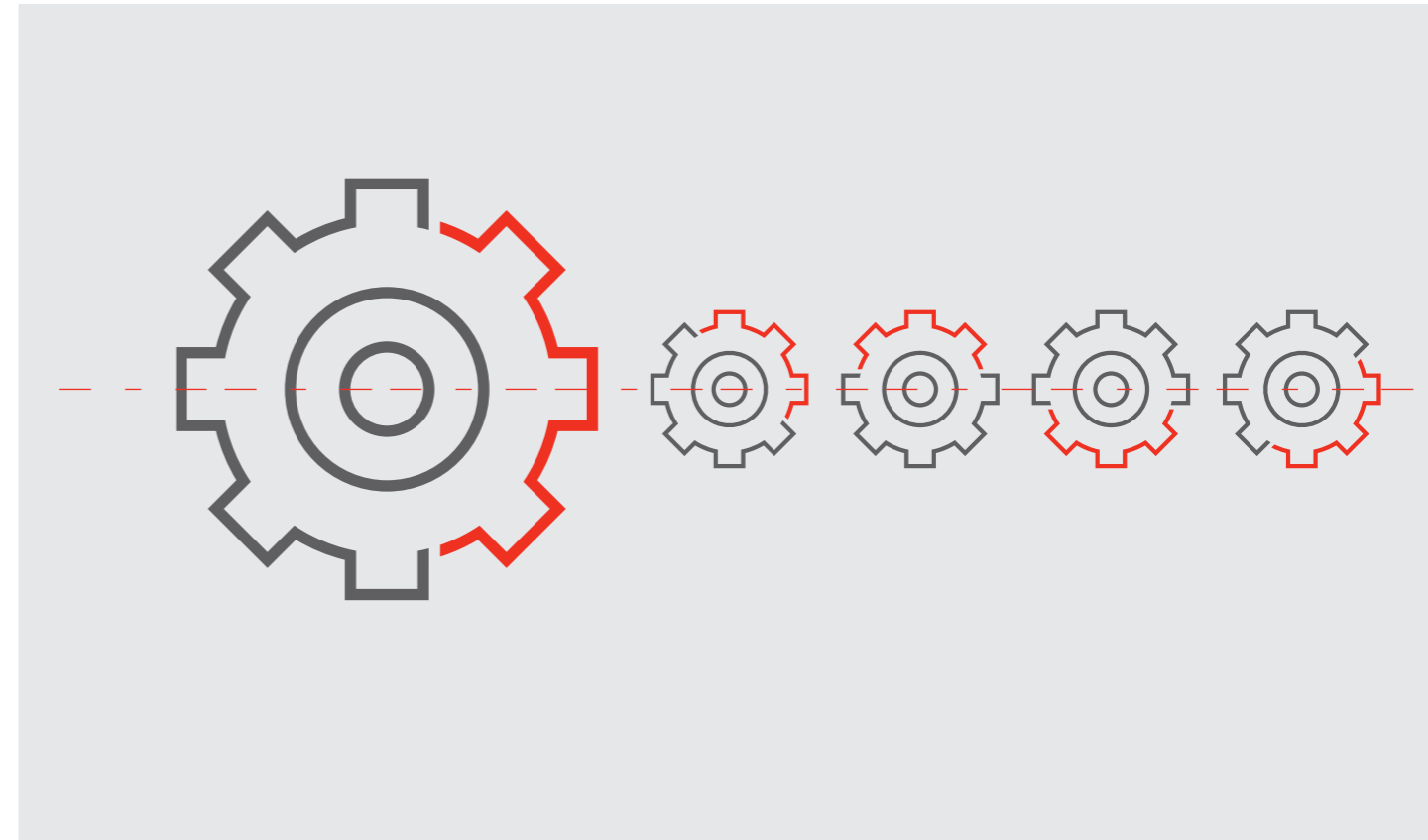


Designation	Material	h_2 [mm]	h [mm]	h_1 [mm]	h_3 [mm]	l_1 [mm]	b [mm]	b_1 [mm]	For blade	Available
UB-UP26-2020-C	12279139	26	20	20	43	82	20	40	GBN...26...	●
UB-UP32-2525-C	12279137	32	25	25	49	95	25	44.5	GBN...32...	●

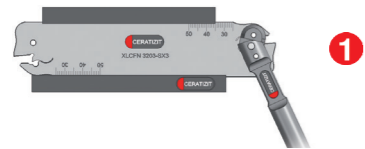
Spare part for clamping block with cooling

Spare parts	Designation
	Grub screw M6.0x8
	Clamping screw M6.0x12

Technical information

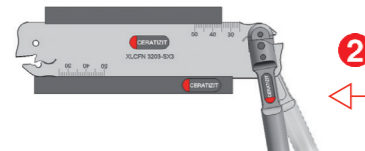


How to use the system?



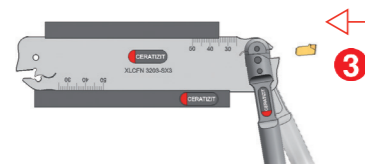
1

Insert mounting key with handle towards the front into the 2 tool location points



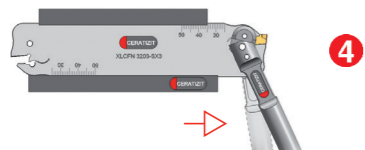
2

When moving the mounting key in the direction of the arrows the insert seat is opened



3

Position the insert pressing it against the location face



4

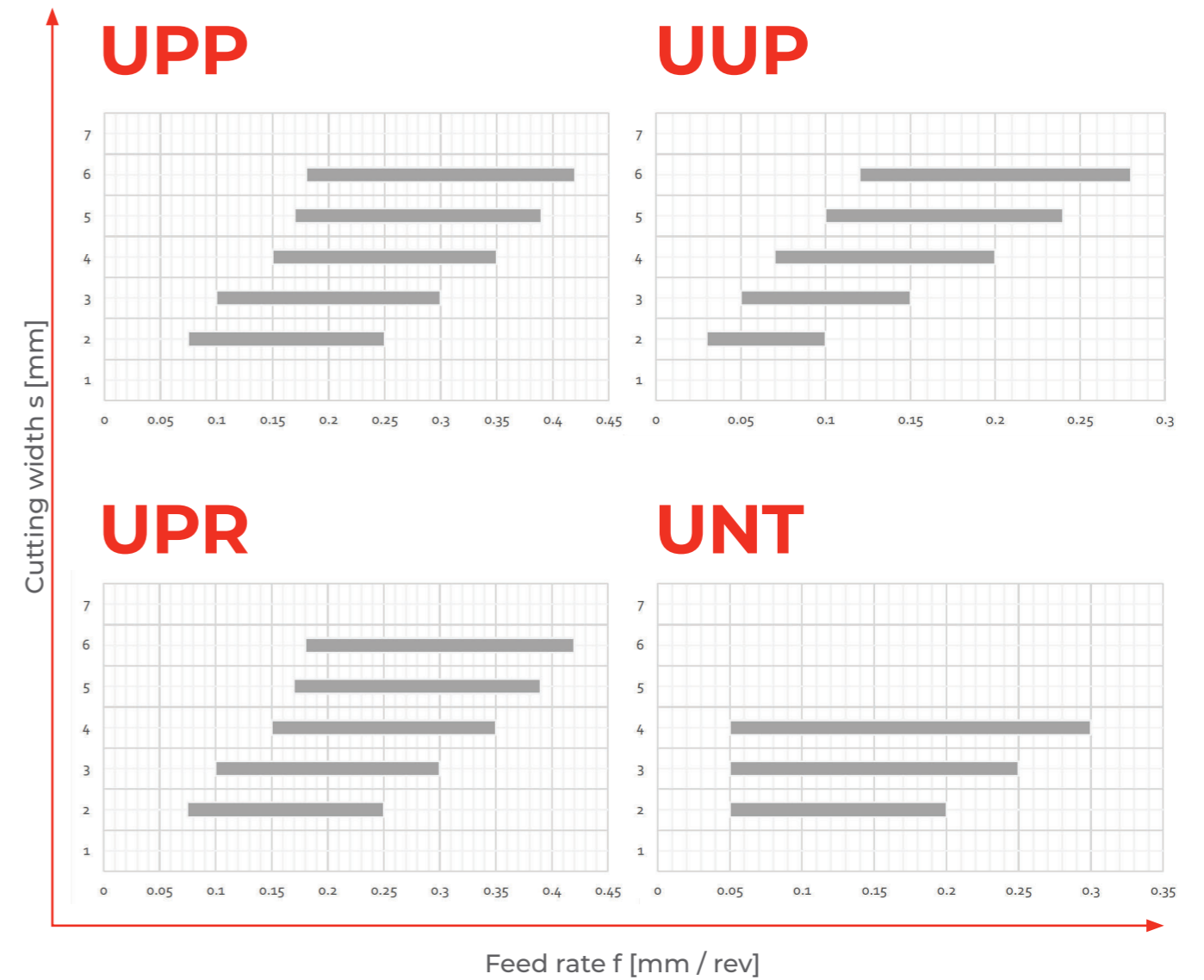
Moving the mounting key forward the insert seat locks and insert is clamped securely

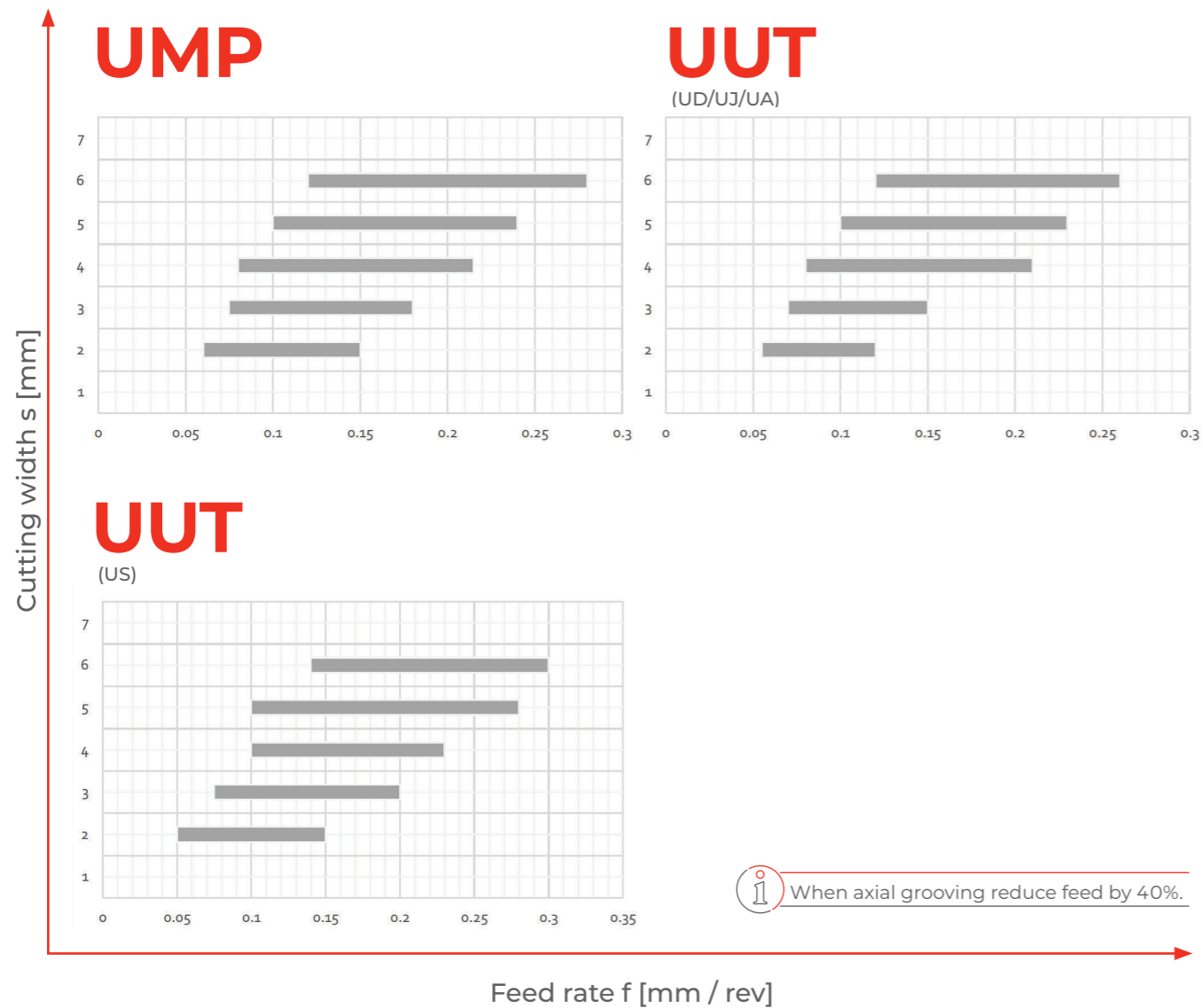


When changing the inserts, always maintain tension on the key!

Feed rate recommendation

When axial grooving reduce feed by 40%.





Feed rate recommendation

UUT

(UD/UJ/UA)

Cutting width	0.5	1	1.5	2	2.5	3	3.5
	a_p (mm)	a_p (mm)	a_p (mm)	a_p (mm)	a_p (mm)	a_p (mm)	a_p (mm)
2	0.10-0.15	0.05-0.15	0.05-0.12	0.05-0.10			
3	0.10-0.17	0.05-0.17	0.05-0.17	0.05-0.15	0.05-0.12		
4	0.10-0.20	0.07-0.20	0.07-0.20	0.07-0.20	0.07-0.17	0.07-0.15	
5	0.10-0.25	0.10-0.25	0.07-0.25	0.07-0.25	0.07-0.22	0.07-0.20	
6	0.15-0.30	0.15-0.30	0.15-0.30	0.15-0.30	0.15-0.30	0.15-0.25	0.15-0.22

UUT

(US)

Cutting width	0.5	1	1.5	2	2.5	3
	a_p (mm)	a_p (mm)	a_p (mm)	a_p (mm)	a_p (mm)	a_p (mm)
2	0.05-0.17	0.05-0.13	0.05-0.10			
3	0.07-0.20	0.07-0.20	0.07-0.18	0.07-0.15		
4	0.10-0.25	0.10-0.25	0.10-0.25	0.10-0.22	0.10-0.18	
5	0.12-0.27	0.12-0.27	0.12-0.27	0.12-0.25	0.12-0.22	
6	0.15-0.30	0.15-0.30	0.15-0.30	0.15-0.30	0.15-0.25	0.15-0.20

UPR / UMR

Cutting width	0.5	1	1.5	2	2.5	3
	a_p (mm)	a_p (mm)	a_p (mm)	a_p (mm)	a_p (mm)	a_p (mm)
2	0.15-0.30	0.15-0.27				
3	0.15-0.35	0.15-0.35	0.15-0.30			
4	0.15-0.40	0.15-0.40	0.15-0.40	0.15-0.30		
5	0.15-0.50	0.15-0.50	0.15-0.50	0.15-0.40	0.15-0.35	
6	0.20-0.70	0.20-0.70	0.20-0.70	0.20-0.60	0.20-0.50	0.20-0.40

Cutting speed recommendation

UPP, UUP, UUT, UPR

Work piece material	Type of treatment/alloy	Hardness HB	Coated carbide		
			MUP13 v_c [m/min]	MUCP32 v_c [m/min]	MUPP34 v_c [m/min]
P Steel	non alloyed steel 0.15% – 0.45% C	150 – 250	80 – 180	110 – 190	80 – 150
	low alloyed steel tempered	250 – 300	60 – 150	110 – 180	70 – 120
	high alloyed steel tempered	350	50 – 120	70 – 160	60 – 100
	corrosion resistant steel annealed	200	50 – 200	120 – 200	90 – 160
M Stainless steel	annealed pearlitic	200	50 – 200	120 – 200	100 – 180
	quenched austenitic	180	50 – 180	100 – 170	80 – 150
	quenched duplex	230 – 260	50 – 100	70 – 110	70 – 110
	hardened martensitic	330	50 – 80	60 – 90	60 – 90
K Cast iron	grey cast iron	180	100 – 200	90 – 180	–
	spheroidal	160	100 – 180	100 – 160	–
	malleable pearlitic	130	80 – 160	80 – 150	–

UMP, UMR

Work piece material	Type of treatment/alloy	Hardness HB	Coated carbide		
			MUP13 v_c [m/min]	MUCP32 v_c [m/min]	MUPP34 v_c [m/min]
M Stainless steel	annealed pearlitic	200	50 – 200	120 – 200	100 – 180
	quenched austenitic	180	50 – 180	100 – 170	80 – 150
	quenched duplex	230 – 260	50 – 100	70 – 110	70 – 110
	hardened martensitic	330	50 – 80	60 – 90	60 – 90
S Exotic	Fe base	200	–	–	20 – 45
	Nickel or cobalt base	250	–	–	15 – 25
	Titanium	Rm 440	–	–	50 – 120

UNT

Work piece material	Type of treatment/alloy	Hardness HB	Uncoated carbide MUN15- v_c [m/min]
N Non-ferrous	Aluminium wrought alloys	100	200 – 2000
	Aluminium cast alloys < 12% Si	90	400 – 1500
	Copper alloys (bronze)	90	200 – 600

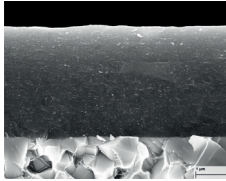
Maximal torque for screws

Designation	max. torque/Nm	Material
7812115/M6X20 DIN 912	7	4493
7802115/M6X25 DIN 912-12.9	7	22485
7897218/M4.0X18/T20	4	11007006
M6X6 DIN 913	0	11040843
7897221/M3.5X14.0/T15	3.2	11081190
10010029/M6X12 DIN 912-12.9	7	11776816
M0102554/M4.0X16/T20 SCREW	4	12003031
7897203/M4.0X14/T15	4	195068
7897209/M4.0X11/T15	4	219981
7897205/M5.0X18/T20	5	195069
7897210/M5.0X13.5/T20	5	219982

Grade description

MUP13

HC-P30 | HC-M25 | HC-K30 | HC-S30



Specification:

Composition: Co 9.0 %; WC balance | Grain size: 0.5-0.8 μm | Hardness: HV₃₀ 1590 |
Coating specification: PVD TiAlN

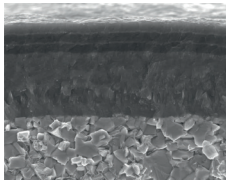
Recommended application:

The universal high-performance grade for steel, austenitic steel, cast iron and heat-resistant alloys.

- ▲ Excellent suitability for universal application
- ▲ High cutting edge stability

MUCP32

HC-P20 | HC-K30 | HC-M20



Specification:

Composition: Co 9.0 %; WC balance | Grain size: 0.5-0.8 μm | Hardness: HV₃₀ 1590 |
Coating specification: CVD TiCN-Al₂O₃ multi-layer

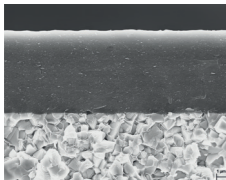
Recommended application:

The reliable choice for the machining of steel and cast iron.

- ▲ Excellent wear resistance
- ▲ Good resistance to oxidation
- ▲ High toughness
- ▲ Good heat resistance

MUPP34

HC-P45 | HC-M40 | HC-S40



Specification:

Composition: Co 12.5 %; mixed carbides 2.0 %; WC balance | Grain size: 1-1.5 μm |
Hardness: HV₃₀ 1380 | Coating specification: PVD TiAlTaN

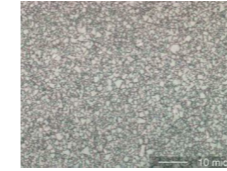
Recommended application:

The reliable solution for steel and austenitic steels under unstable conditions.

- ▲ Ideal for stainless steel
- ▲ Excellent toughness
- ▲ Good wear resistance
- ▲ High application security

MUN15-

HW-K15



Specification:

Composition: Co 6.0% | WC balance; other: 0.20% | Grain size: 0.8-1.3 μm | Hardness: HV₃₀ 1650

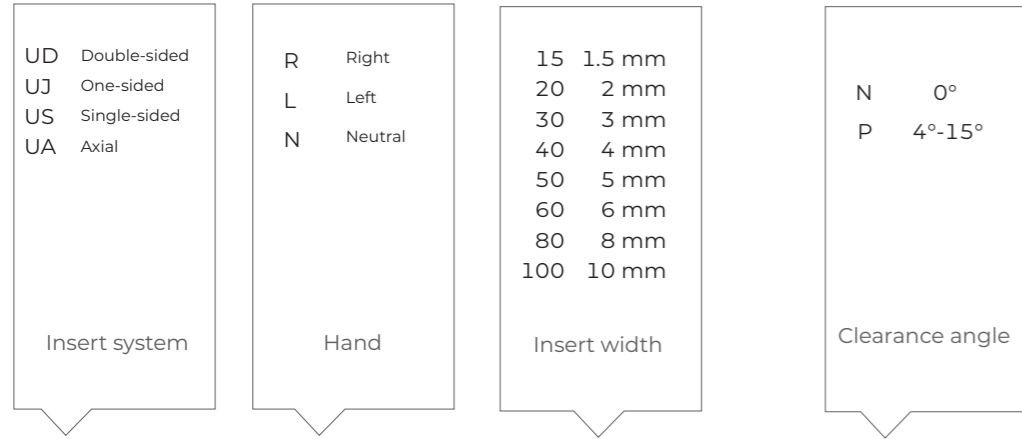
Recommended application:

The uncoated carbide grade for the machining of aluminium and other non-ferrous metals.

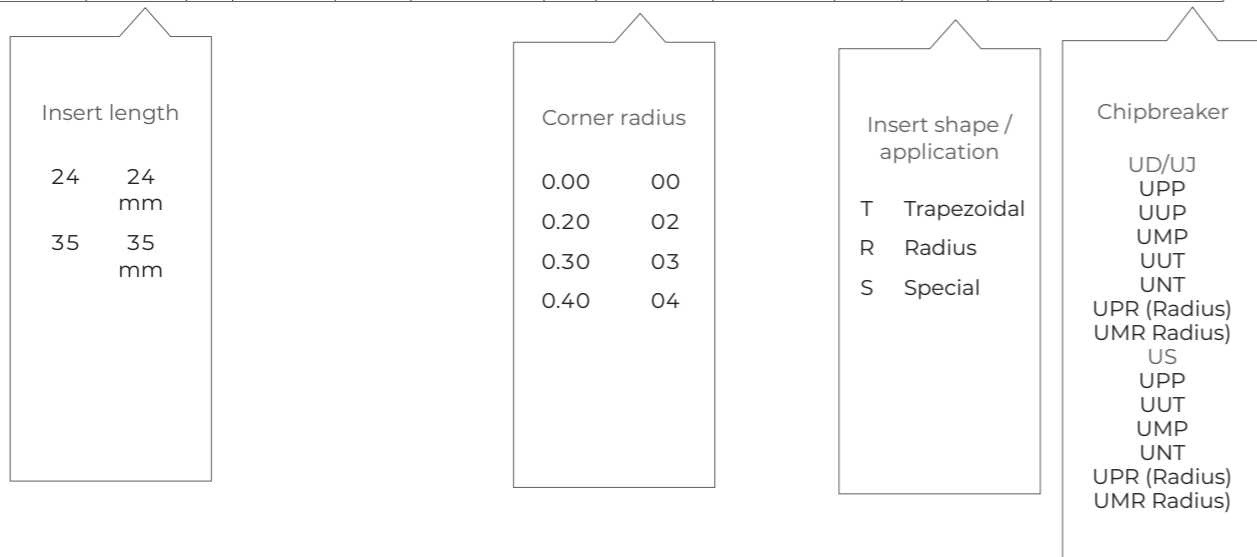
- ▲ Optimal suitable for aluminium
- ▲ High wear resistance
- ▲ High heat resistance
- ▲ Low tendency to adhesion

MASAM designation system

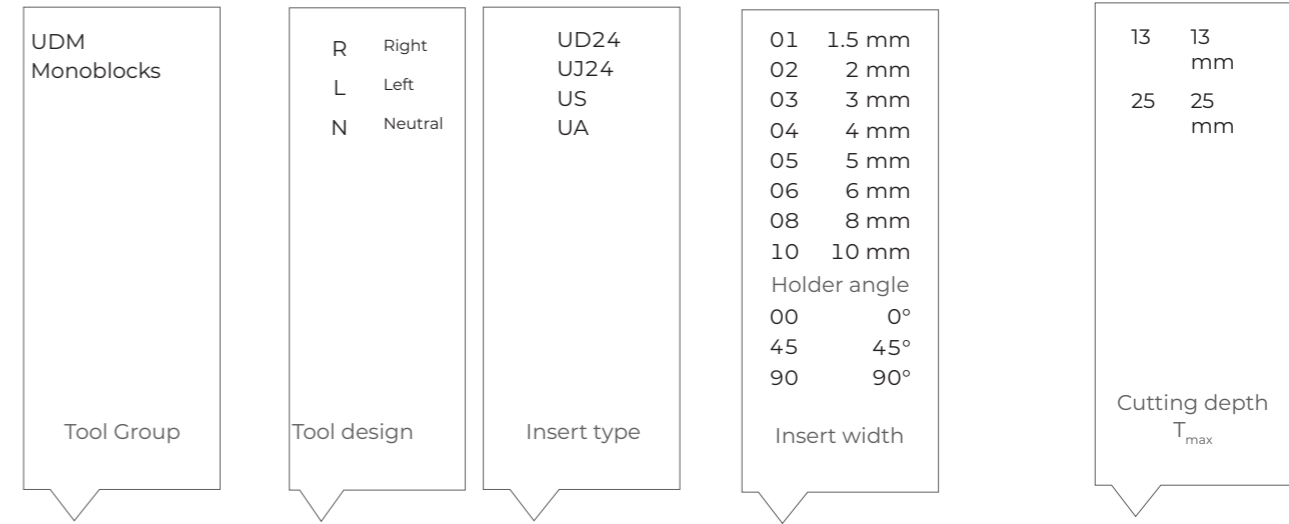
Designation system for inserts



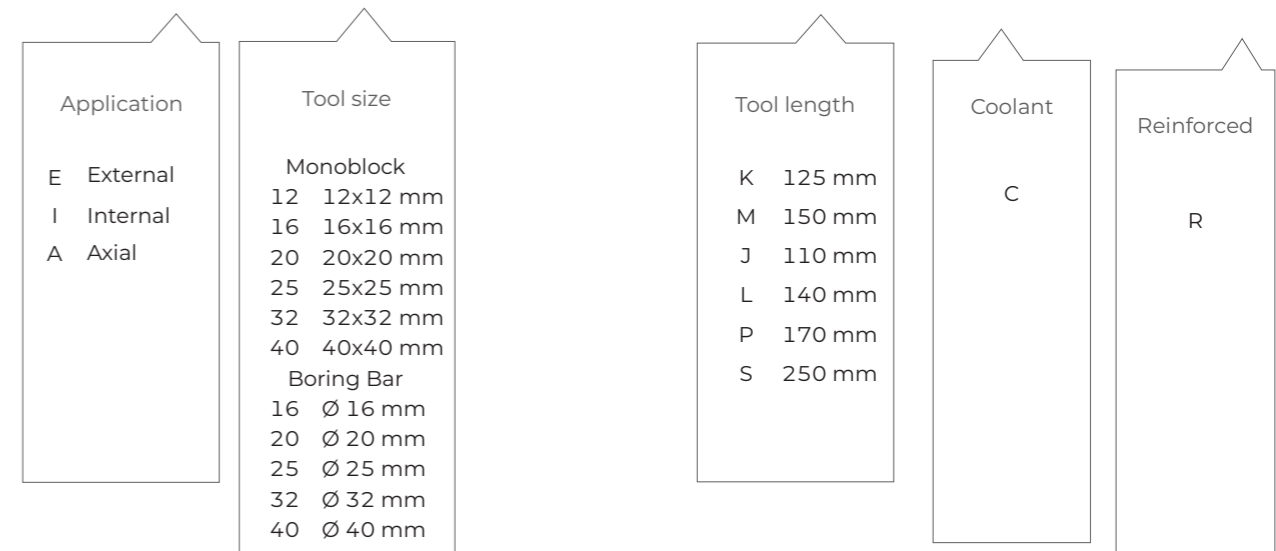
UD 24 - N - 30 . 02 N - T - UPP



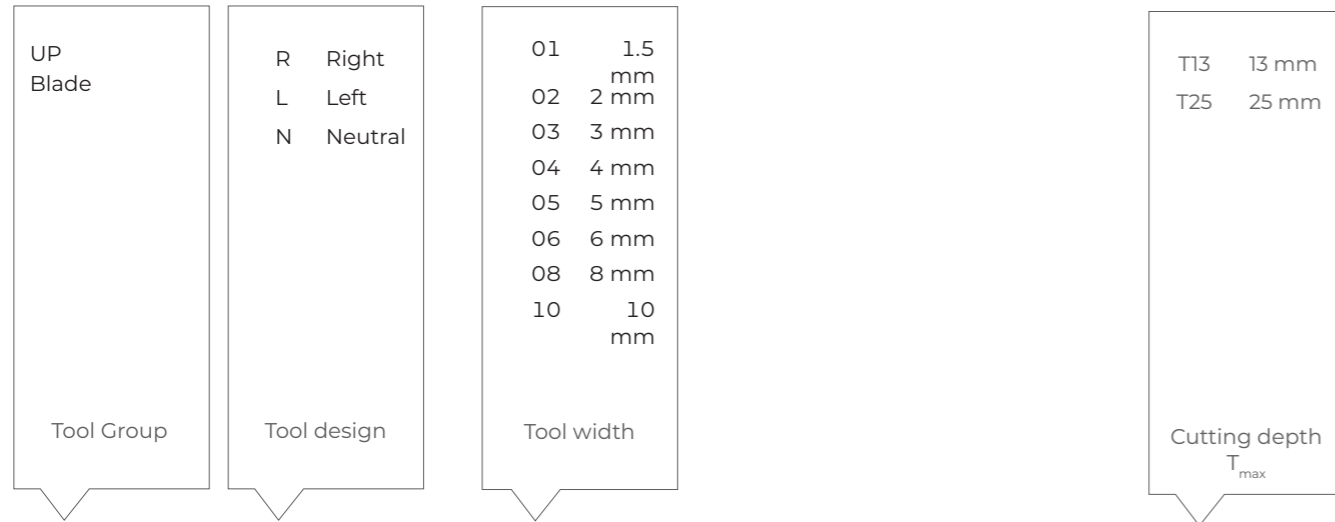
Designation system for Monoblocks tools



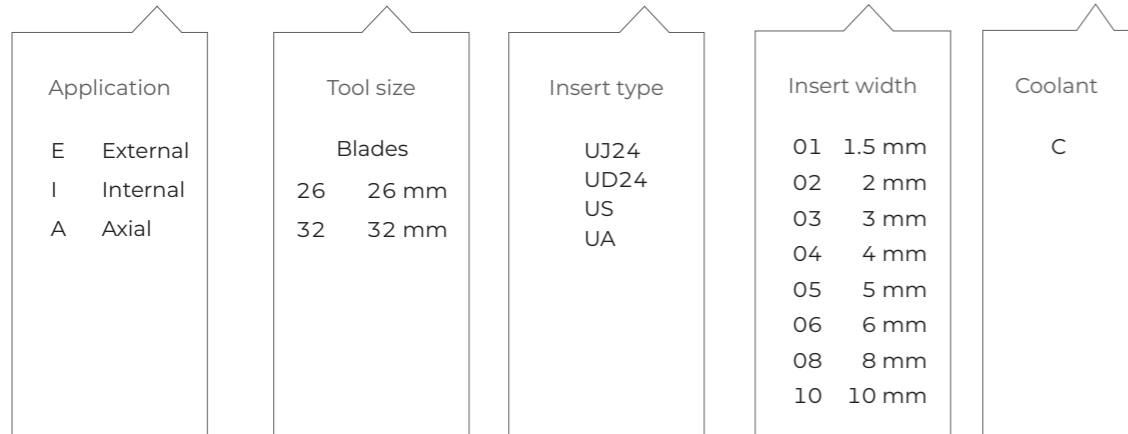
UDM - ER16 - UD24 - 02 - K - C 13 - R



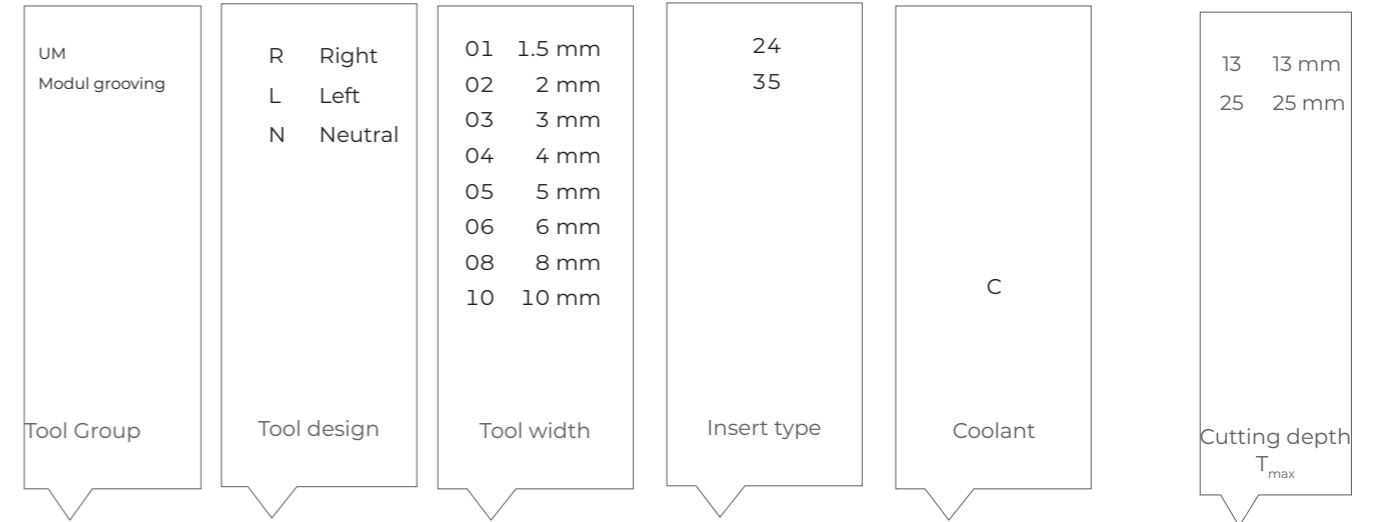
Designation system for blades



UP E R - 26 02 - UJ24 02 C - T13



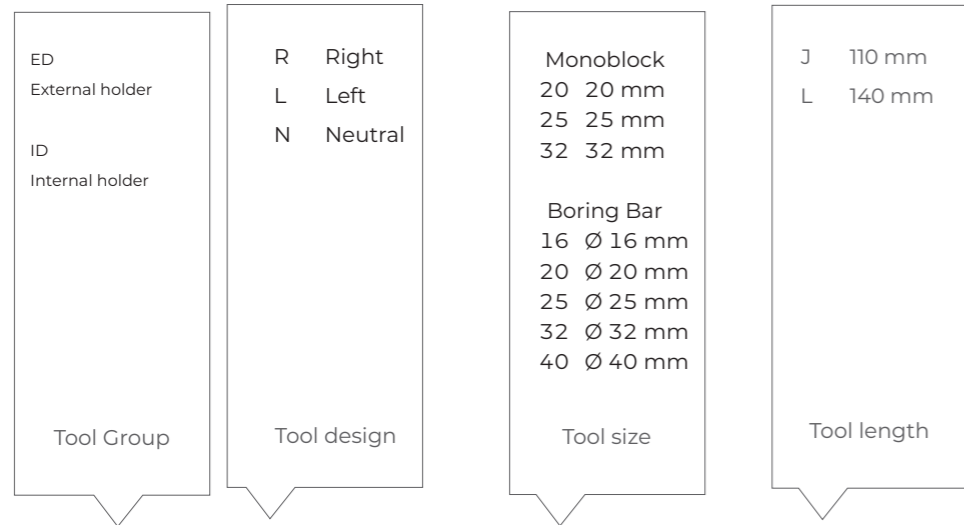
Designation system for moduls



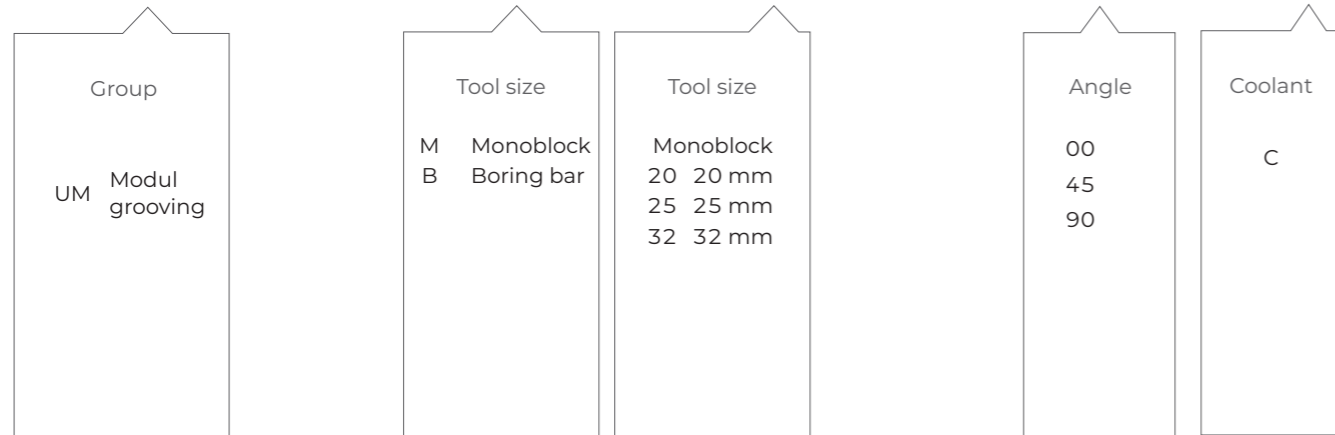
UM - E R 20 03 - UJ 24 - 03 C - 40-50 25



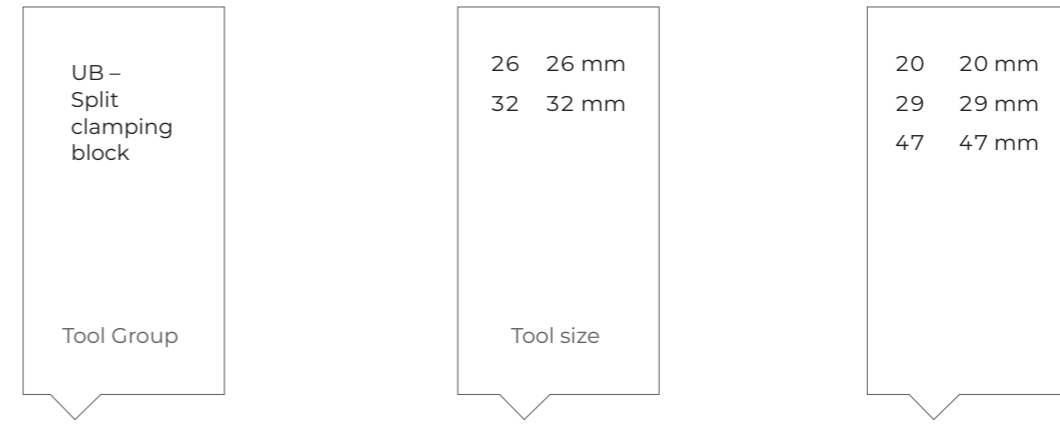
Designation system for module holders



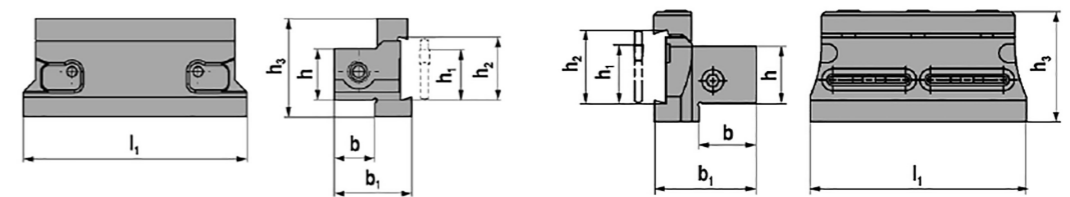
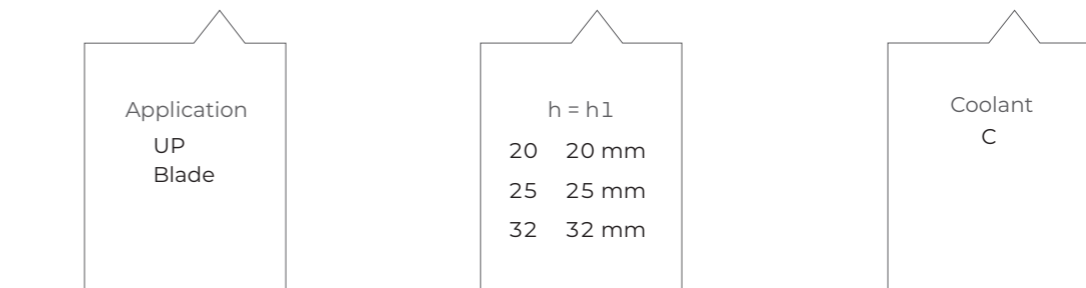
UM- ED R - M - 20 20 - J - 45 - C



Designation system for clamping blocks



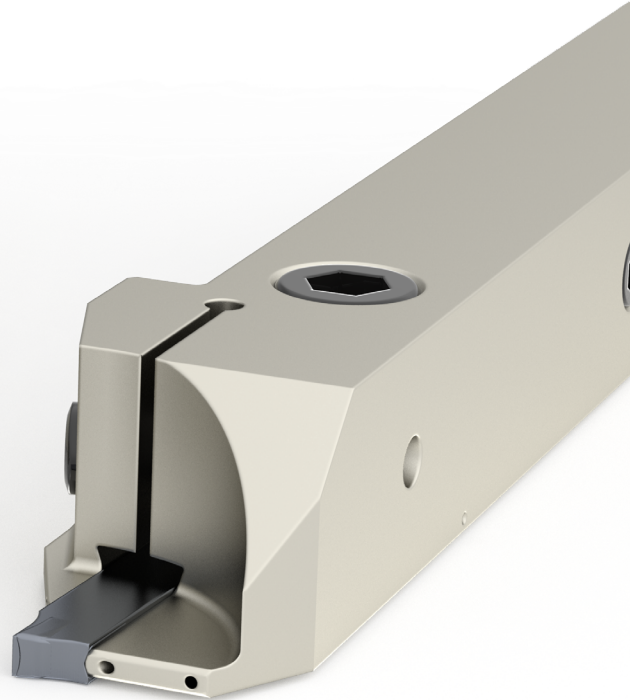
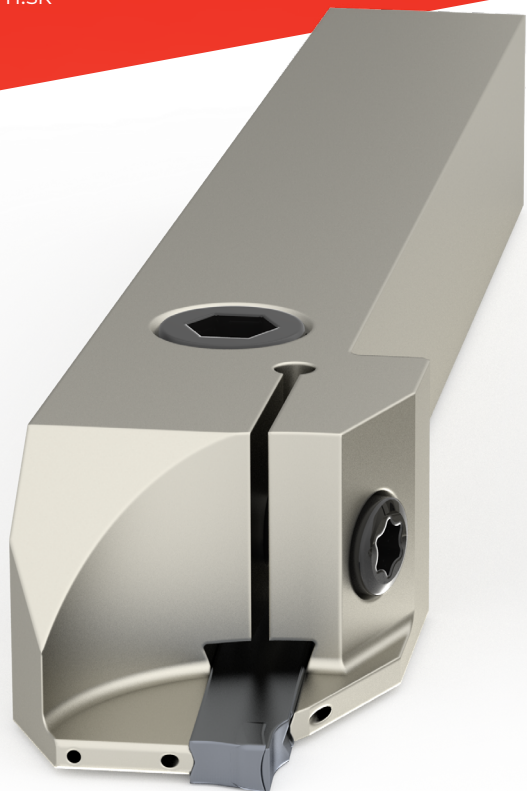
UB - UP 26 - 20 20 - C



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