

# T-Max Q-Cut®

## System with 1 cutting edge

Component diameter 6-32 mm

Complementary system for parting operations

A complementary system for CoroCut 123. Inserts with sharp, ground edge are used, generating low cutting forces when parting off small or thin walled components. Inserts with a large front angle available for pip and burr free machining.



### Inserts

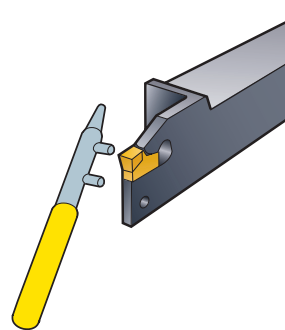
T-Max Q-Cut inserts are available in widths from 2 mm in neutral and right or left hand style.



### -5F geometry

Optimizer to minimize pips and burrs on components due to sharp cutting edge, with a wide choice of front angles.

Recommended for stainless steels, ductile and work hardening materials.

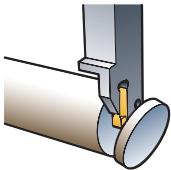


### Tool holders

The holder is equipped with a reinforced blade and is, together with the -5F insert geometry, mainly used for parting operations.

### First choice recommendation

#### Parting off



Insert: N151.2-200-5F 4125  
 Holder: R151.20-1212-20  
 Material: low alloy steel  
 $v_c$  m/min: 120  
 $f_r$  mm/rev: 0.08

For more specific cutting data, see pages F8, F9, F10

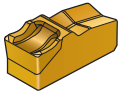
### Insert clamping

The insert is clamped with a spring clamp. For mounting and removing the insert a special key is used.

## Shank tools

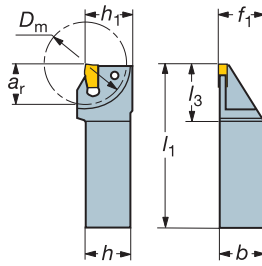
### Parting

#### T-Max Q-Cut spring clamp design



151.2

R/L151.20 Re-inforced



Right hand style shown

Main application	$D_m$ max	$a_r$ max	Seat size <sup>1)</sup>	Ordering code	Dimensions, mm						Gauge inserts
					$b$	$f_1$	$h$	$h_1$	$l_1$	$l_3$	
	13	6	20	R/L151.20-0808-20	8	8.25	8	12	120	11	N151.2-200- 5E
	20.6	10		R/L151.20-1010-20	10	10.25	10	12	120	13	N151.2-200- 5E
	30	15		R/L151.20-1212-20	12	12.25	12	12	150	20.5	N151.2-200- 5E
	30	15		R/L151.20-1612-20	12	12.25	16	16	150	20.5	N151.2-200- 5E
	30	15		R/L151.20-1616-20	16	16.25	16	16	150	20.5	N151.2-200- 5E
	30	15	25	R/L151.20-1212-25	12	12.25	12	12	150	20.5	N151.2-250- 5E
	30	15		R/L151.20-1616-25	16	16.25	16	16	150	20.5	N151.2-250- 5E
	30	15		R151.20-1612-25	12	12.25	16	12	150	20.5	N151.2-250- 5E
	35	17		R/L151.20-2012-25	12	12.25	20	20	125	26	N151.2-250- 5E
	35	17		R/L151.20-2020-25	20	20.25	20	20	125	26	N151.2-250- 5E
	35	17		R/L151.20-2525-25	25	25.3	25	25	150	31.8	N151.2-250- 5E
	35	17		R151.20-2016-25	16	16.25	20	20	125	26	N151.2-250- 5E

<sup>1)</sup> To correspond with seat size on insert.

R = Right hand, L = Left hand

#### Main spare parts

Seat size	Insert key <sup>2)</sup>
20-25	5680 057-021

<sup>2)</sup> To be ordered separately.

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General Information

EXTERNAL MACHINING T-Max Q-Cut®

Shank tools

Parting

For ISO application areas, see bottom of the page.

Tolerances, mm:  
la = +0.25  
re = ±0.05

	Selection criteria, mm				Seat size <sup>1)</sup>	Ordering code	P				M				S			
	la	ψr	re				GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC
Optimized	2.00	0°	0.2		20	N151.2-200-5F	☆	☆	☆	☆	★	★	★	★	★	★	★	
	2.00	5°	0.1			R/L151.2-200 05-5F	☆	☆	☆	☆	★	★	★	★	★	★	★	
	2.00	8°	0.1			R/L151.2-200 08-5F	☆	☆	☆	☆	★	★	★	★	★	★	★	
	2.00	12°	0.1			R/L151.2-200 12-5F	☆	☆	☆	☆	★	★	★	★	★	★	★	
	2.00	15°	0.1			R151.2-200 15-5F	☆	☆	☆	☆	★	★	★	★	★	★	★	
	2.00	15°	0.1			L151.2-200 15-5F	☆	☆	☆	☆	★	★	★	★	★	★	★	
	2.00	20°	0.1			R/L151.2-200 20-5F	☆	☆	☆	☆	★	★	★	★	★	★	★	
	2.50	0°	0.2		25	N151.2-250-5F	☆	☆	☆	☆	★	★	★	★	★	★	★	
	2.50	5°	0.1			R/L151.2-250 05-5F	☆	☆	☆	☆	★	★	★	★	★	★	★	
	2.50	8°	0.1			R/L151.2-250 08-5F	☆	☆	☆	☆	★	★	★	★	★	★	★	
	2.50	12°	0.1			R151.2-250 12-5F	☆	☆	☆	☆	★	★	★	★	★	★	★	
	2.50	12°	0.1			L151.2-250 12-5F	☆	☆	☆	☆	★	★	★	★	★	★	★	
	2.50	15°	0.1			R/L151.2-250 15-5F	☆	☆	☆	☆	★	★	★	★	★	★	★	
							P35	☆	☆	☆	☆	★	★	★	★	★	★	★
						P45	☆	☆	☆	☆	★	★	★	★	★	★	★	
						P30	☆	☆	☆	☆	★	★	★	★	★	★	★	
						M30	☆	☆	☆	☆	★	★	★	★	★	★	★	
						M40	☆	☆	☆	☆	★	★	★	★	★	★	★	
						M35	☆	☆	☆	☆	★	★	★	★	★	★	★	
						M25	☆	☆	☆	☆	★	★	★	★	★	★	★	
						S30	☆	☆	☆	☆	★	★	★	★	★	★	★	
						S40	☆	☆	☆	☆	★	★	★	★	★	★	★	
						S25	☆	☆	☆	☆	★	★	★	★	★	★	★	

<sup>1)</sup> To correspond with seat size on holder. N = Neutral, R = Right hand, L = Left hand  
★ = First choice

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