

Clamping Turning Tools

Info

18820 - 18829 -UNISIX- lathe tool product line type PM



The tried-and-proven turning tool product range for conventional centre turning machines.
For use with KOMET-UNISIX indexable inserts with a total of 6 cutting edges.
Mounting by means of a upside used special clamping screw.

18820 Offset Side-Turning Tool holder PM



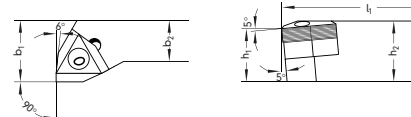
Type
Right-hand.

Note:
When using left-hand indexable inserts
the tool holder can be used for face
turning.

18820



Type	b ₂ x h ₂ x l ₁ mm	for Unisix insert	h ₁ mm	b ₁ mm	18820	...
PM 1/16	16 x 17,7 x 140	P1	15,7	19,8		201
PM 1	16 x 21,7 x 140	P1	19,7	19,8		202
PM 2	20 x 26,1 x 165	P2	23,7	24,0		203



18822 Spare Shims

Type	for tool holder	18822	...
16	PM 1/16		101
1	PM 1		102
2	PM 2		103



18822

18823 Spare clamping screws

Size	for tool holder	18823	...
M 4,5 x 14,5	PM 1/16		101
M 4,5 x 18,7	PM 1		102
M 4,5 x 22,5	PM 2		103



18823

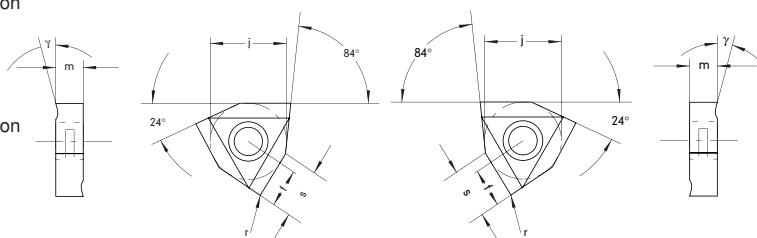
18828 - 18829 Carbide Indexable Inserts KOMET-UNISIX



Use
In tool holder cat. no. 18820. Designed as hexagonal indexable insert (84° point angle) with a total of 6 cutting edges. Indexable inserts with chip deflection steps have a positive rake angle of 18°, tool is mounted in the tool holder at an angle of 5° which means that a positive rake angle of 13° is obtained. (For long-chipping materials: steel, cast steel, etc.) One tool holder size can be used with all indexable inserts.

18828
With chip deflection
step, right-hand
positive.

18829
With chip deflection
step, left-hand
positive.



18828

18829

Insert size	j mm	s mm	m mm	f mm	g	r
P1/W04 42...	12,0	7,5	4,5	6,642	18°	0,2
P2/W04 50...	15,0	9,5	5,0	8,285	18°	0,4



18829

Clockwise Insert size	Carbide quality P 10	Carbide quality P 25		Carbide quality K 10		Carbide quality K 10			
		18828	18828	18828	18828	18828	18828		
P1/W04 42 480.02	10 pcs.		118		120		122		123
P2/W04 50 480.04	10 pcs.		126		128		130		

Counterclockwise Insert size	Carbide quality P 25		Carbide quality P 40		Carbide quality K 10		
	18829	18829	18829	18829	18829	18829	
P1/W04 42 180.02	10 pcs.		120		122		123
P2/W04 50 180.04	10 pcs.				130		

Info

18835 - 18841 Lathe tool holders product line

KOMET®

The state-of-the-art high-performance tool product range. With regular exchangeable tool supports, hardened, for compact, position-defined three-sided position of the indexable insert. Mainly used in conventional turning machines.
All clamping turning tools include tool supports and Torx clamping screw. Wrench and indexable insert not included.

18835

Clamping Turning Tools

KOMET®

Type

Setting angle 93°, right-hand.

Use

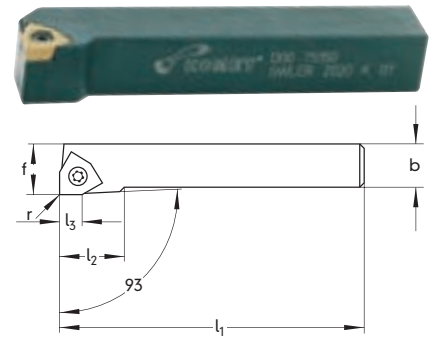
For Unisix indexable inserts, positive.

Note:

Spare clamping screw see cat. no. 18840.

18835

Designation	l ₁ mm	l ₂ mm	l ₃ mm	f mm	r mm	b mm	For indexable inserts	Spare Clamping screw	Right-hand	
									18835	...
SWLCR 1010 E05	70	15	5,3	12	0,2	10	W29.. 24..	N00 57511/T8	103	
SWLCR 1212 F05	80	18	5,3	16	0,2	12	W29.. 24..	N00 57511/T8	104	
SWLCR 1616 H06	100	20	6,6	20	0,2	16	W29.. 34..	N00 57521/T10	105	
SWLCR 2020 K07	125	24	7,9	25	0,2	20	W29.. 42..	N00 57531/T15	106	



18836

Clamping Turning Tools

KOMET®

Type

Setting angle 90°, right-hand.

Use

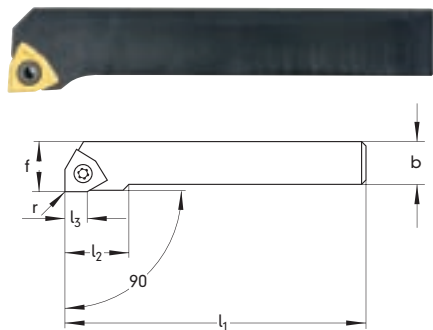
For Unisix indexable inserts, positive.

Note:

Spare clamping screw see cat. no. 18840.

18836

Designation	l ₁ mm	l ₂ mm	l ₃ mm	f mm	r mm	b mm	For indexable inserts	Spare Clamping screw	Right-hand	
									18836	...
SWGCR 1010 E05	70	15	5,3	12	0,2	10	W29.. 24..	N00 57511/T8	103	
SWGCR 1212 F05	80	19	5,3	16	0,2	12	W29.. 24..	N00 57511/T8	104	
SWGCR 1616 H06	100	20	6,6	20	0,2	16	W29.. 34..	N00 57521/T10	105	
SWGCR 2020 K07	125	25	7,9	25	0,2	20	W29.. 42..	N00 57531/T15	106	



18838

Clamping Turning Tools

KOMET®

Type

Setting angle 45°, right-hand.

Use

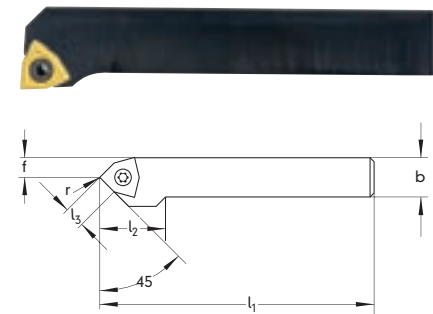
For Unisix indexable inserts, positive.

Note:

Spare clamping screw see cat. no. 18840.

18838

Designation	l ₁ mm	l ₂ mm	l ₃ mm	f mm	r mm	b mm	For indexable inserts	Spare Clamping screw	Right-hand	
									18838	...
SWDCR 1010 E05	70	17	5,3	5	0,2	10	W29.. 24..	N00 57511/T8	103	
SWDCR 1212 F05	80	18	5,3	6	0,2	12	W29.. 24..	N00 57511/T8	104	
SWDCR 1616 H06	100	23	6,6	8	0,2	16	W29.. 34..	N00 57521/T10	105	
SWDCR 2020 K07	125	10	7,9	10	0,2	20	W29.. 42..	N00 57531/T15	106	



18840

Spare clamping screws

KOMET®

Use

For KOMET clamping turning tool
cat. no. 18835 - 18838.

18840

Designation	Size		18840	...
N00 57511	M 2,5 x 7,2	10 pcs.	101	
N00 57521	M 3,5 x 7,3	10 pcs.	102	
N00 57531	M 4,5 x 9	10 pcs.	103	





18839 Clamping Turning Tools (Boring Bars)

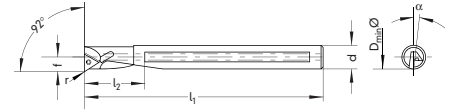
KOMET®

Type
Setting angle 92°, clockwise,
with internal coolant feed.

Use
For Unisix indexable inserts, positive.

Note:
Spare clamping screw see cat. no. 18841.

18839



Designation	Dmin mm	d mm	l1 mm	l2 mm	f mm	r mm	a	For indexable insert	Spare- Clamping screw	Right-hand	
										18839	...
UJ 0410 R	7,9	8	85	15	3,95	0,2	8° 30'	W30.. 04..	N00 56021/T6		102
UJ 0420 R	9,9	10	95	20	4,95	0,2	5° 30'	W30.. 04..	N00 56021/T6		103
UJ 0430 R	11,9	12	110	25	5,95	0,2	7° 30'	W30.. 14..	N00 56101/T8		104
UJ 0450 R	15,9	16	120	30	7,95	0,2	5°	W30.. 14..	N00 56101/T8		105

18841 Spare clamping screws

18939.

KOMET®

Use
For KOMET clamping turning tool (boring bars) cat.
no.

18841



Designation	Size		18841	...
N00 56021	M 2 x 3,6	10 pcs.		101
N00 56101	M 2,6 x 5,1	10 pcs.		102

Info 18842 - 18845 Indexable inserts Unisix

KOMET®

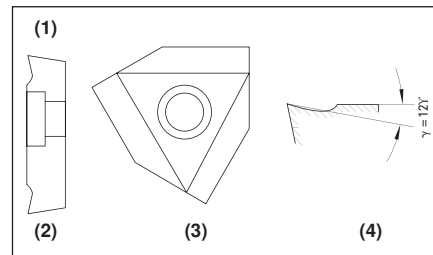
Made of carbide, regular type.
High-performance indexable inserts with 3 positive
ground chip forming steps. 8° clearance angle,
12° rake angle (a) and 84° point angle (at P 800).
Countersink mounting bolt. Free chip flow.

Carbide types: **P 25 M** uncoated, for machining steel

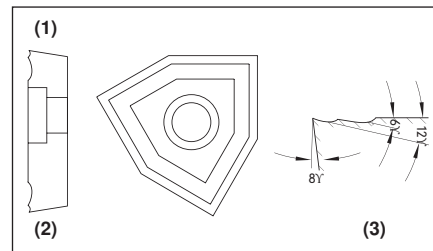
K 10 uncoated, for grey cast iron and non-ferrous metals

BK6425 TiN-coated for steel machining

BK7615 Coated, for grey cast iron and hardened steels



(1) P-tool,
(2) regular,
(3) right-hand cut,
(4) Chip deflection
step.



(1) P-tool,
(2) regular,
(3) Chip deflection
step.

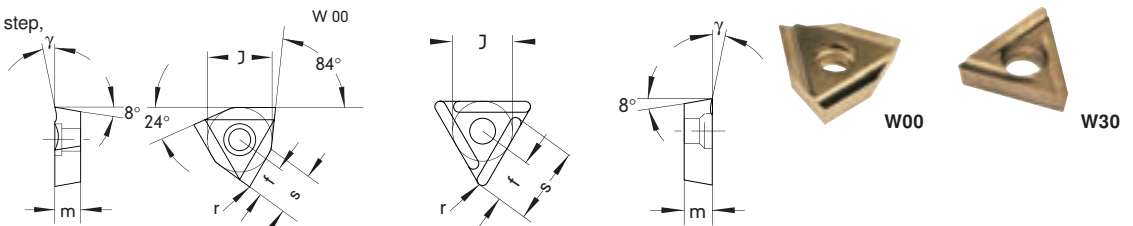
18842 Indexable inserts Unisix

KOMET®

Type
With ground chip deflection step,
right-hand.

W 30

18842



N P M K

Carbide type Insert size	J mm	m mm	s mm	f mm	r mm		Uncoated P 25 M		K 10		Coated BK6425	
							18842	...	18842	...	18842	...
W00 34420.02	10,0	3,0	6,6	5,531	0,2	10 pcs.		113		114		116
W00 42420.02	12,0	3,8	7,9	6,642	0,2	10 pcs.		123		124		126
W00 50420.04	15,0	4,3	9,9	8,285	0,4	10 pcs.		133		134		136
W30 04420.03	4,0	1,8	3,5	3,245	0,3	10 pcs.		143		144		146
W30 14420.04	5,6	2,5	4,5	4,557	0,4	10 pcs.		153		154		156

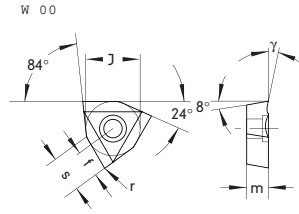


18843

Indexable inserts Unisix



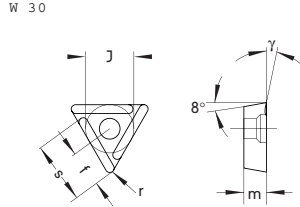
Type
With ground chip deflection step, left-hand.



18843



W00



W30



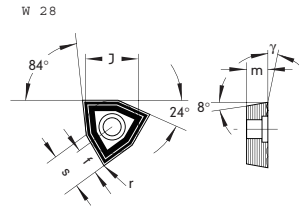
Carbide type Insert size	J mm	m mm	s mm	f mm	r mm		Uncoated P 25 M		K 10		Coated BK6425	
							18843	...	18843	...	18843	...
W00 34120.02	10,0	3,0	6,6	5,531	0,2	10 pcs.		113		114		116
W00 42120.02	12,0	3,8	7,9	6,642	0,2	10 pcs.		123		124		126
W00 50120.04	15,0	4,3	9,9	8,285	0,4	10 pcs.		133		134		136
W30 04120.03	4,0	1,8	3,5	3,245	0,3	10 pcs.		143		144		146
W30 14120.04	5,6	2,5	4,5	4,557	0,4	10 pcs.		153		154		156

18844

Indexable inserts Unisix



Type
with positive sintered-in steps,
cutting edge rounded, standard type.



18844



W28



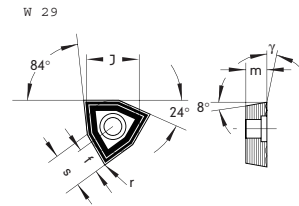
Carbide type Insert size	J mm	m mm	s mm	f mm	r mm		Uncoated P 25 M		K 10		Coated BK6425	
							18844	...	18844	...	18844	...
W28 34000.04	10,0	3,0	6,6	5,509	0,4	10 pcs.		113		114		116
W28 42000.04	12,0	3,8	7,9	6,619	0,4	10 pcs.		123		124		126
W28 50000.04	15,0	4,3	9,9	8,285	0,4	10 pcs.		133		134		136

18845

Indexable inserts Unisix



Type
With positive sintered-in step geometry, cutting
edges chamfered and rounded, reinforced type.



18845



W29

Carbide type Insert size	J mm	m mm	s mm	f mm	r mm		Uncoated P 25 M		Coated BK6425		Coated BK7615	
							18845	...	18845	...	18845	...
W29 24010.04	8,0	3,8	5,3	4,398	0,4	10 pcs.		103		104		105
W29 24010.04	8,0	3,8	5,3	4,398	0,4	10 pcs.		113		114		115
W29 34010.04	10,0	3,8	6,6	5,509	0,4	10 pcs.		117		118		119
W29 34010.04	10,0	3,8	6,6	5,509	0,4	10 pcs.		123		124		125
W29 42010.04	12,0	4,8	7,9	6,619	0,4	10 pcs.		127		128		129
W29 42010.08	12,0	4,8	7,9	6,575	0,8	10 pcs.		127		128		129
W29 42010.08	12,0	4,8	7,9	6,575	0,8	10 pcs.		127		128		129

Profiling turning tool

Info

18849 - 18854 Copying lathe tool product line JK

KOMET®

With accurately embedded profiling reversible cutting insert, precision-ground all round, matches tool holder profile on 2 sides. Guaranteed absolute stability of tool. High feed rates are possible. For external and internal profiling. All tool holders with TORX®-Plus clamping screw, without copying indexable insert and TORX® screwdriver.

18849

Internal Profiling Tool holders JK

KOMET®

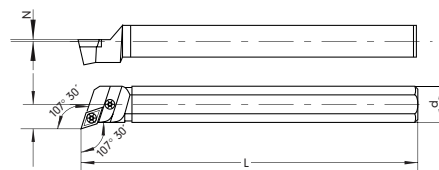
Type
Shape Z, 107° 30', right-hand.

Note:
Spare clamping screw
see cat. no. 18850.

18849



Type	Dmin mm	d mm	L mm	f mm	For indexable insert	Spare clamping Screw	18849	...
JK 55-10-Z-R	12	10	100	6,5	C1-551204L	S 2560-8 IP		101
JK 55-12-Z-R	16	12	125	9,0	C1-551204L	S 2560-8 IP		102
JK 55-16-Z-R	20	16	150	11,0	C1-551204L	S 2560-8 IP		103



18850

Spare Clamping Screws

Use
For KOMET copy turning tools program JK

18850



Designation	18850	...
S 2560-8 IP	10 pcs.	

18854

Profiling Indexable Inserts C1-55

KOMET®

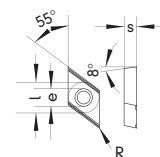
Type
Left-hand. Point angle 55°, rake angle 12°, clearance angle 8°. Precision-ground all round, therefore high cost-effectiveness and long service life. Two embedded edges in tool holder matches tool holder profile throughout.

N M K
Left-hand

18854



Insert size	Carbide Type	l mm	s mm	R mm	18854	...
C1-55 1204L	P25M	6,35	2,4	0,4	10 pcs.	
C1-55 1204L	K10	6,35	2,4	0,4	10 pcs.	
C1-55 1204L	BK/TiN	6,35	2,4	0,4	10 pcs.	



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Performance requires quality.

For example, with the diamond grinding wheels and CBN face wheels from ATORN.

- Longest service life with uniformly high stock removal rate
- Premium grinding wheels with vibration-damping body
- Universal implementation, wet grinding and dry grinding

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Performance requires quality.