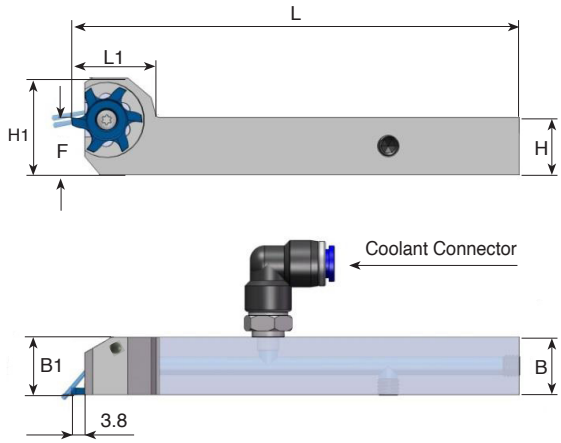
External Toolholders - For G6 Inserts

Coolant through toolholders, for external turning in Swiss type lathes machines. The high pressure coolant is directed towards the insert cutting edge in order to evacuate the chips created and avoid build up edge.
Includes a coolant connector for fast attachment on the machine.

Product Identification - Ordering Codes

G6	T	E	R	1212	K
G6 = Swiss toolholder	T =Type	E = External	R = Right Hand L = Left Hand	Shank Cross Section 1212 = 12x12 mm	Length of Toolholders K = 125 mm M = 150 mm



Right Version

Right hand cutting

Insert Type	Ordering Code	B	H	L1	L	H1	F	B1	Insert Screw Torx +	Torx + Key	**Coolant connector (mm)
G6	*G6ER 1212 K	12	12	20	125	23	12	16	S16LP	K16P	---
	G6ER 1616 K	16	16	20	125	27	16	16	S16LP	K16P	Ø4 / Ø6
	G6ER 2020 K	20	20	20	125	31	20	20	S16LP	K16P	Ø4 / Ø6
	G6ER 2525 M	25	25	20	150	36	25	25	S16LP	K16P	Ø4 / Ø6
TG6	*TG6ER 1212 K	12	12	20	125	23	12	18	S16LP	K16P	---
	TG6ER 1616 K	16	16	20	125	27	16	18	S16LP	K16P	Ø4 / Ø6
	TG6ER 2020 K	20	20	20	125	31	20	20	S16LP	K16P	Ø4 / Ø6
	TG6ER 2525 M	25	25	20	150	36	25	25	S16LP	K16P	Ø4 / Ø6

* Without internal coolant
** Coolant pipe diameter, standard packing with Ø4 mm
For L.H, specify G6EL instead of G6ER
Coated holders provide high abrasive resistance

G6 Inserts

Carbide Grades

BLU PVD triple layer coated Sub-Micron grade for Steel, Stainless Steels, Titanium and hard materials.

K20 Uncoated Sub-Micron carbide grade for Aluminum and non-ferrous materials, Stainless Steels and Titanium.

Cutting Data

ISO Standard	Material	Cutting Speed m/min	
		K20	BLU
P	Low and Medium Carbon Steels <0.55%C	-	80-150
	High Carbon Steels ≥0.55%C	-	70-120
	Alloy Steels,Treated Steels	-	40-80
M	Stainless Steel-Free Cutting	30-80	60-120
	Stainless Steel-Austenitic	20-70	30-90
	Cast Steels	30-80	50-120
K	Cast Iron	50-120	60-130
N	Aluminum ≤12%Si, Copper	120-250	-
	Aluminum >12%Si	90-200	-
	Synthetics, Duroplastics, Thermoplastics	70-150	-
S	Nickel Alloys, Titanium Alloys.	20-50	30-70
H	Hardened Steel, ≤45 HRc	-	20-50