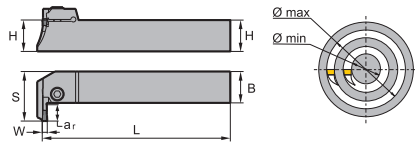
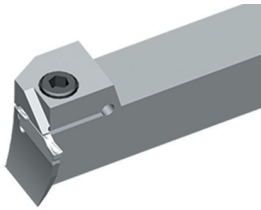


Parting & grooving tool holder (axial)

QF*DR/L



Right hand style

Article	*	Stock		Dimensions [mm]						Inserts
		R	L	HxB	L	S	W	ar _{max}	ØD (min-max)	
QFFD2020R/L10-48L	○ ○			20x20	150	31.5	3	10	48-66	Z*FD**
QFGD2020R/L10-52L	○ ○			20x20	150	31.5	4	10	52-72	Z*GD**
QFFD2020R/L10-74L	● ○			20x20	150	31.5	3	10	74-110	Z*FD**
QFGD2020R/L10-90L	● ○			20x20	150	31.5	4	10	90-140	Z*GD**
QFFD2020R/L10-100L	○ ○			20x20	150	31.5	3	10	100-150	Z*FD**
QFGD2020R/L15-52L	○ ○			20x20	150	36.5	4	15	52-72	Z*GD**
QFFD2525R/L10-48L	● ●			25x25	150	36.5	3	10	48-66	Z*FD**
QFFD2525R/L10-60L	● ○			25x25	150	36.5	3	10	60-80	Z*FD**
QFFD2525R/L10-74L	○ ○			25x25	150	36.5	3	10	74-110	Z*FD**
QFFD2525R/L10-100L	○ ○			25x25	150	36.5	3	10	100-150	Z*FD**
QFGD2525R/L13-52L	○ ○			25x25	150	39.5	4	13	52-72	Z*GD**
QFKD2525R/L13-60L	○ ○			25x25	150	39.5	6	13	60-100	Z*KD**
QFGD2525R/L13-64L	○ ●			25x25	150	39.5	4	13	64-100	Z*GD**
QFGD2525R/L13-90L	○ ○			25x25	150	39.5	4	13	90-140	Z*GD**
QFGD2525R/L13-130L	○ ○			25x25	150	39.5	4	13	130-230	Z*GD**
QFFD2525R/L17-48L	○ ○			25x25	150	43.5	3	17	48-66	Z*FD**
QFFD2525R/L17-60L	○ ○			25x25	150	43.5	3	17	60-80	Z*FD**
QFFD2525R/L17-74L	○ ○			25x25	150	43.5	3	17	74-110	Z*FD**
QFFD2525R/L17-100L	● ○			25x25	150	43.5	3	17	100-150	Z*FD**
QFGD2525R/L22-52L	○ ○			25x25	150	48.5	4	22	52-72	Z*GD**
QFKD2525R/L22-60L	○ ●			25x25	150	48.5	6	22	60-100	Z*KD**
QFGD2525R/L22-64L	○ ○			25x25	150	48.5	4	22	64-100	Z*GD**
QFKD2525R/L22-88L	○ ●			25x25	150	48.5	6	22	88-180	Z*KD**
QFGD2525R/L22-90L	○ ○			25x25	150	48.5	4	22	90-140	Z*GD**
QFGD2525R/L22-130L	● ○			25x25	150	48.5	4	22	130-230	Z*GD**
QFFD2020R/L7-74L	○			20x20	150	28.5	3	7	74-110	Z*FD**
QFFD2020R/L10-60L	●			20x20	150	31.5	3	10	60-80	Z*FD**
QFGD2020R/L10-130L	●			20x20	150	31.5	4	10	130-230	Z*GD**
QFGD2020R/L15-64L	○			20x20	150	36.5	4	15	64-100	Z*GD**
QFGD2020R/L15-90L	○			20x20	150	36.5	4	15	90-140	Z*GD**
QFGD2020R/L15-130L	○			20x20	150	36.5	4	15	130-230	Z*GD**
QFHD2525R/L13-58L	○			25x25	150	39.5	5	13	58-96	Z*HD**
QFHD2525R/L13-86L	●			25x25	150	39.5	5	13	86-140	Z*HD**
QFHD2525R/L13-130L	○ ○			25x25	150	39.5	5	13	130-200	Z*HD**
QFHD2525R/L13-185L	○			25x25	150	39.5	5	13	185-400	Z*HD**
QFHD2525R/L22-58L	○ ○			25x25	150	48.5	5	22	58-96	Z*HD**

System code > A422

Grade selection > A394

Technical info > A501

Cutting data > A456



A

Turning

B

Milling

C

Drilling

D


Technical Information

E

Index

A

Turning



Article	*	Stock		Dimensions [mm]						Inserts 
		R	L	HxB	L	S	W	ar _{max}	ØD (min-max)	
QFHD2525R/L22-86L		○	○	25x25	150	48.5	5	22	86-140	Z*HD**
QFHD2525R/L22-130L		○	○	25x25	150	48.5	5	22	130-200	Z*HD**
QFHD2525R/L22-185L		○	○	25x25	150	48.5	5	22	185-400	Z*HD**
QFKD2525R/L13-88L			○	25x25	150	39.5	6	13	88-180	Z*KD**

● Ex stock ○ On demand

* With internal cooling







B

Milling

Spare parts					
	Insert H	Z*FD** 20-25	Z*GD** 20-25	Z*HD** 20-25	Z*KD** 20-25
	Screw	GB70-85-M6x20 (7.0 Nm)	GB70-85-M6x20 (7.0 Nm)	GB70-85-M6x20 (7.0 Nm)	GB70-85-M6x20 (7.0 Nm)
	Wrench	W50RL	W50RL	W50RL	W50RL

C

Drilling

Insert					
					
A399	A400	A404	A407	A410	A411

D

Technical Information

E

Index

System code > A422

Grade selection > A394

Technical info > A501

Cutting data > A456

External tool holders

Q F G D 2525 R 22 (S) C – (130) (H)

1 2 3 4 5 6 7 8 9 10 11

Holder for parting & grooving

1

Application	
Code	Description
E	External machining
F	Axial machining

2

Insert seat size [mm]	
Holder/cutting width	
Code	Description
A	1,5
B	2,0
E	2,5
F	3,0
G	4,0
H	5,0
K	6,0
L	8,0

3

No. of cutting edges	
Code	Description
S	Single
D	Double

4

Cross section of holder [mm] x [mm]

5

Type	
Code	Description
R	Right
L	Left
N	Right and left

6

Max. cutting depth [mm]

7

Serie	
Code	Description
S	Swiss turning holder
DG	Cut-off holder for greater grooving depths with reinforcement
DGS	Cut-off holder for greater grooving depths without reinforcement

8

With internal cooling

9

Min. diameter of work piece for first axial grooving [mm]

10

Cutting head	
Code	Description
H	0°
L	90°

11