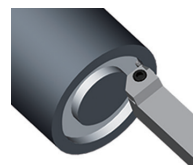
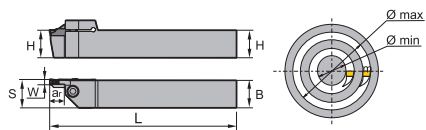
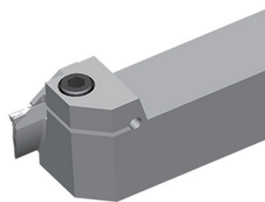


## Parting & grooving tool holder (axial)

QF\*SRR/LL



LL Version

| Article           | * | Stock |   | Dimensions [mm] |     |    |   |                   |                 | Inserts |
|-------------------|---|-------|---|-----------------|-----|----|---|-------------------|-----------------|---------|
|                   |   | R     | L | HxB             | L   | S  | W | ar <sub>max</sub> | ØD<br>(min-max) |         |
| QFHS2525LL30-185H | ● |       |   | 25x25           | 150 | 26 | 5 | 30                | 185-400         | Z*HS**  |
| QFHS2525RR30-185H | ○ |       |   | 25x25           | 150 | 26 | 5 | 30                | 185-400         | Z*HS**  |
| QFKS2525RR30-160H | ○ |       |   | 25x25           | 150 | 26 | 6 | 30                | 160-400         | Z*KS**  |
| QFKS2525LL30-160H | ○ |       |   | 25x25           | 150 | 26 | 6 | 30                | 160-400         | ZT*S**  |

● Ex stock ○ On demand

\* With internal cooling

### Spare parts

|  | Insert | Z*HS**                    | Z*KS**                    | ZT*S**                    |
|--|--------|---------------------------|---------------------------|---------------------------|
|  | H      | 25                        | 25                        | 25                        |
|  | Screw  | GB70-85-M6x20<br>(7.0 Nm) | GB70-85-M6x20<br>(7.0 Nm) | GB70-85-M6x20<br>(7.0 Nm) |
|  | Wrench | W50RL                     | W50RL                     | W50RL                     |

### Insert

|      |      |      |
|------|------|------|
|      |      |      |
| A402 | A405 | A406 |

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

|  |                    |                    |                              |             |
|--|--------------------|--------------------|------------------------------|-------------|
| <b>Holder for parting &amp; grooving</b> | <b>Application</b> |                    | <b>Insert seat size [mm]</b> |             |
|  | Code               | Description        | Holder/cutting width         |             |
|  | E                  | External machining | Code                         | Description |
|  | F                  | Axial machining    | A                            | 1,5         |
|  |                    |                    | B                            | 2,0         |
|  |                    |                    | E                            | 2,5         |
|  |                    |                    | F                            | 3,0         |
|  |                    |                    | G                            | 4,0         |
|  |                    |                    | H                            | 5,0         |
|  |                    |                    | K                            | 6,0         |
|  |                    |                    | L                            | 8,0         |
| <b>1</b>                                 | <b>2</b>           |                    | <b>3</b>                     |             |

|                             |             |  |             |             |
|-----------------------------|-------------|--|-------------|-------------|
| <b>No. of cutting edges</b> |             | <b>Cross section of holder [mm] x [mm]</b> | <b>Type</b> |             |
| Code                        | Description |  | Code        | Description |
| S                           | Single      |  | R           | Right       |
| D                           | Double      | L  | Left        |             |
| <b>4</b>                    |             | <b>5</b>                                   | <b>6</b>    |             |

|                                |              |  |
|--------------------------------|--------------|--|
| <b>Max. cutting depth [mm]</b> | <b>Serie</b> |  |
|                                | Code         | Description  |
|                                | S            | Swiss turning holder   |
|                                | DG           | Cut-off holder for greater grooving depths with reinforcement    |
| <b>7</b>                       | DGS          | Cut-off holder for greater grooving depths without reinforcement |
| <b>8</b>                       |              |  |

|                              |  |                     |             |
|------------------------------|--|---------------------|-------------|
| <b>With internal cooling</b> | <b>Min. diameter of work piece for first axial grooving [mm]</b> | <b>Cutting head</b> |             |
|                              |  | Code                | Description |
|                              |  | H                   | 0°          |
|                              |  | L                   | 90°         |
| <b>9</b>                     | <b>10</b>  | <b>11</b>           |             |

**A**

Turning

**B**

Milling

**C**

Drilling

**D**

Technical Information

**E**

Index