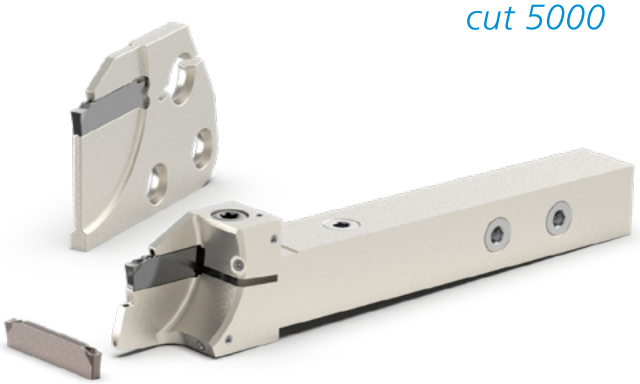
multidec®
cut 5000



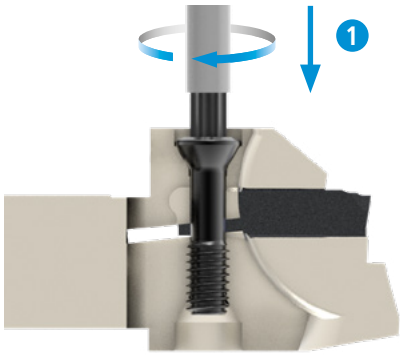
multidec®-CUT 5000

Grooving and parting tools
– *High performance parting tools*
– *Optimised for Swiss-type lathes*
– *Cutting edge widths of 1.5 / 2.0 / 3.0 mm*
– *4 chip breakers for every machining situation*
– *Parting diameter up to Ø65 mm*
– *Optimised holders design for vibration-free machining and long-lasting performance*
– *Direct coolant supply with multidec®-LUB*

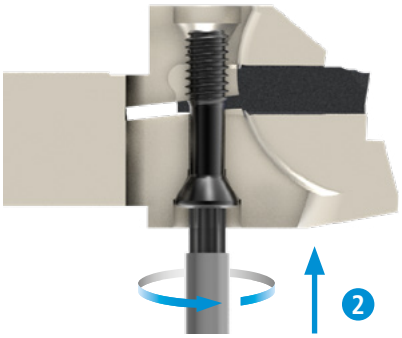


Mounting options

Depending on the machine configuration, the clamping screw can be mounted on the top 1 or bottom side 2, allowing easy access for changing the inserts.



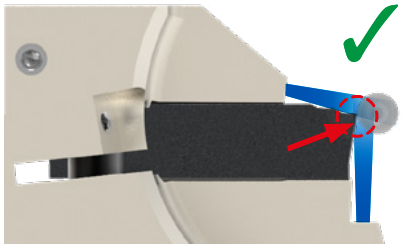
Top access



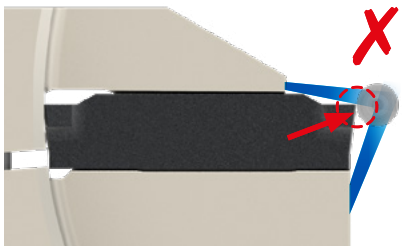
Bottom access

Targeted coolant

Both coolant outlets on chip breaker and on front relief are precisely targetting the cutting edge.



multidec®-CUT 5000
Even with very small diameters, the relief coolant hits precisely the cutting edge. Coolant on front relief allows tool life increase up to 150 %.



Competitors
The relief coolant is ineffective, especially when machining small diameters.



Tool holders with internal coolant "IC+" cutting width from 1.5 mm

Inserts for parting-off up to Ø 40 mm

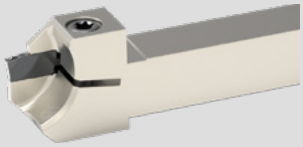
	GT20	Inserts with neutral cut	176
	C40	Inserts with neutral cut	177
	C60	Inserts with neutral cut	178
	C30	Inserts with left-hand / right-hand cut	179

Geometries



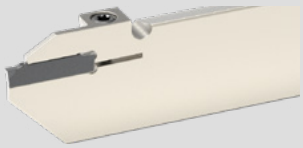
▶ 175

Holder for parting-off up to Ø 40 mm



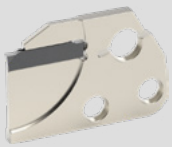
180–183

Cut-off blades



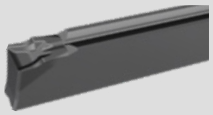
184–185

Modules for parting-off up to Ø 40 mm



186–189

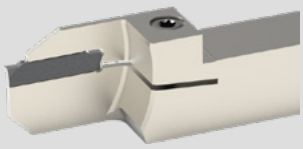
Inserts for parting-off up to Ø 65 mm

	C40	Inserts with neutral cut	191



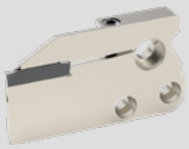
▶ 175

Holders for parting-off up to Ø 65 mm



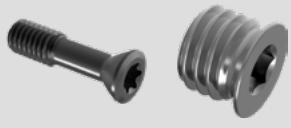
192–195

Modules for parting-off up to Ø 65 mm



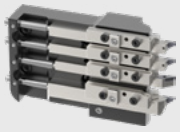
196

Replacement and spare parts



197

Designation system / Compatibility with multidec®-LUB



174

Designation system

Inserts

5002-2.0-EN C40 HMP725

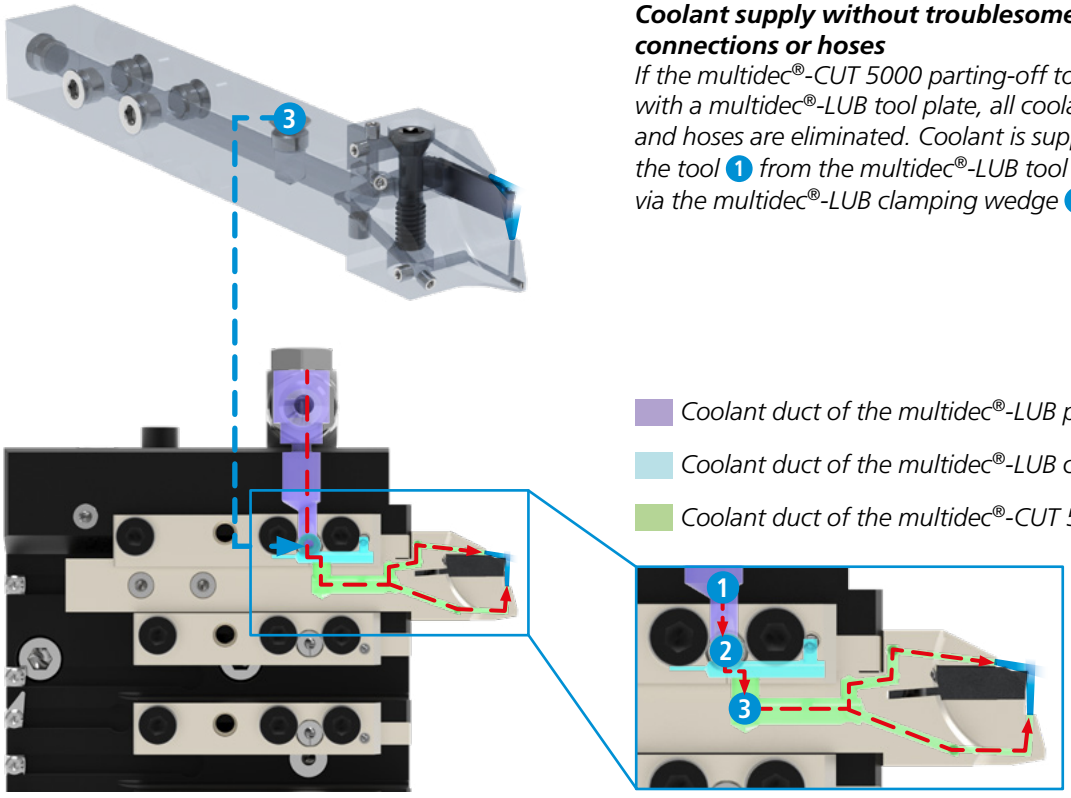
- 5002 — Product type
- 2.0 — Cutting edge geometry
- EN — Parting-off width (mm)
- C40 — Cutting edge type
- HMP725 — Chip breaker
- HM coated — Grade: HMP725 (HM coated)

Holders

5000-2.0-12x100 R 26 IC+

- 5000 — Product type
- 2.0 — Insert width (mm)
- 12x100 — Shank size (mm)
- R — Length (mm)
- 26 — Execution (L/R)
- IC+ — Max. parting-off diameter
- IC+ — IC+ with integrated cutting face and relief cooling

Compatibility with multidec®-LUB system

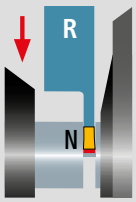


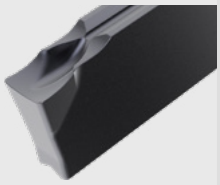
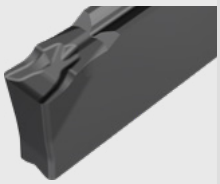
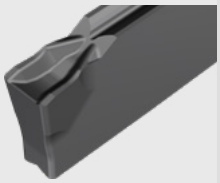
Coolant supply without troublesome connections or hoses

If the multidec®-CUT 5000 parting-off tool is combined with a multidec®-LUB tool plate, all coolant distributors and hoses are eliminated. Coolant is supplied directly to the tool (1) from the multidec®-LUB tool holder plate (2) via the multidec®-LUB clamping wedge (3).

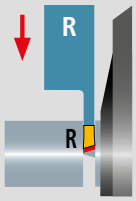
- *Coolant duct of the multidec®-LUB plate*
- *Coolant duct of the multidec®-LUB clamping wedge*
- *Coolant duct of the multidec®-CUT 5000 tool holder*

PARTING-OFF – NEUTRAL CUTTING EDGE

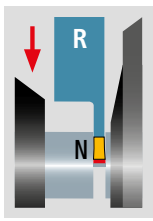


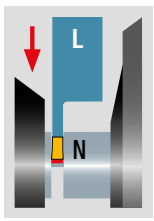
5002 **GT20** Neutral		– Very smooth cut, low cutting forces – Machining of sensitive parts and tubes – For sticky and difficult to cut materials	● ● ○ ○ ● –
5002 5002X **C40** Neutral		– Fine to medium cut – Excellent surface finish and chip control – Very universal use	● ● ● ○ ● –
5002 **C60** Neutral		– Medium to heavy cut – Excellent chip control – Very good resistance to interrupted cut	● ○ ● – – –

PARTING-OFF – L/R CUTTING EDGE



5002 **C30** L/R		– Fine to medium cut – For parting off without counter spindle – Good surface finish and chip control	● ● – – ● –



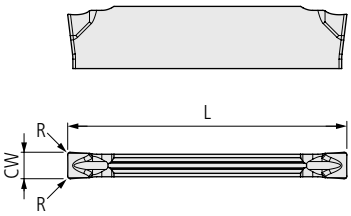






Very smooth cut, low cutting forces
Machining of sensitive parts and tubes
For sticky and difficult to cut materials





Cutting edge	Parting off width	Order designation	Grade		Dimensions					
			○ ● – ○ ● –	● ● ○ – ○ –						
	CW		HMP720	HMP735	CW ±0.04	R	L			
		Art. no.								
EN	1.5	5002-1.5-EN GT20 …	**553692**	**553693**	1.5	0.15	17.8			5000… 180
	2.0	5002-2.0-EN GT20 …	**553192**	**553194**	2.0	0.20	21.1			

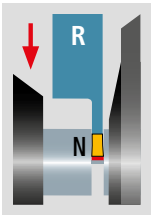
PVD	**HMP735**	– First choice for outstanding process reliability – Very suitable for difficult machining conditions with interrupted cut – AlTiN-based high-performance coating
PVD	**HMP720**	– Wear-resistant grade – Provides maximum tool life in abrasive materials – AlTiN-based high-performance coating

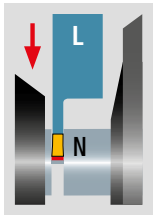
Note
Deppending on the holder, the double-sided two cuts parting-off inserts can be used up to Ø 40 mm.

Application range

	Cutting speeds v_c (m/min)	Feeds f (mm/rev) CW	
		1.5	2.0
P	80–160	0.02–0.10	0.02–0.12
M	70–140	0.02–0.08	0.02–0.10
K	90–150	0.03–0.10	0.04–0.12
N	120–300	0.03–0.12	0.04–0.15
S	50–90	0.02–0.08	0.02–0.10
H	–	–	–

Legend 212



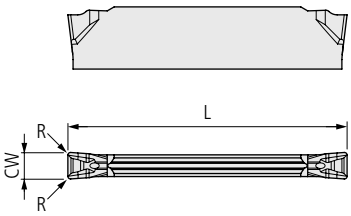






Fine to medium cut
Excellent surface finish and chip control
Very universal use





Cutting edge	Parting off width	Order designation	Grade			Dimensions			
			○ ● ○ ○ ● –	● ● ○ – ● –	● ○ ● – ○ –				
	CW		HMP715	HMP725	HMP835	CW ±0.04	R	L	
			Art. no.						
EN	1.5	5002-1.5-EN C40 …	**553674**	**553675**	**553676**	1.5	0.05	17.8	5000… » 180
	2.0	5002-2.0-EN C40 …	**553677**	**553681**	**553683**	2.0	0.2	21.1	
	3.0	5002-3.0-EN C40 …		**553688**	**553689**	3.0	0.2	21.1	

PVD	**HMP835**	– First choice for outstanding process reliability – Allows high speed and feed rate – Very suitable for difficult machining conditions with interrupted cut – Wear-resistant coating with high temperature resistance
PVD	**HMP725**	– Wear-resistant grade – Provides an outstanding tool life in difficult materials – AlTiN-based high-performance coating
PVD	**HMP715**	– Grade with very high wear resistance – Provides maximum tool life by optimal and stable machining conditions – AlTiN-based high-performance coating

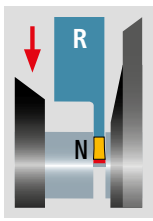
Note
Deppending on the holder, the double-sided two cuts parting-off inserts can be used up to Ø 40 mm.

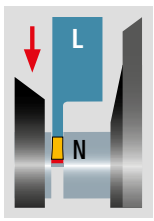
Application range

	Cutting speeds v_c (m/min)	Feeds f (mm/rev) CW 1.5	2.0	3.0
P	80–160	0.02–0.12	0.03–0.15	0.04–0.18
M	70–140	0.02–0.10	0.03–0.12	0.04–0.15
K	90–150	0.03–0.10	0.04–0.12	0.04–0.15
N	120–300	0.03–0.12	0.04–0.15	–
S	50–90	0.02–0.08	0.03–0.10	0.03–0.12
H	–	–	–	–

Legend 212

UTILIS multidec swiss type tools



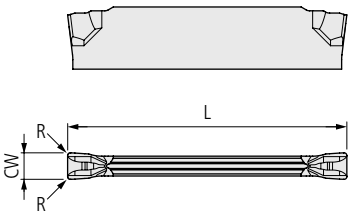






Medium to heavy cut
Excellent chip control
Very good resistance to interrupted cut





Cutting edge	Parting off width	Order designation	Grade			Dimensions			
			○ ● ○ – – –	● ● ● – – –	● ○ ● – – –				
	CW		HMP715	HMP725	HMP835	CW ±0.04	R	L	
			Art. no.						
EN	2.0	5002-2.0-EN C60 …	**553685**	**553686**	**553687**	2.0	0.2	21.1	5000… 180
	3.0	5002-3.0-EN C60 …		**553690**	**553691**	3.0	0.2	21.1	

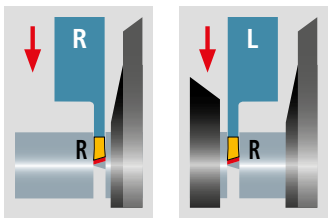
PVD	**HMP835**	– First choice for outstanding process reliability – Allows high speed and feed rate – Very suitable for difficult machining conditions with interrupted cut – Wear-resistant coating with high temperature resistance
PVD	**HMP725**	– Wear-resistant grade – Provides an outstanding tool life in difficult materials – AlTiN-based high-performance coating
PVD	**HMP715**	– Grade with very high wear resistance – Provides maximum tool life by optimal and stable machining conditions – AlTiN-based high-performance coating

Note
Deppending on the holder, the double-sided two cuts parting-off inserts can be used up to Ø 40 mm.

Application range

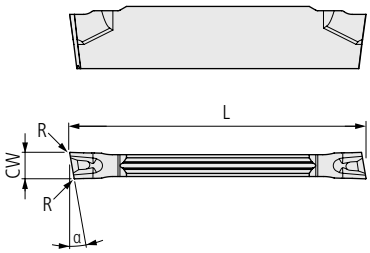
	Cutting speeds v_c (m/min)	Feeds f (mm/rev) CW	
		2.0	3.0
P	80–160	0.03–0.15	0.04–0.20
M	70–140	0.03–0.12	0.04–0.18
K	90–150	0.03–0.15	0.04–0.20
N	–	–	–
S	–	–	–
H	–	–	–

Legend 212



Fine to medium cut
For parting off without counter spindle
Good surface finish and chip control





Cutting edge	Parting off width	Order designation	Grade	Dimensions						
			● ● – – ● –							
	CW		HMP725	CW ±0.04	R	α	L			
			Art. no.							
EL	2.0	5002-2.0-EL-10 C30 …	565065	2.0	0.03	10°	22.4			5000… □ 180 »
		5002-2.0-EL-15 C30 …	565066	2.0	0.03	15°	22.4			
	3.0	5002-3.0-EL-10 C30 …	565068	3.0	0.03	10°	22.4			
		5002-3.0-EL-15 C30 …	565069	3.0	0.03	15°	22.4			
ER	2.0	5002-2.0-ER-10 C30 …	**556838**	2.0	0.03	10°	22.4			
		5002-2.0-ER-15 C30 …	**556839**	2.0	0.03	15°	22.4			
	3.0	5002-3.0-ER-10 C30 …	**556840**	3.0	0.03	10°	22.4			
		5002-3.0-ER-15 C30 …	**556841**	3.0	0.03	15°	22.4			

PVD	**HMP725**	– Wear-resistant grade – Provides an outstanding tool life in difficult materials – AlTiN-based high-performance coating

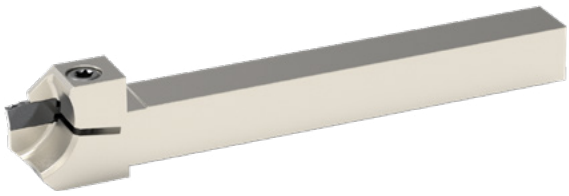
Note
Deppending on the holder, the double-sided two cuts parting-off inserts can be used up to Ø 40 mm.

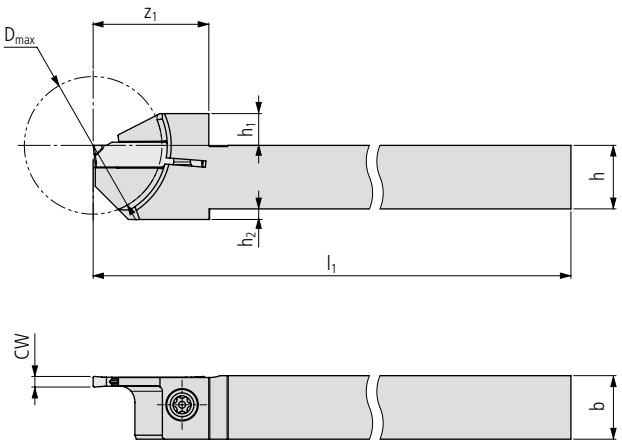
Application range

	Cutting speeds v_c (m/min)	Feeds f (mm/rev) CW	
		2.0	3.0
P	80–160	0.02–0.08	0.03–0.10
M	70–140	0.02–0.08	0.03–0.10
K	–	–	–
N	–	–	–
S	50–90	0.02–0.08	0.03–0.10
H	–	–	–

Legend 212

UTILIS multidec swiss type tools





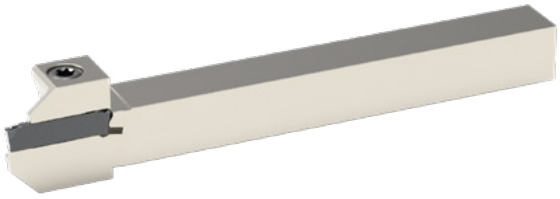
5000… L

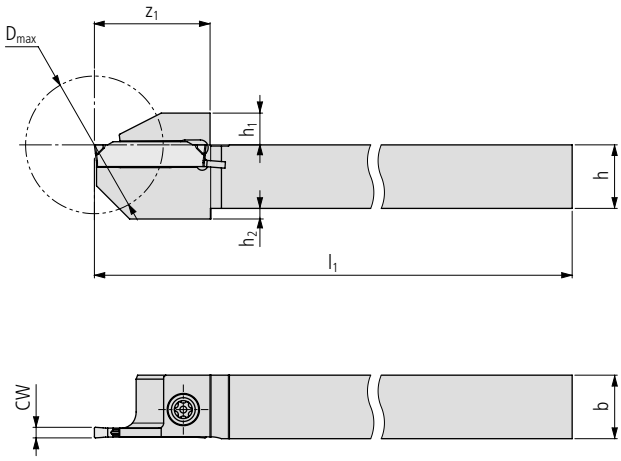
	Cutting width CW	Order designation	Art. no.	Dimensions h	b	l_1	D_{max}	z_1	h_1	h_2		
L	1.5	5000-1.5-08x100 L 16	**556563**	8	9	100	16	18	6	2		5002… 176 »
		5000-1.5-10x100 L 16	**556083**	10	10	100	16	18	6	2		
		5000-1.5-12x100 L 22	**553765**	12	12	100	22	20	6	2		
		5000-1.5-16x125 L 24	**556796**	16	16	125	24	22	6.5	0		
		5000-1.5-20x125 L 24	**563380**	20	20	125	24	22	6.5	0		
		5000-1.5-25x125 L 24	**563413**	25	25	125	24	22	6.5	0		
		5000-1.5-16x125 L 32	**565800**	16	16	125	32	26	6.5	0		
	2.0	5000-2.0-10x100 L 22	**556087**	10	10	100	22	22	6	2		
		5000-2.0-12x100 L 26	**556091**	12	12	100	26	22	6	2		
		5000-2.0-16x125 L 32	**556809**	16	16	125	32	27	6.5	0		
		5000-2.0-20x125 L 40	**556811**	20	20	125	40	31	6.5	0		
		5000-2.0-25x125 L 40	**563384**	25	25	125	40	31	6.5	0		
	3.0	5000-3.0-12x100 L 26	**556655**	12	12	100	26	22	6	2		
		5000-3.0-16x125 L 32	**556858**	16	16	125	32	27	6.5	0		
		5000-3.0-16x125 L 40	**553769**	16	16	125	40	31	6.5	0		
		5000-3.0-20x125 L 40	**556862**	20	20	125	40	31	6.5	0		
		5000-3.0-25x125 L 40	**563395**	25	25	125	40	31	6.5	0		

5000… L INCH

	Cutting width CW	Order designation	Art. no.	Dimensions h Inch	h mm	b	l_1	D_{max}	z_1	h_1	h_2	
L	1.5	5000-1.5-3/8"x100 L 16	**556590**	3/8"	9.525	9.525	100	16	18	6	2	5002… 176 »
		5000-1.5-1/2"x100 L 22	**556596**	1/2"	12.7	12.7	100	22	20	6	2	
		5000-1.5-5/8"x125 L 24	**556801**	5/8"	15.875	15.875	125	24	22	6.5	0	
	2.0	5000-2.0-3/8"x100 L 22	**556649**	3/8"	9.525	9.525	100	22	22	6	2	
		5000-2.0-1/2"x100 L 26	**556651**	1/2"	12.7	12.7	100	26	22	6	2	
		5000-2.0-5/8"x125 L 32	**556817**	5/8"	15.875	15.875	125	32	27	6.5	0	
		5000-2.0-3/4"x125 L 40	**556819**	3/4"	19.05	19.05	125	40	31	6.5	0	
	3.0	5000-3.0-1/2"x100 L 26	**556659**	1/2"	12.7	12.7	100	26	22	6	2	
		5000-3.0-5/8"x125 L 32	**556879**	5/8"	15.875	15.875	125	32	27	6.5	0	
		5000-3.0-5/8"x125 L 40	**556881**	5/8"	15.875	15.875	125	40	31	6.5	0	
		5000-3.0-3/4"x125 L 40	**556883**	3/4"	19.05	19.05	125	40	31	6.5	0	

Legend 212





5000… R

	Cutting width CW	Order designation		Dimensions h	b	l_1	D_{max}	z_1	h_1	h_2		
			Art. no.									
R	1.5	5000-1.5-08x100 R 16	**556562**	8	9	100	16	18	6	2		5002… 176 »
		5000-1.5-10x100 R 16	**556082**	10	10	100	16	18	6	2		
		5000-1.5-12x100 R 22	**553763**	12	12	100	22	20	6	2		
		5000-1.5-16x125 R 24	**556793**	16	16	125	24	22	6.5	0		
		5000-1.5-20x125 R 24	**563378**	20	20	125	24	22	6.5	0		
		5000-1.5-25x125 R 24	**559571**	25	25	125	24	22	6.5	0		
		5000-1.5-16x125 R 32	**565798**	16	16	125	32	26	6.5	0		
	2.0	5000-2.0-10x100 R 22	**556086**	10	10	100	22	22	6	2		
		5000-2.0-12x100 R 26	**556090**	12	12	100	26	22	6	2		
		5000-2.0-16x125 R 32	**556805**	16	16	125	32	27	6.5	0		
		5000-2.0-20x125 R 40	**556807**	20	20	125	40	31	6.5	0		
		5000-2.0-25x125 R 40	**563382**	25	25	125	40	31	6.5	0		
	3.0	5000-3.0-12x100 R 26	**556653**	12	12	100	26	22	6	2		
		5000-3.0-16x125 R 32	**556853**	16	16	125	32	27	6.5	0		
		5000-3.0-16x125 R 40	**553767**	16	16	125	40	31	6.5	0		
		5000-3.0-20x125 R 40	**556856**	20	20	125	40	31	6.5	0		
		5000-3.0-25x125 R 40	**563394**	25	25	125	40	31	6.5	0		

5000… R INCH

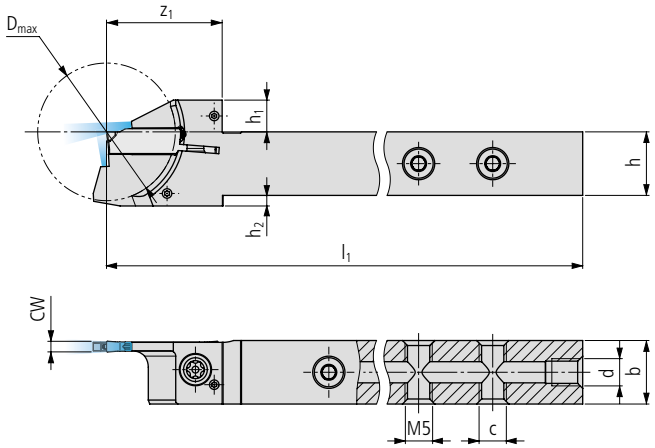
	Cutting width CW	Order designation		Dimensions h Inch	h mm	b	l_1	D_{max}	z_1	h_1	h_2	
			Art. no.									
R	1.5	5000-1.5-3/8"x100 R 16	**556575**	3/8"	9.525	9.525	100	16	18	6	2	5002… 176 »
		5000-1.5-1/2"x100 R 22	**556583**	1/2"	12.7	12.7	100	22	20	6	2	
		5000-1.5-5/8"x125 R 24	**556798**	5/8"	15.875	15.875	125	24	22	6.5	0	
	2.0	5000-2.0-3/8"x100 R 22	**556645**	3/8"	9.525	9.525	100	22	22	6	2	
		5000-2.0-1/2"x100 R 26	**556647**	1/2"	12.7	12.7	100	26	22	6	2	
		5000-2.0-5/8"x125 R 32	**556813**	5/8"	15.875	15.875	125	32	27	6.5	0	
		5000-2.0-3/4"x125 R 40	**556815**	3/4"	19.05	19.05	125	40	31	6.5	0	
	3.0	5000-3.0-1/2"x100 R 26	**556657**	1/2"	12.7	12.7	100	26	22	6	2	
		5000-3.0-5/8"x125 R 32	**556872**	5/8"	15.875	15.875	125	32	27	6.5	0	
		5000-3.0-5/8"x125 R 40	**556875**	5/8"	15.875	15.875	125	40	31	6.5	0	
		5000-3.0-3/4"x125 R 40	**556877**	3/4"	19.05	19.05	125	40	31	6.5	0	

Legend 212

UTILIS multidec® swiss type tools

IC+





5000… L IC+

	Cutting width CW	Order designation	Art. no.	Dimensions h	b	l_1	D_{max}	z_1	h_1	h_2	c	d	
L	1.5	5000-1.5-10x100 L 16 IC+	**554971**	10	11	100	16	18	6	2	M5	M5	5002… 176
		5000-1.5-12x100 L 22 IC+	**553766**	12	12	100	22	20	6	2	M5*	M5	
		5000-1.5-16x125 L 24 IC+	**556797**	16	16	125	24	22	6.5	0	M5*	G⅛"	
		5000-1.5-20x125 L 24 IC+	**563381**	20	20	125	24	22	6.5	0	M8×1	G⅛"	
		5000-1.5-25x125 L 24 IC+	**563414**	25	25	125	24	22	6.5	0	M8×1	G⅛"	
		5000-1.5-16x125 L 32 IC+	**565801**	16	16	125	32	26	6.5	0	M8×1	G⅛"	
	2.0	5000-2.0-10x100 L 22 IC+	**556085**	10	11	100	22	22	6	2	M5	M5	
		5000-2.0-12x100 L 26 IC+	**556089**	12	12	100	26	22	6	2	M8×1	M5	
		5000-2.0-16x125 L 32 IC+	**556810**	16	16	125	32	27	6.5	0	M8×1	G⅛"	
		5000-2.0-20x125 L 40 IC+	**556812**	20	20	125	40	31	6.5	0	M8×1	G⅛"	
		5000-2.0-25x125 L 40 IC+	**563385**	25	25	125	40	31	6.5	0	M8×1	G⅛"	
	3.0	5000-3.0-12x100 L 26 IC+	**556656**	12	12	100	26	22	6	2	M5*	M5	
		5000-3.0-16x125 L 32 IC+	**556860**	16	16	125	32	27	6.5	0	M5*	G⅛"	
		5000-3.0-16x125 L 40 IC+	**553770**	16	16	125	40	31	6.5	0	M5*	G⅛"	
		5000-3.0-20x125 L 40 IC+	**556863**	20	20	125	40	31	6.5	0	M5*	G⅛"	
		5000-3.0-25x125 L 40 IC+	**563397**	25	25	125	40	31	6.5	0	M8×1	G⅛"	

5000… L IC+ INCH

	Cutting width CW	Order designation	Art. no.	Dimensions h Inch	h mm	b	l_1	D_{max}	z_1	h_1	h_2	c	d	
L	1.5	5000-1.5-3/8"x100 L 16 IC+	**556594**	3/8"	9.525	11	100	16	18	6	2	M5	M5	5002… 176
		5000-1.5-1/2"x100 L 22 IC+	**556597**	1/2"	12.7	12.7	100	22	20	6	2	M8×1	M5	
		5000-1.5-5/8"x125 L 24 IC+	**556802**	5/8"	15.875	15.875	125	24	22	6.5	0	M8×1	G⅛"	
	2.0	5000-2.0-3/8"x100 L 22 IC+	**556650**	3/8"	9.525	11	100	22	22	6	2	M5	M5	
		5000-2.0-1/2"x100 L 26 IC+	**556652**	1/2"	12.7	12.7	100	26	22	6	2	M8×1	M5	
		5000-2.0-5/8"x125 L 32 IC+	**556818**	5/8"	15.875	15.875	125	32	27	6.5	0	M8×1	G⅛"	
		5000-2.0-3/4"x125 L 40 IC+	**556820**	3/4"	19.05	19.05	125	40	31	6.5	0	M8×1	G⅛"	
	3.0	5000-3.0-1/2"x100 L 26 IC+	**556661**	1/2"	12.7	12.7	100	26	22	6	2	M8×1	M5	
		5000-3.0-5/8"x125 L 32 IC+	**556880**	5/8"	15.875	15.875	125	32	27	6.5	0	M8×1	G⅛"	
		5000-3.0-5/8"x125 L 40 IC+	**556882**	5/8"	15.875	15.875	125	40	31	6.5	0	M8×1	G⅛"	
		5000-3.0-3/4"x125 L 40 IC+	**556884**	3/4"	19.05	19.05	125	40	31	6.5	0	M8×1	G⅛"	

* M8×1 by request

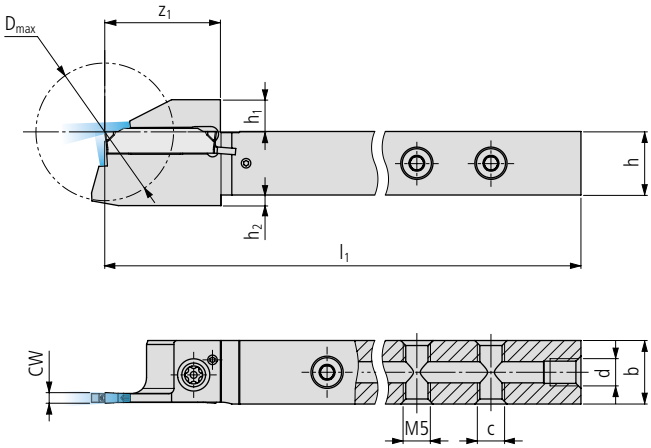
Scope of delivery: Holder without coolant connector

Legend 212

UTILIS multidec® swiss type tools

IC+





5000… R IC+

	Cutting width CW	Order designation	Art. no.	Dimensions h	b	l_1	D_{max}	z_1	h_1	h_2	c	d	
R	1.5	5000-1.5-10x100 R 16 IC+	**556081**	10	11	100	16	18	6	2	M5	M5	5002… 176
		5000-1.5-12x100 R 22 IC+	**553764**	12	12	100	22	20	6	2	M5*	M5	
		5000-1.5-16x125 R 24 IC+	**556794**	16	16	125	24	22	6.5	0	M5*	G⅛"	
		5000-1.5-20x125 R 24 IC+	**563379**	20	20	125	24	22	6.5	0	M8×1	G⅛"	
		5000-1.5-25x125 R 24 IC+	**563412**	25	25	125	24	22	6.5	0	M8×1	G⅛"	
		5000-1.5-16x125 R 32 IC+	**565799**	16	16	125	32	26	6.5	0	M8×1	G⅛"	
	2.0	5000-2.0-10x100 R 22 IC+	**556084**	10	11	100	22	22	6	2	M5	M5	
		5000-2.0-12x100 R 26 IC+	**556088**	12	12	100	26	22	6	2	M5*	M5	
		5000-2.0-16x125 R 32 IC+	**556806**	16	16	125	32	27	6.5	0	M5*	G⅛"	
		5000-2.0-20x125 R 40 IC+	**556808**	20	20	125	40	31	6.5	0	M8×1	G⅛"	
		5000-2.0-25x125 R 40 IC+	**563383**	25	25	125	40	31	6.5	0	M8×1	G⅛"	
	3.0	5000-3.0-12x100 R 26 IC+	**556654**	12	12	100	26	22	6	2	M5*	M5	
		5000-3.0-16x125 R 32 IC+	**556854**	16	16	125	32	27	6.5	0	M5*	G⅛"	
		5000-3.0-16x125 R 40 IC+	**553768**	16	16	125	40	31	6.5	0	M5*	G⅛"	
		5000-3.0-20x125 R 40 IC+	**556857**	20	20	125	40	31	6.5	0	M5*	G⅛"	
		5000-3.0-25x125 R 40 IC+	**558022**	25	25	125	40	31	6.5	0	M8×1	G⅛"	

5000… R IC+ INCH

	Cutting width CW	Order designation	Art. no.	Dimensions h Inch	h mm	b	l_1	D_{max}	z_1	h_1	h_2	c	d	
R	1.5	5000-1.5-3/8"x100 R 16 IC+	**556579**	3/8"	9.525	11	100	16	18	6	2	M5	M5	5002… 176
		5000-1.5-1/2"x100 R 22 IC+	**556584**	1/2"	12.7	12.7	100	22	20	6	2	M8×1	M5	
		5000-1.5-5/8"x125 R 24 IC+	**556800**	5/8"	15.875	15.875	125	24	22	6.5	0	M8×1	G⅛"	
	2.0	5000-2.0-3/8"x100 R 22 IC+	**556646**	3/8"	9.525	11	100	22	22	6	2	M5	M5	
		5000-2.0-1/2"x100 R 26 IC+	**556648**	1/2"	12.7	12.7	100	26	22	6	2	M8×1	M5	
		5000-2.0-5/8"x125 R 32 IC+	**556814**	5/8"	15.875	15.875	125	32	27	6.5	0	M8×1	G⅛"	
		5000-2.0-3/4"x125 R 40 IC+	**556816**	3/4"	19.05	19.05	125	40	31	6.5	0	M8×1	G⅛"	
	3.0	5000-3.0-1/2"x100 R 26 IC+	**556658**	1/2"	12.7	12.7	100	26	22	6	2	M8×1	M5	
		5000-3.0-5/8"x125 R 32 IC+	**556873**	5/8"	15.875	15.875	125	32	27	6.5	0	M8×1	G⅛"	
		5000-3.0-5/8"x125 R 40 IC+	**556876**	5/8"	15.875	15.875	125	40	31	6.5	0	M8×1	G⅛"	
		5000-3.0-3/4"x125 R 40 IC+	**556878**	3/4"	19.05	19.05	125	40	31	6.5	0	M8×1	G⅛"	

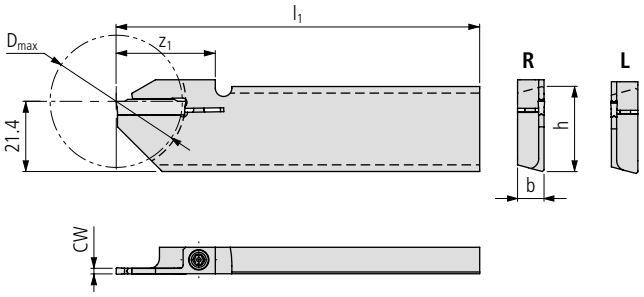
* M8×1 by request

Scope of delivery: Holder without coolant connector

Legend 212

UTILIS multidec swiss type tools



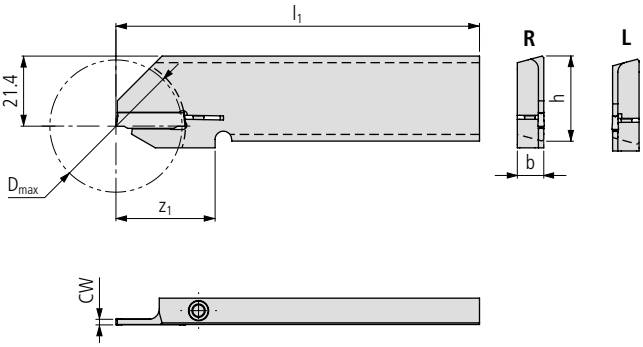


	Cutting width CW	Order designation	Art. no.	Dimensions h	b	l_1	D_{max}	z_1				
L	1.5	5000-1.5-S2608x110 L 32	565476	26	8	110	32	25.5				5002... 176 »
	2.0	5000-2.0-S2608x110 L 40	565472	26	8	110	40	30				
R	1.5	5000-1.5-S2608x110 R 32	565475	26	8	110	32	25.5				
	2.0	5000-2.0-S2608x110 R 40	565471	26	8	110	40	30				

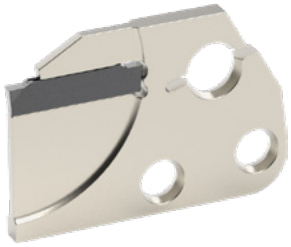
Legend 212

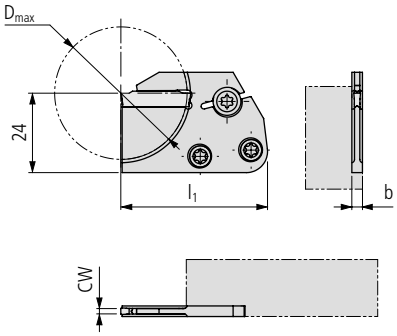
UTILIS multidec® swiss type tools





	Cutting width CW	Order designation	Art. no.	Dimensions h	b	l_1	D_{max}	z_1				
L	1.5	5000-1.5-SU2608x110 L 32	565483	26	8	110	32	25.5				5002... 176 »
	2.0	5000-2.0-SU2608x110 L 40	565474	26	8	110	40	30				
R	1.5	5000-1.5-SU2608x110 R 32	565481	26	8	110	32	25.5				
	2.0	5000-2.0-SU2608x110 R 40	565473	26	8	110	40	30				





	Cutting width CW	Order designation	Art. no.	Dimensions l_1	b	D_{max}				
N	1.5	5000-1.5-MA3.2x41 N 32	564621	41	3.2	32				5002… 176
	2.0	5000-2.0-MA3.2x45 N 40	565353	45	3.2	40				
	3.0	5000-3.0-MA3.2x45 N 40	565354	45	3.2	40				

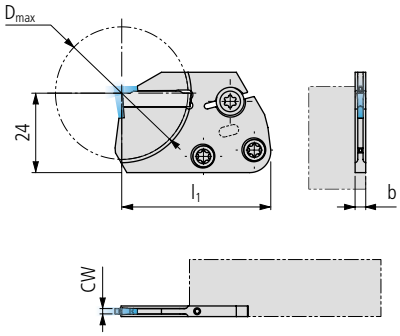
Scope of delivery: Module without mounting screws

Note
Compatible with different holder systems for multi spindle automatic lathes such as Göltenbodt systems.

Legend 212

IC+





	Cutting width CW	Order designation	Art. no.	Dimensions l1	b	Dmax				
L	1.5	5000-1.5-MA3.2x42 L 32 IC+	568781	42	3.2	32				5002… 176 »
	2.0	5000-2.0-MA3.2x45 L 40 IC+	568783	45	3.2	40				
	3.0	5000-3.0-MA3.2x45 L 40 IC+	568788	45	3.2	40				
R	1.5	5000-1.5-MA3.2x42 R 32 IC+	568780	42	3.2	32				
	2.0	5000-2.0-MA3.2x45 R 40 IC+	568782	45	3.2	40				
	3.0	5000-3.0-MA3.2x45 R 40 IC+	568787	45	3.2	40				

Scope of delivery: Module without mounting screws

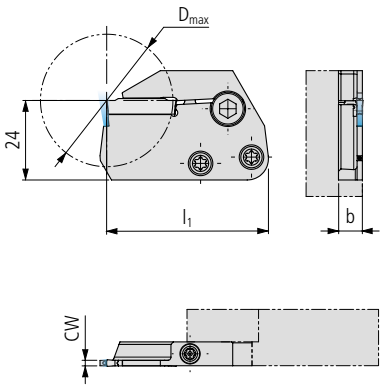
Note
Compatible with different holder systems for multi spindle automatic lathes such as Göltenbodt systems.

Legend 212

UTILIS multidec® swiss type tools

IC





	Cutting width CW	Order designation	Art. no.	Dimensions l_1	b	D_{max}				
L	1.5	5000-1.5-MA7.2x45.5 L 32 IC-C	565312	45.5	7.2	32				5002… 176 »
	2.0	5000-2.0-MA7.2x48.9 L 40 IC-C	565342	48.85	7.2	40				
	3.0	5000-3.0-MA7.2x48.9 L 40 IC-C	565352	48.85	7.2	40				
R	1.5	5000-1.5-MA7.2x45.5 R 32 IC-C	565311	45.5	7.2	32				
	2.0	5000-2.0-MA7.2x48.9 R 40 IC-C	565334	48.85	7.2	40				
	3.0	5000-3.0-MA7.2x48.9 R 40 IC-C	565350	48.85	7.2	40				

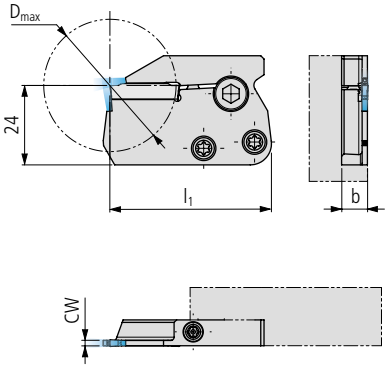
Scope of delivery: Module without mounting screws

Note
Compatible with different holder systems for multi spindle automatic lathes such as Göltenbodt systems.

Legend 212

IC+



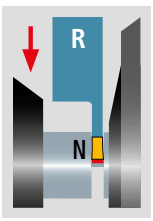


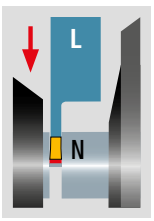
	Cutting width CW	Order designation	Art. no.	Dimensions l_1	b	D_{max}				
L	1.5	5000-1.5-MB7.2x45.5 L 32 IC+	565310	45.5	7.2	32				5002… 176 »
	2.0	5000-2.0-MB7.8x48.9 L 40 IC+	565329	48.85	7.8	40				
	3.0	5000-3.0-MB7.8x48.9 L 40 IC+	564224	48.85	7.8	40				
R	1.5	5000-1.5-MB7.2x45.5 R 32 IC+	564219	45.5	7.2	32				
	2.0	5000-2.0-MB7.8x48.9 R 40 IC+	564222	48.85	7.8	40				
	3.0	5000-3.0-MB7.8x48.9 R 40 IC+	564223	48.85	7.8	40				

Scope of delivery: Module without mounting screws

Note
Compatible with different holder systems for multi spindle automatic lathes such as Göltenbodt systems.

5002X… EN C40 (for > Ø 40 mm)





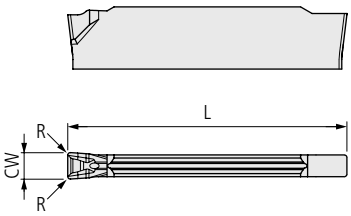
HM

E

Fine to medium cut
Excellent surface finish and chip control
Very universal use

Note
One-sided parting-off insert for diameter over Ø 40 mm.





Cutting edge	Parting off width	Order designation	Grade	Dimensions							
			● ○ ● – ○ –								
	CW		HMP835	CW ±0.04	R	L					
			Art. no.								
EN	2.0	5002X-2.0-EN C40 …	565445	2.0	0.2	21.1					5000… 192
	3.0	5002X-3.0-EN C40 …	565452	3.0	0.2	21.1					

PVD **HMP835**

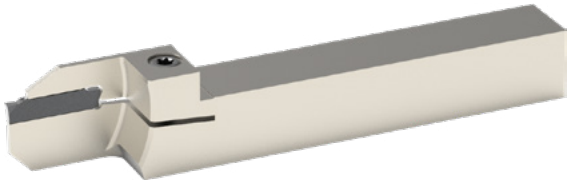
– First choice for outstanding process reliability
– Allows high speed and feed rate
– Very suitable for difficult machining conditions with interrupted cut
– Wear-resistant coating with high temperature resistance

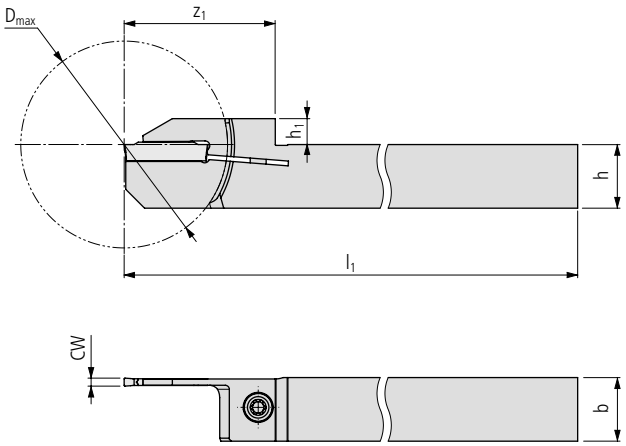
Application range

	Cutting speeds v_c (m/min)	Feeds f (mm/rev) CW	
		2.0	3.0
P	80–160	0.03–0.15	0.04–0.18
M	70–140	0.03–0.12	0.04–0.15
K	90–150	0.04–0.12	0.04–0.15
N	120–300	0.04–0.15	–
S	50–90	0.03–0.10	0.03–0.12
H	–	–	–

Legend 212

UTILIS multidec swiss type tools





5000… L

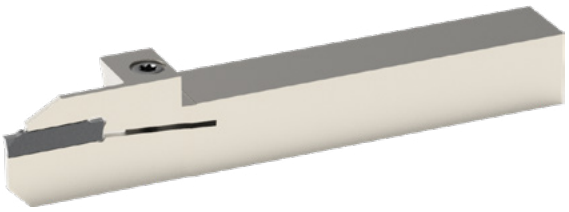
	Cutting width CW	Order designation	Art. no.	Dimensions h	b	l_1	D_{max}	z_1	h_1			
L	2.0	5000-2.0-16x125 L 52	565686	16	16	125	52	38	6.5			5002… 176-179, 191
		5000-2.0-20x125 L 65	565687	20	20	125	65	44	6.5			
		5000-2.0-25x125 L 65	565688	25	25	125	65	44	6.5			
	3.0	5000-3.0-20x125 L 65	565670	20	20	125	65	46	6.5			
		5000-3.0-25x125 L 65	565672	25	25	125	65	46	6.5			

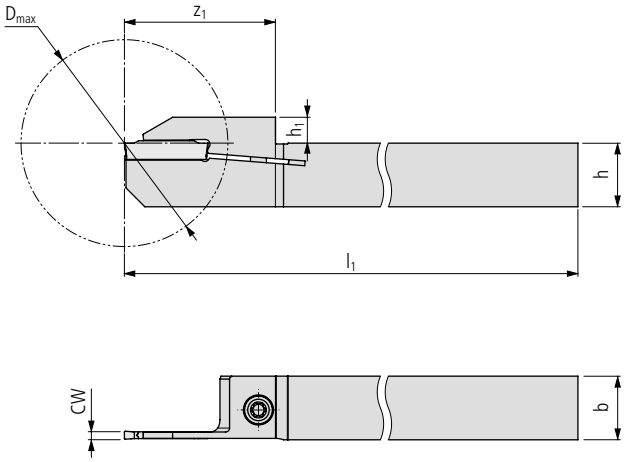
5000… L INCH

	Cutting width CW	Order designation	Art. no.	Dimensions h Inch	h mm	b	l_1	D_{max}	z_1	h_1		
L	2.0	5000-2.0-3/4"x125 L 65	565691	3/4"	19.05	19.05	125	65	44	6.5		5002… 176-179, 191
		5000-2.0-1"x125 L 65	565692	1"	25.4	25.4	125	65	44	6.5		
	3.0	5000-3.0-3/4"x125 L 65	565678	3/4"	19.05	19.05	125	65	46	6.5		
		5000-3.0-1"x125 L 65	565680	1"	25.4	25.4	125	65	46	6.5		

Note
Cutting edges of type 5002X must be used for parting-off over Ø 40 mm.

Legend 212





5000… R

	Cutting width CW	Order designation	Art. no.	Dimensions h	b	l_1	D_{max}	z_1	h_1			
R	2.0	5000-2.0-16x125 R 52	565682	16	16	125	52	38	6.5			5002… 176-179, 191
		5000-2.0-20x125 R 65	565683	20	20	125	65	44	6.5			
		5000-2.0-25x125 R 65	565685	25	25	125	65	44	6.5			
	3.0	5000-3.0-20x125 R 65	565665	20	20	125	65	46	6.5			
		5000-3.0-25x125 R 65	565668	25	25	125	65	46	6.5			

5000… R INCH

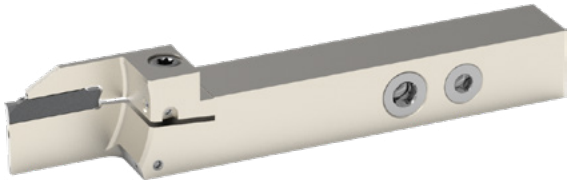
	Cutting width CW	Order designation	Art. no.	Dimensions h Inch	h mm	b	l_1	D_{max}	z_1	h_1		
R	2.0	5000-2.0-3/4"x125 R 65	565689	3/4"	19.05	19.05	125	65	44	6.5		5002… 176-179, 191
		5000-2.0-1"x125 R 65	565690	1"	25.4	25.4	125	65	44	6.5		
	3.0	5000-3.0-3/4"x125 R 65	565674	3/4"	19.05	19.05	125	65	46	6.5		
		5000-3.0-1"x125 R 65	565676	1"	25.4	25.4	125	65	46	6.5		

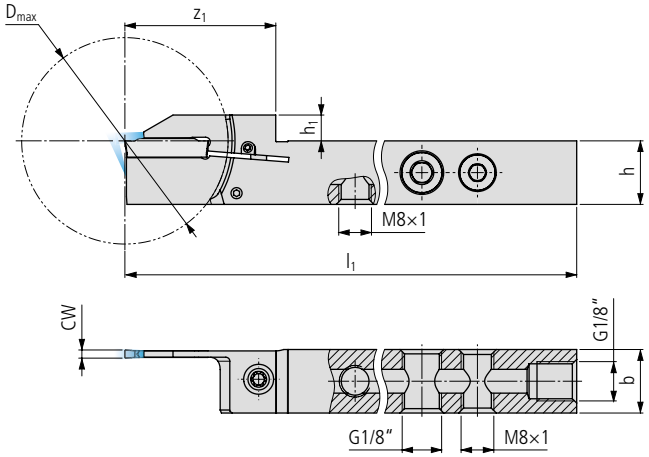
Note
Cutting edges of type 5002X must be used for parting-off over Ø 40 mm.

Legend 212

UTILIS multidec swiss type tools

IC+





5000… L IC+

	Cutting width CW	Order designation	Art. no.	Dimensions h	b	l_1	D_{max}	z_1	h_1				
L	3.0	5000-3.0-20x125 L 65 IC+	565669	20	20	125	65	44	6.5				5002… 176-179, 191
		5000-3.0-25x125 L 65 IC+	565671	25	25	125	65	44	6.5				

5000… L IC+ INCH

	Cutting width CW	Order designation	Art. no.	Dimensions h Inch	h mm	b	l_1	D_{max}	z_1	h_1				
L	3.0	5000-3.0-3/4"x125 L 65 IC+	565677	3/4"	19.05	19.05	125	65	44	6.5				5002… 176-179, 191
		5000-3.0-1"x125 L 65 IC+	565679	1"	25.4	25.4	125	65	44	6.5				

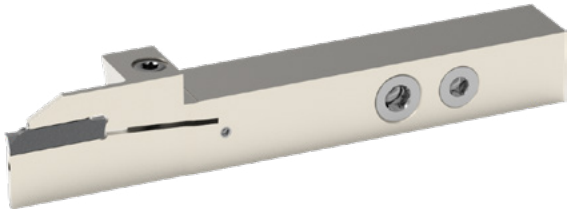
Scope of delivery: Holder without coolant connector

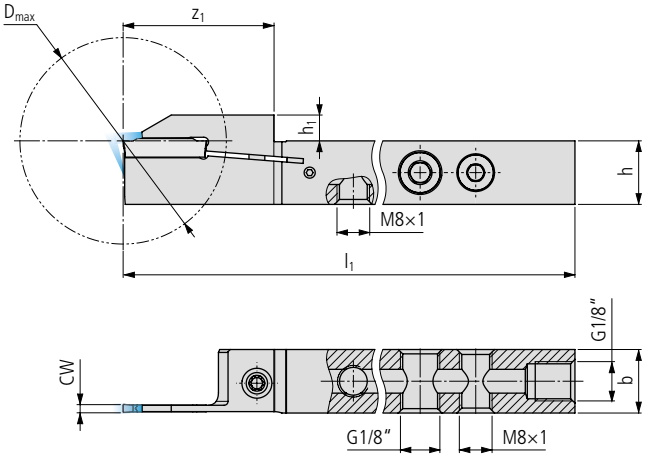
Note
Cutting edges of type 5002X must be used for parting-off over Ø 40 mm.

Legend 212

UTILIS multidec swiss type tools

IC+





5000… R IC+

	Cutting width CW	Order designation	Art. no.	Dimensions h	b	l_1	D_{max}	z_1	h_1				
R	3.0	5000-3.0-20x125 R 65 IC+	565663	20	20	125	65	44	6.5				5002… 176-179, 191
		5000-3.0-25x125 R 65 IC+	563931	25	25	125	65	44	6.5				

5000… R IC+ INCH

	Cutting width CW	Order designation	Art. no.	Dimensions h Inch	h mm	b	l_1	D_{max}	z_1	h_1				
R	3.0	5000-3.0-3/4"x125 R 65 IC+	565673	3/4"	19.05	19.05	125	65	44	6.5				5002… 176-179, 191
		5000-3.0-1"x125 R 65 IC+	565675	1"	25.4	25.4	125	65	44	6.5				

Scope of delivery: Holder without coolant connector

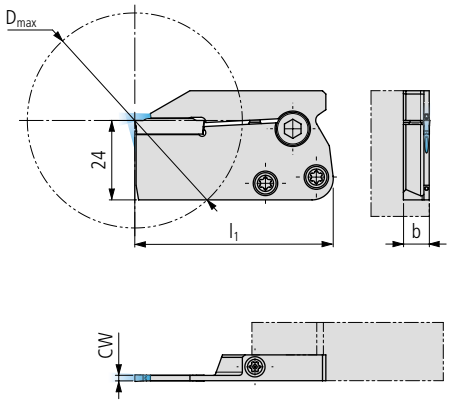
Note
Cutting edges of type 5002X must be used for parting-off over Ø 40 mm.

Legend 212

UTILIS multidec® swiss type tools

IC+





	Cutting width CW	Order designation	Art. no.	Dimensions l_1	b	D_{max}				
L	2.0	5000-2.0-MB7.8x54 L 52 IC+	568792	54	7.8	52				5002… 176–179, 191
	3.0	5000-3.0-MB7.8x54 L 52 IC+	568794	54	7.8	52				
		5000-3.0-MB7.8x60 L 65 IC+	568796	60	7.8	65				
R	2.0	5000-2.0-MB7.8x54 R 52 IC+	568791	54	7.8	52				
	3.0	5000-3.0-MB7.8x54 R 52 IC+	568793	54	7.8	52				
		5000-3.0-MB7.8x60 R 65 IC+	568795	60	7.8	65				

Scope of delivery: Module without mounting screws

Note
Cutting edges of type 5002X must be used for parting-off over Ø 40 mm.

Compatible with different holder systems for multi spindle automatic lathes such as Göltenbodt systems.

Legend 212

For holders 5000

Illustration	Description	Dimensions	Order designation	Art. no.	Holders
	TORX screw	M4 × 16 T15	MSP 40160 T15 WN-093	**556448**	5000… (H ≤ 12 mm) 5000… (H ≤ 1/2") 5000…-S2608 5000…-SU2608 5000…-MA7 5000…-MB7
		M5 × 19 T20	MSP 50190 T20 WN-115	**556447**	5000… (H ≥ 16 mm) 5000… (H ≥ 5/8")
	Screw plug	M5	MSP VSR M5 IB2.5	**150262**	5000… IC+
		G⅛"	MSP VSR G1/8 IB5	**153989**	

TORX screwdriver

Illustration	Description	Dimensions	Order designation	Art. no.	Screws
	TORX screwdriver	T15	MSP TX15	**127482**	M… T15
		T20	MSP TX20	**127537**	M… T20

TORX torque screwdriver with replaceable blade

Illustration	Description	Dimensions	Torque	Order designation	Art. no.	Screws
	TORX torque screwdriver	T15	3 Nm	MSP TX15 D	**114805**	M… T15
		T20	5 Nm	MSP TX20 D-5Nm	**566283**	M… T20
	Blade	T15	–	MSP KTX15 D	**113860**	M… T15
		T20	–	MSP KTX20 D	**113861**	M… T20

Legend 212

UTILIS multidec® swiss type tools