

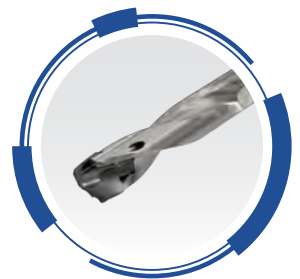
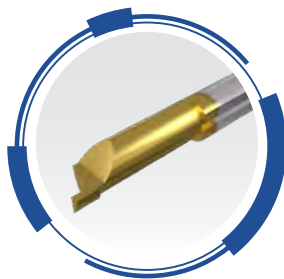
MINIATURE PART MACHINING

PICCO LINES

METRIC CATALOG



MACHINING IN TELLIGENTLY

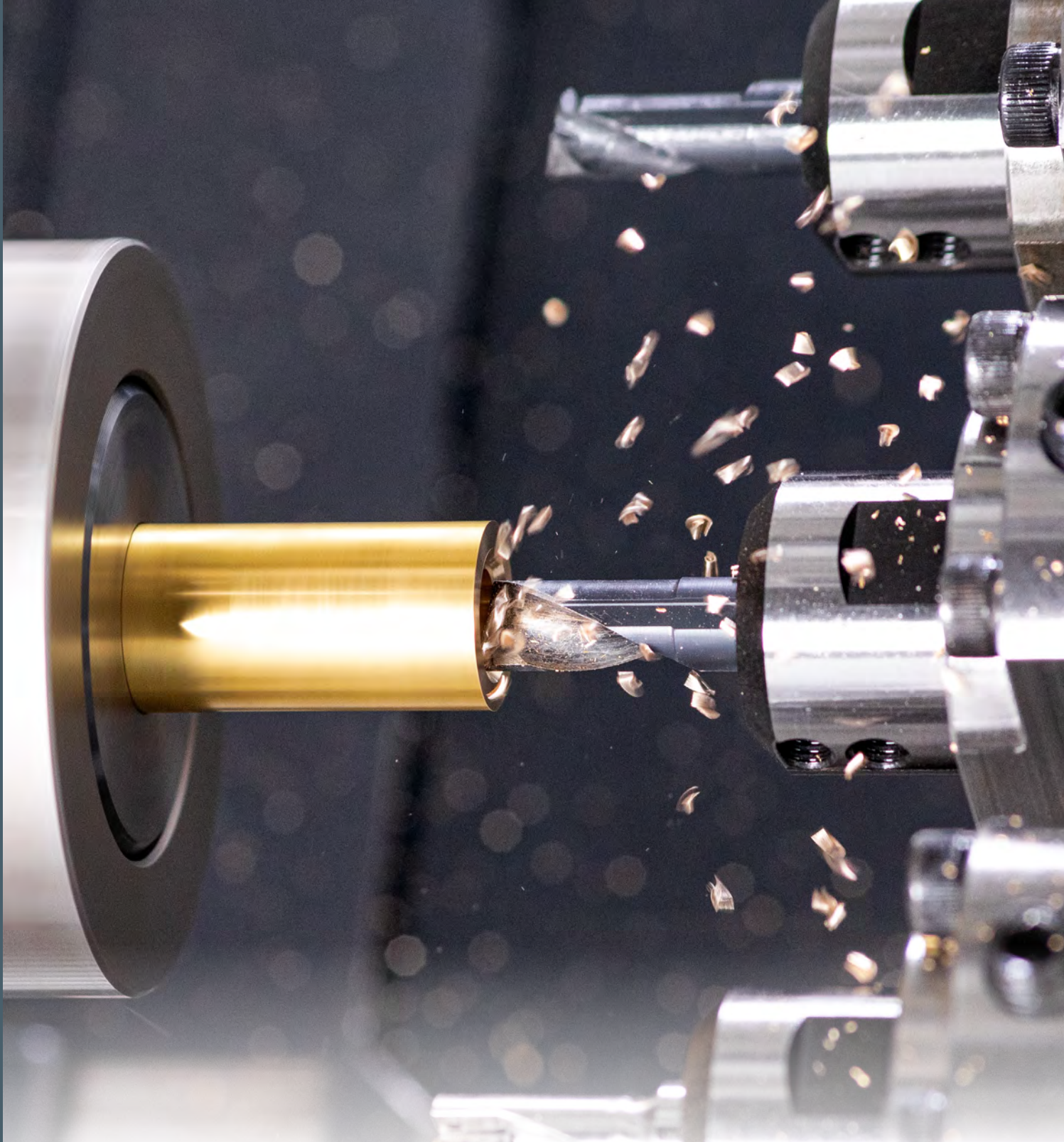


TURNING

FACE
GROOVING

THREADING

DRILLING



Quality Standard

ISCAR has been certified by the prestigious Standards Institution, as being in full compliance to ensure delivery of the finest quality goods. Quality control facilities include the metallurgical laboratory, raw metal testing, an online testing procedure and a machining center for tool performance testing and final product inspection. Only the finest products are packaged for entry into ISCAR's inventory.

SMALL TOOLS **BIG** RESULTS

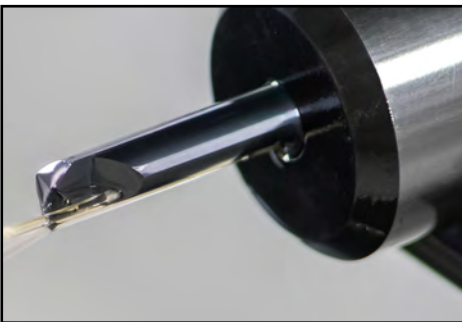


Contents



HOLDERS

page 3



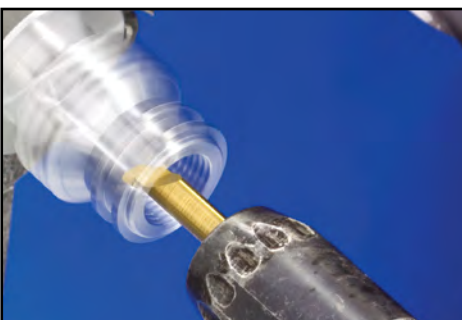
TURNING Lines

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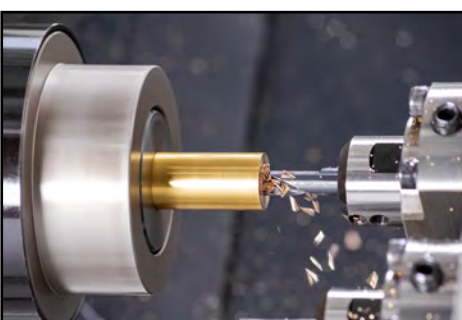
FACE GROOVING Lines

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THREADING Lines

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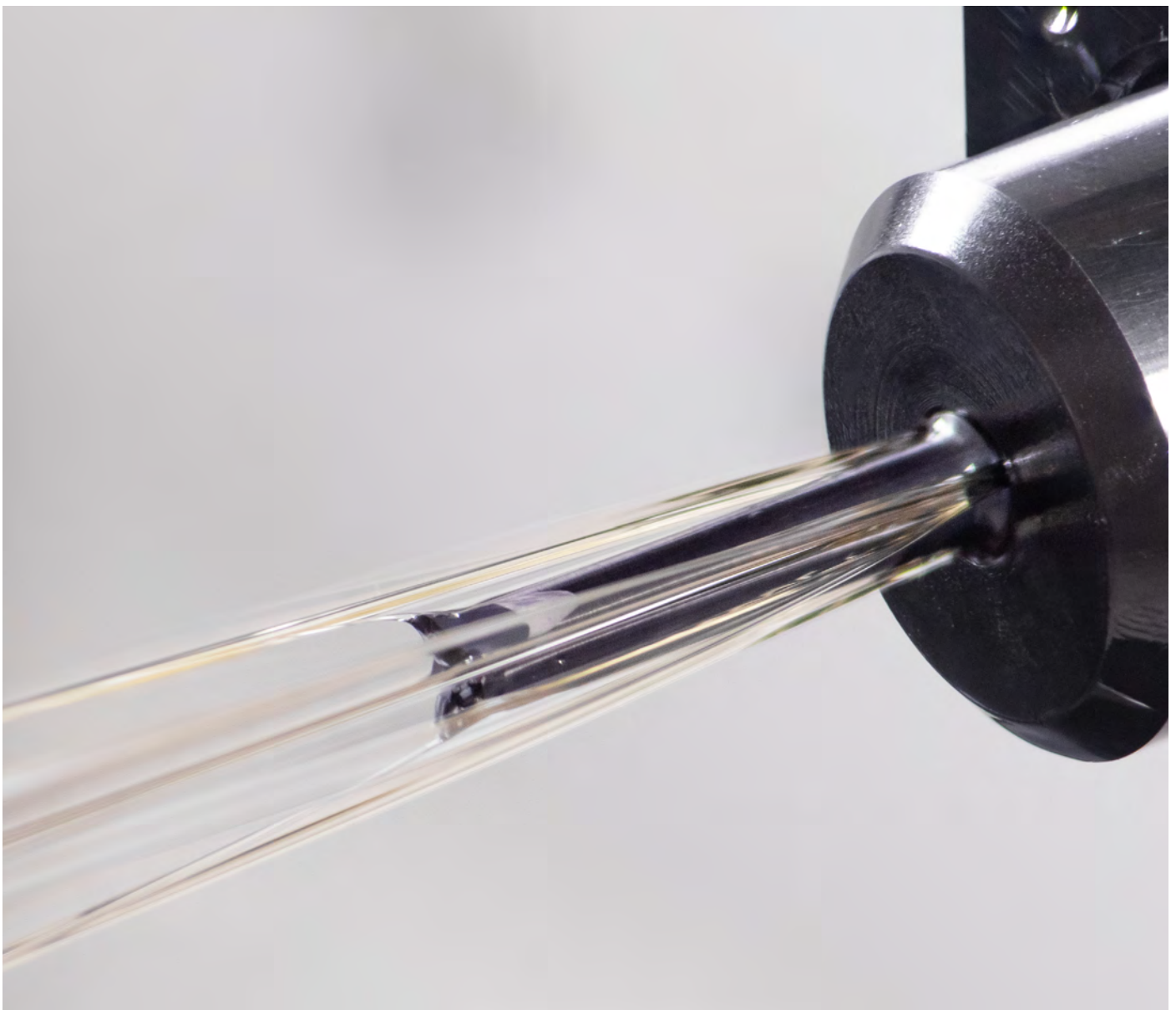
DRILLING LINES

PAGE 37

PICCOJET - Designation Key Code

PICJ	R	G	20	D60	R15	25	IC908
1	2	3	4	5	6	7	8

	Turning	Back Turning	Grooving	Profiling	Chamfering / Back Chamfering	Face Groove	Threading
1	PICJ - PICCOJET	PICJ - PICCOJET	PICJ - PICCOJET	PICJ - PICCOJET	PICJ - PICCOJET	PICJ - PICCOJET	PICJ - PICCOJET
2	RH / LH	RH / LH	RH / LH	RH / LH	RH / LH	RH / LH	RH / LH
3	T	BT	G	P	CH / BC	F	TH
4	Cutting Angle		Width	Width	Chamfering angle	Width	Max. Overhang
5	Min. Diameter	Min. Diameter	Min. Diameter	Min. Diameter	Min. Diameter	DAXN	I -ISO/UN(60 °) / W -Whitworth (BSW, BSF, BSP) (55°)
6	Radius size	Radius size	Radius size			Machining depth -CDX	TPN- Pitch minimum/nominal
7	Max. Overhang	Max. Overhang	Max. Overhang	Max. Overhang	Max. Overhang	Max. Overhang	Min. Diameter
8	Grade	Grade	Grade	Grade	Grade	Grade	Grade



HOLDERS



ACECUT



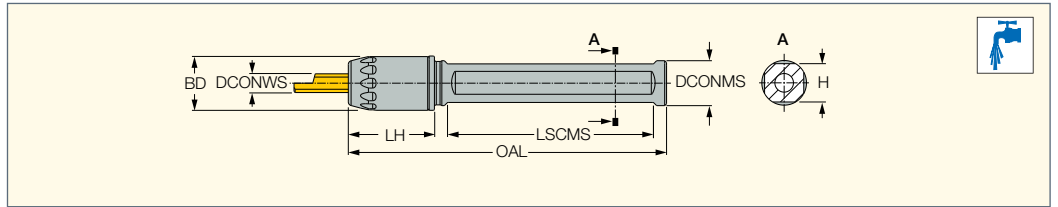
PASSCUT



SWISSTURN

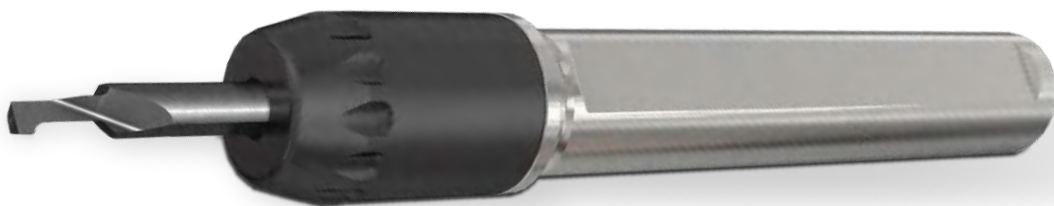
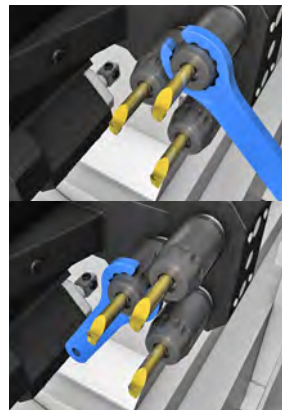
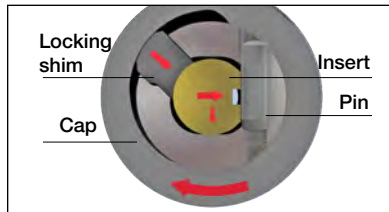
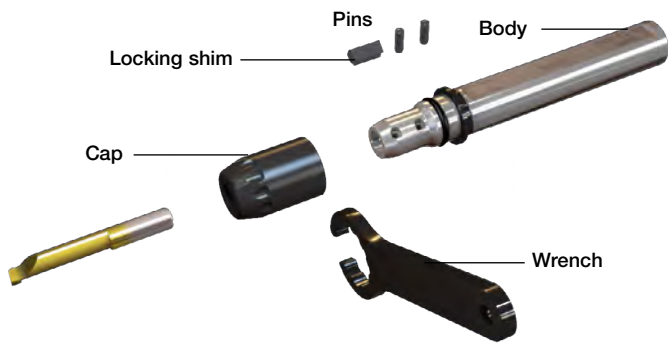


PICCO ACE
 Holders for PICCO-CUT Inserts



Designation	DCONMS	DCONWS	BD	OAL	LH	LSCMS	H		
PICCO ACE 12-4	12.00	4.00	14.50	85.00	23.00	53.00	10.3	PL 16 M6-D5	WRENCH ACE 4-5
PICCO ACE 12-5	12.00	5.00	14.50	85.00	23.00	53.00	10.3	PL 16 M6-D5	WRENCH ACE 4-5
PICCO ACE 16-4	16.00	4.00	14.50	85.00	21.50	53.50	14.0	PL 16 M6-D5	WRENCH ACE 4-5
PICCO ACE 16-5	16.00	5.00	14.50	85.00	21.50	53.00	14.0	PL 16 M6-D5	WRENCH ACE 4-5
PICCO ACE 16-6	16.00	6.00	19.90	85.00	23.00	53.50	14.0	PL 16 M6-D5	WRENCH ACE 6-7
PICCO ACE 16-7	16.00	7.00	19.90	85.00	23.00	53.50	14.0	PL 16 M6-D5	WRENCH ACE 6-7
PICCO ACE 20-4	20.00	4.00	14.50	150.00	21.50	118.00	18.0	PL 16 M6-D5	WRENCH ACE 4-5
PICCO ACE 20-5	20.00	5.00	14.50	150.00	21.50	118.00	18.0	PL 16 M6-D5	WRENCH ACE 4-5
PICCO ACE 20-6	20.00	6.00	19.90	150.00	21.50	118.00	18.0	PL 16 M6-D5	WRENCH ACE 6-7
PICCO ACE 20-7	20.00	7.00	19.90	150.00	21.50	118.00	18.0	PL 16 M6-D5	WRENCH ACE 6-7
PICCO ACE 22-4	22.00	4.00	14.50	150.00	21.50	118.00	20.0	PL 16 M6-D5	WRENCH ACE 4-5
PICCO ACE 22-5	22.00	5.00	14.50	150.00	21.50	118.00	20.0	PL 16 M6-D5	WRENCH ACE 4-5
PICCO ACE 22-6	22.00	6.00	19.90	150.00	21.50	118.00	20.0	PL 16 M6-D5	WRENCH ACE 6-7
PICCO ACE 22-7	22.00	7.00	19.90	150.00	21.50	118.00	20.0	PL 16 M6-D5	WRENCH ACE 6-7
PICCO ACE 25-4	25.00	4.00	14.50	150.00	21.50	118.00	20.0	PL 16 M6-D5	WRENCH ACE 4-5
PICCO ACE 25-5	25.00	5.00	14.50	150.00	21.50	118.00	20.0	PL 16 M6-D5	WRENCH ACE 4-5
PICCO ACE 25-6	25.00	6.00	19.90	150.00	21.50	118.00	20.0	PL 16 M6-D5	WRENCH ACE 6-7
PICCO ACE 25-7	25.00	7.00	19.90	150.00	21.50	118.00	20.0	PL 16 M6-D5	WRENCH ACE 6-7

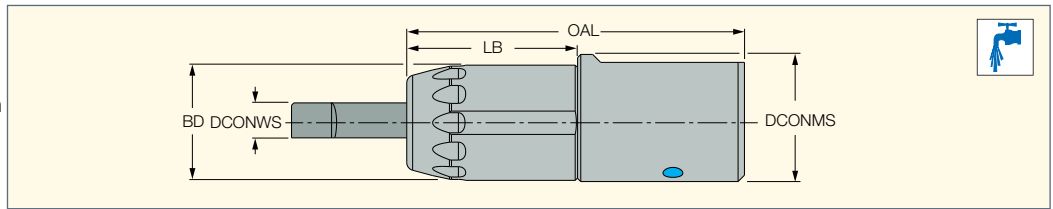
• Holders are suitable for right- and left-hand PICCO inserts



PICCOACE

PICCO ACE-BH

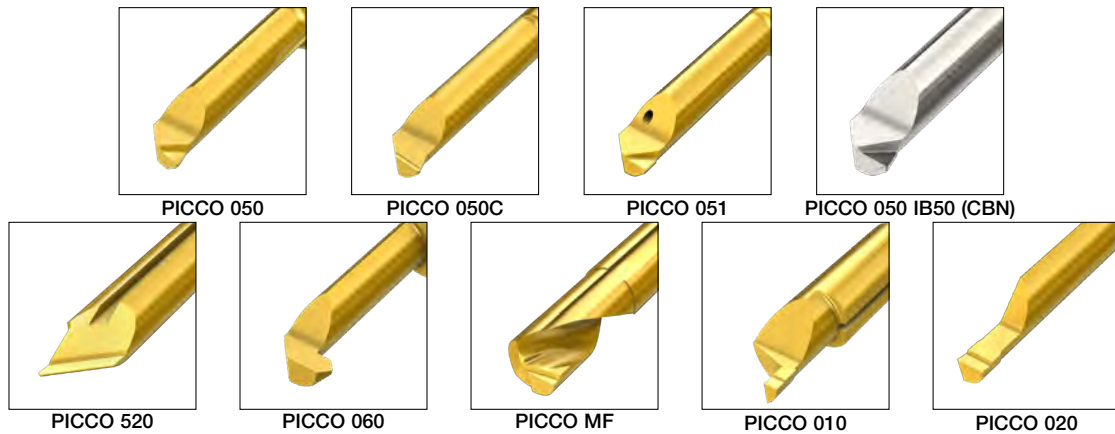
Holders with Short Shanks for ITS BORE System Tools on which PICCO Inserts are Mounted



Designation	DCONMS	DCONWS	BD	OAL	LB	
PICCO ACE-BH 16-4	16.00	4.00	14.50	42.50	21.50	WRENCH ACE 4-5
PICCO ACE-BH 16-5	16.00	5.00	14.50	42.50	21.50	WRENCH ACE 4-5
PICCO ACE-BH 16-6	16.00	6.00	19.90	43.50	21.50	WRENCH ACE 6-7
PICCO ACE-BH 16-7	16.00	7.00	19.90	43.50	21.50	WRENCH ACE 6-7

• Holders are suitable for right- and left-hand PICCO inserts

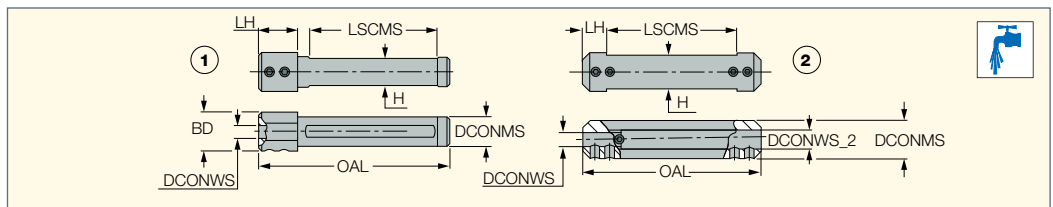
The PICCO-ACE-BH Holders Can Carry a Wide Range of PICCOCUT Insert Geometries



PASSCUT
PICCOCUT HOLDER

PICCO/MG PCO (Holder)

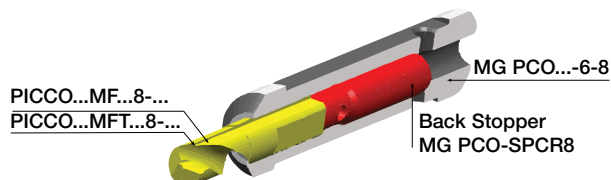
Holders for PICCO-CUT Inserts and Small Diameter Boring Bars



Designation	DCONMS	DCONWS	DCONWS_2	OAL	LH	LSCMS	H	BD	Fig.				
PICCO 12-4-5	12.00	4.00	5.00	75.00	10.00	55.00	10.3	-	2	SR M5X4-PF	HW 2.5		
PICCO 16-4-5	16.00	4.00	5.00	75.00	10.00	55.00	14.0	-	2	SR M5X6-PF	HW 2.5		
PICCO 20-4-5	20.00	4.00	5.00	90.00	10.00	70.00	18.0	-	2	SR M5X6-PF	HW 2.5		
PICCO 22-4-5 (1)	22.00	4.00	5.00	90.00	10.00	70.00	20.0	-	2	SR M5X6-PF	HW 2.5		
PICCO 16-6-7	16.00	6.00	7.00	75.00	10.00	55.00	14.0	-	2	SR M5X6-PF	HW 2.5		
PICCO 20-6-7	20.00	6.00	7.00	90.00	10.00	70.00	18.0	-	2	SR M5X6-PF	HW 2.5		
PICCO 22-6-7 (1)	22.00	6.00	7.00	90.00	10.00	70.00	20.0	-	2	SR M5X6-PF	HW 2.5		
MG PCO-12-6	12.00	6.00	-	75.00	15.00	50.80	11.0	18.00	1	SR M5X6-PF	HW 2.5		
MG PCO-16-6-8	16.00	6.00	8.00	75.00	10.00	55.00	14.0	-	2	SR M5X6-PF	HW 2.5		MG PCO-SPCR8
MG PCO-20-6-8	20.00	6.00	8.00	90.00	10.00	70.00	18.0	-	2	SR M5X6-PF	HW 2.5		MG PCO-SPCR8
MG PCO-22-6-8 (1)	22.00	6.00	8.00	90.00	10.00	70.00	20.0	-	2	SR M5X6-PF	HW 2.5		MG PCO-SPCR8
MG PCO-25-6-8	25.00	6.00	8.00	90.00	10.00	70.00	23.0	-	2	SR M5X6-PF	HW 2.5		MG PCO-SPCR8
MG PCO-16-9	16.00	9.00	-	75.00	15.00	53.00	15.0	20.00	1	SR M5X6-PF	HW 2.5	PL 16	

• Holders are suitable for right- and left-hand inserts, and boring bars

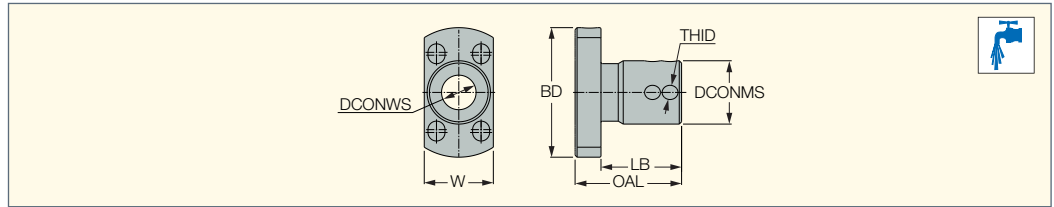
(1) Tools for Swiss-type CNC



QUICKSWISS






SBTH-PICCO

Height-Adjustable Modular Back-End Machining System for Swiss-Type Machines with Round Shank Holders



Designation	DCONMS	DCONWS	BD	OAL	LB	OAW	THID
SBTH-PICCO	22.00	12.00	45.00	37.00	28.00	24.00	5

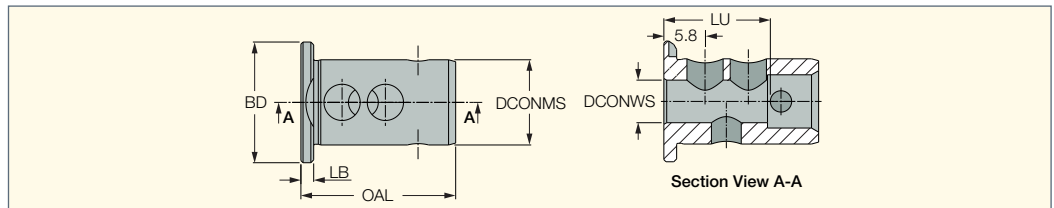
Spare Parts

Designation					
SBTH-PICCO	SR M5X0.5X16 DIN913	SBTA-1K-SP1	SBTA-ZEN1	SBTA-QR5.28X1.78	SR M5X0.5X8 DIN913

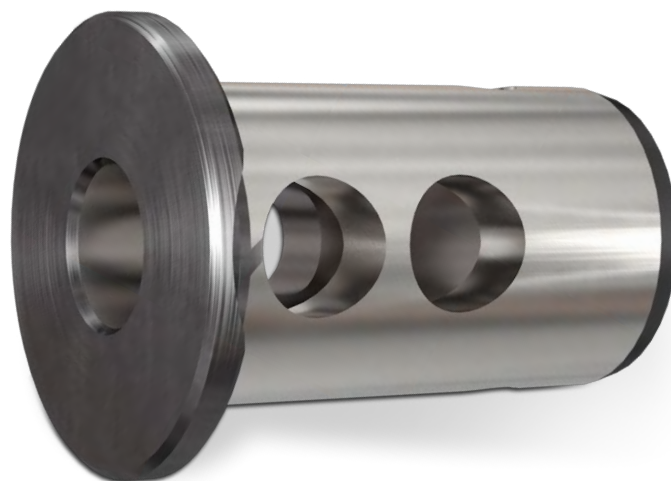
QUICKSWISS

SC-PICCO

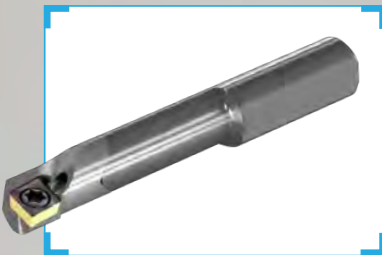
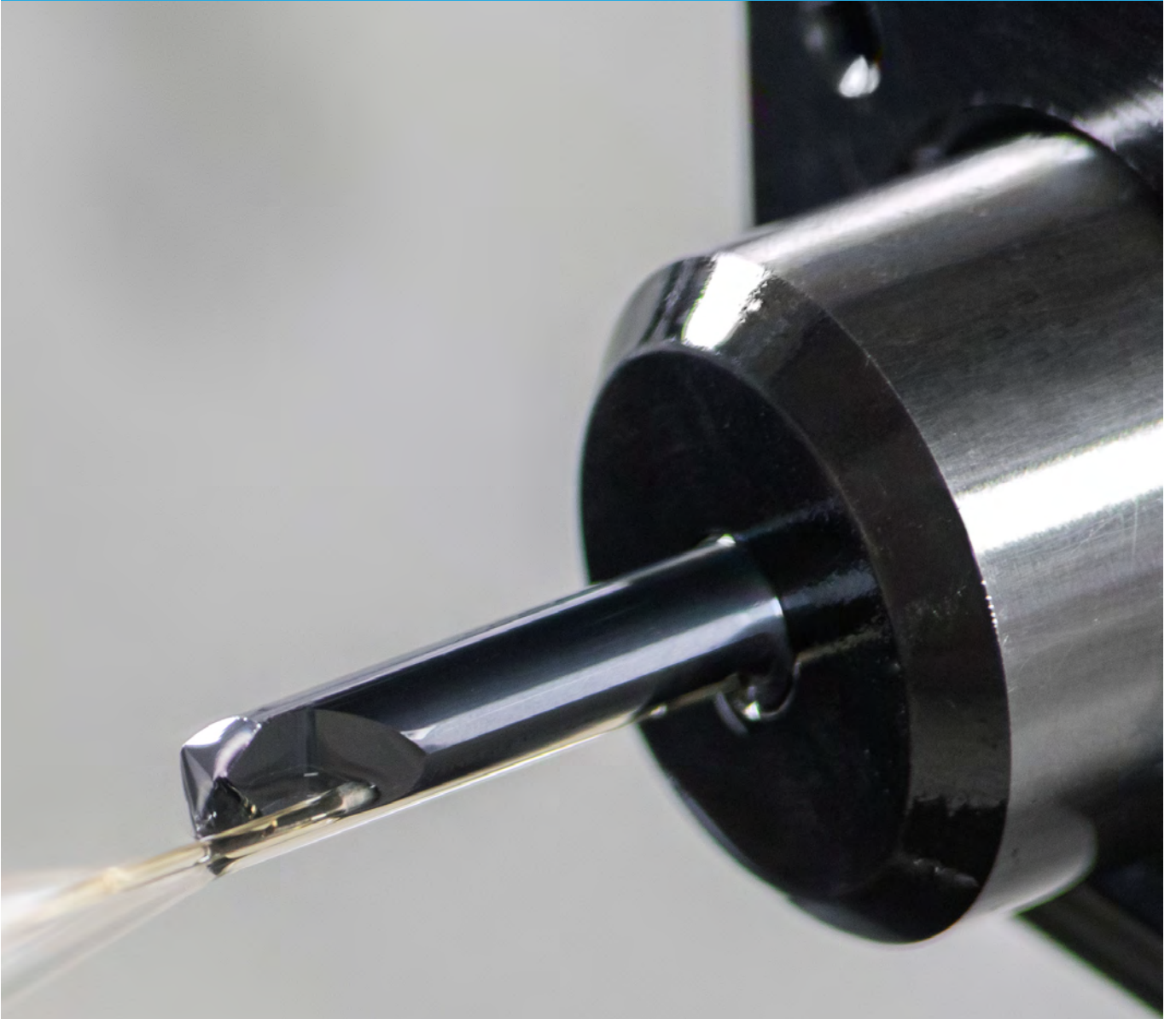
Reduction Sleeves for Round Shank Holders for Modular Back-End Machining System



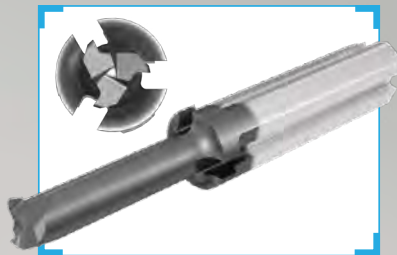
Designation	DCONMS	DCONWS	LSCMS	LU	BD	OAL	LB
SC-12-4-PICCO	12.00	4.00	15.00	15.00	17.00	21.80	1.80
SC-12-5-PICCO	12.00	5.00	15.00	15.00	17.00	21.80	1.80
SC-12-6-PICCO	12.00	6.00	15.00	15.00	17.00	21.80	1.80
SC-12-7-PICCO	12.00	7.00	15.00	15.00	17.00	21.80	1.80
SC-12-8-PICCO	12.00	8.00	15.00	15.00	17.00	21.80	1.80



TURNING LINES



PICCO-INDEX



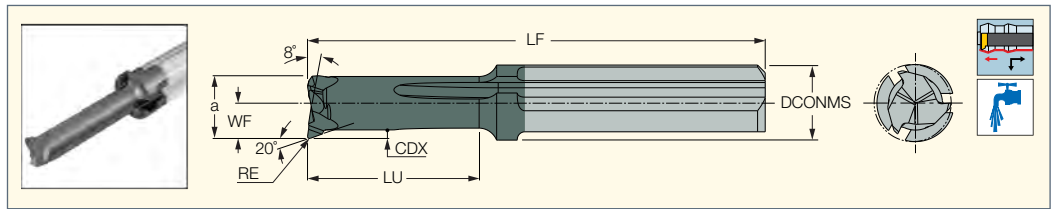
PICCO-3-CUT



PICCO-JET

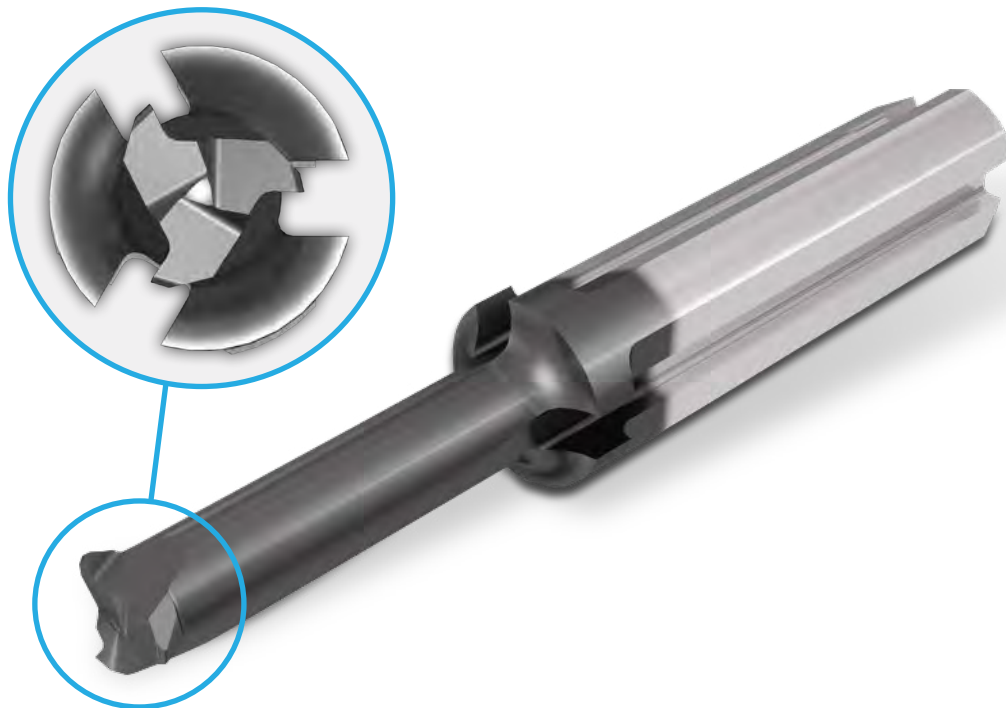
PICCO3CUT

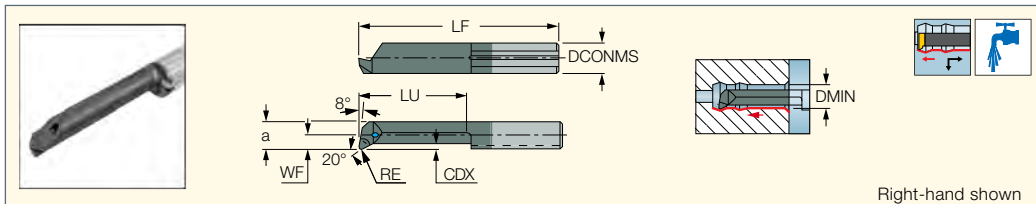
PICCO PMC R/L
Inserts with Three Cutting
Edges for Internal Turning
and Chamfering



Designation	Dimensions								IC908
	DCONMS	D min	CDX	LU	RE	LF	a	WF	
PMC R/LT20D30R10-10	4.00	3.00	0.20	9.30	0.10	24.00	2.40	1.35	●
PMC R/LT20D30R10-15	4.00	3.00	0.20	14.30	0.10	29.00	2.40	1.35	●
PMC R/LT20D30R10-20	4.00	3.00	0.20	19.30	0.10	34.00	2.40	1.35	●
PMC R/LT20D40R10-10	4.00	4.00	0.30	9.30	0.10	24.00	3.30	1.85	●
PMC R/LT20D40R10-15	4.00	4.00	0.30	14.30	0.10	29.00	3.30	1.85	●
PMC R/LT20D40R10-20	4.00	4.00	0.30	19.30	0.10	34.00	3.30	1.85	●
PMC R/LT20D40R10-25	4.00	4.00	0.30	24.30	0.10	39.00	3.30	1.85	●
PMC R/LT20D50R15-10	5.00	5.00	0.50	9.30	0.15	25.00	4.00	2.30	●
PMC R/LT20D50R15-20	5.00	5.00	0.50	19.30	0.15	35.00	4.00	2.30	●
PMC R/LT20D50R15-25	5.00	5.00	0.50	24.30	0.15	40.00	4.00	2.30	●
PMC R/LT20D50R15-35	5.00	5.00	0.50	34.30	0.15	50.00	4.00	2.30	●
PMC R/LT20D60R15-15	6.00	6.00	0.50	14.30	0.15	30.00	5.00	2.80	●
PMC R/LT20D60R15-25	6.00	6.00	0.50	24.30	0.15	40.00	5.00	2.80	●
PMC R/LT20D60R15-30	6.00	6.00	0.50	29.30	0.15	45.00	5.00	2.80	●
PMC R/LT20D60R15-40	6.00	6.00	0.50	39.30	0.15	55.00	5.00	2.80	●
PMC R/LT20D70R15-20	7.00	7.00	0.60	19.30	0.15	35.00	5.90	3.30	●
PMC R/LT20D70R15-30	7.00	7.00	0.60	29.30	0.15	45.00	5.90	3.30	●
PMC R/LT20D70R15-40	7.00	7.00	0.60	39.30	0.15	55.00	5.90	3.30	●
PMC R/LT20D70R15-50	7.00	7.00	0.60	49.30	0.15	65.00	5.90	3.30	●

• Specify right- or left-hand bars



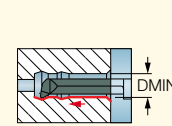
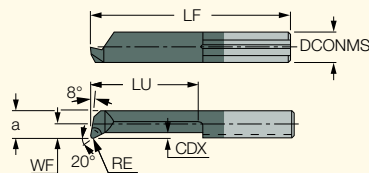


Right-hand shown

Designation	Dimensions								IC908
	DCONMS	DMIN	CDX ⁽¹⁾	LU	RE	LF	a	WF	
PICJ RT20D08R04-4	4.00	0.80	0.08	4.00	0.04	20.00	0.70	-1.30	●
PICJ RT20D10R05-5	4.00	1.00	0.10	4.50	0.05	20.00	0.90	-1.10	●
PICJ RT20D10R05-7	4.00	1.00	0.10	6.50	0.05	22.00	0.90	-1.10	●
PICJ RT20D15R05-5	4.00	1.50	0.10	4.00	0.05	19.00	1.30	-0.70	●
PICJ RT20D15R05-10	4.00	1.50	0.10	9.00	0.05	24.00	1.30	-0.70	●
PICJ RT20D20R05-5	4.00	2.00	0.10	4.00	0.05	19.00	1.70	-0.30	●
PICJ R/LT20D20R05-10	4.00	2.00	0.10	9.00	0.05	24.00	1.70	-0.30	●
PICJ R/LT20D20R05-15	4.00	2.00	0.10	14.00	0.05	29.00	1.70	-0.30	●
PICJ RT20D25R05-5	4.00	2.50	0.15	4.00	0.05	19.00	2.20	0.20	●
PICJ RT20D25R05-10	4.00	2.50	0.15	9.00	0.05	24.00	2.20	0.20	●
PICJ RT20D25R05-16	4.00	2.50	0.15	15.00	0.05	30.00	2.20	0.20	●
PICJ RT20D30R03-10	4.00	2.80	0.20	9.00	0.03	24.00	2.60	0.60	●
PICJ R/LT20D30R10-10	4.00	2.80	0.20	9.00	0.10	24.00	2.60	0.60	●
PICJ RT20D30R03-16	4.00	2.80	0.20	15.00	0.03	30.00	2.60	0.60	●
PICJ R/LT20D30R10-16	4.00	2.80	0.20	15.00	0.10	30.00	2.60	0.60	●
PICJ RT20D30R10-20	4.00	2.80	0.20	19.00	0.10	34.00	2.60	0.60	●
PICJ RT20D35R10-10	4.00	3.50	0.25	9.00	0.10	24.00	3.10	1.10	●
PICJ RT20D35R10-16	4.00	3.50	0.25	15.00	0.10	30.00	3.10	1.10	●
PICJ RT20D35R10-20	4.00	3.50	0.25	19.00	0.10	34.00	3.10	1.10	●
PICJ RT20D35R10-24	4.00	3.50	0.25	23.00	0.10	38.00	3.10	1.10	●
PICJ RT20D40R03-10	4.00	4.00	0.30	9.00	0.03	24.00	3.50	1.50	●
PICJ R/LT20D40R10-10	4.00	4.00	0.30	9.00	0.10	24.00	3.50	1.50	●
PICJ RT20D40R03-16	4.00	4.00	0.30	15.00	0.03	30.00	3.50	1.50	●
PICJ RT20D40R10-16	4.00	4.00	0.30	15.00	0.10	30.00	3.50	1.50	●
PICJ RT20D40R03-20	4.00	4.00	0.30	19.00	0.03	34.00	3.50	1.50	●
PICJ R/LT20D40R10-20	4.00	4.00	0.30	19.00	0.10	34.00	3.50	1.50	●
PICJ RT20D40R10-24	4.00	4.00	0.30	23.00	0.10	38.00	3.50	1.50	●
PICJ R/LT20D40R10-28	4.00	4.00	0.30	27.00	0.10	42.00	3.50	1.50	●
PICJ RT20D50R05-10	5.00	5.00	0.50	9.00	0.05	25.00	4.40	1.90	●
PICJ RT20D50R15-10	5.00	5.00	0.50	9.00	0.15	25.00	4.40	1.90	●
PICJ RT20D50R05-15	5.00	5.00	0.50	14.00	0.05	30.00	4.40	1.90	●
PICJ RT20D50R15-15	5.00	5.00	0.50	14.00	0.15	30.00	4.40	1.90	●
PICJ RT20D50R05-20	5.00	5.00	0.50	19.00	0.05	35.00	4.40	1.90	●
PICJ R/LT20D50R15-20	5.00	5.00	0.50	19.00	0.15	35.00	4.40	1.90	●
PICJ RT20D50R05-25	5.00	5.00	0.50	24.00	0.05	40.00	4.40	1.90	●
PICJ R/LT20D50R15-25	5.00	5.00	0.50	24.00	0.15	40.00	4.40	1.90	●
PICJ RT20D50R15-30	5.00	5.00	0.50	29.00	0.15	45.00	4.40	1.90	●
PICJ RT20D50R15-35	5.00	5.00	0.50	34.00	0.15	50.00	4.40	1.90	●
PICJ RT20D60R05-15	6.00	6.00	0.50	14.00	0.05	30.00	5.30	2.30	●
PICJ R/LT20D60R15-15	6.00	6.00	0.50	14.00	0.15	30.00	5.30	2.30	●
PICJ RT20D60R05-22	6.00	6.00	0.50	21.00	0.05	37.00	5.30	2.30	●
PICJ R/LT20D60R15-22	6.00	6.00	0.50	21.00	0.15	37.00	5.30	2.30	●
PICJ RT20D60R05-25	6.00	6.00	0.50	24.00	0.05	40.00	5.30	2.30	●
PICJ R/LT20D60R15-25	6.00	6.00	0.50	24.00	0.15	40.00	5.30	2.30	●
PICJ RT20D60R05-30	6.00	6.00	0.50	29.00	0.05	45.00	5.30	2.30	●
PICJ R/LT20D60R15-30	6.00	6.00	0.50	29.00	0.15	45.00	5.30	2.30	●
PICJ RT20D60R15-35	6.00	6.00	0.50	34.00	0.15	50.00	5.30	2.30	●
PICJ R/LT20D60R15-42	6.00	6.00	0.50	41.00	0.15	57.00	5.30	2.30	●
PICJ R/LT20D70R15-20	7.00	6.80	0.60	19.00	0.15	35.00	6.30	2.80	●
PICJ RT20D70R15-25	7.00	6.80	0.60	24.00	0.15	40.00	6.30	2.80	●
PICJ R/LT20D70R15-30	7.00	6.80	0.60	29.00	0.15	45.00	6.30	2.80	●
PICJ RT20D70R15-35	7.00	6.80	0.60	34.00	0.15	50.00	6.30	2.80	●
PICJ RT20D70R15-40	7.00	6.80	0.60	39.00	0.15	55.00	6.30	2.80	●
PICJ RT20D70R15-45	7.00	6.80	0.60	44.00	0.15	60.00	6.30	2.80	●
PICJ RT20D70R15-50	7.00	6.80	0.60	49.00	0.15	65.00	6.30	2.80	●

● Specify right- or left-hand bars ⁽¹⁾ Cutting depth maximum



PICCO[®]CUT**PICCO R/L 050, 053, 055**Inserts for Internal Turning
and Chamfering

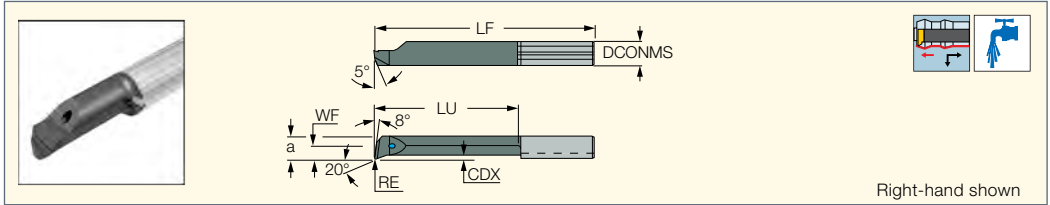
Right-hand shown

Designation	Dimensions								Tough ↔ Hard	
	DCONMS	DMIN	CDX ⁽²⁾	LU	RE	LF	a	WF	IC228	IC908
PICCO R 050.06-2 ⁽¹⁾	4.00	0.60	0.08	2.00	0.04	20.00	0.50	-	●	●
PICCO R 050.06-3 ⁽¹⁾	4.00	0.60	0.08	3.00	0.04	20.00	0.50	-	●	●
PICCO R 050.08-4	4.00	0.80	0.08	4.00	0.04	20.00	0.70	-	●	●
PICCO R/L 050.1-5	4.00	1.00	0.10	4.50	0.05	20.00	0.90	-	●	●
PICCO R/L 050.1-7	4.00	1.00	0.10	6.50	0.05	22.00	0.90	-	●	●
PICCO R 050.15-5	4.00	1.50	0.10	5.00	0.05	19.00	1.30	-	●	●
PICCO R 050.15-10	4.00	1.50	0.10	10.00	0.06	24.00	1.30	-	●	●
PICCO R/L 050.2-5	4.00	2.00	0.10	4.00	0.05	19.00	1.70	-	●	●
PICCO R 055.2-5	4.00	2.00	0.10	5.00	0.05	19.00	1.70	-	●	●
PICCO R/L 050.2-10	4.00	2.00	0.10	9.00	0.05	24.00	1.70	-	●	●
PICCO R 055.2-10	4.00	2.00	0.10	10.00	0.05	24.00	1.70	-	●	●
PICCO L 050.2-15	4.00	2.00	0.10	15.00	0.05	29.00	1.70	-	●	●
PICCO R 050.2-15	4.00	2.00	0.10	14.00	0.05	29.00	1.70	-	●	●
PICCO R 055.2-15	4.00	2.00	0.10	15.00	0.05	29.00	1.70	-	●	●
PICCO R 050.25-5	4.00	2.50	0.15	5.00	0.05	19.00	2.20	0.20	●	●
PICCO R 050.25-10	4.00	2.50	0.15	10.00	0.07	24.00	2.20	0.20	●	●
PICCO R 050.25-16	4.00	2.50	0.15	16.00	0.07	30.00	2.20	0.20	●	●
PICCO R 053.3-10	4.00	2.80	0.20	9.00	0.03	24.00	2.60	0.60	●	●
PICCO R 055.3-10	4.00	2.80	0.20	10.00	0.05	24.00	2.60	0.60	●	●
PICCO R/L 050.3-10	4.00	2.80	0.20	9.00	0.10	24.00	2.60	0.60	●	●
PICCO R 053.3-16	4.00	2.80	0.20	15.00	0.03	30.00	2.60	0.60	●	●
PICCO R 055.3-16	4.00	2.80	0.20	16.00	0.05	30.00	2.60	0.60	●	●
PICCO R/L 050.3-16	4.00	2.80	0.20	15.00	0.10	30.00	2.60	0.60	●	●
PICCO R 053.3-20	4.00	2.80	0.20	19.00	0.03	34.00	2.60	0.60	●	●
PICCO R/L 050.3-20	4.00	2.80	0.20	19.00	0.10	34.00	2.60	0.60	●	●
PICCO R 050.35-10	4.00	3.50	0.25	10.00	0.10	24.00	3.10	1.10	●	●
PICCO R 050.35-16	4.00	3.50	0.25	16.00	0.10	30.00	3.10	1.10	●	●
PICCO R 050.35-20	4.00	3.50	0.25	20.00	0.10	34.00	3.10	1.10	●	●
PICCO R 050.35-24	4.00	3.50	0.25	24.00	0.10	38.00	3.10	1.10	●	●
PICCO R 053.4-10	4.00	4.00	0.30	9.00	0.03	24.00	3.50	1.50	●	●
PICCO R 055.4-10	4.00	4.00	0.30	10.00	0.05	24.00	3.50	1.50	●	●
PICCO R/L 050.4-10	4.00	4.00	0.30	9.00	0.10	24.00	3.50	1.50	●	●
PICCO R 053.4-16	4.00	4.00	0.30	15.00	0.03	30.00	3.50	1.50	●	●
PICCO R 055.4-16	4.00	4.00	0.30	16.00	0.05	30.00	3.50	1.50	●	●
PICCO R/L 050.4-16	4.00	4.00	0.30	15.00	0.10	30.00	3.50	1.50	●	●
PICCO R 053.4-20	4.00	4.00	0.30	19.00	0.03	34.00	3.50	1.50	●	●
PICCO R 055.4-20	4.00	4.00	0.30	20.00	0.05	34.00	3.50	1.50	●	●
PICCO R/L 050.4-20	4.00	4.00	0.30	19.00	0.10	34.00	3.50	1.50	●	●
PICCO R/L 050.4-24	4.00	4.00	0.30	23.00	0.10	38.00	3.50	1.50	●	●
PICCO R/L 050.4-28	4.00	4.00	0.30	27.00	0.10	42.00	3.50	1.50	●	●
PICCO R 055.4-28	4.00	4.00	0.50	28.00	0.05	42.00	3.50	1.50	●	●
PICCO R 055.5-10	5.00	5.00	0.50	9.00	0.05	25.00	4.40	1.90	●	●
PICCO R/L 050.5-10	5.00	5.00	0.50	9.00	0.15	25.00	4.40	1.90	●	●
PICCO R 055.5-15	5.00	5.00	0.50	14.00	0.05	30.00	4.40	1.90	●	●
PICCO R/L 050.5-15	5.00	5.00	0.50	14.00	0.15	30.00	4.40	1.90	●	●
PICCO R 055.5-20	5.00	5.00	0.50	19.00	0.05	35.00	4.40	1.90	●	●
PICCO R/L 050.5-20	5.00	5.00	0.50	19.00	0.15	35.00	4.40	1.90	●	●
PICCO R 055.5-25	5.00	5.00	0.50	24.00	0.05	40.00	4.40	1.90	●	●
PICCO R/L 050.5-25	5.00	5.00	0.50	24.00	0.15	40.00	4.40	1.90	●	●
PICCO R 055.5-30	5.00	5.00	0.50	29.00	0.05	45.00	4.40	1.90	●	●
PICCO R/L 050.5-30	5.00	5.00	0.50	29.00	0.15	45.00	4.40	1.90	●	●
PICCO R/L 050.5-35	5.00	5.00	0.50	34.00	0.15	50.00	4.40	1.90	●	●
PICCO R 055.6-15	6.00	6.00	0.50	14.00	0.05	30.00	5.30	2.30	●	●
PICCO R/L 050.6-15	6.00	6.00	0.50	14.00	0.15	30.00	5.30	2.30	●	●
PICCO R 055.6-22	6.00	6.00	0.50	21.00	0.05	37.00	5.30	2.30	●	●
PICCO R/L 050.6-22	6.00	6.00	0.50	21.00	0.15	37.00	5.30	2.30	●	●
PICCO R 055.6-25	6.00	6.00	0.50	24.00	0.05	40.00	5.30	2.30	●	●
PICCO R/L 050.6-25	6.00	6.00	0.50	24.00	0.15	40.00	5.30	2.30	●	●
PICCO R 055.6-30	6.00	6.00	0.50	29.00	0.05	45.00	5.30	2.30	●	●
PICCO R/L 050.6-30	6.00	6.00	0.50	29.00	0.15	45.00	5.30	2.30	●	●
PICCO R/L 050.6-35	6.00	6.00	0.50	34.00	0.15	50.00	5.30	2.30	●	●
PICCO R/L 050.6-42	6.00	6.00	0.50	41.00	0.15	57.00	5.30	2.30	●	●
PICCO R/L 050.7-20	7.00	6.80	0.60	19.00	0.15	35.00	6.30	2.80	●	●
PICCO R/L 050.7-25	7.00	6.80	0.60	24.00	0.15	40.00	6.30	2.80	●	●
PICCO R/L 050.7-30	7.00	6.80	0.60	29.00	0.15	45.00	6.30	2.80	●	●
PICCO R/L 050.7-35	7.00	6.80	0.60	34.00	0.15	50.00	6.30	2.80	●	●
PICCO R/L 050.7-40	7.00	6.80	0.60	39.00	0.15	55.00	6.30	2.80	●	●
PICCO R/L 050.7-45	7.00	6.80	0.60	44.00	0.15	60.00	6.30	2.80	●	●
PICCO R/L 050.7-50	7.00	6.80	0.60	49.00	0.15	65.00	6.30	2.80	●	●

• Specify right- or left-hand bars ⁽¹⁾ Maximum D.O.C.=0.01-0.03 mm, maximum feed=0.01 mm/rev. ⁽²⁾ Cutting depth maximum

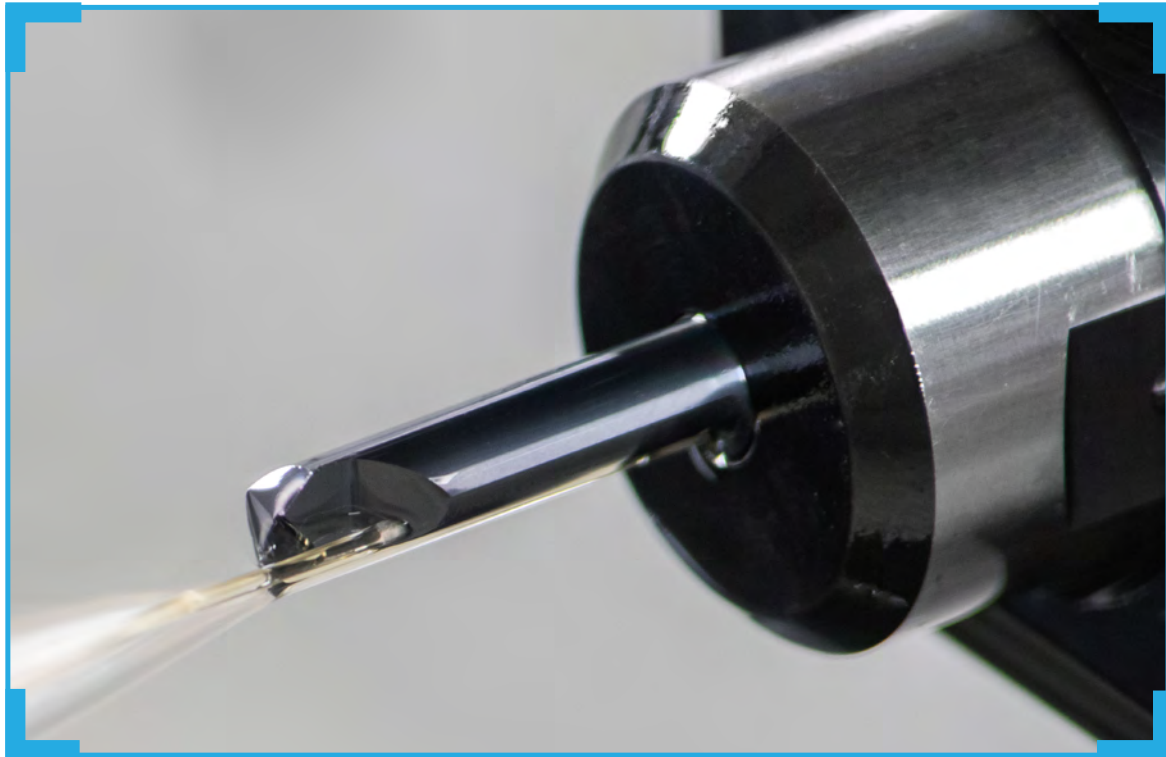
PICJ R/L 050-C

Inserts with Chipformers and Inner Coolant Channel for Internal Boring and Profiling



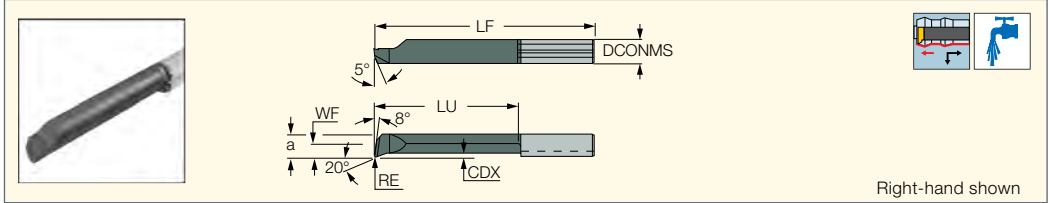
Designation	Dimensions								IC908
	DCONMS	DMIN	CDX ⁽¹⁾	LU	RE	LF	a	WF	
PICJ RT20D40R10-10C	4.00	4.00	0.30	9.00	0.10	24.00	3.50	1.50	●
PICJ RT20D40R10-20C	4.00	4.00	0.30	19.00	0.10	34.00	3.50	1.50	●
PICJ RT20D40R10-28C	4.00	4.00	0.30	27.00	0.10	42.00	3.50	1.50	●
PICJ RT20D50R15-20C	5.00	5.00	0.50	19.00	0.15	35.00	4.40	1.90	●
PICJ RT20D60R15-15C	6.00	6.00	0.50	14.00	0.15	30.00	5.30	2.30	●
PICJ RT20D60R15-22C	6.00	6.00	0.50	21.00	0.15	37.00	5.30	2.30	●
PICJ RT20D70R15-20C	7.00	6.80	0.60	19.00	0.15	35.00	6.30	2.80	●

- All left-hand inserts on request
- ⁽¹⁾ Cutting depth maximum



PICCO CUT

PICCO R/L 050-C
Inserts with Chipformers for
Internal Boring and Profiling



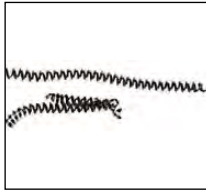
Designation	Dimensions								IC908
	DCONMS	DMIN	CDX ⁽¹⁾	LU	RE	LF	a	WF	
PICCO R/L 050.4-10C	4.00	4.00	0.30	10.00	0.10	24.00	3.50	1.50	●
PICCO R/L 050.4-20C	4.00	4.00	0.30	20.00	0.10	34.00	3.50	1.50	●
PICCO R/L 050.4-24C	4.00	4.00	0.30	24.00	0.10	38.00	3.50	1.50	●
PICCO R/L 050.4-28C	4.00	4.00	0.30	28.00	0.10	42.00	3.50	1.50	●
PICCO R 050.4-16C	4.00	4.00	0.30	16.00	0.10	30.00	3.50	1.50	●
PICCO R/L 050.5-10C	5.00	5.00	0.50	10.00	0.15	25.00	4.40	1.90	●
PICCO R/L 050.5-20C	5.00	5.00	0.50	20.00	0.15	35.00	4.40	1.90	●
PICCO R/L 050.5-25C	5.00	5.00	0.50	25.00	0.15	40.00	4.40	1.90	●
PICCO R/L 050.5-30C	5.00	5.00	0.50	30.00	0.15	45.00	4.40	1.90	●
PICCO R 050.5-15C	5.00	5.00	0.50	15.00	0.15	30.00	4.40	1.90	●
PICCO R 050.5-35C	5.00	5.00	0.50	35.00	0.15	50.00	4.40	1.90	●
PICCO R/L 050.6-15C	6.00	6.00	0.50	15.00	0.15	30.00	5.30	2.30	●
PICCO R/L 050.6-22C	6.00	6.00	0.50	22.00	0.15	37.00	5.30	2.30	●
PICCO R/L 050.6-25C	6.00	6.00	0.50	25.00	0.15	40.00	5.30	2.30	●
PICCO R/L 050.6-30C	6.00	6.00	0.50	30.00	0.15	45.00	5.30	2.30	●
PICCO R/L 050.6-35C	6.00	6.00	0.50	35.00	0.15	50.00	5.30	2.30	●
PICCO R/L 050.6-42C	6.00	6.00	0.50	42.00	0.15	57.00	5.30	2.30	●
PICCO R/L 050.7-20C	7.00	6.80	0.60	20.00	0.15	35.00	6.30	2.80	●
PICCO R/L 050.7-35C	7.00	6.80	0.60	35.00	0.15	50.00	6.30	2.80	●
PICCO R/L 050.7-40C	7.00	6.80	0.60	40.00	0.15	55.00	6.30	2.80	●
PICCO L 050.7-50C	7.00	6.80	0.60	50.00	0.15	65.00	6.30	2.80	●
PICCO R 050.7-25C	7.00	6.80	0.60	25.00	0.15	40.00	6.30	2.80	●
PICCO R 050.7-30C	7.00	6.80	0.60	30.00	0.15	45.00	6.30	2.80	●

• All left-hand inserts on request

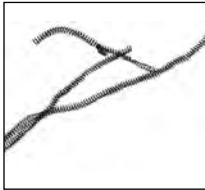
⁽¹⁾ Cutting depth maximum

Stainless Steel 316L**PICCO R 050.6-35C with Chipbreaker**

f= 0.03 mm/rev



f= 0.05 mm/rev

**PICCO R 050.6-35 Standard**

f= 0.03 mm/rev



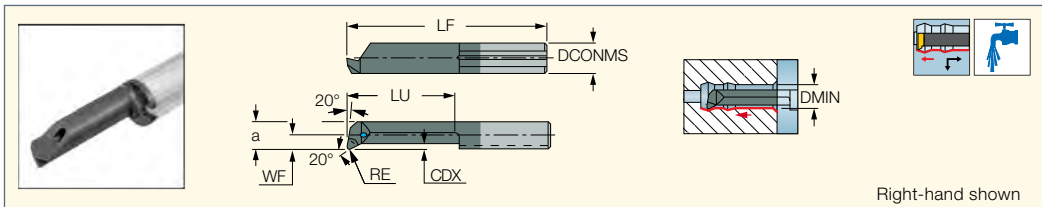
f= 0.05 mm/rev



PICCOJET
COOLANT THROUGH

PICJ R 050.20

Inserts with Inner Coolant Channel for Internal Turning and Chamfering Next to the Bottom of Blind Holes



Right-hand shown

Designation	Dimensions								IC908
	DCONMS	DMIN	CDX ⁽¹⁾	LU	RE	LF	a	WF	
PICJ RT2020D20R05-10	4.00	2.00	0.10	9.00	0.05	24.00	1.70	-	●
PICJ RT2020D30R10-10	4.00	2.80	0.20	9.00	0.10	24.00	2.60	0.60	●
PICJ RT2020D40R10-16	4.00	4.00	0.30	15.00	0.10	30.00	3.50	1.50	●
PICJ RT2020D50R15-20	5.00	5.00	0.50	19.00	0.15	35.00	4.40	1.90	●

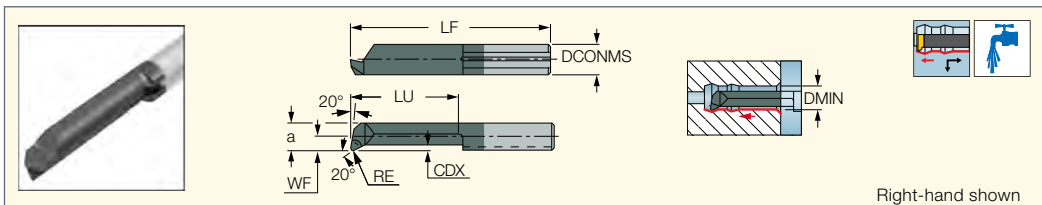
• Specify right- or left-hand bars

⁽¹⁾ Cutting depth maximum

PICCO CUT

PICCO R 050.20

Inserts for Internal Turning and Chamfering Next to the Bottom of Blind Holes



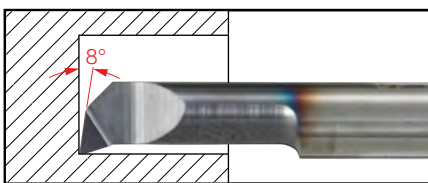
Right-hand shown

Designation	Dimensions								IC908
	DCONMS	DMIN	CDX ⁽¹⁾	LU	RE	LF	a	WF	
PICCO R 050.20.2-10	4.00	2.00	0.10	10.00	0.05	24.00	1.70	-	●
PICCO R 050.20.3-10	4.00	2.80	0.20	10.00	0.10	24.00	2.60	0.60	●
PICCO R 050.20.4-16	4.00	4.00	0.30	16.00	0.10	30.00	3.50	1.50	●
PICCO R 050.20.5-20	5.00	5.00	0.50	19.00	0.15	35.00	4.40	1.90	●

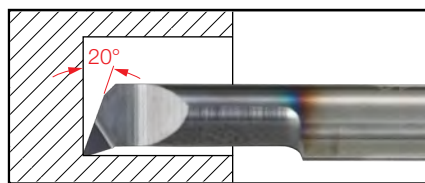
• Specify right- or left-hand bars

⁽¹⁾ Cutting depth maximum

PICCO 050...

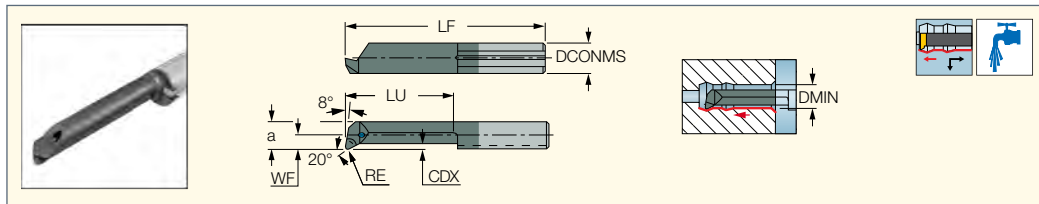


PICCO 050.20...



PICCOJET
COOLANT THROUGH**PICJ R/LHD 050**

Inserts with Inner Coolant Channel for Internal Turning and Chamfering of Hard Steel - Up to 65 HRC



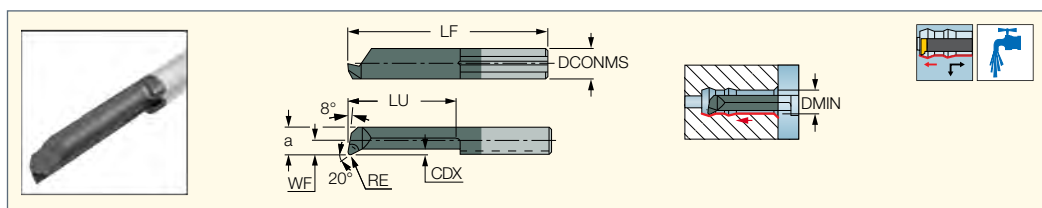
Designation	Dimensions								IC908
	DCONMS	DMIN	CDX ⁽¹⁾	LU	RE	LF	a	WF	
PICJ RT20D30R10-16 IC902	4.00	2.80	0.20	15.00	0.10	30.00	2.60	0.60	●
PICJ RT20D40R10-20 IC902	4.00	4.00	0.30	19.00	0.10	34.00	3.50	1.50	●
PICJ RT20D70R15-20 IC902	7.00	6.80	0.60	19.00	0.15	35.00	6.30	2.80	●

• Specify right- or left-hand bars

⁽¹⁾ Cutting depth maximum

**PICCO CUT****PICCO R/LHD 050**

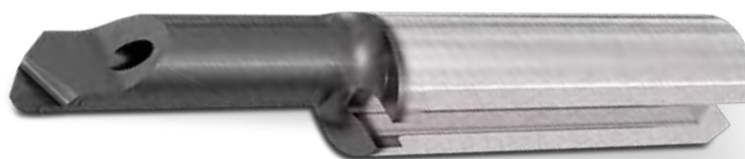
Inserts for Internal Turning and Chamfering Hard Steel - Up to 65 HRC



Designation	Dimensions								IC902
	DCONMS	DMIN	CDX ⁽¹⁾	LU	RE	LF	a	WF	
PICCO R/LHD 050.2-5	4.00	2.00	0.10	4.00	0.05	19.00	1.70	-	●
PICCO RHD 050.3-10	4.00	2.80	0.20	9.00	0.10	24.00	2.60	0.60	●
PICCO RHD 050.3-16	4.00	2.80	0.20	15.00	0.10	30.00	2.60	0.60	●
PICCO RHD 050.4-10	4.00	4.00	0.30	9.00	0.10	24.00	3.50	1.50	●
PICCO RHD 050.4-20	4.00	4.00	0.30	19.00	0.10	34.00	3.50	1.50	●
PICCO RHD 050.5-15	5.00	5.00	0.50	14.00	0.15	30.00	4.40	1.90	●
PICCO R/LHD 050.6-15	6.00	6.00	0.50	14.00	0.15	30.00	5.30	2.30	●
PICCO RHD 050.7-20	7.00	6.80	0.60	19.00	0.15	35.00	6.30	2.80	●
PICCO RHD 050.7-25	7.00	6.80	0.60	24.00	0.15	40.00	6.30	2.80	●
PICCO R/LHD 050.7-35	7.00	6.80	0.60	34.00	0.15	50.00	6.30	2.80	●

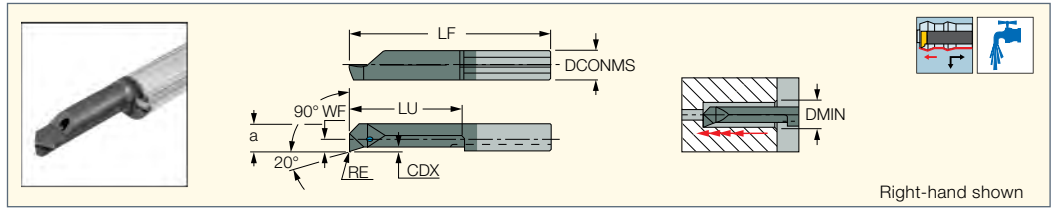
• Specify right- or left-hand bars

⁽¹⁾ Cutting depth maximum



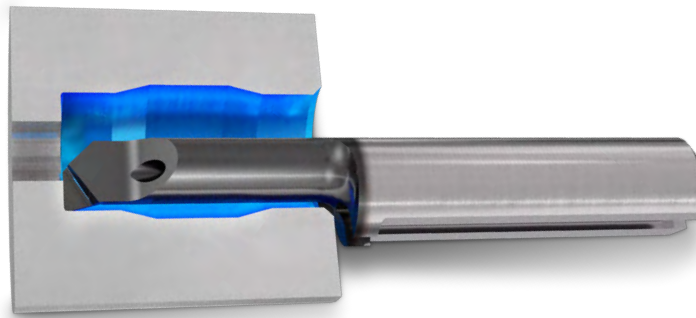
PICJ R/L 090

Inserts with Inner Coolant Channel for Internal Turning and Profiling



Designation	Dimensions								IC908
	DCONMS	DMIN	CDX ⁽¹⁾	LU	RE	LF	a	WF	
PICJ RT90D30R10-10	4.00	2.80	0.20	9.00	0.10	24.00	2.60	0.60	●
PICJ RT90D30R10-16	4.00	2.80	0.20	14.00	0.10	30.00	2.60	0.60	●
PICJ RT90D40R10-10	4.00	4.00	0.30	9.00	0.10	24.00	3.50	1.50	●
PICJ RT90D40R10-16	4.00	4.00	0.30	14.00	0.10	30.00	3.50	1.50	●
PICJ RT90D50R15-10	5.00	5.00	0.50	9.00	0.15	25.00	4.40	1.90	●
PICJ RT90D50R15-15	5.00	5.00	0.50	14.00	0.15	30.00	4.40	1.90	●
PICJ RT90D50R15-20	5.00	5.00	0.50	19.00	0.15	35.00	4.40	1.90	●

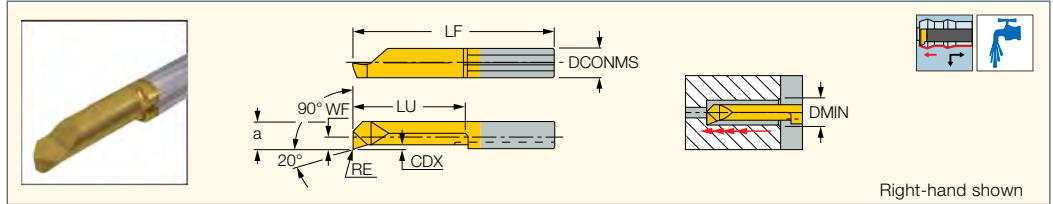
- Specify right- or left-hand bars
- ⁽¹⁾ Cutting depth maximum



PICCO CUT

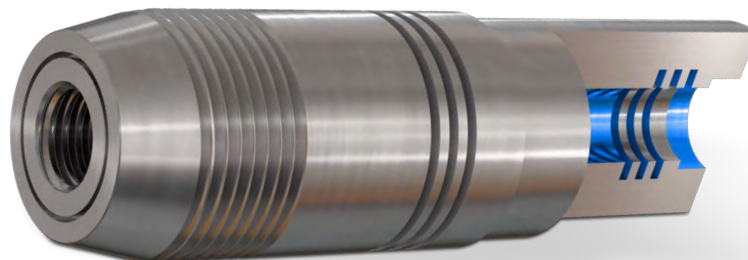
PICCO R/L 090

Inserts for Internal Turning and Profiling



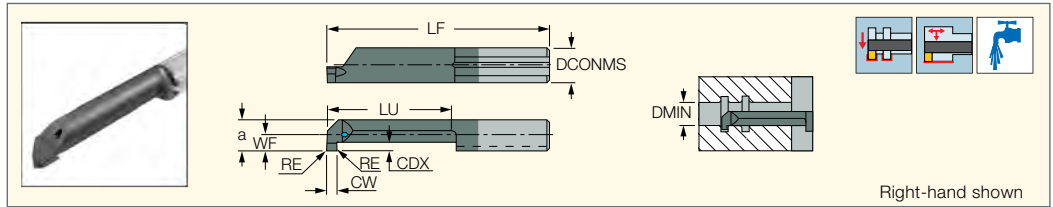
Designation	Dimensions								IC228
	DCONMS	DMIN	CDX ⁽¹⁾	LU	RE	LF	a	WF	
PICCO R/L 090.3-10	4.00	2.80	0.20	9.00	0.10	24.00	2.60	0.60	●
PICCO R/L 090.3-16	4.00	2.80	0.20	15.00	0.10	30.00	2.60	0.60	●
PICCO R/L 090.4-10	4.00	4.00	0.30	9.00	0.10	24.00	3.50	1.50	●
PICCO R/L 090.4-16	4.00	4.00	0.30	15.00	0.10	30.00	3.50	1.50	●
PICCO R/L 090.5-10	5.00	5.00	0.50	9.00	0.15	25.00	4.40	1.90	●
PICCO R 090.5-15	5.00	5.00	0.50	14.00	0.15	30.00	4.40	1.90	●
PICCO R/L 090.5-20	5.00	5.00	0.50	19.00	0.15	35.00	4.40	1.90	●

- Specify right- or left-hand bars
- ⁽¹⁾ Cutting depth maximum



PICCOJET
 COOLANT THROUGH

PICJ R/L 002-007

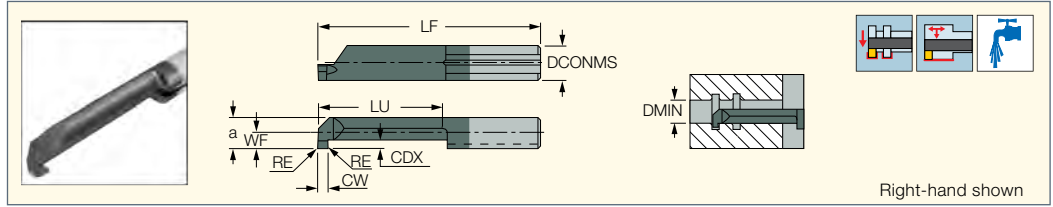
 Inserts with Inner Coolant
 Channel for Internal
 Grooving and Turning


Designation	Dimensions									IC908
	DCONMS	DMIN	CDX ⁽¹⁾	LU	RE	LF	a	WF	CW	
PICJ RG05D20R00-5	4.00	2.00	0.40	4.00	0.00	19.00	1.80	-0.20	0.50	●
PICJ RG05D20R00-10	4.00	2.00	0.40	9.00	0.00	24.00	1.80	-0.20	0.50	●
PICJ RG07D30R00-5	4.00	3.00	0.60	4.00	0.00	19.00	2.70	0.70	0.70	●
PICJ RG07D30R00-10	4.00	3.00	0.60	9.00	0.00	24.00	2.70	0.70	0.70	●
PICJ RG07D30R00-16	4.00	3.00	0.60	15.00	0.00	30.00	2.70	0.70	0.70	●
PICJ RG10D40R00-10	4.00	4.00	0.80	9.00	0.00	24.00	3.50	1.50	1.00	●
PICJ RG10D40R00-16	4.00	4.00	0.80	15.00	0.00	30.00	3.50	1.50	1.00	●
PICJ RG10D40R00-20	4.00	4.00	0.80	19.00	0.00	34.00	3.50	1.50	1.00	●
PICJ RG10D50R00-10	5.00	5.00	1.00	9.00	0.00	25.00	4.40	1.90	1.00	●
PICJ RG10D50R00-15	5.00	5.00	1.00	14.00	0.00	30.00	4.40	1.90	1.00	●
PICJ RG10D50R00-20	5.00	5.00	1.00	19.00	0.00	35.00	4.40	1.90	1.00	●
PICJ RG10D50R00-25	5.00	5.00	1.00	24.00	0.00	40.00	4.40	1.90	1.00	●
PICJ RG10D50R00-30	5.00	5.00	1.00	29.00	0.00	45.00	4.40	1.90	1.00	●
PICJ RG15D50R00-10	5.00	5.00	1.00	9.00	0.00	25.00	4.40	1.90	1.50	●
PICJ RG15D50R00-15	5.00	5.00	1.00	14.00	0.00	30.00	4.40	1.90	1.50	●
PICJ RG15D50R00-20	5.00	5.00	1.00	19.00	0.00	35.00	4.40	1.90	1.50	●
PICJ RG15D50R00-25	5.00	5.00	1.00	24.00	0.00	40.00	4.40	1.90	1.50	●
PICJ RG20D50R00-10	5.00	5.00	1.00	9.00	0.00	25.00	4.40	1.90	2.00	●
PICJ RG20D50R00-15	5.00	5.00	1.00	14.00	0.00	30.00	4.40	1.90	2.00	●
PICJ RG20D50R00-20	5.00	5.00	1.00	19.00	0.00	35.00	4.40	1.90	2.00	●
PICJ RG20D50R00-30	5.00	5.00	1.00	29.00	0.00	45.00	4.40	1.90	2.00	●
PICJ R/LG10D60R00-10	6.00	6.00	1.80	9.00	0.00	25.00	5.30	2.30	1.00	●
PICJ RG10D60R00-15	6.00	6.00	1.80	14.00	0.00	30.00	5.30	2.30	1.00	●
PICJ RG10D60R00-22	6.00	6.00	1.80	21.00	0.00	37.00	5.30	2.30	1.00	●
PICJ RG10D60R00-25	6.00	6.00	1.80	24.00	0.00	40.00	5.30	2.30	1.00	●
PICJ RG10D60R00-30	6.00	6.00	1.80	29.00	0.00	45.00	5.30	2.30	1.00	●
PICJ R/LG15D60R00-10	6.00	6.00	1.80	9.00	0.00	25.00	5.30	2.30	1.50	●
PICJ RG15D60R00-15	6.00	6.00	1.80	14.00	0.00	30.00	5.30	2.30	1.50	●
PICJ RG15D60R00-22	6.00	6.00	1.80	21.00	0.00	37.00	5.30	2.30	1.50	●
PICJ RG15D60R00-25	6.00	6.00	1.80	24.00	0.00	40.00	5.30	2.30	1.50	●
PICJ RG15D60R00-30	6.00	6.00	1.80	29.00	0.00	45.00	5.30	2.30	1.50	●
PICJ RG20D60R00-10	6.00	6.00	1.80	9.00	0.00	25.00	5.30	2.30	2.00	●
PICJ RG20D60R00-15	6.00	6.00	1.80	14.00	0.00	30.00	5.30	2.30	2.00	●
PICJ R/LG20D60R00-22	6.00	6.00	1.80	21.00	0.00	37.00	5.30	2.30	2.00	●
PICJ RG20D60R00-25	6.00	6.00	1.80	24.00	0.00	40.00	5.30	2.30	2.00	●
PICJ RG20D60R00-30	6.00	6.00	1.80	29.00	0.00	45.00	5.30	2.30	2.00	●
PICJ RG10D70R00-10	7.00	6.80	2.50	9.00	0.00	25.00	6.30	2.80	1.00	●
PICJ RG10D70R00-15	7.00	6.80	2.50	14.00	0.00	30.00	6.30	2.80	1.00	●
PICJ RG10D70R00-22	7.00	6.80	2.50	21.00	0.00	37.00	6.30	2.80	1.00	●
PICJ RG10D70R00-25	7.00	6.80	2.50	24.00	0.00	40.00	6.30	2.80	1.00	●
PICJ RG10D70R00-30	7.00	6.80	2.50	29.00	0.00	45.00	6.30	2.80	1.00	●
PICJ RG15D70R00-10	7.00	6.80	2.50	9.00	0.00	25.00	6.30	2.80	1.50	●
PICJ RG15D70R00-15	7.00	6.80	2.50	14.00	0.00	30.00	6.30	2.80	1.50	●
PICJ RG15D70R00-22	7.00	6.80	2.50	21.00	0.00	37.00	6.30	2.80	1.50	●
PICJ RG15D70R00-25	7.00	6.80	2.50	24.00	0.00	40.00	6.30	2.80	1.50	●
PICJ RG15D70R00-30	7.00	6.80	2.50	29.00	0.00	45.00	6.30	2.80	1.50	●
PICJ RG20D70R00-10	7.00	6.80	2.50	9.00	0.00	25.00	6.30	2.80	2.00	●
PICJ R/LG20D70R00-15	7.00	6.80	2.50	14.00	0.00	30.00	6.30	2.80	2.00	●
PICJ RG20D70R00-22	7.00	6.80	2.50	21.00	0.00	37.00	6.30	2.80	2.00	●
PICJ R/LG20D70R00-25	7.00	6.80	2.50	24.00	0.00	40.00	6.30	2.80	2.00	●
PICJ RG20D70R00-30	7.00	6.80	2.50	29.00	0.00	45.00	6.30	2.80	2.00	●

• All carbide bars with sharp corners • Specify right- or left-hand bars

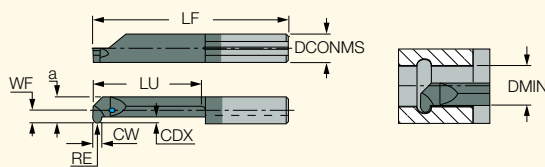
(1) Cutting depth maximum





Designation	Dimensions									Tough ↔ Hard	
	DCONMS	DMIN	CDX ⁽¹⁾	LU	RE	LF	a	WF	CW	IC228	IC908
PICCO R 002.0050-5	4.00	2.00	0.40	5.00	0.00	19.00	1.80	0.20	0.50		●
PICCO R 002.0050-10	4.00	2.00	0.40	10.00	0.00	24.00	1.80	0.20	0.50		●
PICCO R/L 002.0050-15	4.00	2.00	0.40	15.00	0.00	29.00	1.80	0.20	0.50		●
PICCO R 003.0070-5	4.00	3.00	0.60	5.00	0.00	19.00	2.70	0.70	0.70		●
PICCO R 003.0070-10	4.00	3.00	0.60	10.00	0.00	24.00	2.70	0.70	0.70		●
PICCO R 003.0070-16	4.00	3.00	0.60	15.00	0.00	29.00	2.70	0.70	0.70		●
PICCO R/L 004.0100-10	4.00	4.00	0.80	9.00	0.00	24.00	3.50	1.50	1.00	●	
PICCO R/L 004.0100-16	4.00	4.00	0.80	15.00	0.00	30.00	3.50	1.50	1.00	●	
PICCO R/L 004.0100-20	4.00	4.00	0.80	19.00	0.00	34.00	3.50	1.50	1.00	●	
PICCO R/L 005.0100-10	5.00	5.00	1.00	9.00	0.00	25.00	4.40	1.90	1.00	●	
PICCO R/L 005.0100-15	5.00	5.00	1.00	14.00	0.00	30.00	4.40	1.90	1.00	●	
PICCO R/L 005.0100-20	5.00	5.00	1.00	19.00	0.00	35.00	4.40	1.90	1.00	●	
PICCO R/L 005.0100-25	5.00	5.00	1.00	24.00	0.00	40.00	4.40	1.90	1.00	●	
PICCO R/L 005.0100-30	5.00	5.00	1.00	29.00	0.00	45.00	4.40	1.90	1.00	●	
PICCO R/L 005.0150-10	5.00	5.00	1.00	9.00	0.00	25.00	4.40	1.90	1.50	●	
PICCO R/L 005.0150-15	5.00	5.00	1.00	14.00	0.00	30.00	4.40	1.90	1.50	●	
PICCO R 005M0150-15	5.00	5.00	1.00	14.00	0.10	30.00	4.00	1.90	1.50		●
PICCO R/L 005.0150-20	5.00	5.00	1.00	19.00	0.00	35.00	4.40	1.90	1.50	●	
PICCO R/L 005.0150-25	5.00	5.00	1.00	24.00	0.00	40.00	4.40	1.90	1.50	●	
PICCO R 005.0150-30	5.00	5.00	1.00	29.00	0.00	45.00	4.40	1.90	1.50	●	
PICCO R/L 005.0200-10	5.00	5.00	1.00	9.00	0.00	25.00	4.40	1.90	2.00	●	
PICCO R/L 005.0200-15	5.00	5.00	1.00	14.00	0.00	30.00	4.40	1.90	2.00	●	
PICCO R/L 005.0200-20	5.00	5.00	1.00	19.00	0.00	35.00	4.40	1.90	2.00	●	
PICCO R 005.0200-25	5.00	5.00	1.00	24.00	0.00	40.00	4.40	1.90	2.00	●	
PICCO R 005.0200-30	5.00	5.00	1.00	29.00	0.00	45.00	4.40	1.90	2.00	●	
PICCO R/L 006.0100-10	6.00	6.00	1.80	9.00	0.00	25.00	5.30	2.30	1.00	●	
PICCO R/L 006.0100-15	6.00	6.00	1.80	14.00	0.00	30.00	5.30	2.30	1.00	●	
PICCO R/L 006.0100-22	6.00	6.00	1.80	21.00	0.00	37.00	5.30	2.30	1.00	●	
PICCO R/L 006.0100-25	6.00	6.00	1.80	24.00	0.00	40.00	5.30	2.30	1.00	●	
PICCO R/L 006.0100-30	6.00	6.00	1.80	29.00	0.00	45.00	5.30	2.30	1.00	●	
PICCO R/L 006.0150-10	6.00	6.00	1.80	9.00	0.00	25.00	5.30	2.30	1.50	●	
PICCO R/L 006.0150-15	6.00	6.00	1.80	14.00	0.00	30.00	5.30	2.30	1.50	●	
PICCO R/L 006.0150-22	6.00	6.00	1.80	21.00	0.00	37.00	5.30	2.30	1.50	●	
PICCO R/L 006.0150-25	6.00	6.00	1.80	24.00	0.00	40.00	5.30	2.30	1.50	●	
PICCO R 006.0150-30	6.00	6.00	1.80	29.00	0.00	45.00	5.30	2.30	1.50	●	
PICCO R/L 006.0200-10	6.00	6.00	1.80	9.00	0.00	25.00	5.30	2.30	2.00	●	
PICCO R/L 006.0200-15	6.00	6.00	1.80	14.00	0.00	30.00	5.30	2.30	2.00	●	
PICCO R 006M0200-15	6.00	6.00	1.80	14.00	0.10	30.00	5.30	2.30	2.00		●
PICCO R/L 006.0200-22	6.00	6.00	1.80	21.00	0.00	37.00	5.30	2.30	2.00	●	
PICCO R/L 006.0200-25	6.00	6.00	1.80	24.00	0.00	40.00	5.30	2.30	2.00	●	
PICCO R/L 006.0200-30	6.00	6.00	1.80	29.00	0.00	45.00	5.30	2.30	2.00	●	
PICCO R/L 007.0100-10	7.00	6.80	2.50	9.00	0.00	25.00	6.30	2.80	1.00	●	
PICCO R/L 007.0100-15	7.00	6.80	2.50	14.00	0.00	30.00	6.30	2.80	1.00	●	
PICCO R/L 007.0100-22	7.00	6.80	2.50	21.00	0.00	37.00	6.30	2.80	1.00	●	
PICCO R/L 007.0100-25	7.00	6.80	2.50	24.00	0.00	40.00	6.30	2.80	1.00	●	
PICCO R/L 007.0100-30	7.00	6.80	2.50	29.00	0.00	45.00	6.30	2.80	1.00	●	
PICCO R/L 007.0150-10	7.00	6.80	2.50	9.00	0.00	25.00	6.30	2.80	1.50	●	
PICCO R/L 007.0150-15	7.00	6.80	2.50	14.00	0.00	30.00	6.30	2.80	1.50	●	
PICCO R/L 007.0150-22	7.00	6.80	2.50	21.00	0.00	37.00	6.30	2.80	1.50	●	
PICCO R/L 007.0150-25	7.00	6.80	2.50	24.00	0.00	40.00	6.30	2.80	1.50	●	
PICCO R/L 007.0150-30	7.00	6.80	2.50	29.00	0.00	45.00	6.30	2.80	1.50	●	
PICCO R/L 007.0200-10	7.00	6.80	2.50	9.00	0.00	25.00	6.30	2.80	2.00	●	
PICCO R/L 007.0200-15	7.00	6.80	2.50	14.00	0.00	30.00	6.30	2.80	2.00	●	
PICCO R 007M0200-15	7.00	6.80	2.50	14.00	0.10	30.00	6.30	2.80	2.00		●
PICCO R/L 007.0200-22	7.00	6.80	2.50	21.00	0.00	37.00	6.30	2.80	2.00	●	
PICCO R/L 007.0200-25	7.00	6.80	2.50	24.00	0.00	40.00	6.30	2.80	2.00	●	
PICCO R/L 007.0200-30	7.00	6.80	2.50	29.00	0.00	45.00	6.30	2.80	2.00	●	

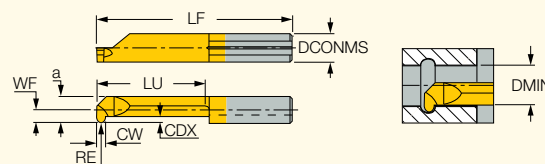
● All carbide bars with sharp corners ● Specify right- or left-hand bars

PICCOJET
COOLANT THROUGH**PICJ R/L 004-007 (Radius)**Full Radius Inserts with
Inner Coolant Channel
for Internal Profiling

Right-hand shown

Designation	Dimensions									IC908
	DCONMS	DMIN	CDX ⁽¹⁾	LU	RE	LF	a	WF	CW	
PICJ RP10D40-16	4.00	4.00	0.80	15.00	0.50	30.00	3.50	1.50	1.00	●
PICJ RP10D50-20	5.00	5.00	1.00	19.00	0.50	35.00	4.40	1.90	1.00	●
PICJ RP10D60-25	6.00	6.00	1.80	24.00	0.50	40.00	5.30	2.30	1.00	●
PICJ RP15D60-25	6.00	6.00	1.80	24.00	0.75	40.00	5.30	2.30	1.50	●
PICJ RP20D60-25	6.00	6.00	1.80	24.00	1.00	40.00	5.30	2.30	2.00	●
PICJ RP10D70-30	7.00	6.80	2.50	29.00	0.50	45.00	6.30	2.80	1.00	●
PICJ RP20D70-30	7.00	6.80	2.50	29.00	1.00	45.00	6.30	2.80	2.00	●

● Specify right- or left-hand bars

⁽¹⁾ Cutting depth maximum**PICCO CUT****PICCO R/L 004-007 (Radius)**Full Radius Inserts for
Internal Profiling

Right-hand shown

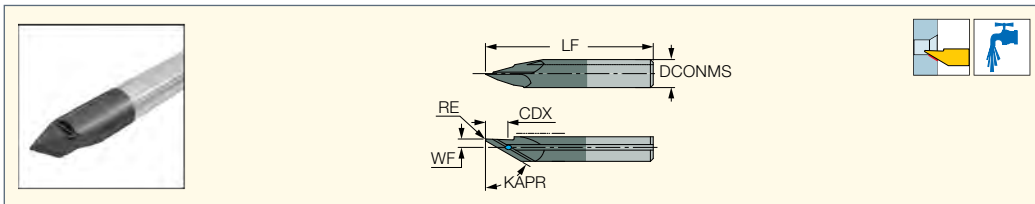
Designation	Dimensions									IC228
	DCONMS	DMIN	CDX ⁽¹⁾	LU	RE	LF	a	WF	CW	
PICCO R/L 004.0.50-16	4.00	4.00	0.80	15.00	0.50	30.00	3.50	1.50	1.00	●
PICCO R/L 005.0.50-20	5.00	5.00	1.00	19.00	0.50	35.00	4.40	1.90	1.00	●
PICCO R/L 005.0.75-20	5.00	5.00	1.00	19.00	0.75	35.00	4.40	1.90	1.50	●
PICCO R/L 005.1.00-20	5.00	5.00	1.00	19.00	1.00	35.00	4.40	1.90	2.00	●
PICCO R/L 006.0.50-25	6.00	6.00	1.80	24.00	0.50	40.00	5.30	2.30	1.00	●
PICCO R/L 006.0.75-25	6.00	6.00	1.80	24.00	0.75	40.00	5.30	2.30	1.50	●
PICCO R/L 006.1.00-25	6.00	6.00	1.80	24.00	1.00	40.00	5.30	2.30	2.00	●
PICCO R/L 007.0.50-30	7.00	6.80	2.50	29.00	0.50	45.00	6.30	2.80	1.00	●
PICCO R/L 007.0.75-30	7.00	6.80	2.50	29.00	0.75	45.00	6.30	2.80	1.50	●
PICCO R/L 007.1.00-30	7.00	6.80	2.50	29.00	1.00	45.00	6.30	2.80	2.00	●

● Specify right- or left-hand bars

⁽¹⁾ Cutting depth maximum

PICJ R/L 520

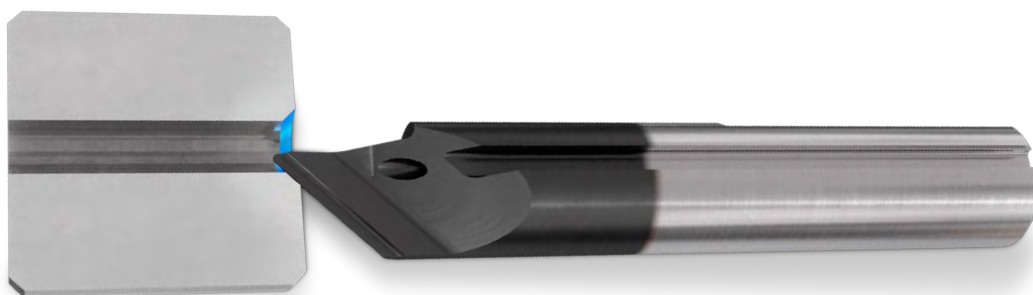
Inserts with Inner Coolant Channel for Internal Chamfering



Designation	Dimensions							IC908
	DCONMS	DMIN	CDX	RE	LF	WF	KAPR ⁽¹⁾	
PICJ RCH45-15	5.00	1.00	3.50	0.20	30.00	1.50	45.0	●

• DMIN for internal applications=20 mm

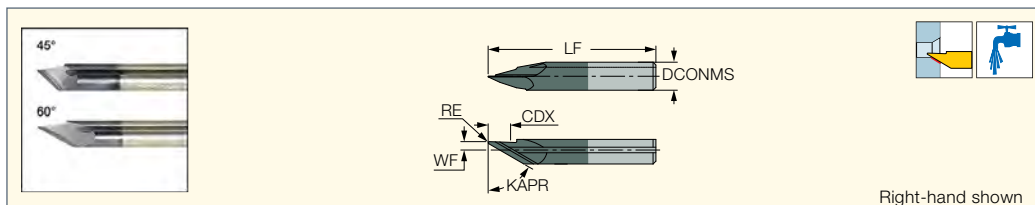
⁽¹⁾ Tool cutting edge angle



PICCO CUT

PICCO R/L 520

Inserts for Internal Chamfering

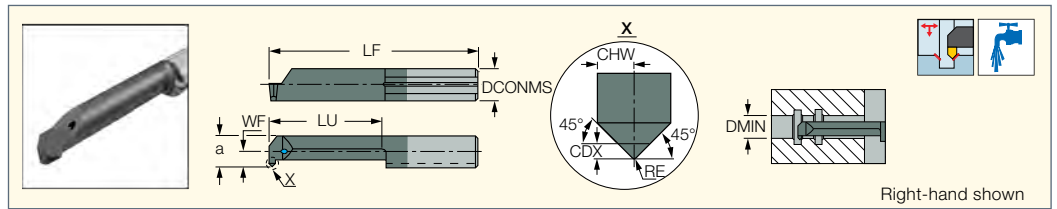


Right-hand shown

Designation	Dimensions							IC908
	DCONMS	DMIN	CDX	RE	LF	WF	KAPR ⁽¹⁾	
PICCO R/L 520.0045-15	5.00	1.00	3.50	0.20	30.00	1.50	45.0	●
PICCO R/L 520.0060-15	5.00	1.00	4.00	0.20	30.00	1.50	60.0	●

• Left hand inserts on request

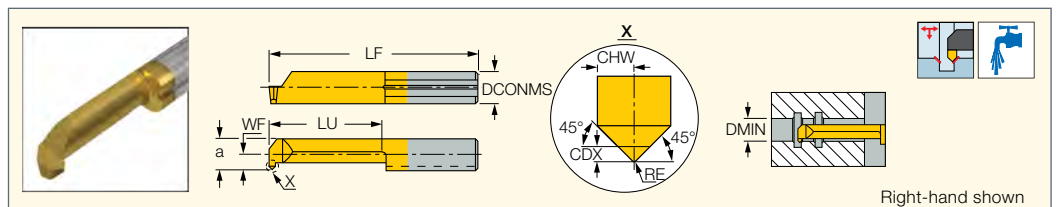
⁽¹⁾ Tool cutting edge angle

PICCOJET
COOLANT THROUGH**PICJ R/L 060**Inserts with Inner Coolant
Channel for Internal Turning
and 45° Chamfering

Designation	Dimensions									IC908
	DCONMS	DMIN	CDX ⁽¹⁾	LU	RE	LF	a	WF	CHW	
PICJ RT45D50R20-15	5.00	5.00	0.70	14.00	0.20	30.00	4.40	1.90	1.0	●
PICJ RT45D50R20-20	5.00	5.00	0.70	19.00	0.20	35.00	4.40	1.90	1.0	●
PICJ RT45D70R20-20	7.00	6.80	0.70	19.00	0.20	35.00	6.30	2.80	1.0	●

- Specify right- or left-hand bars

⁽¹⁾ Cutting depth maximum

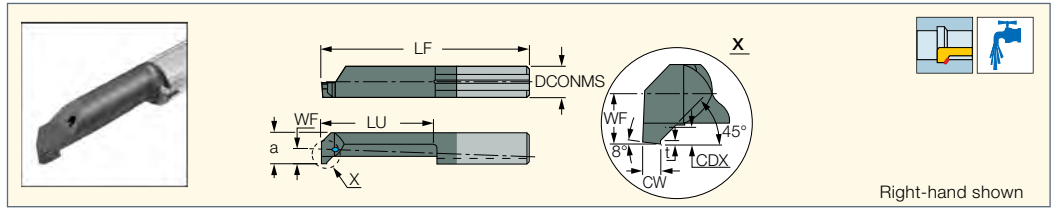
**PICCO CUT****PICCO R/L 060**Inserts for Internal Turning
and 45° Chamfering

Designation	Dimensions									Tough ↔ Hard	
	DCONMS	DMIN	CDX ⁽¹⁾	LU	RE	LF	a	WF	CHW	IC228	IC908
PICCO R/L 060.5-15	5.00	5.00	0.70	14.00	0.20	30.00	4.40	1.90	1.0	●	
PICCO R/L 060.5-20	5.00	5.00	0.70	19.00	0.20	35.00	4.40	1.90	1.0	●	
PICCO R 060.6-20	6.00	6.00	0.70	20.00	0.20	35.00	5.30	2.30	1.0		●
PICCO R 060.6-25	6.00	6.00	0.70	25.00	0.20	40.00	5.30	2.30	1.0		●
PICCO R/L 060.7-20	7.00	6.80	0.70	19.00	0.20	35.00	6.30	2.80	1.0	●	
PICCO R 060.7-40	7.00	6.80	0.70	40.00	0.20	55.00	6.30	2.80	1.0		●

- Specify right- or left-hand bars

⁽¹⁾ Cutting depth maximum

PICJ R/L 070
Back Chamfering Inserts
with Inner Coolant Channel
for Pre-Parting Operations



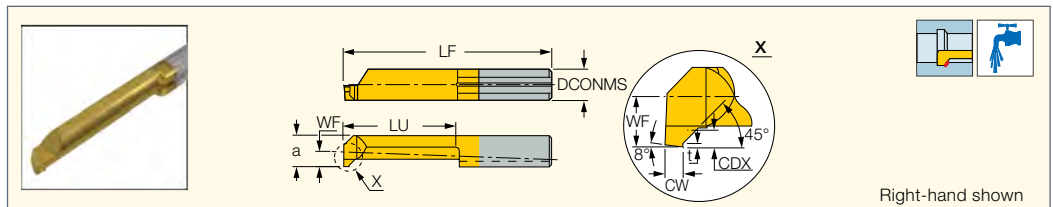
Designation	Dimensions									IC908
	DCONMS	DMIN	CDX ⁽¹⁾	LU	LF	a	WF	CW	t	
PICJ RBCD50-15	5.00	5.00	1.00	14.00	30.00	4.40	1.90	1.00	0.20	●
PICJ RBCD50-20	5.00	5.00	1.00	19.00	35.00	4.40	1.90	1.00	0.20	●

- All carbide bars with sharp corners
 - Specify right- or left-hand bars
- ⁽¹⁾ Cutting depth maximum



PICCOJET

PICCO R/L 070
Back Chamfering Inserts for
Pre-Parting Operations



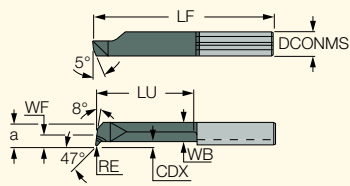
Designation	Dimensions									IC228
	DCONMS	DMIN	CDX ⁽¹⁾	LU	LF	a	WF	CW	t	
PICCO R/L 070.5-15	5.00	5.00	1.00	15.00	30.00	4.40	1.90	1.00	0.20	●
PICCO R/L 070.5-20	5.00	5.00	1.00	20.00	35.00	4.40	1.90	1.00	0.20	●

- All carbide bars with sharp corners
 - Specify right- or left-hand bars
- ⁽¹⁾ Cutting depth maximum

PICCO^{CUT}

PICCO R/L 047

Inserts for Internal Deep Profiling

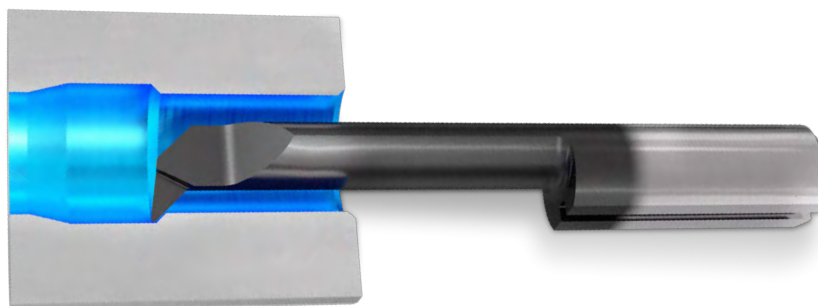


Right-hand shown

Designation	Dimensions									IC908
	DCONMS	DMIN	CDX ⁽¹⁾	LU	RE	LF	a	WF	WB	
PICCO R/L 047.4-20	4.00	4.00	0.30	20.00	0.15	34.00	3.50	1.50	3.00	●
PICCO R/L 047.5-25	5.00	5.00	0.50	25.00	0.15	40.00	4.40	1.90	3.80	●
PICCO R/L 047.6-30	6.00	6.00	0.50	30.00	0.15	45.00	5.30	2.30	4.50	●
PICCO R 047.T6-22	6.00	6.00	1.80	22.00	0.15	37.00	5.30	2.30	3.40	●
PICCO R 047.T6-30	6.00	6.00	1.80	30.00	0.15	45.00	5.30	2.30	3.40	●

• Left hand inserts on request

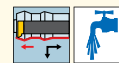
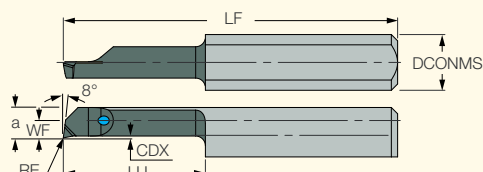
⁽¹⁾ Cutting depth maximum



PICCO^{CUT}

PICCO R/LM

Profiling Inserts with Coolant Channel Optimized for Machining Medical Parts



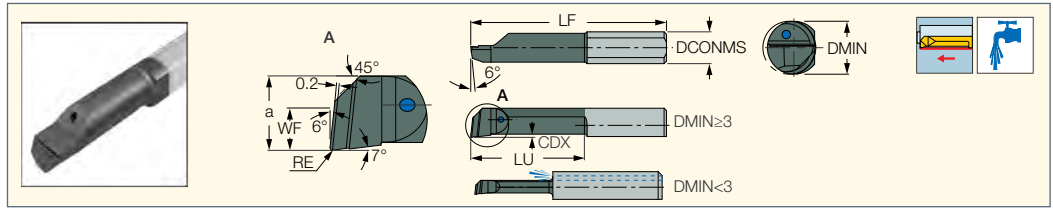
Designation	Dimensions								Tough ↔ Hard	
	DCONMS	DMIN	CDX ⁽¹⁾	LU	RE	LF	a	WF	IC908	IC909
PICCO R/LM050.05-2	4.00	0.50	0.02	2.00	0.02	20.00	0.40	0.20		●
PICCO LM050.08-4	4.00	0.80	0.03	4.00	0.02	20.00	0.70	0.20		●
PICCO RM050.08-4	4.00	0.80	0.03	4.00	0.02	20.00	0.70	0.40		●
PICCO R/LM050.1-5	4.00	1.00	0.05	5.00	0.02	20.00	0.90	0.40		●
PICCO R/LM050.1-7	4.00	1.00	0.05	7.00	0.02	22.00	0.90	0.40		●
PICCO R/LM050.15-10	4.00	1.50	0.08	10.00	0.02	24.00	1.15	0.60		●
PICCO R/LM050.15-5	4.00	1.50	0.08	5.00	0.02	19.00	1.15	0.60		●
PICCO R/LM050.2-10	4.00	2.00	0.08	10.00	0.02	24.00	1.70	0.80		●
PICCO R/LM050.2-5	4.00	2.00	0.08	5.00	0.02	19.00	1.70	0.80		●
PICCO R/LM050.25-10	4.00	2.50	0.10	10.00	0.02	24.00	2.20	0.20		●
PICCO R/LM050.25-5	4.00	2.50	0.10	5.00	0.02	19.00	2.20	0.20		●
PICCO R/LM050.3-10	4.00	3.00	0.15	10.00	0.02	24.00	2.60	0.60		●
PICCO R/LM050.3-16	4.00	3.00	0.15	16.00	0.02	30.00	2.60	0.60		●
PICCO LM050.35-10	4.00	3.50	0.17	10.00	0.02	24.00	3.40	1.10		●
PICCO R/LM050.35-16	4.00	3.50	0.17	16.00	0.02	30.00	3.10	1.10		●
PICCO R/LM050.35-20	4.00	3.50	0.17	20.00	0.02	34.00	3.10	1.10		●
PICCO RM050.35-10	4.00	3.50	0.17	10.00	0.02	24.00	3.10	1.10		●
PICCO R/LM050.4-10	4.00	4.00	0.20	10.00	0.02	24.00	3.50	1.50		●
PICCO R/LM050.4-16	4.00	4.00	0.20	16.00	0.02	30.00	3.50	1.50		●
PICCO LM050.4-20	4.00	4.00	0.20	20.00	0.02	34.00	3.50	1.50		●
PICCO R/LM050.4-24	4.00	4.00	0.20	24.00	0.02	38.00	3.50	1.50		●
PICCO RM050.4-20	4.00	4.00	0.20	20.00	0.02	34.00	3.50	1.50	●	

• An optimized insert geometry and carbide grade for machining medical parts made from titanium, medical standard stainless steel and other difficult to machine materials.

⁽¹⁾ Cutting depth maximum

PICCO^{CUT}

PICCO R/LX050
Reinforced Boring Inserts
with Internal Coolant Holes

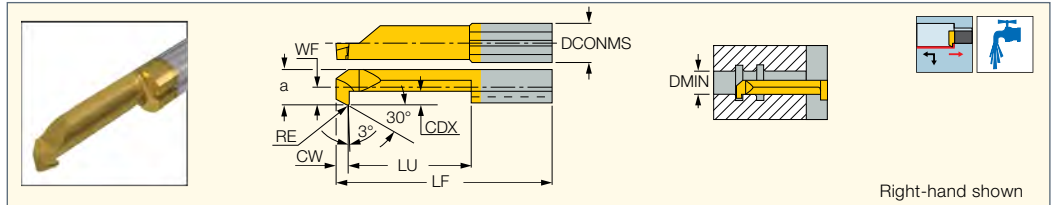


Designation	Dimensions									IC908
	DCONMS	DMIN	CDX ⁽¹⁾	LU	RE	LF	a	WF		
PICCO R/LX050.2-5R15	4.00	2.00	0.10	5.00	0.15	19.00	1.80	-	•	
PICCO R/LX050.2-10R05	4.00	2.00	0.10	10.00	0.05	24.00	1.80	-	•	
PICCO R/LX050.2-10R15	4.00	2.00	0.10	10.00	0.15	24.00	1.80	-	•	
PICCO R/LX050.3-16R10	4.00	3.00	0.15	16.00	0.10	30.00	2.70	0.70	•	
PICCO R/LX050.3-16R20	4.00	3.00	0.15	16.00	0.20	30.00	2.70	0.70	•	
PICCO R/LX050.4-10R10	4.00	4.00	0.20	10.00	0.10	24.00	3.60	1.60	•	
PICCO R/LX050.4-10R20	4.00	4.00	0.20	10.00	0.20	24.00	3.60	1.60	•	
PICCO R/LX050.4-16R10	4.00	4.00	0.20	16.00	0.10	30.00	3.60	1.60	•	
PICCO R/LX050.4-16R20	4.00	4.00	0.20	16.00	0.20	30.00	3.60	1.60	•	
PICCO R/LX050.5-15R10	5.00	5.00	0.30	15.00	0.10	30.00	4.60	2.10	•	
PICCO R/LX050.5-15R20	5.00	5.00	0.30	15.00	0.20	30.00	4.60	2.10	•	
PICCO R/LX050.5-25R10	5.00	5.00	0.30	25.00	0.10	40.00	4.60	2.10	•	
PICCO R/LX050.5-25R20	5.00	5.00	0.30	25.00	0.20	40.00	4.60	2.10	•	
PICCO R/LX050.6-15R10	6.00	6.00	0.40	15.00	0.10	30.00	5.50	2.50	•	
PICCO R/LX050.6-15R20	6.00	6.00	0.40	15.00	0.20	30.00	5.50	2.50	•	
PICCO R/LX050.6-22R20	6.00	6.00	0.40	22.00	0.20	37.00	5.50	2.50	•	
PICCO R/LX050.6-35R20	6.00	6.00	0.40	35.00	0.20	50.00	5.50	2.50	•	

- Left-hand inserts on request
- ⁽¹⁾ Cutting depth maximum

PICCO^{CUT}

PICCO R/L 080
Inserts for Internal Back Turning

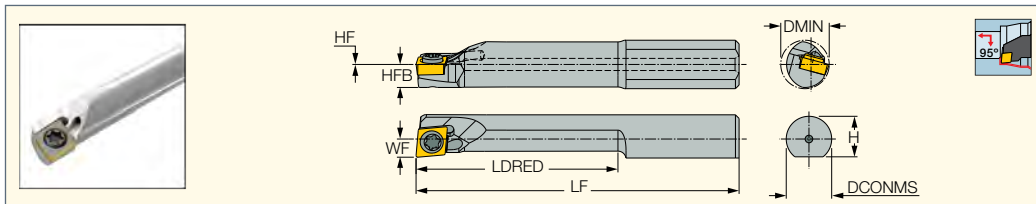


Designation	Dimensions									IC228
	DCONMS	DMIN	CDX ⁽¹⁾	LU	RE	LF	a	WF	CW	
PICCO R/L 080.0003-15	4.00	3.00	0.50	14.00	0.10	30.00	2.60	0.60	1.50	•
PICCO R/L 080.0003-20	4.00	3.00	0.50	19.00	0.10	34.00	2.60	0.60	1.50	•
PICCO R/L 080.0004-15	4.00	4.00	0.80	14.00	0.15	30.00	3.50	1.50	1.50	•
PICCO R/L 080.0004-25	4.00	4.00	0.80	24.00	0.15	39.00	3.50	1.50	1.50	•
PICCO R/L 080.0005-20	5.00	5.00	1.00	19.00	0.20	35.00	4.40	1.90	1.50	•
PICCO R/L 080.0005-30	5.00	5.00	1.00	29.00	0.20	45.00	4.40	1.90	1.50	•
PICCO R/L 080.0006-20	6.00	6.00	1.80	19.00	0.20	35.00	5.30	2.30	1.50	•
PICCO R/L 080.0006-30	6.00	6.00	1.80	29.00	0.20	45.00	5.30	2.30	1.50	•
PICCO R/L 080.0007-20	7.00	7.00	2.50	19.00	0.20	35.00	6.30	2.80	1.50	•
PICCO R/L 080.0007-30	7.00	7.00	2.50	29.00	0.20	45.00	6.30	2.80	1.50	•

- Specify right- or left-hand bars
- ⁽¹⁾ Cutting depth maximum

PICCOINDEX
INDEXABLE INSERTS

PICIN-A-SCLCR/L
PICCO Tools on which 80° Rhombic Inserts are Mounted

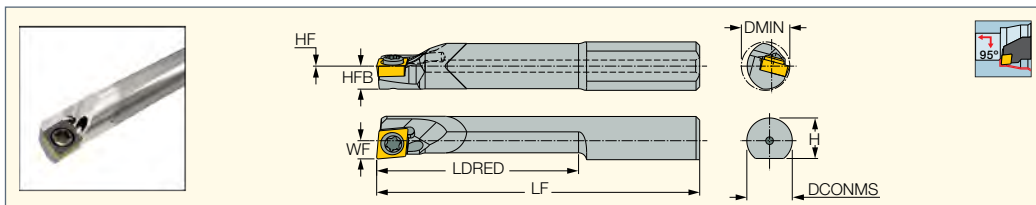


Designation	DCONMS	DMIN	LDRED	LF	WF	H	HF	HFB	CSP ⁽¹⁾	MIID ⁽²⁾		
PICIN A05-T10-SCLCR/L-03	5.00	4.50	10.0	25.00	1.85	4.5	0.0	2.1	1	CCGT 03X101-F1P	CSTA-1.6	T-6/5
PICIN A05-T20-SCLCR/L-03	5.00	4.50	20.0	35.00	1.85	4.5	0.0	2.1	1	CCGT 03X101-F1P	CSTA-1.6	T-6/5
PICIN A06-T15-SCLCR/L-03	6.00	6.00	15.0	30.00	2.25	5.4	0.0	2.9	1	CCGT 03X101-F1P	CSTA-1.6	T-6/5
PICIN A06-T25-SCLCR/L-03	6.00	6.00	25.0	40.00	2.25	5.4	0.0	2.9	1	CCGT 03X101-F1P	CSTA-1.6	T-6/5

⁽¹⁾ 0 - Without coolant supply, 1 - With coolant supply
⁽²⁾ Master insert identification

PICCOINDEX
INDEXABLE INSERTS

PICIN-SCLCR/L
Solid Carbide PICCO Tools Carrying 80° Rhombic Inserts

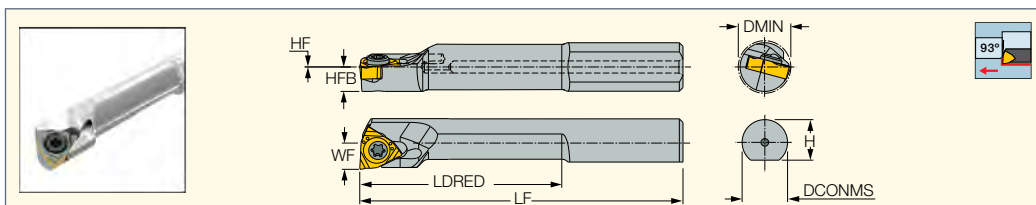


Designation	DCONMS	DMIN	LDRED	LF	WF	H	HF	HFB	CSP ⁽¹⁾	MIID ⁽²⁾		
PICIN E05-T20-SCLCR/L-03	5.00	4.50	20.0	35.00	1.85	4.5	0.0	2.1	1	CCGT 03X101-F1P	CSTA-1.6	T-6/5
PICIN E06-T25-SCLCR/L-03	6.00	6.00	25.0	40.00	2.25	5.4	0.0	2.9	1	CCGT 03X101-F1P	CSTA-1.6	T-6/5
PICIN E05-T30-SCLCR/L-03	5.00	4.50	30.0	45.00	1.85	4.5	0.0	2.1	1	CCGT 03X101-F1P	CSTA-1.6	T-6/5
PICIN E06-T35-SCLCR/L-03	6.00	6.00	35.0	50.00	2.25	5.4	0.0	2.9	1	CCGT 03X101-F1P	CSTA-1.6	T-6/5

⁽¹⁾ 0 - Without coolant supply, 1 - With coolant supply
⁽²⁾ Master insert identification

PICCOINDEX
INDEXABLE INSERTS

PICIN-A-SWUBR/L
PICCO Tools on which Small WBMT/WBGT Trigon Inserts are mounted

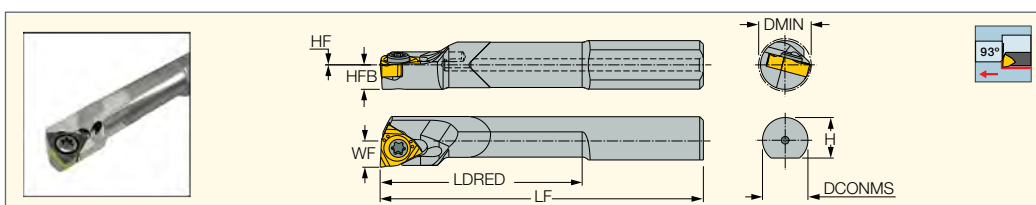


Designation	DCONMS	DMIN	LDRED	LF	WF	H	HF	HFB	CSP ⁽¹⁾	MIID ⁽²⁾		
PICIN A06-T15-SWUBL-06	6.00	6.50	15.0	30.00	3.25	5.4	0.0	3.0	1	WBMT 060101R	SR 14-552	T-6/5
PICIN A06-T15-SWUBR-06	6.00	6.50	15.0	30.00	3.25	5.4	0.0	3.0	1	WBMT 060101L	SR 14-552	T-6/5
PICIN A06-T25-SWUBL-06	6.00	6.50	25.0	40.00	3.25	5.4	0.0	3.0	1	WBMT 060101R	SR 14-552	T-6/5
PICIN A06-T25-SWUBR-06	6.00	6.50	25.0	40.00	3.25	5.4	0.0	3.0	1	WBMT 060101L	SR 14-552	T-6/5

• Use right-hand WBMT 06...R inserts on left-hand tools and left-hand WBMT 06...L inserts on right-hand tools.
⁽¹⁾ 0 - Without coolant supply, 1 - With coolant supply
⁽²⁾ Master insert identification

PICCOINDEX
INDEXABLE INSERTS

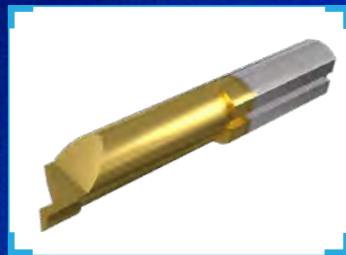
PICIN-SWUBR/L
Solid Carbide PICCO Tools Carrying Small WBMT/WBGT Trigon Inserts



Designation	DCONMS	DMIN	LDRED	LF	WF	H	HF	HFB	CSP ⁽¹⁾	MIID ⁽²⁾		
PICIN E06-T25-SWUBL-06	6.00	6.50	25.0	40.00	3.25	5.4	0.0	3.0	1	WBMT 060101R	SR 14-552	T-6/5
PICIN E06-T25-SWUBR-06	6.00	6.50	25.0	40.00	3.25	5.4	0.0	3.0	1	WBMT 060101L	SR 14-552	T-6/5
PICIN E06-T35-SWUBL-06	6.00	6.50	35.0	50.00	3.25	5.4	0.0	3.0	1	WBMT 060101R	SR 14-552	T-6/5
PICIN E06-T35-SWUBR-06	6.00	6.50	35.0	50.00	3.25	5.4	0.0	3.0	1	WBMT 060101L	SR 14-552	T-6/5

• Use right-hand WBMT 06...R inserts on left-hand tools and left-hand WBMT 06...L inserts on right-hand tools.
⁽¹⁾ 0 - Without coolant supply, 1 - With coolant supply
⁽²⁾ Master insert identification

FACE GROOVING LINES



PICCO-CUT



PICCO-JET

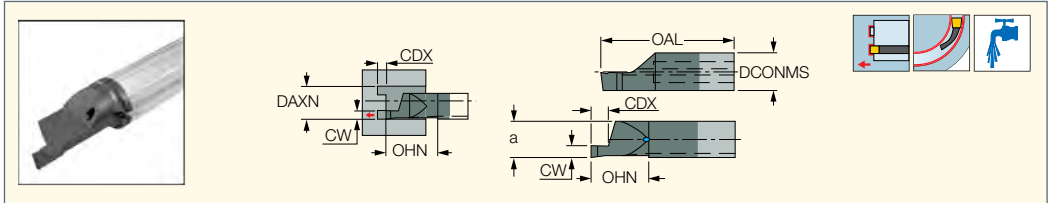


PICCO-CUT

PICCOJET
COOLANT THROUGH

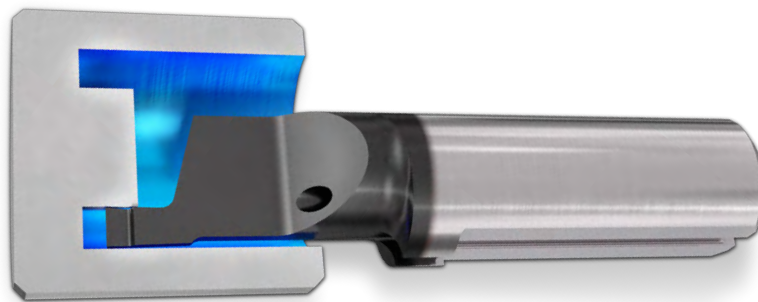
PICJ-010/610
(Face Grooving)

Inserts with Internal Coolant
Channel for Face Grooving



Designation	Dimensions							IC908	Recommended Machining Data
	DAXN ⁽¹⁾	CW	CDX	DCONMS	OHN ⁽²⁾	OAL	a		f face-groove (mm/rev)
PICJ RF10D6T1.5-10	6.0	1.00	1.50	6.00	11.0	26.00	5.20	●	0.01-0.04
PICJ RF15D6T2.0-10	6.0	1.50	2.00	6.00	11.0	26.00	5.20	●	0.01-0.04
PICJ LF15D8T2.5-20	8.0	1.50	2.50	7.00	21.0	35.00	5.90	●	0.01-0.04
PICJ R/LF20D8T3.0-30	8.0	2.00	3.00	7.00	30.0	45.00	5.90	●	0.02-0.05
PICJ RF10D8T1.5-10	8.0	1.00	1.50	6.00	11.0	26.00	5.20	●	0.01-0.04
PICJ RF10D8T1.5-20	8.0	1.00	1.50	7.00	21.0	35.00	5.90	●	0.01-0.04
PICJ RF10D8T1.5-30	8.0	1.00	1.50	7.00	30.0	45.00	5.90	●	0.01-0.04
PICJ RF15D8T2.5-10	8.0	1.50	2.50	6.00	11.0	26.00	5.20	●	0.01-0.04
PICJ RF15D8T2.5-20	8.0	1.50	2.50	6.00	20.0	35.00	5.20	●	0.01-0.04
PICJ RF15D8T2.5-30	8.0	1.50	2.50	7.00	30.0	45.00	5.90	●	0.01-0.04
PICJ RF20D8T3.0-10	8.0	2.00	3.00	7.00	11.0	26.00	5.90	●	0.02-0.05
PICJ RF20D8T3.0-20	8.0	2.00	3.00	6.00	20.0	35.00	5.20	●	0.02-0.05
PICJ RF25D8T3.5-10	8.0	2.50	3.50	7.00	11.0	26.00	5.90	●	0.02-0.05
PICJ RF25D8T3.5-20	8.0	2.50	3.50	7.00	21.0	35.00	5.90	●	0.02-0.05
PICJ RF30D8T3.5-10	8.0	3.00	3.50	7.00	11.0	26.00	5.90	●	0.02-0.06
PICJ RF30D8T3.5-20	8.0	3.00	3.50	7.00	21.0	35.00	5.90	●	0.02-0.06
PICJ RF30D8T3.5-30	8.0	3.00	3.50	7.00	30.0	45.00	5.90	●	0.02-0.06

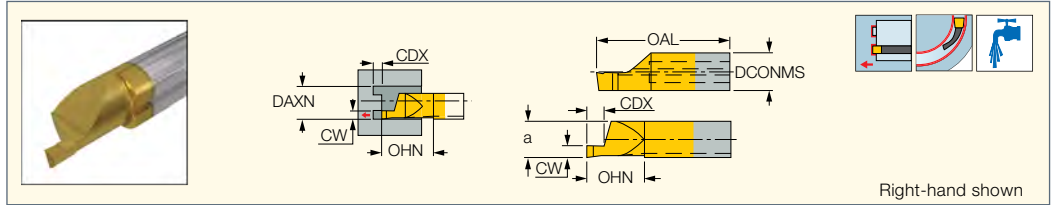
● Only right-hand inserts are available as standard ● All inserts are with sharp corners
⁽¹⁾ Minimum axial grooving diameter ⁽²⁾ Minimum overhang



PICCO CUT

PICCO-010/610 (Face Grooving)

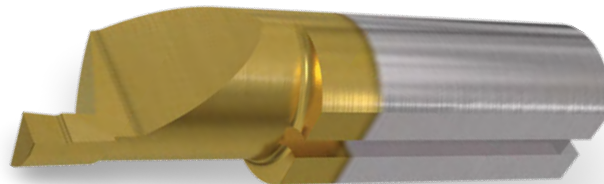
Inserts for Face Grooving



Designation	Dimensions							IC228	Recommended Machining Data f face-groove (mm/rev)
	DAXN ⁽¹⁾	CW	CDX	DCONMS	OHN ⁽²⁾	OAL	a		
PICCO R 010.1006-10	6.0	1.00	1.50	6.00	11.0	26.00	5.20	●	0.01-0.04
PICCO R 010.1506-10	6.0	1.50	2.00	6.00	11.0	26.00	5.20	●	0.01-0.04
PICCO R/L 010.1508-20	8.0	1.50	2.50	7.00	21.0	35.00	5.90	●	0.01-0.04
PICCO R/L 010.1508-30	8.0	1.50	2.50	7.00	30.0	45.00	5.90	●	0.01-0.04
PICCO R/L 010.2008-30	8.0	2.00	3.00	7.00	30.0	45.00	5.90	●	0.02-0.05
PICCO R 010.1008-10	8.0	1.00	1.50	7.00	11.0	26.00	5.90	●	0.01-0.04
PICCO R 010.1008-20	8.0	1.00	1.50	7.00	21.0	35.00	5.90	●	0.01-0.04
PICCO R 010.1008-30	8.0	1.00	1.50	7.00	30.0	45.00	5.90	●	0.01-0.04
PICCO R 010.1508-10	8.0	1.50	2.50	7.00	11.0	26.00	5.90	●	0.01-0.04
PICCO R 010.2008-10	8.0	2.00	3.00	7.00	11.0	26.00	5.90	●	0.02-0.05
PICCO R 010.2008-20	8.0	2.00	3.00	7.00	21.0	35.00	5.90	●	0.02-0.05
PICCO R 010.2508-10	8.0	2.50	3.50	7.00	11.0	26.00	5.90	●	0.02-0.05
PICCO R 010.2508-20	8.0	2.50	3.50	7.00	21.0	35.00	5.90	●	0.02-0.05
PICCO R 010.2508-30	8.0	2.50	3.50	7.00	30.0	45.00	5.90	●	0.02-0.05
PICCO R 010.3008-10	8.0	3.00	3.50	7.00	11.0	26.00	5.90	●	0.02-0.06
PICCO R 010.3008-20	8.0	3.00	3.50	7.00	21.0	35.00	5.90	●	0.02-0.06
PICCO R 010.3008-30	8.0	3.00	3.50	7.00	30.0	45.00	5.90	●	0.02-0.06
PICCO R 610.1008-10	8.0	1.00	1.50	6.00	11.0	26.00	5.20	●	0.01-0.04
PICCO R 610.1008-20	8.0	1.00	1.50	6.00	20.0	35.00	5.20	●	0.01-0.04
PICCO R 610.1508-10	8.0	1.50	2.50	6.00	11.0	26.00	5.20	●	0.01-0.04
PICCO R 610.1508-20	8.0	1.50	2.50	6.00	20.0	35.00	5.20	●	0.01-0.04
PICCO R 610.2008-10	8.0	2.00	3.00	6.00	11.0	26.00	5.20	●	0.02-0.05
PICCO R 610.2008-20	8.0	2.00	3.00	6.00	20.0	35.00	5.20	●	0.02-0.05
PICCO R 610.2508-10	8.0	2.50	3.50	6.00	11.0	26.00	5.20	●	0.02-0.05
PICCO R 610.2508-20	8.0	2.50	3.50	6.00	20.0	35.00	5.20	●	0.02-0.05
PICCO R 610.3008-10	8.0	3.00	3.50	6.00	11.0	26.00	5.20	●	0.02-0.06
PICCO R 610.3008-20	8.0	3.00	3.50	6.00	20.0	35.00	5.20	●	0.02-0.06

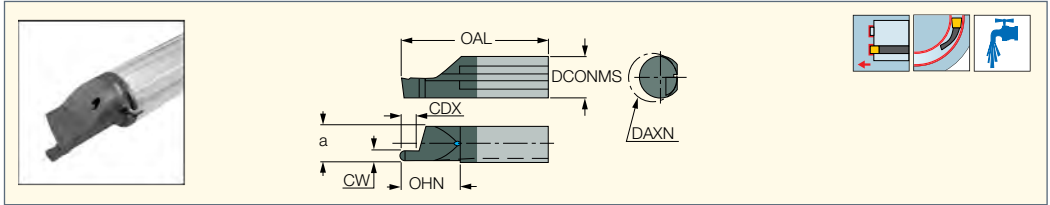
● Only right-hand inserts are available as standard ● All inserts are with sharp corners

⁽¹⁾ Minimum axial grooving diameter ⁽²⁾ Minimum overhang



PICCOJET
COOLANT THROUGH

PICJ-010
(Round Face Groove)
Inserts with Internal
Coolant Channel for Round
Profile Face Grooving

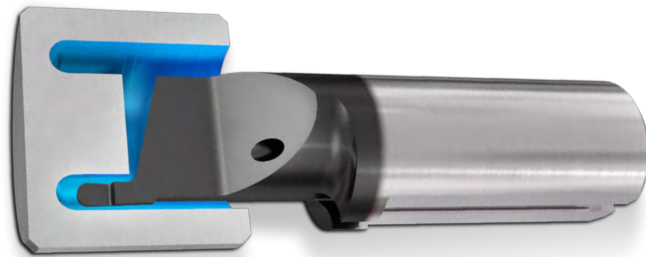


Designation	Dimensions								IC908	Recommended Machining Data
	DAXN ⁽¹⁾	CW	CDX	DCONMS	OHN ⁽²⁾	OAL	a	RE		f face-groove (mm/rev)
PICJ RF10D8T2.0-10	8.0	1.00	2.00	7.00	11.0	26.00	5.90	0.50	●	0.01-0.04
PICJ RF10D8T2.0-20	8.0	1.00	2.00	7.00	20.0	35.00	5.90	0.50	●	0.01-0.04
PICJ RFP16D8T3-10	8.0	1.60	3.00	7.00	11.0	26.00	5.90	0.80	●	0.01-0.05
PICJ RFP16D8T3-20	8.0	1.60	3.00	7.00	20.0	35.00	5.90	0.80	●	0.01-0.05
PICJ RFP20D8T4-10	8.0	2.00	4.00	7.00	11.0	26.00	5.90	1.00	●	0.02-0.05
PICJ RFP20D8T4-20	8.0	2.00	4.00	7.00	20.0	35.00	5.90	1.00	●	0.02-0.05
PICJ RFP25D8T5-10	8.0	2.50	5.00	7.00	11.0	26.00	5.90	1.25	●	0.02-0.05
PICJ RFP30D8T6-10	8.0	3.00	6.00	7.00	11.0	26.00	5.90	1.50	●	0.02-0.05
PICJ RFP30D8T6-20	8.0	3.00	6.00	7.00	20.0	35.00	5.90	1.50	●	0.02-0.05

• Only right-hand inserts are available as standard, left-hand inserts on request

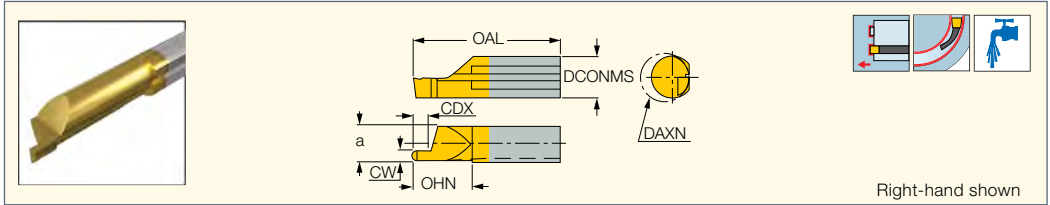
⁽¹⁾ Minimum axial grooving diameter

⁽²⁾ Minimum overhang



PICCO CUT

PICCO-010
(Round Face Groove)
 Inserts for Round Profile
 Face Grooving



Right-hand shown

Designation	Dimensions								IC1008	Recommended Machining Data f face-groove (mm/rev)
	DAXN ⁽¹⁾	CW	CDX	DCONMS	OHN ⁽²⁾	OAL	a	RE		
PICCO R 010.1005-10	8.0	1.00	2.00	7.00	11.0	26.00	5.90	0.50	●	0.01-0.04
PICCO R 010.1005-20	8.0	1.00	2.00	7.00	20.0	35.00	5.90	0.50	●	0.01-0.04
PICCO R 010.1608-10	8.0	1.60	3.00	7.00	11.0	26.00	5.90	0.80	●	0.01-0.05
PICCO R 010.1608-20	8.0	1.60	3.00	7.00	20.0	35.00	5.90	0.80	●	0.01-0.05
PICCO R 010.2010-10	8.0	2.00	4.00	7.00	11.0	26.00	5.90	1.00	●	0.02-0.05
PICCO R 010.2010-20	8.0	2.00	4.00	7.00	20.0	35.00	5.90	1.00	●	0.02-0.05
PICCO R 010.2512-10	8.0	2.50	5.00	7.00	11.0	26.00	5.90	1.25	●	0.02-0.05
PICCO R 010.2512-20	8.0	2.50	5.00	7.00	20.0	35.00	5.90	1.25	●	0.02-0.05
PICCO R 010.3015-10	8.0	3.00	6.00	7.00	11.0	26.00	5.90	1.50	●	0.02-0.05
PICCO R 010.3015-20	8.0	3.00	6.00	7.00	20.0	35.00	5.90	1.50	●	0.02-0.05

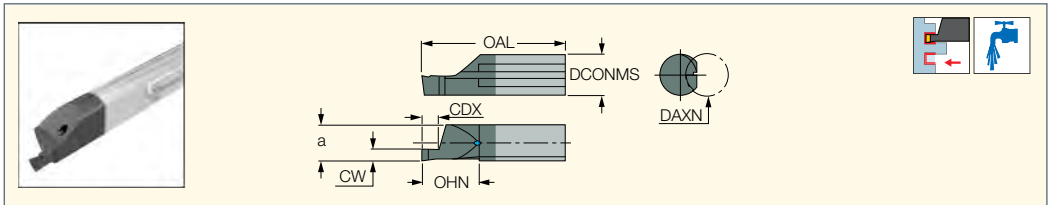
• Only right-hand inserts are available as standard, left-hand inserts on request

⁽¹⁾ Minimum axial grooving diameter

⁽²⁾ Minimum overhang

PICCOJET

PICJ-620
(Groove Along Shaft)
 Inserts with Internal Coolant
 Channel for Grooving Along
 Shaft Dmin 6 mm

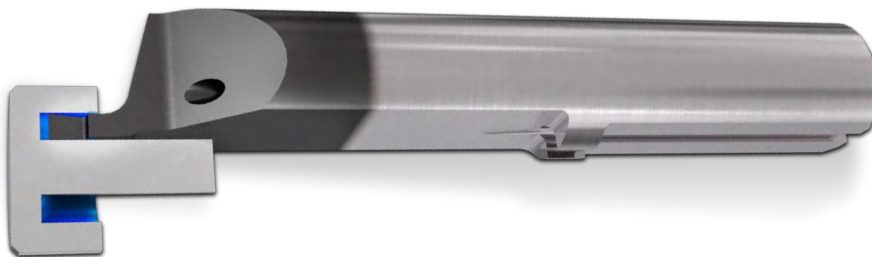


Designation	Dimensions								IC908	Recommended Machining Data f face-groove (mm/rev)
	DAXN ⁽¹⁾	CW	CDX	DCONMS	OHN ⁽²⁾	OAL	a	RE		
PICJ RF10D6T2.0-20	6.0	1.00	2.00	6.00	20.0	35.00	5.20	●	0.01-0.04	
PICJ RF15D6T3.0-20	6.0	1.50	3.00	6.00	20.0	35.00	5.20	●	0.01-0.05	
PICJ RF20D6T4.0-20	6.0	2.00	4.00	6.00	20.0	35.00	5.20	●	0.02-0.06	
PICJ RF25D6T5.0-20	6.0	2.50	5.00	6.00	20.0	35.00	5.20	●	0.02-0.06	
PICJ RF30D6T6.0-20	6.0	3.00	6.00	6.00	20.0	35.00	5.20	●	0.02-0.06	

• Only right-hand inserts are available as standard, left-hand inserts on request • All carbide inserts are with sharp corners

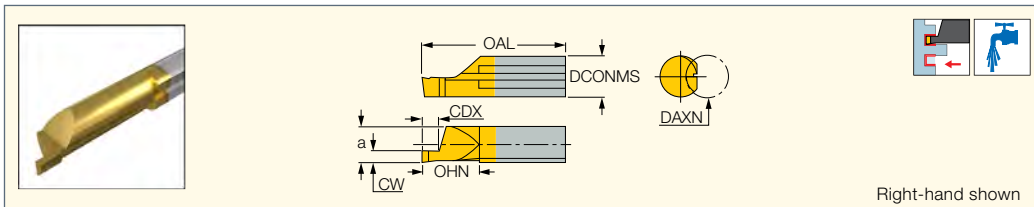
⁽¹⁾ Minimum axial grooving diameter

⁽²⁾ Minimum overhang



PICCO CUT

PICCO-620
(Groove Along Shaft)
 Inserts for Grooving Along
 a Shaft Dmin 6 mm



Right-hand shown

Designation	Dimensions							IC1008	Recommended Machining Data
	DAXN ⁽¹⁾	CW	CDX	DCONMS	OHN ⁽²⁾	OAL	a		f face-groove (mm/rev)
PICCO R 620.1006-20	6.0	1.00	2.00	6.00	20.0	35.00	5.20	●	0.01-0.04
PICCO R 620.1506-20	6.0	1.50	3.00	6.00	20.0	35.00	5.20	●	0.01-0.05
PICCO R 620.2006-20	6.0	2.00	4.00	6.00	20.0	35.00	5.20	●	0.02-0.06
PICCO R 620.2506-20	6.0	2.50	5.00	6.00	20.0	35.00	5.20	●	0.02-0.06
PICCO R 620.3006-20	6.0	3.00	6.00	6.00	20.0	35.00	5.20	●	0.02-0.06

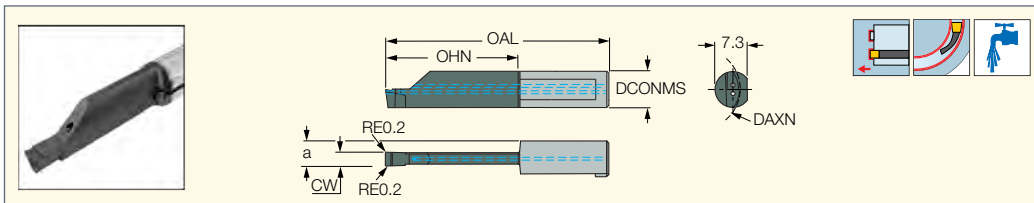
• Only right-hand inserts are available as standard, left-hand inserts on request • All carbide inserts are with sharp corners

⁽¹⁾ Minimum axial grooving diameter

⁽²⁾ Minimum overhang

PICCOJET

PICJ-016/020
(Face Grooving)
 Inserts with Internal Coolant
 Channel for Deep Face Grooving

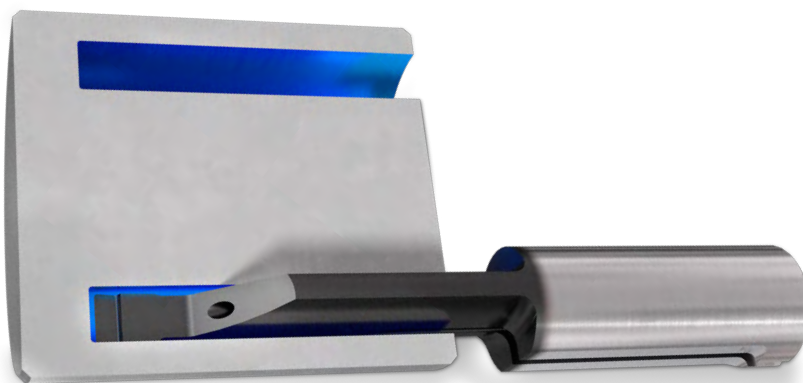


Designation	Dimensions							IC908	Recommended Machining Data
	DAXN ⁽¹⁾	CW	DCONMS	OHN ⁽²⁾	OAL	a	f face-groove (mm/rev)		
PICJ RF30D16T10-10	16.0	3.00	8.00	10.0	30.00	5.50	●	0.01-0.05	
PICJ RF30D16T20-20	16.0	3.00	8.00	20.0	40.00	5.50	●	0.01-0.05	
PICJ RF40D16T20-20	16.0	4.00	8.00	20.0	40.00	6.00	●	0.01-0.05	
PICJ RF30D20T25-25	20.0	3.00	8.00	25.0	45.00	5.50	●	0.01-0.05	
PICJ RF30D20T30-30	20.0	3.00	8.00	30.0	50.00	5.50	●	0.01-0.04	
PICJ RF30D20T40-40	20.0	3.00	8.00	40.0	60.00	5.50	●	0.01-0.04	
PICJ RF40D20T25-25	20.0	4.00	8.00	25.0	45.00	6.00	●	0.01-0.06	
PICJ RF40D20T30-30	20.0	4.00	8.00	30.0	50.00	6.00	●	0.01-0.06	
PICJ RF40D20T40-40	20.0	4.00	8.00	40.0	60.00	6.00	●	0.01-0.05	
PICJ RF50D20T25-25	20.0	5.00	8.00	25.0	45.00	6.50	●	0.02-0.06	
PICJ RF50D20T30-30	20.0	5.00	8.00	30.0	50.00	6.50	●	0.02-0.06	
PICJ RF50D20T35-35	20.0	5.00	8.00	35.0	55.00	6.50	●	0.02-0.05	
PICJ RF50D20T40-40	20.0	5.00	8.00	40.0	60.00	6.50	●	0.02-0.05	

• All inserts have two coolant holes which may be used with coolant pressure up to 100 bars

⁽¹⁾ Minimum axial grooving diameter

⁽²⁾ Minimum overhang

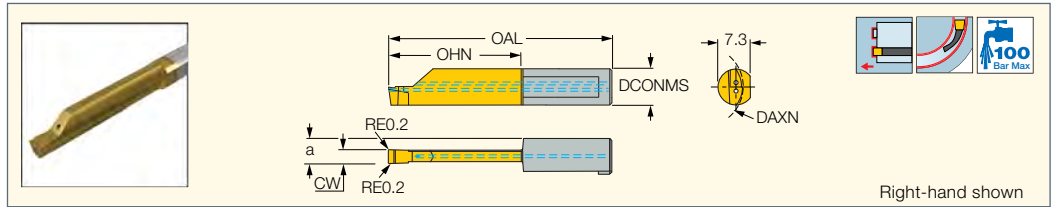


PICCO CUT

PICCO-016/020

(Face Grooving)

Inserts with Coolant Channel for Deep Face Grooving



Right-hand shown

Designation	Dimensions						IC1008	Recommended Machining Data f face-groove (mm/rev)
	DAXN ⁽¹⁾	CW	DCONMS	OHN ⁽²⁾	OAL	a		
PICCO R 016.0300-10	16.0	3.00	8.00	10.0	30.00	5.50	●	0.01-0.05
PICCO R 016.0300-20	16.0	3.00	8.00	20.0	40.00	5.50	●	0.01-0.05
PICCO R 016.0400-10	16.0	4.00	8.00	10.0	30.00	6.00	●	0.01-0.05
PICCO R 016.0400-20	16.0	4.00	8.00	20.0	40.00	6.00	●	0.01-0.05
PICCO R 020.0300-25	20.0	3.00	8.00	25.0	45.00	5.50	●	0.01-0.05
PICCO R 020.0300-30	20.0	3.00	8.00	30.0	50.00	5.50	●	0.01-0.04
PICCO R 020.0300-35	20.0	3.00	8.00	35.0	55.00	5.50	●	0.01-0.04
PICCO R 020.0300-40	20.0	3.00	8.00	40.0	60.00	5.50	●	0.01-0.04
PICCO R 020.0400-25	20.0	4.00	8.00	25.0	45.00	6.00	●	0.01-0.06
PICCO R 020.0400-30	20.0	4.00	8.00	30.0	50.00	6.00	●	0.01-0.06
PICCO R 020.0400-35	20.0	4.00	8.00	35.0	55.00	6.00	●	0.01-0.05
PICCO R 020.0400-40	20.0	4.00	8.00	40.0	60.00	6.00	●	0.01-0.05
PICCO R 020.0500-20	20.0	5.00	8.00	20.0	40.00	6.50	●	0.02-0.06
PICCO R 020.0500-25	20.0	5.00	8.00	25.0	45.00	6.50	●	0.02-0.06
PICCO R 020.0500-30	20.0	5.00	8.00	30.0	50.00	6.50	●	0.02-0.06
PICCO R 020.0500-35	20.0	5.00	8.00	35.0	55.00	6.50	●	0.02-0.05
PICCO R 020.0500-40	20.0	5.00	8.00	40.0	60.00	6.50	●	0.02-0.05

• All inserts have two coolant holes which may be used with coolant pressure up to 100 bars

⁽¹⁾ Minimum axial grooving diameter

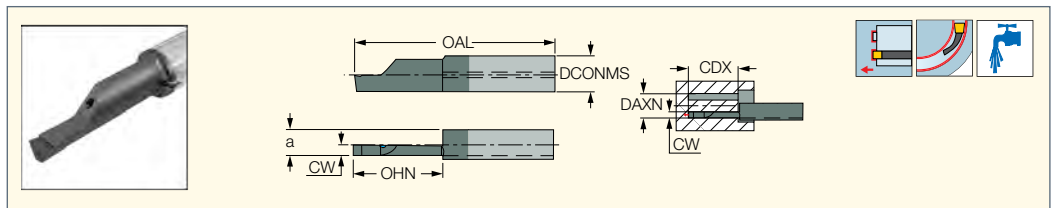
⁽²⁾ Minimum overhang

PICCOJET

COOLANT THROUGH

PICJ-015 (Face Grooving)

Inserts with Internal Coolant Channel for Deep Face Grooving

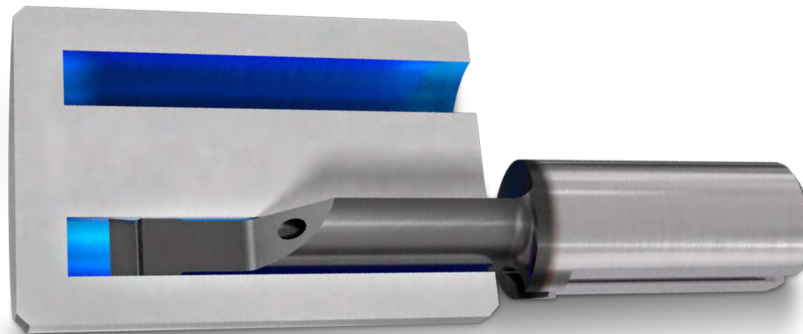


Designation	Dimensions							IC908	Recommended Machining Data f face-groove (mm/rev)
	DAXN ⁽¹⁾	CW	CDX	DCONMS	OHN ⁽²⁾	OAL	a		
PICJ RF25D8T20-20	8.0	2.50	20.00	7.00	20.0	35.00	5.90	●	0.01-0.04
PICJ RF30D8T20-20	8.0	3.00	20.00	7.00	20.0	35.00	5.90	●	0.02-0.05
PICJ RF30D8T30-30	8.0	3.00	30.00	7.00	30.0	45.00	5.90	●	0.01-0.04

• Only right-hand inserts are available as standard, left-hand inserts on request • All inserts are with sharp corners

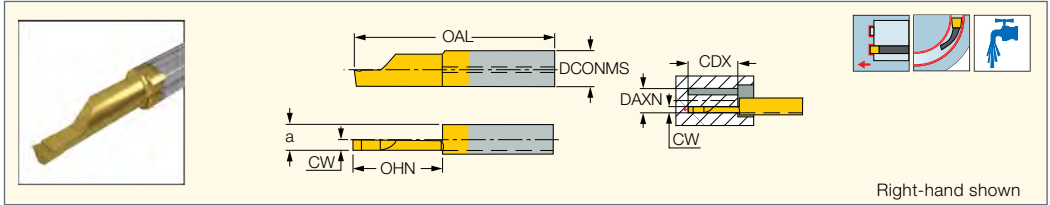
⁽¹⁾ Minimum axial grooving diameter

⁽²⁾ Minimum overhang



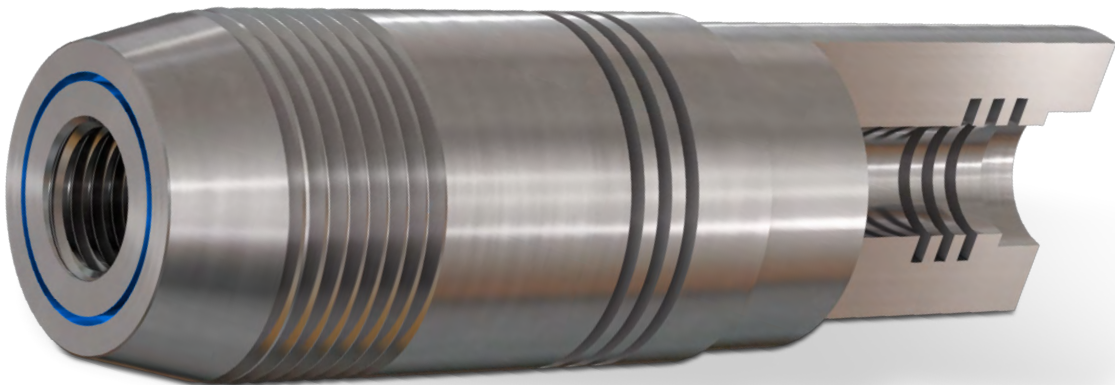
PICCO CUT

PICCO-015 (Face Grooving)
Inserts for Deep Face Grooving



Designation	Dimensions							IC228	Recommended Machining Data
	DAXN ⁽¹⁾	CW	CDX	DCONMS	OHN ⁽²⁾	OAL	a		f face-groove (mm/rev)
PICCO R/L 015.3015-20	8.0	3.00	20.00	7.00	20.0	35.00	5.90	●	0.02-0.05
PICCO R 015.2515-20	8.0	2.50	20.00	7.00	20.0	35.00	5.90	●	0.01-0.04
PICCO R 015.3015-30	8.0	3.00	30.00	7.00	30.0	45.00	5.90	●	0.01-0.04

- Only right-hand inserts are available as standard, left-hand inserts on request
 - All inserts are with sharp corners
- ⁽¹⁾ Minimum axial grooving diameter
⁽²⁾ Minimum overhang



THREADING LINES



PICCO-CUT



PICCO-JET

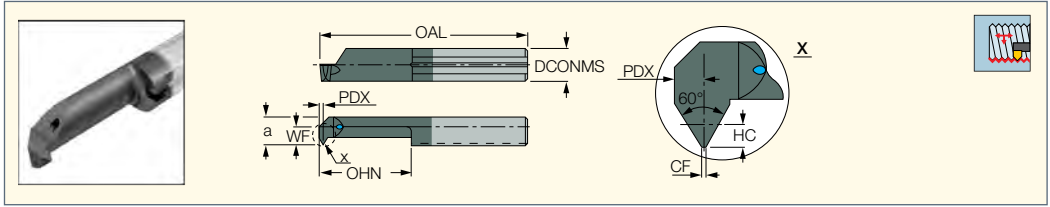


PICCO-INDEX

PICCOJET
COOLANT THROUGH

PICJ R/L-60°
(60° Threading)

Inserts with a 60° Internal Thread Profile and Inner Coolant Channel for 2.4mm Min. Bore Diameter

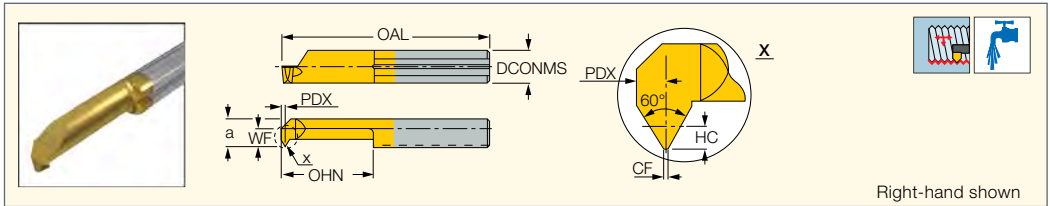


Designation	Dimensions													IC908
	DCONMS	HC	CF	PDX	WF	a	OHN ⁽¹⁾	OAL	DMIN	TPN ⁽²⁾	TPX ⁽³⁾	TPIN ⁽⁴⁾	TPIX ⁽⁵⁾	
PICJ RTH710.50D024	4.00	0.27	0.04	0.3	0.30	2.30	8.0	22.00	2.40	0.500	0.700	36.00	48.00	●
PICJ RTH910.50D032	4.00	0.27	0.09	0.4	1.00	3.00	10.0	24.00	3.20	0.500	0.750	36.00	48.00	●
PICJ RTH1410.50D040	4.00	0.27	0.06	0.4	1.50	3.50	15.0	30.00	4.00	0.500	0.750	36.00	48.00	●
PICJ RTH1410.50D050	5.00	0.27	0.06	0.4	1.90	4.40	15.0	30.00	5.00	0.500	0.750	36.00	48.00	●
PICJ RTH1410.75D050	5.00	0.40	0.09	0.5	1.90	4.40	15.0	30.00	5.00	0.750	1.000	24.00	36.00	●
PICJ R/LTH1411.00D048	5.00	0.55	0.12	0.6	1.90	4.40	15.0	30.00	4.80	1.000	1.250	20.00	24.00	●
PICJ RTH1911.00D048	5.00	0.55	0.12	0.6	1.90	4.40	20.0	35.00	4.80	1.000	1.250	20.00	24.00	●
PICJ RTH1411.00D060	6.00	0.55	0.12	0.6	2.30	5.30	15.0	30.00	6.00	1.000	1.250	20.00	24.00	●
PICJ RTH2111.00D060	6.00	0.55	0.12	0.6	2.30	5.30	22.0	37.00	6.00	1.000	1.250	20.00	24.00	●
PICJ RTH1411.25D060	6.00	0.68	0.15	0.7	2.30	5.30	15.0	30.00	6.00	1.250	1.500	16.00	20.00	●
PICJ RTH1411.50D060	6.00	0.81	0.18	0.8	2.30	5.30	15.0	30.00	6.00	1.500	1.750	14.00	16.00	●
PICJ R/LTH1411.5D070	7.00	0.81	0.18	0.8	2.70	6.30	15.0	30.00	7.00	1.500	1.750	14.00	16.00	●

- Solid tools are suitable for PICCO-N / PICCO ACE-N type holders only • DIN13 , ISO 68-1, ISO 965 (1&2) - Internal tolerance: 6H
- ANSI/ASME B1.1 - Internal tolerance: 2B
- (1) Minimum overhang
- (2) Thread pitch minimum (mm)
- (3) Thread pitch maximum (mm)
- (4) Threads per inch minimum
- (5) Threads per inch maximum

PICCO CUT

PICCO R/L-60°-Thread
Inserts with a 60° Internal Thread Profile for 2.4 mm Min. Bore Diameter

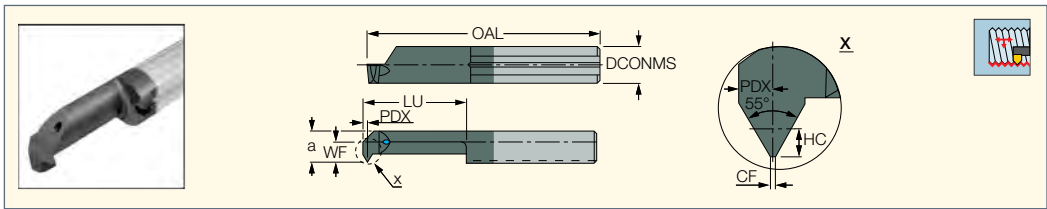


Designation	Dimensions													Tough ↔ Hard	
	DCONMS	DMIN	HC	CF	PDX	WF	a	OHN ⁽¹⁾	OAL	TPN ⁽²⁾	TPX ⁽³⁾	TPIN ⁽⁴⁾	TPIX ⁽⁵⁾	IC228	IC908
PICCO R 003.0105-8	4.00	2.40	0.27	0.04	0.30	0.30	2.30	8.0	22.00	0.500	0.700	36.00	48.00		●
PICCO R 004.0105-10	4.00	3.20	0.27	0.09	0.40	1.00	3.00	10.0	24.00	0.500	0.750	36.00	48.00		●
PICCO R/L 004.0205-15	4.00	4.00	0.27	0.06	0.40	1.50	3.50	15.0	30.00	0.500	0.750	36.00	48.00	●	
PICCO R/L 005.0205-15	5.00	5.00	0.27	0.06	0.40	1.90	4.40	15.0	30.00	0.500	0.750	36.00	48.00	●	
PICCO L 005.0407-15	5.00	5.00	0.40	0.09	0.50	1.90	4.40	15.0	30.00	0.750	1.000	24.00	36.00	●	
PICCO R 005.0407-15	5.00	5.00	0.40	0.09	0.50	1.90	4.40	15.0	30.00	0.750	1.000	24.00	36.00	●	●
PICCO R 005.0407-20	5.00	5.00	0.40	0.09	0.50	1.90	4.40	20.0	35.00	0.750	1.000	24.00	36.00		●
PICCO R/L 005.0510-15	5.00	4.80	0.55	0.12	0.60	1.90	4.40	15.0	30.00	1.000	1.250	20.00	24.00	●	
PICCO R 005.0510-20	5.00	4.80	0.55	0.12	0.60	1.90	4.40	20.0	35.00	1.000	1.250	20.00	24.00		●
PICCO R/L 006.0510-15	6.00	6.00	0.55	0.12	0.60	2.30	5.30	15.0	30.00	1.000	1.250	20.00	24.00	●	
PICCO R 006.0510-22	6.00	6.00	0.55	0.12	0.60	2.30	5.30	22.0	37.00	1.000	1.250	20.00	24.00		●
PICCO R/L 006.0612-15	6.00	6.00	0.68	0.15	0.70	2.30	5.30	15.0	30.00	1.250	1.500	16.00	20.00	●	
PICCO R 006.0612-22	6.00	6.00	0.68	0.15	0.70	2.30	5.30	22.0	37.00	1.250	1.500	16.00	20.00		●
PICCO R/L 006.0815-15	6.00	6.00	0.81	0.18	0.80	2.30	5.30	15.0	30.00	1.500	1.750	14.00	16.00	●	
PICCO R 006.0815-22	6.00	6.00	0.81	0.18	0.80	2.30	5.30	22.0	37.00	1.500	1.750	14.00	16.00		●
PICCO R/L 007.0815-15	7.00	7.00	0.81	0.18	0.80	2.70	6.30	15.0	30.00	1.500	1.750	14.00	16.00	●	

- DIN13 , ISO 68-1, ISO 965 (1&2) - Internal tolerance: 6H • ANSI/ASME B1.1 - Internal tolerance: 2B
- (1) Minimum overhang (2) Thread pitch minimum (mm) (3) Thread pitch maximum (mm) (4) Threads per inch minimum (5) Threads per inch maximum

PICCOJET
COOLANT THROUGH

PICJ-55° (55° Threading)
Inserts with Inner Coolant
Channel for 55° Internal
Threading Profile

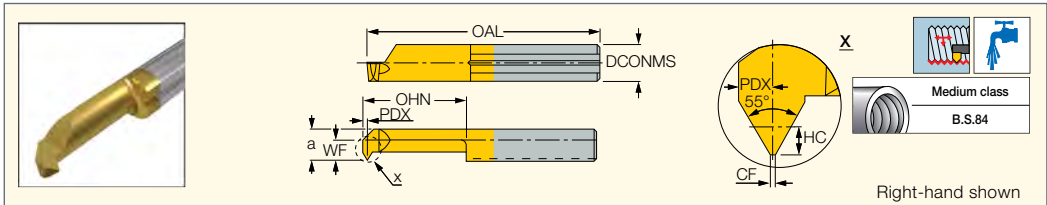


Designation	Dimensions											IC908
	DCONMS	HC	CF	PDX	WF	a	LU	OAL	DMIN	TPIX ⁽¹⁾	TPIN ⁽²⁾	
PICJ RTH14W24D060	6.00	0.81	0.12	0.80	2.30	5.30	15.0	30.00	6.00	24.00	16.00	●
PICJ RTH14W24D070	7.00	0.81	0.12	0.80	2.80	6.30	15.0	30.00	7.00	24.00	16.00	●

- All mini-bars have sharp corners • Solid tools are suitable for PICCO-N / PICCO ACE-N type holders only
- ⁽¹⁾ Threads per inch maximum
- ⁽²⁾ Threads per inch minimum

PICCO-CUT

PICCO-55°-Thread
Inserts for 55° Internal
Thread Profile

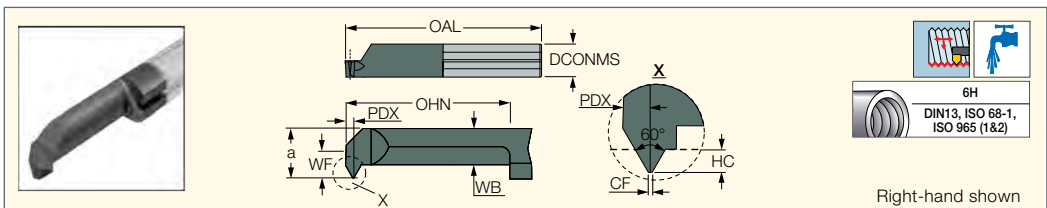


Designation	Dimensions											IC228
	DCONMS	DMIN	HC	CF	PDX	WF	a	OHN ⁽¹⁾	OAL	TPIN ⁽²⁾	TPIX ⁽³⁾	
PICCO R 005.5548-15	5.00	4.80	0.40	0.06	0.50	1.90	4.40	15.0	30.00	24.00	48.00	●
PICCO R 006.5548-15	6.00	6.00	0.40	0.06	0.50	2.30	5.30	15.0	30.00	24.00	48.00	●
PICCO R 006.5524-15	6.00	6.00	0.81	0.12	0.80	2.30	5.30	15.0	30.00	16.00	24.00	●
PICCO R 007.5524-15	7.00	7.00	0.81	0.12	0.80	2.80	6.30	15.0	30.00	16.00	24.00	●

- All mini-bars have sharp corners
- ⁽¹⁾ Minimum overhang ⁽²⁾ Threads per inch minimum ⁽³⁾ Threads per inch maximum

PICCO-CUT

PICCO ISO Full Profile
ISO Standard Inserts for
Full Profile Threads

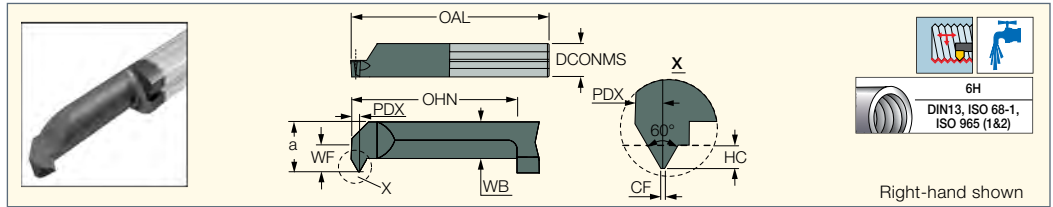


Designation	Dimensions											IC908
	DCONMS	DMIN	HC	CF	PDX	WF	a	WB	OHN ⁽¹⁾	OAL	TP ⁽²⁾	
PICCO R/L 105.0510-15	5.00	4.80	0.54	0.12	0.60	1.90	4.40	3.30	15.0	30.00	1.000	●
PICCO R/L 106.0612-15	6.00	6.00	0.67	0.15	0.70	2.30	5.30	3.40	15.0	30.00	1.250	●
PICCO R/L 106.0815-15	6.00	6.00	0.81	0.18	0.80	2.30	5.30	3.40	15.0	30.00	1.500	●
PICCO R/L 107.0815-15	7.00	7.00	0.81	0.18	0.80	2.80	6.30	3.80	15.0	30.00	1.500	●

- ⁽¹⁾ Minimum overhang
- ⁽²⁾ Thread pitch

PICCOCUT

PICCO ISO Full Profile Fine
ISO Fine Pitch Inserts for
Full Profile Threads



Right-hand shown

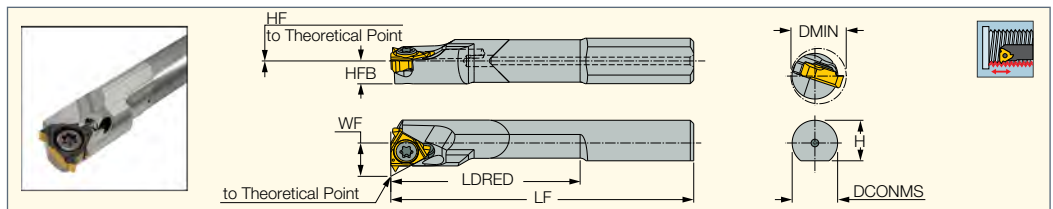
Designation	Dimensions											IC908
	DCONMS	DMIN	HC	CF	PDX	WF	a	OHN ⁽¹⁾	WB	OAL	TP ⁽²⁾	
PICCO R/L 104.0205-15	5.00	4.00	0.27	0.06	0.40	1.50	3.50	15.0	2.40	30.00	0.500	●
PICCO R/L 105.0205-15	5.00	5.00	0.27	0.06	0.40	1.90	4.40	15.0	3.30	30.00	0.500	●
PICCO R/L 105.0407-15	5.00	5.00	0.40	0.09	0.50	1.90	4.40	15.0	3.30	30.00	0.750	●
PICCO R/L 106.0510-15	6.00	6.00	0.54	0.12	0.60	2.30	5.30	15.0	3.40	30.00	1.000	●

⁽¹⁾ Minimum overhang

⁽²⁾ Thread pitch

PICCOINDEX

PICIN-MGSIR/L
Solid Carbide PICCO Tools
on which Internal Laydown
Threading Inserts are Mounted



Designation	DCONMS	DMIN	LDRED	H	HFB	WF	HF	LF	CSP ⁽¹⁾	MIID ⁽²⁾		
PICIN E06-T25-MGSIL-06	6.00	7.30	25.0	5.4	3.0	4.41	0.0	40.00	1	06IL A 55	SR 14-552	T-6/5
PICIN E06-T25-MGSIR-06	6.00	7.30	25.0	5.4	3.0	4.41	0.0	40.00	1	06IR A 55	SR 14-552	T-6/5

• B-steel shank with coolant hole, CB-carbide shank with coolant hole

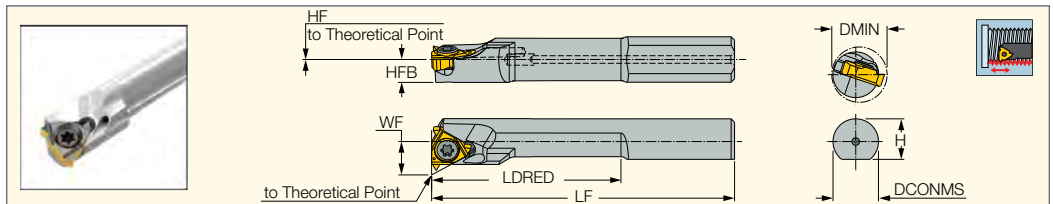
• All toolholders provide 1.5 helix angle, either via the pocket or the anvil supplied • For GTGA inserts, use anvil AL 16-0

⁽¹⁾ 0 - Without coolant supply, 1 - With coolant supply

⁽²⁾ Master insert identification

PICCOINDEX

PICIN-A-SIR/L
PICCO Tools on which
Internal Laydown Threading
Inserts are mounted



Designation	DCONMS	DMIN	LDRED	H	HFB	WF	LF	HF	CSP ⁽¹⁾	MIID ⁽²⁾		
PICIN A06-T15-SIR-06	6.00	7.30	15.0	5.4	3.0	4.41	30.00	0.1	1	06IL A 55	SR 14-552	T-6/5
PICIN A06-T25-SIR/L-06	6.00	7.30	25.0	5.4	3.0	4.41	40.00	0.1	1	06IL/R A 55	SR 14-552	T-6/5

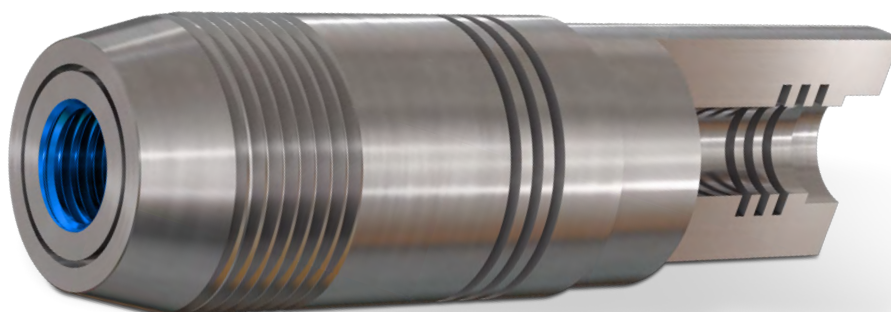
• B-steel shank with coolant hole, CB-carbide shank with coolant hole

• All toolholders provide 1.5 helix angle, either via the pocket or the anvil supplied

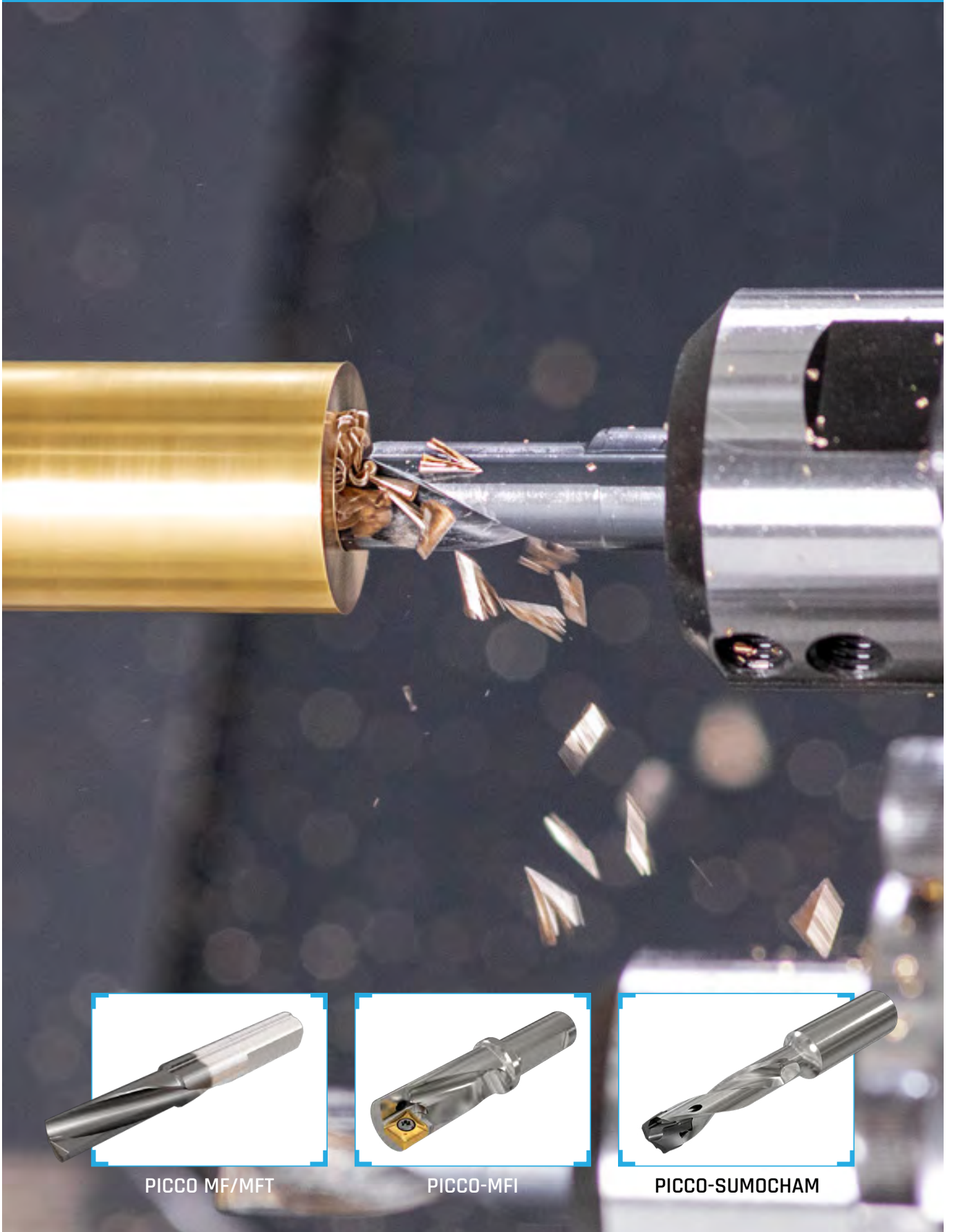
• For GTGA inserts, use anvil AL 16-0

⁽¹⁾ 0 - Without coolant supply, 1 - With coolant supply

⁽²⁾ Master insert identification



DRILLING LINES



PICCO MF/MFT



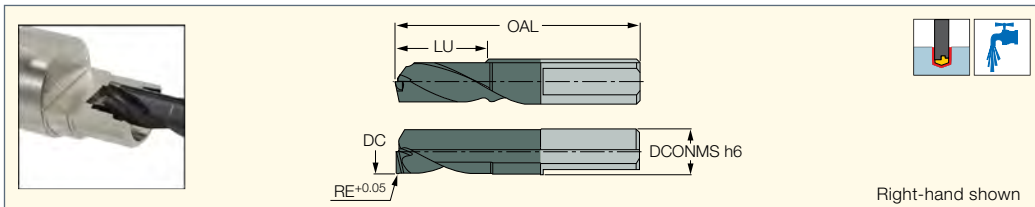
PICCO-MFI



PICCO-SUMOCHAM

PICCOMF

PICCO-MF
Multifunction Solid Carbide
Tools for Drilling, Facing, Internal
and External Turning on Swiss
and Small CNC Machines



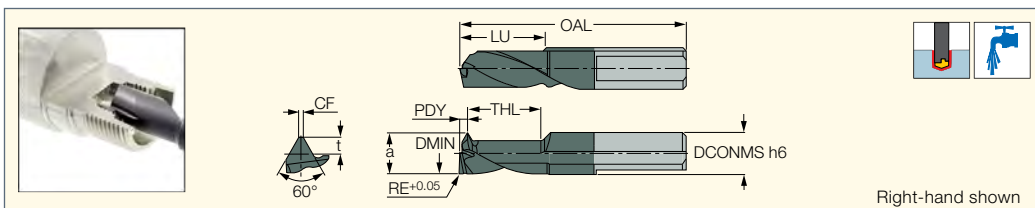
Right-hand shown

Designation	Dimensions						IC908
	DCONMS	DC	LU	OAL	RE		
PICCO R-MF 6-3 L06	6.00	3.00	6.00	28.00	0.10	●	
PICCO R/L-MF 6-4 L08	6.00	4.00	8.00	30.00	0.10	●	
PICCO R/L-MF 6-4 L12	6.00	4.00	12.00	34.00	0.20	●	
PICCO R/L-MF 6-5 L10	6.00	5.00	10.00	32.00	0.10	●	
PICCO R/L-MF 6-5 L15	6.00	5.00	15.00	41.00	0.30	●	
PICCO R/L-MF 6-6 L12	6.00	6.00	12.00	34.00	0.10	●	
PICCO R/L-MF 6-6 L18	6.00	6.00	18.00	43.00	0.30	●	
PICCO R/L-MF 8-7 L14	8.00	7.00	14.00	41.00	0.10	●	
PICCO R/L-MF 8-7 L21	8.00	7.00	21.00	55.00	0.30	●	
PICCO R/L-MF 8-8 L16	8.00	8.00	16.00	43.00	0.10	●	
PICCO R/L-MF 8-8 L24	8.00	8.00	24.00	58.50	0.30	●	

- Dmin can be 0.1 mm smaller by shifting tool center
- Applications: drilling; face turning; internal chamfering; internal turning/ boring; internal profiling; external chamfering; external turning

PICCOMFT

PICCO-MFT
Solid Carbide Tools for Drilling,
Facing, Internal and External
Turning and Threading on Swiss
and Small CNC Machines



Right-hand shown

Designation	Dimensions														IC908
	DCONMS	DMIN	LU	TPN ⁽²⁾	TPX ⁽³⁾	TPIN ⁽⁴⁾	TPIX ⁽⁵⁾	t	a	CF	THL	OAL	PDY	RE	
PICCO R-MFT60 6-4 L08	6.00	4.00	8.00	0.500	0.750	32.00	48.00	0.46	3.90	0.06	7.3	30.00	1.30	0.10	●
PICCO R-MFT60 6-4 L12	6.00	4.00	12.00	0.500	0.750	32.00	48.00	0.46	3.90	0.06	11.6	34.00	1.20	0.20	●
PICCO R/L-MFT60 6-5 L10	6.00	5.00	10.00	0.500	1.000	24.00	48.00	0.61	4.90	0.06	9.0	32.00	1.40	0.10	●
PICCO R/L-MFT60 6-5 L15 ⁽¹⁾	6.00	5.00	15.00	0.500	1.000	24.00	48.00	0.61	4.90	0.06	14.4	37.00	1.40	0.30	●
PICCO R/L-MFT60 6-6 L18 ⁽¹⁾	6.00	6.00	18.00	0.500	1.000	24.00	48.00	0.61	5.90	0.06	17.3	43.00	1.40	0.30	●
PICCO R-MFT60 6-6 L12	6.00	6.00	12.00	0.500	1.000	24.00	48.00	0.61	5.90	0.06	11.0	34.00	1.40	0.10	●
PICCO R/L-MFT60 8-7 L14	8.00	7.00	14.00	0.750	1.250	20.00	32.00	0.76	6.90	0.09	13.0	41.00	1.50	0.10	●
PICCO R-MFT60 8-7 L21	8.00	7.00	21.00	0.750	1.250	20.00	32.00	0.76	6.90	0.09	20.0	55.00	1.50	0.30	●
PICCO R/L-MFT60 8-8 L16	8.00	8.00	16.00	0.900	1.500	16.00	28.00	0.92	7.90	0.11	15.0	43.00	1.50	0.10	●
PICCO L-MFT60 8-8 L24 ⁽¹⁾	8.00	8.00	24.00	0.900	1.500	16.00	28.00	0.92	7.90	0.11	23.0	57.00	1.50	0.30	●
PICCO R-MFT60 8-8 L24	8.00	8.00	24.00	0.900	1.500	16.00	28.00	0.92	7.90	0.11	23.0	51.00	1.50	0.30	●

- Applications: Drilling; face turning; internal chamfering; internal turning/boring; internal profiling; external chamfering; external turning; internal and external 60° threading (right- and left-hand)

- DIN13 , ISO 68-1, ISO 965 (1&2) - Internal tolerance: 6H, External tolerance: 6g
- ANSI/ASME B1.1 - Internal tolerance: 2B, External tolerance: 2A

- ⁽¹⁾ Available on request
- ⁽²⁾ Thread pitch minimum (mm)
- ⁽³⁾ Thread pitch maximum (mm)
- ⁽⁴⁾ Threads per inch minimum
- ⁽⁵⁾ Threads per inch maximum

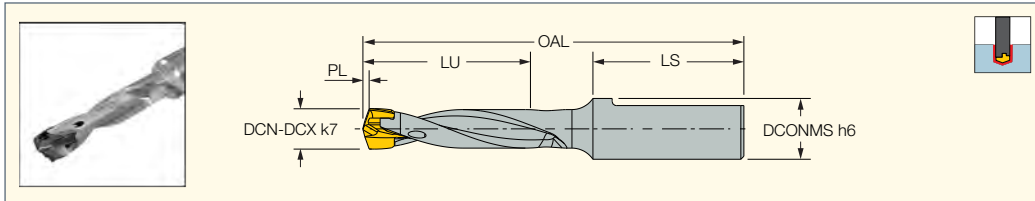
Recommended hole diameter for pre-thread hole

Solid carbide drills		SUMOCHAM exchangeable Drilling heads	Pre-hole size (mm)	ISO		UN		
SCD 030-014-060 PICCO 3D			3		M3.5x0.5			
SCD 035-014-060 PICCO 3D			3.5		M4x0.5		8-36UNF	
SCD 040-017-060 PICCO 3D	ICP/FCP/QCP/HCP	ICP/FCP/HCP	4		M4.5x0.5		10-32UNF	
			4.1		M4.5x0.35			
		ICP/FCP/HCP/QCP	4.2	M5x0.8	M4.5x0.2			
					M4.5x0.25			
					M5x0.75		12-24UNC	
					M5x0.5			
SCD 045-017-060 PICCO 3D	ICP/FCP/QCP/HCP	ICP/FCP/HCP	4.3		M5x0.75			
			4.4		M5x0.5			
		ICP/FCP/HCP/QCP	4.5		M5x0.5			
			4.6		M5x0.35		12-28 UNF	
		ICP/FCP/HCP	4.7		M5x0.35			
					M5x0.2			
					M5x0.25			
					M5.5x0.75			
SCD 050-020-060 PICCO 3D	ICK/ICM/ICP/FCP/HCP/QCP	ICM/ICP/CM/QCP/HCP/FCP	5	M6x1.0	M5.5x0.5			
			5.1			M5.5x0.35		1/4-20UNC
		ICM/ICP/FCP/HCP	5.2		M5.5x0.2			
					M5.5x0.25			
					M5.5x0.35			
					M6x0.75			
		ICM/ICP/FCP/HCP	5.3		M5.5x0.2			
			5.4				1/4-28UNF	
SCD 055-020-060 PICCO 3D	ICK/ICM/ICP/FCP/HCP/QCP	ICM/ICP/FCP/HCP	5.5		M6x0.5			
			5.7		M6x0.35			
SCD 060-020-060 PICCO 3D	ICK/ICM/ICP/FCP/HCP/QCP		6	M7x1.0				
			6.2			M7x0.75		
			6.3					
			6.4					
SCD 065-024-080 PICCO 3D	ICK/ICM/ICP/FCP/HCP/QCP		6.5	M8x1.25			5/16-18UNC	
			6.8					
			6.9				5/16-24 UNF	
SCD 070-024-080 PICCO 3D	ICK/ICM/ICP/FCP/HCP/QCP		7		M8x1			
			7.2			M8x0.75		
SCD 075-029-080 PICCO 3D	ICK/ICM/ICP/FCP/HCP/QCP		7.5	M9x1.25	M8x0.5			
			7.8					3/8-16 UNC
			7.9					
SCD 080-029-080 PICCO 3D	ICK/ICM/ICP/FCP/HCP/QCP		8	M10x1.5	M9x1			
			8.4					3/8-24 UNF
			8.5					
			8.8			M10x1.25		
			9			M10x1		
			9.2			M10x0.75		7/16-14 UNC
			9.3					
		M11x1.5		7/16-20 UNF				
	IHP/ICN/ICK/ICM/ICP/FCP/HCP/QCP		10		M11x1			

PICCO SUMOCHAM

DCN-PICCO

Drill Body with Exchangeable Heads, Internal Coolant Holes and PICCO Connection, Drilling Depth 3xD



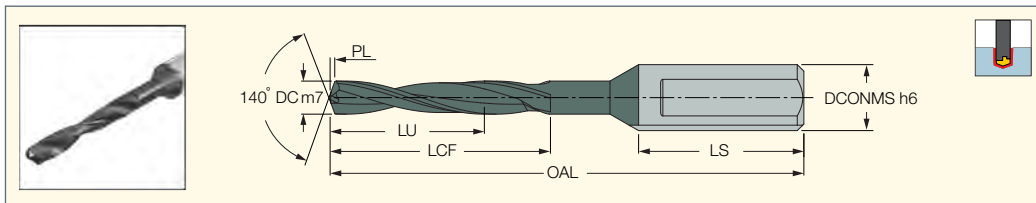
Designation	DCN ⁽²⁾	DCX ⁽³⁾	DCONMS	LU	PL	LS	OAL	SSC ⁽⁴⁾	MIID ⁽⁵⁾	
DCN 040-012-06-3D-PICCO ⁽¹⁾	4.00	4.40	6.00	12.62	0.620	14.9	37.60	4.0	ICP 040	
DCN 045-014-06-3D-PICCO ⁽¹⁾	4.50	4.90	6.00	14.66	0.660	14.9	39.55	4.5	ICP 045	
DCN 050-015-06-3D-PICCO ⁽¹⁾	5.00	5.40	6.00	15.73	0.730	14.9	41.20	5.0	ICP 050	
DCN 055-017-06-3D-PICCO ⁽¹⁾	5.50	5.90	6.00	17.81	0.810	14.9	42.85	5.5	ICP 055	
DCN 060-018-06-3D-PICCO	6.00	6.40	6.00	18.96	0.960	14.9	44.50	6.0	ICP 060	K DCN 6-9.99-Y
DCN 065-020-06-3D-PICCO	6.50	6.90	6.00	21.18	1.180	17.1	46.30	6.5	ICP 065	K DCN 6-9.99-Y
DCN 070-021-08-3D-PICCO	7.00	7.40	8.00	22.01	1.010	20.0	55.60	7.0	ICP 070	K DCN 6-9.99
DCN 075-023-08-3D-PICCO	7.50	7.90	8.00	24.10	1.100	20.0	57.10	7.0	ICP 075	K DCN 6-9.99
DCN 080-024-08-3D-PICCO	8.00	8.40	8.00	25.20	1.200	20.0	59.40	8.0	ICP 080	K DCN 6-9.99
DCN 085-026-08-3D-PICCO	8.50	8.90	8.00	26.35	1.350	20.0	60.90	8.0	ICP 085	K DCN 6-9.99
DCN 090-027-08-3D-PICCO	9.00	9.40	8.00	28.35	1.350	20.0	63.30	9.0	ICP 090	K DCN 6-9.99
DCN 095-029-08-3D-PICCO	9.50	9.90	8.00	30.44	1.440	20.0	64.30	9.0	ICP 095	K DCN 6-9.99
DCN 100-030-08-3D-PICCO	10.00	10.90	8.00	31.50	1.500	20.0	66.20	10.0	ICP 100	K DCN 10-13.99

• Do not mount smaller drilling heads other than the specified range of the drill body

⁽¹⁾ The SK DCN key is supplied with the insert ⁽²⁾ Cutting diameter minimum ⁽³⁾ Cutting diameter maximum ⁽⁴⁾ Seat size code ⁽⁵⁾ Master insert identification

PICCODRILL

SCD-PICCO 3D
Solid Carbide Drills for Swiss and Small CNC Machines

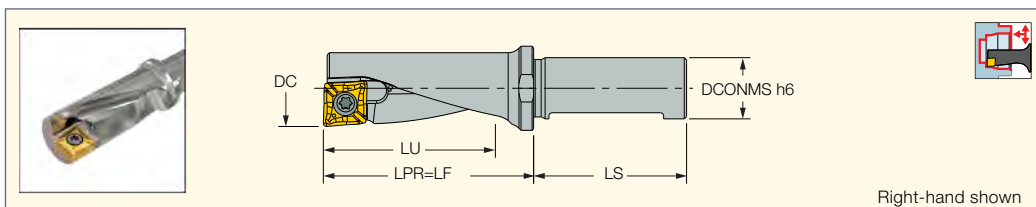


Designation	Dimensions							IC908
	DC	DCONMS	LU	LCF	OAL	LS	PL	
SCD 030-014-060 PICCO 3D	3.00	6.00	14.00	21.0	43.00	15.0	0.500	●
SCD 035-014-060 PICCO 3D	3.50	6.00	14.00	21.0	43.00	15.0	0.600	●
SCD 040-017-060 PICCO 3D	4.00	6.00	17.00	25.0	46.00	15.0	0.600	●
SCD 045-017-060 PICCO 3D	4.50	6.00	17.00	25.0	46.00	15.0	0.700	●
SCD 050-020-060 PICCO 3D	5.00	6.00	20.00	29.0	46.00	15.0	0.800	●
SCD 055-020-060 PICCO 3D	5.50	6.00	20.00	29.0	46.00	15.0	0.900	●
SCD 060-020-060 PICCO 3D	6.00	6.00	20.00	29.0	46.00	15.0	0.900	●
SCD 065-024-080 PICCO 3D	6.50	8.00	24.00	35.0	62.00	19.0	1.000	●
SCD 070-024-080 PICCO 3D	7.00	8.00	24.00	35.0	62.00	19.0	1.100	●
SCD 075-029-080 PICCO 3D	7.50	8.00	29.00	42.0	62.00	19.0	1.200	●
SCD 080-029-080 PICCO 3D	8.00	8.00	29.00	42.0	62.00	19.0	1.300	●



PICCOMFI



DR-MF PICCO
Multifunction Drilling, Boring, Facing and External Turning Tools with a Picco Connection



Designation	DC	LU	LPR	LS	DCONMS	MIID ⁽¹⁾
DR-MF-08R/L-2.25D-08A-04-P	8.00	18.00	22.50	20.0	8.00	XCMT 040104-MF
DRG-MF-10R/L-2.25D-08A-05-P	10.00	22.50	27.50	20.0	8.00	XCMT 050204-MF

⁽¹⁾ Master insert identification

Spare Parts

Designation		
DR-MF-08R/L-2.25D-08A-04-P	SR 18034/HG-P	IP-6/5
DRG-MF-10R/L-2.25D-08A-05-P	SR 14-552	T-6/5

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