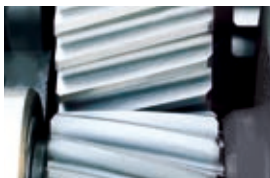




VEHICLES



AEROSPACE



GEARS & BEARINGS



ENGINEERING



WIND ENERGY



**DISCOVER A MULTITUDE
OF SOLUTIONS**

RAG

STECHDREHEN MIT SEITLICHEM VERFAHREN

GROOVING WITH LATERAL MOVEMENT



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Das Stechsystem wurde speziell für das prozesssichere radiale und axiale Stechen in GJL (GG)- und GJS (GGG)-Werkstoffe und zum seitlichen Verfahren konzipiert. Die neue Doppelprisma-Klemmtechnologie nimmt Querkräfte sicher auf und hält die Stechplatte positionsgenau im Plattensitz. Damit lassen sich auch seitliche Vorschubbewegungen prozesssicher realisieren. Je nach Auslegung der Werkzeuge, können beim seitlichen Verfahren Stechtiefen bis 3 mm bei Vorschüben bis 0,25 mm und

The grooving system is designed specifically for radial and axial grooving in GJL (grey cast iron) and GJS (ductile cast iron) materials and for lateral movement, and ensures complete process reliability. The new double prism clamping technology is able to securely absorb transverse forces while holding the grooving insert in position in the insert seating. It also facilitates lateral feed movements with process reliability. Depending on the tool design, grooving depth of up to 3 mm with feed rates up to 0.25 mm

Schnittgeschwindigkeit bis zu 800 m/min gefahren werden. Das Stechschwert und die Klemmelemente überzeugen als extrem stabiles Gesamtsystem. Das System ist modular aufgebaut, Stechschwert und Klemmfinger sind einfach und schnell austauschbar und aus hochwarmfestem Material gefertigt.

Es sind Stechbreiten von 4 bis 8 Millimeter erhältlich. Wird der Grundhalter mit entsprechendem Stechschwert ausgerüstet, sind Stechtiefen bis zu 30 Millimeter mög-


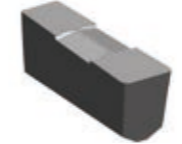
and cutting speeds of up to 800 m/min can be attained with lateral movement. The grooving blade and clamping elements together form an extremely stable complete system. The system is modular and features a grooving blade and clamping element that are made from high temperature-resistant material and are quick and easy to replace.

It is available for grooving widths between 4 mm and 12 mm. If the tool holder is equipped with the appropriate grooving

lich. Durch das Stechdrehen mit seitlichem Verfahren lassen sich mehrere Bearbeitungsschritte mit nur einem Werkzeugsystem abdecken. Das spart weitere Werkzeuge und damit auch Werkzeugplätze auf dem Revolver. In Kombination mit unseren Hochleistungsschneidstoffen steigert das Stechsystem RAG die Prozessflexibilität und gleichzeitig die Produktivität für eine schnellere und kostengünstigere Produktion.

blade, grooving depths of up to 30 mm are attainable. Grooving with lateral movement means that several machining steps can be performed by a single tool system. This means that additional tools are not required, which saves space on the tool turret. When further combined with our high-performance cutting materials, the RAG grooving system increases both process flexibility and productivity, ensuring a faster and more cost-efficient production process.

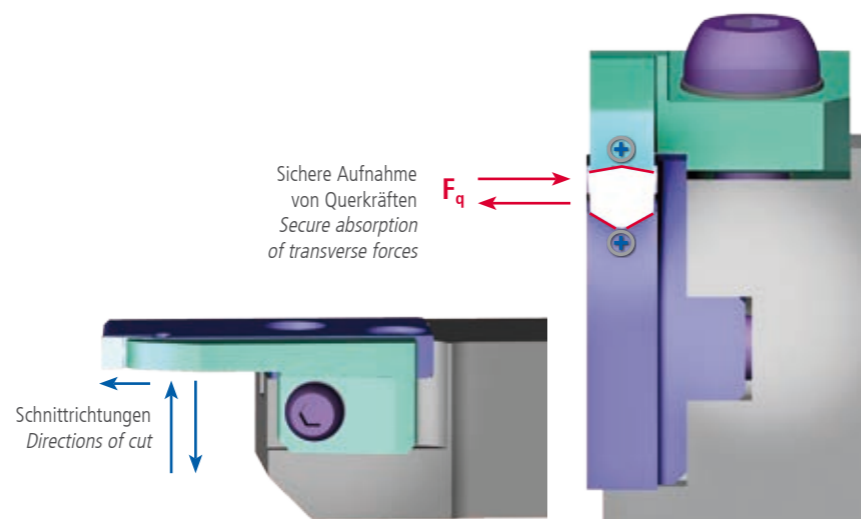
RAG Stechbreiten und Stechtiefen RAG grooving widths and depths				
Stechbreite Grooving width	Stechtiefe / Grooving depth			
	12 mm	18 mm	24 mm	30 mm
4 mm	●	●		
5 mm	●	●	●	
6 mm	●	●	●	●
7 mm	●	●	●	●
8 mm		●	●	●

Grundgeometrien Schneidplatten Basic insert geometries		Typ Type
	Zweischneidige Schneidplatten für kleine Stechtiefen und Formeinstiche Inserts with two cutting edges for smaller grooving depths and different shaped groovings	L
	Einschneidige Schneidplatten für große Stechtiefen Inserts with one cutting edge for large grooving depths	G

Schneidstoffsorten
Types of cutting material

SiALON SL608
SiALON SL608
Oxid-Keramik SN60
Oxide ceramic SN60

EASY CHANGE
TECHNOLOGIE

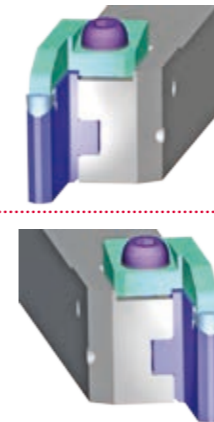


Durch die EASY Change Technologie wird auch ein einfacher Wechsel von keramischen Schneidplatten und CBN-Schneidplatten ermöglicht, ohne den Klemmfinger oder das Schwert auszutauschen.

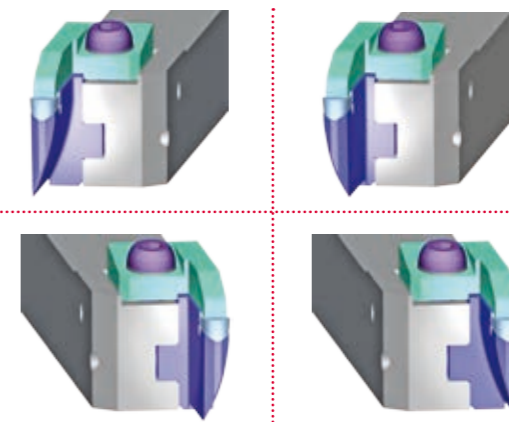
EASY Change Technology also allows easy exchangeability of ceramic inserts and CBN inserts without the need to replace the clamping finger or the grooving blade.

RAG AUSFÜHRUNGSVARIANTEN
RAG VERSIONS

Radialstechen
Radial grooving



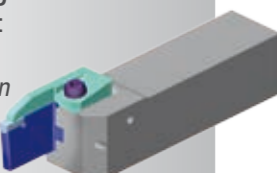
Axialstechen
Axial grooving



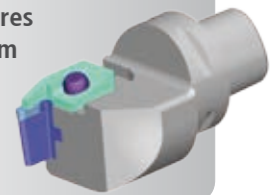
Stechschwert und Spannfinger aus hochwarmfestem Material
Grooving blade and clamping element made from high temperature-resistant material

Basishalter
Basic tool holder

Schaftwerkzeuge mit Querschnitt
Shank tools with cross section
25 x 25
32 x 25



CMS5 - Modulares Werkzeugsystem
CMS5 - Modular tool system



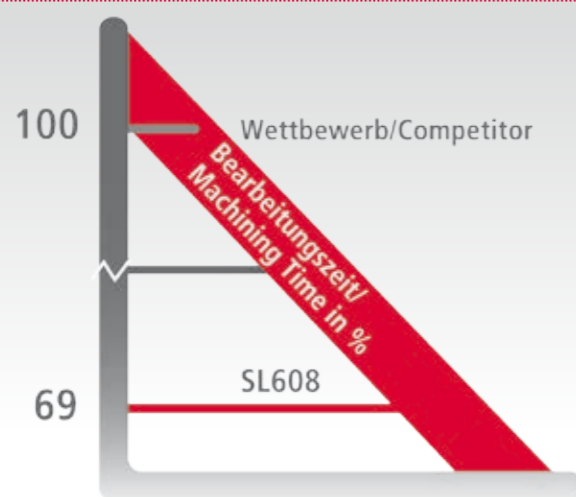
BEARBEITUNGSZEIT UM 31 % VERRINGERT
PROCESSING TIME DECREASED BY 31 %
STECHDREHEN EINER RIEMENSCHLEIBE
GROOVING OF A PULLEY

STANDMENGE AUF 240 % ERHÖHT
TOOL LIFE QUANTITY INCREASED BY 240 %
STECHDREHEN EINER POLY-V SCHEIBE
SEMI FINISHING OF A POLY-V DISC

**ANFORDERUNGEN:
REQUIREMENTS:**
- BEARBEITUNGSZEIT REDUZIEREN
- REDUCTION OF MACHINING TIME
- KEINE GRATBILDUNG
- NO BURRS

**BEDINGUNGEN:
CONDITIONS:**
- GLATTER SCHNITT
- CONTINUOUS CUT
- TROCKENBEARBEITUNG
- DRY CUTTING
- WERKSTOFF GJL 300
- MATERIAL GJL 300

SiALON SL608



SPK-ENGINEERING ZUR STEIGERUNG DER WIRTSCHAFTLICHKEIT DURCH
SPK ENGINEERING FOR INCREASING EFFICIENCY THROUGH
- ABSTIMMUNG WERKSTOFF-/SCHNEIDSTOFF PAARUNG
- HARMONIZING OF WORKPIECE- AND CUTTING MATERIALS
- DEFINITION DER BEARBEITUNGSSTRATEGIE
- DEFINITION OF MACHINING STRATEGY
- FESTLEGUNG DER SCHNITTPARAMETER
- DEFINITION OF CUTTING DATA

Bearbeitung: Längs- und Plandrehen einer Riemenschleibe
Machining of a Pulley: Grooving and facing

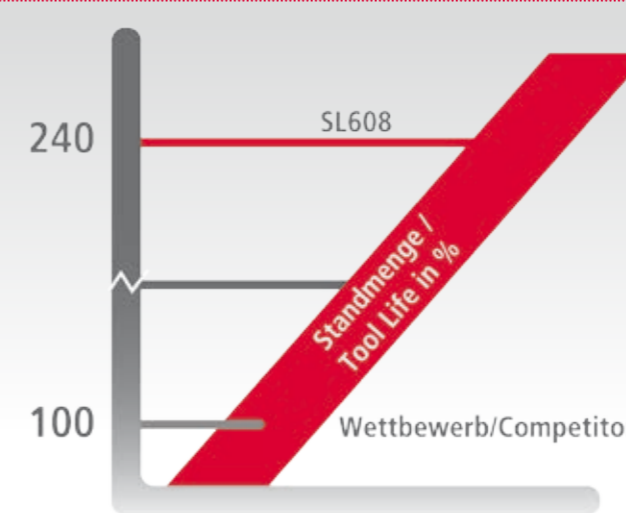
	Wettbewerb Competitor	SPK
Schneidstoff Cutting material:	Hartmetall Carbide	SL608
Schneidplattentyp Insert type:	-	GBMP 12A0800
Schnittgeschwindigkeit v_c : Cutting speed v_c :	250 m/min	800 m/min
Vorschub f : Feed rate f :	0,12 mm	0,10 mm
Schnitttiefe a_p : Depth of cut a_p :	1,5 mm	1,5 mm
Bearbeitungszeit: Machining time:	15,3 min	4,8 min
Standmenge: Tool life quantity:	30 St. / pcs.	30 St./ pcs.



**ANFORDERUNGEN:
REQUIREMENTS:**
- STANDMENGE ERHÖHEN
- INCREASE TOOL LIFE QUANTITY
- PROZESSSICHERHEIT
- PROCESS RELIABILITY

**BEDINGUNGEN:
CONDITIONS:**
- GLATTER SCHNITT
- CONTINUOUS CUT
- TROCKENBEARBEITUNG
- DRY CUTTING

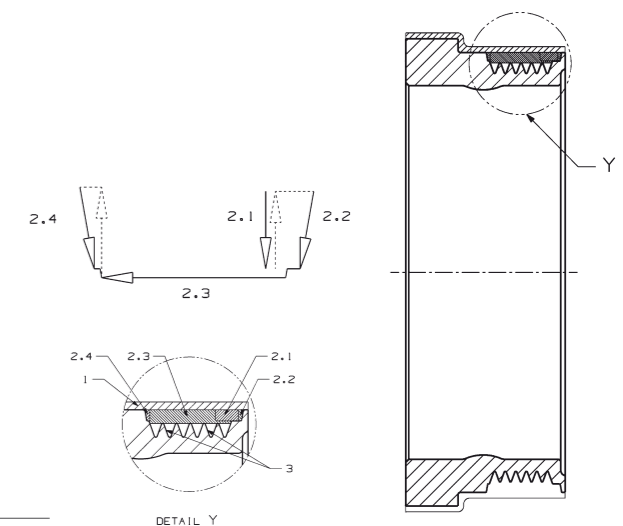
SiALON SL608



SPK-ENGINEERING ZUR STEIGERUNG DER WIRTSCHAFTLICHKEIT DURCH
SPK ENGINEERING FOR INCREASING EFFICIENCY THROUGH
- DEFINITION DER BEARBEITUNGSSTRATEGIE
- DEFINITION OF MACHINING STRATEGY
- FESTLEGUNG DER SCHNITTPARAMETER
- DEFINITION OF CUTTING DATA

Schrupp-Schichten einer Poly-V Scheibe
Semi finishing of a Poly-V Disc

	Wettbewerb Competitor	SPK
Schneidstoff Cutting material:	Hartmetall Carbide	SL608
Schneidplattentyp Insert type:	-	GBMP 12A0600T
Schnittgeschwindigkeit v_c : Cutting speed v_c :	230 m/min	600 m/min
Vorschub f : Feed rate f :	0,20 mm	0,10 mm
Schnitttiefe a_p : Depth of cut a_p :	2,0 mm	2,0 mm
Standmenge: Tool life quantity:	100 %	240 %



RAG Schaftklemmhalter
RAG shank tool



RAG = Radial Axial Stechen (Grooving)

Bezeichnung Stechsystem Designation grooving system

Werkzeughöhe h Tool height h

Stechbreite a Grooving width a

Schneidplattenhöhe Insert height

Ausführung Stechschwert Grooving blade version

Ausführung Version

D_{min} Axial D_{min} Axial

Schaftbreite b Shank width b

Stechtiefe t Grooving depth t

25 mm

25 mm

32 mm

B4 = 4 mm
B5 = 5 mm
B6 = 6 mm
B7 = 7 mm
B8 = 8 mm

H = 5 mm

Gerade Straight
Links Left
Rechts Right

T12 = 12 mm
T18 = 18 mm
T24 = 24 mm
T30 = 30 mm

links Left
rechts Right

D_{min} = 100 mm

RAG - 25 25 - B4 T18 H5 - L G 100

RAG Stechschwerter
RAG grooving blade

Bezeichnung Stechsystem Designation grooving system

Abkürzung für Stechschwert Abbreviation for grooving blade

Schneidplattenhöhe Insert height

D_{min} Axial D_{min} Axial

H = 5 mm

D_{min} = 100 mm

RAG - ST - B4 T18 H5 - L G 100

Stechbreite a Grooving width a

Stechtiefe t Grooving depth t

Ausführung Version

Ausführung Stechschwert Grooving blade version

B4 = 4 mm
B5 = 5 mm
B6 = 6 mm
B7 = 7 mm
B8 = 8 mm

T12 = 12 mm
T18 = 18 mm
T24 = 24 mm
T30 = 30 mm

links Left
rechts Right

Gerade Straight
Links Left
Rechts Right

RAG Spannelemente
RAG clamping elements

RAG CMS Klemmhalter
RAG CMS tool holder

Bezeichnung Stechsystem Designation grooving system

Abkürzung für Spannelement Abbreviation for clamping element

Ausführung Version

RAG - CMS5 - B4 T18 H5 - L G 100

Werkzeuggröße Tool size

d = 50 mm

Bezeichnung Stechsystem Designation grooving system

Abkürzung für Spannelement Abbreviation for clamping element

Ausführung Version

RAG - SP - B4 T18 - L

Stechbreite a Grooving width a

Stechtiefe t Grooving depth t

L					
G			P		
Grundgeometrie Basic insert geometry		Normal-Freiwinkel Clearance angle	Plattentyp Insert type	Plattenhöhe Insert height	
G		B	M	P	12
					A

Toleranz
Tolerance

	a ± mm
M	0,130

Plattengröße ℓ
Insert size ℓ

$\ell = 12 \text{ mm}$

0400 = 4 mm 0500 = 5 mm 0600 = 6 mm 0700 = 7 mm 0800 = 8 mm	Stechnbreite a Grooving width a	Schneidenausführung Cutting edge version	
		0400	T - N
			L1R1 - RAG SL608
			Sorte Cutting material
			Oxidkeramik SN60 SIALON SL608
			Bezeichnung Stechnsystem Designation grooving system
			N neutral

Eingriffstiefe a_p (mm)
in Abhängigkeit von Stechbreite a und
maximaler Stechtiefe t_{max}

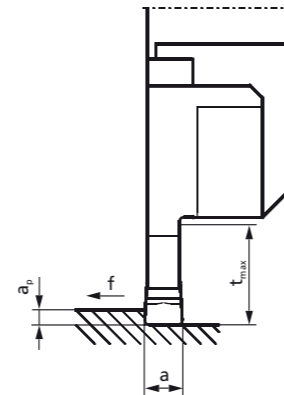
Cutting depth a_p (mm)
Depending on grooving width a and
maximum grooving depth t_{max}

t_{max}	12 mm	18 mm	24 mm	30 mm
STECHBREITE a GROOVING WIDTH				
4 mm	2,0	1,5	-	-
5 mm	2,5	2,5	2,0	-
6 mm	3,0	2,5	2,0	-
7 mm	3,0	2,5	2,0	2,0
8 mm	-	3,0	2,5	2,0

Vorschub f (mm)
in Abhängigkeit von Stechbreite a und
maximaler Stechtiefe t_{max}

Feed rate f (mm)
Depending on grooving width a and
maximum grooving depth t_{max}

t_{max}	12 mm	18 mm	24 mm	30 mm
STECHBREITE a GROOVING WIDTH				
4 mm	0,20	0,15	-	-
5 mm	0,20	0,20	0,15	-
6 mm	0,25	0,20	0,15	-
7 mm	0,25	0,20	0,20	0,15
8 mm	-	0,25	0,20	0,15



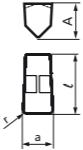
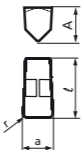
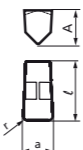
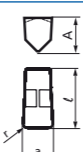
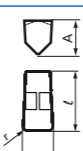
Schnittgeschwindigkeit v_c (m/min)
Cutting speed v_c (m/min)

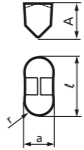
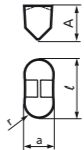
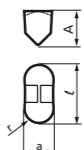
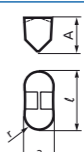
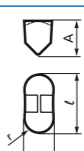
Glatter Schnitt Continuous cut	Richtwerte Recommended values	
	SL608	SN60
Schlichten Finishing		
GJL Werkstoffe GJL materials	800 m/min	600 m/min
GJS Werkstoffe GJS materials	600 m/min	500 m/min
Schruppen Roughing		
GJL Werkstoffe GJL materials	600 m/min	400 m/min
GJS Werkstoffe GJS materials	500 m/min	400 m/min

Unterbrochener Schnitt Interrupted cut	Richtwerte Recommended values	
	SL608	
Schlichten Finishing		
GJL Werkstoffe GJL materials	800 m/min	
GJS Werkstoffe GJS materials	700 m/min	
Schruppen Roughing		
GJL Werkstoffe GJL materials	700 m/min	
GJS Werkstoffe GJS materials	600 m/min	

GBMP

LBMP

Stechbreite a Grooving width a	SPK-Bezeichnung SPK designation	Sorte Grade	Best.-Nr. Ref. no.	Form Shape	Abmessungen (mm) Dimensions (mm)					
					Radi r		h	ℓ	Fase Chamfer	S
					L	R				
a = 4 mm	GBMP 12A0400 T-N L0.5R0.5-RAG SL608	SL 608	19.23.505.03.3		0.5	0.5	5	12	T 00520	N
	GBMP 12A0400 T-N L0.5R0.5-RAG SN60	SN 60	36.23.505.03.5		0.5	0.5	5	12	T 00520	N
a = 5 mm	GBMP 12A0500 T-N L0.8R0.8-RAG SL608	SL 608	19.23.506.03.3		0.8	0.8	5	12	T 00520	N
	GBMP 12A0500 T-N L0.8R0.8-RAG SN60	SN 60	36.23.506.03.5		0.8	0.8	5	12	T 00520	N
a = 6 mm	GBMP 12A0600 T-N L0.8R0.8-RAG SL608	SL 608	19.23.507.03.3		0.8	0.8	5	12	T 00520	N
	GBMP 12A0600 T-N L0.8R0.8-RAG SN60	SN 60	36.23.507.03.5		0.8	0.8	5	12	T 00520	N
a = 7 mm	GBMP 12A0700 T-N L0.8R0.8-RAG SL608	SL 608	19.23.508.03.3		0.8	0.8	5	12	T 00520	N
	GBMP 12A0700 T-N L0.8R0.8-RAG SN60	SN 60	36.23.508.03.5		0.8	0.8	5	12	T 00520	N
a = 8 mm	GBMP 12A0800 T-N L0.8R0.8-RAG SL608	SL 608	19.23.509.03.3		0.8	0.8	5	12	T 00520	N
	GBMP 12A0800 T-N L0.8R0.8-RAG SN60	SN 60	36.23.509.03.5		0.8	0.8	5	12	T 00520	N

Stechbreite a Grooving width a	SPK-Bezeichnung SPK designation	Sorte Grade	Best.-Nr. Ref. no.	Form Shape	Abmessungen (mm) Dimensions (mm)					
					Radi r		h	ℓ	Fase Chamfer	S
					L	R				
a = 4 mm	LBMP 12A0400 T-N L2R2-RAG SL608	SL 608	19.23.500.03.3		2	2	5	12	T 00520	N
	LBMP 12A0400 T-N L2R2-RAG SN60	SN 60	36.23.500.03.5		2	2	5	12	T 00520	N
a = 5 mm	LBMP 12A0500 T-N L2.5R2.5-RAG SL608	SL 608	19.23.501.03.3		2.5	2.5	5	12	T 00520	N
	LBMP 12A0500 T-N L2.5R2.5-RAG SN60	SN 60	36.23.501.03.5		2.5	2.5	5	12	T 00520	N
a = 6 mm	LBMP 12A0600 T-N L3R3-RAG SL608	SL 608	19.23.502.03.3		3	3	5	12	T 00520	N
	LBMP 12A0600 T-N L3R3-RAG SN60	SN 60	36.23.502.03.5		3	3	5	12	T 00520	N
a = 7 mm	LBMP 12A0700 T-N L3.5R3.5-RAG SL608	SL 608	19.23.503.03.3		3.5	3.5	5	12	T 00520	N
	LBMP 12A0700 T-N L3.5R3.5-RAG SN60	SN 60	36.23.503.03.5		3.5	3.5	5	12	T 00520	N
a = 8 mm	LBMP 12A0800 T-N L4R4-RAG SL608	SL 608	19.23.504.03.3		4	4	5	12	T 00520	N
	LBMP 12A0800 T-N L4R4-RAG SN60	SN 60	36.23.504.03.5		4	4	5	12	T 00520	N

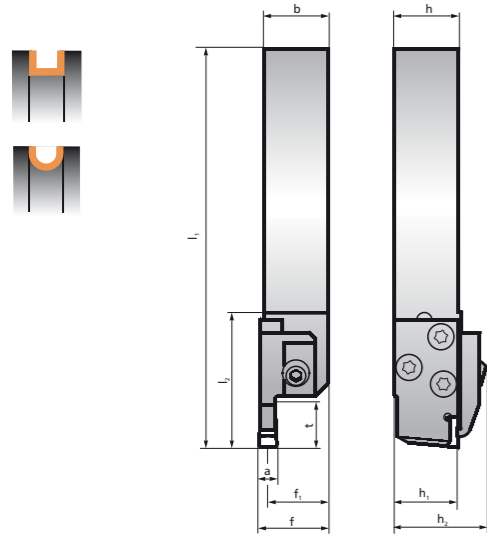


STECHBREITE GROOVING WIDTH 4 MM
STECHTIEFE GROOVING DEPTH 12 MM

SCHAFTAUSFÜHRUNG SHANK VERSION
2525







SCHAFTAUSFÜHRUNG SHANK VERSION
3225







STECHBREITE GROOVING WIDTH 4 MM
STECHTIEFE GROOVING DEPTH 12 MM

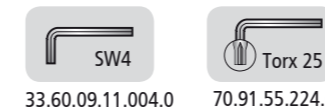
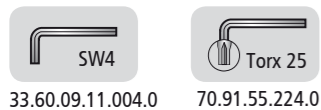


Schaft Shank	Abmessungen Dimensions (mm)									
	h=h ₁	b	l ₁	l ₂	t	a	f ₁	f	h ₂	
2525	25	25	150	47	12	4	23,5	$f_1 + \frac{a}{2}$	36	
3225	32	25	170	47	12	4	23,5	$f_1 + \frac{a}{2}$	43	

Spanwinkel Rake angle γ	0°
Neigungswinkel Back rake angle λ	0°

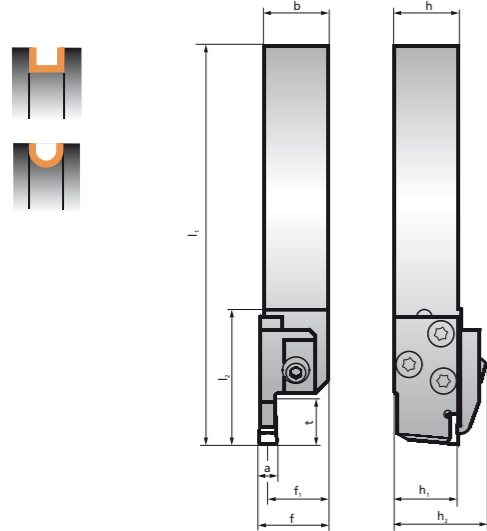
Stechbreite a Stechtiefe t Grooving width a Grooving depth t	Typ Type	Best.-Nr. Ref. no.	Stechschwert Grooving blade		Spannelement Clamping element	
			2525	Typ Type	Best.-Nr. Ref. no.	Typ Type
Links Left a = 4 mm t = 12 mm	 RAG-2525-B4T12H5-LG	719.78.010.01	RAG-ST-B4T12H5-LG	70.91.22.548.0	RAG-SP-B4T12-L	70.91.11.916.0
	 RAG-2525-B4T12H5-LR100	719.78.010.02	RAG-ST-B4T12H5-LR100	70.91.22.549.0	RAG-SP-B4T12-L	70.91.11.916.0
	 RAG-2525-B4T12H5-LL100	719.78.010.03	RAG-ST-B4T12H5-LL100	70.91.22.550.0	RAG-SP-B4T12-L	70.91.11.916.0
Rechts Right a = 4 mm t = 12 mm	 RAG-2525-B4T12H5-RG	719.77.010.01	RAG-ST-B4T12H5-RG	70.91.22.500.0	RAG-SP-B4T12-R	70.91.11.900.0
	 RAG-2525-B4T12H5-RL100	719.77.010.02	RAG-ST-B4T12H5-RL100	70.91.22.501.0	RAG-SP-B4T12-R	70.91.11.900.0
	 RAG-2525-B4T12H5-RR100	719.77.010.03	RAG-ST-B4T12H5-RR100	70.91.22.502.0	RAG-SP-B4T12-R	70.91.11.900.0

Stechbreite a Stechtiefe t Grooving width a Grooving depth t	Typ Type	Best.-Nr. Ref. no.	Stechschwert Grooving blade		Spannelement Clamping element	
			3225	Typ Type	Best.-Nr. Ref. no.	Typ Type
Links Left a = 4 mm t = 12 mm	 RAG-3225-B4T12H5-LG	719.78.011.01	RAG-ST-B4T12H5-LG	70.91.22.548.0	RAG-SP-B4T12-L	70.91.11.916.0
	 RAG-3225-B4T12H5-LR100	719.78.011.02	RAG-ST-B4T12H5-LR100	70.91.22.549.0	RAG-SP-B4T12-L	70.91.11.916.0
	 RAG-3225-B4T12H5-LL100	719.78.011.03	RAG-ST-B4T12H5-LL100	70.91.22.550.0	RAG-SP-B4T12-L	70.91.11.916.0
Rechts Right a = 4 mm t = 12 mm	 RAG-3225-B4T12H5-RG	719.77.011.01	RAG-ST-B4T12H5-RG	70.91.22.500.0	RAG-SP-B4T12-R	70.91.11.900.0
	 RAG-3225-B4T12H5-RL100	719.77.011.02	RAG-ST-B4T12H5-RL100	70.91.22.501.0	RAG-SP-B4T12-R	70.91.11.900.0
	 RAG-3225-B4T12H5-RR100	719.77.011.03	RAG-ST-B4T12H5-RR100	70.91.22.502.0	RAG-SP-B4T12-R	70.91.11.900.0



STECHBREITE GROOVING WIDTH 4 MM
STECHTIEFE GROOVING DEPTH 18 MM

SCHAFTAUSFÜHRUNG SHANK VERSION
2525



Schaft Shank	Abmessungen Dimensions (mm)									
	h=h ₁	b	l ₁	l ₂	t	a	f ₁	f	h ₂	
2525	25	25	156	47	18	4	23,5	$f_1 + \frac{a}{2}$	36	
3225	32	25	176	47	18	4	23,5	$f_1 + \frac{a}{2}$	43	

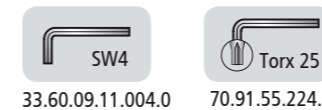
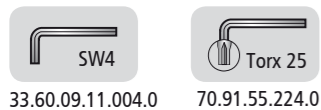
Spanwinkel Rake angle γ	0°
Neigungswinkel Back rake angle λ	0°

Stechbreite a Stechtiefe t Grooving width a Grooving depth t	Typ Type	Best.-Nr. Ref. no.	Stechschwert Grooving blade		Spannelement Clamping element	
		2525	Typ Type	Best.-Nr. Ref. no.	Typ Type	Best.-Nr. Ref. no.
Links Left a = 4 mm t = 18 mm	RAG-2525-B4T18H5-LG	719.78.010.04	RAG-ST-B4T18H5-LG	70.91.22.551.0	RAG-SP-B4T18-L	70.91.11.917.0
	RAG-2525-B4T18H5-LR100	719.78.010.05	RAG-ST-B4T18H5-LR100	70.91.22.552.0	RAG-SP-B4T18-L	70.91.11.917.0
	RAG-2525-B4T18H5-LL100	719.78.010.06	RAG-ST-B4T18H5-LL100	70.91.22.553.0	RAG-SP-B4T18-L	70.91.11.917.0
Rechts Right a = 4 mm t = 18 mm	RAG-2525-B4T18H5-RG	719.77.010.04	RAG-ST-B4T18H5-RG	70.91.22.503.0	RAG-SP-B4T18-R	70.91.11.901.0
	RAG-2525-B4T18H5-RL100	719.77.010.05	RAG-ST-B4T18H5-RL100	70.91.22.504.0	RAG-SP-B4T18-R	70.91.11.901.0
	RAG-2525-B4T18H5-RR100	719.77.010.06	RAG-ST-B4T18H5-RR100	70.91.22.505.0	RAG-SP-B4T18-R	70.91.11.901.0

SCHAFTAUSFÜHRUNG SHANK VERSION
3225

STECHBREITE GROOVING WIDTH 4 MM
STECHTIEFE GROOVING DEPTH 18 MM

Stechbreite a Stechtiefe t Grooving width a Grooving depth t	Typ Type	Best.-Nr. Ref. no.	Stechschwert Grooving blade		Spannelement Clamping element	
		3225	Typ Type	Best.-Nr. Ref. no.	Typ Type	Best.-Nr. Ref. no.
Links Left a = 4 mm t = 18 mm	RAG-3225-B4T18H5-LG	719.78.011.04	RAG-ST-B4T18H5-LG	70.91.22.551.0	RAG-SP-B4T18-L	70.91.11.917.0
	RAG-3225-B4T18H5-LR100	719.78.011.05	RAG-ST-B4T18H5-LR100	70.91.22.552.0	RAG-SP-B4T18-L	70.91.11.917.0
	RAG-3225-B4T18H5-LL100	719.78.011.06	RAG-ST-B4T18H5-LL100	70.91.22.553.0	RAG-SP-B4T18-L	70.91.11.917.0
Rechts Right a = 4 mm t = 18 mm	RAG-3225-B4T18H5-RG	719.77.011.04	RAG-ST-B4T18H5-RG	70.91.22.503.0	RAG-SP-B4T18-R	70.91.11.901.0
	RAG-3225-B4T18H5-RL100	719.77.011.05	RAG-ST-B4T18H5-RL100	70.91.22.504.0	RAG-SP-B4T18-R	70.91.11.901.0
	RAG-3225-B4T18H5-RR100	719.77.011.06	RAG-ST-B4T18H5-RR100	70.91.22.505.0	RAG-SP-B4T18-R	70.91.11.901.0

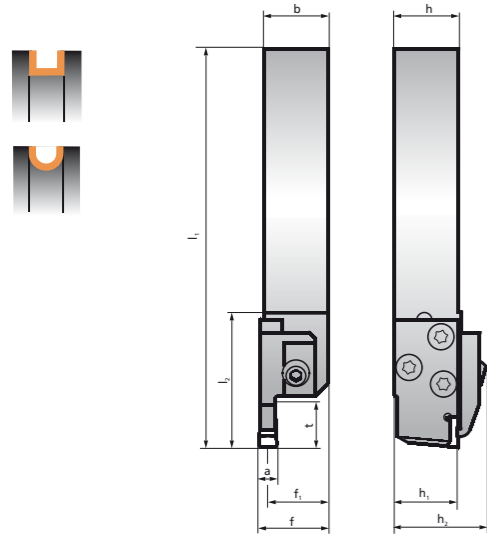


STECHBREITE GROOVING WIDTH 5 MM
STECHTIEFE GROOVING DEPTH 12 MM

SCHAFTAUSFÜHRUNG SHANK VERSION
2525



SCHAFTAUSFÜHRUNG SHANK VERSION
3225







STECHBREITE GROOVING WIDTH 5 MM
STECHTIEFE GROOVING DEPTH 12 MM

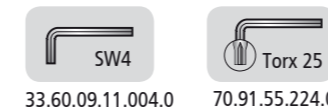
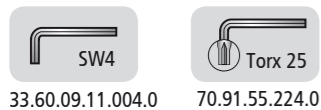


Schaft Shank	Abmessungen Dimensions (mm)									
	h=h ₁	b	l ₁	l ₂	t	a	f ₁	f	h ₂	
2525	25	25	150	47	12	5	23,5	f ₁ + $\frac{a}{2}$	36	
3225	32	25	170	47	12	5	23,5	f ₁ + $\frac{a}{2}$	43	

Spanwinkel Rake angle γ	0°
Neigungswinkel Back rake angle λ	0°

Stechbreite a Stechtiefe t Grooving width a Grooving depth t	Typ Type	Best.-Nr. Ref. no.	Stechschwert Grooving blade		Spannelement Clamping element	
		2525	Typ Type	Best.-Nr. Ref. no.	Typ Type	Best.-Nr. Ref. no.
Links Left a = 5 mm t = 12 mm	 RAG-2525-B5T12H5-LG	719.78.010.07	RAG-ST-B5T12H5-LG	70.91.22.554.0	RAG-SP-B5T12-L	70.91.11.918.0
	 RAG-2525-B5T12H5-LR100	719.78.010.08	RAG-ST-B5T12H5-LR100	70.91.22.555.0	RAG-SP-B5T12-L	70.91.11.918.0
	 RAG-2525-B5T12H5-LL100	719.78.010.09	RAG-ST-B5T12H5-LL100	70.91.22.556.0	RAG-SP-B5T12-L	70.91.11.918.0
Rechts Right a = 5 mm t = 12 mm	 RAG-2525-B5T12H5-RG	719.77.010.07	RAG-ST-B5T12H5-RG	70.91.22.506.0	RAG-SP-B5T12-R	70.91.11.902.0
	 RAG-2525-B5T12H5-RL100	719.77.010.08	RAG-ST-B5T12H5-RL100	70.91.22.507.0	RAG-SP-B5T12-R	70.91.11.902.0
	 RAG-2525-B5T12H5-RR100	719.77.010.09	RAG-ST-B5T12H5-RR100	70.91.22.508.0	RAG-SP-B5T12-R	70.91.11.902.0

Stechbreite a Stechtiefe t Grooving width a Grooving depth t	Typ Type	Best.-Nr. Ref. no.	Stechschwert Grooving blade		Spannelement Clamping element	
		3225	Typ Type	Best.-Nr. Ref. no.	Typ Type	Best.-Nr. Ref. no.
Links Left a = 5 mm t = 12 mm	 RAG-3225-B5T12H5-LG	719.78.011.07	RAG-ST-B5T12H5-LG	70.91.22.554.0	RAG-SP-B5T12-L	70.91.11.918.0
	 RAG-3225-B5T12H5-LR100	719.78.011.08	RAG-ST-B5T12H5-LR100	70.91.22.555.0	RAG-SP-B5T12-L	70.91.11.918.0
	 RAG-3225-B5T12H5-LL100	719.78.011.09	RAG-ST-B5T12H5-LL100	70.91.22.556.0	RAG-SP-B5T12-L	70.91.11.918.0
Rechts Right a = 5 mm t = 12 mm	 RAG-3225-B5T12H5-RG	719.77.011.07	RAG-ST-B5T12H5-RG	70.91.22.506.0	RAG-SP-B5T12-R	70.91.11.902.0
	 RAG-3225-B5T12H5-RL100	719.77.011.08	RAG-ST-B5T12H5-RL100	70.91.22.507.0	RAG-SP-B5T12-R	70.91.11.902.0
	 RAG-3225-B5T12H5-RR100	719.77.011.09	RAG-ST-B5T12H5-RR100	70.91.22.508.0	RAG-SP-B5T12-R	70.91.11.902.0

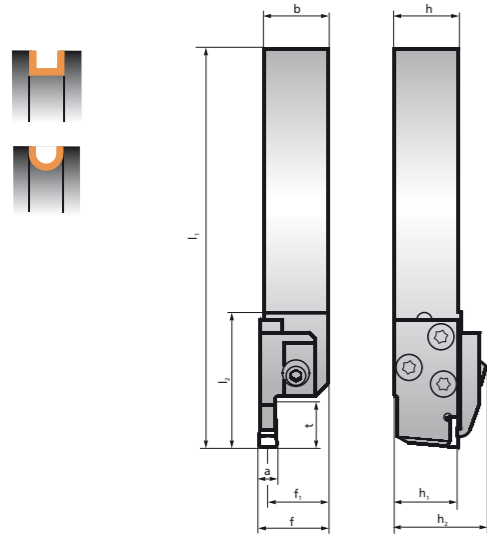


STECHBREITE GROOVING WIDTH 5 MM
STECHTIEFE GROOVING DEPTH 18 MM

SCHAFTAUSFÜHRUNG SHANK VERSION
2525

SCHAFTAUSFÜHRUNG SHANK VERSION
3225

STECHBREITE GROOVING WIDTH 5 MM
STECHTIEFE GROOVING DEPTH 18 MM

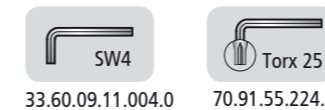
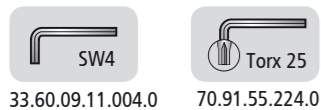


Schaft Shank	Abmessungen Dimensions (mm)									
	h=h ₁	b	l ₁	l ₂	t	a	f ₁	f	h ₂	
2525	25	25	156	47	18	5	23,5	$f_1 + \frac{a}{2}$	36	
3225	32	25	176	47	18	5	23,5	$f_1 + \frac{a}{2}$	43	

Spanwinkel Rake angle γ	0°
Neigungswinkel Back rake angle λ	0°

Stechbreite a Stechtiefe t Grooving width a Grooving depth t	Typ Type	Best.-Nr. Ref. no.	Stechschwert Grooving blade		Spannelement Clamping element	
			2525	Typ Type	Best.-Nr. Ref. no.	Typ Type
Links Left a = 5 mm t = 18 mm	RAG-2525-B5T18H5-LG	719.78.010.10	RAG-ST-B5T18H5-LG	70.91.22.557.0	RAG-SP-B5T18-L	70.91.11.919.0
	RAG-2525-B5T18H5-LR100	719.78.010.11	RAG-ST-B5T18H5-LR100	70.91.22.558.0	RAG-SP-B5T18-L	70.91.11.919.0
	RAG-2525-B5T18H5-LL100	719.78.010.12	RAG-ST-B5T18H5-LL100	70.91.22.559.0	RAG-SP-B5T18-L	70.91.11.919.0
Rechts Right a = 5 mm t = 18 mm	RAG-2525-B5T18H5-RG	719.77.010.10	RAG-ST-B5T18H5-RG	70.91.22.509.0	RAG-SP-B5T18-R	70.91.11.903.0
	RAG-2525-B5T18H5-RL100	719.77.010.11	RAG-ST-B5T18H5-RL100	70.91.22.510.0	RAG-SP-B5T18-R	70.91.11.903.0
	RAG-2525-B5T18H5-RR100	719.77.010.12	RAG-ST-B5T18H5-RR100	70.91.22.511.0	RAG-SP-B5T18-R	70.91.11.903.0

Stechbreite a Stechtiefe t Grooving width a Grooving depth t	Typ Type	Best.-Nr. Ref. no.	Stechschwert Grooving blade		Spannelement Clamping element	
			3225	Typ Type	Best.-Nr. Ref. no.	Typ Type
Links Left a = 5 mm t = 18 mm	RAG-3225-B5T18H5-LG	719.78.011.10	RAG-ST-B5T18H5-LG	70.91.22.557.0	RAG-SP-B5T18-L	70.91.11.919.0
	RAG-3225-B5T18H5-LR100	719.78.011.11	RAG-ST-B5T18H5-LR100	70.91.22.558.0	RAG-SP-B5T18-L	70.91.11.919.0
	RAG-3225-B5T18H5-LL100	719.78.011.12	RAG-ST-B5T18H5-LL100	70.91.22.559.0	RAG-SP-B5T18-L	70.91.11.919.0
Rechts Right a = 5 mm t = 18 mm	RAG-3225-B5T18H5-RG	719.77.011.10	RAG-ST-B5T18H5-RG	70.91.22.509.0	RAG-SP-B5T18-R	70.91.11.903.0
	RAG-3225-B5T18H5-RL100	719.77.011.11	RAG-ST-B5T18H5-RL100	70.91.22.510.0	RAG-SP-B5T18-R	70.91.11.903.0
	RAG-3225-B5T18H5-RR100	719.77.011.12	RAG-ST-B5T18H5-RR100	70.91.22.511.0	RAG-SP-B5T18-R	70.91.11.903.0

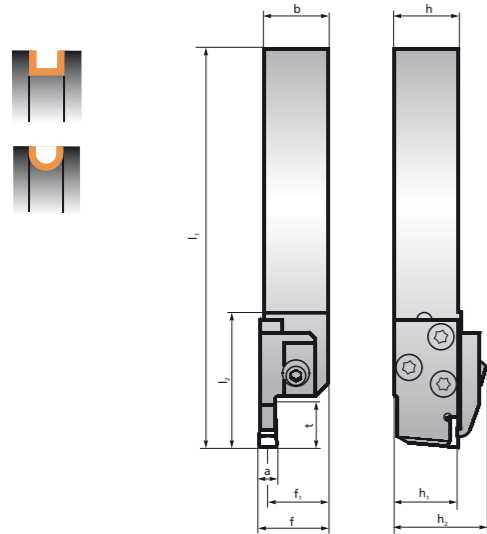


STECHBREITE GROOVING WIDTH 5 MM
STECHTIEFE GROOVING DEPTH 24 MM

SCHAFTAUSFÜHRUNG SHANK VERSION
2525

SCHAFTAUSFÜHRUNG SHANK VERSION
3225

STECHBREITE GROOVING WIDTH 5 MM
STECHTIEFE GROOVING DEPTH 24 MM

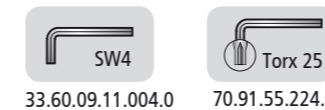
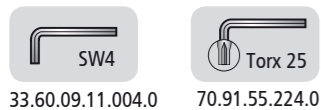


Schaft Shank	Abmessungen Dimensions (mm)									
	h=h ₁	b	l ₁	l ₂	t	a	f ₁	f	h ₂	
2525	25	25	162	47	24	5	23,5	$f_1 + \frac{a}{2}$	36	
3225	32	25	182	47	24	5	23,5	$f_1 + \frac{a}{2}$	43	

Spanwinkel Rake angle γ	0°
Neigungswinkel Back rake angle λ	0°

Stechbreite a Stechtiefe t Grooving width a Grooving depth t	Typ Type	Best.-Nr. Ref. no.	Stechschwert Grooving blade		Spannelement Clamping element	
			2525	Typ Type	Best.-Nr. Ref. no.	Typ Type
Links Left a = 5 mm t = 24 mm	RAG-2525-B5T24H5-LG	719.78.010.13	RAG-ST-B5T24H5-LG	70.91.22.560.0	RAG-SP-B5T24-L	70.91.11.920.0
	RAG-2525-B5T24H5-LR100	719.78.010.14	RAG-ST-B5T24H5-LR100	70.91.22.561.0	RAG-SP-B5T24-L	70.91.11.920.0
	RAG-2525-B5T24H5-LL100	719.78.010.15	RAG-ST-B5T24H5-LL100	70.91.22.562.0	RAG-SP-B5T24-L	70.91.11.920.0
Rechts Right a = 5 mm t = 24 mm	RAG-2525-B5T24H5-RG	719.77.010.13	RAG-ST-B5T24H5-RG	70.91.22.512.0	RAG-SP-B5T24-R	70.91.11.904.0
	RAG-2525-B5T24H5-RL100	719.77.010.14	RAG-ST-B5T24H5-RL100	70.91.22.513.0	RAG-SP-B5T24-R	70.91.11.904.0
	RAG-2525-B5T24H5-RR100	719.77.010.15	RAG-ST-B5T24H5-RR100	70.91.22.514.0	RAG-SP-B5T24-R	70.91.11.904.0

Stechbreite a Stechtiefe t Grooving width a Grooving depth t	Typ Type	Best.-Nr. Ref. no.	Stechschwert Grooving blade		Spannelement Clamping element	
			3225	Typ Type	Best.-Nr. Ref. no.	Typ Type
Links Left a = 5 mm t = 24 mm	RAG-3225-B5T24H5-LG	719.78.011.13	RAG-ST-B5T24H5-LG	70.91.22.560.0	RAG-SP-B5T24-L	70.91.11.920.0
	RAG-3225-B5T24H5-LR100	719.78.011.14	RAG-ST-B5T24H5-LR100	70.91.22.561.0	RAG-SP-B5T24-L	70.91.11.920.0
	RAG-3225-B5T24H5-LL100	719.78.011.15	RAG-ST-B5T24H5-LL100	70.91.22.562.0	RAG-SP-B5T24-L	70.91.11.920.0
Rechts Right a = 5 mm t = 24 mm	RAG-3225-B5T24H5-RG	719.77.011.13	RAG-ST-B5T24H5-RG	70.91.22.512.0	RAG-SP-B5T24-R	70.91.11.904.0
	RAG-3225-B5T24H5-RL100	719.77.011.14	RAG-ST-B5T24H5-RL100	70.91.22.513.0	RAG-SP-B5T24-R	70.91.11.904.0
	RAG-3225-B5T24H5-RR100	719.77.011.15	RAG-ST-B5T24H5-RR100	70.91.22.514.0	RAG-SP-B5T24-R	70.91.11.904.0

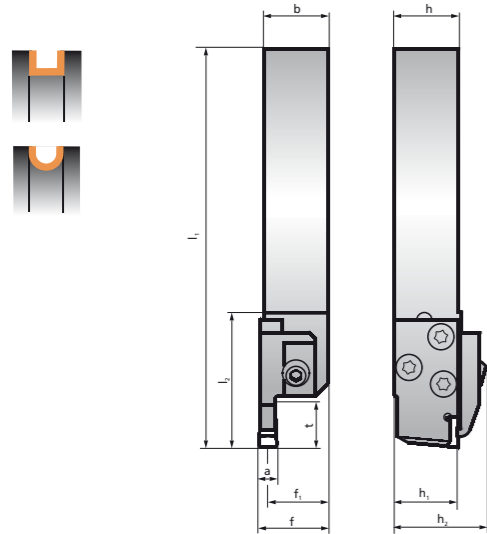


STECHBREITE GROOVING WIDTH 6 MM
STECHTIEFE GROOVING DEPTH 12 MM

SCHAFTAUSFÜHRUNG SHANK VERSION
2525

SCHAFTAUSFÜHRUNG SHANK VERSION
3225

STECHBREITE GROOVING WIDTH 6 MM
STECHTIEFE GROOVING DEPTH 12 MM

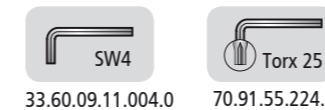
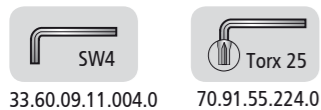


Schaft Shank	Abmessungen Dimensions (mm)									
	h=h ₁	b	l ₁	l ₂	t	a	f ₁	f	f ₁ + $\frac{a}{2}$	h ₂
2525	25	25	150	47	12	6	23,5	f ₁ + $\frac{a}{2}$		36
3225	32	25	170	47	12	6	23,5	f ₁ + $\frac{a}{2}$		43

Spanwinkel Rake angle γ	0°
Neigungswinkel Back rake angle λ	0°

Stechbreite a Stechtiefe t Grooving width a Grooving depth t	Typ Type	Best.-Nr. Ref. no.	Stechschwert Grooving blade		Spannelement Clamping element	
			2525	Typ Type	Best.-Nr. Ref. no.	Typ Type
Links Left a = 6 mm t = 12 mm	RAG-2525-B6T12H5-LG	719.78.010.16	RAG-ST-B6T12H5-LG	70.91.22.563.0	RAG-SP-B6T12-L	70.91.11.921.0
	RAG-2525-B6T12H5-LR100	719.78.010.17	RAG-ST-B6T12H5-LR100	70.91.22.564.0	RAG-SP-B6T12-L	70.91.11.921.0
	RAG-2525-B6T12H5-LL100	719.78.010.18	RAG-ST-B6T12H5-LL100	70.91.22.565.0	RAG-SP-B6T12-L	70.91.11.921.0
Rechts Right a = 6 mm t = 12 mm	RAG-2525-B6T12H5-RG	719.77.010.16	RAG-ST-B6T12H5-RG	70.91.22.515.0	RAG-SP-B6T12-R	70.91.11.905.0
	RAG-2525-B6T12H5-RL100	719.77.010.17	RAG-ST-B6T12H5-RL100	70.91.22.516.0	RAG-SP-B6T12-R	70.91.11.905.0
	RAG-2525-B6T12H5-RR100	719.77.010.18	RAG-ST-B6T12H5-RR100	70.91.22.517.0	RAG-SP-B6T12-R	70.91.11.905.0

Stechbreite a Stechtiefe t Grooving width a Grooving depth t	Typ Type	Best.-Nr. Ref. no.	Stechschwert Grooving blade		Spannelement Clamping element	
			3225	Typ Type	Best.-Nr. Ref. no.	Typ Type
Links Left a = 6 mm t = 12 mm	RAG-3225-B6T12H5-LG	719.78.011.16	RAG-ST-B6T12H5-LG	70.91.22.563.0	RAG-SP-B6T12-L	70.91.11.921.0
	RAG-3225-B6T12H5-LR100	719.78.011.17	RAG-ST-B6T12H5-LR100	70.91.22.564.0	RAG-SP-B6T12-L	70.91.11.921.0
	RAG-3225-B6T12H5-LL100	719.78.011.18	RAG-ST-B6T12H5-LL100	70.91.22.565.0	RAG-SP-B6T12-L	70.91.11.921.0
Rechts Right a = 6 mm t = 12 mm	RAG-3225-B6T12H5-RG	719.77.011.16	RAG-ST-B6T12H5-RG	70.91.22.515.0	RAG-SP-B6T12-R	70.91.11.905.0
	RAG-3225-B6T12H5-RL100	719.77.011.17	RAG-ST-B6T12H5-RL100	70.91.22.516.0	RAG-SP-B6T12-R	70.91.11.905.0
	RAG-3225-B6T12H5-RR100	719.77.011.18	RAG-ST-B6T12H5-RR100	70.91.22.517.0	RAG-SP-B6T12-R	70.91.11.905.0

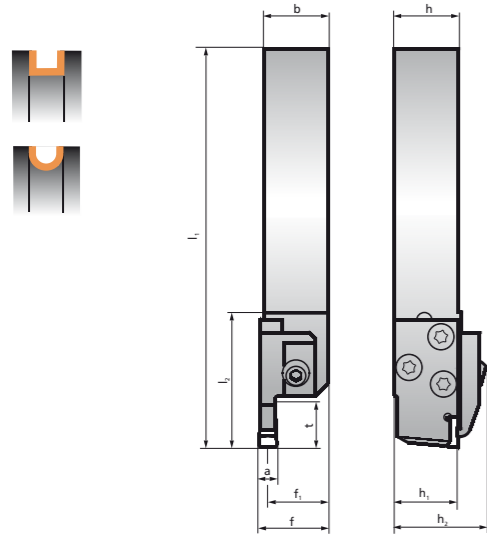


STECHBREITE GROOVING WIDTH 6 MM
STECHTIEFE GROOVING DEPTH 18 MM

SCHAFTAUSFÜHRUNG SHANK VERSION
2525

SCHAFTAUSFÜHRUNG SHANK VERSION
3225

STECHBREITE GROOVING WIDTH 6 MM
STECHTIEFE GROOVING DEPTH 18 MM

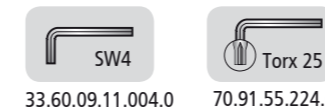
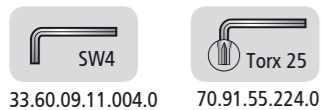


Schaft Shank	Abmessungen Dimensions (mm)									
	h=h ₁	b	l ₁	l ₂	t	a	f ₁	f	h ₂	
2525	25	25	156	47	18	6	23,5	f ₁ + $\frac{a}{2}$	36	
3225	32	25	176	47	18	6	23,5	f ₁ + $\frac{a}{2}$	43	

Spanwinkel Rake angle γ	0°
Neigungswinkel Back rake angle λ	0°

Stechbreite a Stechtiefe t Grooving width a Grooving depth t	Typ Type	Best.-Nr. Ref. no.	Stechschwert Grooving blade		Spannelement Clamping element	
			2525	Typ Type	Best.-Nr. Ref. no.	Typ Type
Links Left a = 6 mm t = 18 mm	RAG-2525-B6T18H5-LG	719.78.010.19	RAG-ST-B6T18H5-LG	70.91.22.566.0	RAG-SP-B6T18-L	70.91.11.922.0
	RAG-2525-B6T18H5-LR100	719.78.010.20	RAG-ST-B6T18H5-LR100	70.91.22.567.0	RAG-SP-B6T18-L	70.91.11.922.0
	RAG-2525-B6T18H5-LL100	719.78.010.21	RAG-ST-B6T18H5-LL100	70.91.22.568.0	RAG-SP-B6T18-L	70.91.11.922.0
Rechts Right a = 6 mm t = 18 mm	RAG-2525-B6T18H5-RG	719.77.010.19	RAG-ST-B6T18H5-RG	70.91.22.518.0	RAG-SP-B6T18-R	70.91.11.906.0
	RAG-2525-B6T18H5-RL100	719.77.010.20	RAG-ST-B6T18H5-RL100	70.91.22.519.0	RAG-SP-B6T18-R	70.91.11.906.0
	RAG-2525-B6T18H5-RR100	719.77.010.21	RAG-ST-B6T18H5-RR100	70.91.22.520.0	RAG-SP-B6T18-R	70.91.11.906.0

Stechbreite a Stechtiefe t Grooving width a Grooving depth t	Typ Type	Best.-Nr. Ref. no.	Stechschwert Grooving blade		Spannelement Clamping element	
			3225	Typ Type	Best.-Nr. Ref. no.	Typ Type
Links Left a = 6 mm t = 18 mm	RAG-3225-B6T18H5-LG	719.78.011.19	RAG-ST-B6T18H5-LG	70.91.22.566.0	RAG-SP-B6T18-L	70.91.11.922.0
	RAG-3225-B6T18H5-LR100	719.78.011.20	RAG-ST-B6T18H5-LR100	70.91.22.567.0	RAG-SP-B6T18-L	70.91.11.922.0
	RAG-3225-B6T18H5-LL100	719.78.011.21	RAG-ST-B6T18H5-LL100	70.91.22.568.0	RAG-SP-B6T18-L	70.91.11.922.0
Rechts Right a = 6 mm t = 18 mm	RAG-3225-B6T18H5-RG	719.77.011.19	RAG-ST-B6T18H5-RG	70.91.22.518.0	RAG-SP-B6T18-R	70.91.11.906.0
	RAG-3225-B6T18H5-RL100	719.77.011.20	RAG-ST-B6T18H5-RL100	70.91.22.519.0	RAG-SP-B6T18-R	70.91.11.906.0
	RAG-3225-B6T18H5-RR100	719.77.011.21	RAG-ST-B6T18H5-RR100	70.91.22.520.0	RAG-SP-B6T18-R	70.91.11.906.0

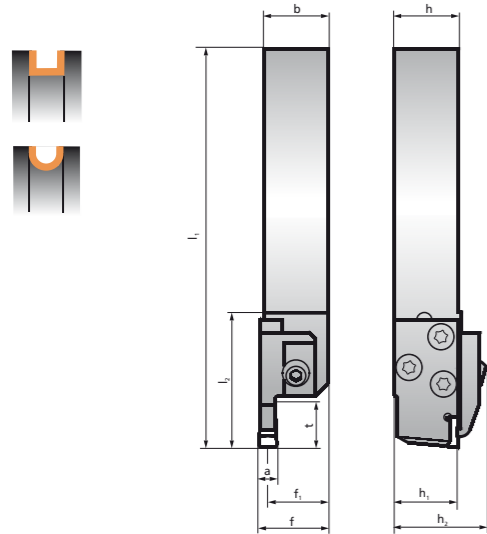


STECHBREITE GROOVING WIDTH 6 MM
STECHTIEFE GROOVING DEPTH 24 MM

SCHAFTAUSFÜHRUNG SHANK VERSION
2525

SCHAFTAUSFÜHRUNG SHANK VERSION
3225

STECHBREITE GROOVING WIDTH 6 MM
STECHTIEFE GROOVING DEPTH 24 MM

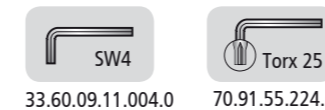
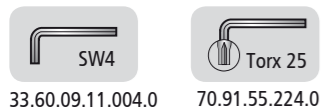


Schaft Shank	Abmessungen Dimensions (mm)									
	h=h ₁	b	l ₁	l ₂	t	a	f ₁	f	h ₂	
2525	25	25	162	47	24	6	23,5	$f_1 + \frac{a}{2}$	36	
3225	32	25	182	47	24	6	23,5	$f_1 + \frac{a}{2}$	43	

Spanwinkel Rake angle γ	0°
Neigungswinkel Back rake angle λ	0°

Stechbreite a Stechtiefe t Grooving width a Grooving depth t	Typ Type	Best.-Nr. Ref. no.	Stechschwert Grooving blade		Spannelement Clamping element	
		2525	Typ Type	Best.-Nr. Ref. no.	Typ Type	Best.-Nr. Ref. no.
Links Left a = 6 mm t = 24 mm	RAG-2525-B6T24H5-LG	719.78.010.22	RAG-ST-B6T24H5-LG	70.91.22.569.0	RAG-SP-B6T24-L	70.91.11.923.0
	RAG-2525-B6T24H5-LR100	719.78.010.23	RAG-ST-B6T24H5-LR100	70.91.22.570.0	RAG-SP-B6T24-L	70.91.11.923.0
	RAG-2525-B6T24H5-LL100	719.78.010.24	RAG-ST-B6T24H5-LL100	70.91.22.571.0	RAG-SP-B6T24-L	70.91.11.923.0
Rechts Right a = 6 mm t = 24 mm	RAG-2525-B6T24H5-RG	719.77.010.22	RAG-ST-B6T24H5-RG	70.91.22.521.0	RAG-SP-B6T24-R	70.91.11.907.0
	RAG-2525-B6T24H5-RL100	719.77.010.23	RAG-ST-B6T24H5-RL100	70.91.22.522.0	RAG-SP-B6T24-R	70.91.11.907.0
	RAG-2525-B6T24H5-RR100	719.77.010.24	RAG-ST-B6T24H5-RR100	70.91.22.523.0	RAG-SP-B6T24-R	70.91.11.907.0

Stechbreite a Stechtiefe t Grooving width a Grooving depth t	Typ Type	Best.-Nr. Ref. no.	Stechschwert Grooving blade		Spannelement Clamping element	
		3225	Typ Type	Best.-Nr. Ref. no.	Typ Type	Best.-Nr. Ref. no.
Links Left a = 6 mm t = 24 mm	RAG-3225-B6T24H5-LG	719.78.011.22	RAG-ST-B6T24H5-LG	70.91.22.569.0	RAG-SP-B6T24-L	70.91.11.923.0
	RAG-3225-B6T24H5-LR100	719.78.011.23	RAG-ST-B6T24H5-LR100	70.91.22.570.0	RAG-SP-B6T24-L	70.91.11.923.0
	RAG-3225-B6T24H5-LL100	719.78.011.24	RAG-ST-B6T24H5-LL100	70.91.22.571.0	RAG-SP-B6T24-L	70.91.11.923.0
Rechts Right a = 6 mm t = 24 mm	RAG-3225-B6T24H5-RG	719.77.011.22	RAG-ST-B6T24H5-RG	70.91.22.521.0	RAG-SP-B6T24-R	70.91.11.907.0
	RAG-3225-B6T24H5-RL100	719.77.011.23	RAG-ST-B6T24H5-RL100	70.91.22.522.0	RAG-SP-B6T24-R	70.91.11.907.0
	RAG-3225-B6T24H5-RR100	719.77.011.24	RAG-ST-B6T24H5-RR100	70.91.22.523.0	RAG-SP-B6T24-R	70.91.11.907.0

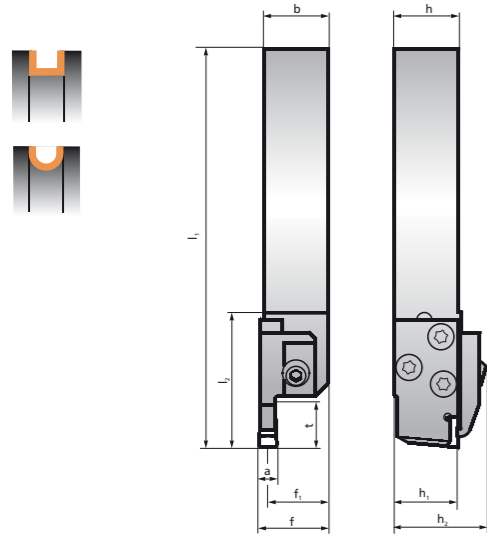


STECHBREITE GROOVING WIDTH 6 MM
STECHTIEFE GROOVING DEPTH 30 MM

SCHAFTAUSFÜHRUNG SHANK VERSION
2525

SCHAFTAUSFÜHRUNG SHANK VERSION
3225

STECHBREITE GROOVING WIDTH 6 MM
STECHTIEFE GROOVING DEPTH 30 MM

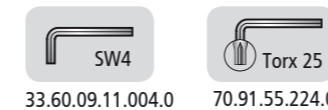
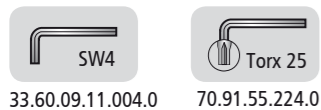


Schaft Shank	Abmessungen Dimensions (mm)									
	h=h ₁	b	l ₁	l ₂	t	a	f ₁	f	h ₂	
2525	25	25	168	47	30	6	23,5	f ₁ + $\frac{a}{2}$	36	
3225	32	25	188	47	30	6	23,5	f ₁ + $\frac{a}{2}$	43	

Spanwinkel Rake angle γ	0°
Neigungswinkel Back rake angle λ	0°

Stechbreite a Stechtiefe t Grooving width a Grooving depth t	Typ Type	Best.-Nr. Ref. no.	Stechschwert Grooving blade		Spannelement Clamping element	
			2525	Typ Type	Best.-Nr. Ref. no.	Typ Type
Links Left a = 6 mm t = 30 mm	RAG-2525-B6T30H5-LG	719.78.010.25	RAG-ST-B6T30H5-LG	70.91.22.572.0	RAG-SP-B6T30-L	70.91.11.924.0
	RAG-2525-B6T30H5-LR100	719.78.010.26	RAG-ST-B6T30H5-LR100	70.91.22.573.0	RAG-SP-B6T30-L	70.91.11.924.0
	RAG-2525-B6T30H5-LL100	719.78.010.27	RAG-ST-B6T30H5-LL100	70.91.22.574.0	RAG-SP-B6T30-L	70.91.11.924.0
Rechts Right a = 6 mm t = 30 mm	RAG-2525-B6T30H5-RG	719.77.010.25	RAG-ST-B6T30H5-RG	70.91.22.524.0	RAG-SP-B6T30-R	70.91.11.908.0
	RAG-2525-B6T30H5-RL100	719.77.010.26	RAG-ST-B6T30H5-RL100	70.91.22.525.0	RAG-SP-B6T30-R	70.91.11.908.0
	RAG-2525-B6T30H5-RR100	719.77.010.27	RAG-ST-B6T30H5-RR100	70.91.22.526.0	RAG-SP-B6T30-R	70.91.11.908.0

Stechbreite a Stechtiefe t Grooving width a Grooving depth t	Typ Type	Best.-Nr. Ref. no.	Stechschwert Grooving blade		Spannelement Clamping element	
			3225	Typ Type	Best.-Nr. Ref. no.	Typ Type
Links Left a = 6 mm t = 30 mm	RAG-3225-B6T30H5-LG	719.78.011.25	RAG-ST-B6T30H5-LG	70.91.22.572.0	RAG-SP-B6T30-L	70.91.11.924.0
	RAG-3225-B6T30H5-LR100	719.78.011.26	RAG-ST-B6T30H5-LR100	70.91.22.573.0	RAG-SP-B6T30-L	70.91.11.924.0
	RAG-3225-B6T30H5-LL100	719.78.011.27	RAG-ST-B6T30H5-LL100	70.91.22.574.0	RAG-SP-B6T30-L	70.91.11.924.0
Rechts Right a = 6 mm t = 30 mm	RAG-3225-B6T30H5-RG	719.77.011.25	RAG-ST-B6T30H5-RG	70.91.22.524.0	RAG-SP-B6T30-R	70.91.11.908.0
	RAG-3225-B6T30H5-RL100	719.77.011.26	RAG-ST-B6T30H5-RL100	70.91.22.525.0	RAG-SP-B6T30-R	70.91.11.908.0
	RAG-3225-B6T30H5-RR100	719.77.011.27	RAG-ST-B6T30H5-RR100	70.91.22.526.0	RAG-SP-B6T30-R	70.91.11.908.0

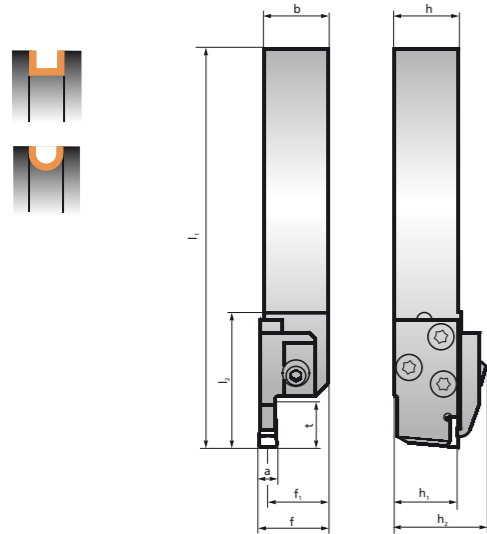


STECHBREITE GROOVING WIDTH 7 MM
STECHTIEFE GROOVING DEPTH 12 MM

SCHAFTAUSFÜHRUNG SHANK VERSION
2525

SCHAFTAUSFÜHRUNG SHANK VERSION
3225

STECHBREITE GROOVING WIDTH 7 MM
STECHTIEFE GROOVING DEPTH 12 MM

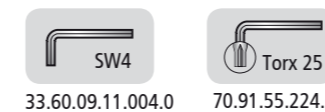
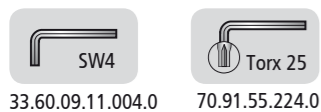


Schaft Shank	Abmessungen Dimensions (mm)									
	h=h ₁	b	l ₁	l ₂	t	a	f ₁	f	h ₂	
2525	25	25	150	47	12	7	23,5	$f_1 + \frac{a}{2}$	36	
3225	32	25	170	47	12	7	23,5	$f_1 + \frac{a}{2}$	43	

Spanwinkel Rake angle γ	0°
Neigungswinkel Back rake angle λ	0°

Stechbreite a Stechtiefe t Grooving width a Grooving depth t	Typ Type	Best.-Nr. Ref. no.	Stechschwert Grooving blade		Spannelement Clamping element	
			2525	Typ Type	Best.-Nr. Ref. no.	Typ Type
Links Left a = 7 mm t = 12 mm	RAG-2525-B7T12H5-LG	719.78.010.28	RAG-ST-B7T12H5-LG	70.91.22.575.0	RAG-SP-B7T12-L	70.91.11.925.0
	RAG-2525-B7T12H5-LR100	719.78.010.29	RAG-ST-B7T12H5-LR100	70.91.22.576.0	RAG-SP-B7T12-L	70.91.11.925.0
	RAG-2525-B7T12H5-LL100	719.78.010.30	RAG-ST-B7T12H5-LL100	70.91.22.577.0	RAG-SP-B7T12-L	70.91.11.925.0
Rechts Right a = 7 mm t = 12 mm	RAG-2525-B7T12H5-RG	719.77.010.28	RAG-ST-B7T12H5-RG	70.91.22.527.0	RAG-SP-B7T12-R	70.91.11.909.0
	RAG-2525-B7T12H5-RL100	719.77.010.29	RAG-ST-B7T12H5-RL100	70.91.22.528.0	RAG-SP-B7T12-R	70.91.11.909.0
	RAG-2525-B7T12H5-RR100	719.77.010.30	RAG-ST-B7T12H5-RR100	70.91.22.529.0	RAG-SP-B7T12-R	70.91.11.909.0

Stechbreite a Stechtiefe t Grooving width a Grooving depth t	Typ Type	Best.-Nr. Ref. no.	Stechschwert Grooving blade		Spannelement Clamping element	
			3225	Typ Type	Best.-Nr. Ref. no.	Typ Type
Links Left a = 7 mm t = 12 mm	RAG-3225-B7T12H5-LG	719.78.011.28	RAG-ST-B7T12H5-LG	70.91.22.575.0	RAG-SP-B7T12-L	70.91.11.925.0
	RAG-3225-B7T12H5-LR100	719.78.011.29	RAG-ST-B7T12H5-LR100	70.91.22.576.0	RAG-SP-B7T12-L	70.91.11.925.0
	RAG-3225-B7T12H5-LL100	719.78.011.30	RAG-ST-B7T12H5-LL100	70.91.22.577.0	RAG-SP-B7T12-L	70.91.11.925.0
Rechts Right a = 7 mm t = 12 mm	RAG-3225-B7T12H5-RG	719.77.011.28	RAG-ST-B7T12H5-RG	70.91.22.527.0	RAG-SP-B7T12-R	70.91.11.909.0
	RAG-3225-B7T12H5-RL100	719.77.011.29	RAG-ST-B7T12H5-RL100	70.91.22.528.0	RAG-SP-B7T12-R	70.91.11.909.0
	RAG-3225-B7T12H5-RR100	719.77.011.30	RAG-ST-B7T12H5-RR100	70.91.22.529.0	RAG-SP-B7T12-R	70.91.11.909.0

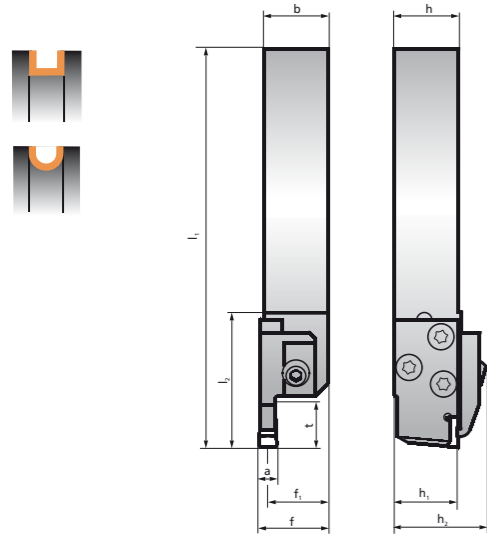


STECHBREITE GROOVING WIDTH 7 MM
STECHTIEFE GROOVING DEPTH 18 MM

SCHAFTAUSFÜHRUNG SHANK VERSION
2525

SCHAFTAUSFÜHRUNG SHANK VERSION
3225

STECHBREITE GROOVING WIDTH 7 MM
STECHTIEFE GROOVING DEPTH 18 MM

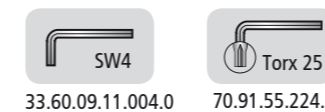
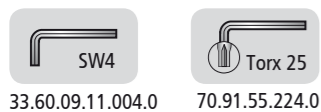


Schaft Shank	Abmessungen Dimensions (mm)									
	h=h ₁	b	l ₁	l ₂	t	a	f ₁	f	f ₁ + $\frac{a}{2}$	h ₂
2525	25	25	156	47	18	7	23,5	f ₁ + $\frac{a}{2}$	36	
3225	32	25	176	47	18	7	23,5	f ₁ + $\frac{a}{2}$	43	

Spanwinkel Rake angle γ	0°
Neigungswinkel Back rake angle λ	0°

Stechbreite a Stechtiefe t Grooving width a Grooving depth t	Typ Type	Best.-Nr. Ref. no.	Stechschwert Grooving blade		Spannelement Clamping element	
			2525	Typ Type	Best.-Nr. Ref. no.	Typ Type
Links Left a = 7 mm t = 18 mm	RAG-2525-B7T18H5-LG	719.78.010.31	RAG-ST-B7T18H5-LG	70.91.22.578.0	RAG-SP-B7T18-L	70.91.11.926.0
	RAG-2525-B7T18H5-LR100	719.78.010.32	RAG-ST-B7T18H5-LR100	70.91.22.579.0	RAG-SP-B7T18-L	70.91.11.926.0
	RAG-2525-B7T18H5-LL100	719.78.010.33	RAG-ST-B7T18H5-LL100	70.91.22.580.0	RAG-SP-B7T18-L	70.91.11.926.0
Rechts Right a = 7 mm t = 18 mm	RAG-2525-B7T18H5-RG	719.77.010.31	RAG-ST-B7T18H5-RG	70.91.22.530.0	RAG-SP-B7T18-R	70.91.11.910.0
	RAG-2525-B7T18H5-RL100	719.77.010.32	RAG-ST-B7T18H5-RL100	70.91.22.531.0	RAG-SP-B7T18-R	70.91.11.910.0
	RAG-2525-B7T18H5-RR100	719.77.010.33	RAG-ST-B7T18H5-RR100	70.91.22.532.0	RAG-SP-B7T18-R	70.91.11.910.0

Stechbreite a Stechtiefe t Grooving width a Grooving depth t	Typ Type	Best.-Nr. Ref. no.	Stechschwert Grooving blade		Spannelement Clamping element	
			3225	Typ Type	Best.-Nr. Ref. no.	Typ Type
Links Left a = 7 mm t = 18 mm	RAG-3225-B7T18H5-LG	719.78.011.31	RAG-ST-B7T18H5-LG	70.91.22.578.0	RAG-SP-B7T18-L	70.91.11.926.0
	RAG-3225-B7T18H5-LR100	719.78.011.32	RAG-ST-B7T18H5-LR100	70.91.22.579.0	RAG-SP-B7T18-L	70.91.11.926.0
	RAG-3225-B7T18H5-LL100	719.78.011.33	RAG-ST-B7T18H5-LL100	70.91.22.580.0	RAG-SP-B7T18-L	70.91.11.926.0
Rechts Right a = 7 mm t = 18 mm	RAG-3225-B7T18H5-RG	719.77.011.31	RAG-ST-B7T18H5-RG	70.91.22.530.0	RAG-SP-B7T18-R	70.91.11.910.0
	RAG-3225-B7T18H5-RL100	719.77.011.32	RAG-ST-B7T18H5-RL100	70.91.22.531.0	RAG-SP-B7T18-R	70.91.11.910.0
	RAG-3225-B7T18H5-RR100	719.77.011.33	RAG-ST-B7T18H5-RR100	70.91.22.532.0	RAG-SP-B7T18-R	70.91.11.910.0

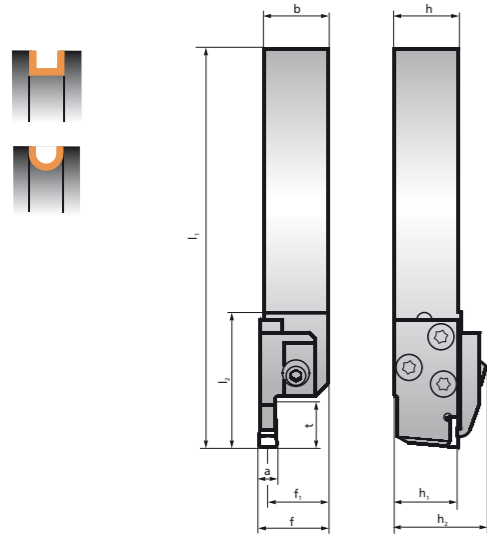


STECHBREITE GROOVING WIDTH 7 MM
STECHTIEFE GROOVING DEPTH 24 MM

SCHAFTAUSFÜHRUNG SHANK VERSION
2525







SCHAFTAUSFÜHRUNG SHANK VERSION
3225







STECHBREITE GROOVING WIDTH 7 MM
STECHTIEFE GROOVING DEPTH 24 MM

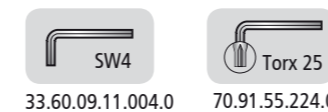
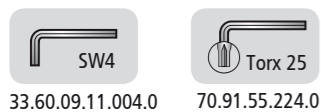


Schaft Shank	Abmessungen Dimensions (mm)									
	h=h ₁	b	l ₁	l ₂	t	a	f ₁	f	h ₂	
2525	25	25	162	47	24	7	23,5	$f_1 + \frac{a}{2}$	36	
3225	32	25	182	47	24	7	23,5	$f_1 + \frac{a}{2}$	43	

Spanwinkel Rake angle γ	0°
Neigungswinkel Back rake angle λ	0°

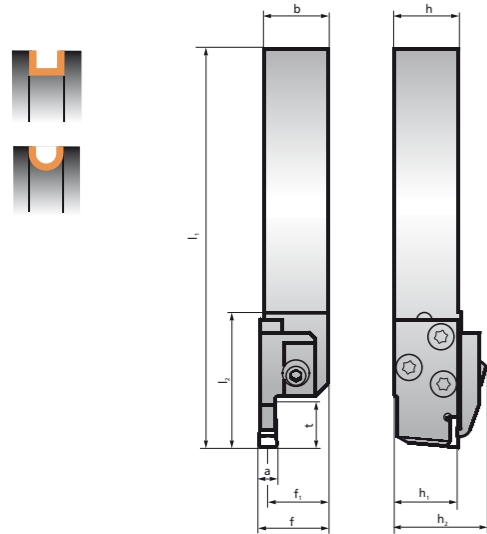
Stechbreite a Stechtiefe t Grooving width a Grooving depth t	Typ Type	Best.-Nr. Ref. no.	Stechschwert Grooving blade		Spannelement Clamping element	
			2525	Typ Type	Best.-Nr. Ref. no.	Typ Type
Links Left a = 7 mm t = 24 mm	 RAG-2525-B7T24H5-LG	719.78.010.34	RAG-ST-B7T24H5-LG	70.91.22.581.0	RAG-SP-B7T24-L	70.91.11.927.0
	 RAG-2525-B7T24H5-LR100	719.78.010.35	RAG-ST-B7T24H5-LR100	70.91.22.582.0	RAG-SP-B7T24-L	70.91.11.927.0
	 RAG-2525-B7T24H5-LL100	719.78.010.36	RAG-ST-B7T24H5-LL100	70.91.22.583.0	RAG-SP-B7T24-L	70.91.11.927.0
Rechts Right a = 7 mm t = 24 mm	 RAG-2525-B7T24H5-RG	719.77.010.34	RAG-ST-B7T24H5-RG	70.91.22.533.0	RAG-SP-B7T24-R	70.91.11.911.0
	 RAG-2525-B7T24H5-RL100	719.77.010.35	RAG-ST-B7T24H5-RL100	70.91.22.534.0	RAG-SP-B7T24-R	70.91.11.911.0
	 RAG-2525-B7T24H5-RR100	719.77.010.36	RAG-ST-B7T24H5-RR100	70.91.22.535.0	RAG-SP-B7T24-R	70.91.11.911.0

Stechbreite a Stechtiefe t Grooving width a Grooving depth t	Typ Type	Best.-Nr. Ref. no.	Stechschwert Grooving blade		Spannelement Clamping element	
			3225	Typ Type	Best.-Nr. Ref. no.	Typ Type
Links Left a = 7 mm t = 24 mm	 RAG-3225-B7T24H5-LG	719.78.011.34	RAG-ST-B7T24H5-LG	70.91.22.581.0	RAG-SP-B7T24-L	70.91.11.927.0
	 RAG-3225-B7T24H5-LR100	719.78.011.35	RAG-ST-B7T24H5-LR100	70.91.22.582.0	RAG-SP-B7T24-L	70.91.11.927.0
	 RAG-3225-B7T24H5-LL100	719.78.011.36	RAG-ST-B7T24H5-LL100	70.91.22.583.0	RAG-SP-B7T24-L	70.91.11.927.0
Rechts Right a = 7 mm t = 24 mm	 RAG-3225-B7T24H5-RG	719.77.011.34	RAG-ST-B7T24H5-RG	70.91.22.533.0	RAG-SP-B7T24-R	70.91.11.911.0
	 RAG-3225-B7T24H5-RL100	719.77.011.35	RAG-ST-B7T24H5-RL100	70.91.22.534.0	RAG-SP-B7T24-R	70.91.11.911.0
	 RAG-3225-B7T24H5-RR100	719.77.011.36	RAG-ST-B7T24H5-RR100	70.91.22.535.0	RAG-SP-B7T24-R	70.91.11.911.0



STECHBREITE GROOVING WIDTH 7 MM
STECHTIEFE GROOVING DEPTH 30 MM

SCHAFTAUSFÜHRUNG SHANK VERSION
2525



Schaft Shank	Abmessungen Dimensions (mm)									
	h=h ₁	b	l ₁	l ₂	t	a	f ₁	f	f ₁ + $\frac{a}{2}$	h ₂
2525	25	25	168	47	30	7	23,5	f ₁ + $\frac{a}{2}$		36
3225	32	25	188	47	30	7	23,5	f ₁ + $\frac{a}{2}$		43

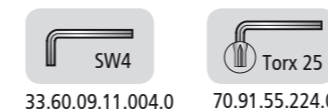
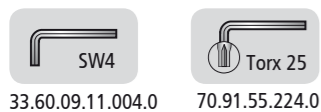
Spanwinkel Rake angle γ	0°
Neigungswinkel Back rake angle λ	0°

Stechbreite a Stechtiefe t Grooving width a Grooving depth t	Typ Type	Best.-Nr. Ref. no.	Stechschwert Grooving blade		Spannelement Clamping element	
			2525 Typ Type	Best.-Nr. Ref. no.	Typ Type	Best.-Nr. Ref. no.
Links Left a = 7 mm t = 30 mm	RAG-2525-B7T30H5-LG	719.78.010.37	RAG-ST-B7T30H5-LG	70.91.22.584.0	RAG-SP-B7T30-L	70.91.11.928.0
	RAG-2525-B7T30H5-LR100	719.78.010.38	RAG-ST-B7T30H5-LR100	70.91.22.585.0	RAG-SP-B7T30-L	70.91.11.928.0
	RAG-2525-B7T30H5-LL100	719.78.010.39	RAG-ST-B7T30H5-LL100	70.91.22.586.0	RAG-SP-B7T30-L	70.91.11.928.0
Rechts Right a = 7 mm t = 30 mm	RAG-2525-B7T30H5-RG	719.77.010.37	RAG-ST-B7T30H5-RG	70.91.22.536.0	RAG-SP-B7T30-R	70.91.11.912.0
	RAG-2525-B7T30H5-RL100	719.77.010.38	RAG-ST-B7T30H5-RL100	70.91.22.537.0	RAG-SP-B7T30-R	70.91.11.912.0
	RAG-2525-B7T30H5-RR100	719.77.010.39	RAG-ST-B7T30H5-RR100	70.91.22.538.0	RAG-SP-B7T30-R	70.91.11.912.0

SCHAFTAUSFÜHRUNG SHANK VERSION
3225

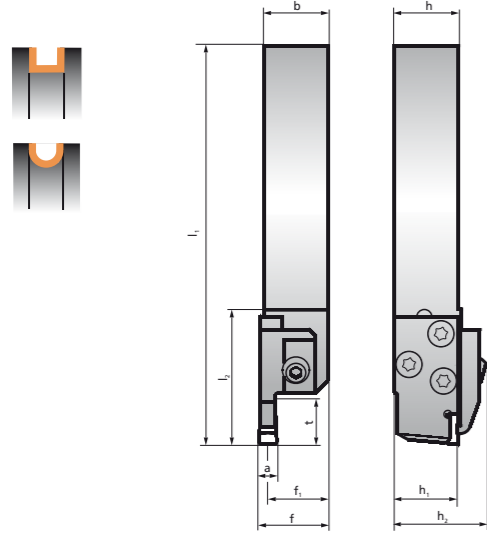
STECHBREITE GROOVING WIDTH 7 MM
STECHTIEFE GROOVING DEPTH 30 MM

Stechbreite a Stechtiefe t Grooving width a Grooving depth t	Typ Type	Best.-Nr. Ref. no.	Stechschwert Grooving blade		Spannelement Clamping element	
			3225 Typ Type	Best.-Nr. Ref. no.	Typ Type	Best.-Nr. Ref. no.
Links Left a = 7 mm t = 30 mm	RAG-3225-B7T30H5-LG	719.78.011.37	RAG-ST-B7T30H5-LG	70.91.22.584.0	RAG-SP-B7T30-L	70.91.11.928.0
	RAG-3225-B7T30H5-LR100	719.78.011.38	RAG-ST-B7T30H5-LR100	70.91.22.585.0	RAG-SP-B7T30-L	70.91.11.928.0
	RAG-3225-B7T30H5-LL100	719.78.011.39	RAG-ST-B7T30H5-LL100	70.91.22.586.0	RAG-SP-B7T30-L	70.91.11.928.0
Rechts Right a = 7 mm t = 30 mm	RAG-3225-B7T30H5-RG	719.77.011.37	RAG-ST-B7T30H5-RG	70.91.22.536.0	RAG-SP-B7T30-R	70.91.11.912.0
	RAG-3225-B7T30H5-RL100	719.77.011.38	RAG-ST-B7T30H5-RL100	70.91.22.537.0	RAG-SP-B7T30-R	70.91.11.912.0
	RAG-3225-B7T30H5-RR100	719.77.011.39	RAG-ST-B7T30H5-RR100	70.91.22.538.0	RAG-SP-B7T30-R	70.91.11.912.0



STECHBREITE GROOVING WIDTH 8 MM
STECHTIEFE GROOVING DEPTH 18 MM

SCHAFTAUSFÜHRUNG SHANK VERSION
2525



Schaft Shank	Abmessungen Dimensions (mm)									
	h=h ₁	b	l ₁	l ₂	t	a	f ₁	f	h ₂	
2525	25	25	156	47	18	8	23,5	f ₁ + $\frac{a}{2}$	36	
3225	32	25	176	47	18	8	23,5	f ₁ + $\frac{a}{2}$	43	

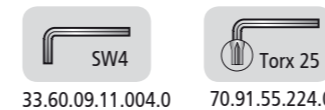
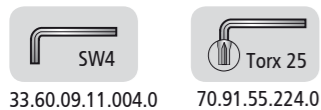
Spanwinkel Rake angle γ	0°
Neigungswinkel Back rake angle λ	0°

Stechbreite a Stechtiefe t Grooving width a Grooving depth t	Typ Type	Best.-Nr. Ref. no.	Stechschwert Grooving blade		Spannelement Clamping element	
			2525	Typ Type	Best.-Nr. Ref. no.	Typ Type
Links Left a = 8 mm t = 18 mm	RAG-2525-B8T18H5-LG	719.78.010.40	RAG-ST-B8T18H5-LG	70.91.22.587.0	RAG-SP-B8T18-L	70.91.11.929.0
	RAG-2525-B8T18H5-LR100	719.78.010.41	RAG-ST-B8T18H5-LR100	70.91.22.588.0	RAG-SP-B8T18-L	70.91.11.929.0
	RAG-2525-B8T18H5-LL100	719.78.010.42	RAG-ST-B8T18H5-LL100	70.91.22.589.0	RAG-SP-B8T18-L	70.91.11.929.0
Rechts Right a = 8 mm t = 18 mm	RAG-2525-B8T18H5-RG	719.77.010.40	RAG-ST-B8T18H5-RG	70.91.22.539.0	RAG-SP-B8T18-R	70.91.11.913.0
	RAG-2525-B8T18H5-RL100	719.77.010.41	RAG-ST-B8T18H5-RL100	70.91.22.540.0	RAG-SP-B8T18-R	70.91.11.913.0
	RAG-2525-B8T18H5-RR100	719.77.010.42	RAG-ST-B8T18H5-RR100	70.91.22.541.0	RAG-SP-B8T18-R	70.91.11.913.0

SCHAFTAUSFÜHRUNG SHANK VERSION
3225

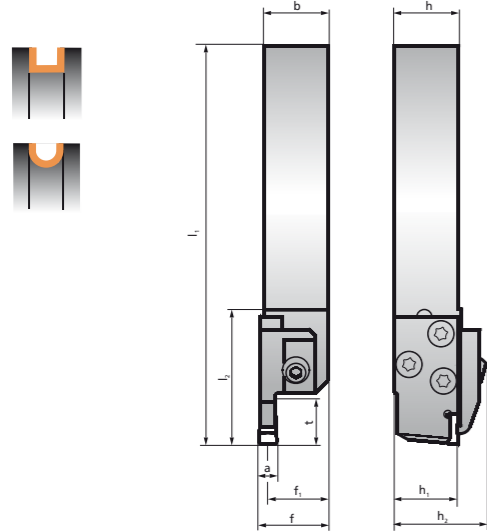
STECHBREITE GROOVING WIDTH 8 MM
STECHTIEFE GROOVING DEPTH 18 MM

Stechbreite a Stechtiefe t Grooving width a Grooving depth t	Typ Type	Best.-Nr. Ref. no.	Stechschwert Grooving blade		Spannelement Clamping element	
			3225	Typ Type	Best.-Nr. Ref. no.	Typ Type
Links Left a = 8 mm t = 18 mm	RAG-3225-B8T18H5-LG	719.78.011.40	RAG-ST-B8T18H5-LG	70.91.22.587.0	RAG-SP-B8T18-L	70.91.11.929.0
	RAG-3225-B8T18H5-LR100	719.78.011.41	RAG-ST-B8T18H5-LR100	70.91.22.588.0	RAG-SP-B8T18-L	70.91.11.929.0
	RAG-3225-B8T18H5-LL100	719.78.011.42	RAG-ST-B8T18H5-LL100	70.91.22.589.0	RAG-SP-B8T18-L	70.91.11.929.0
Rechts Right a = 8 mm t = 18 mm	RAG-3225-B8T18H5-RG	719.77.011.40	RAG-ST-B8T18H5-RG	70.91.22.539.0	RAG-SP-B8T18-R	70.91.11.913.0
	RAG-3225-B8T18H5-RL100	719.77.011.41	RAG-ST-B8T18H5-RL100	70.91.22.540.0	RAG-SP-B8T18-R	70.91.11.913.0
	RAG-3225-B8T18H5-RR100	719.77.011.42	RAG-ST-B8T18H5-RR100	70.91.22.541.0	RAG-SP-B8T18-R	70.91.11.913.0



STECHBREITE GROOVING WIDTH 8 MM
STECHTIEFE GROOVING DEPTH 24 MM

SCHAFTAUSFÜHRUNG SHANK VERSION
2525



Schaft Shank	Abmessungen Dimensions (mm)									
	h=h ₁	b	l ₁	l ₂	t	a	f ₁	f	h ₂	
2525	25	25	162	47	24	8	23,5	f ₁ + $\frac{a}{2}$	36	
3225	32	25	182	47	24	8	23,5	f ₁ + $\frac{a}{2}$	43	

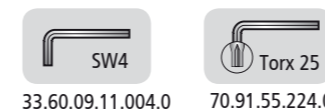
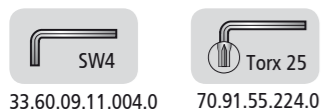
Spanwinkel Rake angle γ	0°
Neigungswinkel Back rake angle λ	0°

Stechbreite a Stechtiefe t Grooving width a Grooving depth t	Typ Type	Best.-Nr. Ref. no.	Stechschwert Grooving blade		Spannelement Clamping element	
			2525	Typ Type	Best.-Nr. Ref. no.	Typ Type
Links Left a = 8 mm t = 24 mm	RAG-2525-B8T24H5-LG	719.78.010.43	RAG-ST-B8T24H5-LG	70.91.22.590.0	RAG-SP-B8T24-L	70.91.11.930.0
	RAG-2525-B8T24H5-LR100	719.78.010.44	RAG-ST-B8T24H5-LR100	70.91.22.591.0	RAG-SP-B8T24-L	70.91.11.930.0
	RAG-2525-B8T24H5-LL100	719.78.010.45	RAG-ST-B8T24H5-LL100	70.91.22.592.0	RAG-SP-B8T24-L	70.91.11.930.0
Rechts Right a = 8 mm t = 24 mm	RAG-2525-B8T24H5-RG	719.77.010.43	RAG-ST-B8T24H5-RG	70.91.22.542.0	RAG-SP-B8T24-R	70.91.11.914.0
	RAG-2525-B8T24H5-RL100	719.77.010.44	RAG-ST-B8T24H5-RL100	70.91.22.543.0	RAG-SP-B8T24-R	70.91.11.914.0
	RAG-2525-B8T24H5-RR100	719.77.010.45	RAG-ST-B8T24H5-RR100	70.91.22.544.0	RAG-SP-B8T24-R	70.91.11.914.0

SCHAFTAUSFÜHRUNG SHANK VERSION
3225

STECHBREITE GROOVING WIDTH 8 MM
STECHTIEFE GROOVING DEPTH 24 MM

Stechbreite a Stechtiefe t Grooving width a Grooving depth t	Typ Type	Best.-Nr. Ref. no.	Stechschwert Grooving blade		Spannelement Clamping element	
			3225	Typ Type	Best.-Nr. Ref. no.	Typ Type
Links Left a = 8 mm t = 24 mm	RAG-3225-B8T24H5-LG	719.78.011.43	RAG-ST-B8T24H5-LG	70.91.22.590.0	RAG-SP-B8T24-L	70.91.11.930.0
	RAG-3225-B8T24H5-LR100	719.78.011.44	RAG-ST-B8T24H5-LR100	70.91.22.591.0	RAG-SP-B8T24-L	70.91.11.930.0
	RAG-3225-B8T24H5-LL100	719.78.011.45	RAG-ST-B8T24H5-LL100	70.91.22.592.0	RAG-SP-B8T24-L	70.91.11.930.0
Rechts Right a = 8 mm t = 24 mm	RAG-3225-B8T24H5-RG	719.77.011.43	RAG-ST-B8T24H5-RG	70.91.22.542.0	RAG-SP-B8T24-R	70.91.11.914.0
	RAG-3225-B8T24H5-RL100	719.77.011.44	RAG-ST-B8T24H5-RL100	70.91.22.543.0	RAG-SP-B8T24-R	70.91.11.914.0
	RAG-3225-B8T24H5-RR100	719.77.011.45	RAG-ST-B8T24H5-RR100	70.91.22.544.0	RAG-SP-B8T24-R	70.91.11.914.0

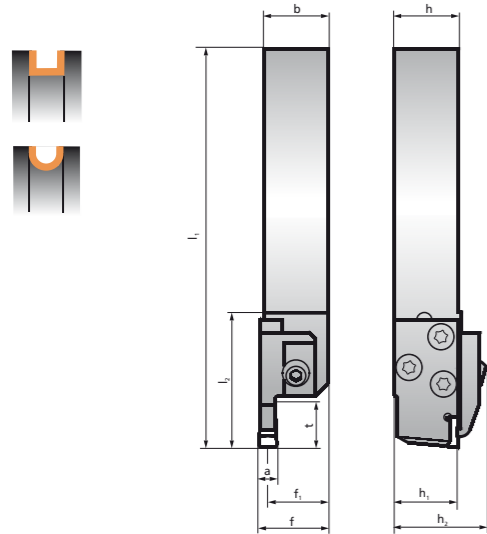


STECHBREITE GROOVING WIDTH 8 MM
STECHTIEFE GROOVING DEPTH 30 MM

SCHAFTAUSFÜHRUNG SHANK VERSION
2525

SCHAFTAUSFÜHRUNG SHANK VERSION
3225

STECHBREITE GROOVING WIDTH 8 MM
STECHTIEFE GROOVING DEPTH 30 MM

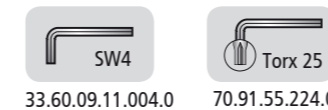
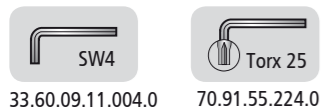


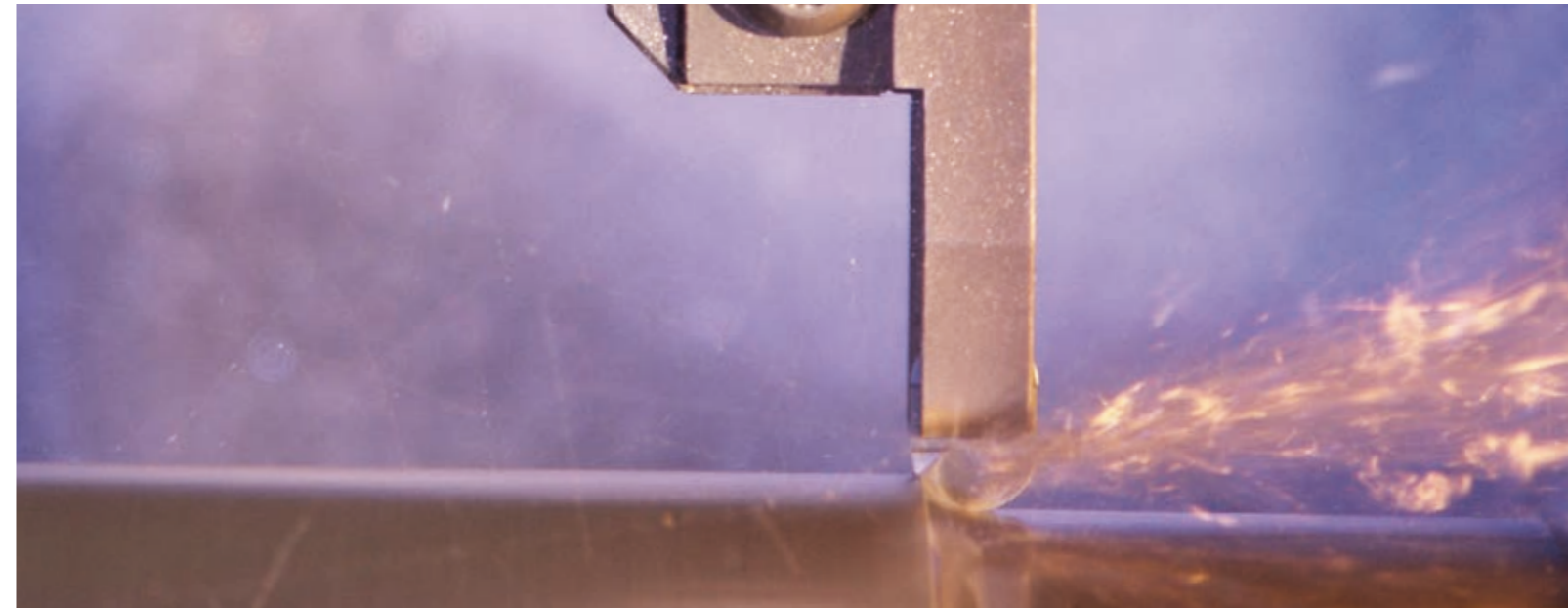
Schaft Shank	Abmessungen Dimensions (mm)									
	h=h ₁	b	l ₁	l ₂	t	a	f ₁	f	h ₂	
2525	25	25	168	47	30	8	23,5	$f_1 + \frac{a}{2}$	36	
3225	32	25	188	47	30	8	23,5	$f_1 + \frac{a}{2}$	43	

Spanwinkel Rake angle γ	0°
Neigungswinkel Back rake angle λ	0°

Stechbreite a Stechtiefe t Grooving width a Grooving depth t	Typ Type	Best.-Nr. Ref. no.	Stechschwert Grooving blade		Spannelement Clamping element	
			2525	Typ Type	Best.-Nr. Ref. no.	Typ Type
Links Left a = 8 mm t = 30 mm	RAG-2525-B8T30H5-LG	719.78.010.46	RAG-ST-B8T30H5-LG	70.91.22.593.0	RAG-SP-B8T30-L	70.91.11.931.0
	RAG-2525-B8T30H5-LR100	719.78.010.47	RAG-ST-B8T30H5-LR100	70.91.22.594.0	RAG-SP-B8T30-L	70.91.11.931.0
	RAG-2525-B8T30H5-LL100	719.78.010.48	RAG-ST-B8T30H5-LL100	70.91.22.595.0	RAG-SP-B8T30-L	70.91.11.931.0
Rechts Right a = 8 mm t = 30 mm	RAG-2525-B8T30H5-RG	719.77.010.46	RAG-ST-B8T30H5-RG	70.91.22.545.0	RAG-SP-B8T30-R	70.91.11.915.0
	RAG-2525-B8T30H5-RL100	719.77.010.47	RAG-ST-B8T30H5-RL100	70.91.22.546.0	RAG-SP-B8T30-R	70.91.11.915.0
	RAG-2525-B8T30H5-RR100	719.77.010.48	RAG-ST-B8T30H5-RR100	70.91.22.547.0	RAG-SP-B8T30-R	70.91.11.915.0

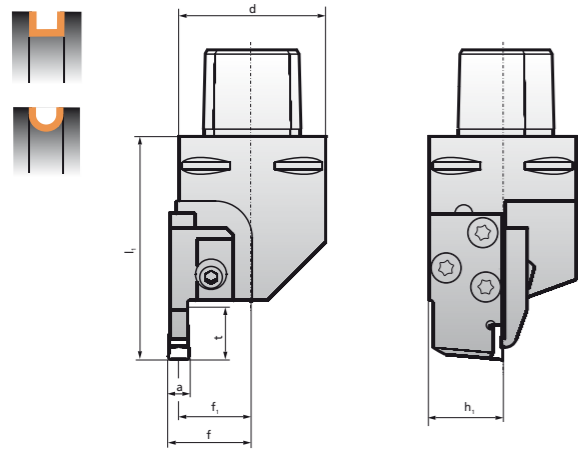
Stechbreite a Stechtiefe t Grooving width a Grooving depth t	Typ Type	Best.-Nr. Ref. no.	Stechschwert Grooving blade		Spannelement Clamping element	
			3225	Typ Type	Best.-Nr. Ref. no.	Typ Type
Links Left a = 8 mm t = 30 mm	RAG-3225-B8T30H5-LG	719.78.011.46	RAG-ST-B8T30H5-LG	70.91.22.593.0	RAG-SP-B8T30-L	70.91.11.931.0
	RAG-3225-B8T30H5-LR100	719.78.011.47	RAG-ST-B8T30H5-LR100	70.91.22.594.0	RAG-SP-B8T30-L	70.91.11.931.0
	RAG-3225-B8T30H5-LL100	719.78.011.48	RAG-ST-B8T30H5-LL100	70.91.22.595.0	RAG-SP-B8T30-L	70.91.11.931.0
Rechts Right a = 8 mm t = 30 mm	RAG-3225-B8T30H5-RG	719.77.011.46	RAG-ST-B8T30H5-RG	70.91.22.545.0	RAG-SP-B8T30-R	70.91.11.915.0
	RAG-3225-B8T30H5-RL100	719.77.011.47	RAG-ST-B8T30H5-RL100	70.91.22.546.0	RAG-SP-B8T30-R	70.91.11.915.0
	RAG-3225-B8T30H5-RR100	719.77.011.48	RAG-ST-B8T30H5-RR100	70.91.22.547.0	RAG-SP-B8T30-R	70.91.11.915.0





STECHBREITE GROOVING WIDTH 4 MM
STECHTIEFE GROOVING DEPTH 12 MM

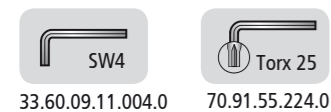
AUSFÜHRUNG VERSION
CMS5



	Abmessungen Dimensions (mm)						
	h ₁	d	l ₁	t	a	f	f ₁
CMS5	25	50	70	12	4	f ₁ ± 0.2	25

Spanwinkel Rake angle γ	0°
Neigungswinkel Back rake angle λ	0°

Stechbreite a Stechtiefe t Grooving width a Grooving depth t	Typ Type	Best.-Nr. Ref. no.	Stechschwert Grooving blade		Spannelement Clamping element	
			CMS5	Typ Type	Best.-Nr. Ref. no.	Typ Type
Links Left a = 4 mm t = 12 mm	RAG-CMS5-B4T12H5-LG	799.78.001.01	RAG-ST-B4T12H5-LG	70.91.22.548.0	RAG-SP-B4T12-L	70.91.11.916.0
	RAG-CMS5-B4T12H5-LR100	799.78.001.02	RAG-ST-B4T12H5-LR100	70.91.22.549.0	RAG-SP-B4T12-L	70.91.11.916.0
	RAG-CMS5-B4T12H5-LL100	799.78.001.03	RAG-ST-B4T12H5-LL100	70.91.22.550.0	RAG-SP-B4T12-L	70.91.11.916.0
Rechts Right a = 4 mm t = 12 mm	RAG-CMS5-B4T12H5-RG	799.77.001.01	RAG-ST-B4T12H5-RG	70.91.22.500.0	RAG-SP-B4T12-R	70.91.11.900.0
	RAG-CMS5-B4T12H5-RL100	799.77.001.02	RAG-ST-B4T12H5-RL100	70.91.22.501.0	RAG-SP-B4T12-R	70.91.11.900.0
	RAG-CMS5-B4T12H5-RR100	799.77.001.03	RAG-ST-B4T12H5-RR100	70.91.22.502.0	RAG-SP-B4T12-R	70.91.11.900.0

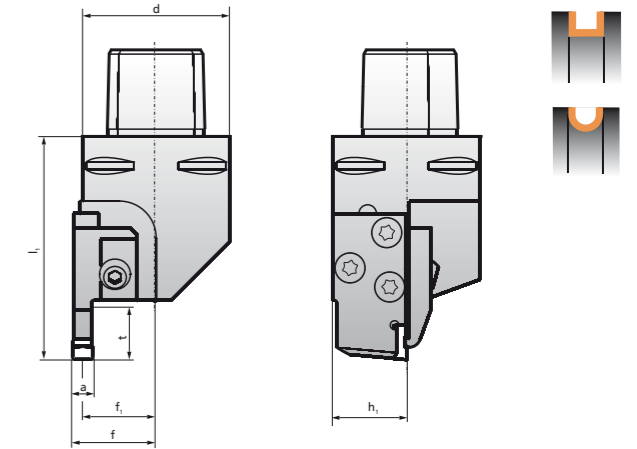


AUSFÜHRUNG VERSION
CMS5

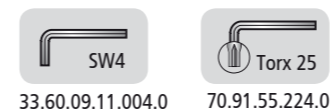
STECHBREITE GROOVING WIDTH 4 MM
STECHTIEFE GROOVING DEPTH 18 MM

	Abmessungen Dimensions (mm)						
	h ₁	d	l ₁	t	a	f	f ₁
CMS5	25	50	76	18	4	f ₁ ± 0.2	25

Spanwinkel Rake angle γ	0°
Neigungswinkel Back rake angle λ	0°

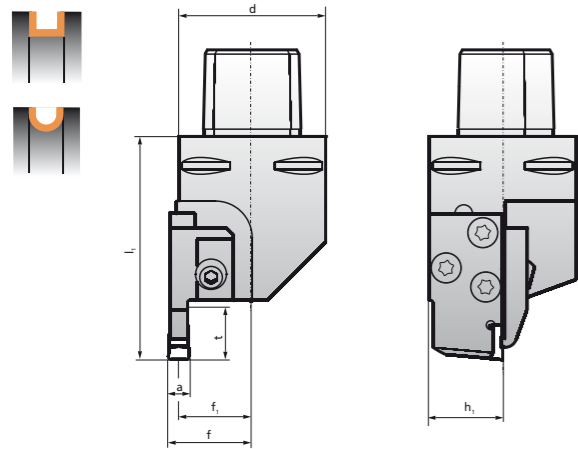


Stechbreite a Stechtiefe t Grooving width a Grooving depth t	Typ Type	Best.-Nr. Ref. no.	Stechschwert Grooving blade		Spannelement Clamping element	
			CMS5	Typ Type	Best.-Nr. Ref. no.	Typ Type
Links Left a = 4 mm t = 18 mm	RAG-CMS5-B4T18H5-LG	799.78.001.04	RAG-ST-B4T18H5-LG	70.91.22.551.0	RAG-SP-B4T18-L	70.91.11.917.0
	RAG-CMS5-B4T18H5-LR100	799.78.001.05	RAG-ST-B4T18H5-LR100	70.91.22.552.0	RAG-SP-B4T18-L	70.91.11.917.0
	RAG-CMS5-B4T18H5-LL100	799.78.001.06	RAG-ST-B4T18H5-LL100	70.91.22.553.0	RAG-SP-B4T18-L	70.91.11.917.0
Rechts Right a = 4 mm t = 18 mm	RAG-CMS5-B4T18H5-RG	799.77.001.04	RAG-ST-B4T18H5-RG	70.91.22.503.0	RAG-SP-B4T18-R	70.91.11.901.0
	RAG-CMS5-B4T18H5-RL100	799.77.001.05	RAG-ST-B4T18H5-RL100	70.91.22.504.0	RAG-SP-B4T18-R	70.91.11.901.0
	RAG-CMS5-B4T18H5-RR100	799.77.001.06	RAG-ST-B4T18H5-RR100	70.91.22.505.0	RAG-SP-B4T18-R	70.91.11.901.0



STECHBREITE GROOVING WIDTH 5 MM
STECHTIEFE GROOVING DEPTH 12 MM

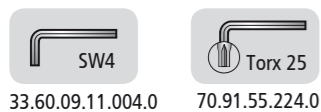
AUSFÜHRUNG VERSION
CMS5



	Abmessungen Dimensions (mm)						
	h ₁	d	l ₁	t	a	f	f ₁
CMS5	25	50	70	12	5	f ₁ + $\frac{a}{2}$	25

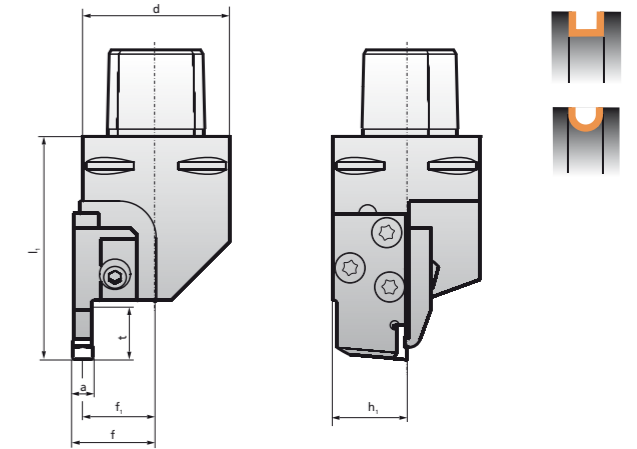
Spanwinkel Rake angle γ	0°
Neigungswinkel Back rake angle λ	0°

Stechbreite a Stechtiefe t Grooving width a Grooving depth t	Typ Type	Best.-Nr. Ref. no.	Stechschwert Grooving blade		Spannelement Clamping element		
			CMS5	Typ Type	Best.-Nr. Ref. no.	Typ Type	Best.-Nr. Ref. no.
Links Left a = 5 mm t = 12 mm		RAG-CMS5-B5T12H5-LG	799.78.001.07	RAG-ST-B5T12H5-LG	70.91.22.554.0	RAG-SP-B5T12-L	70.91.11.918.0
		RAG-CMS5-B5T12H5-LR100	799.78.001.08	RAG-ST-B5T12H5-LR100	70.91.22.555.0	RAG-SP-B5T12-L	70.91.11.918.0
		RAG-CMS5-B5T12H5-LL100	799.78.001.09	RAG-ST-B5T12H5-LL100	70.91.22.556.0	RAG-SP-B5T12-L	70.91.11.918.0
Rechts Right a = 5 mm t = 12 mm		RAG-CMS5-B5T12H5-RG	799.77.001.07	RAG-ST-B5T12H5-RG	70.91.22.506.0	RAG-SP-B5T12-R	70.91.11.902.0
		RAG-CMS5-B5T12H5-RL100	799.77.001.08	RAG-ST-B5T12H5-RL100	70.91.22.507.0	RAG-SP-B5T12-R	70.91.11.902.0
		RAG-CMS5-B5T12H5-RR100	799.77.001.09	RAG-ST-B5T12H5-RR100	70.91.22.508.0	RAG-SP-B5T12-R	70.91.11.902.0



AUSFÜHRUNG VERSION
CMS5

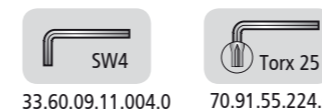
STECHBREITE GROOVING WIDTH 5 MM
STECHTIEFE GROOVING DEPTH 18 MM



	Abmessungen Dimensions (mm)						
	h ₁	d	l ₁	t	a	f	f ₁
CMS5	25	50	76	18	5	f ₁ + $\frac{a}{2}$	25

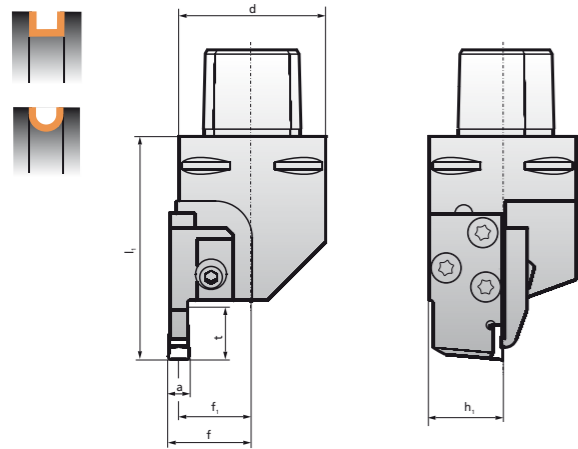
Spanwinkel Rake angle γ	0°
Neigungswinkel Back rake angle λ	0°

Stechbreite a Stechtiefe t Grooving width a Grooving depth t	Typ Type	Best.-Nr. Ref. no.	Stechschwert Grooving blade		Spannelement Clamping element		
			CMS5	Typ Type	Best.-Nr. Ref. no.	Typ Type	Best.-Nr. Ref. no.
Links Left a = 5 mm t = 18 mm		RAG-CMS5-B5T18H5-LG	799.78.001.10	RAG-ST-B5T18H5-LG	70.91.22.557.0	RAG-SP-B5T18-L	70.91.11.919.0
		RAG-CMS5-B5T18H5-LR100	799.78.001.11	RAG-ST-B5T18H5-LR100	70.91.22.558.0	RAG-SP-B5T18-L	70.91.11.919.0
		RAG-CMS5-B5T18H5-LL100	799.78.001.12	RAG-ST-B5T18H5-LL100	70.91.22.559.0	RAG-SP-B5T18-L	70.91.11.919.0
Rechts Right a = 5 mm t = 18 mm		RAG-CMS5-B5T18H5-RG	799.77.001.10	RAG-ST-B5T18H5-RG	70.91.22.509.0	RAG-SP-B5T18-R	70.91.11.903.0
		RAG-CMS5-B5T18H5-RL100	799.77.001.11	RAG-ST-B5T18H5-RL100	70.91.22.510.0	RAG-SP-B5T18-R	70.91.11.903.0
		RAG-CMS5-B5T18H5-RR100	799.77.001.12	RAG-ST-B5T18H5-RR100	70.91.22.511.0	RAG-SP-B5T18-R	70.91.11.903.0



STECHBREITE GROOVING WIDTH 5 MM
STECHTIEFE GROOVING DEPTH 24 MM

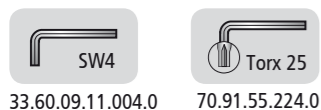
AUSFÜHRUNG VERSION
CMS5



	Abmessungen Dimensions (mm)						
	h ₁	d	l ₁	t	a	f	f ₁
CMS5	25	50	82	24	5	f ₁ + $\frac{a}{2}$	25

Spanwinkel Rake angle γ	0°
Neigungswinkel Back rake angle λ	0°

Stechbreite a Stechtiefe t Grooving width a Grooving depth t	Typ Type	Best.-Nr. Ref. no.	Stechschwert Grooving blade		Spannelement Clamping element	
			CMS5	Typ Type	Best.-Nr. Ref. no.	Typ Type
Links Left a = 5 mm t = 24 mm	RAG-CMS5-B5T24H5-LG	799.78.001.13	RAG-ST-B5T24H5-LG	70.91.22.560.0	RAG-SP-B5T24-L	70.91.11.920.0
	RAG-CMS5-B5T24H5-LR100	799.78.001.14	RAG-ST-B5T24H5-LR100	70.91.22.561.0	RAG-SP-B5T24-L	70.91.11.920.0
	RAG-CMS5-B5T24H5-LL100	799.78.001.15	RAG-ST-B5T24H5-LL100	70.91.22.562.0	RAG-SP-B5T24-L	70.91.11.920.0
Rechts Right a = 5 mm t = 24 mm	RAG-CMS5-B5T24H5-RG	799.77.001.13	RAG-ST-B5T24H5-RG	70.91.22.512.0	RAG-SP-B5T24-R	70.91.11.904.0
	RAG-CMS5-B5T24H5-RL100	799.77.001.14	RAG-ST-B5T24H5-RL100	70.91.22.513.0	RAG-SP-B5T24-R	70.91.11.904.0
	RAG-CMS5-B5T24H5-RR100	799.77.001.15	RAG-ST-B5T24H5-RR100	70.91.22.514.0	RAG-SP-B5T24-R	70.91.11.904.0

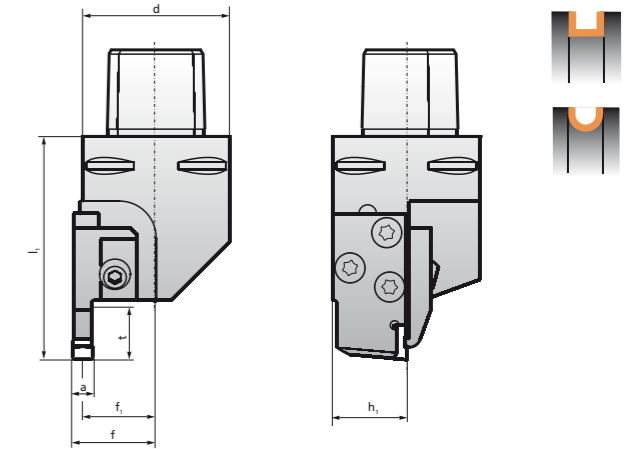


AUSFÜHRUNG VERSION
CMS5

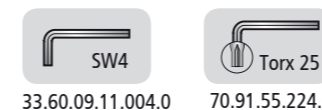
STECHBREITE GROOVING WIDTH 6 MM
STECHTIEFE GROOVING DEPTH 12 MM

	Abmessungen Dimensions (mm)						
	h ₁	d	l ₁	t	a	f	f ₁
CMS5	25	50	70	12	6	f ₁ + $\frac{a}{2}$	25

Spanwinkel Rake angle γ	0°
Neigungswinkel Back rake angle λ	0°

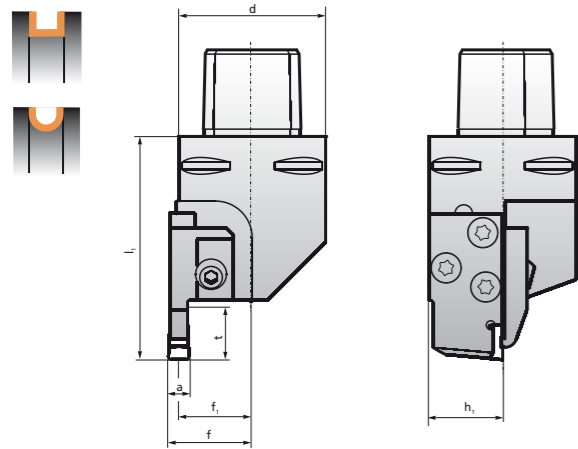


Stechbreite a Stechtiefe t Grooving width a Grooving depth t	Typ Type	Best.-Nr. Ref. no.	Stechschwert Grooving blade		Spannelement Clamping element	
			CMS5	Typ Type	Best.-Nr. Ref. no.	Typ Type
Links Left a = 6 mm t = 12 mm	RAG-CMS5-B6T12H5-LG	799.78.001.16	RAG-ST-B6T12H5-LG	70.91.22.563.0	RAG-SP-B6T12-L	70.91.11.921.0
	RAG-CMS5-B6T12H5-LR100	799.78.001.17	RAG-ST-B6T12H5-LR100	70.91.22.564.0	RAG-SP-B6T12-L	70.91.11.921.0
	RAG-CMS5-B6T12H5-LL100	799.78.001.18	RAG-ST-B6T12H5-LL100	70.91.22.565.0	RAG-SP-B6T12-L	70.91.11.921.0
Rechts Right a = 6 mm t = 12 mm	RAG-CMS5-B6T12H5-RG	799.77.001.16	RAG-ST-B6T12H5-RG	70.91.22.515.0	RAG-SP-B6T12-R	70.91.11.905.0
	RAG-CMS5-B6T12H5-RL100	799.77.001.17	RAG-ST-B6T12H5-RL100	70.91.22.516.0	RAG-SP-B6T12-R	70.91.11.905.0
	RAG-CMS5-B6T12H5-RR100	799.77.001.18	RAG-ST-B6T12H5-RR100	70.91.22.517.0	RAG-SP-B6T12-R	70.91.11.905.0



STECHBREITE GROOVING WIDTH 6 MM
STECHTIEFE GROOVING DEPTH 18 MM

AUSFÜHRUNG VERSION
CMS5

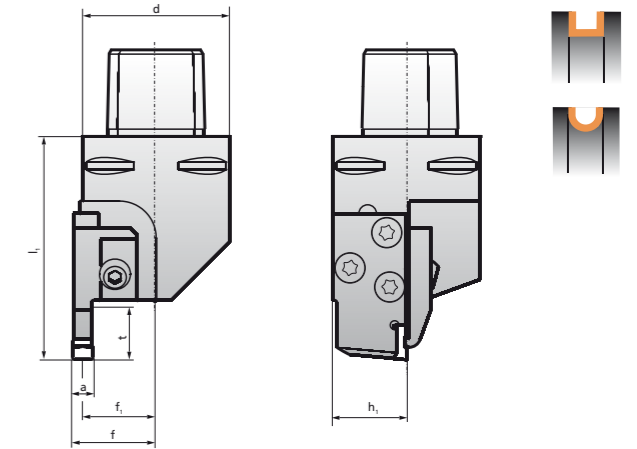


	Abmessungen Dimensions (mm)						
	h ₁	d	l ₁	t	a	f	f ₁
CMS5	25	50	76	18	6	f ₁ + $\frac{a}{2}$	25

Spanwinkel Rake angle γ	0°
Neigungswinkel Back rake angle λ	0°

AUSFÜHRUNG VERSION
CMS5

STECHBREITE GROOVING WIDTH 6 MM
STECHTIEFE GROOVING DEPTH 24 MM

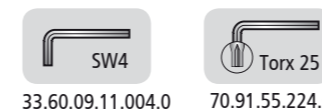
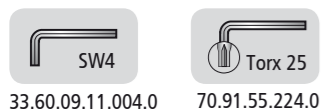


	Abmessungen Dimensions (mm)						
	h ₁	d	l ₁	t	a	f	f ₁
CMS5	25	50	82	24	6	f ₁ + $\frac{a}{2}$	25

Spanwinkel Rake angle γ	0°
Neigungswinkel Back rake angle λ	0°

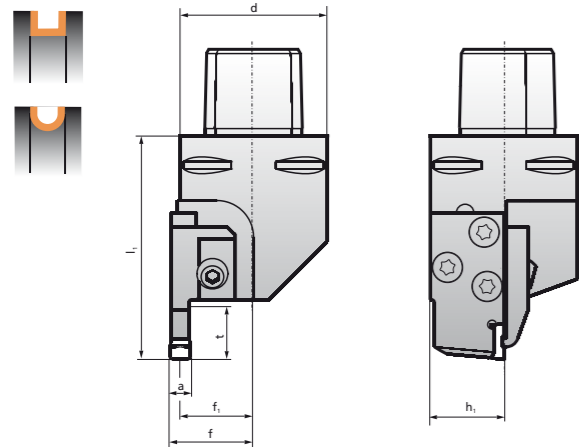
Stechbreite a Stechtiefe t Grooving width a Grooving depth t	Typ Type	Best.-Nr. Ref. no.	Stechschwert Grooving blade		Spannelement Clamping element		
			CMS5	Typ Type	Best.-Nr. Ref. no.	Typ Type	Best.-Nr. Ref. no.
Links Left a = 6 mm t = 18 mm		RAG-CMS5-B6T18H5-LG	799.78.001.19	RAG-ST-B6T18H5-LG	70.91.22.566.0	RAG-SP-B6T18-L	70.91.11.922.0
		RAG-CMS5-B6T18H5-LR100	799.78.001.20	RAG-ST-B6T18H5-LR100	70.91.22.567.0	RAG-SP-B6T18-L	70.91.11.922.0
		RAG-CMS5-B6T18H5-LL100	799.78.001.21	RAG-ST-B6T18H5-LL100	70.91.22.568.0	RAG-SP-B6T18-L	70.91.11.922.0
Rechts Right a = 6 mm t = 18 mm		RAG-CMS5-B6T18H5-RG	799.77.001.19	RAG-ST-B6T18H5-RG	70.91.22.518.0	RAG-SP-B6T18-R	70.91.11.906.0
		RAG-CMS5-B6T18H5-RL100	799.77.001.20	RAG-ST-B6T18H5-RL100	70.91.22.519.0	RAG-SP-B6T18-R	70.91.11.906.0
		RAG-CMS5-B6T18H5-RR100	799.77.001.21	RAG-ST-B6T18H5-RR100	70.91.22.520.0	RAG-SP-B6T18-R	70.91.11.906.0

Stechbreite a Stechtiefe t Grooving width a Grooving depth t	Typ Type	Best.-Nr. Ref. no.	Stechschwert Grooving blade		Spannelement Clamping element		
			CMS5	Typ Type	Best.-Nr. Ref. no.	Typ Type	Best.-Nr. Ref. no.
Links Left a = 6 mm t = 24 mm		RAG-CMS5-B6T24H5-LG	799.78.001.22	RAG-ST-B6T24H5-LG	70.91.22.569.0	RAG-SP-B6T24-L	70.91.11.923.0
		RAG-CMS5-B6T24H5-LR100	799.78.001.23	RAG-ST-B6T24H5-LR100	70.91.22.570.0	RAG-SP-B6T24-L	70.91.11.923.0
		RAG-CMS5-B6T24H5-LL100	799.78.001.24	RAG-ST-B6T24H5-LL100	70.91.22.571.0	RAG-SP-B6T24-L	70.91.11.923.0
Rechts Right a = 6 mm t = 24 mm		RAG-CMS5-B6T24H5-RG	799.77.001.22	RAG-ST-B6T24H5-RG	70.91.22.521.0	RAG-SP-B6T24-R	70.91.11.907.0
		RAG-CMS5-B6T24H5-RL100	799.77.001.23	RAG-ST-B6T24H5-RL100	70.91.22.522.0	RAG-SP-B6T24-R	70.91.11.907.0
		RAG-CMS5-B6T24H5-RR100	799.77.001.24	RAG-ST-B6T24H5-RR100	70.91.22.523.0	RAG-SP-B6T24-R	70.91.11.905.0



STECHBREITE GROOVING WIDTH 6 MM
STECHTIEFE GROOVING DEPTH 30 MM

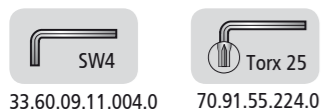
AUSFÜHRUNG VERSION
CMS5



	Abmessungen Dimensions (mm)							
	h ₁	d	l ₁	t	a	f	f ₁	
CMS5	25	50	88	30	6	f ₁ ± 0.02	25	

Spanwinkel Rake angle γ	0°
Neigungswinkel Back rake angle λ	0°

Stechbreite a Stechtiefe t Grooving width a Grooving depth t	Typ Type	Best.-Nr. Ref. no.	Stechschwert Grooving blade		Spannelement Clamping element		
			CMS5	Typ Type	Best.-Nr. Ref. no.	Typ Type	Best.-Nr. Ref. no.
Links Left a = 6 mm t = 30 mm		RAG-CMS5-B6T30H5-LG	799.78.001.25	RAG-ST-B6T30H5-LG	70.91.22.572.0	RAG-SP-B6T30-L	70.91.11.924.0
		RAG-CMS5-B6T30H5-LR100	799.78.001.26	RAG-ST-B6T30H5-LR100	70.91.22.573.0	RAG-SP-B6T30-L	70.91.11.924.0
		RAG-CMS5-B6T30H5-LL100	799.78.001.27	RAG-ST-B6T30H5-LL100	70.91.22.574.0	RAG-SP-B6T30-L	70.91.11.924.0
Rechts Right a = 6 mm t = 30 mm		RAG-CMS5-B6T30H5-RG	799.77.001.25	RAG-ST-B6T30H5-RG	70.91.22.524.0	RAG-SP-B6T30-R	70.91.11.908.0
		RAG-CMS5-B6T30H5-RL100	799.77.001.26	RAG-ST-B6T30H5-RL100	70.91.22.525.0	RAG-SP-B6T30-R	70.91.11.908.0
		RAG-CMS5-B6T30H5-RR100	799.77.001.27	RAG-ST-B6T30H5-RR100	70.91.22.526.0	RAG-SP-B6T30-R	70.91.11.908.0

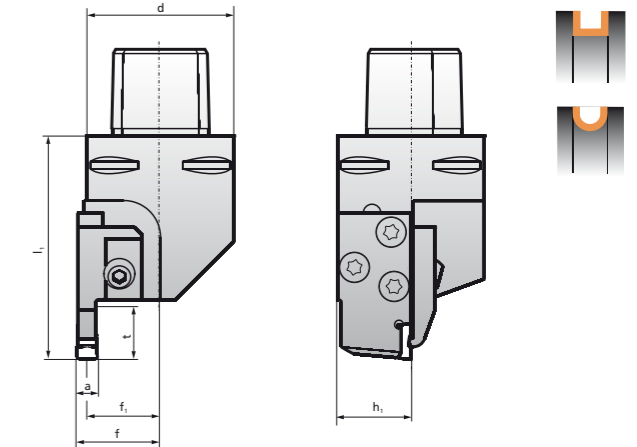


AUSFÜHRUNG VERSION
CMS5

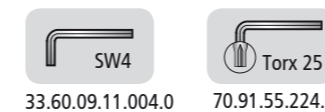
STECHBREITE GROOVING WIDTH 7 MM
STECHTIEFE GROOVING DEPTH 12 MM

	Abmessungen Dimensions (mm)							
	h ₁	d	l ₁	t	a	f	f ₁	
CMS5	25	50	70	12	7	f ₁ ± 0.02	25	

Spanwinkel Rake angle γ	0°
Neigungswinkel Back rake angle λ	0°

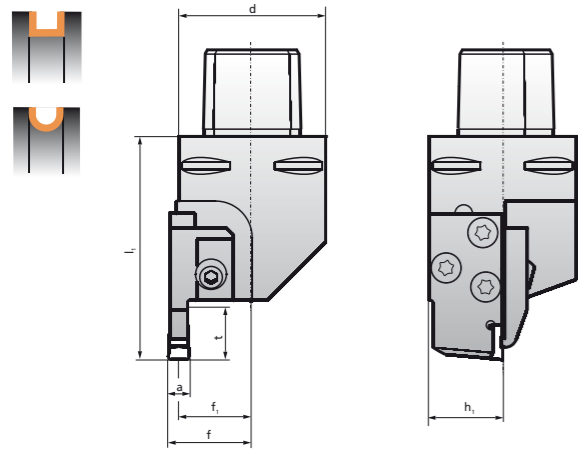


Stechbreite a Stechtiefe t Grooving width a Grooving depth t	Typ Type	Best.-Nr. Ref. no.	Stechschwert Grooving blade		Spannelement Clamping element		
			CMS5	Typ Type	Best.-Nr. Ref. no.	Typ Type	Best.-Nr. Ref. no.
Links Left a = 7 mm t = 12 mm		RAG-CMS5-B7T12H5-LG	799.78.001.28	RAG-ST-B7T12H5-LG	70.91.22.575.0	RAG-SP-B7T12-L	70.91.11.925.0
		RAG-CMS5-B7T12H5-LR100	799.78.001.29	RAG-ST-B7T12H5-LR100	70.91.22.576.0	RAG-SP-B7T12-L	70.91.11.925.0
		RAG-CMS5-B7T12H5-LL100	799.78.001.30	RAG-ST-B7T12H5-LL100	70.91.22.577.0	RAG-SP-B7T12-L	70.91.11.925.0
Rechts Right a = 7 mm t = 12 mm		RAG-CMS5-B7T12H5-RG	799.77.001.28	RAG-ST-B7T12H5-RG	70.91.22.527.0	RAG-SP-B7T12-R	70.91.11.909.0
		RAG-CMS5-B7T12H5-RL100	799.77.001.29	RAG-ST-B7T12H5-RL100	70.91.22.528.0	RAG-SP-B7T12-R	70.91.11.909.0
		RAG-CMS5-B7T12H5-RR100	799.77.001.30	RAG-ST-B7T12H5-RR100	70.91.22.529.0	RAG-SP-B7T12-R	70.91.11.909.0



STECHBREITE GROOVING WIDTH 7 MM
STECHTIEFE GROOVING DEPTH 18 MM

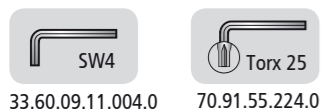
AUSFÜHRUNG VERSION
CMS5



	Abmessungen Dimensions (mm)						
	h ₁	d	l ₁	t	a	f	f ₁
CMS5	25	50	76	18	7	f ₁ + $\frac{a}{2}$	25

Spanwinkel Rake angle γ	0°
Neigungswinkel Back rake angle λ	0°

Stechbreite a Stechtiefe t Grooving width a Grooving depth t	Typ Type	Best.-Nr. Ref. no.	Stechschwert Grooving blade		Spannelement Clamping element		
			CMS5	Typ Type	Best.-Nr. Ref. no.	Typ Type	Best.-Nr. Ref. no.
Links Left a = 7 mm t = 18 mm		RAG-CMS5-B7T18H5-LG	799.78.001.31	RAG-ST-B7T18H5-LG	70.91.22.578.0	RAG-SP-B7T18-L	70.91.11.926.0
		RAG-CMS5-B7T18H5-LR100	799.78.001.32	RAG-ST-B7T18H5-LR100	70.91.22.579.0	RAG-SP-B7T18-L	70.91.11.926.0
		RAG-CMS5-B7T18H5-LL100	799.78.001.33	RAG-ST-B7T18H5-LL100	70.91.22.580.0	RAG-SP-B7T18-L	70.91.11.926.0
Rechts Right a = 7 mm t = 18 mm		RAG-CMS5-B7T18H5-RG	799.77.001.31	RAG-ST-B7T18H5-RG	70.91.22.530.0	RAG-SP-B7T18-R	70.91.11.910.0
		RAG-CMS5-B7T18H5-RL100	799.77.001.32	RAG-ST-B7T18H5-RL100	70.91.22.531.0	RAG-SP-B7T18-R	70.91.11.910.0
		RAG-CMS5-B7T18H5-RR100	799.77.001.33	RAG-ST-B7T18H5-RR100	70.91.22.532.0	RAG-SP-B7T18-R	70.91.11.910.0

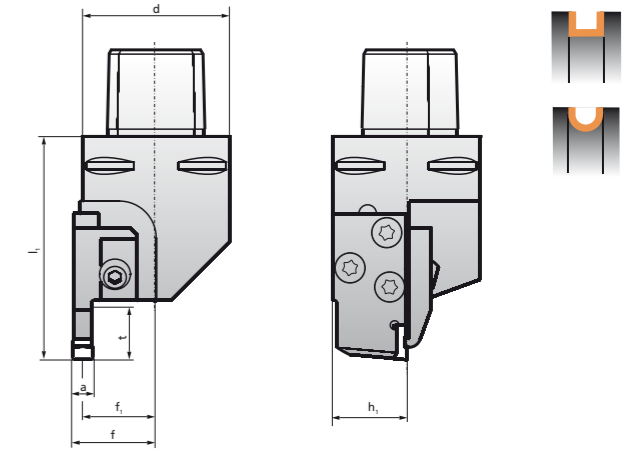


AUSFÜHRUNG VERSION
CMS5

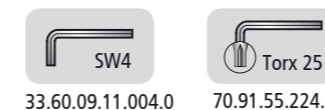
STECHBREITE GROOVING WIDTH 7 MM
STECHTIEFE GROOVING DEPTH 24 MM

	Abmessungen Dimensions (mm)						
	h ₁	d	l ₁	t	a	f	f ₁
CMS5	25	50	82	24	7	f ₁ + $\frac{a}{2}$	25

Spanwinkel Rake angle γ	0°
Neigungswinkel Back rake angle λ	0°

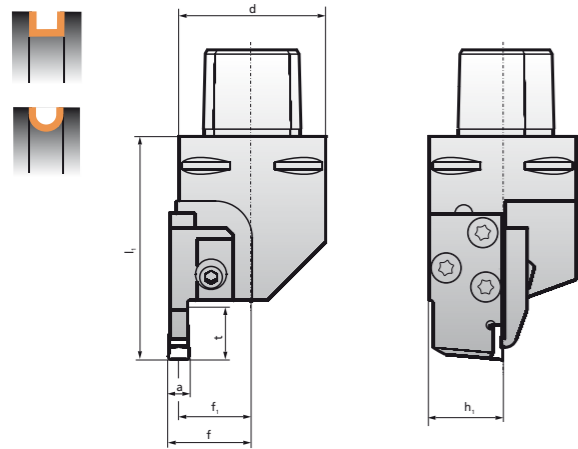


Stechbreite a Stechtiefe t Grooving width a Grooving depth t	Typ Type	Best.-Nr. Ref. no.	Stechschwert Grooving blade		Spannelement Clamping element		
			CMS5	Typ Type	Best.-Nr. Ref. no.	Typ Type	Best.-Nr. Ref. no.
Links Left a = 7 mm t = 24 mm		RAG-CMS5-B7T24H5-LG	799.78.001.34	RAG-ST-B7T24H5-LG	70.91.22.581.0	RAG-SP-B7T24-L	70.91.11.927.0
		RAG-CMS5-B7T24H5-LR100	799.78.001.35	RAG-ST-B7T24H5-LR100	70.91.22.582.0	RAG-SP-B7T24-L	70.91.11.927.0
		RAG-CMS5-B7T24H5-LL100	799.78.001.36	RAG-ST-B7T24H5-LL100	70.91.22.583.0	RAG-SP-B7T24-L	70.91.11.927.0
Rechts Right a = 7 mm t = 24 mm		RAG-CMS5-B7T24H5-RG	799.77.001.34	RAG-ST-B7T24H5-RG	70.91.22.533.0	RAG-SP-B7T24-R	70.91.11.911.0
		RAG-CMS5-B7T24H5-RL100	799.77.001.35	RAG-ST-B7T24H5-RL100	70.91.22.534.0	RAG-SP-B7T24-R	70.91.11.911.0
		RAG-CMS5-B7T24H5-RR100	799.77.001.36	RAG-ST-B7T24H5-RR100	70.91.22.535.0	RAG-SP-B7T24-R	70.91.11.911.0



STECHBREITE GROOVING WIDTH 7 MM
STECHTIEFE GROOVING DEPTH 30 MM

AUSFÜHRUNG VERSION
CMS5

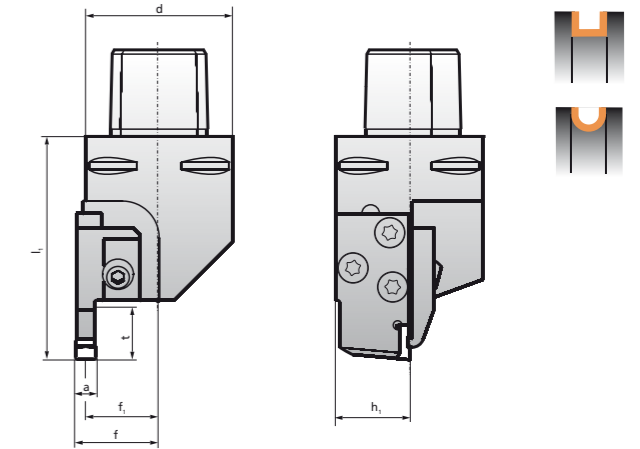


	Abmessungen Dimensions (mm)						
	h ₁	d	l ₁	t	a	f	f ₁
CMS5	25	50	88	30	7	$f_1 + \frac{a}{2}$	25

Spanwinkel Rake angle γ	0°
Neigungswinkel Back rake angle λ	0°

AUSFÜHRUNG VERSION
CMS5

STECHBREITE GROOVING WIDTH 8 MM
STECHTIEFE GROOVING DEPTH 18 MM

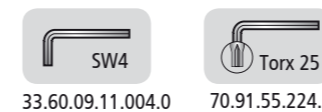
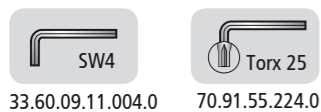


	Abmessungen Dimensions (mm)						
	h ₁	d	l ₁	t	a	f	f ₁
CMS5	25	50	76	18	8	$f_1 + \frac{a}{2}$	25

Spanwinkel Rake angle γ	0°
Neigungswinkel Back rake angle λ	0°

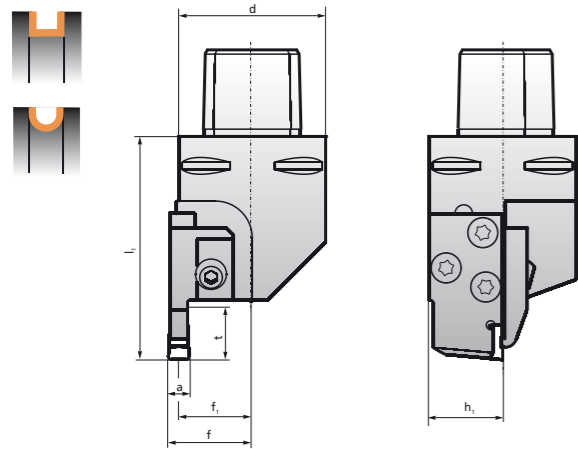
Stechbreite a Stechtiefe t Grooving width a Grooving depth t	Typ Type	Best.-Nr. Ref. no.	Stechschwert Grooving blade		Spannelement Clamping element		
			CMS5	Typ Type	Best.-Nr. Ref. no.	Typ Type	Best.-Nr. Ref. no.
Links Left a = 7 mm t = 30 mm		RAG-CMS5-B7T30H5-LG	799.78.001.37	RAG-ST-B7T30H5-LG	70.91.22.584.0	RAG-SP-B7T30-L	70.91.11.928.0
		RAG-CMS5-B7T30H5-LR100	799.78.001.38	RAG-ST-B7T30H5-LR100	70.91.22.585.0	RAG-SP-B7T30-L	70.91.11.928.0
		RAG-CMS5-B7T30H5-LL100	799.78.001.39	RAG-ST-B7T30H5-LL100	70.91.22.586.0	RAG-SP-B7T30-L	70.91.11.928.0
Rechts Right a = 7 mm t = 30 mm		RAG-CMS5-B7T30H5-RG	799.77.001.37	RAG-ST-B7T30H5-RG	70.91.22.536.0	RAG-SP-B7T30-R	70.91.11.912.0
		RAG-CMS5-B7T30H5-RL100	799.77.001.38	RAG-ST-B7T30H5-RL100	70.91.22.537.0	RAG-SP-B7T30-R	70.91.11.912.0
		RAG-CMS5-B7T30H5-RR100	799.77.001.39	RAG-ST-B7T30H5-RR100	70.91.22.538.0	RAG-SP-B7T30-R	70.91.11.912.0

Stechbreite a Stechtiefe t Grooving width a Grooving depth t	Typ Type	Best.-Nr. Ref. no.	Stechschwert Grooving blade		Spannelement Clamping element		
			CMS5	Typ Type	Best.-Nr. Ref. no.	Typ Type	Best.-Nr. Ref. no.
Links Left a = 8 mm t = 18 mm		RAG-CMS5-B8T18H5-LG	799.78.001.40	RAG-ST-B8T18H5-LG	70.91.22.587.0	RAG-SP-B8T18-L	70.91.11.929.0
		RAG-CMS5-B8T18H5-LR100	799.78.001.41	RAG-ST-B8T18H5-LR100	70.91.22.588.0	RAG-SP-B8T18-L	70.91.11.929.0
		RAG-CMS5-B8T18H5-LL100	799.78.001.42	RAG-ST-B8T18H5-LL100	70.91.22.588.0	RAG-SP-B8T18-L	70.91.11.929.0
Rechts Right a = 8 mm t = 18 mm		RAG-CMS5-B8T18H5-RG	799.77.001.40	RAG-ST-B8T18H5-RG	70.91.22.539.0	RAG-SP-B8T18-R	70.91.11.913.0
		RAG-CMS5-B8T18H5-RL100	799.77.001.41	RAG-ST-B8T18H5-RL100	70.91.22.540.0	RAG-SP-B8T18-R	70.91.11.913.0
		RAG-CMS5-B8T18H5-RR100	799.77.001.42	RAG-ST-B8T18H5-RR100	70.91.22.541.0	RAG-SP-B8T18-R	70.91.11.913.0



STECHBREITE GROOVING WIDTH 8 MM
STECHTIEFE GROOVING DEPTH 24 MM

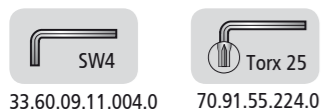
AUSFÜHRUNG VERSION
CMS5



	Abmessungen Dimensions (mm)						
	h ₁	d	l ₁	t	a	f	f ₁
CMS5	25	50	82	24	8	f ₁ + $\frac{a}{2}$	25

Spanwinkel Rake angle γ	0°
Neigungswinkel Back rake angle λ	0°

Stechbreite a Stechtiefe t Grooving width a Grooving depth t	Typ Type	Best.-Nr. Ref. no.	Stechschwert Grooving blade		Spannelement Clamping element		
			CMS5	Typ Type	Best.-Nr. Ref. no.	Typ Type	Best.-Nr. Ref. no.
Links Left a = 8 mm t = 24 mm		RAG-CMS5-B8T24H5-LG	799.78.001.43	RAG-ST-B8T24H5-LG	70.91.22.590.0	RAG-SP-B8T24-L	70.91.11.930.0
		RAG-CMS5-B8T24H5-LR100	799.78.001.44	RAG-ST-B8T24H5-LR100	70.91.22.591.0	RAG-SP-B8T24-L	70.91.11.930.0
		RAG-CMS5-B8T24H5-LL100	799.78.001.45	RAG-ST-B8T24H5-LL100	70.91.22.592.0	RAG-SP-B8T24-L	70.91.11.930.0
Rechts Right a = 8 mm t = 24 mm		RAG-CMS5-B8T24H5-RG	799.77.001.43	RAG-ST-B8T24H5-RG	70.91.22.542.0	RAG-SP-B8T24-R	70.91.11.914.0
		RAG-CMS5-B8T24H5-RL100	799.77.001.44	RAG-ST-B8T24H5-RL100	70.91.22.543.0	RAG-SP-B8T24-R	70.91.11.914.0
		RAG-CMS5-B8T24H5-RR100	799.77.001.45	RAG-ST-B8T24H5-RR100	70.91.22.544.0	RAG-SP-B8T24-R	70.91.11.914.0

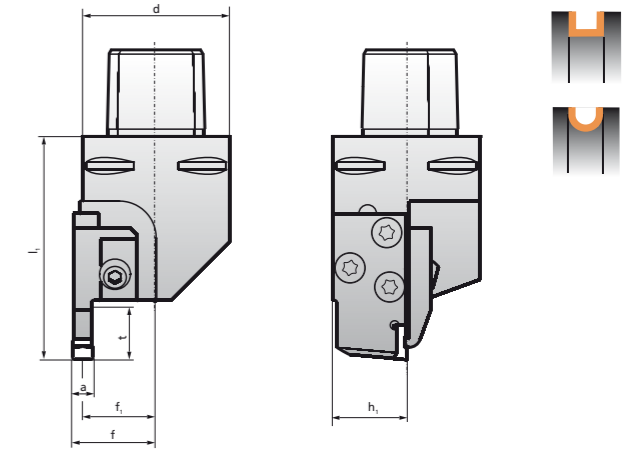


AUSFÜHRUNG VERSION
CMS5

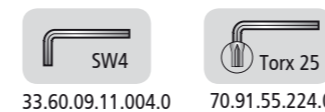
STECHBREITE GROOVING WIDTH 8 MM
STECHTIEFE GROOVING DEPTH 30 MM

	Abmessungen Dimensions (mm)						
	h ₁	d	l ₁	t	a	f	f ₁
CMS5	25	50	88	30	8	f ₁ + $\frac{a}{2}$	25

Spanwinkel Rake angle γ	0°
Neigungswinkel Back rake angle λ	0°



Stechbreite a Stechtiefe t Grooving width a Grooving depth t	Typ Type	Best.-Nr. Ref. no.	Stechschwert Grooving blade		Spannelement Clamping element		
			CMS5	Typ Type	Best.-Nr. Ref. no.	Typ Type	Best.-Nr. Ref. no.
Links Left a = 8 mm t = 30 mm		RAG-CMS5-B8T30H5-LG	799.78.001.46	RAG-ST-B8T30H5-LG	70.91.22.593.0	RAG-SP-B8T30-L	70.91.11.931.0
		RAG-CMS5-B8T30H5-LR100	799.78.001.47	RAG-ST-B8T30H5-LR100	70.91.22.594.0	RAG-SP-B8T30-L	70.91.11.931.0
		RAG-CMS5-B8T30H5-LL100	799.78.001.48	RAG-ST-B8T30H5-LL100	70.91.22.595.0	RAG-SP-B8T30-L	70.91.11.931.0
Rechts Right a = 8 mm t = 30 mm		RAG-CMS5-B8T30H5-RG	799.77.001.46	RAG-ST-B8T30H5-RG	70.91.22.545.0	RAG-SP-B8T30-R	70.91.11.915.0
		RAG-CMS5-B8T30H5-RL100	799.77.001.47	RAG-ST-B8T30H5-RL100	70.91.22.546.0	RAG-SP-B8T30-R	70.91.11.915.0
		RAG-CMS5-B8T30H5-RR100	799.77.001.48	RAG-ST-B8T30H5-RR100	70.91.22.547.0	RAG-SP-B8T30-R	70.91.11.915.0



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