MINIATURE PART MACHINING
PICCO LINES
METRIC CATALOG

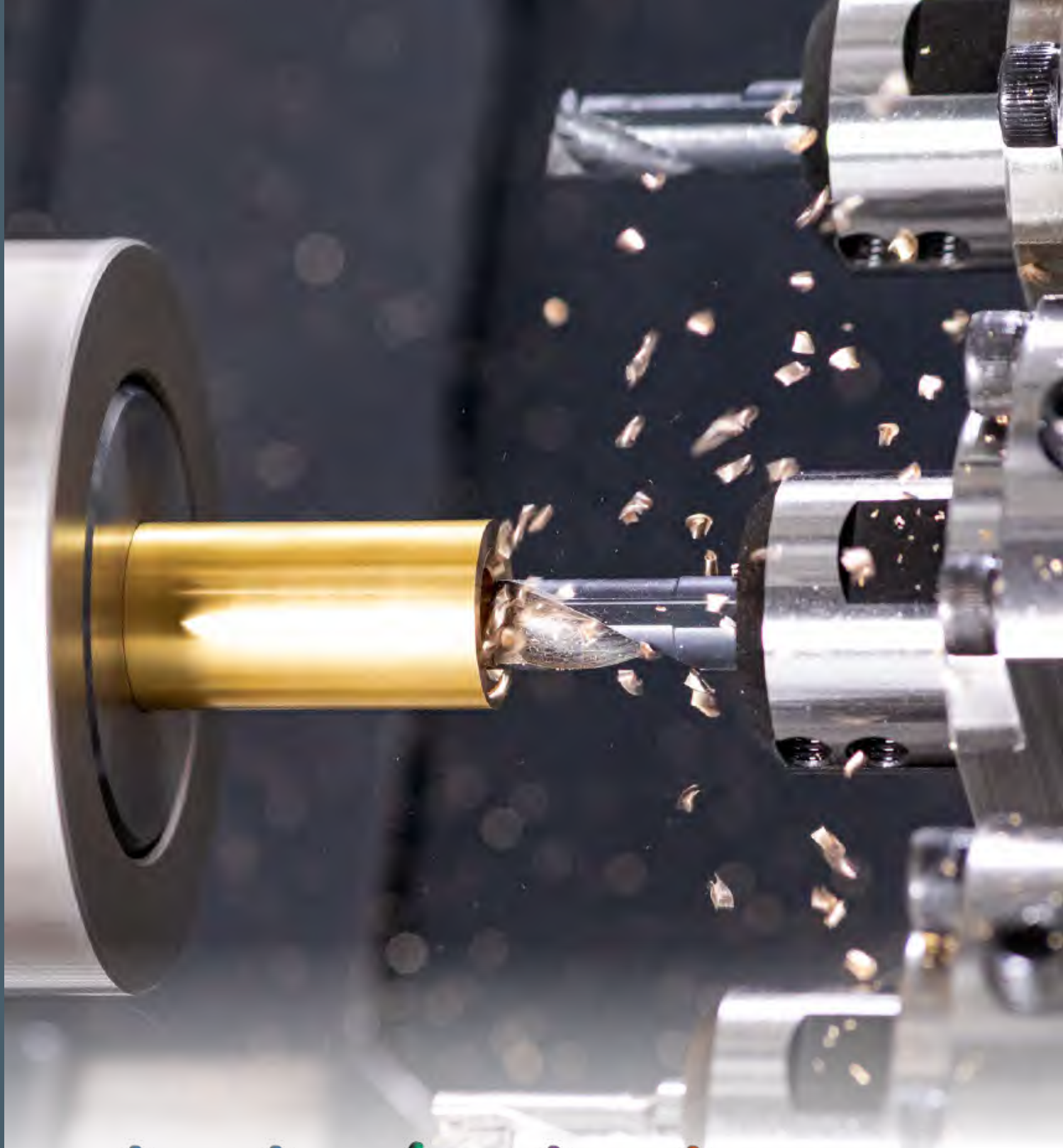


MACHINING INTELLIGENTLY



TURNING | FACE GROOVING | THREADING | DRILLING

Member IMC Group
ISCAR
www.iscar.com



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



Member IMC Group

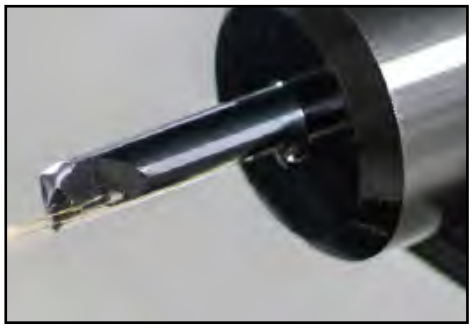
ISCAR

www.iscar.com

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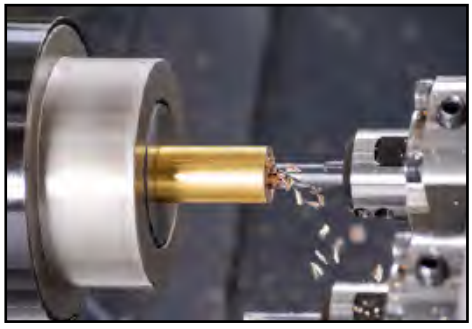
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THREADING Lines page 33

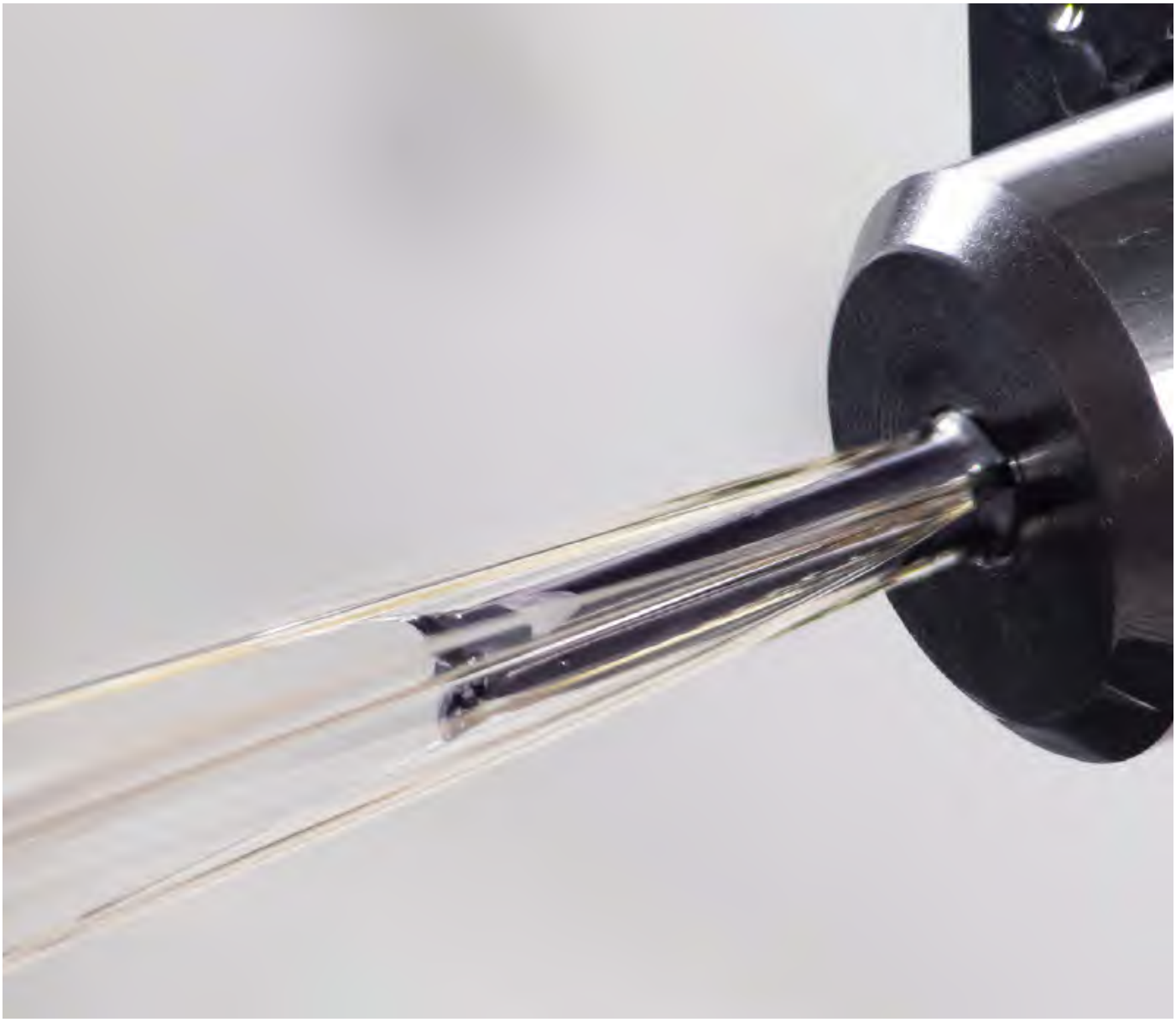


DRILLING LINES PAGE 37

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

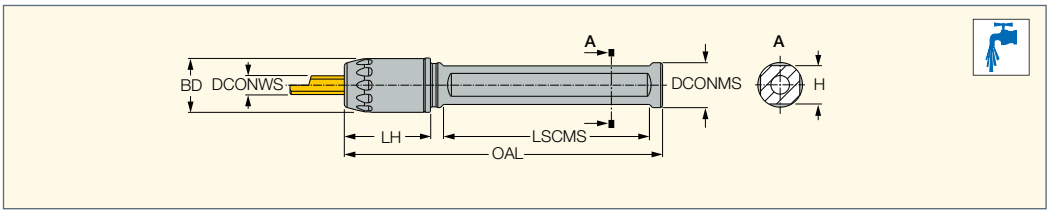
PASSCUT

SWISSTURN

ACECUT PICCOCUT HOLDER

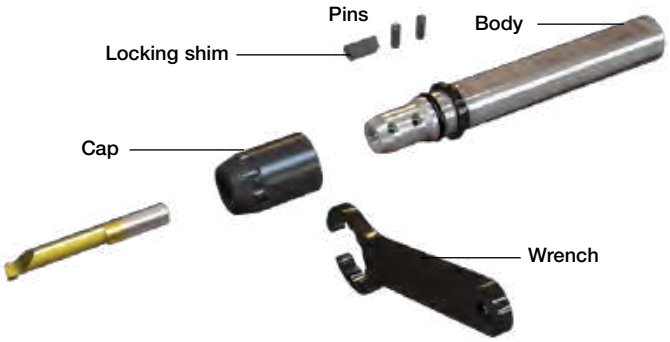
PICCO ACE

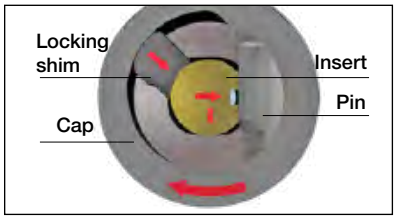
Holders for PICCO-CUT Inserts

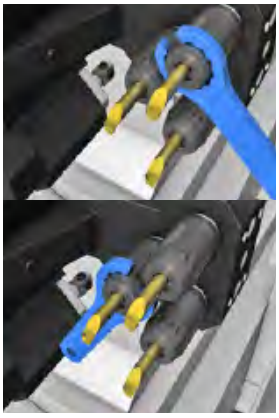


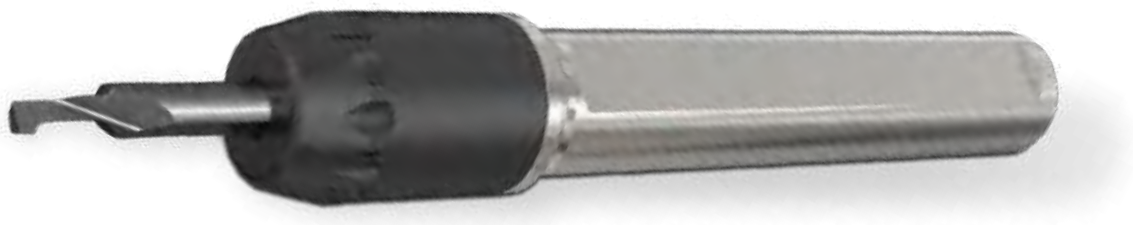
Designation	DCONMS	DCONWS	BD	OAL	LH	LSCMS	H		
PICCO ACE 12-4	12.00	4.00	14.50	85.00	23.00	53.00	10.3	PL 16 M6-D5	WRENCH ACE 4-5
PICCO ACE 12-5	12.00	5.00	14.50	85.00	23.00	53.00	10.3	PL 16 M6-D5	WRENCH ACE 4-5
PICCO ACE 16-4	16.00	4.00	14.50	85.00	21.50	53.50	14.0	PL 16 M6-D5	WRENCH ACE 4-5
PICCO ACE 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





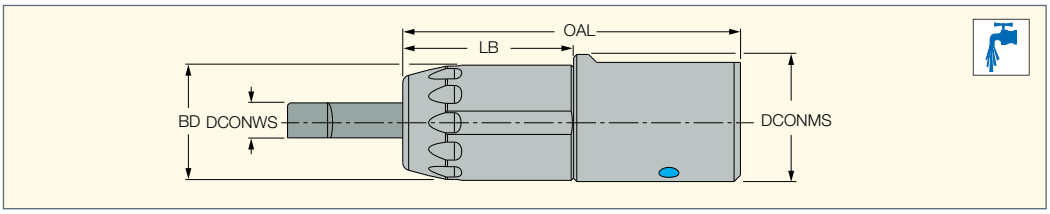




PICCOACE

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


PICCO 050


PICCO 050C


PICCO 051

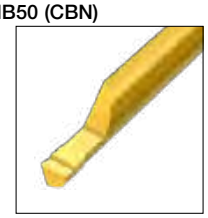

PICCO 050 IB50 (CBN)


PICCO 520


PICCO 060


PICCO MF


PICCO 010

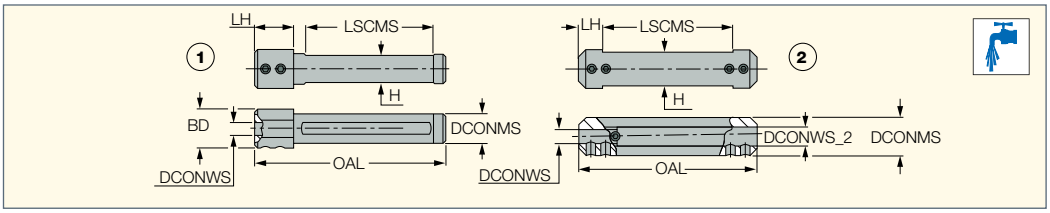

PICCO 020

PASSCUT

PICCOCUT HOLDER

PICCO/MG PCO (Holder)

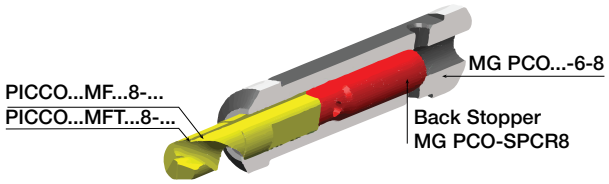
Holders for PICCO-CUT Inserts and Small Diameter Boring Bars



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	

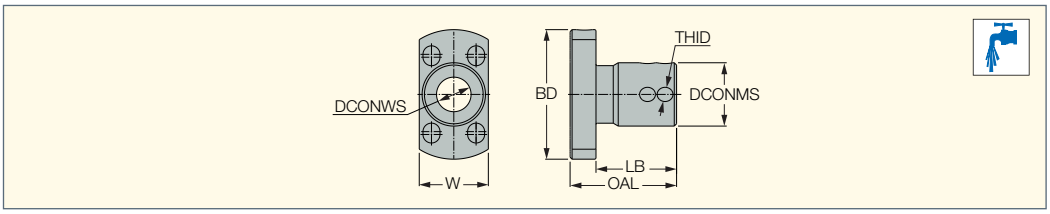
- Holders are suitable for right- and left-hand inserts, and boring bars

(1) Tools for Swiss-type CNC



QUICKSWISS

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



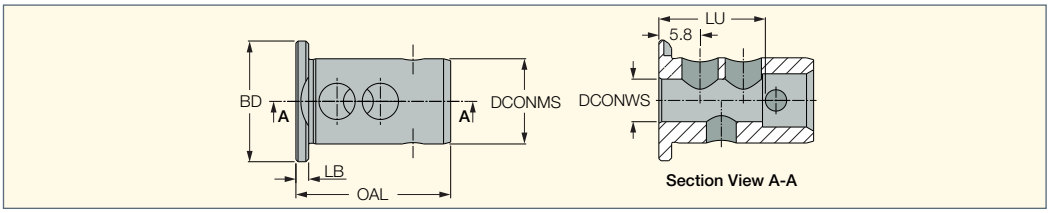
Designation	DCONMS	DCONWS	BD	OAL	LB	OAW	THID
SBTH-PICCO	22.00	12.00	45.00	37.00	28.00	24.00	5

Spare Parts

Designation					
SBTH-PICCO	SR M5X0.5X16 DIN913	SBTA-IK-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



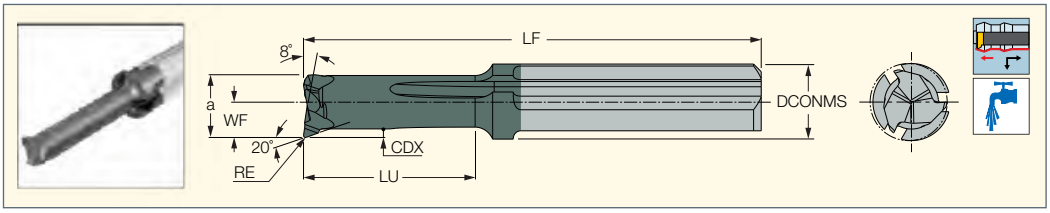
PICCO-3-CUT



PICCO-JET

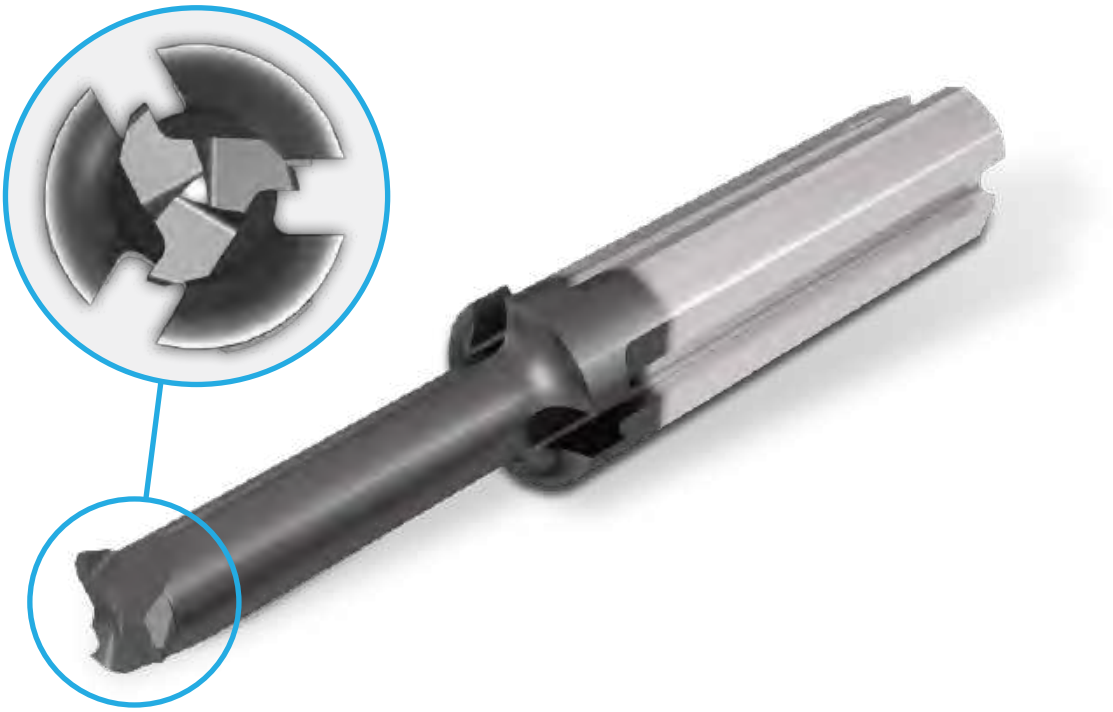
PICCO3CUT

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	●

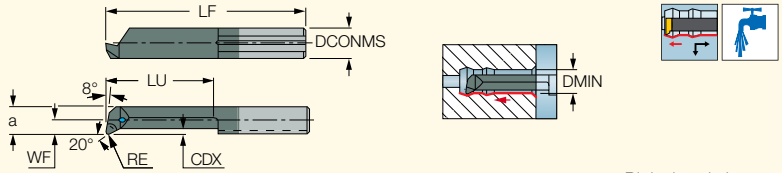
• Specify right- or left-hand bars



PICCOJET
COOLANT THROUGH

PICJ R/L 050, 053, 055
Inserts with Inner Coolant Channel for Internal Turning and Chamfering





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

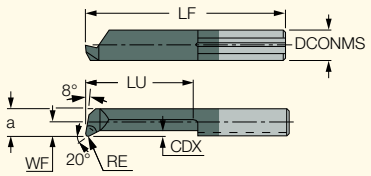


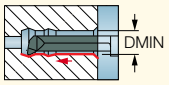
PICCOCUT

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	•	•

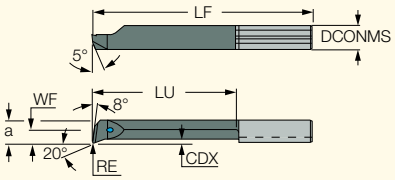
• Specify right- or left-hand bars (1) Maximum D.O.C.=0.01-0.03 mm, maximum feed=0.01 mm/rev. (2) Cutting depth maximum

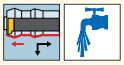
PICCOJET
COOLANT THROUGH

PICJ R/L 050-C

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







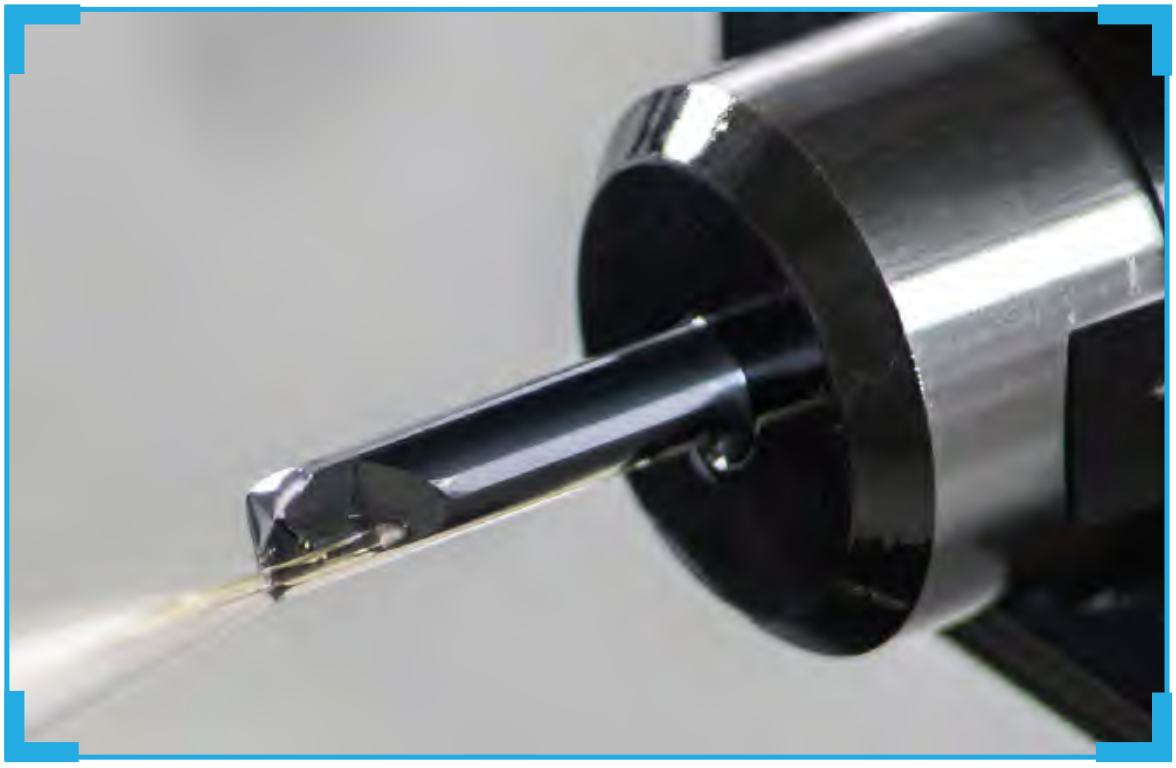
Right-hand shown

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

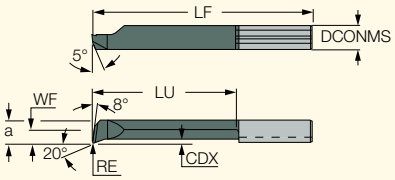


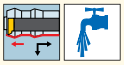


PICCOCUT

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







Right-hand shown

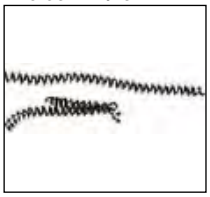
Designation	Dimensions								IC908
	DCONMS	DMIN	CDX(1)	LU	RE	LF	a	WF	
PICCO R/L 050.4-10C	4.00	4.00	0.30	10.00	0.10	24.00	3.50	1.50	•
PICCO R/L 050.4-20C	4.00	4.00	0.30	20.00	0.10	34.00	3.50	1.50	•
PICCO R/L 050.4-24C	4.00	4.00	0.30	24.00	0.10	38.00	3.50	1.50	•
PICCO R/L 050.4-28C	4.00	4.00	0.30	28.00	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

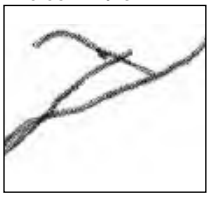
Stainless Steel 316L

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

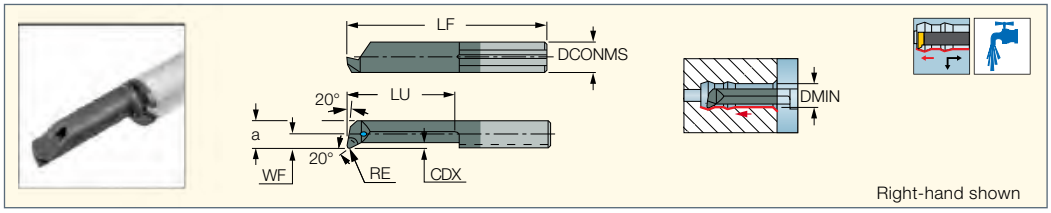


f= 0.05 mm/rev



PICCOJET
COOLANT THROUGH

PICJ R 050.20
Inserts with Inner Coolant Channel for Internal Turning and Chamfering Next to the Bottom of Blind Holes

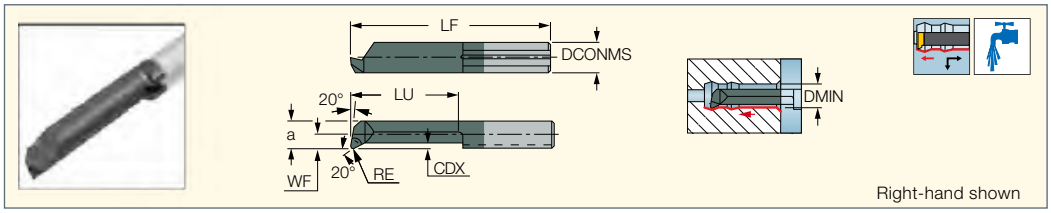


Designation	Dimensions								IC908
	DCONMS	DMIN	CDX(1)	LU	RE	LF	a	WF	
PICJ RT2020D20R05-10	4.00	2.00	0.10	9.00	0.05	24.00	1.70	-	●
PICJ RT2020D30R10-10	4.00	2.80	0.20	9.00	0.10	24.00	2.60	0.60	●
PICJ RT2020D40R10-16	4.00	4.00	0.30	15.00	0.10	30.00	3.50	1.50	●
PICJ RT2020D50R15-20	5.00	5.00	0.50	19.00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

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

PICCOCUT

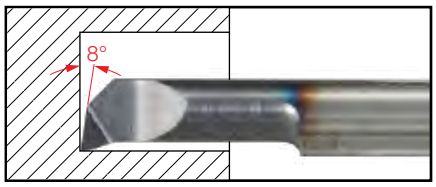
PICCO R 050.20
Inserts for Internal Turning and Chamfering Next to the Bottom of Blind Holes



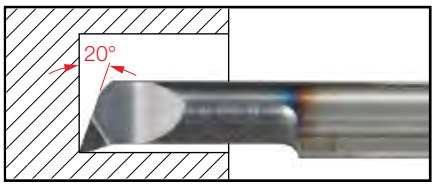
Designation	Dimensions								IC908
	DCONMS	DMIN	CDX(1)	LU	RE	LF	a	WF	
PICCO R 050.20.2-10	4.00	2.00	0.10	10.00	0.05	24.00	1.70	-	●
PICCO R 050.20.3-10	4.00	2.80	0.20	10.00	0.10	24.00	2.60	0.60	●
PICCO R 050.20.4-16	4.00	4.00	0.30	16.00	0.10	30.00	3.50	1.50	●
PICCO R 050.20.5-20	5.00	5.00	0.50	19.00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

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

PICCO 050...



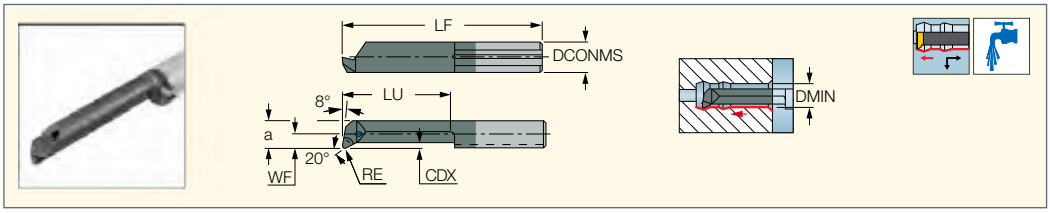
PICCO 050.20...



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

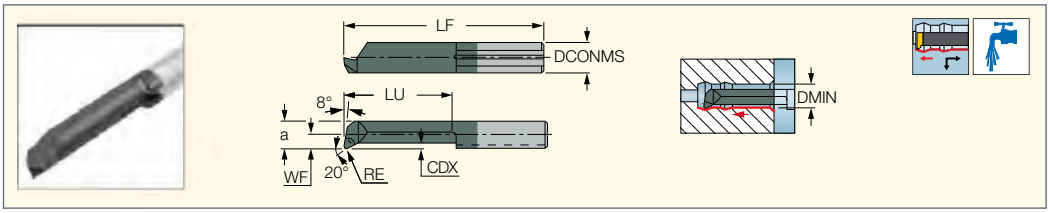
(1) Cutting depth maximum



PICCOCUT

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

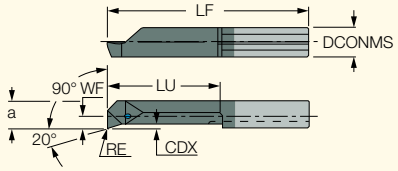


PICCOJET
COOLANT THROUGH

PICJ R/L 090

Inserts with Inner Coolant Channel for Internal Turning and Profiling



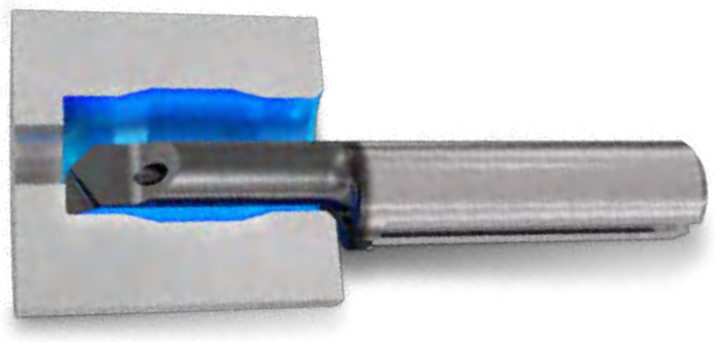


Right-hand shown

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

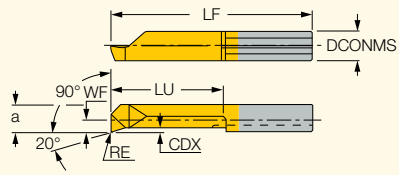


PICCOCUT

PICCO R/L 090

Inserts for Internal Turning and Profiling





Right-hand shown

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

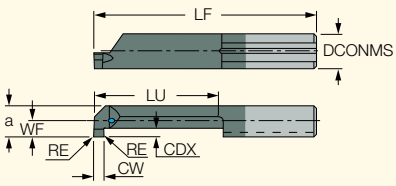


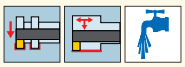
PICCOJET COOLANT THROUGH

PICJ R/L 002-007

Inserts with Inner Coolant Channel for Internal Grooving and Turning







Right-hand shown

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

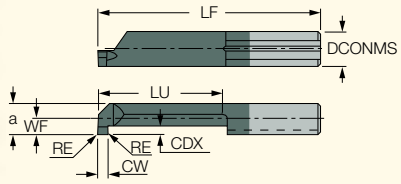


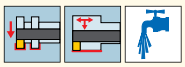
PICCOCUT

PICCO R/L 002-007

Inserts for Internal Grooving and Turning







Right-hand shown

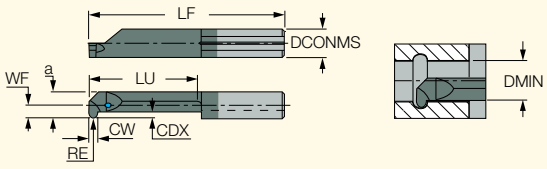
Designation	Dimensions									Tough ↔ Hard	
	DCONMS	DMIN	CDX(1)	LU	RE	LF	a	WF	CW	IC228	IC908
PICCO R 002.0050-5	4.00	2.00	0.40	5.00	0.00	19.00	1.80	0.20	0.50		•
PICCO R 002.0050-10	4.00	2.00	0.40	10.00	0.00	24.00	1.80	0.20	0.50		•
PICCO R/L 002.0050-15	4.00	2.00	0.40	15.00	0.00	29.00	1.80	0.20	0.50		•
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	•

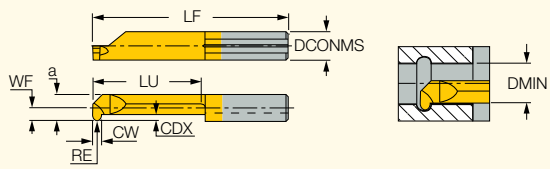
• Specify right- or left-hand bars
(1) Cutting depth maximum



PICCOCUT

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	•

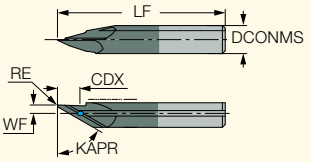
• Specify right- or left-hand bars
(1) Cutting depth maximum

PICCOJET
COOLANT THROUGH

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

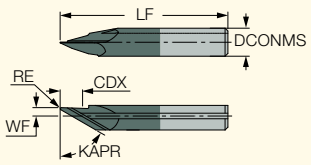


PICCOCUT

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	●

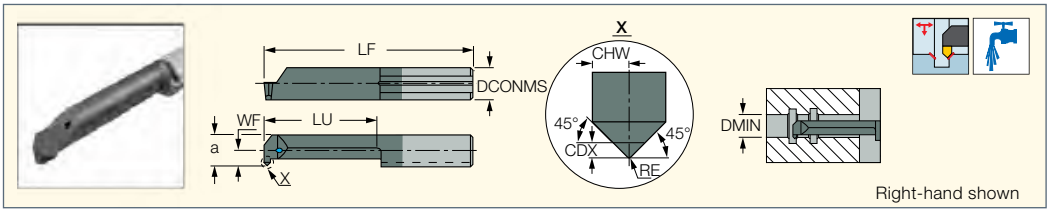
• Left hand inserts on request

(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	●

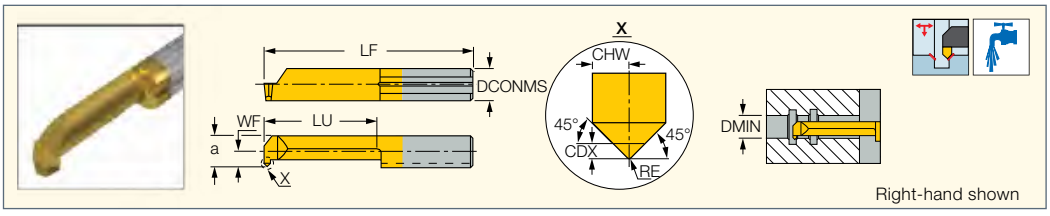
• Specify right- or left-hand bars
(1) Cutting depth maximum



PICCOCUT

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		●

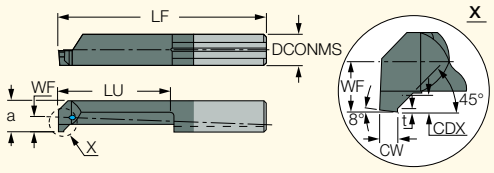
• Specify right- or left-hand bars
(1) Cutting depth maximum

PICCOJET
COOLANT THROUGH

PICJ R/L 070

Back Chamfering Inserts
with Inner Coolant Channel
for Pre-Parting Operations





Right-hand shown

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

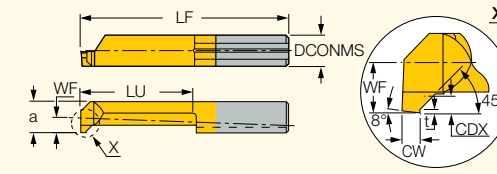


PICCOCUT

PICCO R/L 070

Back Chamfering Inserts for
Pre-Parting Operations





Right-hand shown

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	●

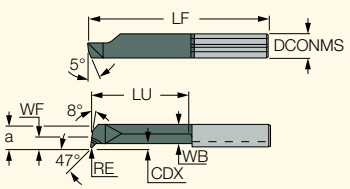
• All carbide bars with sharp corners • Specify right- or left-hand bars
(1) Cutting depth maximum

PICCOCUT

PICCO R/L 047

Inserts for Internal Deep Profiling





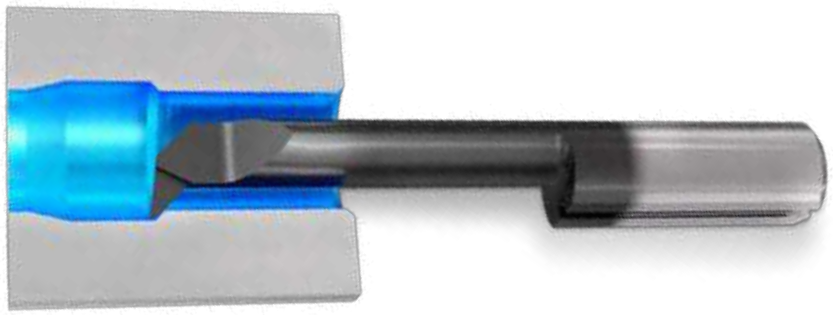


Right-hand shown

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

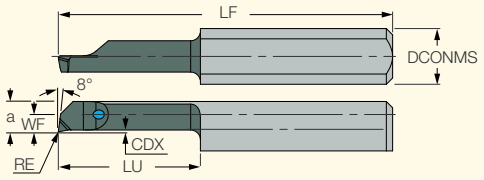


PICCOCUT

PICCO R/LM

Profiling Inserts with Coolant Channel Optimized for Machining Medical Parts







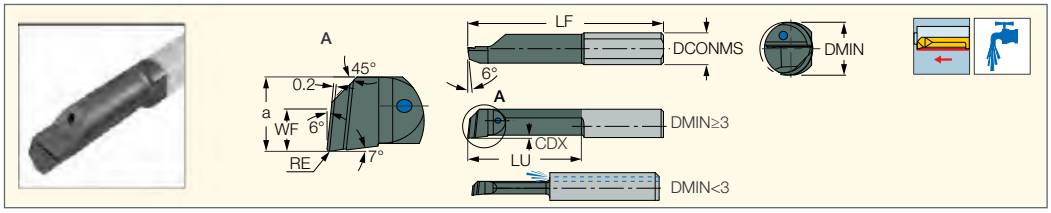
Designation	Dimensions								Tough ↔ Hard	
	DCONMS	DMIN	CDX(1)	LU	RE	LF	a	WF	IC908	IC909
PICCO R/LM050.05-2	4.00	0.50	0.02	2.00	0.02	20.00	0.40	0.20		●
PICCO LM050.08-4	4.00	0.80	0.03	4.00	0.02	20.00	0.70	0.20		●
PICCO RM050.08-4	4.00	0.80	0.03	4.00	0.02	20.00	0.70	0.40		●
PICCO R/LM050.1-5	4.00	1.00	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

PICCOCUT

PICCO R/LX050
Reinforced Boring Inserts
with Internal Coolant Holes

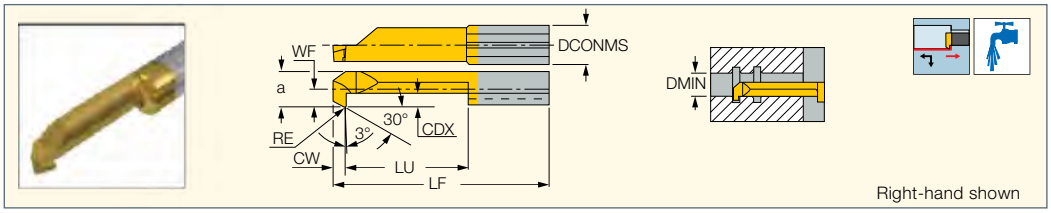


Designation	Dimensions								IC908
	DCONMS	DMIN	CDX(1)	LU	RE	LF	a	WF	
PICCO R/LX050.2-5R15	4.00	2.00	0.10	5.00	0.15	19.00	1.80	-	•
PICCO R/LX050.2-10R05	4.00	2.00	0.10	10.00	0.05	24.00	1.80	-	•
PICCO R/LX050.2-10R15	4.00	2.00	0.10	10.00	0.15	24.00	1.80	-	•
PICCO R/LX050.3-16R10	4.00	3.00	0.15	16.00	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

PICCOCUT

PICCO R/L 080
Inserts for Internal Back Turning



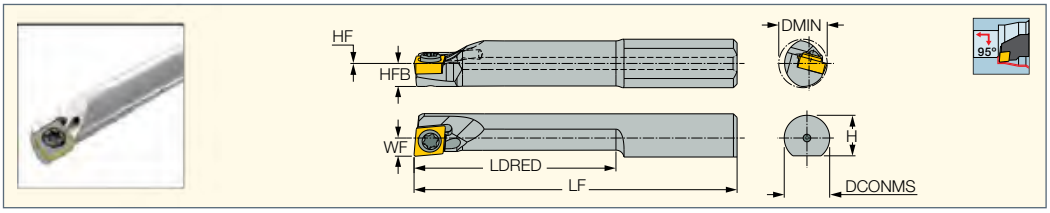
Designation	Dimensions									IC228
	DCONMS	DMIN	CDX(1)	LU	RE	LF	a	WF	CW	
PICCO R/L 080.0003-15	4.00	3.00	0.50	14.00	0.10	30.00	2.60	0.60	1.50	•
PICCO R/L 080.0003-20	4.00	3.00	0.50	19.00	0.10	34.00	2.60	0.60	1.50	•
PICCO R/L 080.0004-15	4.00	4.00	0.80	14.00	0.15	30.00	3.50	1.50	1.50	•
PICCO R/L 080.0004-25	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



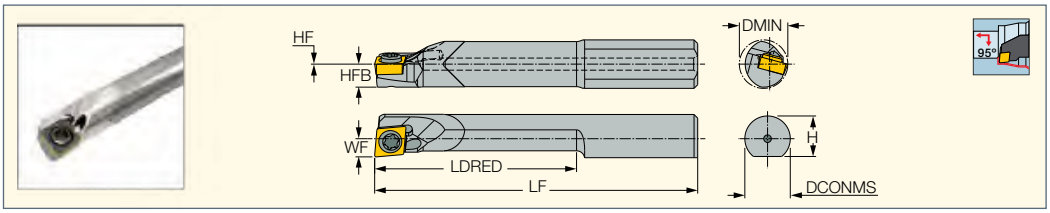
Designation	DCONMS	DMIN	LDRED	LF	WF	H	HF	HFB	CSP(1)	MIID(2)		
PICIN A05-T10-SCLCR/L-03	5.00	4.50	10.0	25.00	1.85	4.5	0.0	2.1	1	CCGT 03X101-F1P	CSTA-1.6	T-6/5
PICIN A05-T20-SCLCR/L-03	5.00	4.50	20.0	35.00	1.85	4.5	0.0	2.1	1	CCGT 03X101-F1P	CSTA-1.6	T-6/5
PICIN A06-T15-SCLCR/L-03	6.00	6.00	15.0	30.00	2.25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



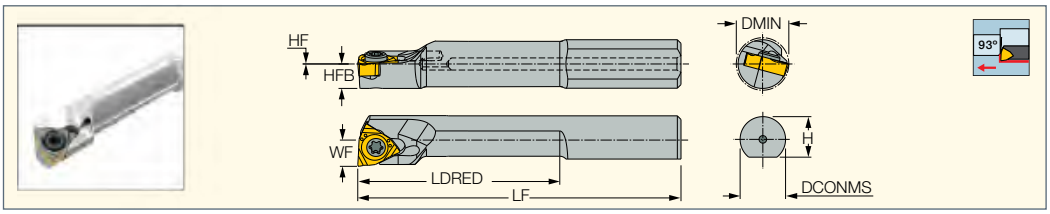
Designation	DCONMS	DMIN	LDRED	LF	WF	H	HF	HFB	CSP(1)	MIID(2)		
PICIN E05-T20-SCLCR/L-03	5.00	4.50	20.0	35.00	1.85	4.5	0.0	2.1	1	CCGT 03X101-F1P	CSTA-1.6	T-6/5
PICIN E06-T25-SCLCR/L-03	6.00	6.00	25.0	40.00	2.25	5.4	0.0	2.9	1	CCGT 03X101-F1P	CSTA-1.6	T-6/5
PICIN E05-T30-SCLCR/L-03	5.00	4.50	30.0	45.00	1.85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

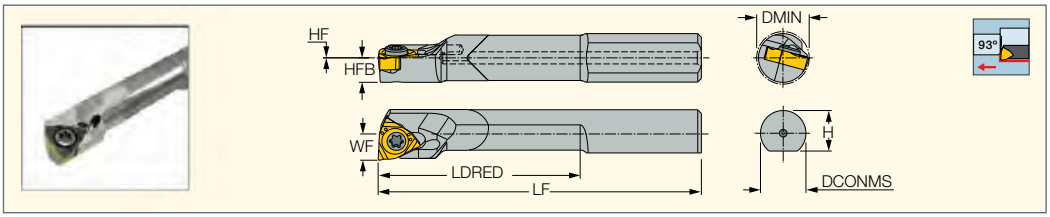
- Use right-hand WBMT 06...R inserts on left-hand tools and left-hand WBMT 06...L inserts on right-hand tools.

(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

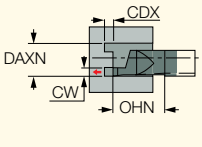
PICCO-JET

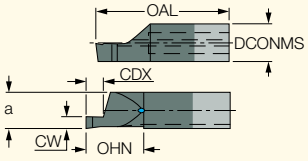
PICCO-CUT

PICCOJET COOLANT THROUGH

PICJ-010/610
(Face Grooving)
Inserts with Internal Coolant Channel for Face Grooving



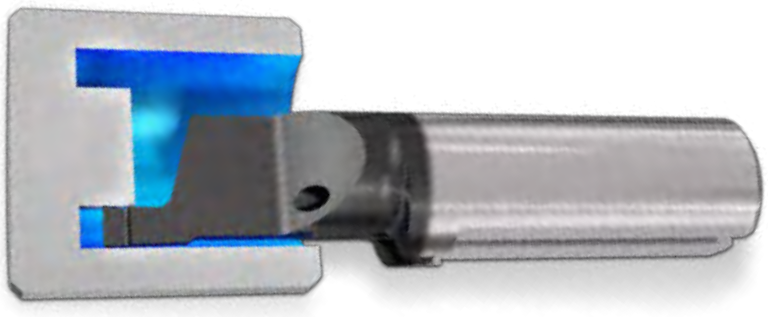






Designation	Dimensions							IC908	Recommended Machining Data
	DAXN[1]	CW	CDX	DCONMS	OHN[2]	OAL	a		f face-groove (mm/rev)
PICJ RF10D6T1.5-10	6.0	1.00	1.50	6.00	11.0	26.00	5.20	•	0.01-0.04
PICJ RF15D6T2.0-10	6.0	1.50	2.00	6.00	11.0	26.00	5.20	•	0.01-0.04
PICJ LF15D8T2.5-20	8.0	1.50	2.50	7.00	21.0	35.00	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

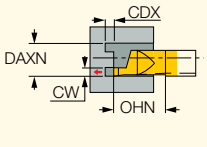
• Only right-hand inserts are available as standard • All inserts are with sharp corners
[1] Minimum axial grooving diameter [2] Minimum overhang

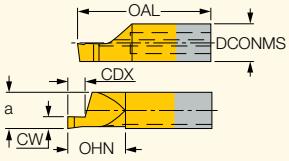


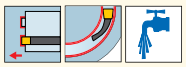
PICCOCUT

PICCO-010/610
(Face Grooving)
Inserts for Face Grooving





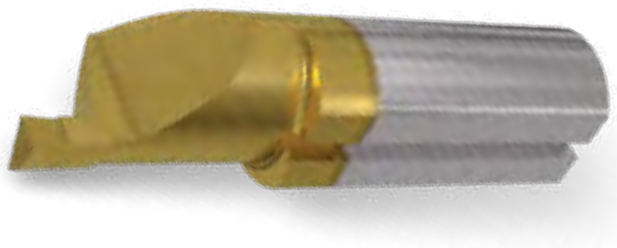




Right-hand shown

Designation	Dimensions							IC228	Recommended Machining Data
	DAXN(1)	CW	CDX	DCONMS	OHN(2)	OAL	a		f face-groove (mm/rev)
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

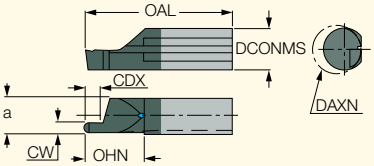
• Only right-hand inserts are available as standard • All inserts are with sharp corners
(1) Minimum axial grooving diameter (2) Minimum overhang



PICCOJET
COOLANT THROUGH

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

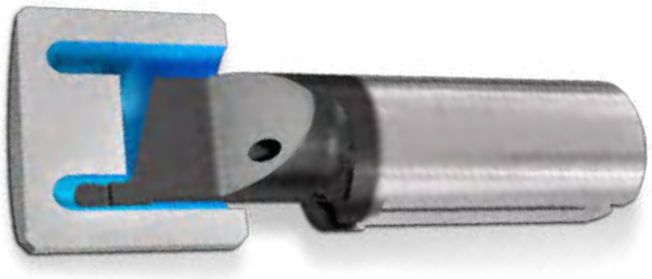






Designation	Dimensions								IC908	Recommended Machining Data
	DAXN[1]	CW	CDX	DCONMS	OHN[2]	OAL	a	RE		f face-groove (mm/rev)
PICJ RF10D8T2.0-10	8.0	1.00	2.00	7.00	11.0	26.00	5.90	0.50	•	0.01-0.04
PICJ RF10D8T2.0-20	8.0	1.00	2.00	7.00	20.0	35.00	5.90	0.50	•	0.01-0.04
PICJ RFP16D8T3-10	8.0	1.60	3.00	7.00	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

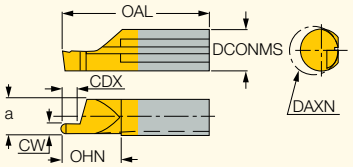
• Only right-hand inserts are available as standard, left-hand inserts on request
[1] Minimum axial grooving diameter
[2] Minimum overhang



PICCOCUT

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







Right-hand shown

Designation	Dimensions DAXN(1)	CW	CDX	DCONMS	OHN(2)	OAL	a	RE	IC1008	Recommended Machining Data f face-groove (mm/rev)
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

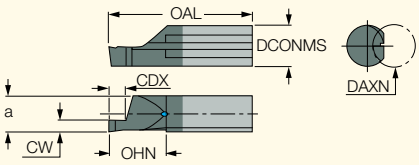
(1) Minimum axial grooving diameter

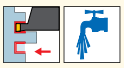
(2) Minimum overhang

PICCOJET COOLANT THROUGH

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







Designation	Dimensions DAXN(1)	CW	CDX	DCONMS	OHN(2)	OAL	a	IC908	Recommended Machining Data f face-groove (mm/rev)
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

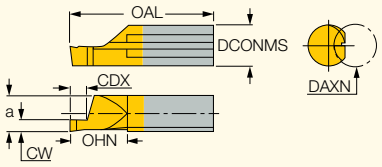
(2) Minimum overhang



PICCOCUT

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





Right-hand shown

Designation	Dimensions DAXN(1)	CW	CDX	DCONMS	OHN(2)	OAL	a	IC1008	Recommended Machining Data 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

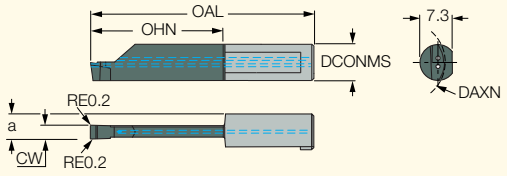
- Only right-hand inserts are available as standard, left-hand inserts on request
- All carbide inserts are with sharp corners

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

PICCOJET
COOLANT THROUGH

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

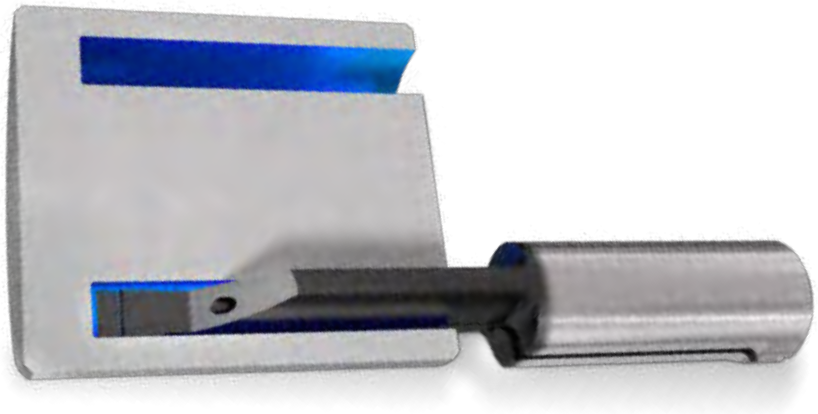




Designation	Dimensions DAXN(1)	CW	DCONMS	OHN(2)	OAL	a	IC908	Recommended Machining Data f face-groove (mm/rev)
PICJ RF30D16T10-10	16.0	3.00	8.00	10.0	30.00	5.50	●	0.01-0.05
PICJ RF30D16T20-20	16.0	3.00	8.00	20.0	40.00	5.50	●	0.01-0.05
PICJ RF40D16T20-20	16.0	4.00	8.00	20.0	40.00	6.00	●	0.01-0.05
PICJ 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

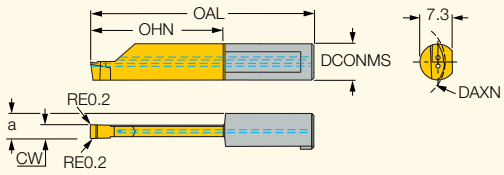


PICCOCUT

PICCO-016/020 (Face Grooving)

Inserts with Coolant Channel for Deep Face Grooving





Right-hand shown

Designation	Dimensions DAXN(1)	CW	DCONMS	OHN(2)	OAL	a	IC1008	Recommended Machining Data f face-groove (mm/rev)
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

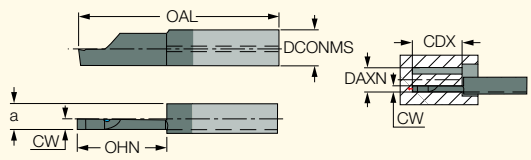
(2) Minimum overhang

PICCOJET COOLANT THROUGH

PICJ-015 (Face Grooving)

Inserts with Internal Coolant Channel for Deep Face Grooving



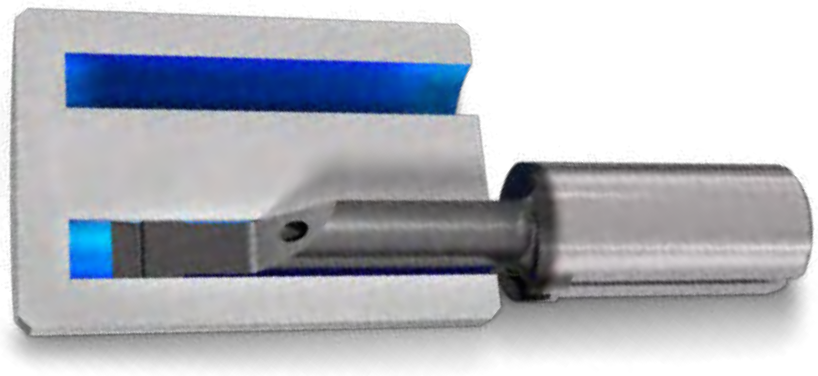


Designation	Dimensions DAXN(1)	CW	CDX	DCONMS	OHN(2)	OAL	a	IC908	Recommended Machining Data f face-groove (mm/rev)
PICJ RF25D8T20-20	8.0	2.50	20.00	7.00	20.0	35.00	5.90	●	0.01-0.04
PICJ RF30D8T20-20	8.0	3.00	20.00	7.00	20.0	35.00	5.90	●	0.02-0.05
PICJ RF30D8T30-30	8.0	3.00	30.00	7.00	30.0	45.00	5.90	●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

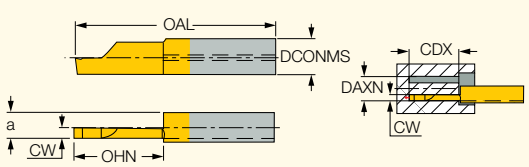
(2) Minimum overhang



PICCOCUT

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





Right-hand shown

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

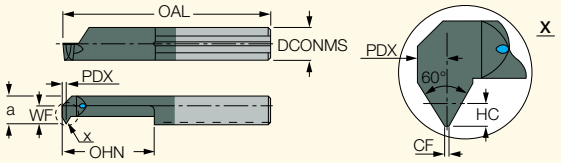
PICCO-JET

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 RTH7I0.50D024	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 RTH9I0.50D032	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 RTH14I0.50D040	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 RTH14I0.50D050	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 RTH14I0.75D050	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/LTH14I1.00D048	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 RTH19I1.00D048	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 RTH14I1.00D060	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 RTH21I1.00D060	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 RTH14I1.25D060	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 RTH14I1.50D060	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/LTH14I1.5D070	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	●

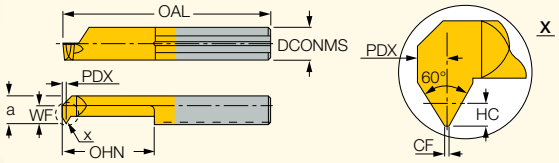
- Solid tools are suitable for PICCO-N / PICCO ACE-N type holders only
- DIN13 , ISO 68-1, ISO 965 (1&2) - Internal tolerance: 6H
- ANSI/ASME B1.1 - Internal tolerance: 2B

(1) Minimum overhang
(2) Thread pitch minimum (mm)
(3) Thread pitch maximum (mm)
(4) Threads per inch minimum
(5) Threads per inch maximum

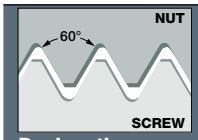
PICCOCUT

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





Right-hand shown



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

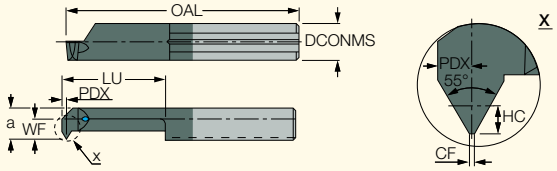
(1) Minimum overhang (2) Thread pitch minimum (mm) (3) Thread pitch maximum (mm) (4) Threads per inch minimum (5) Threads per inch maximum

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

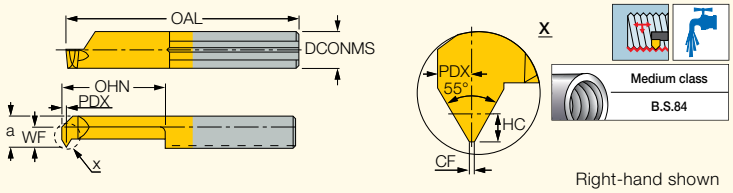
(2) Threads per inch minimum

PICCOCUT

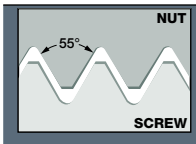
PICCO-55°-Thread

Inserts for 55° Internal Thread Profile





Right-hand shown



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

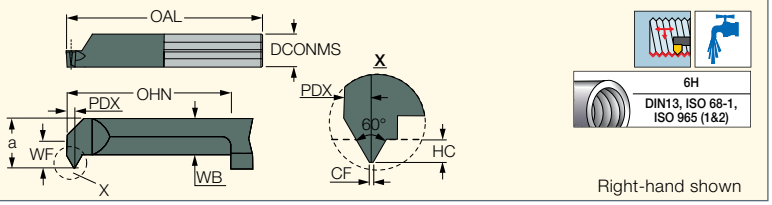
(1) Minimum overhang (2) Threads per inch minimum (3) Threads per inch maximum

PICCOCUT

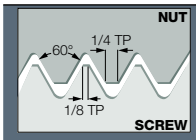
PICCO ISO Full Profile

ISO Standard Inserts for Full Profile Threads





Right-hand shown



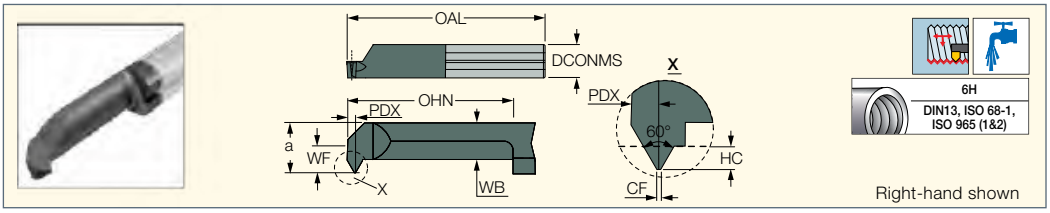
Designation	Dimensions											IC908
	DCONMS	DMIN	HC	CF	PDX	WF	a	WB	OHN(1)	OAL	TP(2)	
PICCO R/L 105.0510-15	5.00	4.80	0.54	0.12	0.60	1.90	4.40	3.30	15.0	30.00	1.000	●
PICCO R/L 106.0612-15	6.00	6.00	0.67	0.15	0.70	2.30	5.30	3.40	15.0	30.00	1.250	●
PICCO R/L 106.0815-15	6.00	6.00	0.81	0.18	0.80	2.30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

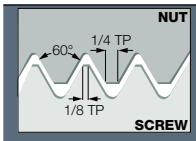
(1) Minimum overhang

(2) Thread pitch

PICCOCUT

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



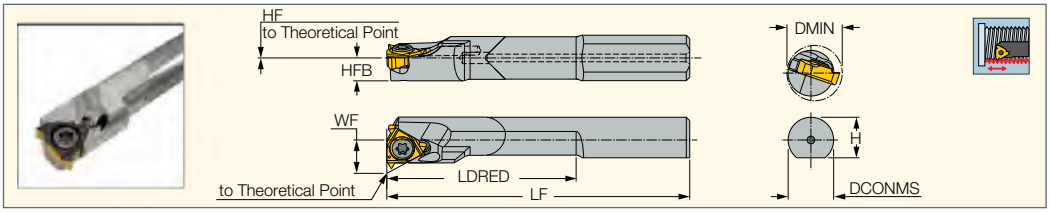


Designation	Dimensions DCONMS	DMIN	HC	CF	PDX	WF	a	OHN(1)	WB	OAL	TP(2)	IC908
PICCO R/L 104.0205-15	5.00	4.00	0.27	0.06	0.40	1.50	3.50	15.0	2.40	30.00	0.500	●
PICCO R/L 105.0205-15	5.00	5.00	0.27	0.06	0.40	1.90	4.40	15.0	3.30	30.00	0.500	●
PICCO R/L 105.0407-15	5.00	5.00	0.40	0.09	0.50	1.90	4.40	15.0	3.30	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
INDEXABLE INSERTS

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



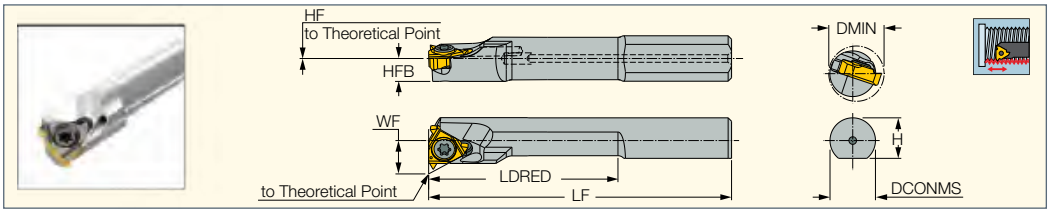
Designation	DCONMS	DMIN	LDRED	H	HFB	WF	HF	LF	CSP(1)	MIID(2)		
PICIN E06-T25-MGSIL-06	6.00	7.30	25.0	5.4	3.0	4.41	0.0	40.00	1	06IL A 55	SR 14-552	T-6/5
PICIN E06-T25-MGSIR-06	6.00	7.30	25.0	5.4	3.0	4.41	0.0	40.00	1	06IR A 55	SR 14-552	T-6/5

- 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
INDEXABLE INSERTS

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

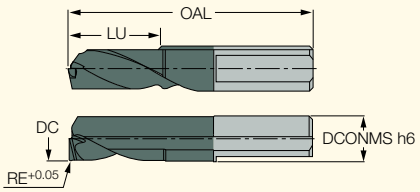
PICCO-SUMOCHAM

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 DCONMS	DC	LU	OAL	RE	IC908
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	●

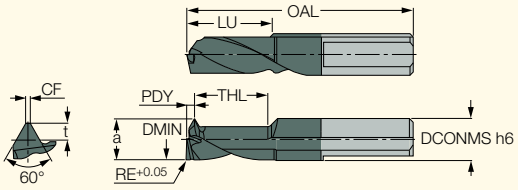
- Dmin can be 0.1 mm smaller by shifting tool center
- Applications: drilling; face turning; internal chamfering; internal turning/ boring; internal profiling; external chamfering; external turning

PICCOMFT

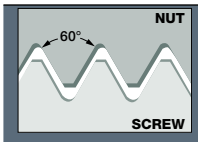
PICCO-MFT

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





Right-hand shown



Designation	Dimensions DCONMS	DMIN	LU	TPN(2)	TPX(3)	TPIN(4)	TPIX(5)	t	a	CF	THL	OAL	PDY	RE	IC908
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

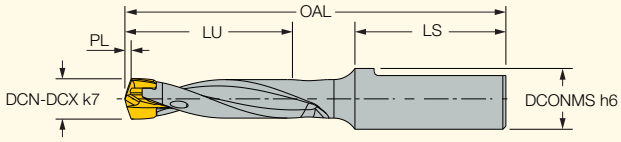
Recommended hole diameter for pre-thread hole

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	4		M4.5x0.5		10-32UNF
	ICP/FCP/HCP	4.1		M4.5x0.35		
	ICP/FCP/HCP/QCP	4.2	M5x0.8	M4.5x0.2		
				M4.5x0.25		
	ICP/FCP/HCP	4.3		M5x0.75		
	ICP/FCP/HCP	4.4			12-24UNC	
SCD 045-017-060 PICCO 3D	ICP/FCP/QCP/HCP	4.5		M5x0.5		
	ICP/FCP/HCP/QCP	4.6				12-28 UNF
	ICP/FCP/HCP	4.7		M5x0.35		
	ICP/FCP/HCP/QCP	4.8		M5x0.2		
				M5x0.25		
				M5.5x0.75		
SCD 050-020-060 PICCO 3D	ICK/ICM/ICP/FCP/HCP/QCP	5	M6x1.0	M5.5x0.5		
	ICN/ICP/ICM/QCP/HCP/FCP	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		
	ICN/ICM/ICP/FCP/HCP	5.4				1/4-28UNF
SCD 055-020-060 PICCO 3D	ICK/ICM/ICP/FCP/HCP/QCP	5.5		M6x0.5		
	ICM/ICP/FCP/HCP	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			5/16-18UNC	
		6.8	M8x1.25			
		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		M8x0.5		
		7.8	M9x1.25			
		7.9			3/8-16 UNC	
SCD 080-029-080 PICCO 3D	ICK/ICM/ICP/FCP/HCP/QCP	8		M9x1		
		8.4				3/8-24 UNF
		8.5	M10x1.5			
		8.8		M10x1.25		
		9		M10x1		
		9.2		M10x0.75		
		9.3			7/16-14 UNC	
		9.5	M11x1.5			
		9.8				7/16-20 UNF
	IHP/ICN/ICK/ICM/ICP/FCP/HCP/QCP	10		M11x1		

PICCOSUMOCHAM

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

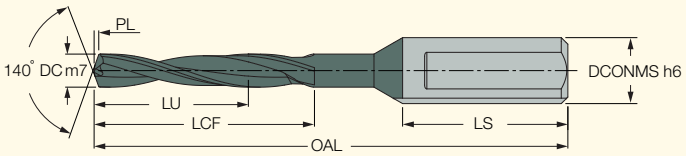
- Do not mount smaller drilling heads other than the specified range of the drill body

[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





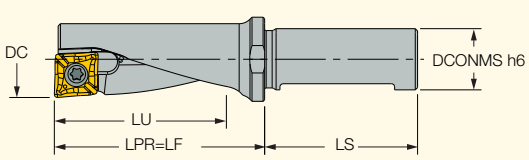
Designation	Dimensions							IC908
	DC	DCONMS	LU	LCF	OAL	LS	PL	
SCD 030-014-060 PICCO 3D	3.00	6.00	14.00	21.0	43.00	15.0	0.500	●
SCD 035-014-060 PICCO 3D	3.50	6.00	14.00	21.0	43.00	15.0	0.600	●
SCD 040-017-060 PICCO 3D	4.00	6.00	17.00	25.0	46.00	15.0	0.600	●
SCD 045-017-060 PICCO 3D	4.50	6.00	17.00	25.0	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





Right-hand shown

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

MINIATURE PART MACHINING
PICCO LINES
METRIC CATALOG



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E-CAT

MACHINING INTELLIGENTLY

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