

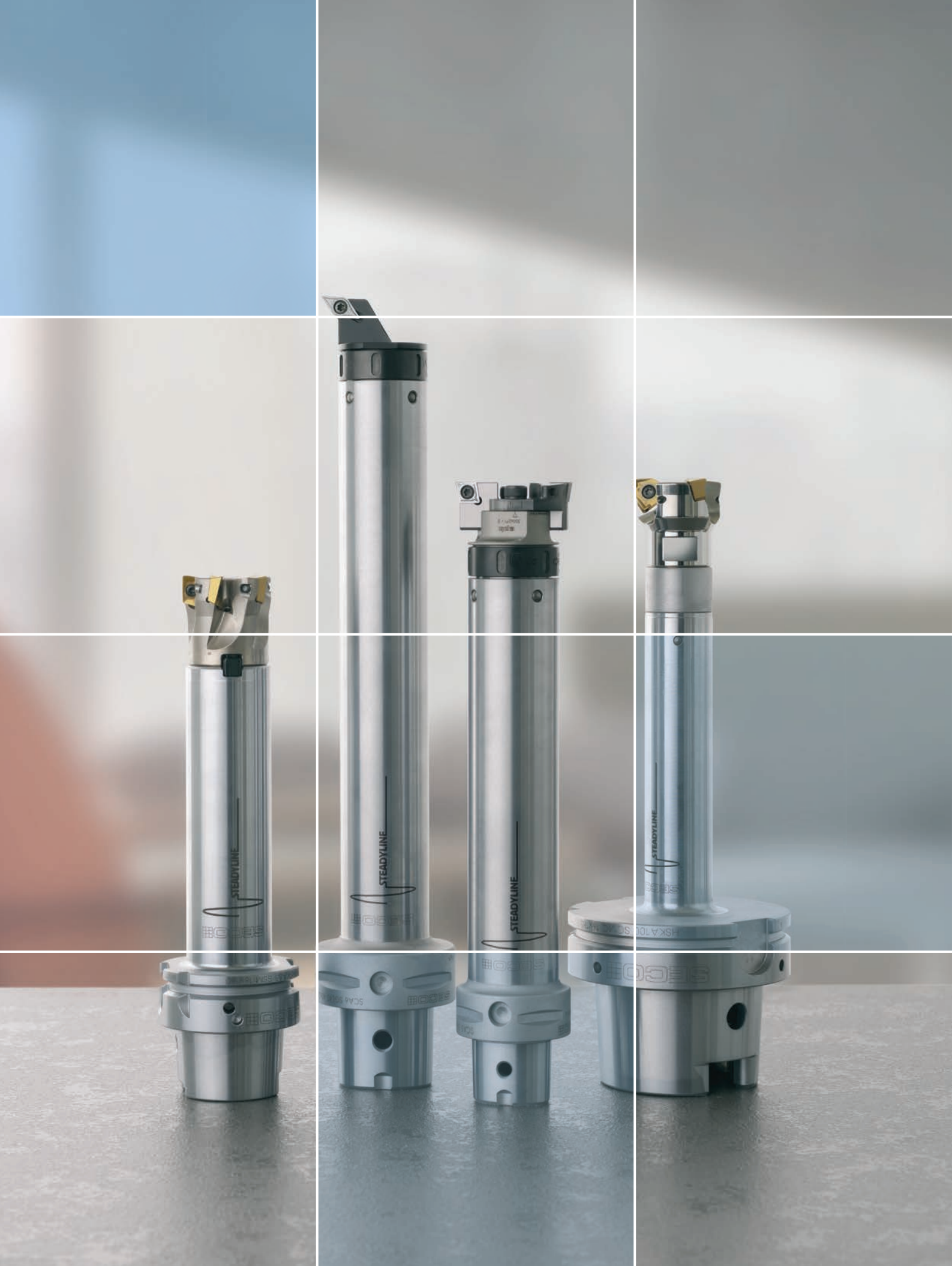
**STEADYLINE®  
FOR TURNING,  
BORING &  
MILLING**



**REDUCE VIBRATIONS &  
INCREASE PRODUCTIVITY**

*THIEME*

**SECO** 



# OVERCOME TOOL OVERHANG CHALLENGES

When using long overhang tools to machine difficult-to-access areas, such as deep cavities or sections of large, complex monolithic workpieces, vibration often becomes an issue. Unless, you use the patented Steadyline® damped tooling from Seco®.

Steadyline® products, which include cost-effective milling holders as well as turning and boring bars, perform typical long overhang operations twice as fast as traditional tools. Plus, these highly productive vibration-damping solutions offer high metal-removal rates, smooth part surface finishes and long tool life – all while reducing machine tool stress.

In addition to using Steadyline® products to optimise your processes, you can also rely on our applications expertise – which encompasses all metal-working industry segments – to further strengthen your competitive advantage. Overall, when you work with Seco®, you experience a true partnership based on trust, respect and communication. With 4,100 team members in over 40 countries, we are a globally networked resource that is dedicated to solving your challenges and supporting your operations.

Visit [www.secotools.com](http://www.secotools.com) for all the latest information, machining data, manufacturing techniques and other developments on Steadyline® products.

Introduction .....	3
Vibration challenges .....	4
Principle of Steadyline® .....	5
Turning and Boring	
Steadyline® turning range .....	6
Case studies turning.....	10

Turning	
Steadyline® turning .....	12
Steadyline® thread turning .....	38
Steadyline® MDT .....	43
Boring	
Boring head solutions .....	48
GL heads for rough boring .....	50
GL heads for fine boring .....	52

Milling	
Steadyline® milling range .....	54
Case studies milling .....	55
Milling – tool holders	
HSK-A .....	56-57
DIN 69871-ADB/TF .....	58-60
BT-JIS-ADB/TF .....	61-64
Seco-Capto™ .....	65-66
Custom Tooling .....	67

# VIBRATION CHALLENGES



## IMPACT OF MACHINING VIBRATIONS UNDERSTANDING YOUR CHALLENGES

As large, complex workpieces with deep cavities have become more common, manufacturers must contend with machining difficult-to-access features that require tools with long overhangs. Traditional approaches are not economically acceptable in these scenarios, as high levels of vibration impact the cutting process.

Negative effects of vibrations include:

- Poor surface quality
- Unacceptable inaccuracy
- Excessive noise
- Disproportionate tool wear
- Machine tool damage (e.g. spindle, etc.)
- Reduced material removal rate
- Increased costs from longer production time
- Waste of both scrap material and energy



Machined with Steadyline®



Machined with a conventional holder, equivalent dimension

## ACHIEVING STABLE CONDITIONS OUR SOLUTION: STEADYLINE®

Steadyline® vibration damping holders drastically improve the dynamic rigidity of milling, turning and boring assemblies. This allows the use of much higher cutting data, with quieter operation and optimum stability.

Through a patented passive-dynamic damping system, Steadyline® increases productivity, improves surface finish and boosts both tool and spindle life. Incorporating Steadyline® into your operations will increase output and reduce operating cost.



## SIMPLE AND EFFICIENT STEADYLINE® OPERATING PRINCIPLE

In the Steadyline® system the vibration absorber is positioned where deflection is highest, at the front of the bar. The absorber damps vibrations as soon as they are transmitted from the cutting tool to the body of the bar. This prevents them from spreading along the bar, thus limiting the deflection of the tool. The result is greater rigidity that ensures high stability even with extreme cutting conditions that dramatically increase the chip removal rate.

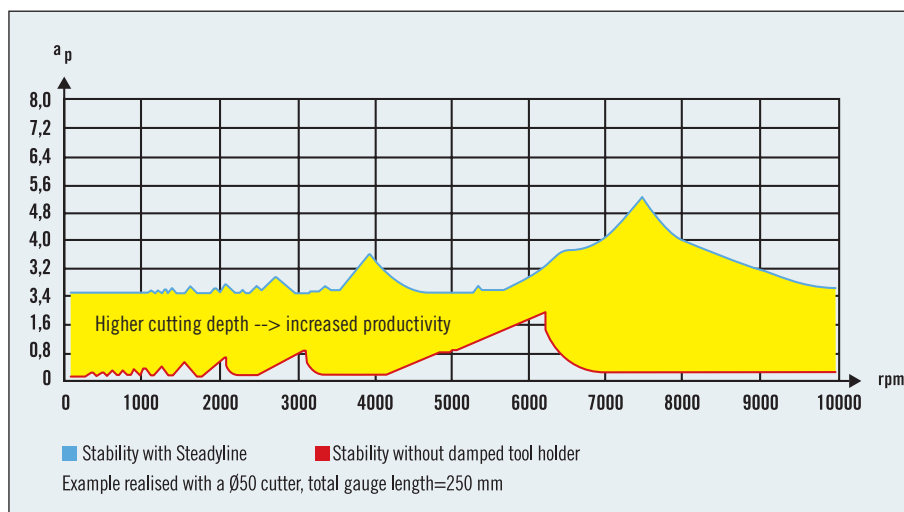


Conventional holder

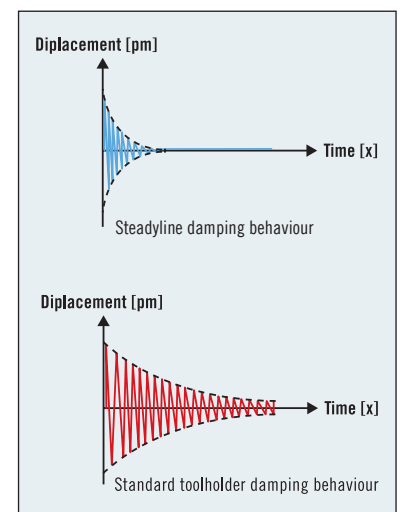


Holder with anti-vibration system

### COMPARISON BETWEEN A CLASSIC MODULAR SYSTEM AND A STEADYLINE® HOLDER

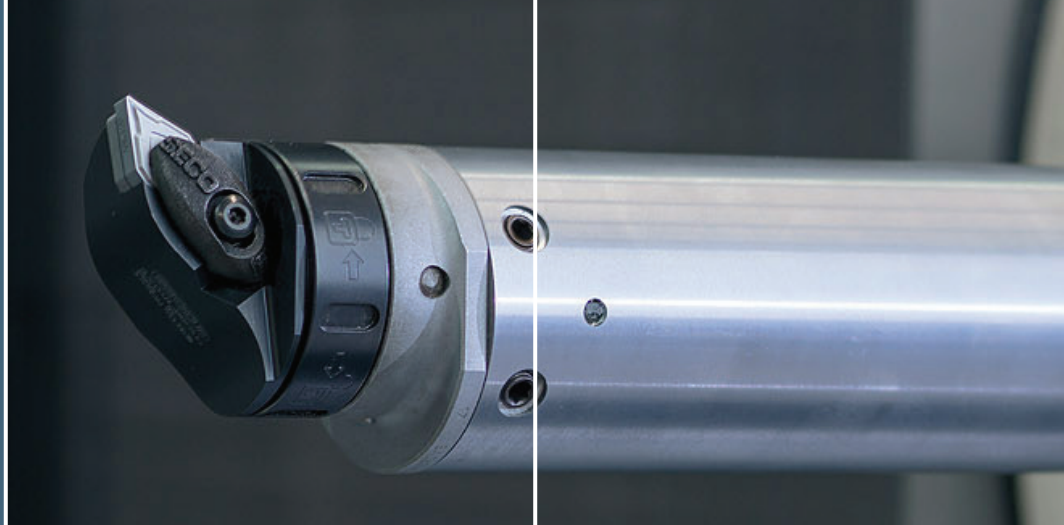


### DAMPING BEHAVIOUR



This data represents measurements of the maximum depth at which the holder is stable, at different speeds. At a given speed, the Steadyline® holder's optimal depth of cut ( $a_p$ ) can be 2 to 4 times higher than what would be used with a modular system, and the surface finish is improved dramatically. Higher RPMs can also be reached in stable conditions.

# TURNING & BORING



## FLEXIBLE & EFFICIENT TOOL CHANGE SYSTEM TURNING RANGE WITH A MODULAR CONNECTION (GL & BA)

### STEADYLINE® BAR

- Available are over 75 standard Steadyline® bars
- Available in six sizes:  $\varnothing 32$  mm,  $\varnothing 40$  mm,  $\varnothing 50$  mm,  $\varnothing 60$  mm,  $\varnothing 80$  mm and  $\varnothing 100$  mm, metric and imperial
- Available in three lengths: 6xD, 8xD, 10xD
- Shank connection: Seco-Capto™, HSK-T/A and cylindrical

### GL TURNING HEADS AND GL CONNECTION

GL turning heads offer a compact, flexible and modular tool changing system for internal applications, especially for Steadyline® boring and turning. The GL connection is based on a precisely ground 'tapered quadrilobe' centering system, firmly locked with a fine pitched nut to the Steadyline® bar.

The compact GL turning head preserves the damping strength of the Steadyline® system, making it one of the most stable solutions on the market for tool overhang challenges by reducing vibrations and increasing productivity.

### JET STREAM TOOLING® GL TURNING HEADS

The JET GL turning head provides the Steadyline® system with further flexibility and efficiency with its integrated Jetstream Tooling® within the GL turning head. JET GL turning heads use a multifunction coolant clamp for successful integration.

- More than 170 GL turning heads
- Available in three connection sizes: GL32, GL40, GL50
- Cutting directions: left and right
- Negative inserts for roughing: CN, DN, WN
- Positive inserts for finishing: CC, DC, TC, VB
- CBN inserts: RN, TN
- Heads for threading inserts
- Heads for MDT (2 to 4 mm) grooving with Jetstream Tooling
- 40 Jet GL turning heads

Body sizes:  
 $\varnothing 32$ ,  $\varnothing 40$ ,  $\varnothing 50$ ,  $\varnothing 60$ ,  
 $\varnothing 80$ ,  $\varnothing 100$  mm

Modular connection:  
GL32, GL40, GL50,  
BA060, BA080, BA100



Shank connection:  
Machine sides  
HSK-T/A63 and  
HSK-T/A100,  
Seco-Capto™ (C4,  
C5, C6, C8) and  
Cylindrical  $\varnothing 32$ ,  
 $\varnothing 40$ ,  $\varnothing 50$ ,  $\varnothing 60$ ,  
 $\varnothing 80$ ,  $\varnothing 100$  mm

Lengths:  
6xD, 8xD, 10xD

Broad choice of  
turning, boring,  
threading and  
MDT grooving  
heads



Coolant clamp



JET GL turning heads

# TURNING & BORING

## CUSTOMER BENEFITS

- **STABLE:** The compact and short GL turning heads enhance the damping function by remaining close to the Steadyline® damping mass.
- **MODULAR:** Inventory reduction can be achieved using different types and styles of Steadyline® bars equipped with suitable GL turning heads.
- **ACCURATE:** The taper quadrilobe coupling produces a strong self-centering connection with repeatability within  $\pm 0.002$  mm with identical conditions.
- **EFFICIENT:** Ensures a quick and firm connection, which drastically decreases head-changing time and increases productivity.
- **FLEXIBLE:** The quadrilobe design enables 180-degree orientation changes to the turning head, allowing left- and right-hand tools depending on the machining system.
- **LONGEVITY:** Jetstream Tooling provides enhanced chip breaking and higher tool life, especially when machining superalloys.

Boring heads with GL machine side connection HSK-T/A and Seco-Capto™ bars are also designed for rotating and boring applications. Rough and fine boring heads with GL machine side connections are available. For more details, please visit the chapter "Boring."

## BA-CONNECTION

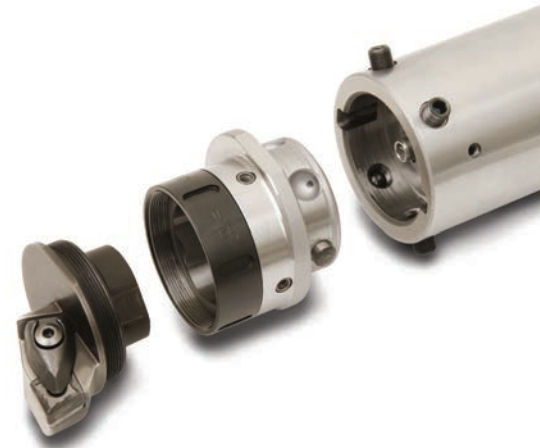
On larger sizes of Steadyline® bars (from  $\varnothing 60$  mm), BA-to-GL adapters are used to mount GL50 turning heads. Therefore, tool inventory can be reduced as current GL50 turning heads can be mounted on larger size Steadyline® bars.

BA-to-GL adapters are available for bars  $\varnothing 60$  mm,  $\varnothing 80$  mm and  $\varnothing 100$  mm, with two offset sizes: a short one for lower bore sizes, and a wider one to create additional space between the bar and the wall of the bore to evacuate the chips.

- Available in three sizes:  $\varnothing 60$  mm,  $\varnothing 80$  mm and  $\varnothing 100$  mm
- Each has two offset sizes for lower bore sizes and additional chip space
- Flexibility for chip space and minimum bore diameter
- Using existing GL50 turning heads for reduced tool inventory

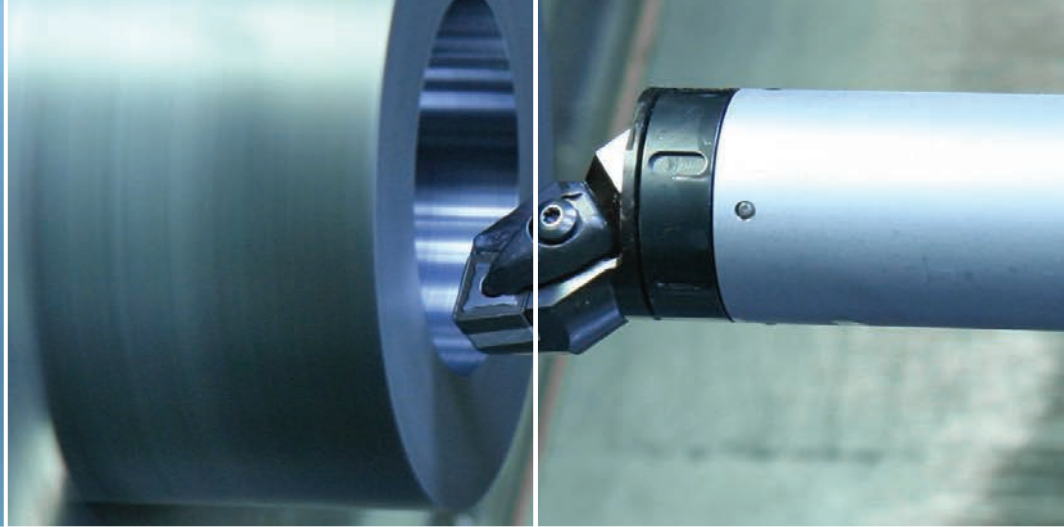


GL connection for Steadyline® bars  $\varnothing 32$ ,  $\varnothing 40$ ,  $\varnothing 50$  mm



BA connection for Steadyline® bars  $\varnothing 60$ ,  $\varnothing 80$ ,  $\varnothing 100$  mm

# TURNING & BORING

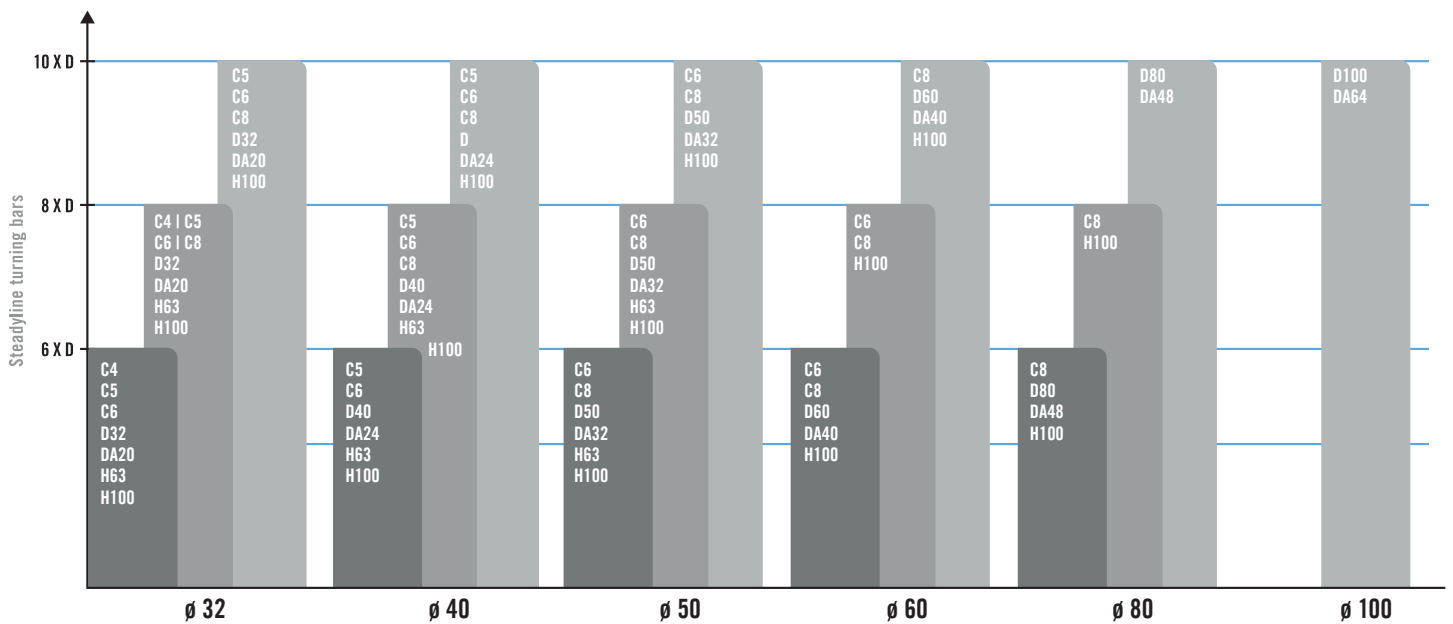


## OPTIMISING YOUR RETURN ON INVESTMENT TURNING RANGE SELECTION

To achieve perfect application processes with Steadyline®, Seco® offers a wide range of inserts for turning, threading and grooving. Our inserts include adapted chip-breaker geometries and a selection of solid carbide grades and PCBN, ensuring a perfect match for every application. This versatility boosts productivity and allows manufacturers to adopt greater degrees of flexibility in their processes when machining materials ranging from aluminium to hardened steel.



### RANGE SELECTION



D = Cylindrical, DA = Cylindrical inch, H = HSK



# TURNING & BORING

## MACHINE CLAMPING RECOMMENDATIONS

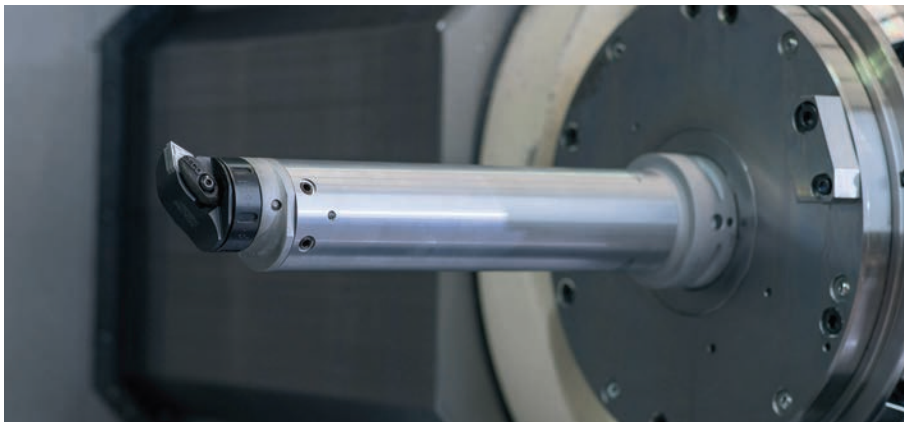
Our first recommendation for clamping the bars onto the machines is to use bars with Seco-Capto™ machine side connections.

Second choice is the bars with HSK-T/A machine side connections, as both these solutions provide several benefits:

- Maximum stability thanks to the taper-face system and higher bending resistance
- High positioning accuracy of cutting edge, etc.

While using the third choice, the cylindrical bars, Seco® strongly recommend to clamp on the marked cylindrical clamping area ensuring the full 4xD clamping lengths using split sleeves / boring holders.

While preparing your machine, ensure that your tool is correctly and safely clamped. Also note that it is important to never clamp directly onto the bar. For heavy, long bars used on machines with automatic tool changers, take the swimming torque into consideration.

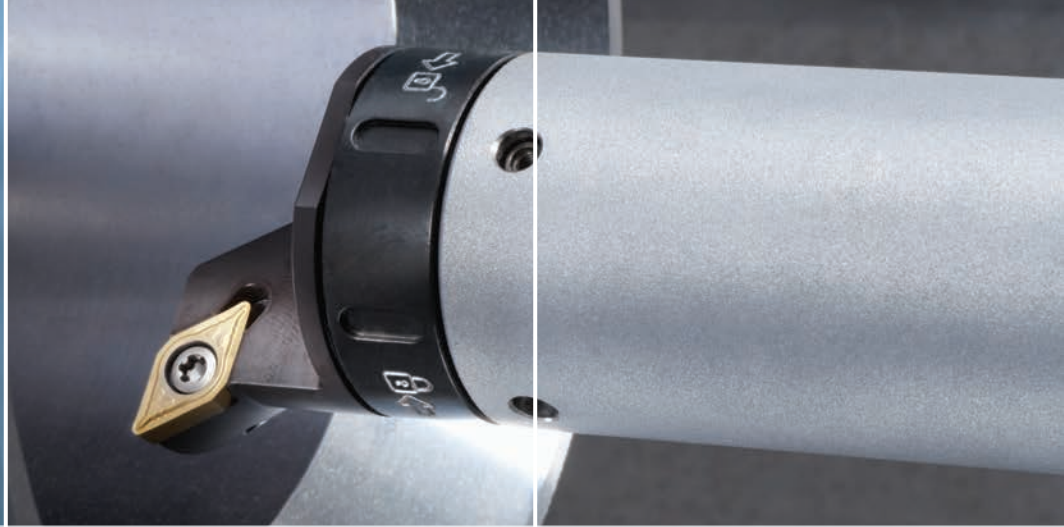


Seco-Capto™ clamping



Cylindrical clamping

# CASE STUDIES TURNING



## 6xD - CASE 1

Operation:	Threading
Tooling:	C6-D40-208-GL40, GL40-CNR-27037-27AHD
Insert:	27NR5.5ISO, CP500
Coolant:	Internal
Material:	SS1672 - DIN: CK45

Cutting data	Metric	$v_c$	Number of passes
		130 m/min	16
			3.25 infeed

**Results** Reduction of number of passes

## 6xD - CASE 2

Operation:	Grooving + internal turning
Tooling:	C6-D32-160-GL32, GL32-CGHR-27032-1604JET
Insert:	LCMF1604M0-0400-MP, CP500
Coolant:	Internal
Material:	SS1672 - DIN: CK45

Cutting data	Metric	$v_c$	$a_r$
		180 m/min	10 mm of depth
1: grooving		$a_p$	$f$
	Metric	4 mm	0.15 mm/rev
2: turning internal		$a_p$	$f$
	Metric	1.5 mm	0.25 mm/rev

**Results** Process stability for 6 x D



## 8xD - CASE 1

Operation:	Roughing
Tooling:	C6-D50-368-GL450, GL50-DCLNR-32032-12
Insert:	CNMM120408-R4, TP2501
Coolant:	Internal
Material:	SS1672 - DIN: CK45

Cutting data	Metric	$v_c$	$f$
		250 m/min	0.2 mm/rev
	Metric	$a_p$	
		3.0 mm	

**Results** Security for large cutting depths

## 8xD - CASE 2

Operation:	Grooving + internal turning
Tooling:	C6-D32-224-GL32, GL32-CGHR-27032-1604JET
Insert:	LCMF1604M0-0400-MP, TGP25
Coolant:	Internal
Material:	SS1672 - DIN: CK45

Cutting data	Metric	$v_c$	$a_r$
		180 m/min	10 mm
1: grooving		$a_p$	$f$
	Metric	4 mm	0.15 mm/rev
2: turning internal		$v_c = 250$ m/min	$f$
	Metric	$a_p = 1.5$ mm	0.25 mm/rev

**Results** Stability for 8 x D



## 10xD - CASE 1

Operation:	Roughing
Tooling:	C6-D50-468-GL50, GL50-DDUNR-32032-15
Insert:	DNMG150608-M5, TP2501
Coolant:	Internal
Material:	SS1672 - DIN: CK45

Cutting data	Metric	$v_c$	$f$
		250 m/min	0.25 mm/rev
	Metric	$a_p$	
		4.0 mm	

**Results** High chip removal rates for 10 x D

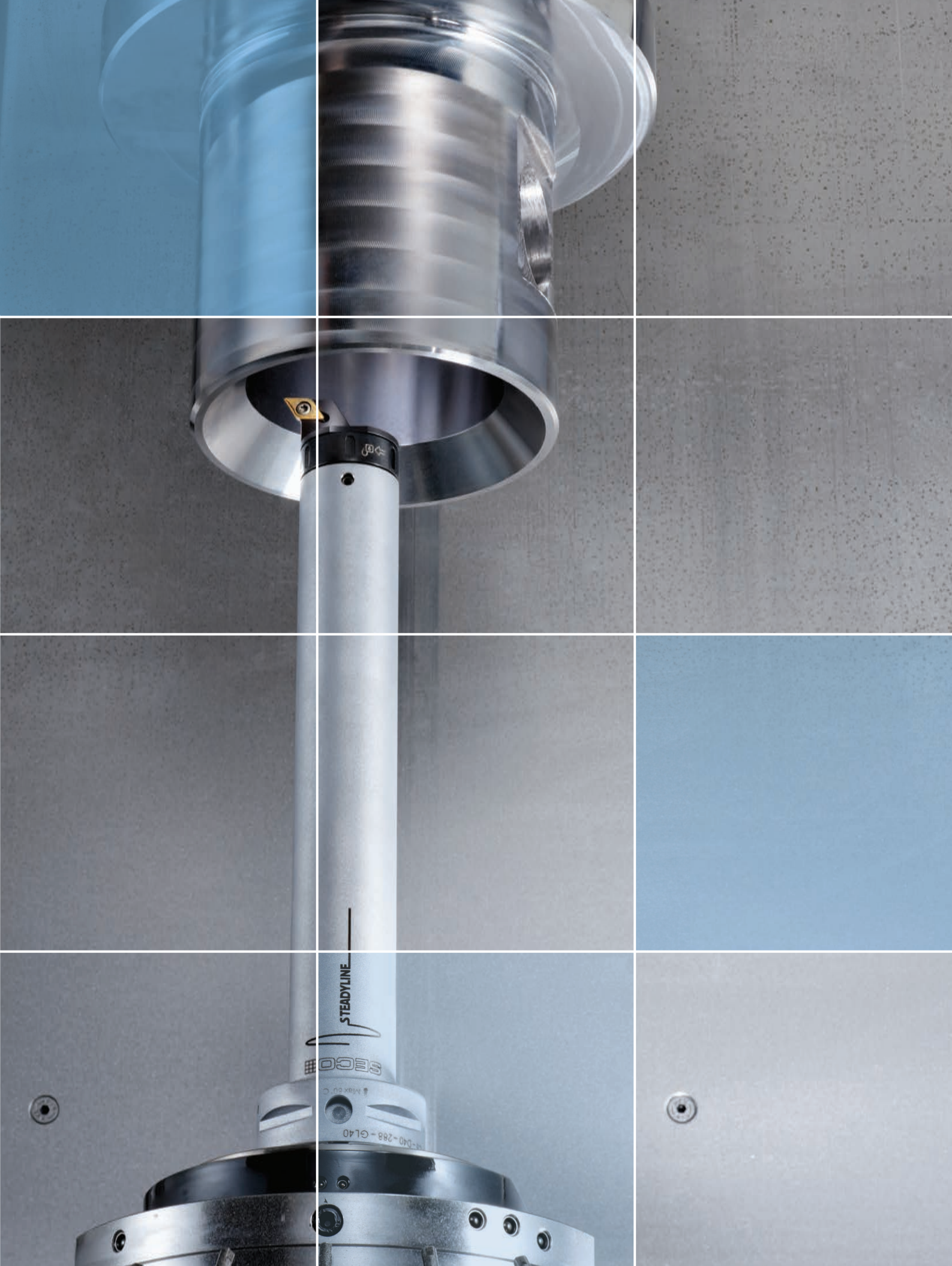
## 10xD - CASE 2

Operation:	Internal turning roughing
Tooling:	D60-541-BA060, BA060-05-27-GL50, GL50-DDUNR-32032-15
Insert:	DNMG150608-M3, TP1501
Coolant:	Internal
Material:	42CrMo4 SMG P5

Cutting data	Metric	$v_c$	$f$
		185 m/min	0.3 mm/rev
	Metric	$a_p$	
		2.5 mm	

**Results** Process stability for 10 x D

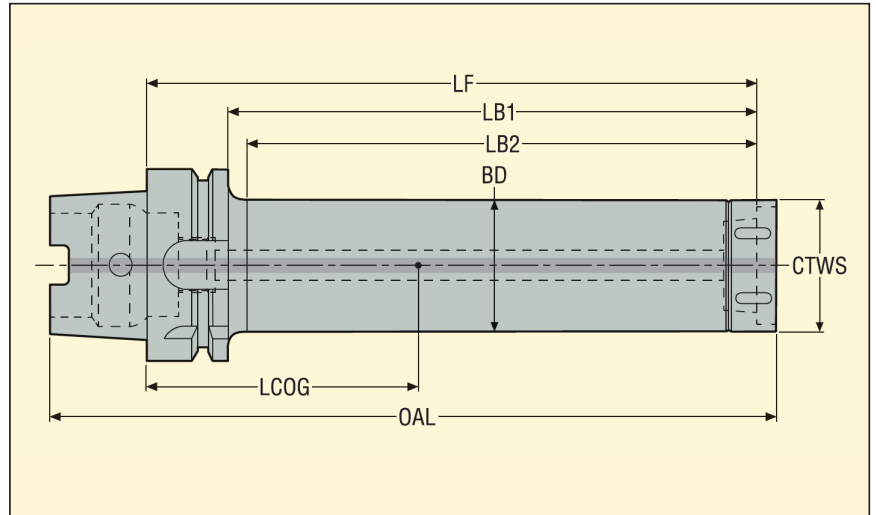




# STEADYLINE® TURNING HSK

SECO EPB® GL – Steadyliner®, GL holders, body diameters 32, 40, 50 mm

HSK-T/A



- With dynamic damping, ready to use
- With through coolant
- For GL turning and boring heads, see pages 20-45, 51, 53

Machine side	Workpiece side	Designation	Dimensions in mm						Max. RPM*	RFID hole	Balancing	KG
			LF	LB1	LB2	BD	OAL	LCOG				
HSK-T/A 63	GL32	E9374-D32-160-GL32	160,0	118,0	112,0	32,0	197,4	58,9	10000	1	PB	1,60
	GL32	E9374-D32-224-GL32	224,0	182,0	176,0	32,0	261,4	90,2	8000	1	PB	2,00
	GL40	E9374-D40-208-GL40	208,0	166,0	160,0	40,0	246,4	92,8	8000	1	PB	2,70
	GL40	E9374-D40-288-GL40	288,0	246,0	240,0	40,0	326,4	134,4	6000	1	PB	3,50
	GL50	E9374-D50-268-GL50	268,0	226,0	224,5	50,0	307,4	131,8	6000	1	PB	4,80
GL50	E9374-D50-368-GL50	368,0	326,0	324,5	50,0	407,4	184,8	4000	1	PB	6,40	
HSK-T/A 100	GL32	E9376-D32-160-GL32	160,0	115,0	109,0	32,0	215,4	32,9	10000	1	PB	3,00
	GL32	E9376-D32-224-GL32	224,0	179,0	173,0	32,0	279,4	55,0	8000	1	PB	3,40
	GL32	E9376-D32-288-GL32	288,0	243,0	237,0	32,0	343,4	80,5	6000	1	PB	3,80
	GL40	E9376-D40-208-GL40	208,0	163,0	157,0	40,0	264,4	62,8	8000	1	PB	4,10
	GL40	E9376-D40-288-GL40	288,0	243,0	237,0	40,0	344,4	98,3	6000	1	PB	4,90
	GL40	E9376-D40-368-GL40	368,0	323,0	317,0	40,0	424,4	139,8	5000	1	PB	5,80
	GL50	E9376-D50-268-GL50	268,0	223,0	218,0	50,0	325,4	104,3	6000	1	PB	6,20
	GL50	E9376-D50-368-GL50	368,0	323,0	318,0	50,0	425,4	154,3	4000	1	PB	7,80
	GL50	E9376-D50-468-GL50	468,0	423,0	418,0	50,0	525,4	211,6	2500	1	PB	9,70

\* Max. RPM only when used in rotating boring

## Accessories to be ordered separately

For nut of GL bore size	Replaceable end	Torque key
GL32	SL00-32	SL00-32.250
GL40	SL00-40	SL00-40.350
GL50	SL00-50	SL00-50.550

## Spare Parts included in delivery

For nut of GL bore size	Locking key
GL32	SL32
GL40	SL40
GL50	SL50

Please check availability in current price and stock-list and on [www.secotools.com](http://www.secotools.com)

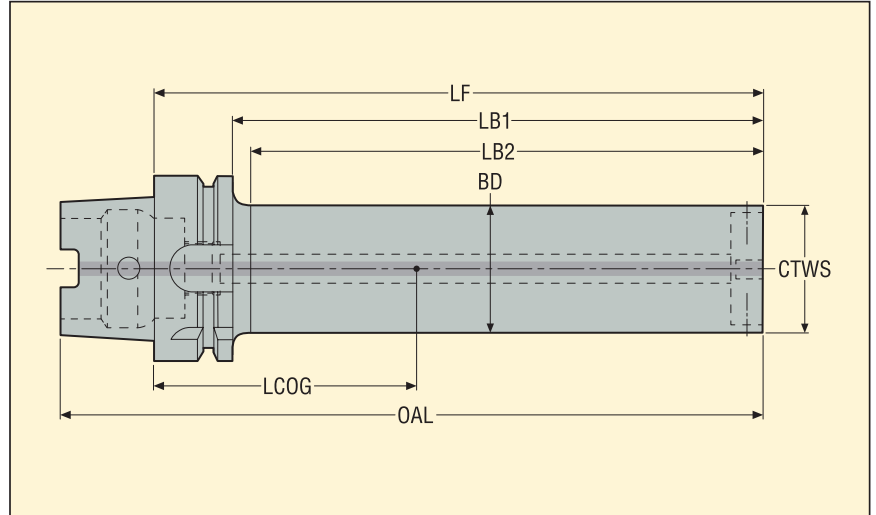
# STEADYLINE® TURNING HSK


SECO EPB® BA – Steadyline®, BA holders, body diameters 60 and 80 mm

HSK-T/A




- With dynamic damping, ready to use
- To hold BA to GL adapters with GL turning heads
- With through coolant



Machine side Taper	Workpiece side BA size CTWS	Designation	Dimensions in mm						Max. RPM*	RFID hole	Balancing	 KG
			LF	BD	LB1	LB2	OAL	LCOG				
HSK-T/A 100	BA060	E9376-D60-301-BA060	301,0	60,0	256,0	251,0	351,0	133,1	4000	1	PB	8,90
	BA060	E9376-D60-421-BA060	421,0	60,0	376,0	371,0	471,0	197,2	3000	1	PB	11,80
	BA060	E9376-D60-541-BA060	541,0	60,0	496,0	491,0	591,0	260,6	2000	1	PB	14,50
	BA080	E9376-D80-421-BA080	421,0	80,0	376,0	371,0	471,0	209,7	3000	1	PB	19,40
	BA080	E9376-D80-581-BA080	581,0	80,0	536,0	531,0	631,0	295,5	2000	1	PB	31,70

\* Max. RPM only when used in rotating boring (boring heads as custom made on request)

### Accessories to be ordered separately

For	Locking key
	
BA060	03H04
BA080	03H05

### Spare Parts included in delivery

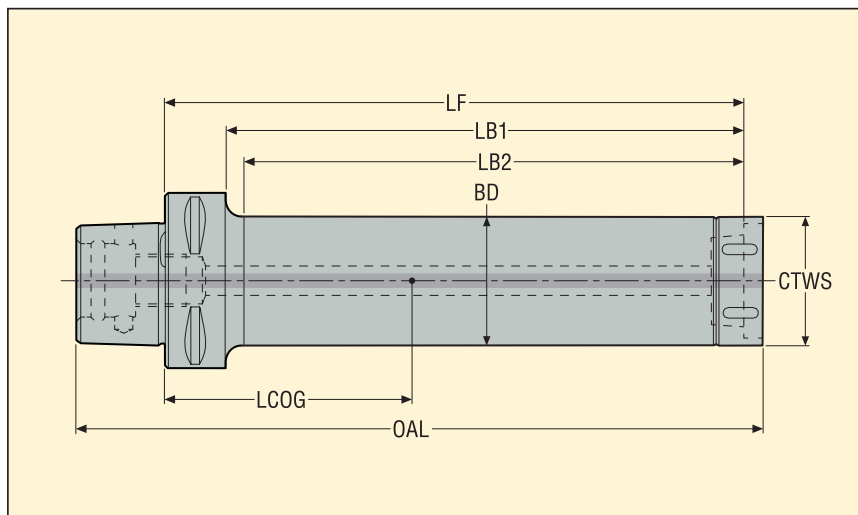
For	Locking screw
	
BA060	90FQ4
BA080	90FQ52

Please check availability in current price and stock-list and on [www.secotools.com](http://www.secotools.com)

# STEADYLINE® TURNING CAPTO

SECO EPB® GL – Steadyline®, GL holders, body diameters 32, 40, 50 mm

Seco-Capto™



- With dynamic damping, ready to use
- With through coolant
- For GL turning and boring heads, see pages 20-45, 51, 53

Machine side	Workpiece side	Designation	Dimensions in mm						Max. RPM*	RFID hole	Balancing	KG
			LF	LB1	LB2	BD	OAL	LCOG				
C4	GL32	C4-D32-160-GL32	160,0	137,0	134,0	32,0	189,4	74,7	10000	0	PB	1,20
	GL32	C4-D32-224-GL32	224,0	201,0	198,0	32,0	253,4	109,2	8000	0	PB	1,70
C5	GL32	C5-D32-160-GL32	160,0	137,0	133,0	32,0	195,4	65,2	10000	1	PB	1,40
	GL32	C5-D32-224-GL32	224,0	201,0	197,0	32,0	259,4	98,5	8000	1	PB	1,80
	GL32	C5-D32-288-GL32	288,0	265,0	261,0	32,0	323,4	133,6	6000	1	PB	2,20
	GL40	C5-D40-208-GL40	208,0	185,0	181,0	40,0	244,4	98,3	8000	1	PB	2,50
	GL40	C5-D40-288-GL40	288,0	265,0	261,0	40,0	324,4	140,9	6000	1	PB	3,30
	GL40	C5-D40-368-GL40	368,0	345,0	341,0	40,0	404,4	187,4	5000	1	PB	4,30
C6	GL32	C6-D32-160-GL32	160,0	135,0	129,0	32,0	203,4	52,1	10000	1	PB	1,80
	GL32	C6-D32-224-GL32	224,0	199,0	193,0	32,0	267,4	82,2	8000	1	PB	2,20
	GL32	C6-D32-288-GL32	288,0	263,0	257,0	32,0	331,4	114,9	6000	1	PB	2,60
	GL40	C6-D40-208-GL40	208,0	183,0	177,0	40,0	252,4	86,4	8000	1	PB	2,90
	GL40	C6-D40-288-GL40	288,0	263,0	257,0	40,0	332,4	127,5	6000	1	PB	3,70
	GL40	C6-D40-368-GL40	368,0	343,0	337,0	40,0	412,4	173,1	5000	1	PB	4,60
	GL50	C6-D50-268-GL50	268,0	243,0	238,0	50,0	313,4	126,6	6000	1	PB	5,00
	GL50	C6-D50-368-GL50	368,0	343,0	338,0	50,0	413,4	179,4	4000	1	PB	6,60
	GL50	C6-D50-468-GL50	468,0	443,0	438,0	50,0	513,4	238,5	2500	1	PB	8,50

\* Max. RPM only when used in rotating boring

## Accessories to be ordered separately

For nut of GL bore size	Replaceable end	Torque key
GL32	SL00-32	SL00-32.250
GL40	SL00-40	SL00-40.350
GL50	SL00-50	SL00-50.550

## Spare Parts included in delivery

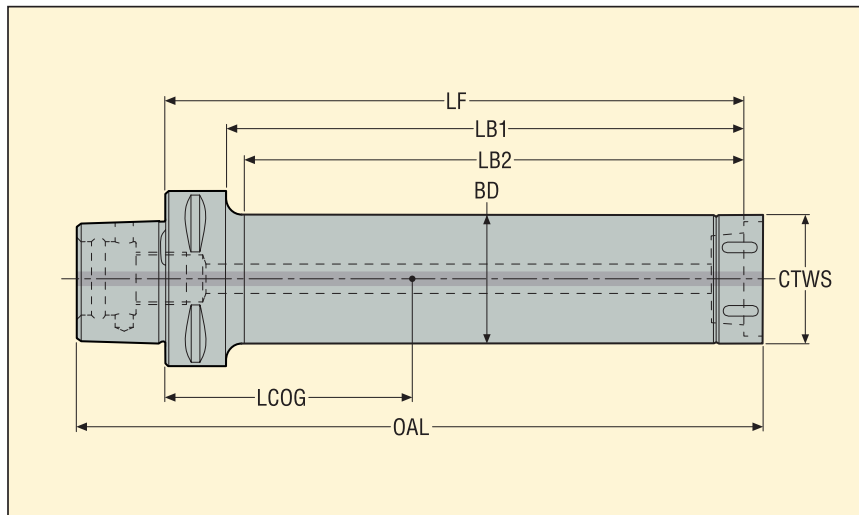
For nut of GL bore size	Locking key
GL32	SL32
GL40	SL40
GL50	SL50

Please check availability in current price and stock-list and on [www.secotools.com](http://www.secotools.com)

# STEADYLINE® TURNING CAPTO

SECO EPB® GL – Steadyline®, GL holders, body diameters 32, 40, 50 mm

Seco-Capto™



- With dynamic damping, ready to use
- With through coolant
- For GL turning and boring heads, see pages 20-45, 51, 53

Machine side Seco-Capto™ shank size	Workpiece side GL size CTWS	Designation	Dimensions in mm						Max. RPM*	RFID hole	Balancing	KG
			LF	LB1	LB2	BD	OAL	LCOG				
C8	GL32	C8-D32-224-GL32	224,0	191,0	181,0	32,0	277,5	58,2	8000	1	PB	3,20
	GL32	C8-D32-288-GL32	288,0	255,0	245,0	32,0	341,5	84,7	6000	1	PB	3,60
	GL40	C8-D40-288-GL40	288,0	255,0	245,0	40,0	341,5	102,1	6000	1	PB	4,70
	GL40	C8-D40-368-GL40	368,0	335,0	325,0	40,0	422,5	144,0	5000	1	PB	5,60
	GL50	C8-D50-268-GL50	268,0	235,0	225,0	50,0	323,5	107,6	6000	1	PB	5,90
	GL50	C8-D50-368-GL50	368,0	335,0	325,0	50,0	423,5	158,1	4000	1	PB	7,50
	GL50	C8-D50-468-GL50	468,0	435,0	425,0	50,0	523,4	215,6	2500	1	PB	9,40

\* Max. RPM only when used in rotating boring

## Accessories to be ordered separately

For nut of GL bore size	Replaceable end	Torque key
GL32	SL00-32	SL00-32.250
GL40	SL00-40	SL00-40.350
GL50	SL00-50	SL00-50.550

## Spare Parts included in delivery

For nut of GL bore size	Locking key
GL32	SL32
GL40	SL40
GL50	SL50

Please check availability in current price and stock-list and on [www.secotools.com](http://www.secotools.com)

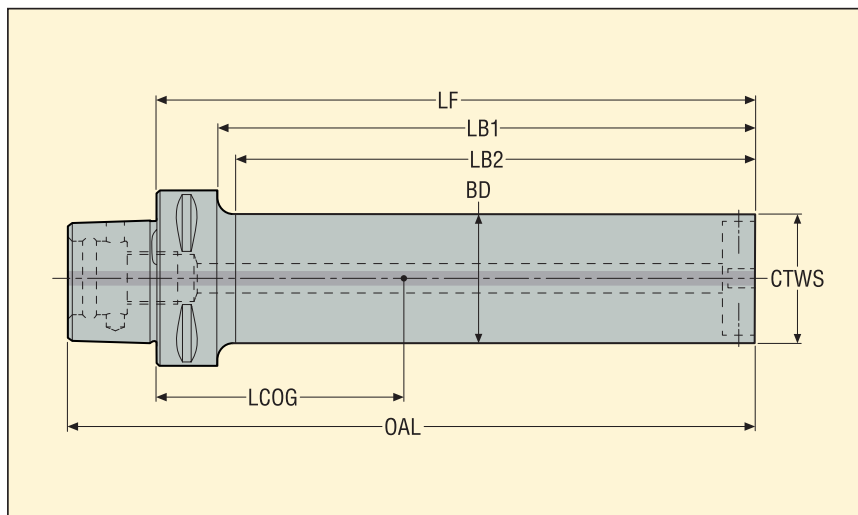
# STEADYLINE® TURNING CAPTO

SECO EPB® BA – Steadyline®, BA holders, body diameters 60 and 80 mm

Seco-Capto™



- With dynamic damping, ready to use
- To hold BA to GL adapters with GL turning heads
- With through coolant



Machine side Seco-Capto™ shank size	Workpiece side BA size CTWS	Designation	Dimensions in mm						Max. RPM*	RFID hole	Balancing	KG
			LF	BD	LB1	LB2	OAL	LCOG				
C6	BA060	C6-D60-301-BA060	301,0	60,0	276,0	273,0	339,0	151,7	4000	1	PB	7,80
	BA060	C6-D60-421-BA060	421,0	60,0	396,0	393,0	459,0	218,6	3000	1	PB	10,60
C8	BA060	C8-D60-301-BA060	301,0	60,0	268,0	263,0	349,0	137,0	4000	1	PB	8,60
	BA060	C8-D60-421-BA060	421,0	60,0	388,0	383,0	469,0	202,5	3000	1	PB	11,40
	BA060	C8-D60-541-BA060	541,0	60,0	508,0	503,0	589,0	266,8	2000	1	PB	14,00
	BA080	C8-D80-421-BA080	421,0	80,0	388,0	383,0	469,0	213,9	3000	1	PB	18,80
	BA080	C8-D80-581-BA080	581,0	80,0	548,0	543,0	629,0	300,4	2000	1	PB	25,10

\* Max. RPM only when used in rotating boring (boring heads as custom made on request)

## Accessories to be ordered separately

For BA size	Locking key
BA060	03H04
BA080	03H05

## Spare Parts included in delivery

For	Locking screw
BA060	90FQ4
BA080	90FQ52

Please check availability in current price and stock-list and on [www.secotools.com](http://www.secotools.com)



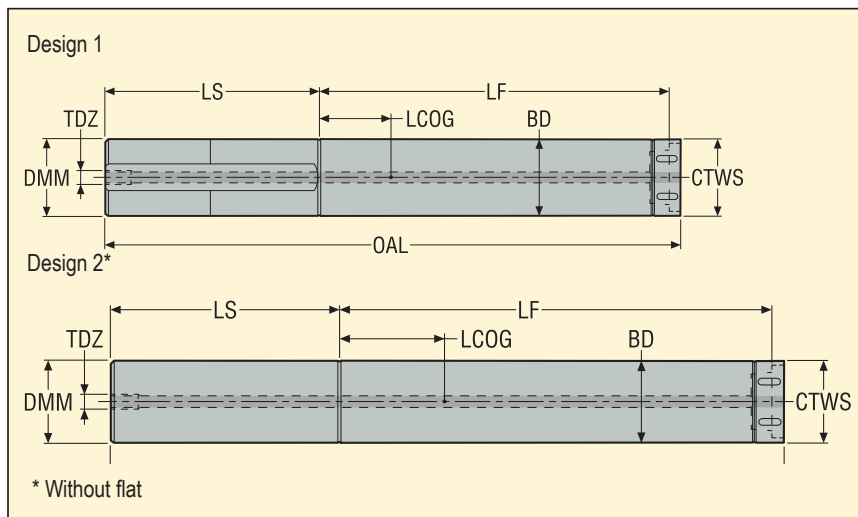
# STEADYLINE® TURNING CYLINDRICAL

SECO EPB® GL – Steadyline®, GL holders, body diameters 32, 40, 50 mm

Cylindrical



- With dynamic damping, ready to use
- With through coolant channel and coolant supply connecting thread
- For GL turning and boring heads, see pages 20-45, 51, 53



Machine side DMM mm	Workpiece side GL size CTWS	Designation	Dimensions in mm					TDZ	Design	RFID hole	KG
			LS	LF	BD	OAL	LCOG				
32	GL32	D32-160-GL32	128,0	160,0	32,0	293,4	25,3	G 1/4	1	0	1,80
	GL32	D32-224-GL32	128,0	224,0	32,0	357,5	60,2	G 1/4	1	0	2,30
	GL32	D32-288-GL32	128,0	288,0	32,0	421,5	95,7	G 1/4	2	0	2,70
40	GL40	D40-208-GL40	160,0	208,0	40,0	374,5	35,6	G 1/4	1	0	3,80
	GL40	D40-288-GL40	160,0	288,0	40,0	454,5	78,3	G 1/4	1	0	4,60
	GL40	D40-368-GL40	160,0	368,0	40,0	534,5	124,3	G 1/4	2	0	5,50
50	GL50	D50-268-GL50	200,0	268,0	50,0	475,5	46,4	G 1/4	1	0	7,50
	GL50	D50-368-GL50	200,0	368,0	50,0	575,5	99,0	G 1/4	1	0	9,10
	GL50	D50-468-GL50	200,0	468,0	50,0	675,5	158,1	G 1/4	2	0	11,00

\* Max. RPM only when used in rotating boring

## Accessories to be ordered separately

For nut of GL bore size	Replaceable end	Torque key
GL32	SL00-32	SL00-32.250
GL40	SL00-40	SL00-40.350
GL50	SL00-50	SL00-50.550

## Spare Parts included in delivery

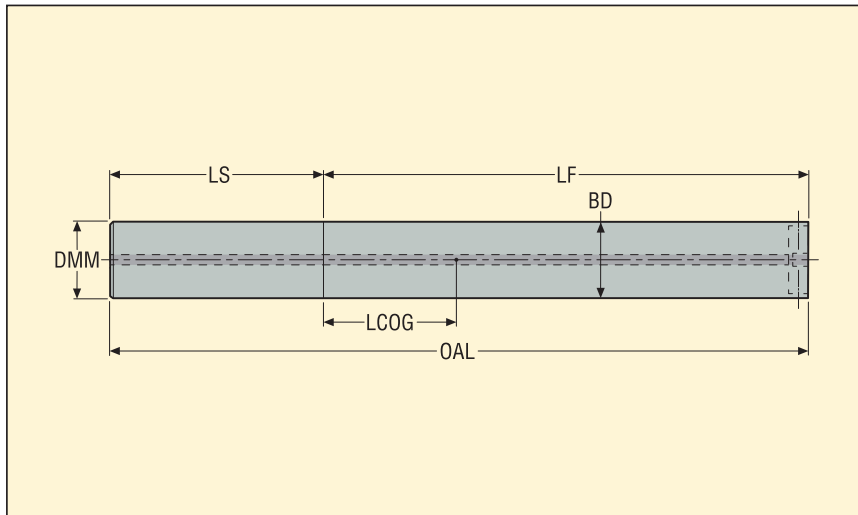
For nut of GL bore size	Locking key
GL32	SL32
GL40	SL40
GL50	SL50

Please check availability in current price and stock-list and on [www.secotools.com](http://www.secotools.com)


# STEADYLINE® TURNING CYLINDRICAL

SECO EPB® BA – Steadyline®, BA holders, body diameters 60, 80 and 100 mm


Cylindrical



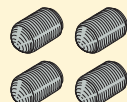
- With dynamic damping, ready to use
- To hold BA to GL adapters with GL turning heads
- With through coolant

Machine side DMM mm	Workpiece side BA size	Designation	Dimensions in mm					RFID hole	 <b>KG</b>
			LF	BD	LS	OAL	LCOG		
60	BA060	D60-301-BA060	301,0	60,0	240,0	541,0	50,1	0	12,50
	BA060	D60-541-BA060	541,0	60,0	240,0	781,0	179,1	0	18,10
80	BA080	D80-421-BA080	421,0	80,0	320,0	741,0	71,0	0	30,20
	BA080	D80-741-BA080	741,0	80,0	320,0	1061,0	241,6	0	43,40
100	BA100	D100-939-BA100	939,0	100,0	500,0	1439,0	271,9	0	84,66

## Accessories to be ordered separately

For BA size	Locking key
	
BA060	03H04
BA080	03H05
BA100	03H06

## Spare Parts included in delivery

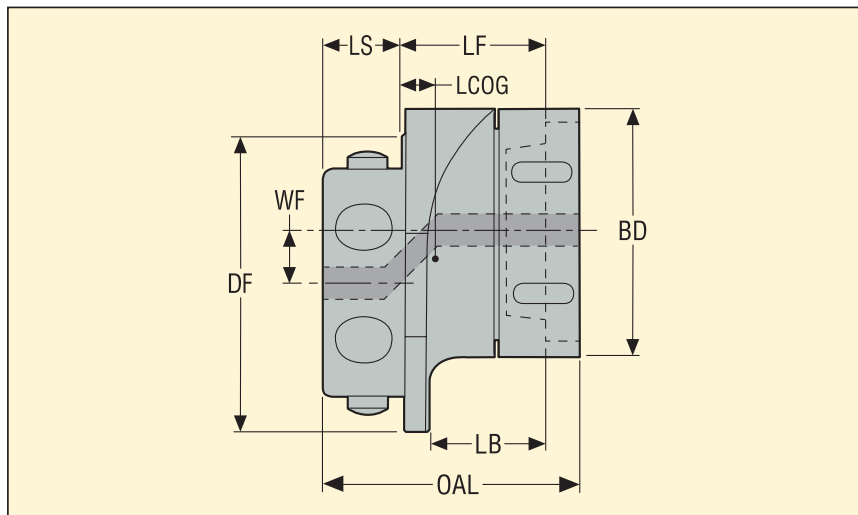
For	Locking screw
	
BA060	90FQ4
BA080	90FQ52
BA100	90FQ6

Please check availability in current price and stock-list and on [www.secotools.com](http://www.secotools.com)

# STEADYLINE® TURNING CYLINDRICAL

SECO EPB® BA – BA to GL adapters

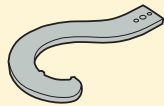
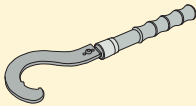
Cylindrical



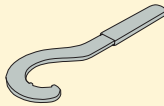
- To hold GL50 turning heads on Steadyline® BA holders
- Each adapter size available with 2 radial offset sizes WF
- With through coolant

Machine side	Workpiece side	Designation	Dimensions in mm								RFID hole	KG
			WF	LF	DF	BD	LB	LS	OAL	LCOG		
BA060	GL50	BA060-05-27-GL50	5,0	27,0	60,0	50,0	21,5	16,0	50,4	5,8	0	0,60
	GL50	BA060-10-27-GL50	10,0	27,0	60,0	50,0	21,5	16,0	50,4	5,8	0	1,00
BA080	GL50	BA080-15-27-GL50	15,0	27,0	80,0	50,0	21,5	22,0	56,4	1,4	0	0,90
	GL50	BA080-23-27-GL50	23,0	27,0	80,0	50,0	21,5	22,0	56,4	1,4	0	0,90
BA100	GL50	BA100-28-29-GL50	28,0	29,0	100,0	50,0	21,5	25,0	61,4	1,4	0	1,5
	GL50	BA100-38-29-GL50	38,0	29,0	100,0	50,0	21,5	25,0	61,4	1,0	0	1,5

## Accessories to be ordered separately

For GL size	Replaceable end	Torque key
GL50	 SL00-50	 SL00-50.550

## Spare Parts included in delivery

For	Locking key
GL50	 SL50

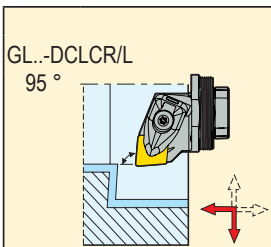
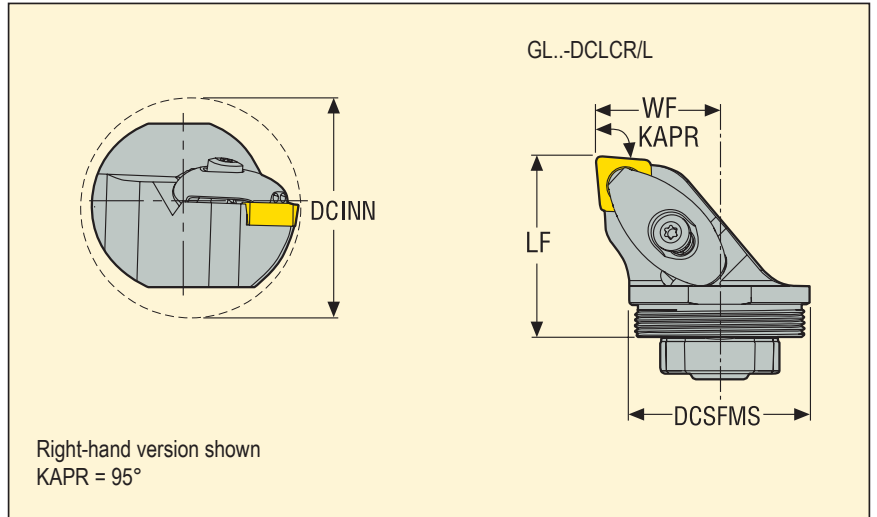
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# TURNING – STEADYLINE®, GL-HEADS, INTERNAL JETSTREAM TOOLING®

Toolholders for inserts CCGT, CCGW, CCMT and CCMW



- For inserts programme, see Turning Catalog pages 398, 452, 480-481
- GAMO° = Rake angle, LAMS° = Inclination angle
- For holder code key, see pages 13-14
- For coolant clamps code key, see page 22



Size		Designation	Dimensions in mm				GAMO°	LAMS°		
			DCSFMS	LF	WF	DCINN				
GL32	09	GL32-DCLCR-22032-09JET	32	32	22	40	0	-2	0,2	CC..09T3..
		GL32-DCLCL-22032-09JET	32	32	22	40	0	-2	0,2	CC..09T3..
GL40	09	GL40-DCLCR-27032-09JET	40	32	27	50	0	-2	0,2	CC..09T3..
		GL40-DCLCL-27032-09JET	40	32	27	50	0	-2	0,2	CC..09T3..
GL50	09	GL50-DCLCR-32032-09JET	50	32	32	63	0	-2	0,3	CC..09T3..
		GL50-DCLCL-32032-09JET	50	32	32	63	0	-2	0,3	CC..09T3..

## Spare Parts included in delivery

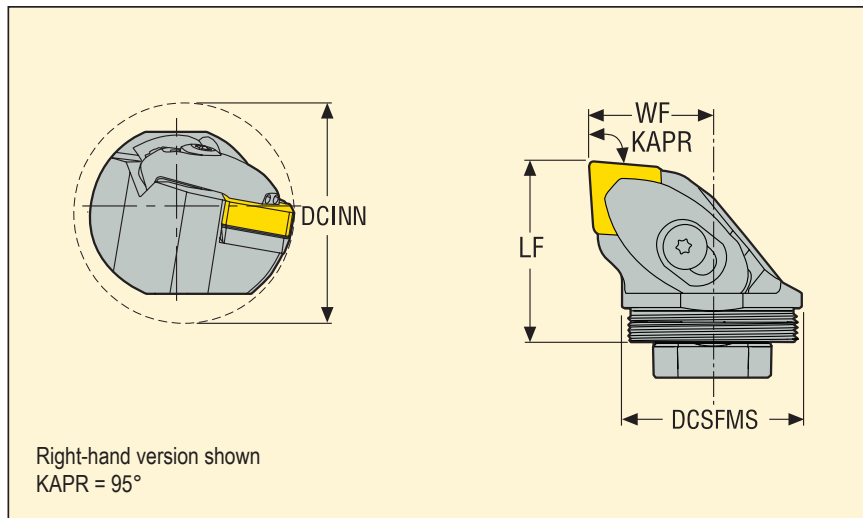
Accessories to be ordered separately

For GL size	Clamp key	Clamp screw	Coolant clamp	Coolant seal	Key (T-handle)	O-ring	Spring	Clamp kit
GL32	H4B-T09P	L84017-T09P	CP14U00S-2	930RD13	DOUBLE-T	O-RING-5.0X1.2	S5608	CP14U00S-2-SET
GL40	H4B-T09P	L84017-T09P	CP14U00S-2	930RD13	DOUBLE-T	O-RING-5.0X1.2	S5608	CP14U00S-2-SET
GL50	H4B-T09P	L84017-T09P	CP14U00S-2	930RD13	DOUBLE-T	O-RING-5.0X1.2	S5608	CP14U00S-2-SET

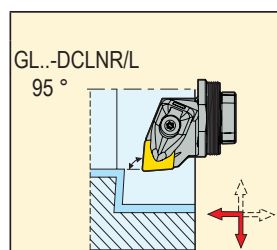
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# TURNING – STEADYLINE®, GL-HEADS, INTERNAL JETSTREAM TOOLING®

Toolholders for inserts CNGG, CNMA, CNMG and CNMM



- For inserts programme, see Turning Catalog pages 399-406, 453-454, 480-481
- GAMO° = Rake angle, LAMS° = Inclination angle
- For holder code key, see page(s) 13-14
- For coolant clamps code key, see page 22



Size	Designation	Dimensions in mm				GAMO°	LAMS°	KG	Image
		DCSFMS	LF	WF	DCINN				
GL32	GL32-DCLNR-22032-12JET	32	32	22	40	-6	-10	0,2	CN..1204..
	GL32-DCLNL-22032-12JET	32	32	22	40	-6	-10	0,2	CN..1204..
GL40	GL40-DCLNR-27032-12JET	40	32	27	50	-6	-10	0,2	CN..1204..
	GL40-DCLNL-27032-12JET	40	32	27	50	-6	-10	0,2	CN..1204..
GL50	GL50-DCLNR-32032-12JET	50	32	32	63	-6	-8	0,3	CN..1204..
	GL50-DCLNL-32032-12JET	50	32	32	63	-6	-8	0,3	CN..1204..

## Spare Parts included in delivery

Accessories to be ordered separately

For GL size	Clamp screw	Coolant clamp	Coolant seal	Insert shim	Key (T-handle)	O-ring	Shim/clamp key	Shim screw	Spring	Clamp kit
GL32	L85021-T15P	CN17U00S-2	930RD13	DCO120310	DOUBLE-T	O-RING-5.0X1.2	H4B-T15P	C04008-T15P	S6912	CN17U00S-2-SET
GL40	L85021-T15P	CN17U00S-2	930RD13	DCO120310	DOUBLE-T	O-RING-5.0X1.2	H4B-T15P	C04008-T15P	S6912	CN17U00S-2-SET
GL50	L85021-T15P	CN17U00S-2	930RD13	DCO120310	DOUBLE-T	O-RING-5.0X1.2	H4B-T15P	C04008-T15P	S6912	CN17U00S-2-SET

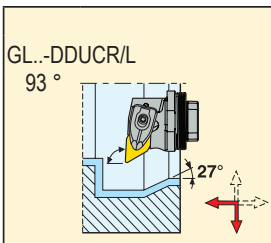
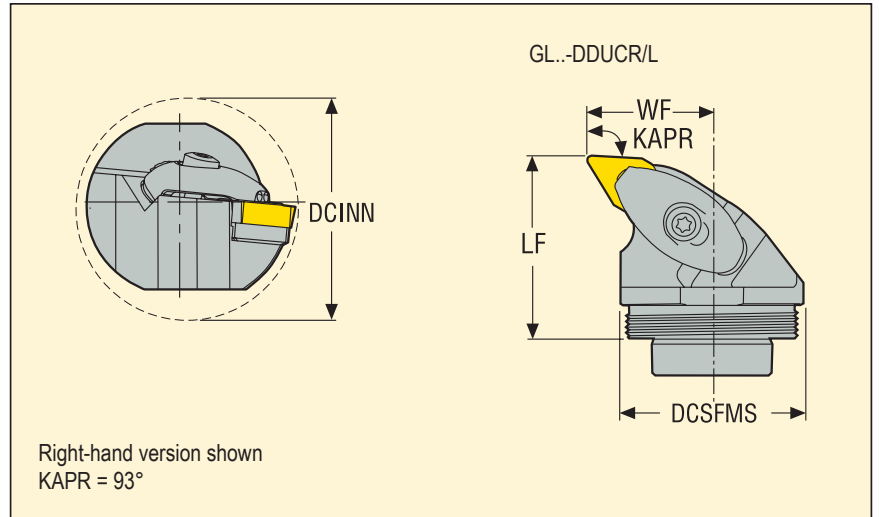
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# TURNING – STEADYLINE®, GL-HEADS, INTERNAL JETSTREAM TOOLING®

Toolholders for inserts DCGT, DCGW, DCMT, DCMW and DCMX



- For inserts programme, see Turning Catalog pages 407-410, 455, 482
- GAMO° = Rake angle, LAMS° = Inclination angle
- For holder code key, see pages 13-14
- For coolant clamps code key, see page 22



Size	Designation	Dimensions in mm					GAMO°	LAMS°	KG	Symbol
		DCSFMS	LF	WF	DCINN					
GL32	11 GL32-DDUCR-22032-11JET	32	32	22	40	0	-5	0,2	DC..11T3..	
	GL32-DDUCL-22032-11JET	32	32	22	40	0	-5	0,2	DC..11T3..	
GL40	11 GL40-DDUCR-27032-11JET	40	32	27	50	0	-5	0,2	DC..11T3..	
	GL40-DDUCL-27032-11JET	40	32	27	50	0	-5	0,2	DC..11T3..	
GL50	11 GL50-DDUCR-32032-11JET	50	32	32	63	0	-5	0,3	DC..11T3..	
	GL50-DDUCL-32032-11JET	50	32	32	63	0	-5	0,3	DC..11T3..	

### Spare Parts included in delivery

Accessories to be ordered separately

For GL size	Clamp key	Clamp screw	Coolant clamp	Coolant seal	Insert shim	Key (T-handle)	O-ring	Shim key	Shim screw	Spring	Clamp kit
GL32	H4B-T09P	L84017-T09P	CP14U00S-2	930RD13	126.19-620	DOUBLE-T	O-RING-5.0X1.2	H4B-T15P	C94006-T15P	S5608	CP14U00S-2-SET
GL40	H4B-T09P	L84017-T09P	CP14U00S-2	930RD13	126.19-620	DOUBLE-T	O-RING-5.0X1.2	H4B-T15P	C94006-T15P	S5608	CP14U00S-2-SET
GL50	H4B-T09P	L84017-T09P	CP14U00S-2	930RD13	126.19-620	DOUBLE-T	O-RING-5.0X1.2	H4B-T15P	C94006-T15P	S5608	CP14U00S-2-SET

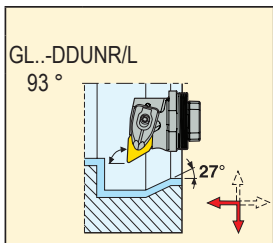
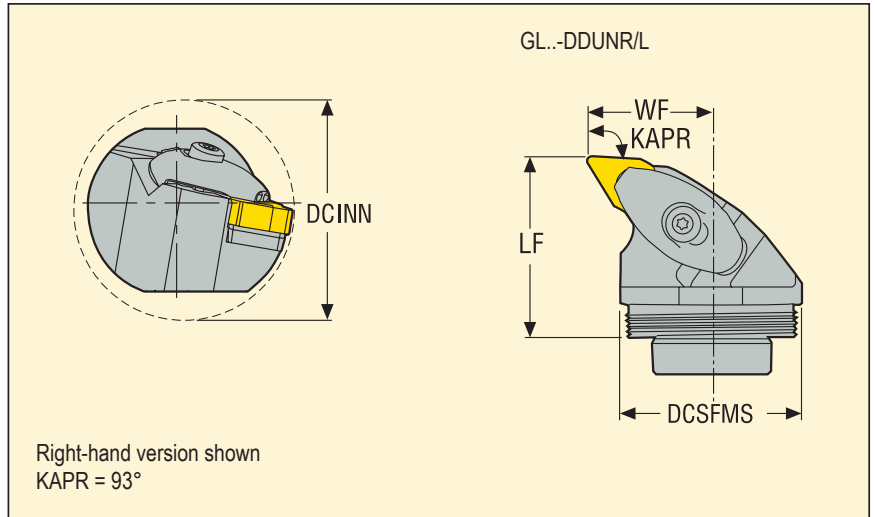
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# TURNING – STEADYLINE®, GL-HEADS, INTERNAL JETSTREAM TOOLING®

Toolholders for inserts DNGG, DNGN, DNMA, DNMG, DNMM, DNMU and DNMX



- For inserts programme, see Turning Catalog pages 410-416, 456-457
- GAMO° = Rake angle, LAMS° = Inclination angle
- For holder code key, see pages 13-14
- For coolant clamps code key, see page 22



Size	Designation	Dimensions in mm				GAMO°	LAMS°	KG	Image	
		DCSFMS	LF	WF	DCINN					
GL32	11	GL32-DDUNR-22032-11JET	32	32	22	40	-6	-10	0,2	DN..1104..
		GL32-DDUNL-22032-11JET	32	32	22	40	-6	-10	0,2	DN..1104..
	15	GL32-DDUNR-22032-15JET	32	32	22	40	-6	-14	0,2	DN..1506..
		GL32-DDUNL-22032-15JET	32	32	22	40	-6	-14	0,2	DN..1506..
GL40	11	GL40-DDUNR-27032-11JET	40	32	27	50	-6	-10	0,2	DN..1104..
		GL40-DDUNL-27032-11JET	40	32	27	50	-6	-10	0,2	DN..1104..
	15	GL40-DDUNR-27032-15JET	40	32	27	50	-6	-14	0,2	DN..1506..
		GL40-DDUNL-27032-15JET	40	32	27	50	-6	-14	0,2	DN..1506..
GL50	15	GL50-DDUNR-32032-15JET	50	32	32	63	-6	-14	0,4	DN..1506..
		GL50-DDUNL-32032-15JET	50	32	32	63	-6	-14	0,4	DN..1506..

## Spare Parts included in delivery

Accessories to be ordered separately

For GL size	Clamp key	Clamp screw	Coolant clamp	Coolant seal	Insert shim	Key (T-handle)	O-ring	Shim/clamp key	Shim key	Shim screw	Spring	Clamp kit
32-11	–	L84017-T09P	CN14U00S-2	930RD13	DDN110310	DOUBLE-T	O-RING-5.0X1.2	H4B-T09P	–	C03007-T09P	S5608	CN14U00S-2-SET
32R-15	H4B-T09P	L84017-T09P	CN14U10S-2R	930RD13	DDN150416	DOUBLE-T	O-RING-5.0X1.2	–	H4B-T15P	C04008-T15P	S5608	CN14U10S-2R-SET
32L-15	H4B-T09P	L84017-T09P	CN14U10S-2L	930RD13	DDN150416	DOUBLE-T	O-RING-5.0X1.2	–	H4B-T15P	C04008-T15P	S5608	CN14U10S-2L-SET
40-11	–	L84017-T09P	CN14U00S-2	930RD13	DDN110310	DOUBLE-T	O-RING-5.0X1.2	H4B-T09P	–	C03007-T09P	S5608	CN14U00S-2-SET
40-15	–	L85021-T15P	CN17U00S-2	930RD13	DDN150416	DOUBLE-T	O-RING-5.0X1.2	H4B-T15P	–	C04008-T15P	S6912	CN17U00S-2-SET
50-15	–	L85021-T15P	CN17U00S-2	930RD13	DDN150416	DOUBLE-T	O-RING-5.0X1.2	H4B-T15P	–	C04008-T15P	S6912	CN17U00S-2-SET

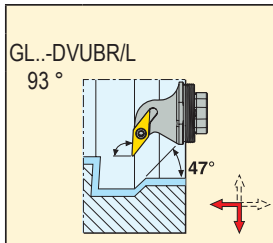
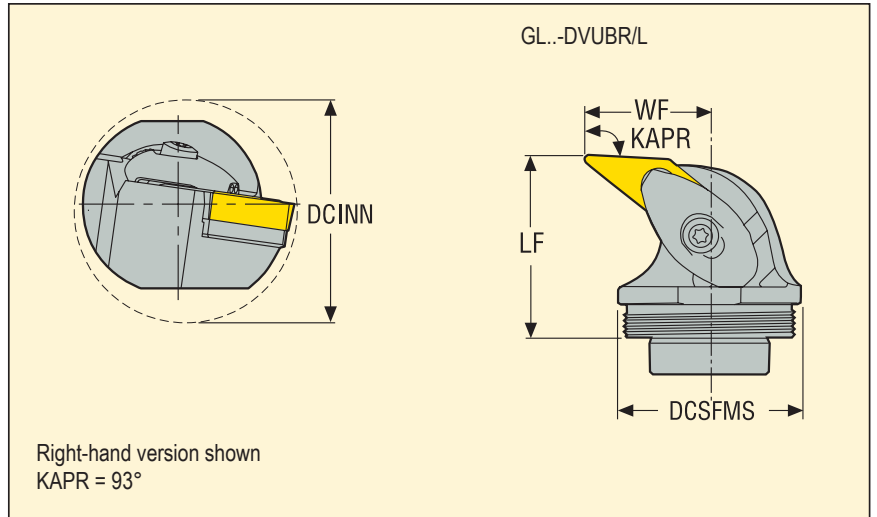
Please check availability in current price and stock-list and on [www.secotools.com](http://www.secotools.com)

# TURNING – STEADYLINE®, GL-HEADS, INTERNAL JETSTREAM TOOLING®

Toolholders for inserts VBG, VBGW, VBMT and VBWW



- For inserts programme, see Turning Catalog pages 441-443, 475, 484
- GAMO° = Rake angle, LAMS° = Inclination angle
- For holder code key, see pages 13-14
- For coolant clamps code key, see page 22



Size	Designation	Dimensions in mm				GAMO°	LAMS°	KG	Insert
		DCSFMS	LF	WF	DCINN				
GL32	16 GL32-DVUBR-22032-16JET	32	32	22	40	0	-8	0,2	VB..1604..
	16 GL32-DVUBL-22032-16JET	32	32	22	40	0	-8	0,2	VB..1604..
GL40	16 GL40-DVUBR-27032-16JET	40	32	27	50	0	-3	0,2	VB..1604..
	16 GL40-DVUBL-27032-16JET	40	32	27	50	0	-3	0,2	VB..1604..
GL50	16 GL50-DVUBR-32032-16JET	50	32	32	63	0	-3	0,3	VB..1604..
	16 GL50-DVUBL-32032-16JET	50	32	32	63	0	-3	0,3	VB..1604..

## Spare Parts included in delivery

Accessories to be ordered separately

For GL size	Clamp key	Clamp screw	Coolant clamp	Coolant seal	Insert shim	Key (T-handle)	O-ring	Shim key	Shim screw	Spring	Clamp kit
GL32..R	H4B-T09P	L84017-T09P	CP14U20S-2R	930RD13	171.19-620	DOUBLE-T	O-RING-5.0X1.2	H4B-T15P	C94006-T15P	S5608	CP14U20S-2R-SET
GL32..L	H4B-T09P	L84017-T09P	CP14U20S-2L	930RD13	171.19-620	DOUBLE-T	O-RING-5.0X1.2	H4B-T15P	C94006-T15P	S5608	CP14U20S-2L-SET
GL40..R	H4B-T09P	L84017-T09P	CP14U20S-2R	930RD13	171.19-620	DOUBLE-T	O-RING-5.0X1.2	H4B-T15P	C94006-T15P	S5608	CP14U20S-2R-SET
GL40..L	H4B-T09P	L84017-T09P	CP14U20S-2L	930RD13	171.19-620	DOUBLE-T	O-RING-5.0X1.2	H4B-T15P	C94006-T15P	S5608	CP14U20S-2L-SET
GL50..R	H4B-T09P	L84017-T09P	CP14U20S-2R	930RD13	171.19-620	DOUBLE-T	O-RING-5.0X1.2	H4B-T15P	C94006-T15P	S5608	CP14U20S-2R-SET
GL50..L	H4B-T09P	L84017-T09P	CP14U20S-2L	930RD13	171.19-620	DOUBLE-T	O-RING-5.0X1.2	H4B-T15P	C94006-T15P	S5608	CP14U20S-2L-SET

Please check availability in current price and stock-list and on [www.secotools.com](http://www.secotools.com)

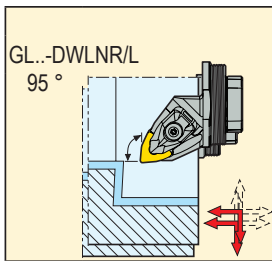
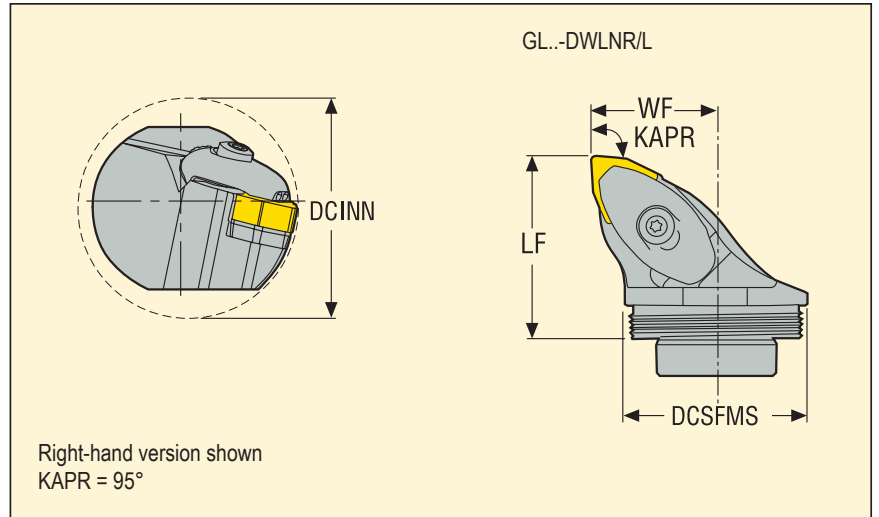


# TURNING – STEADYLINE®, GL-HEADS, INTERNAL JETSTREAM TOOLING®

Toolholders for inserts WNGG, WNMA, WNMG and WNMM



- For inserts programme, see Turning Catalog pages 447-451, 478
- GAMO° = Rake angle, LAMS° = Inclination angle
- For holder code key, see pages 13-14
- For coolant clamps code key, see page 22



Size	Designation	Dimensions in mm				GAMO°	LAMS°	KG	Insert
		DCSFMS	LF	WF	DCINN				
GL32	GL32-DWLNR-22032-06JET	32	32	22	40	-5	-12	0,2	WN..0604..
	GL32-DWLNL-22032-06JET	32	32	22	40	-5	-12	0,2	WN..0604..
GL40	GL40-DWLNR-27032-06JET	40	32	27	50	-5	-12	0,2	WN..0604..
	GL40-DWLNL-27032-06JET	40	32	27	50	-5	-12	0,2	WN..0604..
GL50	GL50-DWLNR-32032-06JET	50	32	32	63	-5	-12	0,3	WN..0604..
	GL50-DWLNL-32032-06JET	50	32	32	63	-5	-12	0,3	WN..0604..

## Spare Parts included in delivery

Accessories to be ordered separately

For size GL size	Clamp screw	Coolant clamp	Coolant seal	Insert shim	Key (T-handle)	O-ring	Shim/clamp key	Shim screw	Spring	Clamp kit
GL32	L84017-T09P	CN14U00S-2	930RD13	DWN060310	DOUBLE-T	O-RING-5.0X1.2	H4B-T09P	C03007-T09P	S5608	CN14U00S-2-SET
GL40	L84017-T09P	CN14U00S-2	930RD13	DWN060310	DOUBLE-T	O-RING-5.0X1.2	H4B-T09P	C03007-T09P	S5608	CN14U00S-2-SET
GL50	L84017-T09P	CN14U00S-2	930RD13	DWN060310	DOUBLE-T	O-RING-5.0X1.2	H4B-T09P	C03007-T09P	S5608	CN14U00S-2-SET

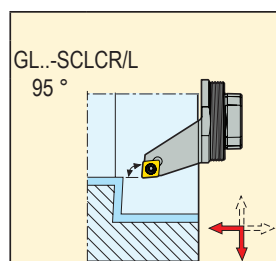
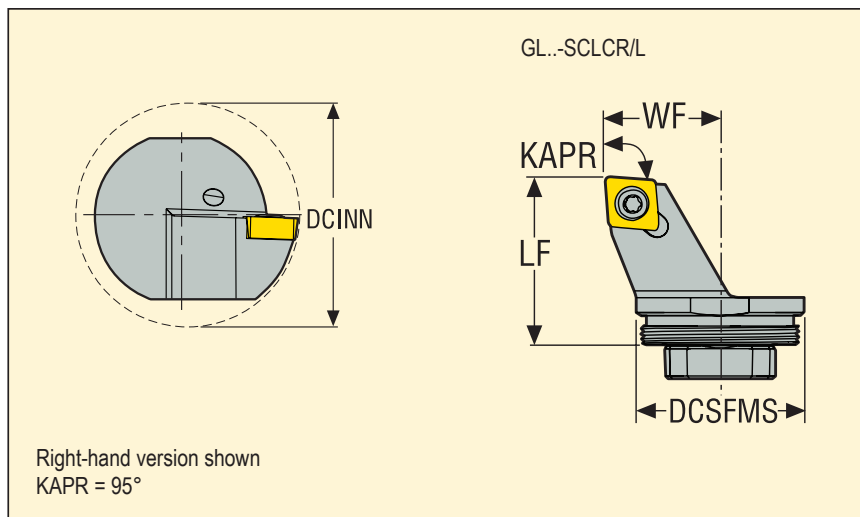
Please check availability in current price and stock-list and on [www.secotools.com](http://www.secotools.com)

# TURNING – STEADYLINE®, GL-HEADS, INTERNAL

Toolholders for inserts CCGT, CCGW, CCGX and CCMT



- For inserts programme, see Turning Catalog pages 398, 452, 480-481
- GAMO° = Rake angle, LAMS° = Inclination angle
- For holder code key, see pages 13-14



Size		Designation	Dimensions in mm				GAMO°	LAMS°		
			DCSFMS	LF	WF	DCINN				
GL32	06	GL32-SCLCR-22032-06	32	32	22,0	40	0	-2	0,1	CC..0602..
		GL32-SCLCL-22032-06	32	32	22,0	40	0	-2	0,1	CC..0602..
	09	GL32-SCLCR-22032-09	32	32	22,0	40	0	-2	0,1	CC..09T3..
		GL32-SCLCL-22032-09	32	32	22,0	40	0	-2	0,1	CC..09T3..
	12	GL32-SCLCR-22032-12	32	32	22,0	40	0	-8	0,1	CC..1204..
		GL32-SCLCL-22032-12	32	32	22,0	40	0	-8	0,1	CC..1204..
GL40	06	GL40-SCLCR-27032-06	40	32	27,0	50	0	-2	0,2	CC..0602..
		GL40-SCLCL-27032-06	40	32	27,0	50	0	-2	0,2	CC..0602..
	09	GL40-SCLCR-27032-09	40	32	27,0	50	0	-2	0,2	CC..09T3..
		GL40-SCLCL-27032-09	40	32	27,0	50	0	-2	0,2	CC..09T3..
	12	GL40-SCLCR-27032-12	40	32	27,0	50	0	-8	0,2	CC..1204..
		GL40-SCLCL-27032-12	40	32	27,0	50	0	-8	0,2	CC..1204..
GL50	06	GL50-SCLCR-32032-06	50	32	32,0	63	0	-2	0,3	CC..0602..
		GL50-SCLCL-32032-06	50	32	32,0	63	0	-2	0,3	CC..0602..
	09	GL50-SCLCR-32032-09	50	32	32,0	63	0	-2	0,3	CC..09T3..
		GL50-SCLCL-32032-09	50	32	32,0	63	0	-2	0,3	CC..09T3..
	12	GL50-SCLCR-32032-12	50	32	32,0	63	0	-5	0,3	CC..1204..
		GL50-SCLCL-32032-12	50	32	32,0	63	0	-5	0,3	CC..1204..

## Spare Parts included in delivery

For GL size	Insert key	Insert screw	Insert shim	Shim screw
...06	T07P-2	C02506-T07P	-	-
...09	T15P-2	C04008-T15P	-	-
...12	T15P-2	C05012-T15P	123.19-621	CA5008

## Accessories to be ordered separately

Shim key
-
-
5SMS795

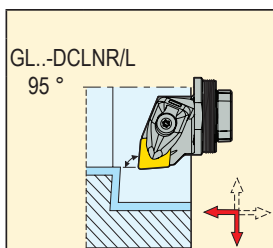
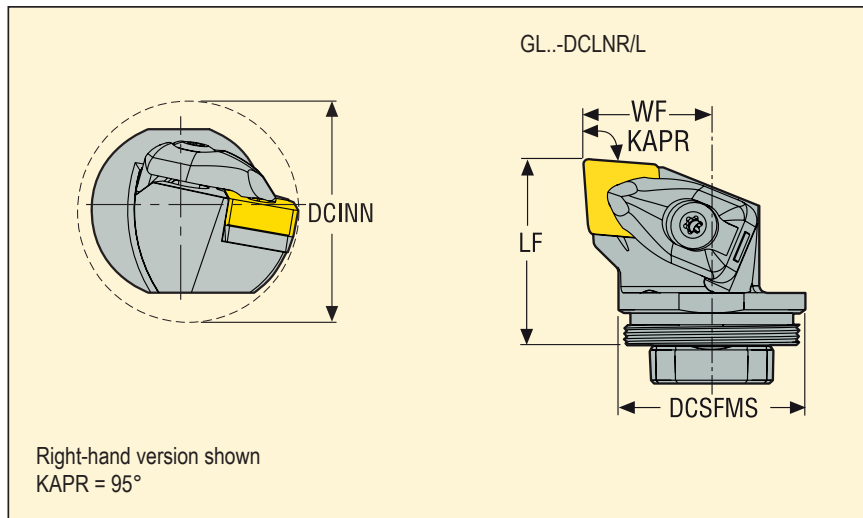
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# TURNING – STEADYLINE®, GL-HEADS, INTERNAL

Toolholders for inserts CNGG, CNMA, CNMG and CNMM



- For inserts programme, see Turning Catalog pages 399-406, 453-454, 480-481
- GAMO° = Rake angle, LAMS° = Inclination angle
- For holder code key, see pages 13-14



Size	Designation	Dimensions in mm				GAMO°	LAMS°	KG	Insert
		DCSFMS	LF	WF	DCINN				
GL32	GL32-DCLNR-22032-12	32	32	22,0	40	-6	-10	0,2	CN..1204..
	GL32-DCLNL-22032-12	32	32	22,0	40	-6	-10	0,2	CN..1204..
GL40	GL40-DCLNR-27032-12	40	32	27,0	50	-6	-10	0,2	CN..1204..
	GL40-DCLNL-27032-12	40	32	27,0	50	-6	-10	0,2	CN..1204..
GL50	GL50-DCLNR-32032-12	50	32	32,0	63	-6	-8	0,3	CN..1204..
	GL50-DCLNL-32032-12	50	32	32,0	63	-6	-8	0,3	CN..1204..
	GL50-DCLNR-32037-16	50	37	32,0	63	-5	-14	0,4	CN..1606..
	GL50-DCLNL-32037-16	50	37	32,0	63	-5	-14	0,4	CN..1606..
	GL50-DCLNR-32040-19	50	40	32,0	63	-5	-14	0,4	CN..1906..
	GL50-DCLNL-32040-19	50	40	32,0	63	-5	-14	0,4	CN..1906..

## Spare Parts included in delivery

For GL size	Clamp pin	Clamp screw	Floating wedge clamp	Insert shim	Shim/clamp key	Shim screw	Spring	Clamp kit
...12	FP2012	L85021-T15P	CD12-S	DCO120310	T15P-7	C04008-T15P	S6912	CD12-S12
...16	FP2012	L86026-T20P	CD16-S	DCN160616	T20P-7L	C05010-T20P	S7010	CD16-S16
...19	FP2012	L86026-T20P	CD19-S	DCN190416	T20P-7L	C05010-T20P	S7010	CD19-S19

Accessories to be ordered separately

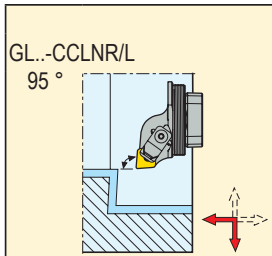
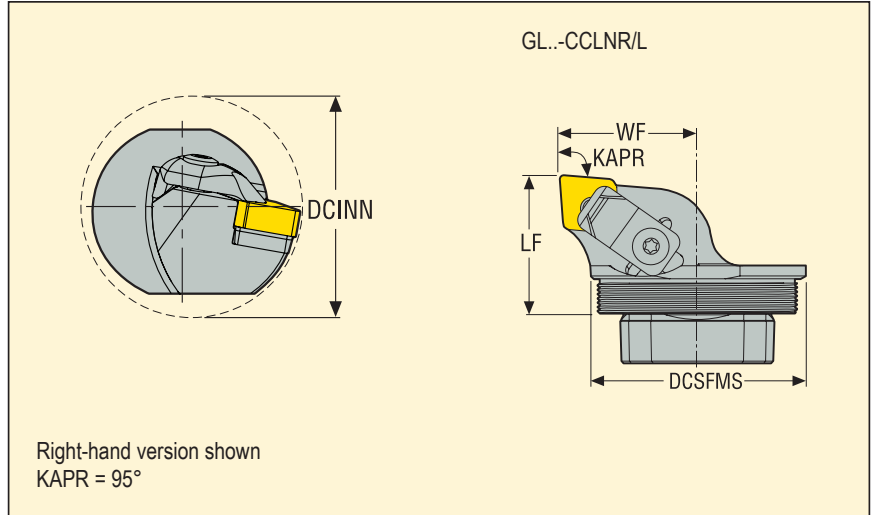
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# TURNING – STEADYLINE®, GL-HEADS, INTERNAL

Toolholders for PCBN inserts CNMN








- For inserts programme, see Turning Catalog page 454
- GAMO° = Rake angle, LAMS° = Inclination angle
- For holder code key, see pages 13-14



Size		Designation	Dimensions in mm				GAMO°	LAMS°	 KG	
			DCSFMS	LF	WF	DCINN				
GL50	12	GL50-CCLNR-32032-12	50	32	31,9	63	-6	-6	0,4	CNMN1204..
		GL50-CCLNL-32032-12	50	32	31,9	63	-6	-6	0,4	CNMN1204..

## Spare Parts included in delivery

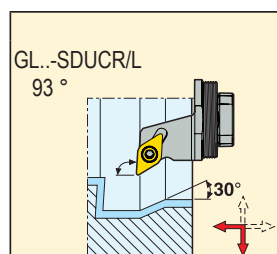
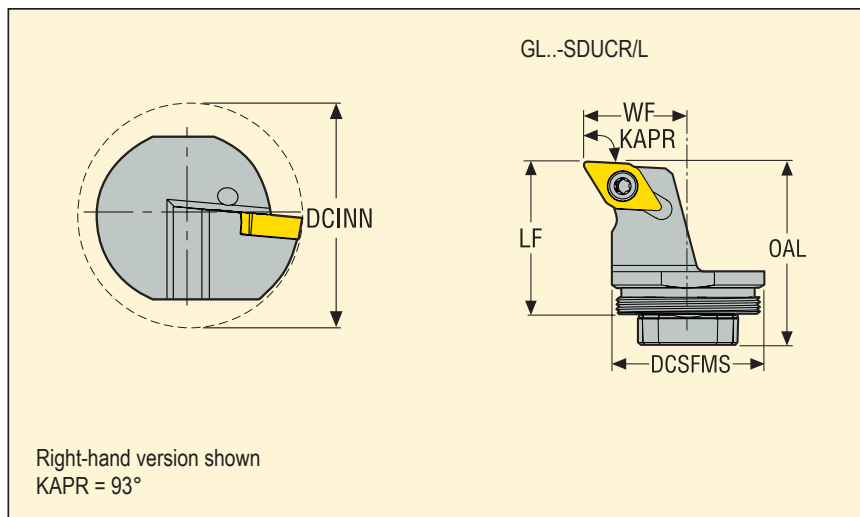
For GL size	Clamp 	Insert shim 	Key 	Pressure plate 	Shim screw 
..12	CC17P	CCN120312	T09P-2	P1311	F94009-T09P

# TURNING – STEADYLINE®, GL-HEADS, INTERNAL

Toolholders for inserts DCGT, DCGW, DCMT and DCMX



- For inserts programme, see Turning Catalog pages 407-410, 455, 482
- GAMO° = Rake angle, LAMS° = Inclination angle
- For holder code key, see pages 13-14



Size	Designation	Dimensions in mm					GAMO°	LAMS°	KG	Key
		DCSFMS	LF	WF	DCINN					
GL32	11 GL32-SDUCR-22032-11	32	32	22,0	40	0	-5	0,1	DC..11T3..	
	GL32-SDUCL-22032-11	32	32	22,0	40	0	-5	0,1	DC..11T3..	
GL40	11 GL40-SDUCR-27032-11	40	32	27,0	50	0	-5	0,2	DC..11T3..	
	GL40-SDUCL-27032-11	40	32	27,0	50	0	-5	0,2	DC..11T3..	
GL50	11 GL50-SDUCR-32032-11	50	32	32,0	63	0	-5	0,3	DC..11T3..	
	GL50-SDUCL-32032-11	50	32	32,0	63	0	-5	0,3	DC..11T3..	

## Spare Parts included in delivery

For GL size	Insert key	Insert screw
...11	T15P-2	C04008-T15P

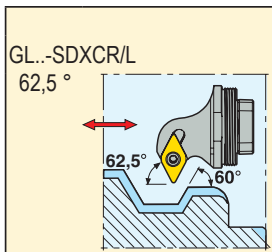
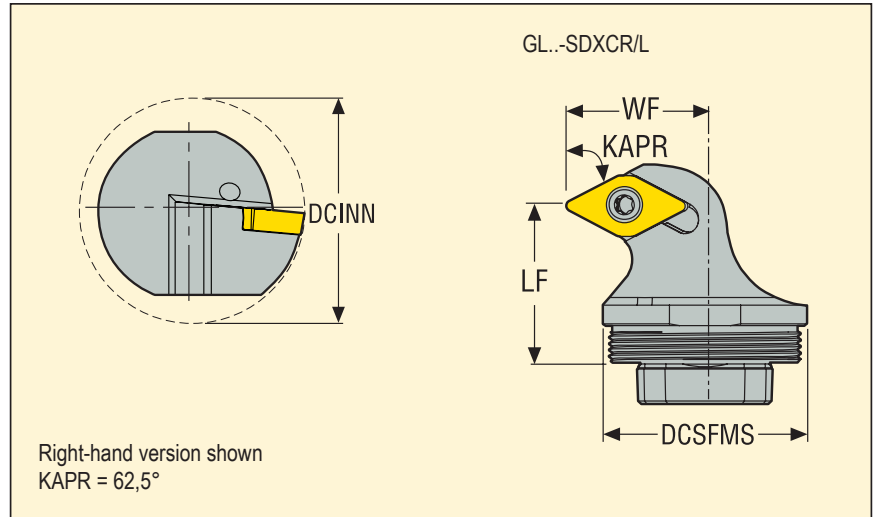
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# TURNING – STEADYLINE®, GL-HEADS, INTERNAL

Toolholders for inserts DCGT, DCGW, DCMT, DCMW and DCMX



- For inserts programme, see Turning Catalog pages 407-410, 455, 482
- GAMO° = Rake angle, LAMS° = Inclination angle
- For holder code key, see pages 13-14



Size	Designation	Dimensions in mm				GAMO°	LAMS°	KG	Key
		DCSFMS	LF	WF	DCINN				
GL32	GL32-SDXCR-22025-11	32	25	21,9	40	0	-5	0,2	DC..11T3..
	GL32-SDXCL-22025-11	32	25	21,9	40	0	-5	0,2	DC..11T3..
GL40	GL40-SDXCR-27025-11	40	25	26,9	50	0	-5	0,2	DC..11T3..
	GL40-SDXCL-27025-11	40	25	26,9	50	0	-5	0,2	DC..11T3..
GL50	GL50-SDXCR-32025-11	50	25	31,9	63	0	-5	0,3	DC..11T3..
	GL50-SDXCL-32025-11	50	25	31,9	63	0	-5	0,3	DC..11T3..

## Spare Parts included in delivery

For GL size	Insert screw	Key
...11	C04008-T15P	T15P-2

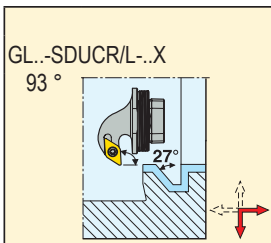
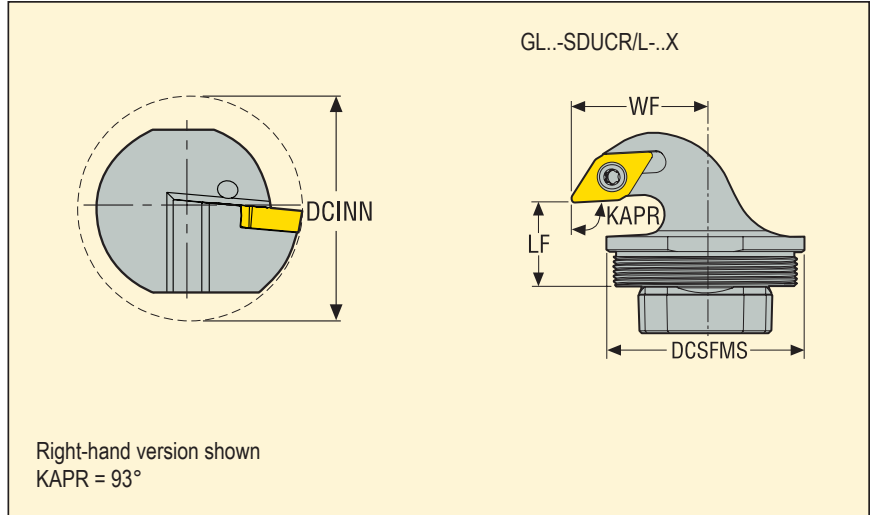
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# TURNING – STEADYLINE®, GL-HEADS, INTERNAL

Toolholders for inserts DCGT, DCGW, DCMT, DCMW and DCMX





- For inserts programme, see Turning Catalog pages 407-410, 455, 482
- GAMO° = Rake angle, LAMS° = Inclination angle
- For holder code key, see pages 13-14



Size	Designation	Dimensions in mm					GAMO°	LAMS°	KG	Key
		DCSFMS	LF	WF	DCINN					
GL32	11 GL32-SDUCR-22018-11X	32	18	21,9	40	0	-5	0,2	DC..11T3..	
	GL32-SDUCL-22018-11X	32	18	21,9	40	0	-5	0,2	DC..11T3..	
GL40	11 GL40-SDUCR-27017-11X	40	17	26,9	50	0	-5	0,2	DC..11T3..	
	GL40-SDUCL-27017-11X	40	17	26,9	50	0	-5	0,2	DC..11T3..	
GL50	11 GL50-SDUCR-32017-11X	50	17	32,0	63	0	-5	0,3	DC..11T3..	
	GL50-SDUCL-32017-11X	50	17	32,0	63	0	-5	0,3	DC..11T3..	

## Spare Parts included in delivery

For GL size	Insert screw	Key
		
..-11	C04008-T15P	T15P-2

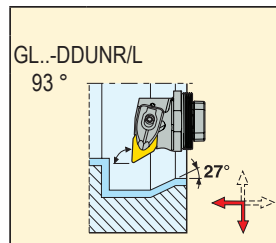
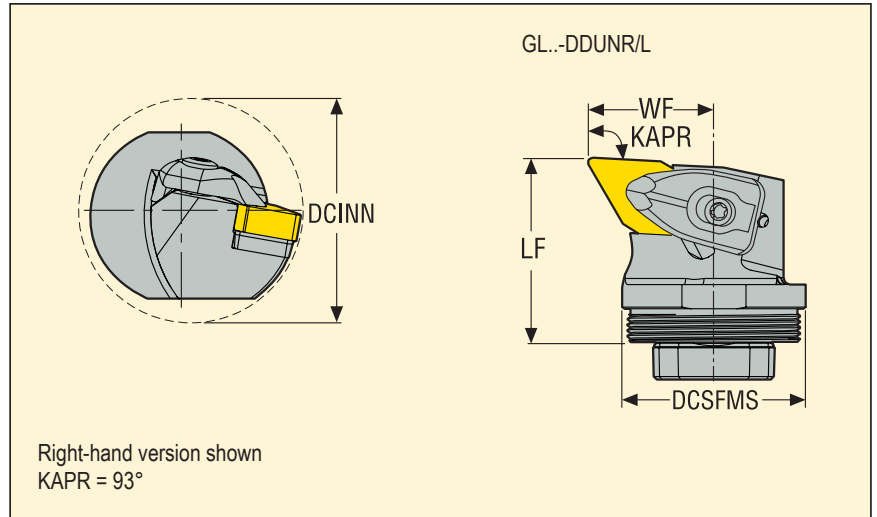
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# TURNING – STEADYLINE®, GL-HEADS, INTERNAL

Toolholders for PCBN inserts DNGA, DNGN, DNMA, DNMM



- For inserts programme, see Turning Catalog pages 410-416, 456-457
- GAMO° = Rake angle, LAMS° = Inclination angle
- For holder code key, see pages 13-14



Size	Designation	Dimensions in mm				GAMO°	LAMS°	KG	Insert
		DCSFMS	LF	WF	DCINN				
GL32	11 GL32-DDUNR-22032-11	32	32	22,0	40	-6	-10	0,2	DN..1104..
	GL32-DDUNL-22032-11	32	32	22,0	40	-6	-10	0,2	DN..1104..
GL40	11 GL40-DDUNR-27032-11	40	32	27,0	50	-5	-10	0,2	DN..1104..
	GL40-DDUNL-27032-11	40	32	27,0	50	-5	-10	0,2	DN..1104..
GL32	15 GL32-DDUNR-22032-15	32	32	21,9	40	-6	-14	0,2	DN..1506..
	GL32-DDUNL-22032-15	32	32	21,9	40	-6	-14	0,2	DN..1506..
GL40	15 GL40-DDUNR-27032-15	40	32	27,0	50	-6	-12	0,2	DN..1506..
	GL40-DDUNL-27032-15	40	32	27,0	50	-6	-12	0,2	DN..1506..
GL50	15 GL50-DDUNR-32032-15	50	32	27,0	63	-6	-12	0,3	DN..1506..
	GL50-DDUNL-32032-15	50	32	27,0	63	-6	-12	0,3	DN..1506..

## Spare Parts included in delivery

Accessories to be ordered separately

For GL size	Clamp pin	Clamp screw	Floating wedge clamp	Insert shim	Shim/clamp key	Shim screw	Spring	Clamp kit
...11	FP1508	L84017-T09P	CD09-S	DDN110310	T09P-2	C03007-T09P	S5608	CD09-S09
GL32...-15	FP2012	L85021-T15P	CD12-S	DDN150416	T15P-2	C04008-T15P	S6912	CD12-S12
GL40/50...-15	FP2012	L85021-T15P	CD12-S	DDN150416	T15P-7	C04008-T15P	S6912	CD12-S12

Please check availability in current price and stock-list and on [www.secotools.com](http://www.secotools.com)

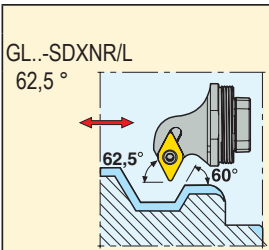
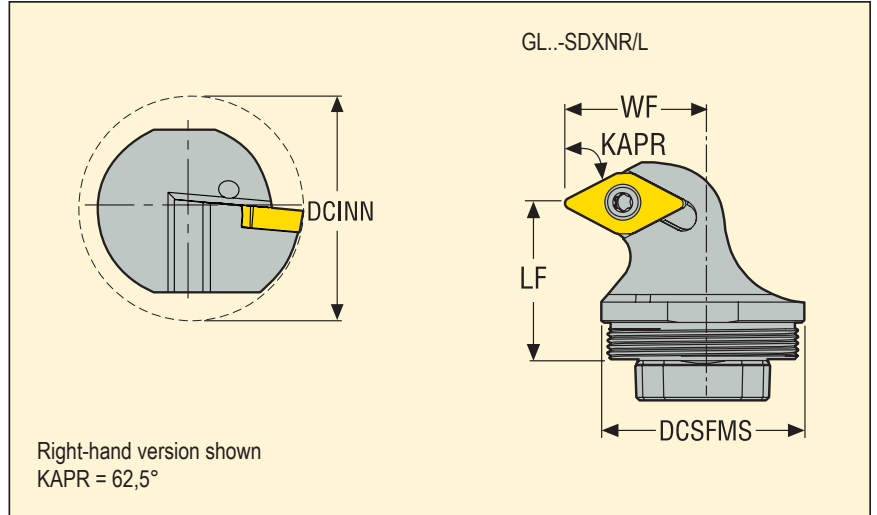


# TURNING – STEADYLINE®, GL-HEADS, INTERNAL

Toolholders for inserts DNMA, DNMU and DNMX



- For inserts programme, see Turning Catalog pages 415-416, 457
- GAMO° = Rake angle, LAMS° = Inclination angle
- For holder code key, see pages 13-14



Size	Designation	Dimensions in mm					GAMO°	LAMS°	KG	Key
		DCSFMS	LF	WF	DCINN					
GL32	11	GL32-SDXNR-22025-11	32	25	21,9	40	0	-10	0,2	DN..1104..
		GL32-SDXNL-22025-11	32	25	21,8	40	0	-10	0,2	DN..1104..

## Spare Parts included in delivery

For GL size	Insert screw	Key
...11	C03511-T09P	T09P-2

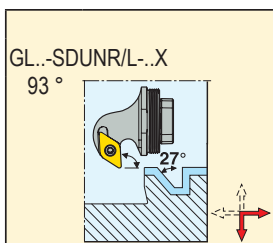
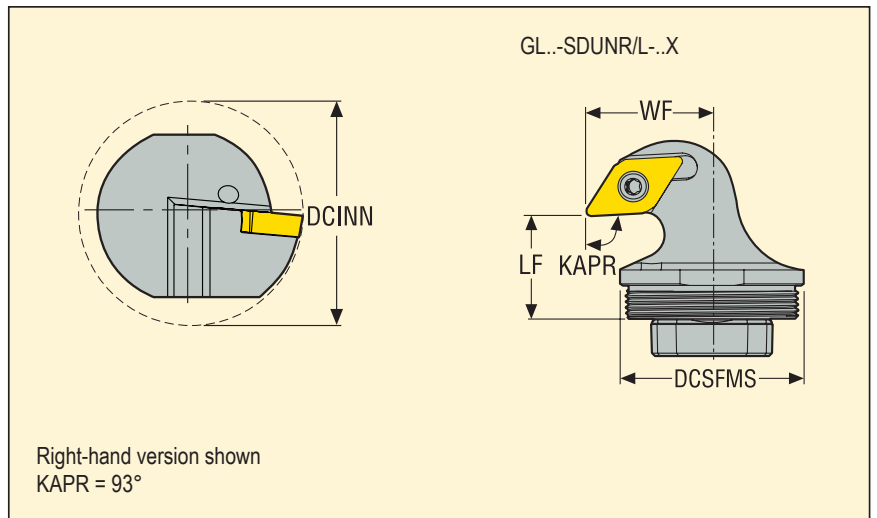
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# TURNING – STEADYLINE®, GL-HEADS, INTERNAL

Toolholders for inserts DNMU and DNMX





- For inserts programme, see Turning Catalog pages 415-416, 457
- GAMO° = Rake angle, LAMS° = Inclination angle
- For holder code key, see pages 13-14



Size		Designation	Dimensions in mm				GAMO°	LAMS°		
			DCSFMS	LF	WF	DCINN				
GL32	11	GL32-SDUNR-22018-11X	32	18	21,9	40	0	-10	0,2	DN..1104..
		GL32-SDUNL-22018-11X	32	18	21,9	40	0	-10	0,2	DN..1104..

## Spare Parts included in delivery

For GL size	Insert screw	Key
		
...11	C03511-T09P	T09P-2

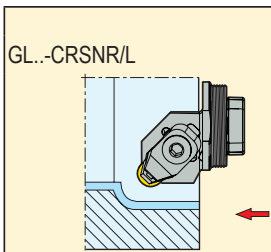
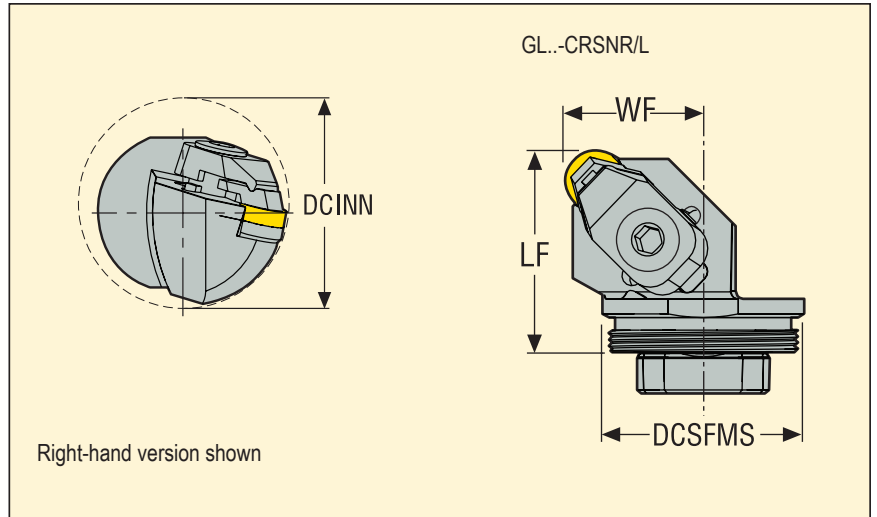
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# TURNING – STEADYLINE® , GL-HEADS, INTERNAL

Toolholders for PCBN inserts RNGN-LF, RNGN and RNMN



- For inserts programme, see Turning Catalog pages 459-461, 482-483
- GAMO° = Rake angle, LAMS° = Inclination angle
- For holder code key, see page 13-14



Size	Designation	Dimensions in mm				GAMO°	LAMS°	KG	
		DCSFMS	LF	WF	DCINN				
GL32	09 GL32-CRSNR-22032-09	32	32	22,0	40	-6	-12	0,2	RN.N0903..
	GL32-CRSNL-22032-09	32	32	22,0	40	-6	-12	0,2	RN.N0903..

## Spare Parts included in delivery

## Accessories to be ordered separately

For GL size	Cantilever clamp	Clamp key	Insert shim	Pressure plate	Shim screw	Shim key
...09	CC17P-09	4SMS795	117.10-620	P1311-09	174.10-652-T07P	T07P-2

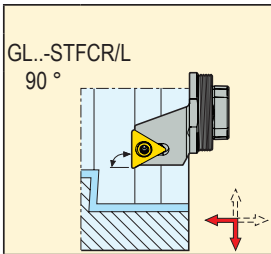
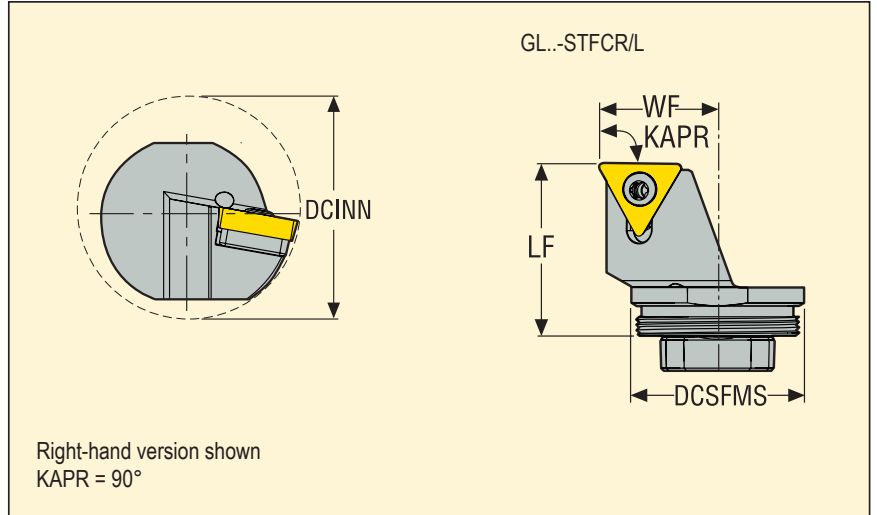
Please check availability in current price and stock-list and on [www.secotools.com](http://www.secotools.com)

# TURNING – STEADYLINE®, GL-HEADS, INTERNAL

Toolholders for inserts TCGT, TCGX, TCMT, TCMW and TCMX



- For inserts programme, see Turning Catalog pages 431-434, 483
- GAMO° = Rake angle, LAMS° = Inclination angle
- For holder code key, see pages 13-14



Size	Designation	Dimensions in mm				GAMO°	LAMS°	KG	Symbol
		DCSFMS	LF	WF	DCINN				
GL32	GL32-STFCR-22032-16	32	32	22,0	40	0	-10	0,2	TC..16T3..
	GL32-STFCL-22032-16	32	32	22,0	40	0	-10	0,2	TC..16T3..
GL40	GL40-STFCR-27032-16	40	32	27,0	50	0	-8	0,2	TC..16T3..
	GL40-STFCL-27032-16	40	32	27,0	50	0	-8	0,2	TC..16T3..
GL50	GL50-STFCR-32032-16	50	32	32,0	63	0	-8	0,3	TC..16T3..
	GL50-STFCL-32032-16	50	32	32,0	63	0	-8	0,3	TC..16T3..

## Spare Parts included in delivery

Accessories to be ordered separately

For GL size	Insert key	Insert screw	Insert shim	Shim screw	Shim key
...16	T15P-2	C03509-T15P	STN160312	CA3510	9/64SMS875

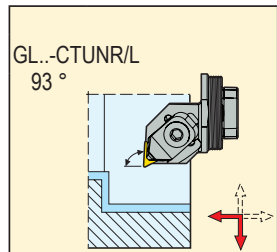
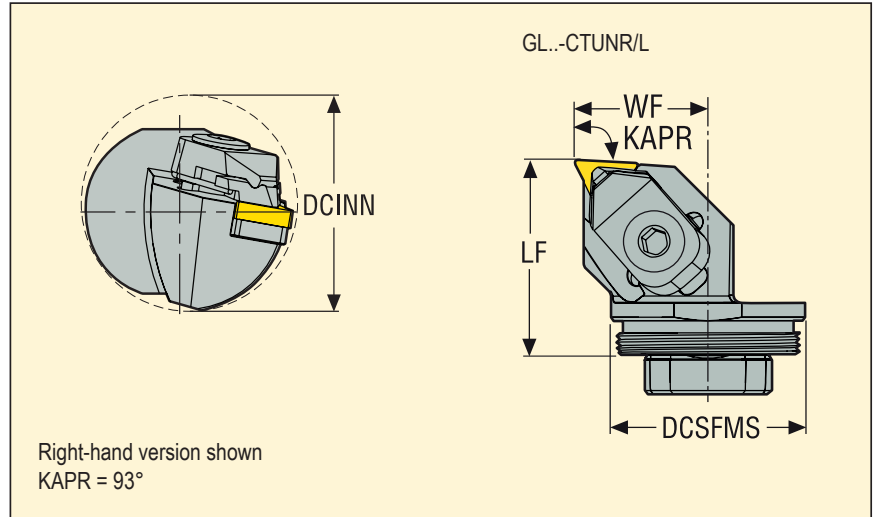
Please check availability in current price and stock-list and on [www.secotools.com](http://www.secotools.com)

# TURNING – STEADYLINE®, GL-HEADS, INTERNAL

Toolholders for PCBN inserts TNGN-LF, TNGN, TNGX, TNMN and TNMX



- For inserts programme, see Turning Catalog pages 470-474
- GAMO° = Rake angle, LAMS° = Inclination angle
- For holder code key, see pages 13-14



Size	Designation	Dimensions in mm				GAMO°	LAMS°	KG	Warning
		DCSFMS	LF	WF	DCINN				
GL32	11 GL32-CTUNR-22032-11	32	32	22,0	40	-6	-10	0,2	TN..1103..
	GL32-CTUNL-22032-11	32	32	22,0	40	-6	-10	0,2	TN..1103..

## Spare Parts included in delivery

Accessories to be ordered separately

For GL size	Cantilever clamp	Clamp key	Insert shim	Pressure plate	Shim screw	Shim key
..-11	CC17P-06	4SMS795	CTN110308	P1311-06	CS2507-T07P	T07P-2

Please check availability in current price and stock-list and on [www.secotools.com](http://www.secotools.com)

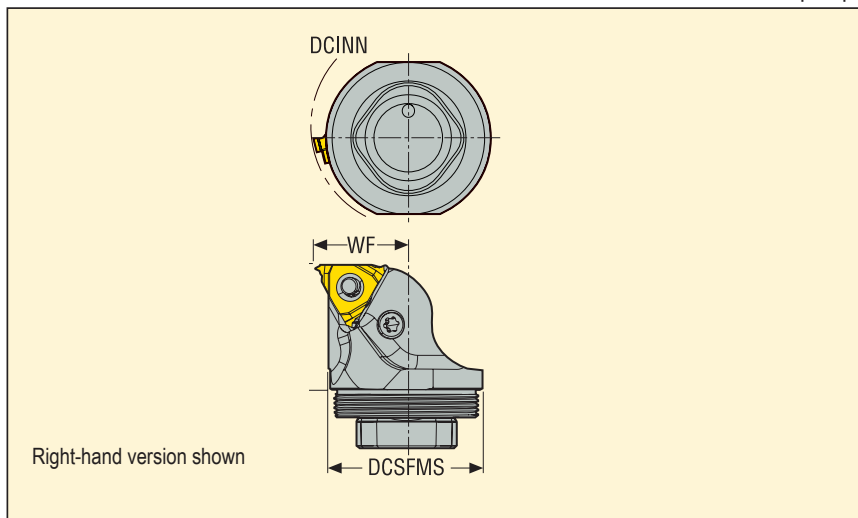
# THREAD TURNING – STEADYLINE®, GL-HEADS, INTERNAL JETSTREAM TOOLING®

Toolholders for S-inserts

Snap-Tap®



- For inserts programme, see Threading Catalog pages 85, 87, 90-91, 94-95, 98-99, 101-103, 105, 107, 109, 113



Application	Designation	Dimensions in mm				KG	16
		DCSFMS	LF	WF	DCINN		
	GL32-PNR-20032-16AHDJET	32,0	32,0	19,8	40,0	0,2	16
	GL32-PNL-20032-16AHDJET	32,0	32,0	19,8	40,0	0,2	16
	GL40-PNR-24032-16AHDJET	40,0	32,0	23,8	50,0	0,2	16
	GL40-PNL-24032-16AHDJET	40,0	32,0	23,8	50,0	0,2	16
	GL50-PNR-29032-16AHDJET	50,0	32,0	28,8	60,0	0,3	16
	GL50-PNL-29032-16AHDJET	50,0	32,0	28,8	60,0	0,3	16

## Spare Parts included in delivery

For holder	Insert lever	Insert shim (S)	Lever screw	Locking key	Shim pin
..16..	PP3712	GXA16-1	LS0612-T15P	T15P-7	AC4625

## Accessories to be ordererd separately

For holder	Insert shim (M)	Insert shim (S)						
..16..	MXA16-1	GXA16-0	GXA16-1	GXA16-2	GXA16-3	GXA16-4	GXA16-98	GXA16-99

Please check availability in current price and stock-list and on [www.secotools.com](http://www.secotools.com)

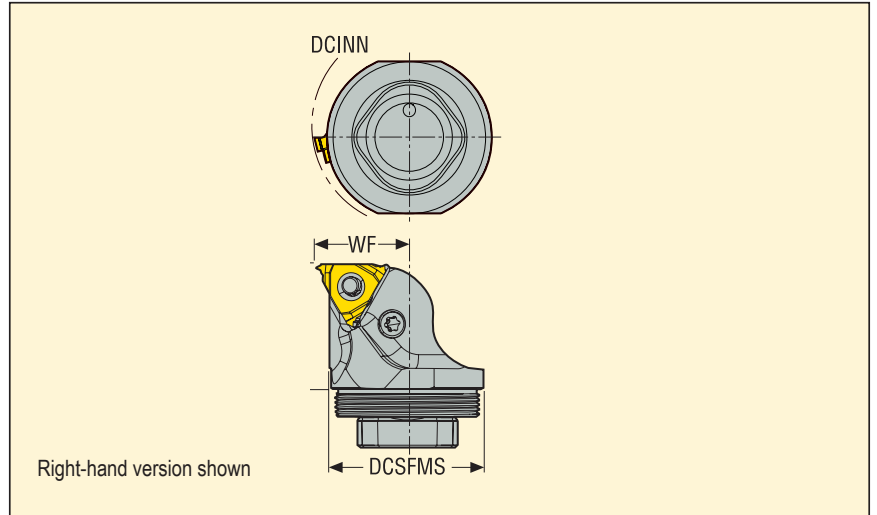
# THREAD TURNING – STEADYLINE®, GL-HEADS, INTERNAL JETSTREAM TOOLING®

Toolholders for S-inserts

Snap-Tap®



- For inserts programme, see Threading Catalog pages 85, 87, 90-91, 94-95, 98, 101, 103, 105, 107, 109-110, 111-115



Application	Designation	Dimensions in mm				KG		
		DCSFMS	LF	WF	DCINN			
	GL32-PNR-22032-22AHDJET	32,0	32,0	21,3	40,0	0,2	22	
	GL32-PNL-22032-22AHDJET	32,0	32,0	21,3	40,0	0,2	22	
	GL40-PNR-26032-22AHDJET	40,0	32,0	25,3	50,0	0,3	22	
	GL40-PNL-26032-22AHDJET	40,0	32,0	25,3	50,0	0,3	22	
	GL50-PNR-31032-22AHDJET	50,0	32,0	30,3	60,0	0,4	22	
	GL50-PNL-31032-22AHDJET	50,0	32,0	30,3	60,0	0,4	22	
	GL40-PNR-27037-27AHDJET	40,0	37,0	26,8	50,0	0,3	27	
	GL50-PNR-32037-27AHDJET	50,0	37,0	31,8	60,0	0,4	27	

## Spare Parts included in delivery

For holder	Insert lever	Insert shim (S)	Lever screw	Locking key	Shim pin
..22A..	PP4816	NXA22-1	LS0815-T25P	T25P-7	AC5035
..27A..	PP6019	VXA27-1	LS0820-T25P	T25P-7	AC6050

## Accessories to be ordered separately

For holder	Insert shim (M)	Insert shim (S)													
..22A..	MXA22-1	NXA22-0	NXA22-0.5	NXA22-1	NXA22-1.5	NXA22-2	NXA22-3	NXA22-4	NXA22-97.5	NXA22-98	NXA22-98.5	NXA22-99	NXA22-99.5		
..27A..	MXA27-1	VXA27-0	VXA27-0.5	VXA27-1	VXA27-1.5	VXA27-2	VXA27-3	VXA27-4	-	VXA27-98	VXA27-98.5	VXA27-99	VXA27-99.5		

Please check availability in current price and stock-list and on [www.secotools.com](http://www.secotools.com)

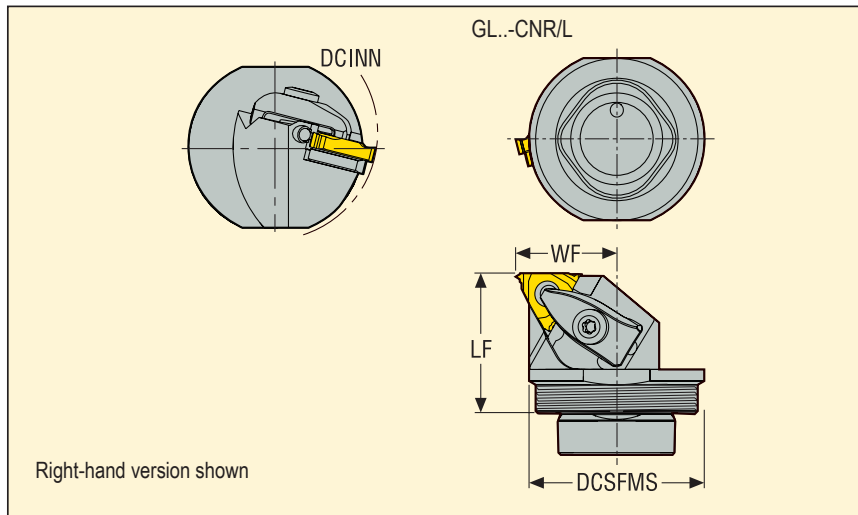
# THREAD TURNING – STEADYLINE®, GL-HEADS, INTERNAL

Toolholders with GL connection for S-inserts

Snap-Tap®



- For inserts programme, see Threading Catalog pages 85, 87, 90-91, 94-95, 98-99, 101-103, 105, 107, 109, 113



Application	Designation	Dimensions in mm				KG	
		DCSFMS	LF	WF	DCINN		
	GL32-CNR-20032-16AHD	32,0	32	19,8	40	0,2	16..
	GL32-CNL-20032-16AHD	32,0	32	19,8	40	0,2	16..
	GL40-CNR-24032-16AHD	40,0	32	24,0	50	0,3	16..
	GL40-CNL-24032-16AHD	40,0	32	24,0	50	0,3	16..
	GL50-CNR-29032-16AHD	50,0	32	29,0	63	0,4	16..
	GL50-CNL-29032-16AHD	50,0	32	29,0	63	0,4	16..

## Spare Parts included in delivery

For holder	Cantilever clamp	Clamp key	Clamp screw	Insert shim (S)	Shim key	Shim screw	Spring
..-16	 CHD16	 T15P-2	 L85020-T15P	 GX16-1	 T09P-2	 CS3507-T09P	 S6912

## Accessories to be ordered separately

For holder	Insert shim (M)	Insert shim (S)					
..-16	 MX16-1	 GX16-0	 GX16-2	 GX16-3	 GX16-4	 GX16-98	 GX16-99

Please check availability in current price and stock-list and on [www.secotools.com](http://www.secotools.com)



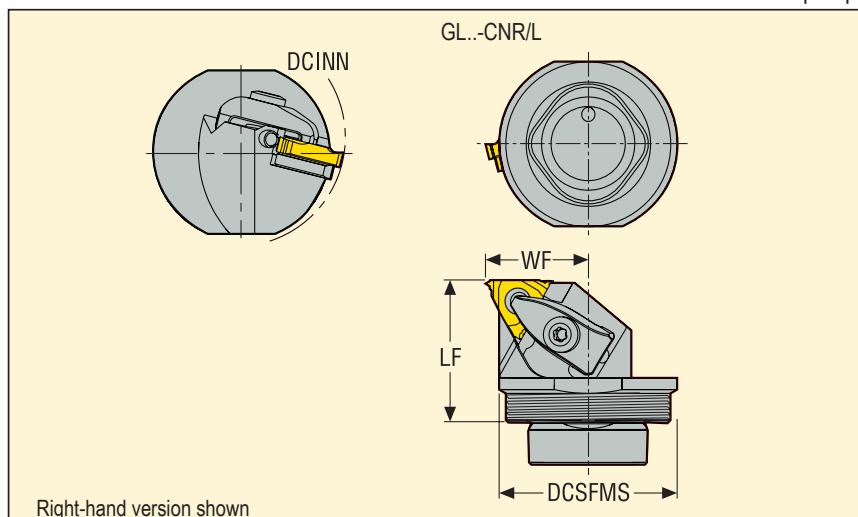
# THREAD TURNING – STEADYLINE®, GL-HEADS, INTERNAL

Toolholders with GL connection for S-inserts

Snap-Tap®



- For inserts programme, see Threading Catalog pages 85, 87, 90-91, 94-95, 98, 101, 103, 105, 107, 109-110, 111-115



Application	Designation	Dimensions in mm				KG		
		DCSFMS	LF	WF	DCINN			
	GL32-CNR-22032-22AHD	32,0	32	21,3	38	0,2	22..	
	GL32-CNL-22032-22AHD	32,0	32	21,3	38	0,2	22..	
	GL40-CNR-26032-22AHD	40,0	32	26,0	50	0,3	22..	
	GL40-CNL-26032-22AHD	40,0	32	26,0	50	0,3	22..	
	GL50-CNR-31032-22AHD	50,0	32	31,0	63	0,4	22..	
	GL50-CNL-31032-22AHD	50,0	32	31,0	63	0,4	22..	
	GL40-CNR-27037-27AHD	40,0	37	27,0	50	0,3	27..	
	GL50-CNR-32037-27AHD	50,0	37	32,0	58	0,4	27..	

## Spare Parts included in delivery

For holder	Cantilever clamp	Clamp key	Clamp screw	Insert shim (S)	Shim/clamp key	Shim screw	Spring
..-22	CSP22HD-T15P	T15P-2	–	NX22-1	–	CS4009-T15P	–
..-27	CHD27	T15P-2	L86025-T20P	VX27-1	T20P-7L	C05012-T15P	S7616

## Accessories to be ordered separately

For holder	Shim key	Insert shim (M)	Insert shim (S)										
..-22	T15P-2	MX22-1	NX22-0	NX22-0.5	NX22-1.5	NX22-2	NX22-3	NX22-4	NX22-97.5	NX22-98	NX22-98.5	NX22-99	NX22-99.5
..-27	T15P-2	MX27-1	VX27-0	VX27-0.5	VX27-1.5	VX27-2	VX27-3	VX27-4	–	VX27-98	VX27-98.5	VX27-99	VX27-99.5

Please check availability in current price and stock-list and on [www.secotools.com](http://www.secotools.com)

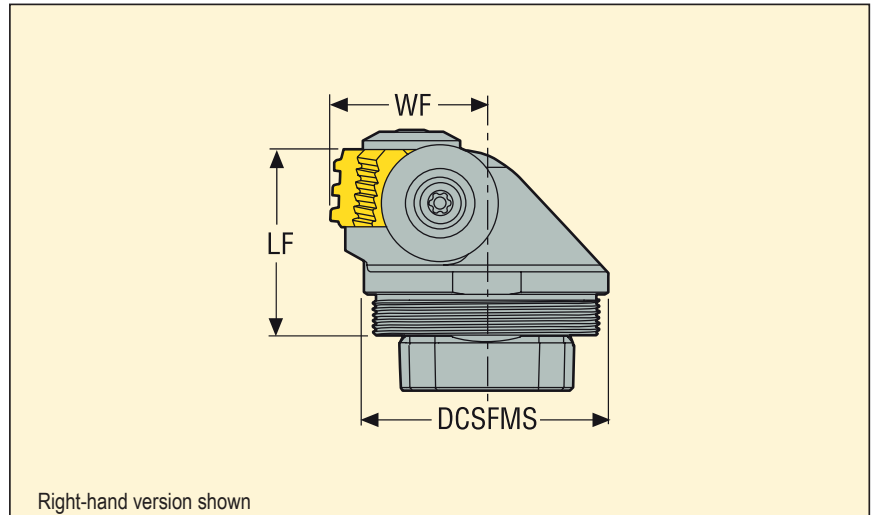
# THREAD TURNING – STEADYLINE®, GL-HEADS, INTERNAL

Toolholders for chasers, internal

Snap-Tap®



For inserts programme, see Threading Catalog page 116



Application	Designation	Dimensions in mm			KG	INSL
		DCSFMS	LF	WF		
	GL50-CNR-32035-9-I	50,0	35,0	32,0	0,4	12.700
	GL50-CNR-32038-1-X	50,0	38,0	32,0	0,4	15.875
	GL50-CNR-32044-5-X	50,0	44,0	32,0	0,5	25.000
	GL50-CNL-32035-9-I	50,0	35,0	32,0	0,5	12.700
	GL50-CNL-32038-1-X	50,0	38,0	32,0	0,5	15.875
	GL50-CNL-32044-5-X	50,0	44,0	32,0	0,5	25.000

## Spare Parts included in delivery

For holder	Clamp kit side	Clamp kit top	Key, side clamp	Key, top clamp
...9-1	W200613-T20P	W200613-T20P	T20P-7	T20P-7
...1-X, ...5-X	W200613-T20P	W240618-T25P	T20P-7	T25P-7

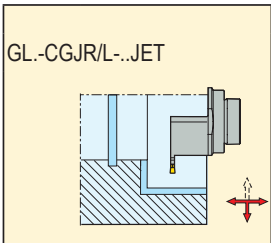
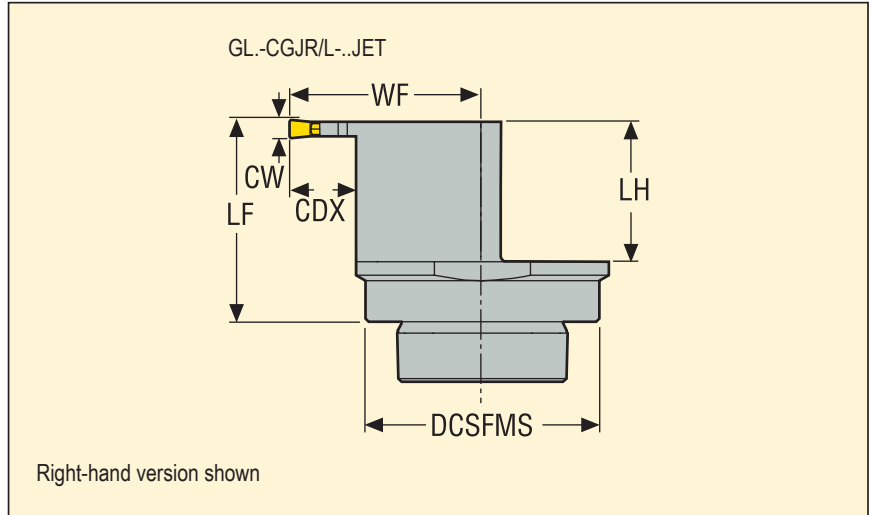
Please check availability in current price and stock-list and on [www.secotools.com](http://www.secotools.com)

# MDT – STEADYLINE®, GL-HEADS, INTERNAL JETSTREAM TOOLING®

Toolholders for inserts LCGF, LCGN, LCMF and LCMR



• For inserts programme, see Turning Catalog pages 632-649



Size	Designation	Dimensions in mm							KG	Insert
		DCSFMS	LF	WF	LH	CDX	DCINN*			
GL32	GL32-CGJR-25032-1902JET	32	32	25,0	23,0	7,0	43	0,2	LC..1902..	
	GL32-CGJL-25032-1902JET	32	32	25,0	23,0	7,0	43	0,2	LC..1902..	
GL40	GL40-CGJR-29032-1902JET	40	32	29,0	22,0	7,0	51	0,2	LC..1902..	
	GL40-CGJL-29032-1902JET	40	32	29,0	22,0	7,0	51	0,2	LC..1902..	
GL50	GL50-CGJR-34032-1902JET	50	32	34,0	21,5	7,0	61	0,3	LC..1902..	
	GL50-CGJL-34032-1902JET	50	32	34,0	21,5	7,0	61	0,3	LC..1902..	

\* DCINN – minimum bore diameter, see page(s) 529

## Spare Parts included in delivery

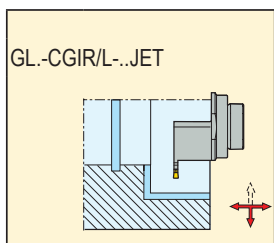
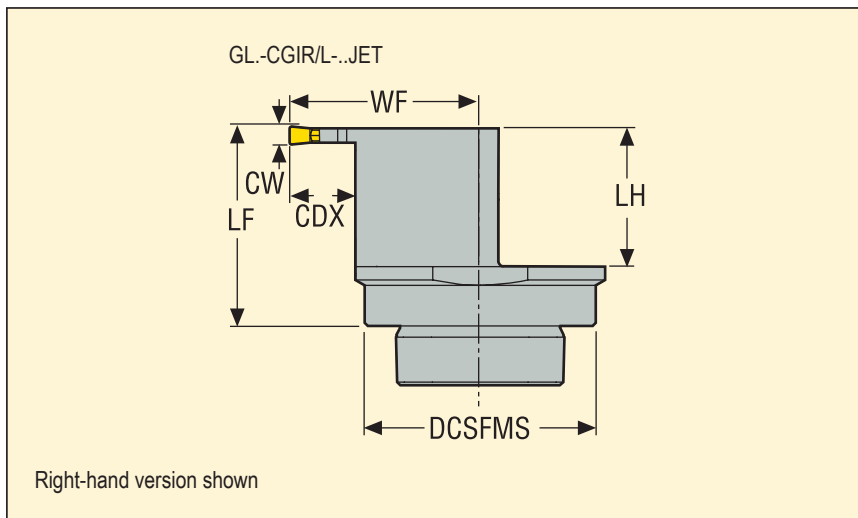
For size	Clamp key	Clamp screw
1902	T15P-7	L85011-T15P

# MDT – STEADYLINE®, GL-HEADS, INTERNAL JETSTREAM TOOLING®

Toolholders for inserts LCGF, LCGN, LCMF and LCMR



• For inserts programme, see Turning Catalog pages 632-649



Size	CW	Designation	Dimensions in mm						KG	
			DCSFMS	LF	WF	LH	CDX	DCINN*		
GL32	3	GL32-CGIR-26032-1603JET	32	32	26,5	23,0	9,0	44	0,2	LC..1603..
		GL32-CGIL-26032-1603JET	32	32	26,5	23,0	9,0	44	0,2	LC..1603..
GL40	3	GL40-CGIR-30032-1603JET	40	32	30,5	22,5	9,0	52	0,2	LC..1603..
		GL40-CGIL-30032-1603JET	40	32	30,5	22,5	9,0	52	0,2	LC..1603..
GL50	3	GL50-CGIR-35032-1603JET	50	32	35,5	21,5	9,0	62	0,3	LC..1603..
		GL50-CGIL-35032-1603JET	50	32	35,5	21,5	9,0	62	0,3	LC..1603..

\* DCINN – minimum bore diameter, see page(s) 529

## Spare Parts included in delivery

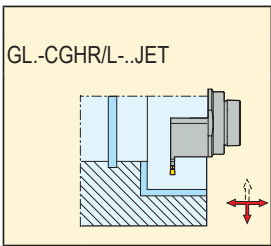
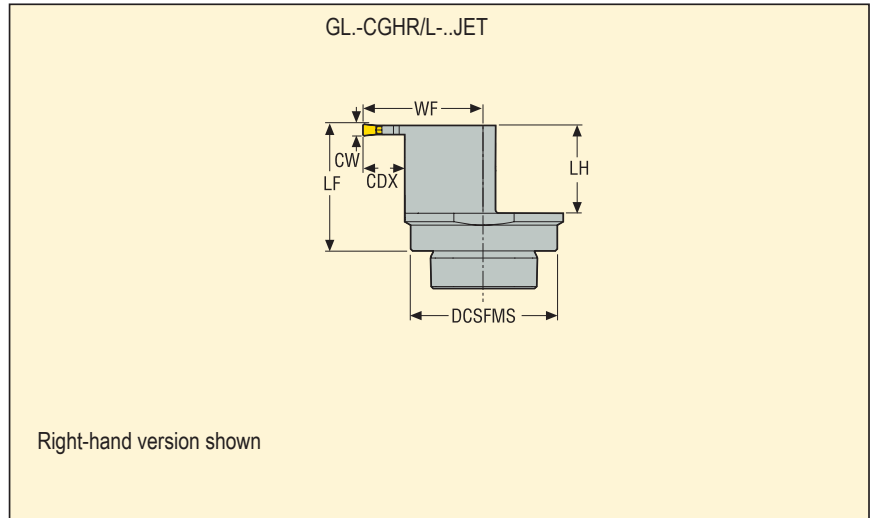
For size	Clamp key	Clamp screw
1603	T15P-7	L85011-T15P

# MDT – STEADYLINE®, GL-HEADS, INTERNAL JETSTREAM TOOLING®

Toolholders for inserts LCGF, LCGN, LCMF and LCMR



• For inserts programme, see Turning Catalog pages 632-649



Size	Designation	Dimensions in mm							KG	Insert
		DCSFMS	LF	WF	LH	CDX	DCINN*			
GL32	GL32-CGHR-27032-1604JET	32	32	27,5	23,0	10,0	45	0,2	LC..1604..	
	GL32-CGHL-27032-1604JET	32	32	27,5	23,0	10,0	45	0,2	LC..1604..	
GL40	GL40-CGHR-31032-1604JET	40	32	31,5	22,5	10,0	53	0,2	LC..1604..	
	GL40-CGHL-31032-1604JET	40	32	31,5	22,5	10,0	53	0,2	LC..1604..	
GL50	GL50-CGHR-36032-1604JET	50	32	36,5	21,5	10,0	63	0,3	LC..1604..	
	GL50-CGHL-36032-1604JET	50	32	36,5	21,5	10,0	63	0,3	LC..1604..	

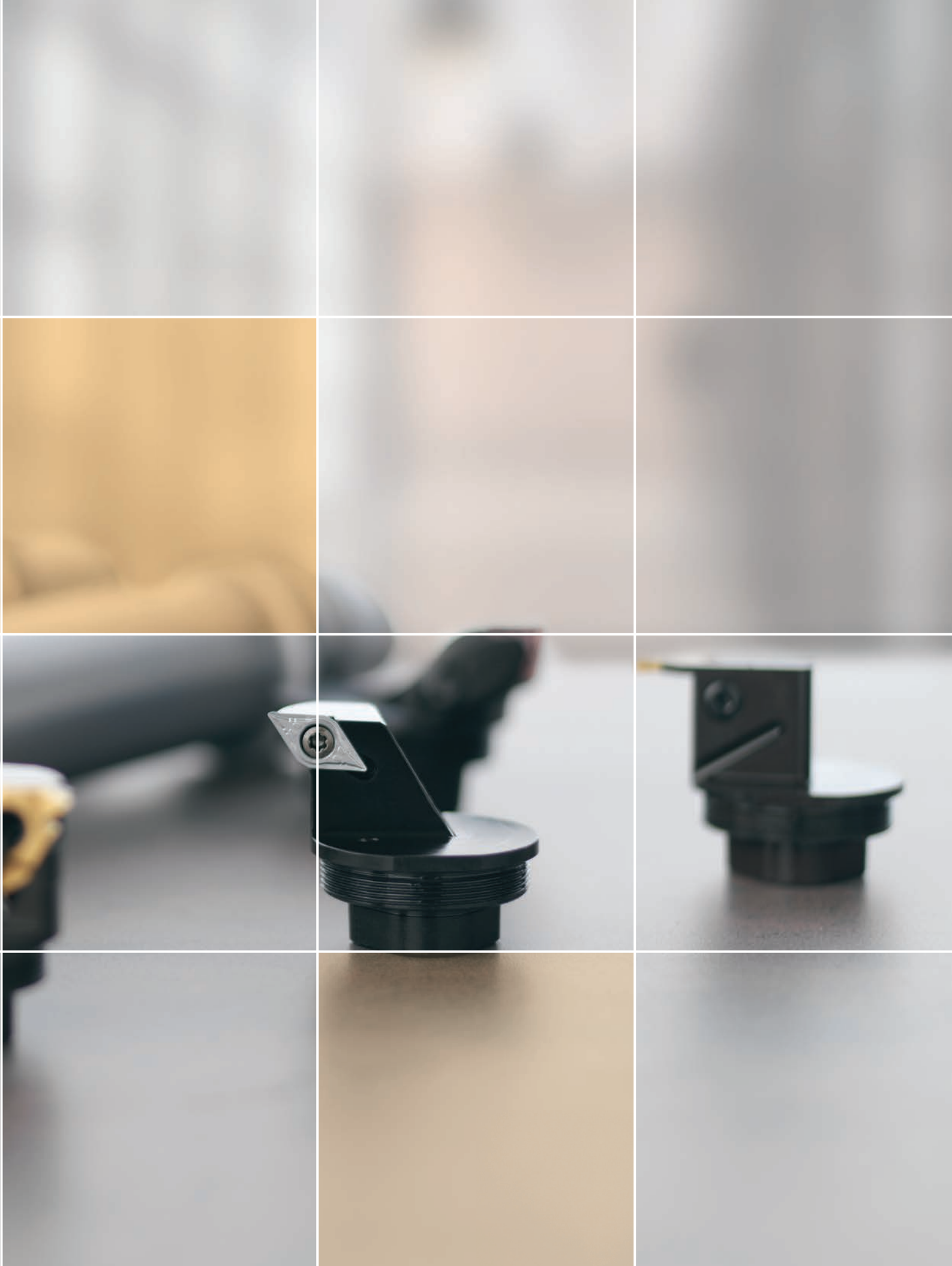
\* DCINN – minimum bore diameter, see page(s) 529

## Spare Parts included in delivery

For size	Clamp key	Clamp screw
1604	T15P-7	L85011-T15P

Please check availability in current price and stock-list and on [www.secotools.com](http://www.secotools.com)





# BORING HEADS



## EXPANDING THE BENEFITS OF VIBRATION DAMPING FOR HIGHER DEPTHS

Steadyline® bars with Seco-Capto™ and HSK-T/A machine side connection are equally suitable for static turning operations and for rotating boring operations.

By incorporating the advanced damping capabilities of Steadyline®, these boring solutions eliminate vibration, achieve higher productivity, boost surface quality and enable depths of up to 10xD.

Steadyline® bars with Seco-Capto™ machine side connection can be mounted on steep angle spindles (DIN, BT, CAT) using the shortest Seco-Capto™ adapters to maintain the efficiency of the Steadyline® damper.

### ROUGH BORING HEAD - EPB® 610 (GL CONNECTION)



### FINE BORING HEAD - EPB® 620 (GL CONNECTION)



- Available in three sizes:  $\varnothing 32$  mm,  $\varnothing 40$  mm,  $\varnothing 50$  mm
- Suitable for boring applications up to 10xD







# ROUGH BORING HEADS



## EXCELLENT PERFORMANCE FOR DIAMETERS 36 MM - 69 MM

### SECO EPB® 610 ROUGH BORING HEADS

Featuring a compact design and GL connection, EPB® 610 boring heads provide the best possible damping performance when used with Steadyline® GL turning and boring bars. The advanced capabilities of Steadyline® allow bars of up to 10xD to achieve the same results as shorter, non-damped assemblies.

The insert holders achieve a 90° lead angle for rhombic inserts, 0° rake angle and 0° inclination angle. A push-pull setting mechanism makes it fast and easy to set the diameter using a presetter.

The rough boring head assembly combines a body (head) with two insert holders to optimise geometrical hole precision starting from cast, flame cut or drilled holes. The symmetrical design ensures the best possible balance.

### OPTIMISED PERFORMANCE

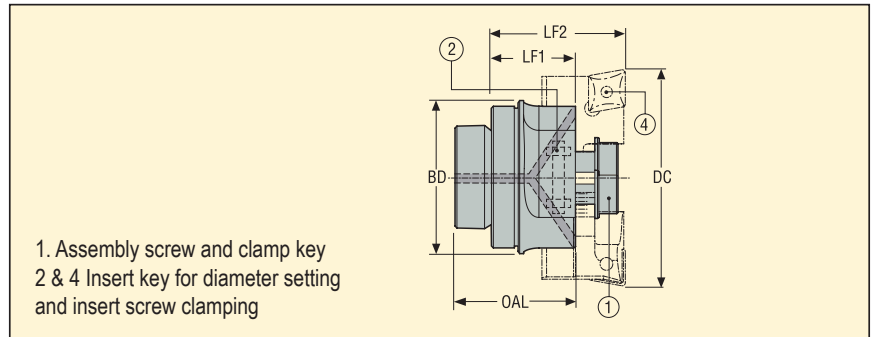
- High rigidity through a tight fit between the holders and body and large clamping screws
- Depth of cut of up to half the insert width maximises insert efficiency and metal removal rates
- Staggered boring using an included shim to offset one holder can increase or split the radial depth of cut
- Through-coolant delivery to increase insert life, performance and chip flow



# ROUGH BORING HEADS, SECO EPB® 610

SECO EPB® 610 GL – Rough boring heads, compact

GL

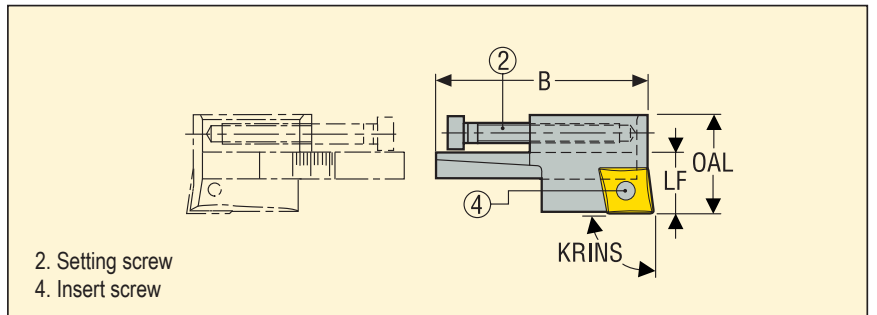
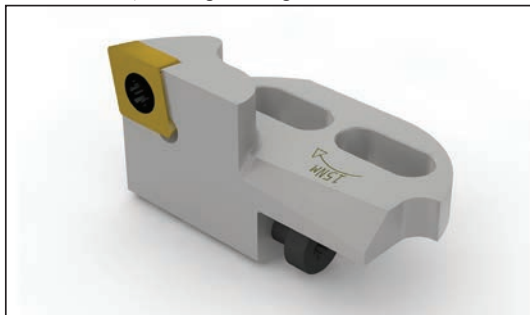


- Compact design and GL connection for best damping performance when used on Steadyline® turning and boring bar GL
- Symmetrical and staggered boring modes are possible
- Individual insert holder adjusting driving mechanism
- Internal coolant supply against cutting edges

Machine side GL size	Workpiece side Capacity DC Ø mm	Ordering and Product No.	Designation	Dimensions in mm				Max. RPM	 * KG
				OAL	LF1	LF2	BD		
GL32	36,0-46,0	02904458	GL32-0610-20	27,6	21,1	32,0	32,0	7500	0,10
GL40	45,0-56,0	02904459	GL40-0610-30	31,6	22,1	35,0	40,0	5700	0,20
GL50	55,0-69,0	02904460	GL50-0610-40	33,7	22,2	36,0	50,0	4500	0,30

\*Without insert holder.

## Insert holders, for rough boring heads SECO EPB® 610



Suitable for boring heads SECO EPB® 610 with Graflex or GL connection

For boring head	Capacity DC Ø mm	Ordering and Product No.	Designation	KRINS°	Dimensions in mm			Suitable insert size	 KG
					OAL	LF	B		
EPB® 61020	36,0-46,0	02971268	A61020CC0690	90,0	17,6	10,9	26,0	CC...0602...	0,1
EPB® 61030	39,0-56,0	02904461	A61030CC0990	90,0	21,6	12,9	33,0	CC...09T3...	0,1
EPB® 61040	50,0-69,0	02904462	A61040CC0990	90,0	22,5	13,8	43,8	CC...09T3...	0,1

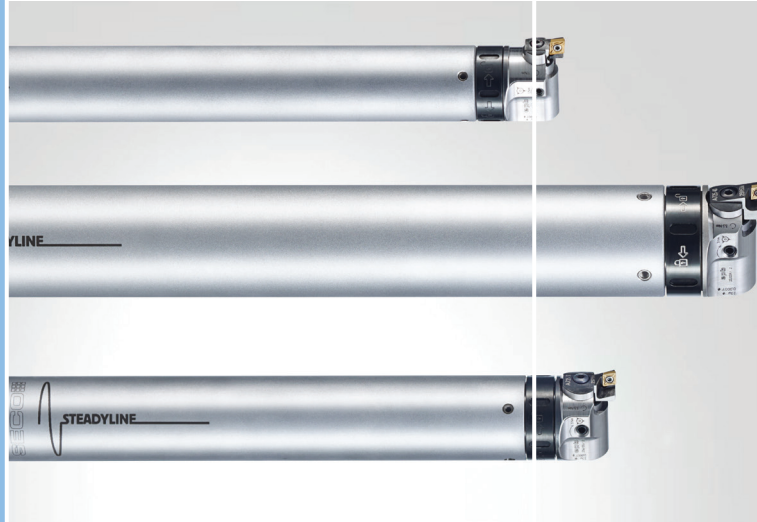
## Spare Parts included in delivery

For head	Assembly screw	Clamp key	Insert key	Shim, staggered boring
GL32-0610-20	950DC0412	03HL03	T07P-3	AU6102003
GL40-0610-30	950DC0616	03HL05	T15P-3	AU6103003
GL50-0610-40	950D0616	03HL05	T15P-3	AU6104003

## Accessories to be ordered separately

For insert size	Insert screw	Setting screw
A61020CC0690	C02504-T07P	19A61020
A61030CC0990	C04008-T15P	19A61030
A61040CC0990	C04008-T15P	19A61040
A61050CC1290	C05012-T15P	19A61050
A61060CC1290	C05012-T15P	19A61060

Please check availability in current price and stock-list and on [www.secotools.com](http://www.secotools.com)



## SUPERB FINISHING PERFORMANCE FOR DIAMETERS 34 MM TO 69 MM

### SECO EPB® 620 FINE BORING HEADS

The Seco EPB® 620 fine boring head assembly features a body (head) and radially fitted insert holder that incorporates a common front end design to accommodate the existing range of insert holders. Micrometric adjustment allows for maximum precision while a wide range of fine boring, chamfering and back boring holders can be used with the heads to ensure flexibility.



Seco EPB® 620 heads include a clamping screw for the insert holder, key for the insert holder clamping screw, diameter setting, barrel locking screw and operating instructions.

Seco EPB® 620 insert holders include the insert screw and key for the insert screw clamping. Additionally, chamfering insert holders also include a specific insert holder clamp screw, which is used instead of the standard clamp screw.

### PREDICTABLE AND REPEATABLE PRECISION

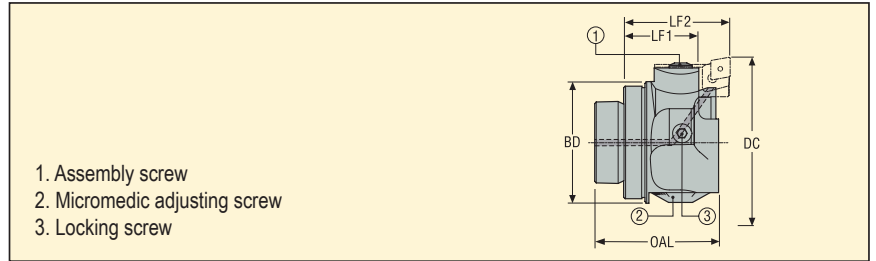
- Angular orientation of the cutting edge according to DIN 6987/ISO 7388 for SA and ISO 12164 for HSK
- Heads with insert holders pre-balanced on median diameter setting
- Insert holder setting mechanism features micrometric adjusting screw (1 increment = 0,01 mm on diameter) and a vernier scale (resolution of 2,5 µm on diameter)
- Through-coolant delivery to increase insert life, performance and chip flow



# FINE BORING HEADS, SECO EPB® 620

SECO EPB® 620 GL – Fine boring heads, compact, with GL connection

GL

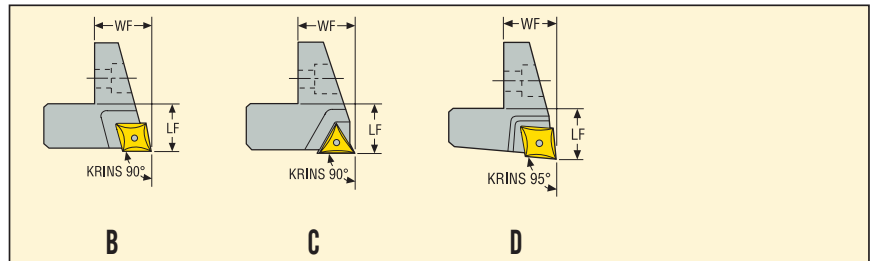


- Compact design and GL connection for best damping performance when used on Steadyline® turning and boring bar GL
- Adjusting increment 0.01mm and vernier 2.5µm, on the diameter
- Internal coolant supply against cutting edge

Machine side GL size	Workpiece side Capacity DC Ø mm	Ordering and Product No.	Designation	Dimensions in mm				Max. RPM	KG*
				OAL	BD	LF1	LF2		
GL32	34,0-46,0	02904469	GL32-0620-20	35,2	32,0	23,8	32,1	7000	0,13
GL40	42,0-56,0	02904470	GL40-0620-30	40,7	40,0	24,8	35,1	5600	0,22
GL50	52,0-69,0	02904471	GL50-0620-40	43,7	50,0	25,8	36,1	4800	0,32

\*Without insert holder.

Insert holders, for fine boring heads SECO EPB® 620



Suitable for radial boring heads SECO EPB® 620

Insert holders type	For boring head	Insert holder size	Capacity DC Ø mm	Ordering and Product No.	Designation	Dimensions in mm		Suitable insert size	Design	KG
						WF	LF			
90° for CC inserts	EPB® 62020	20	30,0-46,0	00056581	A72520	5,0	8,3	CC...0602...	B	0,02
	EPB® 62030	30	39,0-56,0	00056582	A72530	8,0	10,3	CC...0602...	B	0,02
	EPB® 62040	40	50,0-69,0	00056583	A72540	9,5	10,3	CC...0602...	B	0,02
90° for TC inserts	EPB® 62030	30	39,0-56,0	00056572	A72430	7,9	10,3	TC...1102...	C	0,01
	EPB® 62040	40	50,0-69,0	00056573	A72440	9,4	10,3	TC...1102...	C	0,02
95° for CC inserts	GL32-0520-20	20	30-40/-34-45	00056591	A72620	8,3	5	CC...0602...	D	0,01
	GL40-0520-30	30	39-51/-42-55	00056592	A72630	10,3	8	CC...0602...	D	0,01
	GL50-0520-40	40	50-65/-52-69	00056593	A72640	10,3	9,5	CC...0602...	D	0,02

Spare Parts included in delivery

For head	Assembly screw	Clamp key	Locking screw
GL32-0620-20	19TB0305	H2,0-2D	950L0406
GL40-0620-30	19TB04075	03M03C	950L0608
GL50-0620-50	19TB04075	03M03C	950L0608

Spare Parts included in delivery

For insert size	Insert key	Insert screw
CC...0602...	T07P-3	C02504-T07P
CC...09T3...	T15P-3	C04008-T15P
TC...1102...	T07P-3	C02504-T07P
WB...0301...	T06P-2	C02035-T06P

Please check availability in current price and stock-list and on [www.secotools.com](http://www.secotools.com)

# MILLING



## VERSATILE SOLUTIONS FOR ALL YOUR MILLING APPLICATIONS WIDE MILLING RANGE OF SECO STEADYLINE®

With configuration for Combimaster™ and shell-mill holders, Steadyline® covers a broad range of milling applications from  $\varnothing 20$  mm to over  $\varnothing 160$  mm. Introduced in 2009, the shell-mill holders are already providing highly efficient performance in thousands of applications worldwide. All Steadyline® products maximise rigidity through a conical-reinforced cylindrical shape that achieves high static and dynamic stability in heavy machining applications. Additionally, the holders feature a chrome-coated surface that increases resistance to wear and corrosion.



### SHELL-MILL HOLDERS - TYPE 5555-5556

Providing an ideal solution across a range of applications, shell-mill holders excel for slot milling, square shoulder milling, contouring, face milling, helical interpolation ramping and copy milling.

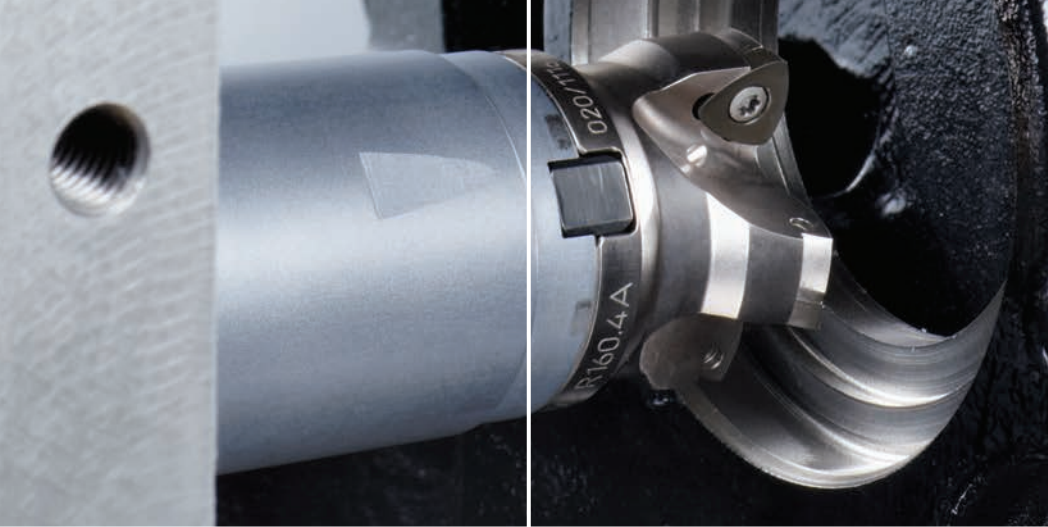
- Arbor:  $\varnothing 16$  mm to  $\varnothing 40$  mm
- Enhanced bearing surface
- Coolant channels through pilot

### FLEXIBLE SYSTEM: COMBIMASTER™

A versatile option with high levels of interchangeability, the Combimaster™ system features replaceable head milling cutters for all kinds of applications (e.g. square shoulder milling, end milling, copy milling, face milling, plunge milling, disc milling, etc.) and many insert styles.

- Connection size: M10 to M20
- Different pitch versions
- Rigid clamping





# CASE STUDIES MILLING

## CASE 1: SHELL MILL CONVENTIONAL MILLING TOOL

Operation: Pocket milling  
Cutter: R220.97-0050-V22.2A  
Tooling: C6-391.5525-22210  
Insert: VPGX220640ER-E10, H25  
Material: AlZnMgCu1.5

Cutting data	Metric			
	$v_c$	1180m/min	$f_z$	0.25 mm/tooth
	$a_p$	3.5 mm	$a_e$	25 mm

## CASE 1: SHELL MILL AV SYSTEM

Operation: Pocket milling  
Cutter: R220.97-0050-V22.2A  
Tooling: C6-391.5555-22210  
Insert: VPGX220640ER-E10, H25  
Material: AlZnMgCu1.5

Cutting data	Metric			
	$v_c$	1270m/min	$f_z$	0.25 mm/tooth
	$a_p$	7.0 mm	$a_e$	25 mm

**Results**

- Increased feed rate
- Doubled cutting depth

## CASE 2: COMBIMASTER™ CONVENTIONAL MILLING TOOL

Operation: Side milling  
Cutter: R217.69-1020.RE-10-3A (ø20 mm)  
Tooling: E9304582010185  
Material: 1.1206 CK50

Cutting data	Metric			
	$v_c$	312m/min	$f_z$	0.3 mm/tooth
	$a_p$	0.9 mm	$a_e$	4.0 mm

## CASE 2: COMBIMASTER™ AV SYSTEM

Operation: Side milling  
Cutter: R217.69-1020.RE-10-3A (ø20 mm)  
Tooling: E9304K82010185  
Material: 1.1206 CK50

Cutting data	Metric			
	$v_c$	312 m/min	$f_z$	0.3 mm/tooth
	$a_p$	2.2 mm	$a_e$	4.0 mm

**Results** Increased cutting depth:  $a_p \times 2,3$

## CASE 3: COMBIMASTER™ CONVENTIONAL MILLING TOOL

Operation: Slotting  
Cutter: R217.69-1020.RE-10-3A (ø20 mm)  
Tooling: E9304582010185  
Material: 1.1206 CK50

Cutting data	Metric			
	$v_c$	200 m/min	$f_z$	0.16 mm
	$a_p$	0.25 mm	$a_e$	20 mm

## CASE 3: COMBIMASTER™ AV SYSTEM

Operation: Slotting  
Cutter: R217.69-1020.RE-10-3A (ø20 mm)  
Tooling: E9304K82010185  
Material: 1.1206 CK50

Cutting data	Metric			
	$v_c$	200 mm/min	$f_z$	0.16 mm
	$a_p$	0.8 mm	$a_e$	20 mm

**Results** 3 times higher cutting depth

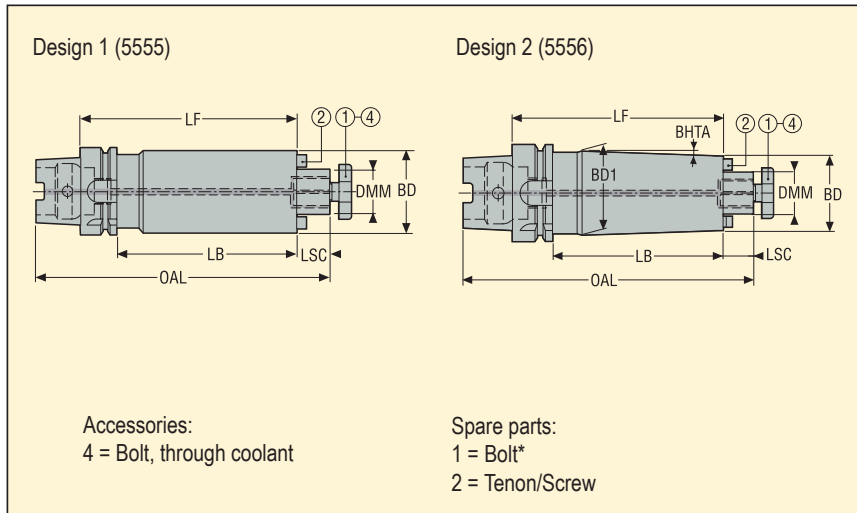
# HSK-A TOOL HOLDERS

SECO EPB® 5555/5556 – Steadyline®, vibration damping shell mill holders

HSK-A/ ISO12164-1-HSK-A



- With dynamic damping, ready to use
- Direct run-out 5 µm maximum
- With coolant supply channels through the spigot



Machine side	Workpiece side	Designation	Dimensions in mm						Design	BHTA°	RFID hole	Balancing	KG
			LF	BD	BD1	OAL	LB	LSC					
HSK-A63	16	E9304555516160	160,0	38,0	38,0	209,0	134,0	17,0	1	–	1	PB	2,40
	22	E9304555522210	210,0	48,0	48,0	261,0	184,0	19,0	1	–	1	PB	3,54
	22	E9304555622260	260,0	48,0	63,3	311,0	234,0	19,0	2	1,9	1	PB	5,38
	27	E9304555527260	260,0	60,0	60,0	313,0	234,0	21,0	1	–	1	PB	6,56
HSK-A100	22	E9306555522210	210,0	48,0	48,0	279,0	181,0	19,0	1	–	1	PB	4,80
	22	E9306555622260	260,0	48,0	65,0	329,0	231,0	19,0	2	1,9	1	PB	6,78
	27	E9306555527260	260,0	60,0	60,0	331,0	231,0	21,0	1	–	1	PB	7,92
	32	E9306555532330	330,0	78,0	78,0	404,0	301,0	24,0	1	–	1	PB	14,42

## Accessories to be ordered separately

For DMM	Bolt, through coolant	Spanner
16	5801608L	5811608
22	5802210L	5812210
27	5802712L	5812712
32	5803216L	5813216

## Spare Parts included in delivery

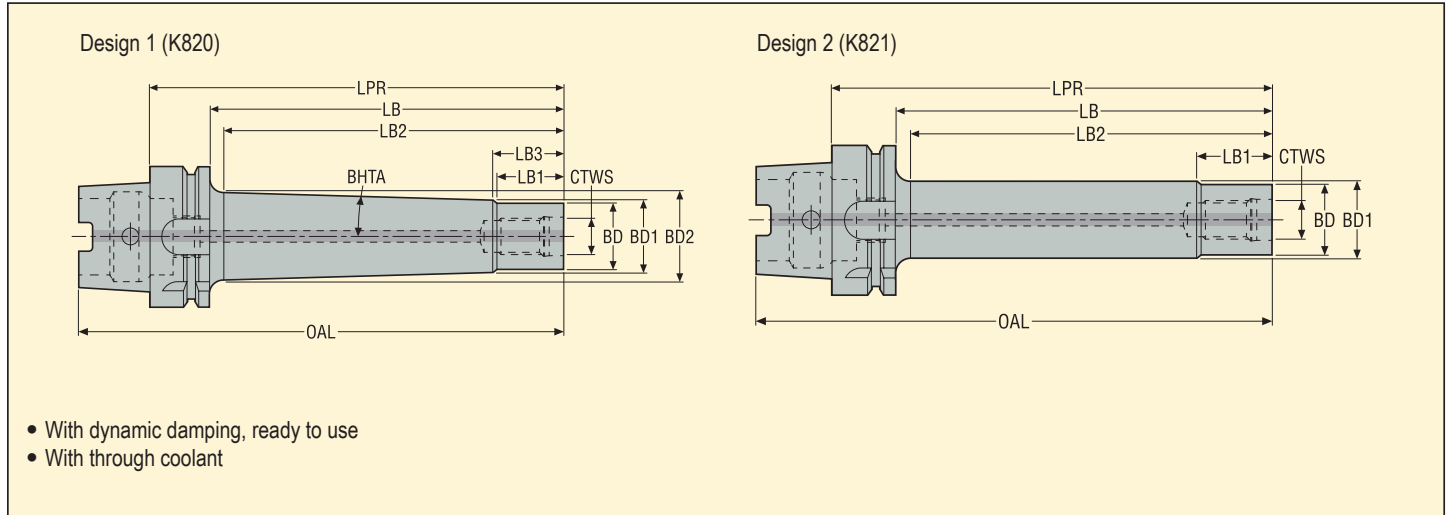
For DMM	Bolt	Screw	Tenon
16	5801608	951D0312	16C2080810A
22	5802210	951D0416	16C2101111
27	5802712	951D0516	16C2121214A
32	5803216	951D0516	16C2141421A



# HSK-A TO COMBIMASTER™ ADAPTERS

SECO EPB® K820-K821 – Steadyliner® vibration damping Combimaster™ arbors

HSK-A/ ISO12164-1-HSK-A



Machine side	Workpiece side	Combimaster™	Dimensions in mm									BHTA°	Design	Max. RPM	RFID hole	Balancing	KG
			CTWS	Designation	LPR	LB	LB2	LB1	BD	BD2	BD1						
HSK-A63	M10	E9304K82010185	185,0	159,0	154,2	20,0	18,5	36,6	24,0	217,0	2,8	1	12000	1	PB	1,51	
	M12	E9304K82012185	185,0	159,0	154,2	20,0	23,0	42,0	29,5	217,0	2,8	1	12000	1	PB	1,90	
	M16	E9304K82016185	185,0	159,0	154,2	20,0	30,0	59,5	37,0	217,0	2,8	1	10000	1	PB	2,59	
	M16	E9304K82016235	235,0	209,0	190,6	20,0	30,0	53,0	37,0	267,0	2,8	1	8000	1	PB	3,50	
	M16	E9304K82116160	160,0	134,0	129,0	22,0	30,0	30,5	30,5	192,0	–	2	10000	1	PB	1,40	
	M20	E9304K82020185	185,0	159,0	140,2	24,7	36,5	55,7	45,0	217,0	2,7	1	10000	1	PB	3,30	
	M20	E9304K82020235	235,0	209,0	186,4	24,7	36,5	60,1	45,0	267,0	2,7	1	8000	1	PB	4,30	
HSK-A100	M12	E9306K82012235	235,0	206,0	201,2	20,0	23,0	46,6	29,5	285,0	2,8	1	8000	1	PB	4,00	
	M16	E9306K82016235	235,0	206,0	201,2	20,0	30,0	54,0	37,0	285,0	2,8	1	8000	1	PB	4,78	
	M16	E9306K82016285	285,0	256,0	251,2	20,0	30,0	58,8	37,0	335,0	2,8	1	6000	1	PB	5,86	
	M16	E9306K82116185	185,0	156,0	151,0	22,0	30,0	30,5	30,5	235,0	–	2	8000	1	PB	2,91	
	M20	E9306K82020235	235,0	206,0	201,2	24,7	36,5	61,6	45,0	285,0	2,7	1	8000	1	PB	5,70	
	M20	E9306K82020285	285,0	256,0	251,2	24,7	36,5	66,4	45,0	335,0	2,7	1	6000	1	PB	7,20	

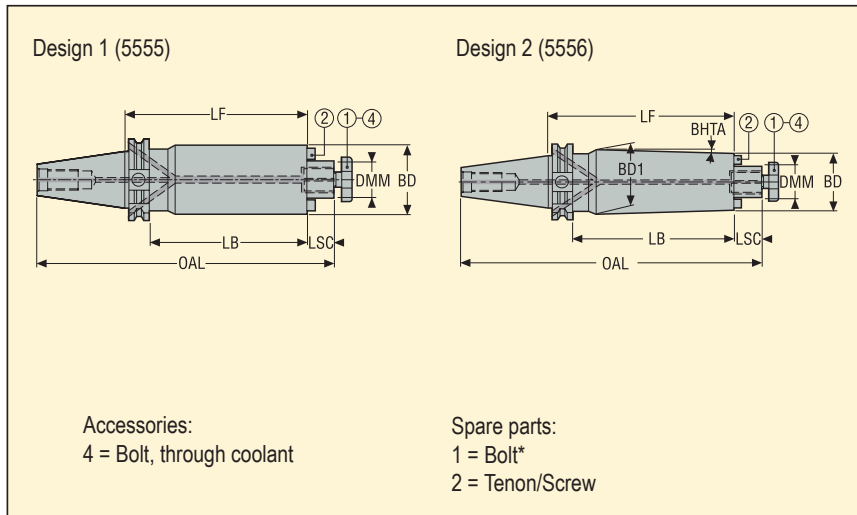
# DIN 69871 TOOL HOLDERS

SECO EPB® 5555/5556 – Steadyline®, vibration damping shell mill holders

DIN 69871-ADB



- With dynamic damping, ready to use
- Direct run-out 5 µm maximum
- With coolant supply channels through the spigot



Machine side	Workpiece side	Designation	Dimensions in mm						Design	BHTA°	RFID hole	Balancing	KG
			LF	BD	BD1	OAL	LB	LSC					
DIN40 ADB	16	E3469555516160	160,0	38,0	38,0	245,4	141,0	17,0	1	–	1	PB	2,12
	22	E3469555522210	210,0	48,0	48,0	297,4	191,0	19,0	1	–	1	PB	3,74
	22	E3469555622260	260,0	48,0	63,2	347,4	241,0	19,0	2	1,9	1	PB	5,56
DIN50 ADB	22	E3471555522210	210,0	48,0	48,0	330,7	191,0	19,0	1	–	1	PB	5,36
	22	E3471555622260	260,0	48,0	66,0	380,7	241,0	19,0	2	2,0	1	PB	7,52
	27	E3471555527260	260,0	60,0	60,0	382,7	241,0	21,0	1	–	1	PB	8,52
	27	E3471555627320	320,0	60,0	79,5	442,7	301,0	21,0	2	1,7	1	PB	12,26
	32	E3471555532330	330,0	78,0	78,0	455,7	311,0	24,0	1	–	1	PB	14,96
	40	E3471555540350	350,0	89,0	89,0	475,7	331,0	27,0	1	–	1	PB	20,40

DMM 40, includes 4 threaded holes on the bearing face according to DIN 6357

## Accessories to be ordered separately

For Taper/ DMM	Bolt, through coolant	Spanner
DIN40/ 16	5801608L	5811608
DIN40/ 22	5802210L	5812210
DIN50/ 22	5802210L	5812210
DIN50/ 27	5802712L	5812712
DIN50/ 32	5803216L	5813216
DIN50/ 40	5804020L	5814020

## Spare Parts included in delivery

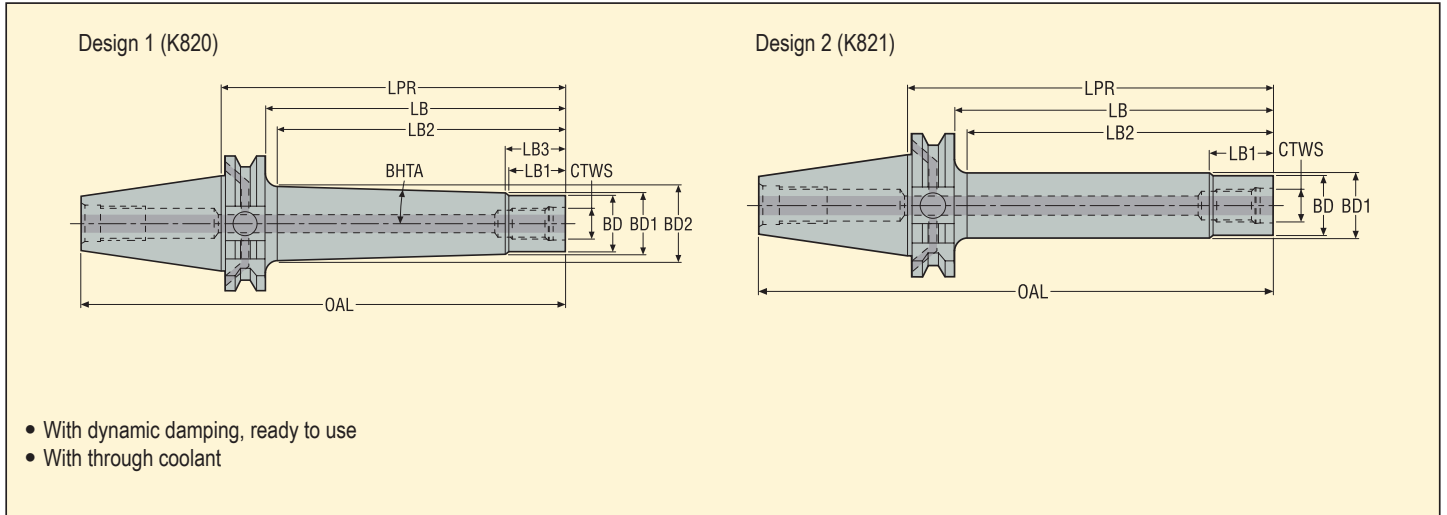
For Taper/ DMM	Bolt	Plug	Screw	Tenon
DIN40/ 16	5801608	950A0406	950D0312	16C2080810A
DIN40/ 22	5802210	950A0406	950D0416	16C2101111
DIN50/ 22	5802210	950A0606	950D0416	16C2101111
DIN50/ 27	5802712	950A0606	950D0516	16C2121214A
DIN50/ 32	5803216	950A0606	950D0516	16C2141421A
DIN50/ 40	5804020	950A0606	950D0616	16C2161621A

Please check availability in current price and stock-list and on [www.secotools.com](http://www.secotools.com)

# DIN 69871 TO COMBIMASTER™ ADAPTERS

SECO EPB® K820-K821 – Steadyline® vibration damping Combimaster™ arbors

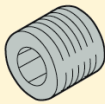
DIN 69871-ADB



- With dynamic damping, ready to use
- With through coolant

Machine side	Workpiece side	Designation	Dimensions in mm								BHTA°	Design	Max. RPM	RFID hole	Balancing	KG
			LPR	LB	LB2	LB1	BD	BD2	BD1	OAL						
DIN40 ADB																
	M12	E3469K82012185	185,0	165,9	–	20,0	23,0	42,7	30,0	253,4	2,8	1	10000	1	PB	2,20
	M16	E3469K82016185	185,0	165,9	–	20,0	30,0	50,2	37,0	253,4	2,8	1	10000	1	PB	2,80
	M16	E3469K82016235	235,0	215,9	–	20,0	30,0	50,0	37,0	303,4	2,8	1	8000	1	PB	3,70
DIN50 ADB																
	M16	E3471K82016235	235,0	215,9	211,1	20,0	30,0	55,0	37,0	336,7	2,8	1	8000	1	PB	5,50
	M16	E3471K82016285	285,0	265,9	261,1	20,0	30,0	59,8	37,0	386,7	2,8	1	6000	1	PB	6,60
	M16	E3471K82116185	185,0	165,9	160,9	22,0	30,0	30,5	30,5	286,7	–	2	10000	1	PB	3,50

## Spare Parts included in delivery

For Taper	Plug
	
DIN40	950A0406
DIN50	950A0606

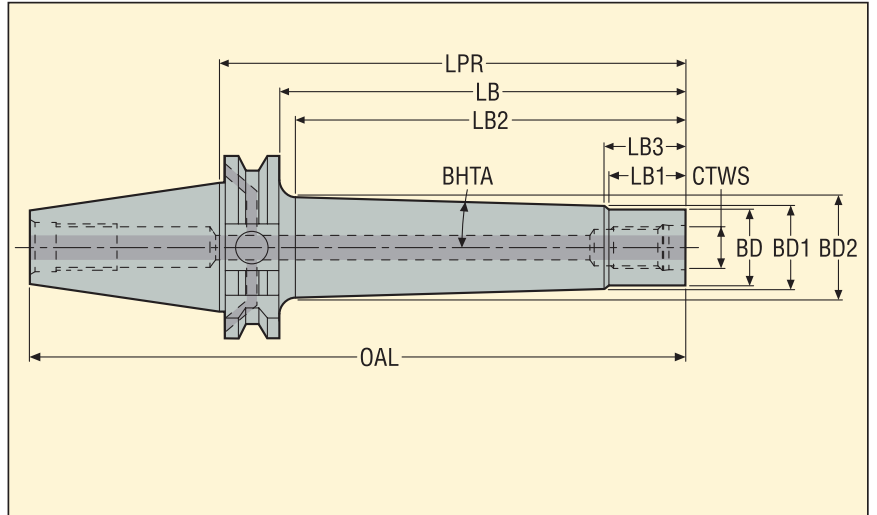
# DIN 69871 TAPER-FACE TOOL HOLDERS

SECO EPB® K820 – Steadyline®, vibration damping Combimaster™ holders

DIN Taper-Face



- With dynamic damping, ready to use
- With through coolant



Machine side	Workpiece side	Designation	Dimensions in mm									BHTA°	Max. RPM	RFID hole	Balancing	KG	
			LPR	LB	LB2	LB3	LB1	BD2	BD1	BD	OAL						
DIN TF40 ADB	M20	E3269K82020185	185,0	165,9	144,3	29,0	24,7	56,1	45,0	36,5	253,4	2,7	10000	1	PB	3,60	
DIN TF50 ADB	M20	E3271K82020285	285,0	265,9	264,0	29,0	24,7	67,6	45,0	36,5	386,8	2,7	6000	1	PB	8,00	
	M20	E3271K82020235	235,0	215,9	211,1	29,0	24,7	62,5	45,0	36,5	336,8	2,7	8000	1	PB	6,50	

## Spare Parts included in delivery

For Taper	Plug
DIN TF40	950A0406
DIN TF50	950A0606

Please check availability in current price and stock-list and on [www.secotools.com](http://www.secotools.com)  
 Note: Other Steadyline® Combimaster™ sizes exist in non Taper-Face DIN types, see page 59.

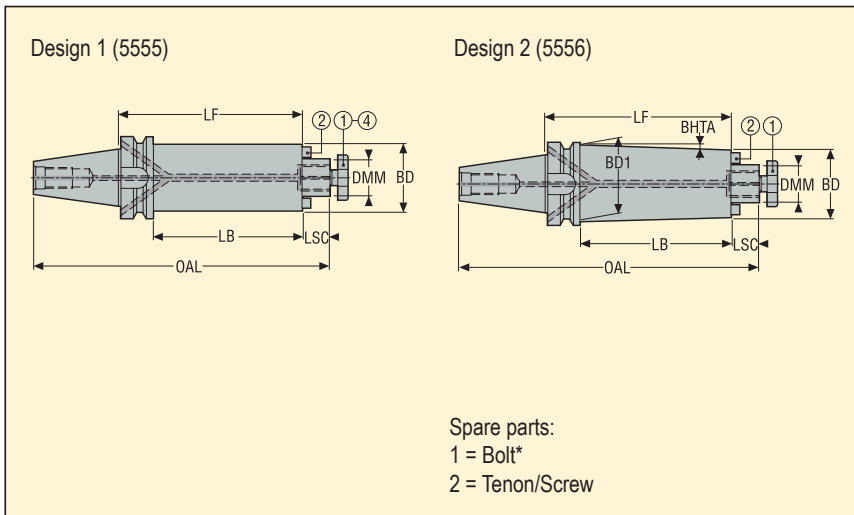
# BT JIS TOOL HOLDERS

SECO EPB® 5555/5556 – Steadyline®, vibration damping shell mill holders

BT JIS B 6339-ADB



- With dynamic damping, ready to use
- Direct run-out 5 µm maximum
- With coolant supply channels through the spigot



Machine side	Workpiece side	Designation	Dimensions in mm						Design	BHTA°	RFID hole	Balancing	KG
			LF	BD	BD1	OAL	LB	LSC					
BT40 ADB	16	E3414555516160	160,0	38,0	38,0	242,4	133,0	17,0	1	–	1	PB	2,23
	22	E3414555522210	210,0	48,0	48,0	294,4	183,0	19,0	1	–	1	PB	3,78
	22	E3414555622260	260,0	48,0	60,0	344,4	233,0	19,0	2	1,3	1	PB	5,40
	27	E3414555527260	260,0	60,0	60,0	346,4	233,0	21,0	1	–	1	PB	6,86
BT50 ADB	22	E3416555522210	210,0	48,0	48,0	330,8	172,0	19,0	1	–	1	PB	6,08
	22	E3416555622260	260,0	48,0	64,0	380,8	222,0	19,0	2	1,9	1	PB	7,90
	27	E3416555527260	260,0	60,0	60,0	382,8	222,0	21,0	1	–	1	PB	9,06
	27	E3416555627320	320,0	60,0	80,0	442,8	282,0	21,0	2	1,9	1	PB	12,64
	32	E3416555532330	330,0	78,0	78,0	455,8	292,0	24,0	1	–	1	PB	15,34
	40	E3416555540350	350,0	89,0	89,0	475,8	312,0	27,0	1	–	1	PB	20,70

DMM 40, includes 4 threaded holes on the bearing face according to DIN 6357

## Accessories to be ordered separately

For Taper/ DMM	Bolt, through coolant	Spanner
BT40/ 16	5801608L	5811608
BT40/ 22	5802210L	5812210
BT40/ 27	5802712L	5812712
BT50/ 22	5802210L	5812210
BT50/ 27	5802712L	5812712
BT50/ 32	5803216L	5813216
BT50/ 40	5804020L	5814020

## Spare Parts included in delivery

For Taper/ DMM	Bolt	Plug	Screw	Tenon
BT40/ 16	5801608	950A0406	950D0312	16C2080810A
BT40/ 22	5802210	950A0406	950D0416	16C2101111
BT40/ 27	5802712	950A0406	950D0516	16C2121214A
BT50/ 22	5802210	950A0606	950D0416	16C2101111
BT50/ 27	5802712	950A0606	950D0516	16C2121214A
BT50/ 32	5803216	950A0606	950D0516	16C2141421A
BT50/ 40	5804020	950A0606	950D0616	16C2161621A

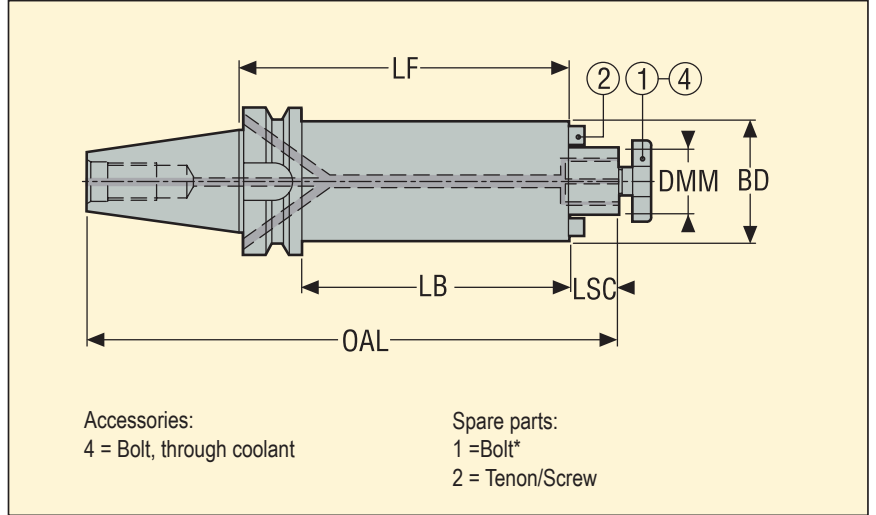
# BT JIS TAPER-FACE TOOL HOLDERS

SECO EPB® 5555 – Steadyline®, vibration damping shell mill holders

BT Taper-Face



- With dynamic damping, ready to use
- Direct run-out 5 µm maximum
- With coolant supply channels through the spigot



Machine side	Workpiece side	Designation	Dimensions in mm					Max. RPM	RFID hole	Balancing	KG
			LF	BD	OAL	LB	LSC				
BT TF40 ADB	22	E3214555522210	210,0	48,0	294,4	183,0	19,0	8000	1	PB	3,80
	27	E3214555527260	260,0	60,0	346,4	233,0	21,0	6000	1	PB	6,90
BT TF50 ADB	32	E3216555532330	330,0	78,0	455,8	292,0	24,0	4000	1	PB	15,30
	40	E3216555540350	350,0	89,0	478,8	312,0	27,0	3100	1	PB	20,70

DMM 40, includes 4 threaded holes on the bearing face according to DIN 6357

## Accessories to be ordered separately

For	Bolt, through coolant	Spanner
E3214555522210	5802210L	5812210
E3214555527260	5802712L	5812712
E3216555532330	5803216L	5813216
E3216555540350	5804020L	5814020

## Spare Parts included in delivery

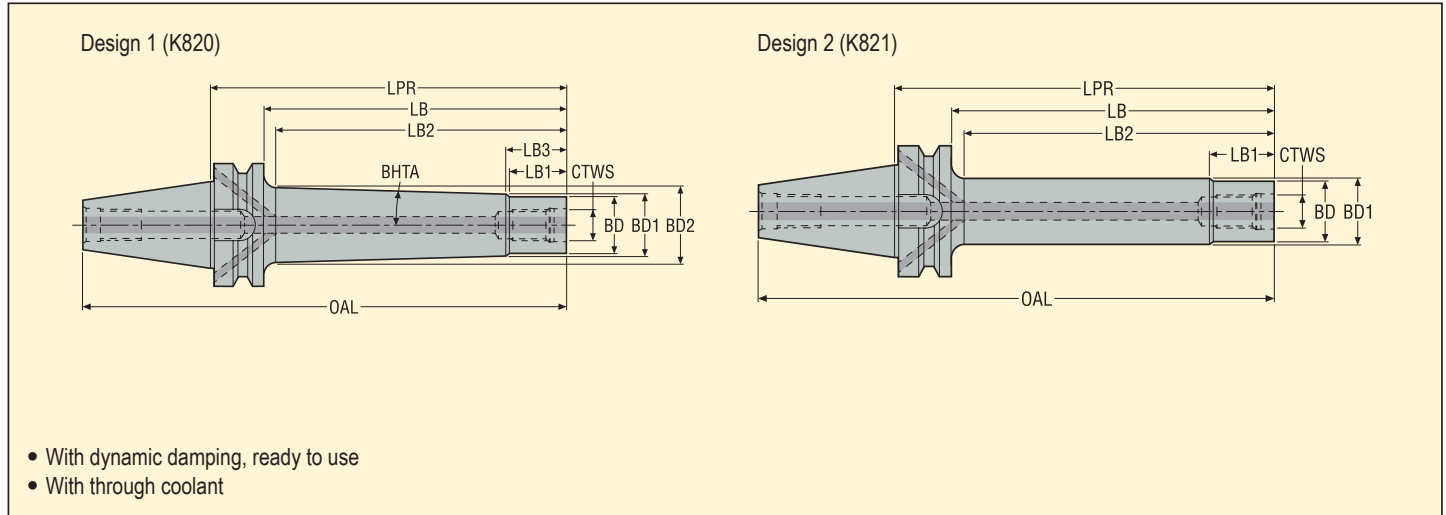
For	Bolt	Plug	Screw	Tenon
E3214555522210	5802210	950A0406	950D0416	16C2101111
E3214555527260	5802712	950A0406	950D0516	16C2121214A
E3216555532330	5803216	950A0606	950D0516	16C2141421A
E3216555540350	5804020	950A0606	950D0616	16C2161621A

Please check availability in current price and stock-list and on [www.secotools.com](http://www.secotools.com)

# BT JIS TO COMBIMASTER™ ADAPTERS

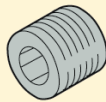
SECO EPB® K820-K821 – Steadyliner® vibration damping Combimaster™ arbors

BT JIS B 6339-ADB



Machine side	Workpiece side	Designation	Dimensions in mm									BHTA°	Design	Max. RPM	RFID hole	Balancing	KG
			LPR	LB	LB2	LB4	LB1	BD	BD2	BD1	OAL						
BT40 ADB	M12	E3414K82012185	185,0	158,0	153,2	24,0	20,0	23,0	41,9	30,0	250,4	2,8	1	10000	1	PB	2,20
	M16	E3414K82016185	185,0	158,0	153,2	24,0	20,0	30,0	49,4	37,0	250,4	2,8	1	10000	1	PB	2,80
	M16	E3414K82016235	235,0	208,0	203,2	24,0	20,0	30,0	54,2	37,0	300,4	2,8	1	8000	1	PB	3,70
	M16	E3414K82116160	160,0	133,0	128,0	-	22,0	30,0	30,5	30,5	225,4	-	2	10000	1	PB	1,80
BT50 ADB	M16	E3416K82016235	235,0	197,0	192,2	24,0	20,0	30,0	53,2	37,0	336,8	2,8	1	8000	1	PB	6,10
	M16	E3416K82016285	285,0	247,0	242,2	24,0	20,0	30,0	57,0	37,0	386,8	2,8	1	6000	1	PB	7,20
	M16	E3416K82116185	185,0	147,0	142,0	-	22,0	30,0	30,5	30,5	286,8	-	2	10000	1	PB	4,40

## Spare Parts included in delivery

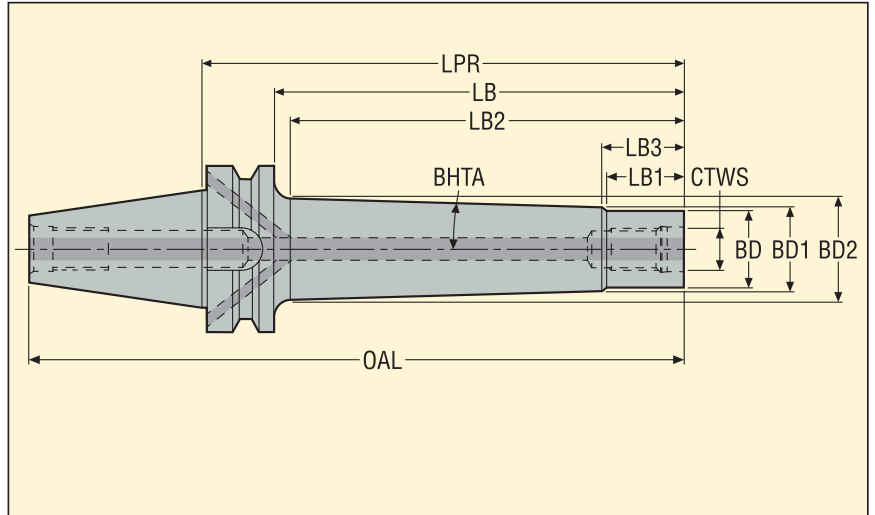
For Taper	Plug
	
BT40	950A0406
BT50	950A0606

Please check availability in current price and stock-list and on [www.secotools.com](http://www.secotools.com)

# BT JIS TAPER-FACE TO COMBIMASTER™ ADAPTERS

SECO EPB® K820 – Steadylite®, vibration damping Combimaster™ holders

BT Taper-Face



- With dynamic damping, ready to use
- With through coolant

Machine side Taper	Workpiece side Combimaster™ CTWS	Designation	Dimensions in mm									BHTA°	RPMX	RFID hole	Balancing	KG
			LPR	LB	LB2	LB3	LB1	BD2	BD1	BD	OAL					
BT TF40 ADB	M20	E3214K82020185	185,0	158,0	156,1	29,0	24,7	57,2	45,0	36,5	250,4	2,7	10000	1	PB	3,70
BT TF50 ADB	M20	E3216K82020235	235,0	197,0	192,2	29,0	24,7	60,7	45,0	36,5	336,8	2,7	8000	1	PB	7,10
	M20	E3216K82020285	285,0	247,0	242,2	29,0	24,7	65,5	45,0	36,5	386,8	2,7	6000	1	PB	8,50

## Spare Parts included in delivery

For Taper	Plug
BT TF40	950A0406
BT TF50	950A0606

Please check availability in current price and stock-list and on [www.secotools.com](http://www.secotools.com)  
 Note: Other Steadylite® Combimaster™ sizes exist in non Taper-Face BT types, see page 63.



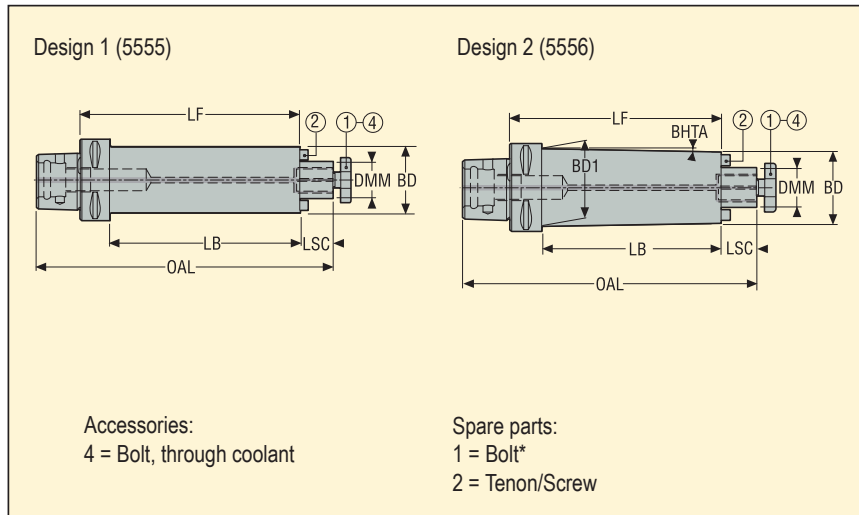
# SECO-CAPTO™ TOOL HOLDERS

SECO EPB® 5555/5556 – Steadyline®, vibration damping shell mill holders

Seco-Capto™



- With dynamic damping, ready to use



Machine side Seco-Capto™ shank	Workpiece side DMM mm	Designation	Dimensions in mm						Design	BHTA°	RFID hole	Balancing	KG
			LF	BD	BD1	OAL	LB	LSC					
C6	16	C6-391.5555-16160	160,0	38,0	38,0	215,0	135,0	17,0	1	–	1	PB	2,1
	22	C6-391.5555-22210	210,0	48,0	48,0	267,0	185,0	19,0	1	–	1	PB	3,6
	22	C6-391.5556-22260	260,0	48,0	60,0	317,0	235,0	19,0	2	1,3	1	PB	4,0
	27	C6-391.5555-27260	260,0	60,0	60,0	319,0	235,0	21,0	1	–	1	PB	6,8
C8	22	C8-391.5555-22210	210,0	48,0	48,0	277,0	177,0	19,0	1	–	1	PB	4,5
	22	C8-391.5556-22260	260,0	48,0	64,0	327,0	227,0	19,0	2	1,8	1	PB	6,4
	27	C8-391.5555-27260	260,0	60,0	60,0	329,0	227,0	21,0	1	–	1	PB	7,6
	27	C8-391.5556-27320	320,0	60,0	75,0	389,0	287,0	21,0	2	1,3	1	PB	10,6
	32	C8-391.5555-32330	330,0	78,0	78,0	402,0	297,0	24,0	1	–	1	PB	20,0
	40	C8-391.5555-40350	350,0	89,0	89,0	422,0	317,0	27,0	1	–	1	PB	19,0

DMM 40, includes 4 threaded holes on the bearing face according to DIN 6357

## Accessories to be ordered separately

For DMM	Bolt, through coolant	Spanner
16	5801608L	5811608
22	5802210L	5812210
27	5802712L	5812712
32	5803216L	5813216
40	5804020L	5814020

## Spare Parts included in delivery

For DMM	Bolt	Screw	Tenon
16	5801608	951D0312	16C2080810A
22	5802210	951D0416	16C2101111
27	5802712	951D0516	16C2121214A
32	5803216	951D0516	16C2141421A
40	5804020	951D0616	16C2161621A

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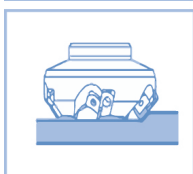
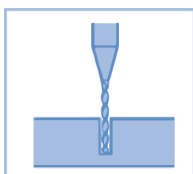
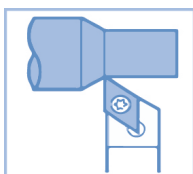




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