

# T-Max Q-Cut®

## System with 1 cutting edge

For deep parting, internal grooving and small diameter face grooving



### Toolholder assortment

There are a wide range of different toolholders for T-Max Q-Cut® inserts

### T-Max Q-Cut® options

- T-Max Q-Cut® 151.2 for deep parting
- T-Max Q-Cut® 151.3 for internal machining and small diameter face grooving



### T-Max Q-Cut® SL - Flexible tool solution

By using CoroTurn® SL adaptors and T-Max Q-Cut® cutting blades for insert types 151.2 and 151.3 a large number of tooling solutions, both external and internal, can be made from a limited number of items.



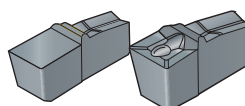
### Insert geometries

A large variety of geometries are available, dedicated to different applications and feed areas.

### Insert grades

To cover all types of work piece materials the T-Max Q-Cut® inserts are available in a variety of specially developed grades:

- Cemented carbide
- Polycrystalline diamond
- Cubic boron nitride see page B8



### Design your own solution

Blanks for grinding your profile



More options are available thanks to tailored design. For more information on our Tailor Made program see page I2

ISO application areas:





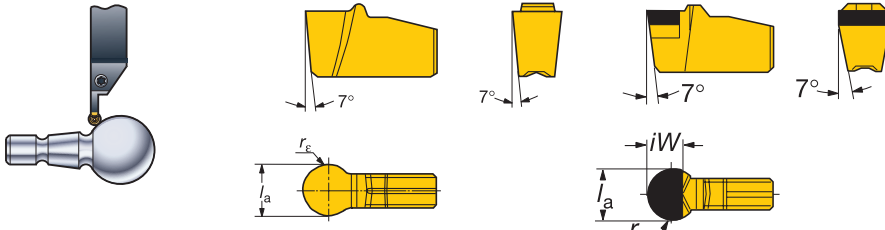






# T-Max Q-Cut®

## Profiling



For ISO application areas, see bottom of the page.

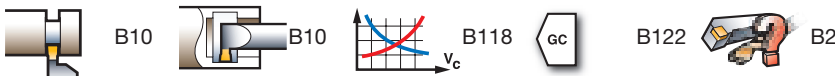
		Selection criteria, mm						Application areas																								
		$l_a$	Inch	$r_\epsilon$	$iW$	Seat size 1)	Ordering code	P			M			K		N		S		H												
								GC	GC	GC	CT	GC	GC	CT	GC	GC	CD	CD	GC	GC	CB											
								235	4025	4125	525	1005	235	4125	525	H13A	4025	4125	H13A	1810	CD10	CD	H13A	1005	235	H13A	CB20					
Medium feed		3.00		1.5		30	N151.2-300-30-5P	☆	★	☆	☆	☆	☆	☆	☆	★	☆															
		3.17	.125	1.59		30	N151.2-A125-30-5P	☆	★	☆	☆	☆	☆	☆	☆	★	☆															
		4.00		2		40	N151.2-400-40-5P	☆	★	☆	☆	☆	☆	☆	☆	★	☆															
		5.00		2.5		40	N151.2-500-40-5P	☆	★	☆	☆	☆	☆	☆	☆	★	☆															
		4.76	.187	2.37		40	N151.2-A187-40-5P	☆	★	☆	☆	☆	☆	☆	☆	★	☆															
		6.00		3		50	N151.2-600-50-5P	☆	★	☆	☆	☆	☆	☆	☆	★	☆															
		6.35	.250	3.17		50	N151.2-A250-50-5P	☆	★	☆	☆	☆	☆	☆	☆	★	☆															
		8.00		4		60	N151.2-800-60-5P	☆	★	☆	☆	☆	☆	☆	☆	★	☆															
Optimized		3.00		1.5		30	N151.2-300-30-4P	★			☆	☆	★	☆	☆		★	☆			★	★					☆					
		3.17	.125	1.59		30	N151.2-A125-30-4P	★			☆	☆	★	☆	☆		★	☆			★	★					☆					
		3.96	.156	1.98		40	N151.2-A156-40-4P	★			☆	☆	★	☆	☆		★	☆			★	★					☆					
		4.00		2		40	N151.2-400-40-4P	★			☆	☆	★	☆	☆		★	☆			★	★					☆					
		4.50		2.25		40	N151.2-450-40-4P	★			☆	☆	★	☆	☆		★	☆			★	★					☆					
		4.75	.187	23.75		40	N151.2-A187-40-4P	★			☆	☆	★	☆	☆		★	☆			★	★					☆					
		5.00		2.5		40	N151.2-500-40-4P	★			☆	☆	★	☆	☆		★	☆			★	★					☆					
		5.56	.219	2.78		50	N151.2-A219-50-4P	★			☆	☆	★	☆	☆		★	☆			★	★					☆					
		6.00		3		50	N151.2-600-50-4P	★			☆	☆	★	☆	☆		★	☆			★	★					☆					
		6.35	.250	3.17		50	N151.2-A250-50-4P	★			☆	☆	★	☆	☆		★	☆			★	★			☆		★					
		7.14	.281	3.57		60	N151.2-A281-60-4P	★			☆	☆	★	☆	☆		★	☆			★	★					☆					
		7.93	.312	3.96		60	N151.2-A312-60-4P	★			☆	☆	★	☆	☆		★	☆			★	★					☆					
		8.00		4		60	N151.2-800-60-4P	★			☆	☆	★	☆	☆		★	☆			★	★					☆					
		9.52	.375	4.76		80	N151.2-A375-80-4P	★			☆	☆	★	☆	☆		★	☆			★	★			☆		★					
10.00		5		80	N151.2-1000-80-4P	★			☆	☆	★	☆	☆		★	☆			★	★					☆							
		<b>For profiling of hardened materials</b>																														
Optimized		3.00		1.5	2.5	30	N151.2-300-30E-P																						★			
		3.17	.125	1.59	2.59	30	N151.2-A125-30E-P																						★			
		4.00		2	3	40	N151.2-400-40E-P																							★		
		5.00		2.5	3.5	40	N151.2-500-40E-P																								★	
		4.75	.187	2.37	3.38	40	N151.2-A187-40E-P																									★
		6.00		3	4	50	N151.2-600-50E-P																									★
6.35	.250	3.17	4.19	50	N151.2-A250-50E-P																									★		
7.92	.312	3.96	4.95	60	N151.2-A312-60E-P																									★		
		<b>For profiling in non-ferrous materials</b>																														
Optimized		3.18	.125	1.59	2.59	30	N151.2-A125-30 F-P																									
		4.00		2	3	40	N151.2-400-40 F-P																									
		6.00		3	4	50	N151.2-600-50 F-P																									
		6.35	.250	3.18	4.19	50	N151.2-A250-50 F-P																									
		7.92	.312	3.96	4.95	60	N151.2-A312-60 F-P																									
8.00		4	5	60	N151.2-800-60 F-P																											

1) To correspond with seat size on holder.

Ordering example: 10 pieces N151.2-600-60-5T

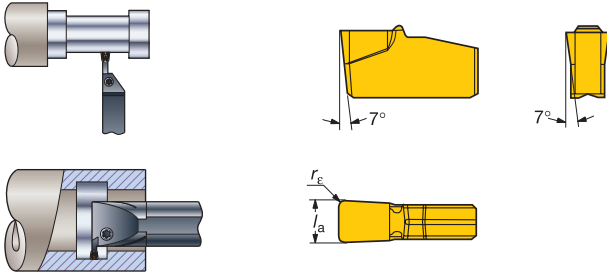
N = Neutral  
★ = First choice

For tolerances, see page B111.



# T-Max Q-Cut®

## Turning and recessing



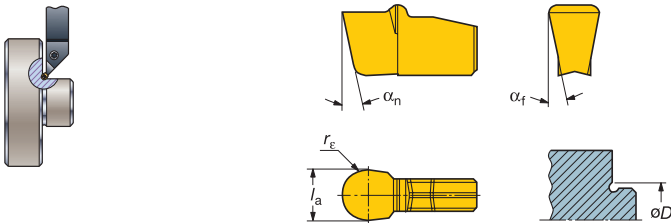
For ISO application areas, see bottom of the page.

		Selection criteria, mm					P					M			K			S	
		$l_a$	$r_\epsilon$	Seat size <sup>1)</sup>	Ordering code		GC	GC	GC	GC	CT	GC	GC	CT	GC	GC	GC	GC	
Medium feed		3.00	0.4	30	N151.2-3004-30-5T	235	3020	4025	4125	525	235	4125	525	3020	4025	4125	235		
		4.00	0.4	40	N151.2-4004-40-5T	☆	☆	★	☆	☆	☆	★	☆	★	☆	☆	☆		
		4.00	0.8		N151.2-4008-40-5T	☆	☆	★	☆	☆	☆	★	☆	★	☆	☆	☆		
		5.00	0.4	50	N151.2-5004-50-5T	☆	☆	★	☆	☆	☆	★	☆	★	☆	☆	☆		
		6.00	0.8	60	N151.2-6008-60-5T	☆		★	☆	☆	☆	★	☆		★	☆			
High feed		3.00	0.4	30	N151.2-3004-30-4T	☆	★			★				★					
		4.00	0.4	40	N151.2-4004-40-4T	☆	★			★				★					
		4.00	0.8		N151.2-4008-40-4T	☆	★		☆			☆			★				
		5.00	0.4	50	N151.2-5004-50-4T	☆	★			★				★					
		6.00	0.8		N151.2-6008-60-4T	☆	★			☆			★						
							P45	P15	P20	P30	P10	M35	M25	M10	K15	K25	K30	S30	

<sup>1)</sup> To correspond with seat size on holder.

Ordering example: 10 pieces N151.2-3004-30-5T  
N = Neutral

## Undercutting



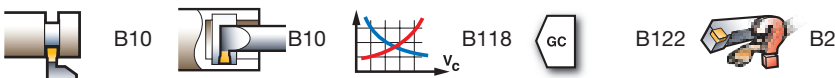
For ISO application areas, see bottom of the page.

		Selection criteria, mm							P		M		K	N	S	
		$l_a$	$r_\epsilon$	Min. ØD	$\alpha_n^\circ$	$\alpha_f^\circ$	Seat size <sup>1)</sup>	Ordering code		GC	CT	GC	CT	GC	GC	
Medium feed		2.00	1	30	5°	5°	20	N151.2-200-20-4U	235	525	235	H13A	H13A	H13A	GC	
		3.00	1.5	28	7°	7°	25	N151.2-300-25-4U	★	☆	★	☆	★	★	☆	★
		4.00	2	23	11°	11°	30	N151.2-400-30-4U	★	☆	★	☆	★	★	☆	★
		5.00	2.5	27	11°	11°	40	N151.2-500-40-4U	★	☆	★	☆	★	★	☆	★
		6.00	3	27	11°	11°	50	N151.2-600-50-4U	★	☆	★	☆	★	★	☆	★
		8.00	4	30	11°	11°	60	N151.2-800-60-4U	★		★		★		★	
									P45	P10	M35	M10	K20	N20	S30	S15

<sup>1)</sup> To correspond with seat size on holder.

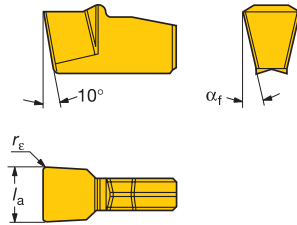
Ordering example: 10 pieces N151.2-200-20-4U 235  
N = Neutral  
★ = First choice

For tolerances, see page B111.

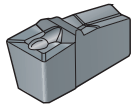
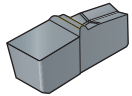


## T-Max Q-Cut®

Blanks for grooving inserts



For grinding instructions see Metalcutting Technical guide



	Selection criteria, mm					Seat size <sup>1)</sup>	Ordering code	H13A
	$l_a$	$r_e$	$\alpha_f$	Width range min	Width range max			
	2.4	0.1	11°	1.9	2.3	20	N151.2-240-20-3B	☆
	3.4	0.1	11°	2.3	3.3	25	N151.2-340-25-3B	☆
	4.4	0.2	12°	3	4.3	30	N151.2-440-30-3B	☆
	5.4	0.2	5°	4	5.3	40	N151.2-540-40-3B	☆
	6.5	0.2	5°	5	6.4	50	N151.2-650-50-3B	☆
	8.5	0.3	6°	6	8.4	60	N151.2-850-60-3B	☆
	2.6	0.1	11°	1.9	2.3	20	N151.2-260-20-4B	☆
	3.65	0.1	11°	2.3	3.3	25	N151.2-365-25-4B	☆
	4.65	0.2	12°	3	4.3	30	N151.2-465-30-4B	☆
	5.6	0.2	5°	4	5.3	40	N151.2-560-40-4B	☆
	6.75	0.2	5°	5	6.4	50	N151.2-675-50-4B	☆
	8.8	0.3	6°	6	8.4	60	N151.2-880-60-4B	☆
	11.45	0.3	10°	8	11.2	80	N151.2-1145-80-4B	☆

<sup>1)</sup> To correspond with seat size on holder.

Ordering example: 10 pieces N151.2-240-20-3B H13A  
N = Neutral

For tolerances, see page B111.





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