Turbo-cutters of HSS with straight shank

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Types of serration and applications

Serration 1

light metals (long chips), light metal alloys, lead, tin, plastics

Serration 2

light metals (short chips), brass, copper alloys

Serration 3

steel and cast steel, alloyed and unalloyed, cast iron and malleable cast iron

Serration 5

steel and cast steel, alloyed and unalloyed

Cyl. shape 'AS' with face serration

Type	AS 0304	AS 0607	AS 0616	AS 0820	AS 1013	AS 1225	AS 1625
Head size	3 x 4 mm	6 x 7 mm	6 x 16 mm	8 x 20 mm	10 x 13 mm	12 x 25 mm	16 x 25 mm
Serration/ 1	–	–	742.031	–	–	742.061	742.071
Item No. 2	–	–	742.032	–	742.052	742.062	742.072
3	–	–	742.033	742.043	742.053	742.063	742.073
5	742.015	742.025	742.035	–	742.055	–	–

rounded cyl. shape 'C'

Type	C 0304	C 0620	C 0850	C 1020	C 1225
Head size	3 x 4 mm	6 x 20 mm	8 x 50 mm	10 x 20 mm	12 x 25 mm
Serration/ 1	–	742.121	742.131	–	742.151
Item No. 2	–	742.122	742.132	–	742.152
3	–	742.123	–	742.143	742.153
5	742.115	742.125	–	–	742.155

Pointed arch shape G

Type	G 0618	G 1220	G 1225	G 1230	G 1630
Head size	6 x 18 mm	12 x 20 mm	12 x 25 mm	12 x 30 mm	16 x 30 mm
Serration/ 1	742.211	742.221	–	742.241	742.251
Item No. 2	742.212	742.222	–	742.242	742.252
3	742.213	742.223	742.233	742.243	742.253
5	742.215	–	–	742.245	742.255

Drop shape E

Type	E 0607	E 1220	E 1625
Head size	6 x 7 mm	12 x 20 mm	16 x 25 mm
Serration/ 1	–	742.321	742.331
Item No. 2	–	742.322	742.332
3	–	742.323	742.333
5	742.315	–	–

Spherical shape D

Type	D 0302	D 0403	D 0504	D 0605	D 0807	D 1009	D 1210	D 1614
Head dia.	3 mm	4 mm	5 mm	6 mm	8 mm	10 mm	12 mm	16 mm
Serration/ 1	–	–	–	–	742.451	–	742.471	742.481
Item No. 2	–	–	–	742.442	742.452	742.462	742.472	742.482
3	742.413	742.423	742.433	742.443	742.453	742.463	742.473	742.483
5	–	–	–	–	742.455	742.465	–	–

Club shape K

Type	K 0620	K 1230
Head size	6 x 18 mm	12 x 20 mm
Serration/2	742.612	742.622
Item No. 3	742.613	742.623

Flame shape H

Type	H 0305	H 0608	H 0820	H 1230	H 1635	H 1750
Head size	3 x 5 mm	6 x 8 mm	8 x 20 mm	12 x 30 mm	16 x 35 mm	17 x 50 mm
Serration/ 1	–	–	–	–	–	742.551
Item No. 3	–	–	742.523	742.533	742.543	–
5	742.505	742.515	–	–	–	–

Round taper shape L

Type	L 1020	L 1230	L 1630
Head size	10 x 20 mm	12 x 30 mm	16 x 30 mm
Serration/ 1	–	–	742.731
Item No. 2	742.712	–	742.732
3	742.713	742.723	742.733
5	–	–	742.735

Acute taper shape M

Type	M 0304	M 0607	M 0618	M 0820	M 1020	M 1225	M 1230
Head size	3 x 4 mm	6 x 7 mm	6 x 18 mm	8 x 20 mm	10 x 20 mm	12 x 25 mm	12 x 30 mm
Serration/ 1	–	–	742.831	–	–	742.861	742.871
Item No. 2	–	–	742.832	–	742.852	742.862	742.872
3	–	–	742.833	742.843	742.853	742.863	742.873
5	742.815	742.825	742.835	–	742.855	–	742.875

Angle shape N

Type	N 0303	N 0606	N 1213	N 1230
Head size	3 x 3 mm	6 x 6 mm	12 x 13 mm	12 x 30 mm
Serration/ 1	–	–	742.931	–
Item No. 2	–	–	742.932	–
3	–	–	742.933	742.943
5	742.915	742.925	–	–

Turbo-cutters (with internal thread) of HSS

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types of toothing and fields of application see above Fitting cutter bolts see Item 282 A, page 84

Cyl. form AS with face serration

Pointed arch shape G

Round taper shape L

Type	AS 2215	AS 3030		G 2045	G 3555	L 2055	
Head size	22 x 15 mm	30 x 30 mm		20 x 45 mm	35 x 55 mm	20 x 55 mm	
Intern.thread		M 8	M 10		M 10	M 12	M 10
Serration/ 1	–	–		–	744.221	744.611	
Item No. 2	–	744.122		744.212	–	–	
3	744.113	–		–	–	–	

Spherical shape D

Drop shape E

Flame shape H

Acute taper sh. M

Type	D 2018	D 2522	D 3027	D 3532	E 2535	H 2055	M 2540
Head size	20 mm dia.	25 mm dia.	30 mm dia.	35 mm dia.	25 x 35 mm	20 x 55 mm	25 x 40 mm
Intern.thread	M 8	M 10	M 12	M 12	M 12	M 10	M 10
Serration/ 1	744.411	744.421	–	–	–	744.511	–
Item No. 2	–	744.422	–	–	–	744.512	–
3	744.413	–	744.433	744.443	744.313	–	744.713