



MaxiLock D - the ultimate in clamping



CERATIZIT - secrets of success

Secrets of success

- CERATIZIT is your partner for exceptional hard material solutions. Hard materials and tools from CERATIZIT - our solutions to complex problems are an integral part of our customers' success. Our products guarantee: economy - long life - speed! And it is precisely this combination which gives our business partners a direct competitive advantage.
- Premier performance is only possible through a total appreciation of the requirements of our business partners. A performance achieved through flexible thinking and continuous dialogue with our customers. A pioneering spirit and a deep understanding of powder metallurgy characterize the history of CERATIZIT. One of the attributes of our company philosophy is the search for perfection: target oriented - sustainably - passionately!
- Intensive research and development activities, taking into account the precise requirements and working processes of the customer, are today's investment for the solutions of tomorrow - and beyond.

Corporate values

- 1 The views and focus of our business partners matter
- 2 Innovative and flexible thinking matters
- 3 Communication matters
- 4 Employee development matters
- 5 Professionalism matters
- 6 Our environment matters



Tailored cutting tool solutions

- Cutting materials, coatings, inserts, tooling systems and machining solutions - all this is included in the cutting tool division at CERATIZIT.
- Worldwide well-known companies process advanced materials applying cutting tool products from CERATIZIT: from the automotive industry to the aerospace industry, mechanical engineering and tool construction to the oil industry.
- The basis of these long-term business relations is the faith of the customers in the extensive know-how of the carbide specialists.

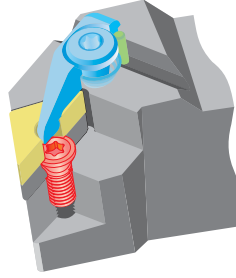


Clamping systems

MaxiLock D

First choice for cutting with negative inserts with hole.

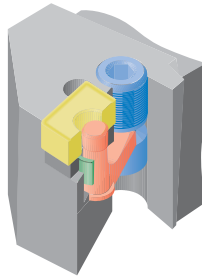
Safe and **precise positioning** of the insert through **double clamping effect**.



- Clamping element
- Insert
- Shim
- Pin
- Screw

MaxiLock N

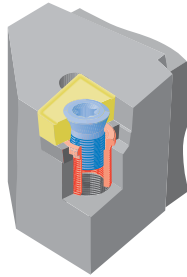
This clamping system is suitable for all negative form inserts with holes. The actuation screw can easily be reached from the upper and the lower side of the holder. In the unlocked position constituent parts remain intact.



- Clamping screw
- Insert
- Shim
- Wedge
- Lever

MaxiLock S

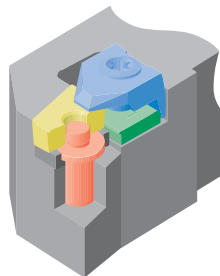
The form lock screw guarantees a safe connection of the insert and the tool holder. Chip evacuation is not hindered by obstructive clamping elements. Due to the neutral insert position the effective rake angle is identical to that of the insert form and geometry.



- Clamping screw
- Insert
- Shim
- Threaded shim screw

MaxiLock P

The insert with a clearance angle of 7° and a cylindrical bore is fixed with a wedge and claw lock against a fix pin. Up to three cutting edges can be used (1 support face).

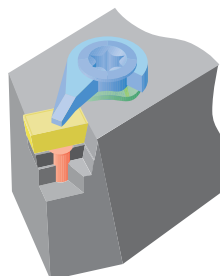


- Clamping element
- Insert
- Shim
- Wedge
- Pad pin

Simplex N / P

The tried and tested CERATIZIT Simplex clamping systems are characterised by their simplicity. The insert is clamped by means of a claw.

Not suitable for drawing cuts.



- Clamping screw and clamping claw
- Insert
- Shim
- Shim pin

Selection of the correct clamping system

Clamping system	Cutting depth / feed rate (mm)						Insert shape	Insert - form of top surface
	a _p	f	a _p	f	a _p	f		
	0,3 - 2,0	0,08 - 0,25	2,0 - 6,0	0,2 - 0,6	5,0 - 15,0	0,5 - 1,5		
								
MaxiLock D 	✓	✓	✓		      	  		
MaxiLock N 	✓	✓	✓		      	  		
MaxiLock S 	✓	✓			    	 		
MaxiLock P 		✓			  			
Simplex N 		✓			    KNUX	 KNUX 		
Simplex P 	✓	✓			 	 		

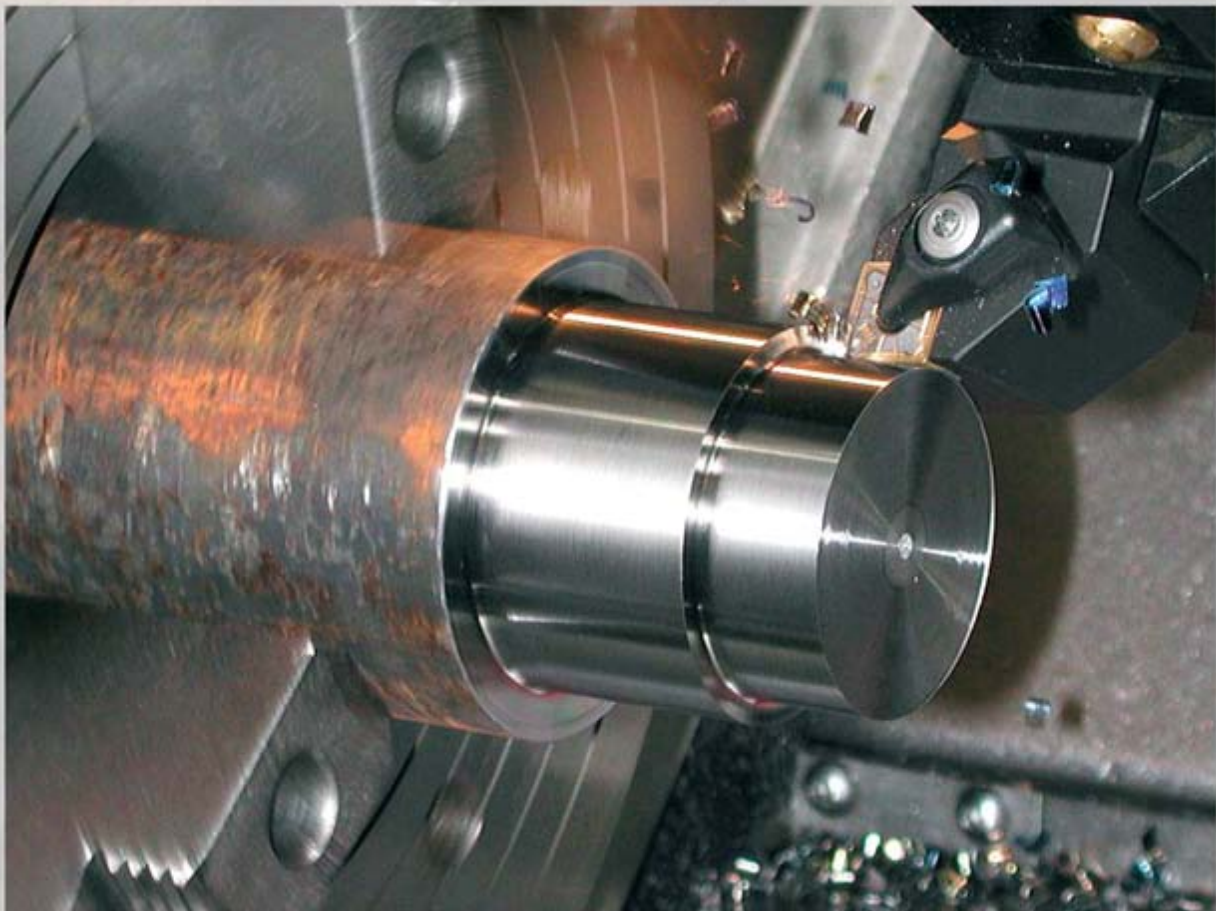
MaxiLock D - product features

- Robust top clamp for safe positioning of the insert in the insert seat
- Claw, spring and clamping screw (clamping element) = **ONE SPARE PART**
- **'All inclusive'** concept with integrated spare shim and screw
- Clamping key integrated in the shank to reduce packaging volume and storage
- Reinforced shim, clamped with screw
- **Torx Plus® system.** Torque is transmitted better giving safer clamping
- Optimised insert seat so that precise insert positioning and clamping is possible despite adhesion and wear

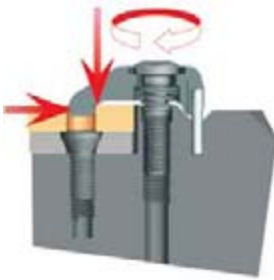


MaxiLock D - application advantages

- Secure clamping of the insert also under tension (e.g. copy turning)
- No tilting of the insert towards the front during heavy or interrupted cuts
- Maximum feed rates for Masterfinish inserts applied
- Suitable also for inserts made of various hard materials such as ceramic, CBN or PCD



MaxiLock D - the advantages are in the detail



When clamping the insert it is drawn to the contact face and location face at the same time. Precise positioning guaranteed.



Clamping element with intact constituent parts. Reduced inventory.



'All inclusive'.
A crash can always happen.
The spare shim integrated in the shank will save you the journey to tool storage.
The spare part is at hand and can easily be applied at the machine or presetting procedure.



An integrated coolant nozzle provides safe cooling and chip evacuation for internal machining.
This is only applicable to boring bars for W ... inserts.



Tilting of the insert towards the front, a well-known weak point of the lever lock system during heavy cutting operations is avoided.

MaxiLock D - the advantages are in the detail

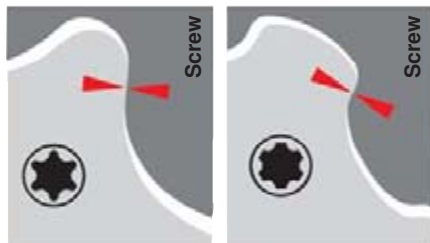


Even inserts with excessive wear and material adhesion can be positioned and clamped precisely thanks to the design of the insert seat.



As the constituent parts remain intact, even in unfavourable application conditions clamping is no problem.

From the Torx® screw to the Torx Plus® screw ...



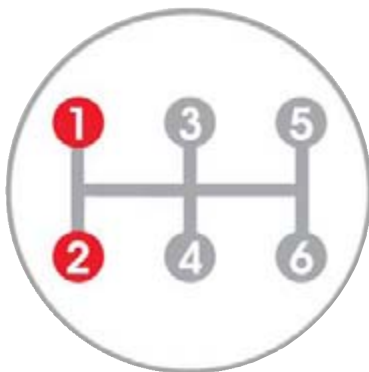
Torx® insert

Torx Plus®-insert

The Torx Plus® screwdrivers provide better transmission of torque moments than Torx® standard tools.

The considerably larger contact face of the Torx Plus® screwdriver in the Torx Plus® screw guarantees longer service life of both the tool and the screw.

CERATIZIT corporate values ...



1 The views and focus of our business partners matters

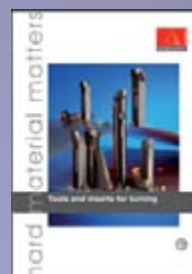
- Instead of talking product with customers, we work on real solutions for business partners.

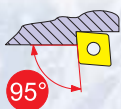
2 Innovative and flexible thinking matters

- We have the power to challenge state-of-the-art technologies and the courage to develop intelligent alternatives.
- Our speed of thought and decisive actions give us a leading edge.

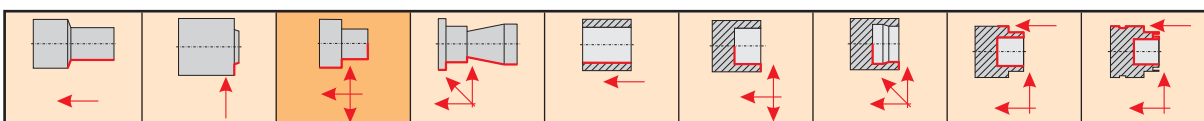


Main catalogue
'Tools and inserts for
turning' No. 183

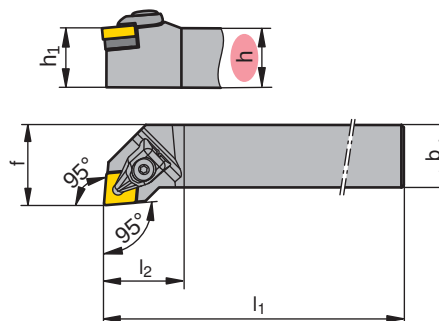




MaxiLock D - external DCLNR



DCLN...



Picture shows right-hand version

h [mm]	Type, description	LNR 	h ₁ [mm]	b [mm]	l ₁ [mm]	l ₂ [mm]	f [mm]	
20	DCLNR 2020 K12	R	20	20	125	32.0	25	CN.. 1204..
25	DCLNR 2525 M12	R	25	25	150	32.0	32	CN.. 1204..
25	DCLNR 2525 M12-X07	R	25	25	150	32.0	32	CNMX 1207..
25	DCLNR 2525 M16	R	25	25	150	38.0	32	CN.. 1606..
32	DCLNR 3225 P12	R	32	25	170	32.0	32	CN.. 1204..
32	DCLNR 3232 P16	R	32	32	170	37.0	40	CN.. 1606..
32	DCLNR 3232 P19	R	32	32	170	42.0	40	CN.. 1906..
40	DCLNR 4040 S19	R	40	40	250	42.0	50	CN.. 1906..

Ordering example: 1 piece DCLNR 2020 K12

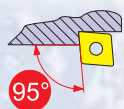
	h	1	2	3	4
CNMX 1207..	25	M4,5x12-15IP/10002887	U-CN12T3-D	S-15IP-T	SET-02X-D
CN.. 1204..	20 - 32	M4,5x12-15IP/10002887	U-CN12T3-D	S-15IP-T	SET-02-D
CN.. 1606..	25 - 32	M5x14-20IP/10003023	U-CN1604-D	S-20IP-T	SET-03-D
CN.. 1906..	32 - 40	M5x14-20IP/10003023	U-CN1905-D	S-20IP-T	SET-04-D



X07 = for ceramic inserts with dimple

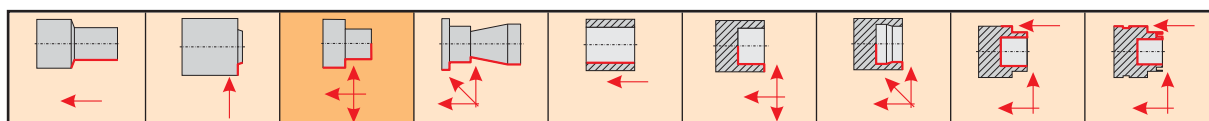
	CN.. 1204..	CNMX 1207..	CN.. 1606..	CN.. 1906..

Insert programme see catalogue
No. 183

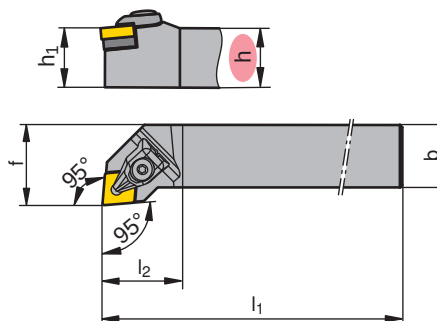


MaxiLock D - external

DCLNL



DCLN...



Picture shows right-hand version

h [mm]	Type, description	LNR 	h ₁ [mm]	b [mm]	l ₁ [mm]	l ₂ [mm]	f [mm]	
20	DCLNL 2020 K12	L	20	20	125	32.0	25	CN.. 1204..
25	DCLNL 2525 M12	L	25	25	150	32.0	32	CN.. 1204..
25	DCLNL 2525 M12-X07	L	25	25	150	32.0	32	CNMX 1207..
25	DCLNL 2525 M16	L	25	25	150	38.0	32	CN.. 1606..
32	DCLNL 3225 P12	L	32	25	170	32.0	32	CN.. 1204..
32	DCLNL 3232 P16	L	32	32	170	37.0	40	CN.. 1606..
32	DCLNL 3232 P19	L	32	32	170	42.0	40	CN.. 1906..
40	DCLNL 4040 S19	L	40	40	250	42.0	50	CN.. 1906..

Ordering example: 1 piece DCLNL 2020 K12

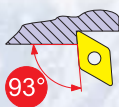
	h	1 	2 	3 	4
CNMX 1207..	25	M4,5x12-15IP/10002887	U-CN12T3-D	S-15IP-T	SET-02X-D
CN.. 1204..	20 - 32	M4,5x12-15IP/10002887	U-CN12T3-D	S-15IP-T	SET-02-D
CN.. 1606..	25 - 32	M5x14-20IP/10003023	U-CN1604-D	S-20IP-T	SET-03-D
CN.. 1906..	32 - 40	M5x14-20IP/10003023	U-CN1905-D	S-20IP-T	SET-04-D



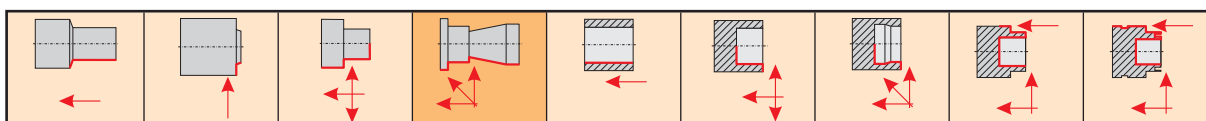
X07 = for ceramic inserts with dimple

	CN.. 1204.. 	CNMX 1207.. 	CN.. 1606.. 	CN.. 1906..
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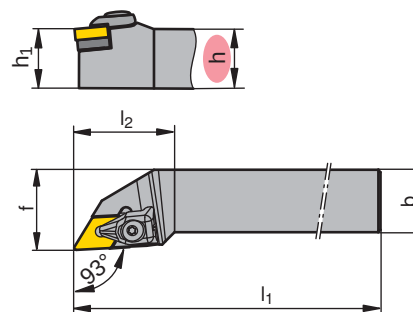
Insert programme see catalogue No. 183



MaxiLock D - external DDJNR/L



DDJN...



Picture shows right-hand version

h [mm]	Type, description	LNR 	h ₁ [mm]	b [mm]	l ₁ [mm]	l ₂ [mm]	f [mm]	
20	DDJNR 2020 K11	R	20	20	125	40.0	25	DN.. 1104..
20	DDJNR 2020 K15	R	20	20	125	40.0	25	DN.. 1506..
25	DDJNR 2525 M11	R	25	25	150	40.0	32	DN.. 1104..
25	DDJNR 2525 M15	R	25	25	150	40.0	32	DN.. 1506..
20	DDJNL 2020 K11	L	20	20	125	40.0	25	DN.. 1104..
20	DDJNL 2020 K15	L	20	20	125	40.0	25	DN.. 1506..
25	DDJNL 2525 M11	L	25	25	150	40.0	32	DN.. 1104..
25	DDJNL 2525 M15	L	25	25	150	40.0	32	DN.. 1506..

Ordering example: 1 piece DDJNR 2020 K11

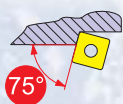
	h	1	2	3	4
DN.. 1104..	20 - 25	M3x7-09IP/10003007	U-DN1103-D	S-09IP-T	SET-01L-D
DN.. 1506..	20 - 32	M4,5x12-15IP/10002887	U-DN15T3-D	S-15IP-T	SET-02-D



DN 1504 (s = 4,76 mm) = U-DN1505-D

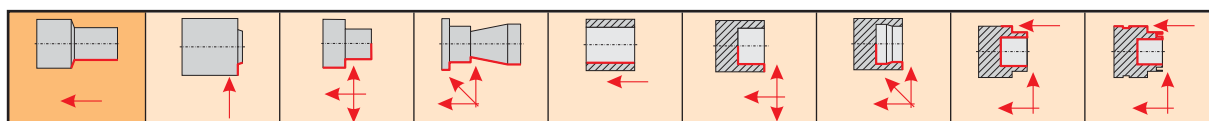
	DN.. 1506..	DN.. 1104..		

Insert programme see catalogue
No. 183

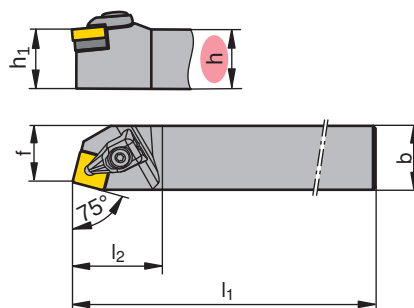


MaxiLock D - external

DSBNR/L



DSBN...



Picture shows right-hand version

h [mm]	Type, description	LNR	h ₁ [mm]	b [mm]	l ₁ [mm]	l ₂ [mm]	f [mm]	
20	DSBNR 2020 K12	R	20	20	125	35.0	17	SN.. 1204..
25	DSBNR 2525 M12	R	25	25	150	35.0	22	SN.. 1204..
25	DSBNR 2525 M15	R	25	25	150	43.0	22	SN.. 1506..
32	DSBNR 3232 P15	R	32	32	170	42.0	27	SN.. 1506..
32	DSBNR 3232 P19	R	32	32	170	48.0	27	SN.. 1906..
40	DSBNR 4040 S19	R	40	40	250	48.0	35	SN.. 1906..
40	DSBNR 4040 S25	R	40	40	250	57.0	35	SN.. 2507..
20	DSBNL 2020 K12	L	20	20	125	35.0	17	SN.. 1204..
25	DSBNL 2525 M12	L	25	25	150	35.0	22	SN.. 1204..
25	DSBNL 2525 M15	L	25	25	150	43.0	22	SN.. 1506..
32	DSBNL 3232 P15	L	32	32	170	42.0	27	SN.. 1506..
32	DSBNL 3232 P19	L	32	32	170	48.0	27	SN.. 1906..
40	DSBNL 4040 S19	L	40	40	250	48.0	35	SN.. 1906..
40	DSBNL 4040 S25	L	40	40	250	57.0	35	SN.. 2507..

Ordering example: 1 piece DSBNR 2020 K12

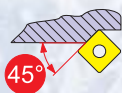
	h	1	2	3	4
SN.. 1204..	20 - 25	M4,5x12-15IP/10002887	U-SN12T3-D	S-15IP-T	SET-02-D
SN.. 1506..	25 - 32	M5x14-20IP/10003023	U-SN1504-D	S-20IP-T	SET-03-D
SN.. 1906..	32 - 40	M5x14-20IP/10003023	U-SN1905-D	S-20IP-T	SET-04-D
SN.. 2507..	40	M6x16-25IP/10003048	U-SN2506-D	S-25IP-T	SET-05-D



SN 2509 (s = 9,52 mm) = U-SN2504-D

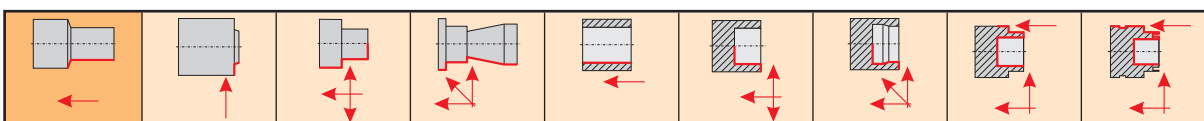
	SN.. 1204..	SN.. 1506..	SN.. 1906..	SN.. 2507..

Insert programme see catalogue
No. 183

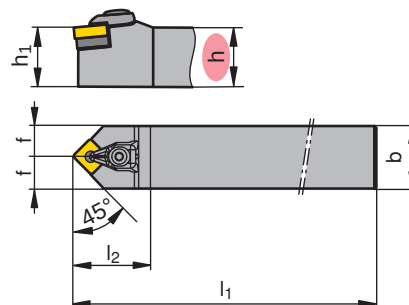


MaxiLock D - external

DSDNN



DSDN...



h [mm]	Type, description	LNR 	h ₁ [mm]	b [mm]	l ₁ [mm]	l ₂ [mm]	f [mm]	
20	DSDNN 2020 K12	N	20	20	125	38.0	10	SN.. 1204..
25	DSDNN 2525 M12	N	25	25	150	38.0	12.5	SN.. 1204..
25	DSDNN 2525 M12-X07	N	25	25	150	39.0	12.5	SNMX 1207..

Ordering example: 1 piece DSDNN 2020 K12

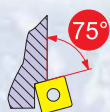
	h	1	2	3	4
SN.. 1204..	20 - 25	M4,5x12-15IP/10002887	U-SN12T3-D	S-15IP-T	SET-02-D
SNMX 1207..	25	M4,5x12-15IP/10002887	U-SN12T3-D	S-15IP-T	SET-02X-D



X07 = for ceramic inserts with dimple

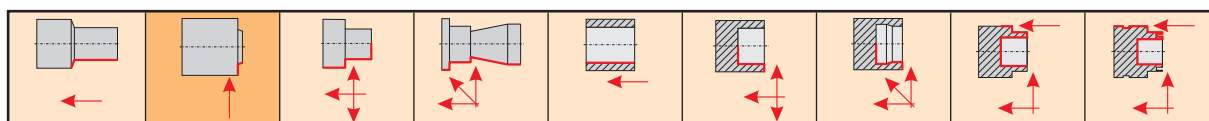
	SN.. 1204.. 	SNMX 1207.. 		
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Insert programme see catalogue
No. 183

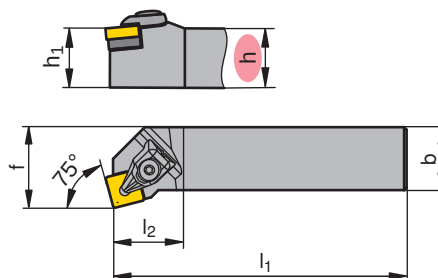


MaxiLock D - external

DSKNR/L



DSKN...



Picture shows right-hand version

h [mm]	Type, description	LNR	h ₁ [mm]	b [mm]	l ₁ [mm]	l ₂ [mm]	f [mm]	
25	DSKNR 2525 M12	R	25	25	150	28.0	32	SN.. 1204..
25	DSKNR 2525 M12-X07	R	25	25	150	28.0	32	SNMX 1207..
25	DSKNL 2525 M12	L	25	25	150	28.0	32	SN.. 1204..
25	DSKNL 2525 M12-X07	L	25	25	150	28.0	32	SNMX 1207..

Ordering example: 1 piece DSKNR 2525 M12

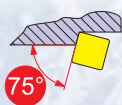
	h	1	2	3	4
SN.. 1204..	25	M4,5x12-15IP/10002887	U-SN12T3-D	S-15IP-T	SET-02-D
SNMX 1207..	25	M4,5x12-15IP/10002887	U-SN12T3-D	S-15IP-T	SET-02X-D



X07 = for ceramic inserts with dimple

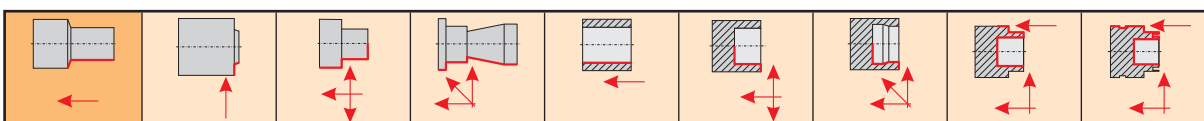
	SN.. 1204..	SNMX 1207..		

Insert programme see catalogue No. 183

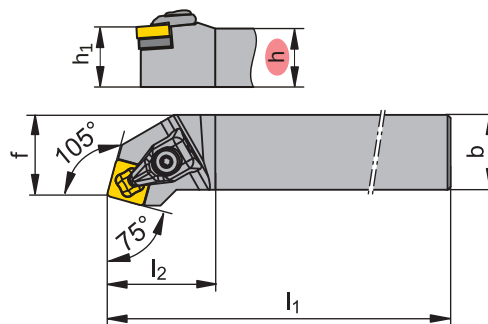


MaxiLock D - external

DSRNR/L



DSRN...



Picture shows right-hand version

h [mm]	Type, description	L N R 	h ₁ [mm]	b [mm]	l ₁ [mm]	l ₂ [mm]	f [mm]	
25	DSRNR 2525 M12-X07	R	25	25	150	36.0	27	SNMX 1207..
25	DSRNL 2525 M12-X07	L	25	25	150	36.0	27	SNMX 1207..

Ordering example: 1 piece DSRNR 2525 M12-X07

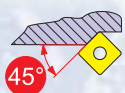
	h	1	2	3	4
SNMX 1207..	25	M4,5x12-15IP/10002887	U-SN12T3-D	S-15IP-T	SET-02X-D



X07 = for ceramic inserts with dimple

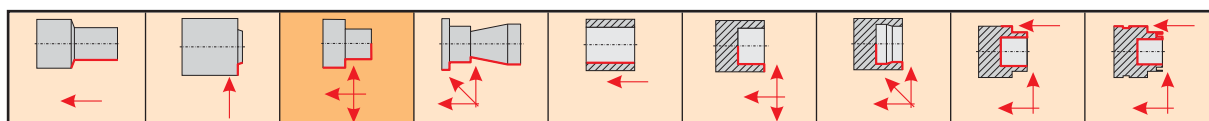
	SNMX 1207.. 			
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Insert programme see catalogue
No. 183

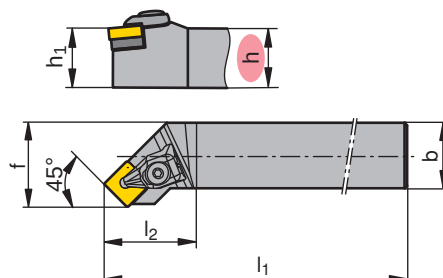


MaxiLock D - external

DSSNR/L



DSSN...



Picture shows right-hand version

h [mm]	Type, description	LNR 	h ₁ [mm]	b [mm]	l ₁ [mm]	l ₂ [mm]	f [mm]	
20	DSSNR 2020 K12	R	20	20	125	35.0	25	SN.. 1204..
25	DSSNR 2525 M12	R	25	25	150	35.0	32	SN.. 1204..
25	DSSNR 2525 M12-X07	R	25	25	150	40.0	32	SNMX 1207..
32	DSSNR 3225 P12	R	32	25	170	35.0	32	SN.. 1204..
20	DSSNL 2020 K12	L	20	20	125	35.0	25	SN.. 1204..
25	DSSNL 2525 M12	L	25	25	150	35.0	32	SN.. 1204..
25	DSSNL 2525 M12-X07	L	25	25	150	40.0	32	SNMX 1207..
32	DSSNL 3225 P12	L	32	25	170	35.0	32	SN.. 1204..

Ordering example: 1 piece DSSNR 2020 K12

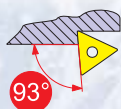
	h	1	2	3	4
SN.. 1204..	20 - 32	M4,5x12-15IP/10002887	U-SN12T3-D	S-15IP-T	SET-02-D
SNMX 1207..	25	M4,5x12-15IP/10002887	U-SN12T3-D	S-15IP-T	SET-02X-D



X07 = for ceramic inserts with dimple

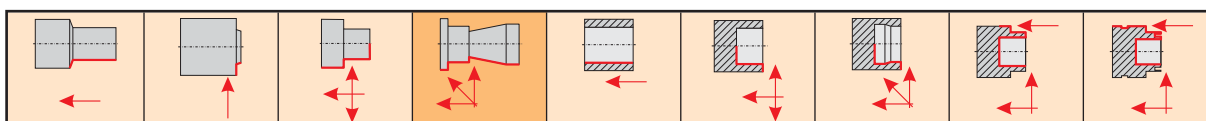
	SN.. 1204.. 	SNMX 1207.. 		
--	-----------------	-----------------	--	--

Insert programme see catalogue No. 183

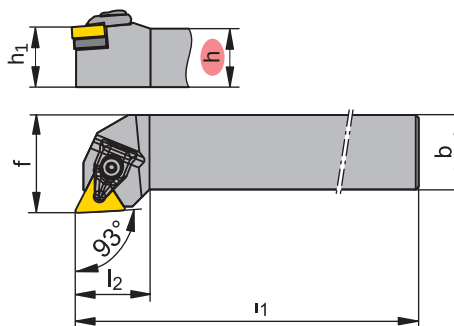


MaxiLock D - external

DTJNR/L



DTJN...



Picture shows right-hand version

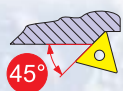
h [mm]	Type, description	LNR 	h ₁ [mm]	b [mm]	l ₁ [mm]	l ₂ [mm]	f [mm]	
20	DTJNR 2020 K16	R	20	20	125	23.0	25	TN.. 1604..
25	DTJNR 2525 M16	R	25	25	150	24.0	32	TN.. 1604..
20	DTJNL 2020 K16	L	20	20	125	23.0	25	TN.. 1604..
25	DTJNL 2525 M16	L	25	25	150	24.0	32	TN.. 1604..

Ordering example: 1 piece DTJNR 2020 K16

TN.. 1604..	h 20 - 25	1 M3x7-09IP/10003007	2 U-TN1603-D	3 S-09IP-T	4 SET-01-D

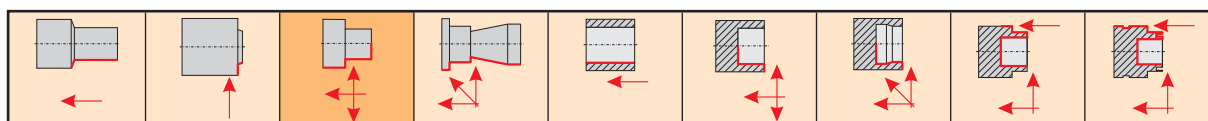
	TN.. 1604.. 			
--	-----------------	--	--	--

Insert programme see catalogue
No. 183

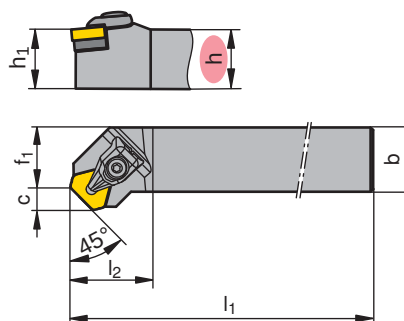


MaxiLock D DoubleEdge - external

DE-DTSNR/L



DE-DTSN...



Picture shows right-hand version

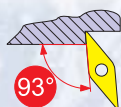
h [mm]	Type, description	L N R 	h ₁ [mm]	b [mm]	l ₁ [mm]	l ₂ [mm]	f ₁ [mm]	c [mm]	
20	DE-DTSNR 2020 K16	R	20	20	125	25.0	18.0	7.0	DE-TNMG 1604..
25	DE-DTSNR 2525 M16	R	25	25	150	26.0	25.0	7.0	DE-TNMG 1604..
25	DE-DTSNR 2525 M22	R	25	25	150	32.0	23.5	8.5	DE-TNMG 2204..
32	DE-DTSNR 3225 P27	R	32	25	170	40.0	22.2	9.8	DE-TNMG 2706..
20	DE-DTSNL 2020 K16	L	20	20	125	25.0	18.0	7.0	DE-TNMG 1604..
25	DE-DTSNL 2525 M16	L	25	25	150	26.0	25.0	7.0	DE-TNMG 1604..
25	DE-DTSNL 2525 M22	L	25	25	150	32.0	23.5	8.5	DE-TNMG 2204..
32	DE-DTSNL 3225 P27	L	32	25	170	40.0	22.2	9.8	DE-TNMG 2706..

Ordering example: 1 piece DE-DTSNR 2020 K16

	h	1	2	3	4
DE-TNMG 1604..	20 - 25	M3x7-09IP/10003007	U-DETN1603-D	S-09IP-T	SET-01L-D
DE-TNMG 2204..	25	M4,5x12-15IP/10002887	U-DETN22T3-D	S-15IP-T	SET-02-D
DE-TNMG 2706..	32	M5x14-20IP/10003023	U-DETN2704-D	S-20IP-T	SET-03-D

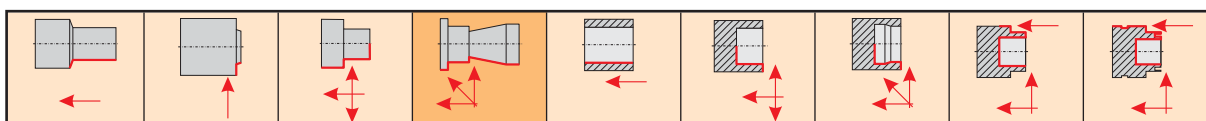
	DE-TNMG 1604..	DE-TNMG 2204..	DE-TNMG 2706..	

Insert programme see catalogue
No. 183

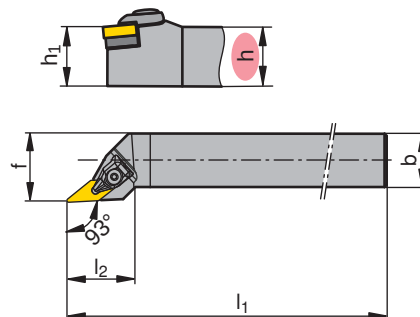


MaxiLock D - external

DVJNR/L



DVJN...



Picture shows right-hand version

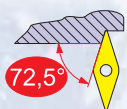
h [mm]	Type, description	LNR 	h ₁ [mm]	b [mm]	l ₁ [mm]	l ₂ [mm]	f [mm]	
20	DVJNR 2020 K16	R	20	20	125	39.0	25	VN.. 1604..
25	DVJNR 2525 M16	R	25	25	150	39.0	32	VN.. 1604..
20	DVJNL 2020 K16	L	20	20	125	39.0	25	VN.. 1604..
25	DVJNL 2525 M16	L	25	25	150	39.0	32	VN.. 1604..

Ordering example: 1 piece DVJNR 2020 K16

	h	1	2	3	4
VN.. 1604..	20 - 25	M3x7-09IP/10003007	U-VN1603-D	S-09IP-T	SET-01L-D

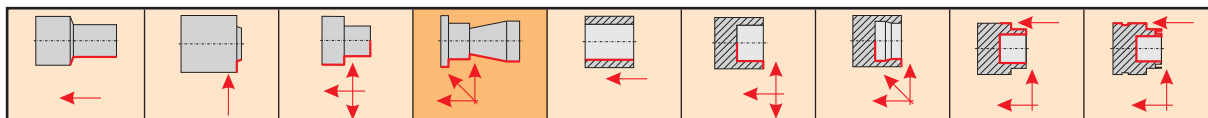
	VN.. 1604.. 			
--	-----------------	--	--	--

Insert programme see catalogue
No. 183

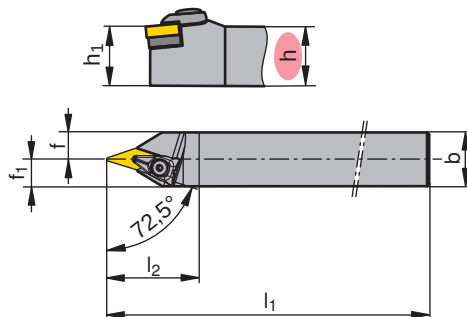


MaxiLock D - external

DVVNN



DVVN...



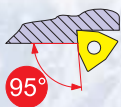
h [mm]	Type, description	LNR 	h ₁ [mm]	b [mm]	l ₁ [mm]	l ₂ [mm]	f [mm]	f ₁ [mm]	
20	DVVNN 2020 K16	N	20	20	125	43.0	7.5	12.5	VN.. 1604..
25	DVVNN 2525 M16	N	25	25	150	43.0	12.5	12.5	VN.. 1604..

Ordering example: 1 piece DVVNN 2020 K16

	h				
		1	2	3	4
VN.. 1604..	20 - 25	M3x7-09IP/10003007	U-VN1603-D	S-09IP-T	SET-01L-D

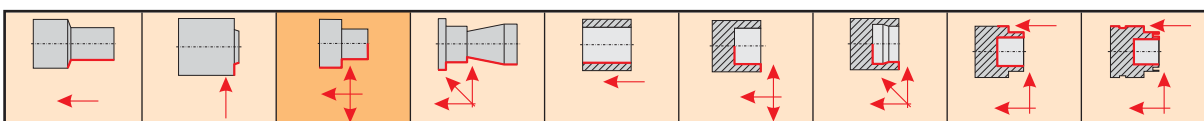
	VN.. 1604.. 			
--	-----------------	--	--	--

Insert programme see catalogue
No. 183

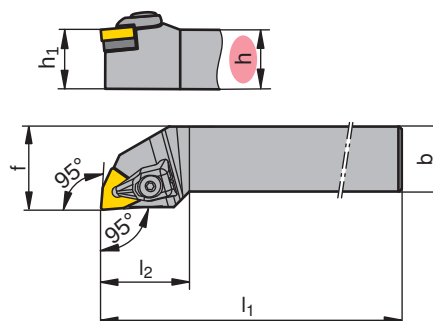


MaxiLock D - external

DWLNR/L



DWLN...



Picture shows right-hand version

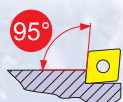
h [mm]	Type, description	LNR 	h ₁ [mm]	b [mm]	l ₁ [mm]	l ₂ [mm]	f [mm]	
20	DWLNR 2020 K06	R	20	20	125	27.0	25	WN.. 0604..
20	DWLNR 2020 K08	R	20	20	125	34.0	25	WN.. 0804..
25	DWLNR 2525 M06	R	25	25	150	27.0	32	WN.. 0604..
25	DWLNR 2525 M08	R	25	25	150	34.0	32	WN.. 0804..
20	DWLNL 2020 K06	L	20	20	125	27.0	25	WN.. 0604..
20	DWLNL 2020 K08	L	20	20	125	34.0	25	WN.. 0804..
25	DWLNL 2525 M06	L	25	25	150	27.0	32	WN.. 0604..
25	DWLNL 2525 M08	L	25	25	150	34.0	32	WN.. 0804..

Ordering example: 1 piece DWLNR 2020 K06

	h	1	2	3	4
WN.. 0604..	20 - 25	M3x7-09IP/10003007	U-WN0603-D	S-09IP-T	SET-01L-D
WN.. 0804..	20 - 25	M4,5x12-15IP/10002887	U-WN08T3-D	S-15IP-T	SET-02-D

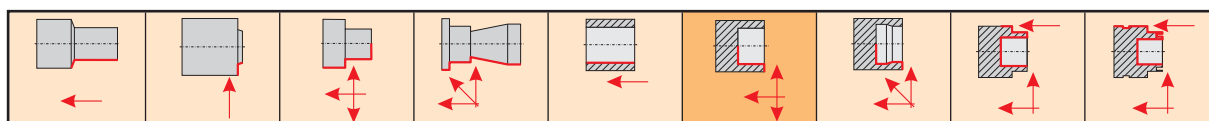
	WN.. 0604..	WN.. 0804..		

Insert programme see catalogue
No. 183

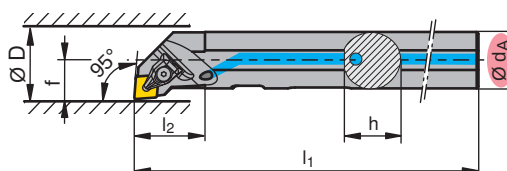


MaxiLock D - internal

DCLNR/L



DCLN...



Picture shows right-hand version

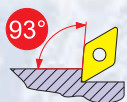
d _A [mm]	Type, description	LNR 	h [mm]	l ₁ [mm]	l ₂ [mm]	f [mm]	D [mm]	
32	A32S DCLNR 12	R	31	250	40.0	22	40	CN.. 1204..
40	A40T DCLNR 12	R	39	300	45.0	27	50	CN.. 1204..
32	A32S DCLNL 12	L	31	250	40.0	22	40	CN.. 1204..
40	A40T DCLNL 12	L	39	300	45.0	27	50	CN.. 1204..

Ordering example: 1 piece A32S DCLNR 12

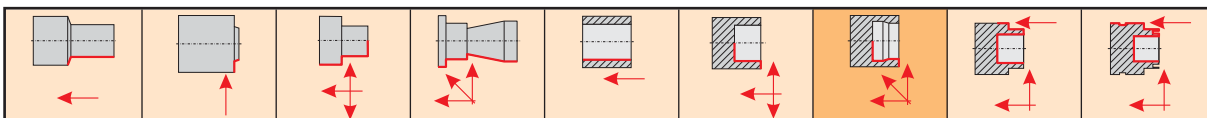
	d _A	1	2	3	4
CN.. 1204..	32 - 40	M4,5x12-15IP/10002887	U-CN12T3-D	S-15IP-T	SET-02-D

	CN.. 1204.. 			
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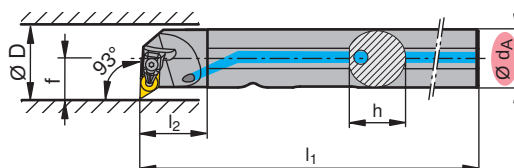
Insert programme see catalogue
No. 183



MaxiLock D - internal DDUNR/L



DDUN...



Picture shows right-hand version

d _A [mm]	Type, description	LNR 	h [mm]	l ₁ [mm]	l ₂ [mm]	f [mm]	D [mm]	
32	A32S DDUNR 11	R	31	250	40.0	22	40	DN.. 1104..
40	A40T DDUNR 15	R	39	300	45.0	27	50	DN.. 1506..
32	A32S DDUNL 11	L	31	250	40.0	22	40	DN.. 1104..
40	A40T DDUNL 15	L	39	300	45.0	27	50	DN.. 1506..

Ordering example: 1 piece A32S DDUNR 11

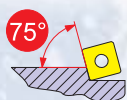
	d _A	1	2	3	4
DN.. 1104..	32	M3x7-09IP/10003007	U-DN1103-D	S-09IP-T	SET-01L-D
DN.. 1506..	40	M4,5x12-15IP/10002887	U-DN15T3-D	S-15IP-T	SET-02-D



DN 1504 (s = 4,76 mm) = U-DN1505-D

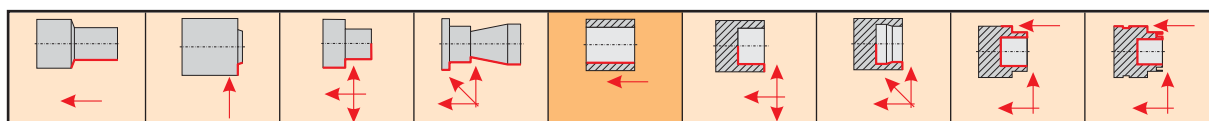
	DN.. 1104..	DN.. 1506..		

Insert programme see catalogue
No. 183

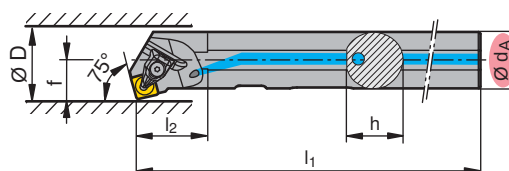


MaxiLock D - internal

DSKNR/L



DSKN...



Picture shows right-hand version

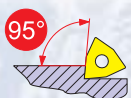
d_A [mm]	Type, description	LNR 	h [mm]	l_1 [mm]	l_2 [mm]	f [mm]	D [mm]	
32	A32S DSKNR 12	R	31	250	40.0	22	40	SN.. 1204..
32	A32S DSKNL 12	L	31	250	40.0	22	40	SN.. 1204..

Ordering example: 1 piece A32S DSKNR 12

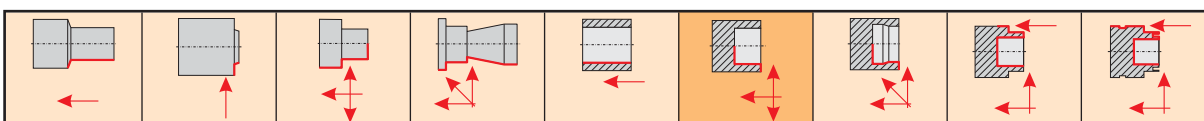
	d_A	1	2	3	4
SN.. 1204..	32	M4,5x12-15IP/10002887	U-SN12T3-D	S-15IP-T	SET-02-D

	SN.. 1204.. 			
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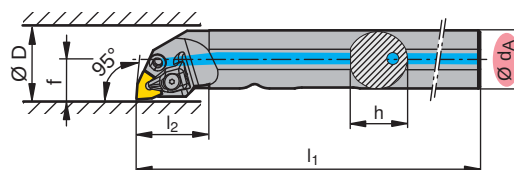
Insert programme see catalogue
No. 183



MaxiLock D - internal DWLNR/L



DWLN...



- Version A with coolant hole
- Version S without coolant hole

Picture shows right-hand version

d _A [mm]	Type, description	LNR 	h [mm]	l ₁ [mm]	l ₂ [mm]	f [mm]	D [mm]	
25	A25R DWLNR 06	R	24	200	32.0	17	32	WN.. 0604..
25	S25T DWLNR 08	R	23	300	40.0	17	32	WN.. 0804..
32	A32S DWLNR 08	R	31	250	40.0	22	40	WN.. 0804..
32	S32U DWLNR 08	R	30	350	40.0	22	40	WN.. 0804..
40	A40T DWLNR 08	R	39	300	45.0	27	50	WN.. 0804..
40	S40V DWLNR 08	R	38	400	45.0	27	50	WN.. 0804..
25	A25R DWLNL 06	L	24	200	32.0	17	32	WN.. 0604..
32	A32S DWLNL 08	L	31	250	40.0	22	40	WN.. 0804..
40	A40T DWLNL 08	L	39	300	45.0	27	50	WN.. 0804..

Ordering example: 1 piece A25R DWLNR 06

	d _A	Type, version					
WN.. 0604..	25	A	M3x7-09IP/10003007	U-WN0603-D	S-09IP-T	HY-M5	SET-01-D
WN.. 0804..	25	S			S-15IP-T		SET-02-D
WN.. 0804..	32 - 40	A	M4,5x12-15IP/10002887	U-WN08T3-D	S-15IP-T	HY-M5	SET-02-D
WN.. 0804..	32 - 40	S	M4,5x12-15IP/10002887	U-WN08T3-D	S-25IP-T		SET-02-D

	WN.. 0604.. 	WN.. 0804.. 			
--	-----------------	-----------------	--	--	--

MaxiLock D - technical information/spare parts



Recommended torque moments ...

				Clamping element	Thread	Torx	Nm	in lbs
			DE-TN.. 1604..	Set-01-D	M4	09IP	2,0	17,7
	DN.. 1104..			Set-01L-D	M4	09IP	2,0	17,7
CN.. 1204..	DN.. 1506..	SN.. 1204..	DE-TN.. 2204..	Set-02-D	M5	15IP	4,0	35,4
CN.. 1207..		SN.. 1207..		Set-02X-D	M5	15IP	4,0	35,4
CN.. 1606..		SN.. 1506..	DE-TN.. 2706..	Set-03-D	M6	20IP	6,5	57,5
CN.. 1906..		SN.. 1906..		Set-04-D	M6	20IP	6,5	57,5
		SN.. 2507..		Set-05-D	M7	25IP	8,0	70,8

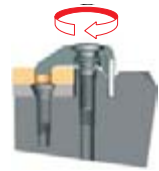
			Clamping element	Thread	Torx	Nm	in lbs
TN.. 1604..		WN.. 0604..	Set-01-D	M4	09IP	2,0	17,7
	VN 1604..		Set-01L-D	M4	09IP	2,0	17,7
		WN.. 0804..	Set-02-D	M5	15IP	4,0	35,4
			Set-03-D	M6	20IP	6,5	57,5
			Set-04-D	M6	20IP	6,5	57,5
			Set-05-D	M7	25IP	8,0	70,8

Torque key (inserts/bits)

	DMSD 1-5Nm/SORT
	DMSD 2-8Nm/SORT
	DMSD-B 9IP-50
	DMSD-B 15IP-50
	DMSD-B 20IP-50
	DMSD-B 25IP-50

IP... = TorxPlus®

MaxiLock D - technical information/spare parts



Spare parts for external tool holders...

... with insert	Shim	Screw	Clamping element	Key
CN.. 1204..	U-CN12T3-D	M4.5x12-15IP/10002887	Set-02-D	S-15IP-T
CN.. 1207..	U-CN12T3-D	M4.5x12-15IP/10002887	Set-02X-D	S-15IP-T
CN.. 1606..	U-CN1604-D	M5x14-20IP/10003023	Set-03-D	S-20IP-T
CN.. 1906..	U-CN1905-D	M5x14-20IP/10003023	Set-04-D	S-20IP-T
DN.. 1104..	U-DN1103-D	M3x7-09IP/10003007	Set-01L-D	S-09IP-T
DN.. 1504..	U-DN1505-D	M4.5x12-15IP/10002887	Set-02-D	S-15IP-T
DN.. 1506..	U-DN15T3-D	M4.5x12-15IP/10002887	Set-02-D	S-15IP-T
SN.. 1204..	U-SN12T3-D	M4.5x12-15IP/10002887	Set-02-D	S-15IP-T
SN.. 1207..	U-SN12T3-D	M4.5x12-15IP/10002887	Set-02X-D	S-15IP-T
SN.. 1506..	U-SN1504-D	M5x14-20IP/10003023	Set-03-D	S-20IP-T
SN.. 1906..	U-SN1905-D	M5x14-20IP/10003023	Set-04-D	S-20IP-T
SN.. 2507..	U-SN2506-D	M6x16-25IP/10003048	Set-05-D	S-25IP-T
SN.. 2509..	U-SN2504-D	M6x16-25IP/10003048	Set-05-D	S-25IP-T
TN.. 1604..	U-TN1603-D	M3x7-09IP/10003007	Set-01-D	S-09IP-T
DE-TN.. 1604..	U-DETN1603-D	M3x7-09IP/10003007	Set-01-D	S-09IP-T
DE-TN.. 2204..	U-DETN22T3-D	M4.5x12-15IP/10002887	Set-02-D	S-15IP-T
DE-TN.. 2706..	U-DETN2704-D	M5x14-20IP/10003023	Set-03-D	S-20IP-T
VN 1604..	U-VN1603-D	M3x7-09IP/10003007	Set-01L-D	S-09IP-T
WN.. 0604..	U-WN0603-D	M3x7-09IP/10003007	Set-01-D	S-09IP-T
WN.. 0804..	U-WN08T3-D	M4.5x12-15IP/10002887	Set-02-D	S-15IP-T

Spare parts for tool holders ...

... with insert	Shim	Screw	Coolant nozzle	Clamping element	Key
CN.. 1204..	U-CN12T3-D	M4.5x12-15IP/10002887		Set-02-D	S-15IP-T
DN.. 1104..	U-DN1103-D	M3x7-09IP/10003007		Set-01L-D	S-09IP-T
DN.. 1504..	U-DN1505-D	M4.5x12-15IP/10002887		Set-02-D	S-15IP-T
DN.. 1506..	U-DN15T3-D	M4.5x12-15IP/10002887		Set-02-D	S-15IP-T
SN.. 1204..	U-SN12T3-D	M4.5x12-15IP/10002887		Set-02-D	S-15IP-T
WN.. 0604..	U-WN0603-D	M3x7-09IP/10003007	HY-M5	Set-01-D	S-09IP-T
WN.. 0804..	U-WN08T3-D	M4.5x12-15IP/10002887	HY-M5	Set-02-D	S-15IP-T

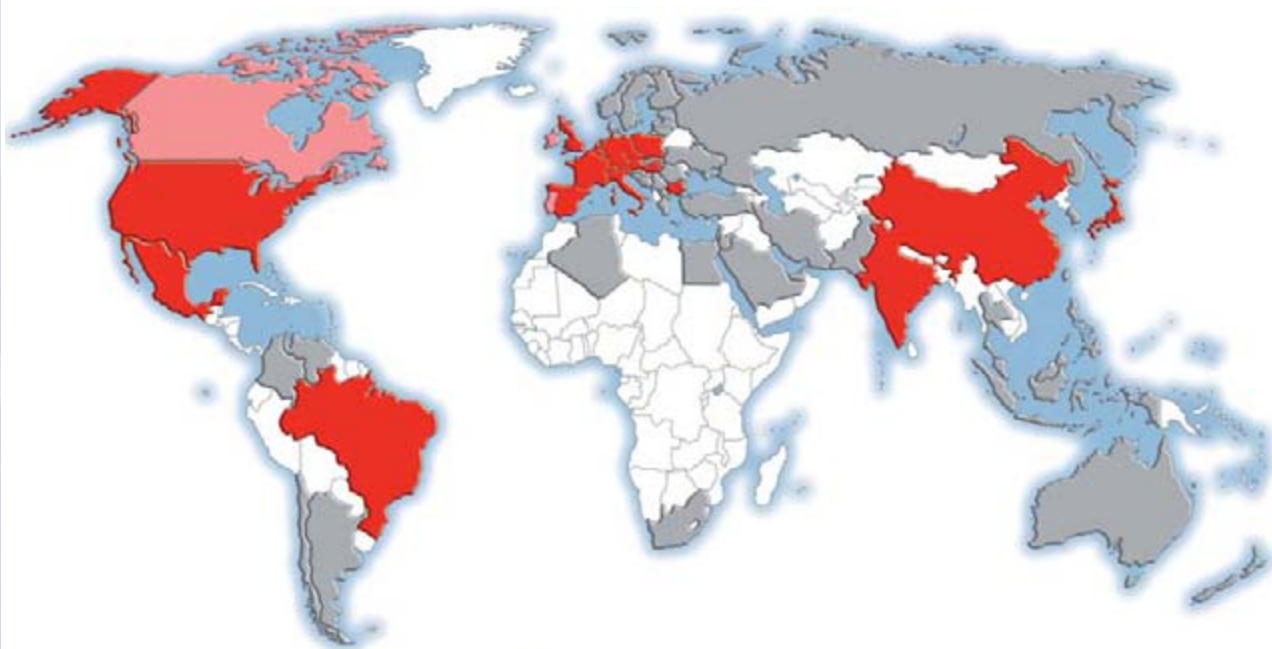
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347

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