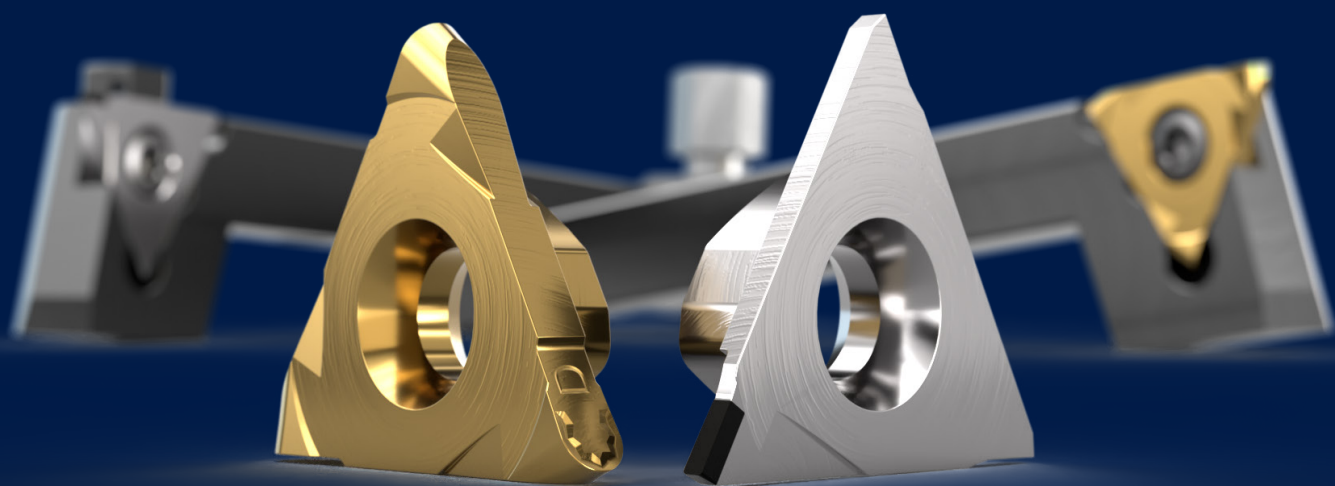




# SYSTEM DED

## Performanceline

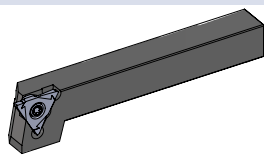
## SYSTEM DED

Einstecken mit  
dreischneidigen Wendeplatten

grooving with three-cutting  
edges indexable inserts

## Übersicht

summary



**Klemmhalter  
geschraubt**

**toolholder  
screwed**

**Maße  
dimensions  
[mm]**

**Seite  
page**

**Typ .208. ... .S5-D**

Klemmhalter,  
Außenbearbeitung

toolholder,  
external application

Spannbereich  
holding capacity  
S 5.2 - 5.5  
t max. 5.5

**... 3**

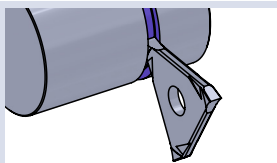
**Typ .208. ... .S5-IK**

Klemmhalter,  
Außenbearbeitung,  
innere Kühlmittelzufuhr

toolholder,  
external application,  
through coolant

Spannbereich  
holding capacity  
S 5.2 - 5.5  
t max. 5.5

**... 4**



**Wendescheidplatten  
geschraubt,  
Stechdrehen**

**indexable inserts  
screwed,  
grooving**

**Maße  
dimensions  
[mm]**

**Seite  
page**

Performanceline  
**Typ DDP.C. ... .20/CBN**

Stechdrehen allgemein,  
für Hartbearbeitung

for general grooving,  
for hard machining

Stechbreite  
width of groove  
C 1.0 / 2.0  
t max. 5.0

**... 5**

Performanceline  
**Typ DDP.G. ... .20**

Stechdrehen allgemein,  
mit gelasertem Spanformer

for general grooving,  
with lasered chipformer

Stechbreite  
width of groove  
C 1.0 - 5.0  
t max. 5.0

**... 6**

Performanceline  
**Typ DDP.V. ... .VR**

Stechdrehen allgemein,  
mit gelasertem Spanformer  
und Vollradius

for general grooving,  
with lasered chipformer  
and full radius

Vollradius  
full radius  
R 0.5 - 2.5  
t max. 5.0

**... 7**

## SYSTEM DED

Einstecken mit  
dreischneidigen Wendeplatten

grooving with three-cutting  
edges indexable inserts

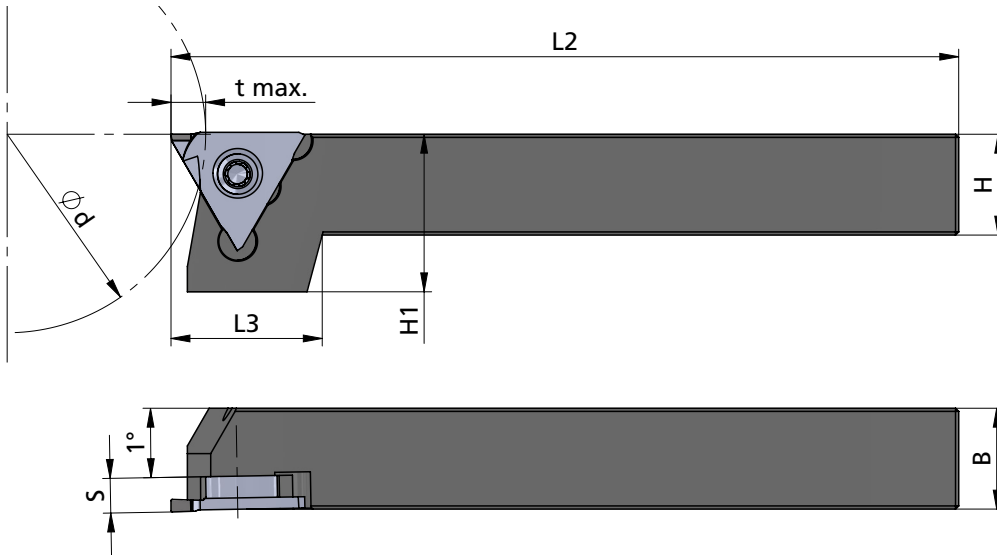
## Typ .208. ... .S5-D

Klemmhalter,  
Außenbearbeitung

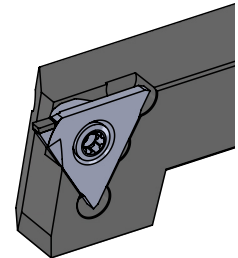
toolholder,  
external application

Stechtiefe t max. 5.5 mm  
Spannbereich S 5.2 - 5.5 mm

depth of groove t max. 5.5 mm  
holding capacity S 5.2 - 5.5 mm



Beispielzeichnung  
exemplary application



Rechts (R): wie gezeichnet  
Links (L): spiegelbildlich

Rechte Schneidpl. in rechtem  
Halter

Abmessungen in mm

righthand (R): as shown  
lefthand version (L): mirror image

RH insert in RH toolholder

dimensions in mm

| Bestellnummer<br>part number | H  | B  | *t max. | L2  | L3 | H1 | S         | Spannschraube<br>screw | Schraubenschlüssel<br>wrench | Anzugs-<br>drehmoment<br>torque | für Wende-<br>schneidplatte<br>indexable insert                    |
|------------------------------|----|----|---------|-----|----|----|-----------|------------------------|------------------------------|---------------------------------|--------------------------------------------------------------------|
| R/L .208.1212.S5-D           | 12 | 12 | 5.5     | 125 | 24 | 25 | 5.2 - 5.5 | A.SPS010               | T20F-P                       | 6.0 Nm                          | R/L DDP.C. ... .20/CBN<br>R/- DDP.G. ... .20<br>R/- DDP.V. ... .VR |
| R/L .208.1616.S5-D           | 16 | 16 | 5.5     | 125 | 24 | 25 |           | A.SPS011               |                              |                                 |                                                                    |
| R/L .208.2020.S5-D           | 20 | 20 | 5.5     | 125 | 24 | 25 |           | A.SPS011               |                              |                                 |                                                                    |
| R/L .208.2525.S5-D           | 25 | 25 | 5.5     | 125 | -  | -  |           | A.SPS011               |                              |                                 |                                                                    |

\*t max. reduziert bei Werkstück Ø d > 63  
\*t max. reduced for workpiece Ø d > 63

Bestellbeispiel:  
für rechte Ausführung  
R.208.1212.S5-D

order-example:  
righthand version  
R.208.1212.S5-D

## SYSTEM DED

Einstecken mit  
dreischneidigen Wendeplatten

grooving with three-cutting  
edges indexable inserts

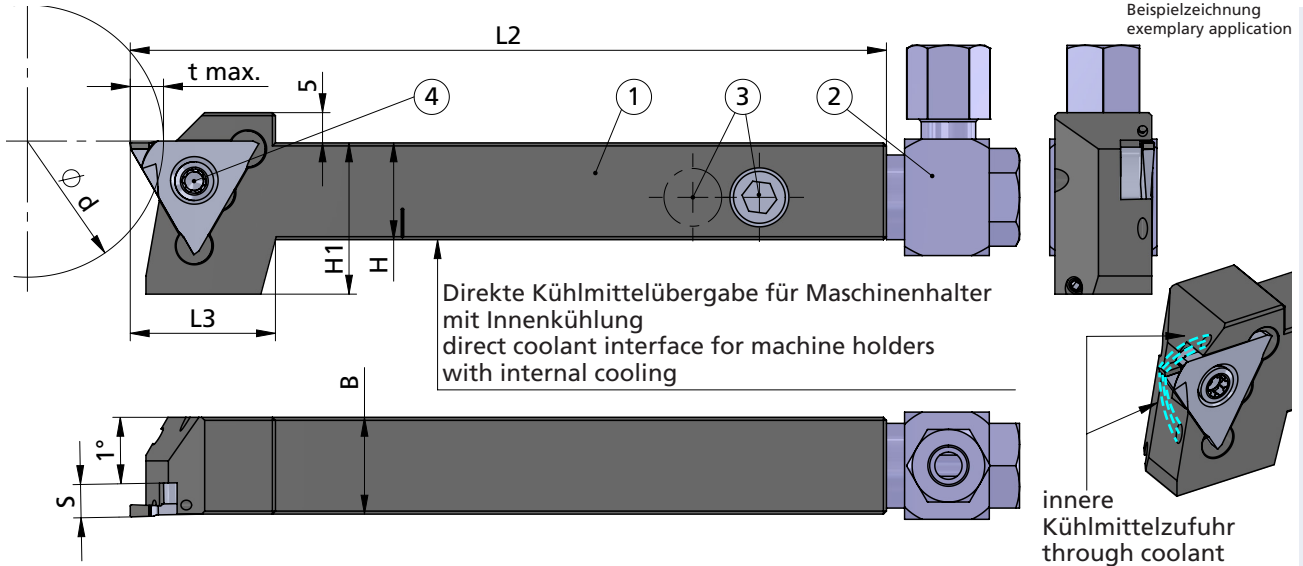
## Typ .208. ... .S5-IK

Klemmhalter,  
Außenbearbeitung,  
innere Kühlmittelzufuhr

toolholder,  
external application,  
through coolant

Stechtiefe t max. 5.5 mm  
Spannbereich S 5.2 - 5.5 mm

depth of groove t max. 5.5 mm  
holding capacity S 5.2 - 5.5 mm



Rechts (R): wie gezeichnet  
Links (L): spiegelbildlich

righthand (R): as shown  
lefthand version (L): mirror image

Abmessungen in mm

dimensions in mm



| Pos.1                        |    |    |         |     |    |    |           | Pos.2                                   |                    | Pos.3              |                              | Pos.4    |          |               |                                                                    |
|------------------------------|----|----|---------|-----|----|----|-----------|-----------------------------------------|--------------------|--------------------|------------------------------|----------|----------|---------------|--------------------------------------------------------------------|
|                              |    |    |         |     |    |    |           | Kühlmittelanschl.<br>cooling connection | WSR-Anschluss-M8x1 | WSR-Anschluss-G1/8 | Gewindestift<br>threaded pin | A.VSS003 | A.VSS001 |               | Spannschraube<br>screw                                             |
| Bestellnummer<br>part number | H  | B  | *t max. | L2  | L3 | H1 | S         |                                         |                    |                    |                              |          |          |               | für Wende-<br>schneidplatte<br>indexable insert                    |
| R/L .208.1212.S5-IK          | 12 | 12 | 5.5     | 125 | 24 | 25 | 5,2 - 5,5 |                                         | ●                  |                    | ●                            | A.SPS010 |          | T20F-P 6.0 Nm | R/L DDP.C. ... .20/CBN<br>R/- DDP.G. ... .20<br>R/- DDP.V. ... .VR |
| R/L .208.1616.S5-IK          | 16 | 16 | 5.5     | 125 | 24 | 25 |           |                                         | ●                  |                    | ●                            | A.SPS011 |          |               |                                                                    |
| R/L .208.2020.S5-IK          | 20 | 20 | 5.5     | 125 | 24 | 25 |           |                                         | ●                  |                    | ●                            | A.SPS011 |          |               |                                                                    |
| R/L .208.2525.S5-IK          | 25 | 25 | 5.5     | 125 | -  | -  |           |                                         | ●                  |                    | ●                            | A.SPS011 |          |               |                                                                    |

\*t max. reduziert bei Werkstück Ø d > 63

\*t max. reduced for workpiece Ø d > 63

Bestellbeispiel:  
für rechte Ausführung  
R.208.1212.S5-IK

order-example:  
righthand version  
R.208.1212.S5-IK

## SYSTEM DED

Einstecken mit  
dreischneidigen Wendeplatten

grooving with three-cutting  
edges indexable inserts

## Typ DDP.C. ... .20/CBN

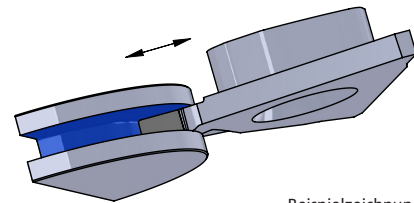
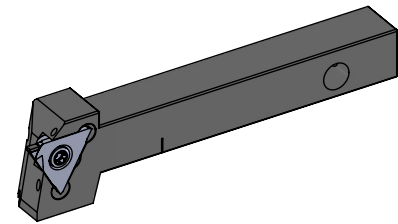
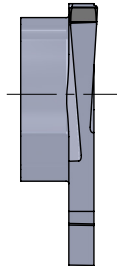
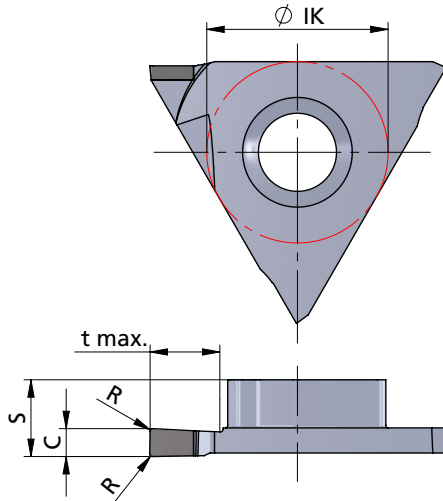
Wendeschneidplatte,  
Stechdrehen allgemein,  
für Hartbearbeitung

indexable insert,  
for general grooving,  
for hard machining

## Performanceline

Stechtiefe t max. 5.0 mm  
Stechbreite C 1.0 / 2.0 mm

depth of groove t max. 5.0 mm  
width of groove C 1.0 / 2.0 mm



Beispielzeichnung  
exemplary application

Rechte Schneidpl. in rechtem Halter,  
wie gezeichnet

Linke Schneidpl. in linkem Halter

Abmessungen in mm

RH insert in RH toolholder, as shown

LH insert in LH toolholder

dimensions in mm



| Bestellnummer<br>part number |     |     |      |        |      |      |      |       |     | Klemmhalter Typ<br>toolholder type |
|------------------------------|-----|-----|------|--------|------|------|------|-------|-----|------------------------------------|
|                              | C   | R   | S    | t max. | Ø IK | K10F | P04C | AL41F | CBN |                                    |
| R/L DDP.C.0100.20/CBN        | 1.0 | 0.2 | 5.35 | 5.0    | 13   |      |      |       | ●   | R/L .208. ... .S5-D                |
| R/L DDP.C.0200.20/CBN        | 2.0 | 0.2 | 5.50 | 5.0    | 13   |      |      |       | ●   | R/L .208. ... .S5-IK               |

## Technische Hinweise

Technical instructions



- Achtung:  
CBN-Schneiden können ohne  
Kühlung eingesetzt werden!!

Attention:  
CBN-inserts could be used  
without cooling!!



- oder:  
Einsatz bei perfekter, gleichbleibender und  
ununterbrochener Kühlbedingung!!

or:  
Use with perfect, consistent and  
uninterrupted cooling!!

Weitere HM Sorten können Sie in der Sorten-  
übersicht im Kapitel "Technische Hinweise" und  
der Preisliste finden.

Bestellbeispiel:  
für Sorte CBN:  
RDDP.C.0100.20/CBN

More carbide grades you can find in the grades  
summary in the chapter "technical instructions"  
and in the price list.

order-example:  
grade CBN:  
RDDP.C.0100.20/CBN

## SYSTEM DED

Einstecken mit dreischneidigen Wendeplatten

grooving with three-cutting edges indexable inserts

## Typ DDP.G. ... .20

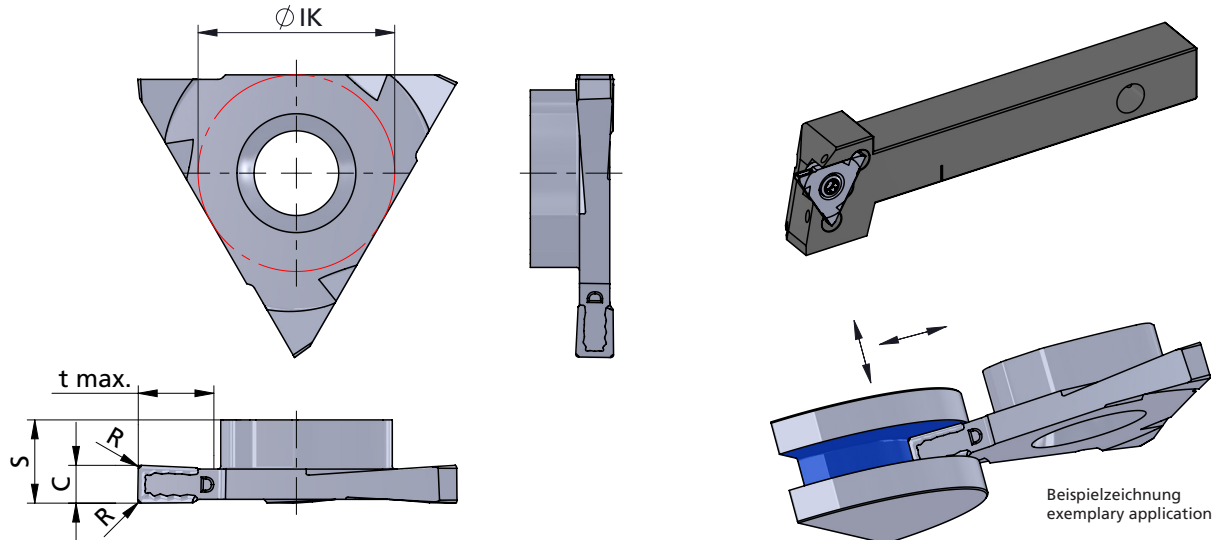
Wendeschneidplatte, Stechdrehen allgemein, mit gelasertem Spanformer

indexable insert, for general grooving, with lasered chipformer

## Performanceline

Stechtiefe t max. 5.0 mm  
Stechbreite C 1.0 - 5.0 mm

depth of groove t max. 5.0 mm  
width of groove C 1.0 - 5.0 mm



Rechte Schneidpl. in rechtem Halter, wie gezeichnet

Linke Schneidpl. in linkem Halter

Abmessungen in mm

RH insert in RH toolholder, as shown

LH insert in LH toolholder

dimensions in mm

Bestellnummer  
part number

C

R

S

t max.

Ø IK

K10F

P04C

AL41F

CBN

Klemmhalter Typ

toolholder type

R/- DDP.G.0100.20  
R/- DDP.G.0150.20  
R/- DDP.G.0180.20  
R/- DDP.G.0200.20  
R/- DDP.G.0250.20  
R/- DDP.G.0300.20  
R/- DDP.G.0400.20  
R/- DDP.G.0500.20

1.0  
1.5  
1.8  
2.0  
2.5  
3.0  
4.0  
5.0

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0.2  
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R/L .208. ... .S5-D  
R/L .208. ... .S5-IK

Weitere HM Sorten können Sie in der Sortenübersicht im Kapitel "Technische Hinweise" und der Preisliste finden.

Bestellbeispiel:  
für Sorte P04C:  
RDDP.G.0100.20/P04C

3D Spanformer optimiert für  
Vorschub f = 0.02 mm/U

3D chipformer optimized for  
feed f = 0.02 mm/rev

More carbide grades you can find in the grades summary in the chapter "technical instructions" and in the price list.

order-example:  
grade P04C:  
RDDP.G.0100.20/P04C

## SYSTEM DED

Einstecken mit  
dreischneidigen Wendeplatten

grooving with three-cutting  
edges indexable inserts

## Typ DDP.V. ... .VR

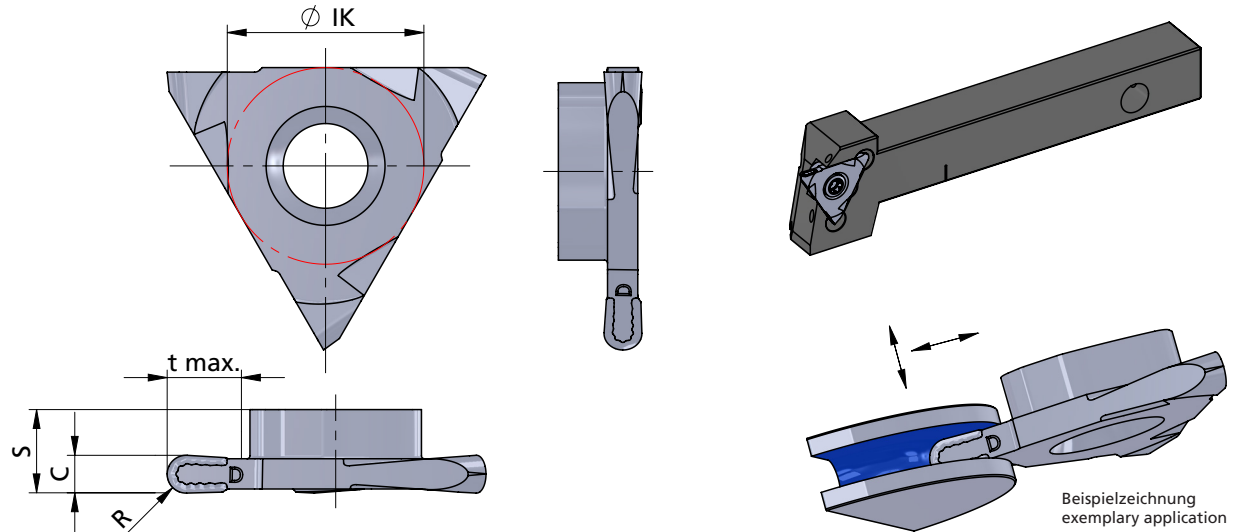
Wendeschneidplatte,  
Stechdrehen allgemein,  
mit gelasertem Spanformer  
und Vollradius

indexable insert,  
for general grooving,  
with lasered chipformer  
and full radius

## Performanceline

Stechtiefe t max. 5.0 mm  
Vollradius R 0.5 - 2.5

depth of groove t max. 5.0 mm  
full radius R 0.5 - 2.5



Rechte Schneidpl. in rechtem Halter,  
wie gezeichnet

Linke Schneidpl. in linkem Halter

Abmessungen in mm

RH insert in RH toolholder, as shown

LH insert in LH toolholder

dimensions in mm

| Bestellnummer<br>part number |     |      |      |        |      |  |      |      |       |     | Klemhalter Typ<br>toolholder type           |
|------------------------------|-----|------|------|--------|------|--|------|------|-------|-----|---------------------------------------------|
|                              | C   | R    | S    | t max. | Ø IK |  | K10F | P04C | AL41F | CBN |                                             |
| R/- DDP.V.0100.VR            | 1.0 | 0.50 | 5.35 | 5.0    | 13   |  | ●    | ●    |       |     | R/L .208. ... .S5-D<br>R/L .208. ... .S5-IK |
| R/- DDP.V.0120.VR            | 1.2 | 0.60 | 5.30 | 5.0    | 13   |  | ●    | ●    |       |     |                                             |
| R/- DDP.V.0150.VR            | 1.5 | 0.75 | 5.50 | 5.0    | 13   |  | ●    | ●    |       |     |                                             |
| R/- DDP.V.0200.VR            | 2.0 | 1.00 | 5.50 | 5.0    | 13   |  | ●    | ●    |       |     |                                             |
| R/- DDP.V.0250.VR            | 2.5 | 1.25 | 5.50 | 5.0    | 13   |  | ●    | ●    |       |     |                                             |
| R/- DDP.V.0300.VR            | 3.0 | 1.50 | 5.50 | 5.0    | 13   |  | ●    | ●    |       |     |                                             |
| R/- DDP.V.0400.VR            | 4.0 | 2.00 | 5.50 | 5.0    | 13   |  | ●    | ●    |       |     |                                             |
| R/- DDP.V.0500.VR            | 5.0 | 2.50 | 5.50 | 5.0    | 13   |  | ●    | ●    |       |     |                                             |

Weitere HM Sorten können Sie in der Sorten-  
übersicht im Kapitel "Technische Hinweise" und  
der Preisliste finden.

Bestellbeispiel:  
für Sorte P04C:  
RDDP.V.0100.VR/P04C

3D Spanformer optimiert für  
Vorschub f = 0.02 mm/U

3D chipformer optimized for  
feed f = 0.02 mm/rev

More carbide grades you can find in the grades  
summary in the chapter "technical instructions"  
and in the price list.

order-example:  
grade P04C:  
RDDP.V.0100.VR/P04C



**Span ...**  
chip

... **kontrolle**  
control

... **form**  
shape

... **bruch**  
breakage

... **abfuhr**  
evacuation

**Dümmel®**

**FORMT PRÄZISION - LIEFERT PERFORMANCE**  
shaping precision – delivering performance