

Precision monoblock holder

With internal cooling

SC Grooving system (for sliding head lathe machines)

Shank sizes ranging from 10×10 to 20×20 mm
Grooving widths from 2.0 to 3.0 mm

DG(S)C Grooving system (for greater depths)

Shank sizes ranging from 16×16 to 25×25 mm
Grooving widths from 2.0 to 6.0 mm

YOUR BENEFITS

- Reduction of heat generation
- Increase of the cutting parameters
- Controlled chip removal rate
- Outstanding surface finish
- No adjustment of coolant nozzles necessary
- Coolant supplied directly to the cutting edge



Fig.: QEFD2525L20-DGC

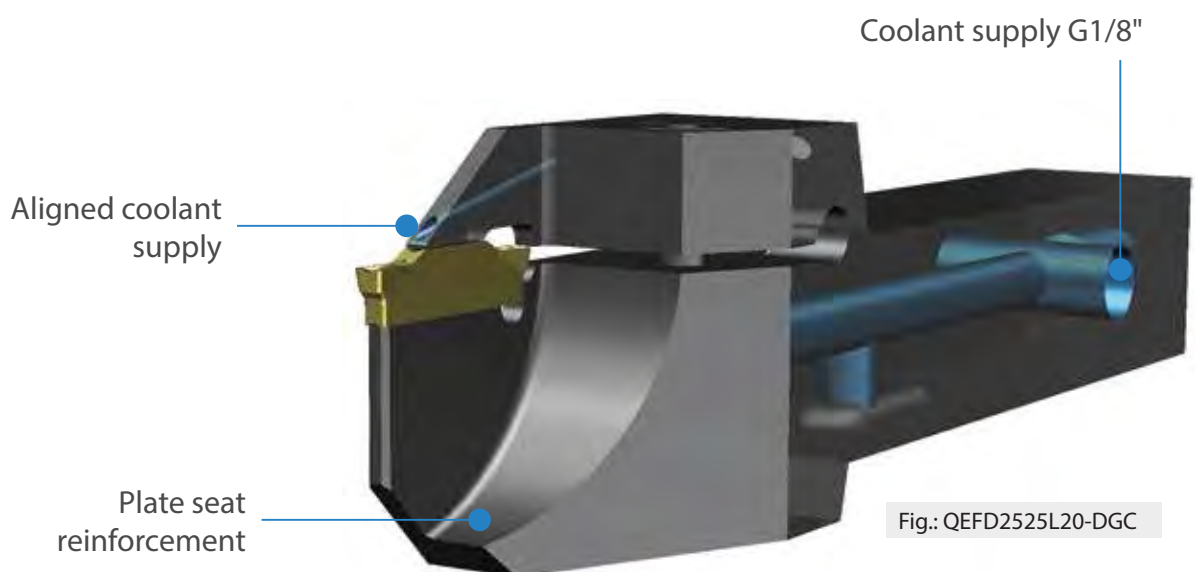


Fig.: QEFD2525L20-DGC

External tool holders

Q E G D 2525 R 22 – S C

1

2

3

4

5

6

7

8

9

Holder for parting & grooving	Application		Insert seat size [mm]	
	Code	Description	Holder/cutting width	
	E	External machining	Code	Description
			B	2,0
		E	2,5	
		F	3,0	
		G	4,0	
		H	5,0	
		K	6,0	
1	2		3	
Number of cutting edges		Cross section of holder [mm] x [mm]	Type	
Code	Description		Code	Description
S	Single		R	Right
D	Double	L	Left	
4	5	6		
Max. cutting depth [mm]	Serie			
	Code	Description		
	S	Swiss turning holder		
	DG	Cut-off holder for greater grooving depths with reinforcement		
	DGS	Cut-off holder for greater grooving depths without reinforcement		
7	8			
With internal cooling				
9				

A

Turning

B

Milling

C

Drilling

D

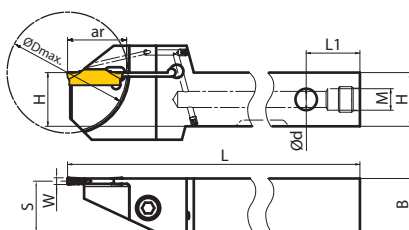
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Parting & grooving tool holder (external)

QE*DR/L-DGC



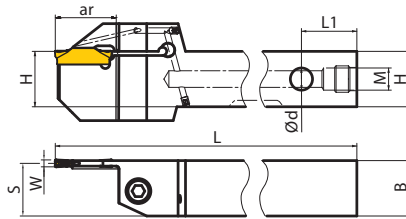
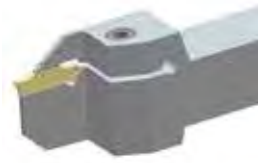
Article	*	Stock		Dimensions [mm]										kg	Inserts
		R	L	HxB	L	S	W	ar	M	L1	d	ØD max			
QEBD1616R/L20-DGC	*	●	●	16x16	96	15,00	2,00	20	G1/8	20	G1/8	40		Z*BD02002	
QEBD2020R/L20-DGC	*	●	●	20x20	111	19,00	2,00	20	G1/8	20	G1/8	40		Z*BD02002	
QEBD2525R/L20-DGC	*	●	●	25x25	126	24,00	2,00	20	G1/8	20	G1/8	40		Z*BD02002	
QEBD1616R/L30-DGC	*	●	●	16x16	105	15,00	2,00	30	G1/8	20	G1/8	60		Z*BD02002	
QEBD2020R/L30-DGC	*	●	●	20x20	120	19,00	2,00	30	G1/8	20	G1/8	60		Z*BD02002	
QEBD2525R/L30-DGC	*	●	●	25x25	135	24,00	2,00	30	G1/8	20	G1/8	60		Z*BD02002	
QEED1616R/L20-DGC	*	●	●	16x16	96	14,75	2,50	20	G1/8	20	G1/8	40		Z*ED02502	
QEED2020R/L20-DGC	*	●	●	20x20	111	18,75	2,50	20	G1/8	20	G1/8	40		Z*ED02502	
QEED2525R/L20-DGC	*	●	●	25x25	126	23,75	2,50	20	G1/8	20	G1/8	40		Z*ED02502	
QEED1616R/L30-DGC	*	●	●	16x16	105	14,75	2,50	30	G1/8	20	G1/8	60		Z*ED02502	
QEED2020R/L30-DGC	*	●	●	20x20	120	18,75	2,50	30	G1/8	20	G1/8	60		Z*ED02502	
QEED2525R/L30-DGC	*	●	●	25x25	135	23,75	2,50	30	G1/8	20	G1/8	60		Z*ED02502	
Qefd1616R/L20-DGC	*	●	●	16x16	96	14,50	3,00	20	G1/8	20	G1/8	40		Z*FD0303	
Qefd2020R/L20-DGC	*	●	●	20x20	111	18,50	3,00	20	G1/8	20	G1/8	40		Z*FD0303	
Qefd2525R/L20-DGC	*	●	●	25x25	126	23,50	3,00	20	G1/8	20	G1/8	40		Z*FD0303	
Qefd1616R/L30-DGC	*	●	●	16x16	105	14,50	3,00	30	G1/8	20	G1/8	60		Z*FD0303	
Qefd2020R/L30-DGC	*	●	●	20x20	120	18,50	3,00	30	G1/8	20	G1/8	60		Z*FD0303	
Qefd2525R/L30-DGC	*	●	●	25x25	135	23,50	3,00	30	G1/8	20	G1/8	60		Z*FD0303	
QEGD1616R/L20-DGC	*	●	●	16x16	96	18,00	4,00	20	G1/8	20	G1/8	40		Z*GD0404	
QEGD2020R/L20-DGC	*	●	●	20x20	111	23,00	4,00	20	G1/8	20	G1/8	40		Z*GD0404	
QEGD2525R/L20-DGC	*	●	●	25x25	126	23,00	4,00	20	G1/8	20	G1/8	40		Z*GD0404	
QEGD1616R/L30-DGC	*	●	●	16x16	105	18,00	4,00	30	G1/8	20	G1/8	60		Z*GD0404	
QEGD2020R/L30-DGC	*	●	●	20x20	120	23,00	4,00	30	G1/8	20	G1/8	60		Z*GD0404	
QEGD2525R/L30-DGC	*	●	●	25x25	135	23,00	4,00	30	G1/8	20	G1/8	60		Z*GD0404	

● Ex stock ○ On demand

* With internal cooling

Parting & grooving tool holder (external)

QE*DR/L-DGSC



Article	*	Stock		Dimensions [mm]										kg	Inserts
		R	L	HxB	L	S	W	ar	M	L1	d	ØD max			
QEED1616R/L30-DGSC	*	●	●	16x16	105	14,75	2,50	30	G1/8	20	G1/8	-		Z*ED02502	
QEED2020R/L30-DGSC	*	●	●	20x20	120	18,75	2,50	30	G1/8	20	G1/8	-		Z*ED02502	
QEED2525R/L30-DGSC	*	●	●	25x25	135	23,75	2,50	30	G1/8	20	G1/8	-		Z*ED02502	
Qefd1616R/L30-DGSC	*	●	●	16x16	105	14,50	3,00	30	G1/8	20	G1/8	-		Z*FD0303	
Qefd2020R/L30-DGSC	*	●	●	20x20	120	18,50	3,00	30	G1/8	20	G1/8	-		Z*FD0303	
Qefd2525R/L30-DGSC	*	●	●	25x25	135	23,50	3,00	30	G1/8	20	G1/8	-		Z*FD0303	
QEGD1616R/L30-DGSC	*	●	●	16x16	105	14,00	4,00	30	G1/8	20	G1/8	-		Z*GD0404	
QEGD2020R/L30-DGSC	*	●	●	20x20	120	18,00	4,00	30	G1/8	20	G1/8	-		Z*GD0404	
QEGD2525R/L30-DGSC	*	●	●	25x25	135	23,00	4,00	30	G1/8	20	G1/8	-		Z*GD0404	
QeHD2525R/L30-DGSC	*	●	●	25x25	135	22,50	5,00	30	G1/8	20	G1/8	-		Z*HD0504	
QEKD2525R/L30-DGSC	*	●	●	25x25	135	22,00	6,00	30	G1/8	20	G1/8	-		Z*KD0608	

● Ex stock ○ On demand

* With internal cooling

Spare parts

H	Z*BD**	Z*ED**	Z*FD**	Z*GD**
	16-25	16-25	16-25	20-25
Wrench	WH40L	WH40L	WH40L	WH40L
Screw	GB70-85-M5x20	GB70-85-M5x20	GB70-85-M5x20	GB70-85-M5x20
Grub screw (bottom)	PT1/8x4	PT1/8x4	PT1/8x4	PT1/8x4
Grub screw	PT1/8x7	PT1/8x7	PT1/8x7	PT1/8x7
Wrench	WH50L	WH50L	WH50L	WH50L

A

Turning

B

Milling

C

Drilling

D

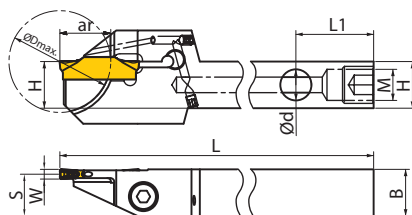
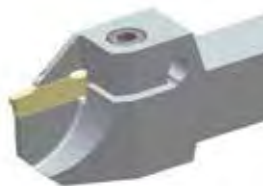
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Parting & grooving tool holder (external)

QE*DR/L-SC



Article	*	Stock		Dimensions [mm]										kg	Inserts
		R	L	HxB	L	S	W	ar	M	L1	d	ØD max			
QEBD1010R/L10-SC	*	●	●	10x10	110	9,25	2,00	10	G1/16	20	G1/16	20		ZTBD02002	
QEBD1212R/L13-SC	*	●	●	12x12	110	11,25	2,00	13	G1/8	20	G1/8	26		ZTBD02002	
QEBD1616R/L13-SC	*	●	●	16x16	110	15,25	2,00	13	G1/8	20	G1/8	26		ZTBD02002	
QEBD2020R/L13-SC	*	●	●	20x20	110	19,25	2,00	13	G1/8	20	G1/8	26		ZTBD02002	
QEED1010R/L10-SC	*	●	●	10x10	110	9,25	2,50	10	G1/16	20	G1/16	20		ZTED02503	
QEED1212R/L13-SC	*	●	●	12x12	110	11,25	2,50	13	G1/8	20	G1/8	26		ZTED02503	
QEED1616R/L17-SC	*	●	●	16x16	110	15,25	2,50	17	G1/8	20	G1/8	34		ZTED02503	
QEED2020R/L17-SC	*	●	●	20x20	110	19,25	2,50	17	G1/8	20	G1/8	34		ZTED02503	
Qefd1212R/L13-SC	*	●	●	12x12	110	11,25	3,00	13	G1/8	20	G1/8	26		ZTFD0303	
Qefd1616R/L17-SC	*	●	●	16x16	110	15,25	3,00	17	G1/8	20	G1/8	34		ZTFD0303	
Qefd2020R/L22-SC	*	●	●	20x20	110	19,25	3,00	22	G1/8	20	G1/8	44		ZTFD0303	

● Ex stock ○ On demand

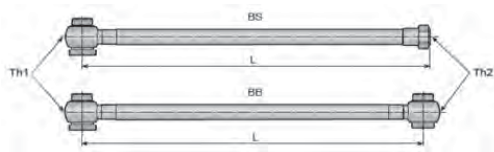
* With internal cooling

Spare parts

	H	ZTBD**	ZTBD**	ZTED**	ZTED**	ZTFD**	ZTFD**
		10-12	16-20	10-12	16-20	12	16-20
	Wrench	WH30L	WH40L	WH30L	WH40L	WH30L	WH40L
	Screw	GB70-85-M4X12	GB70-85-M6x20	GB70-85-M4X12	GB70-85-M6x20	GB70-85-M4X12	GB70-85-M5x20

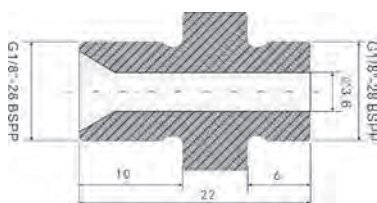
Accessoires

Coolant hose



Article	Dimensions [mm]			Stock
	L	Th1	Th2	
HOSE G1/8-7/16/200BS	200	G1/8"-28 BSPP	G1/8"-28 BSPP	○
HOSE G1/8-7/16/300BS	300	G1/8"-28 BSPP	G1/8"-28 BSPP	○
HOSE G1/8-7/16/200BB	200	G1/8"-28 BSPP	G1/8"-28 BSPP	○
HOSE G1/8-7/16/300BB	300	G1/8"-28 BSPP	G1/8"-28 BSPP	○

Coolant connection



Article	Stock
NIPPLE G1/8- G1/8	○

- Ex stock
- On demand

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Turning

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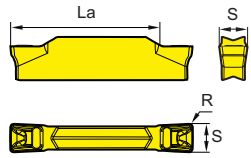












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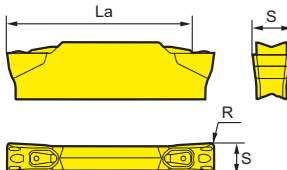




-  Ideal machining conditions
-  Normal machining conditions
-  Unfavourable machining conditions

Parting inserts

Parting & grooving insert (double sided)						HC ¹ (CVD)	HC ¹ (PVD)	HW	
 <p>Double cutting edge</p>						P	   		
						M	   		
						K			
						N			
						S	  		
						H			
ISO	S	R±0.1	La max	f		YB9320 YBG205 YBG202 YBG302			
	ZTBD02002-MM	2,0	0,2	13	0,02-0,07		● ● ○ ○		
	ZTED02503-MM	2,5	0,3	17	0,03-0,1		●		
	ZTFD0303-MM	3,0	0,3	17	0,04-0,13		●		
	ZTGD0404-MM	4,0	0,4	22	0,06-0,18		●		
	ZTHD0504-MM	5,0	0,4	22	0,08-0,23		●		
	ZTKD0608-MM	6,0	0,8	22	0,12-0,27		●		
	ZTLD0808-MM	8,0	0,8	28	0,13-0,29		● ○		

-  Ideal machining conditions
-  Normal machining conditions
-  Unfavourable machining conditions

Parting inserts

Parting & grooving insert (double sided)						HC ¹ (CVD)	HC ¹ (PVD)	HW	
 <p>Double cutting edge</p>						P			
						M			
						K			
						N			
						S			
						H			
ISO	S	R±0.1	La max	f	YBC152	YBG205			
	ZTFD0302-PL	3	0.2	17	0,04-0,13	●	●		
	ZTFD0303-PL	3	0.3	17	0,04-0,13	●	●		
	ZTGD0402-PL	4	0.2	22	0,06-0,18	●	●		
	ZTGD0404-PL	4	0.4	22	0,06-0,18	●	●		
	ZTHD0504-PL	5	0.4	22	0,08-0,23	●	●		
	ZTHD0508-PL	5	0.8	22	0,08-0,23	●	●		
	ZTKD0604-PL	6	0.4	22	0,12-0,27	●	●		
ZTKD0608-PL	6	0.8	22	0,12-0,27	●	●			

● Ex stock ○ On demand

HC¹ Coated carbide
HW Uncoated carbide

Parting inserts

- Ideal machining conditions
- ⊗ Normal machining conditions
- ⊗ Unfavourable machining conditions

Parting & grooving insert (double sided)						HC ¹ (CVD)		HC ¹ (PVD)		HW						
<p>Double cutting edge</p>						P	⊗	⊗			⊗	⊗	⊗			
						M						⊗	⊗	⊗		
						K										
						N									⊗	
						S								⊗	⊗	
						H										
ISO	S±0.10	R±0.1	La max	f	YBC252	YBC251	YB9320	YBG205	YBG202	YBG302	YD201					
	ZPED02502-MG	2,5	0,2	17	0,03-0,1	●		●	●	●						
	ZPFD0302-MG	3,0	0,2	17	0,04-0,13	●		●	●	●						
	ZPGD0402-MG	4,0	0,2	22	0,07-0,18	●		●	●	●	○					
	ZPHD0503-MG	5,0	0,3	22	0,1-0,24			●	●	●						
	ZPKD0604-MG	6,0	0,4	22	0,12-0,29	○		●	●	●						

Parting inserts

- Ideal machining conditions
- ⊗ Normal machining conditions
- ⊗ Unfavourable machining conditions

ZT** parting & grooving insert (double sided)								HC ¹ (CVD)		HC ¹ (PVD)		HW						
								P	⊗				⊗	⊗	⊗			
								M						⊗	⊗	⊗		
								K										
								N										
								S								⊗	⊗	
								H										
ISO	L	S	θ	R	La max	f	YBC252	YB9320	YBG202	YBG302	HW							
	ZPED02502-MG-6L	20,0	2,35	6°	0,2	17	0,03-0,08			○	●							
	ZPED02502-MG-6R	20,0	2,35	6°	0,2	17	0,03-0,08		●	○	●							
	ZPED02502-MG-15L	20,0	2,35	15°	0,2	17	0,03-0,05			○	●							
	ZPED02502-MG-15R	20,0	2,35	15°	0,2	17	0,03-0,05			●	●							
	ZPFD0302-MG-6L	20,0	2,85	6°	0,2	17	0,04-0,1		●	●	●							
	ZPFD0302-MG-6R	20,0	2,85	6°	0,2	17	0,04-0,1		●	●	●							
	ZPFD0302-MG-15L	20,0	2,85	15°	0,2	17	0,04-0,08			●	●							
ZPFD0302-MG-15R	20,0	2,85	15°	0,3	17	0,04-0,08	○	●	●	●								

● Ex stock ○ On demand

HC¹ Coated carbide
HW Uncoated carbide

A

Turning

B

Milling

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Drilling

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