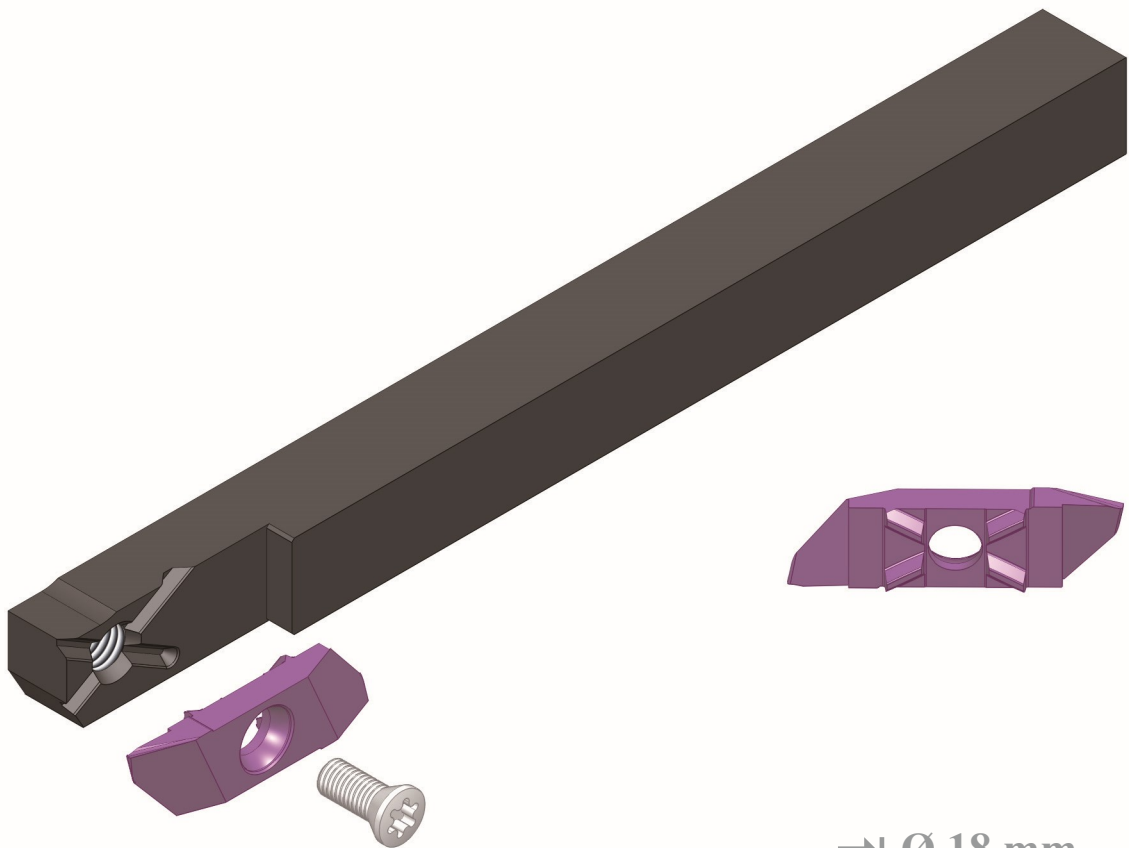


# 800 line +

**Cut off and back turning inserts**  
*High performance geometries*



→ Ø 18 mm

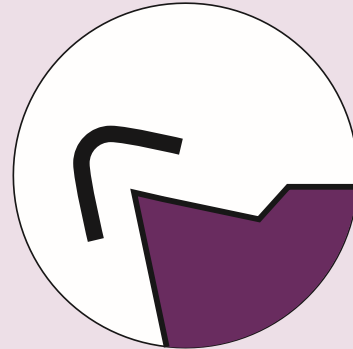
**Coating of inserts**

✓ = Available

Designation	Description
BI40U	AlTiN, new generation
BI100	AlCr, exceptional heat resistance

**Treatment of the cutting edges**

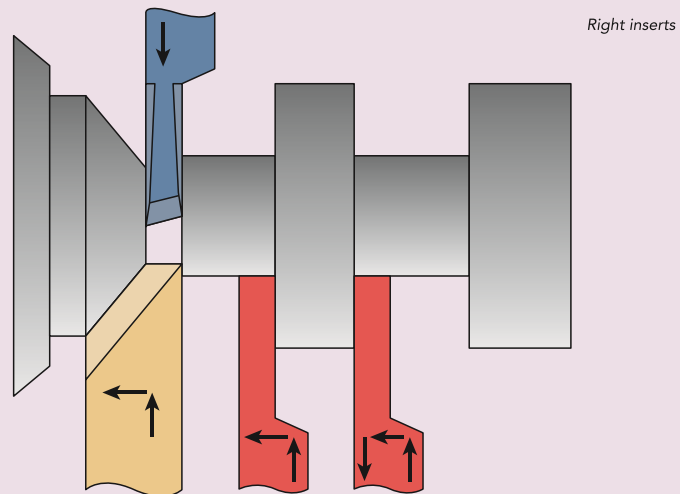
= Treated cutting edges



**Insert 800line+ : field of application**

Maximum cutting-off  
Ø 18 mm


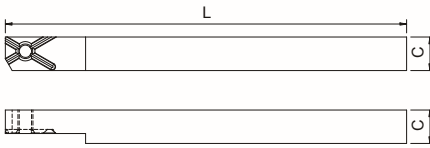
Maximum turning  
ap 3,5 mm



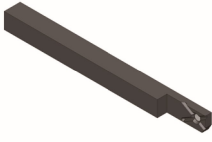
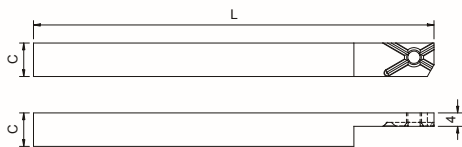
Cutting off

Plunging-Turning

Plunging-Turning

8xxR	Right tool-holder	Section C	Length L	Article nr.	
				R	L
		10 x 10	124	810R	810L
		12 x 12	124	812R	812L
		16 x 16	124	816R	816L
		8 x 8	124	808R+	808L+

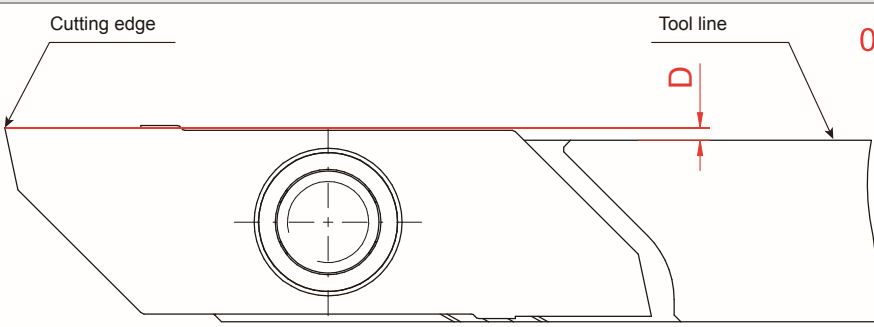
*Please see the note below  
Bitte lesen Sie den Hinweis unten  
Veuillez voir la note ci-dessous*

8xxR4	Right «Pick-up» tool-holder	Section C	Length L	Article nr.
				810R4
		10 x 10	124	810R4
		12 x 12	124	812R4
		16 x 16	124	816R4

*Use with 853R+, 853Rb and 853Rb - r inserts*

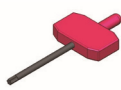
**Note on the tool-holders 808R+ and 808L+**


Tool-holder section 8x8 mm




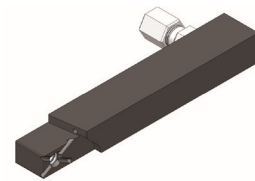
$0,5 \leq D \leq 0,6$

※ 주의  
8mm홀더에 인서트 체결시  
인서트의 폭이 커서 "D"만큼  
돌출. 간섭에 유의

100-1	Key	Article nr.
	Torx 15	100-1

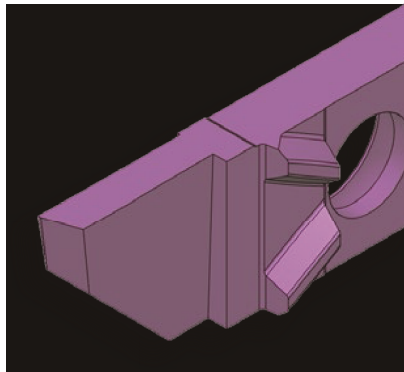
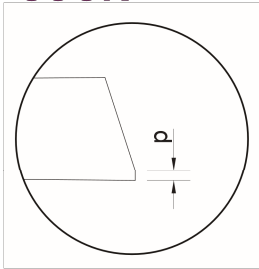
100-4	Screw for standard tool-holder	Article nr.
	M4,5 x 10,5	100-4

100-4c	Screw for 8x8 mm «Pick-up» tool-holder	Article nr.
	M4,5 x 7	100-4c



**800 line +**

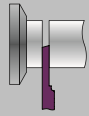
**858R**



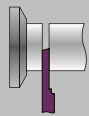
The slight flat (p) of the cutting edge increases the stability of this insert and avoids the deviation during the cut-off process.

Available widths: 1,0; 1,5 and 2,0 mm.

858R	Cut off insert 18° Abstechplatte 18° Tronconneur 18°	e	L	p	Article nr. Artikel Nr. N° Article	BI40U*
		1,0	6	0,10	858R1,0	✓
		1,5	7	0,15	858R1,5	✓
		2,0	8	0,20	858R2,0	✓
<p>Use with 8xxL tool-holders Verwendung mit 8xxL Werkzeughalter Utilisation avec les porte-outils 8xxL</p>						

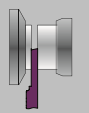

**Guide bush cut off Ø 18 mm**

844R	Standard resharable cut off insert 12°	e	L	Article nr.	BI40U
		1,0	5	844R1,0	✓
		1,2	6	844R1,2	✓
		1,5	7,5	844R1,5	✓
		2,0	9	844R2,0	✓
		2,5	9	844R2,5	✓


**Guide bush cut off Ø 14 mm**

842Rb	Short cut off insert 15° with chip breaker	e	L	Article nr.	BI40U
		1,0	5	842Rb1,0	✓
		1,5	7	842Rb1,5	✓
		2,0	7	842Rb2,0	✓

843Rb - r	Short cut off insert 15° with chip breaker and radius	e	L	r	Article nr.	BI40U
		1,0	5	0,1	843Rb1,0 - r 0,1 -	✓
		1,2	7	0,1	843Rb1,2 - r 0,1 -	✓
		1,5	7	0,1	843Rb1,5 - r 0,1 -	✓
		2,0	7	0,1	843Rb2,0 - r 0,1 -	✓
		2,5	7	0,1	843Rb2,5 - r 0,1 -	✓


**Sub spindle cut off Ø 18 mm**

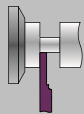
853R+	Standard resharable cut off insert 12°	e	L	Article nr.	BI40U
		1,0	5	853R+1,0	✓
		1,2	6	853R+1,2	✓
		1,5	7,5	853R+1,5	✓
		2,0	9	853R+2,0	✓
<i>Use with 8xxL tool-holders</i>					



Sub spindle cut off Ø 14 mm

853Rb	Short cut off insert 15° with chip breaker	e	L	Article nr.	B140U
		1,0	5	853Rb1,0	✓
		1,5	7	853Rb1,5	✓
		2,0	7	853Rb2,0	✓
<i>Use with 8xxL tool-holders</i>					

853Rb - r	Short cut off insert 15° with chip breaker and radius	e	L	r	Article nr.	B140U
		1,5	7	0,1	853Rb1,5 - r 0,1 -	✓
		2,0	7	0,1	853Rb2,0 - r 0,1 -	✓
		2,5	7	0,1	853Rb2,5 - r 0,1 -	✓
<i>Use with 8xxL tool-holders</i>						



Back turning

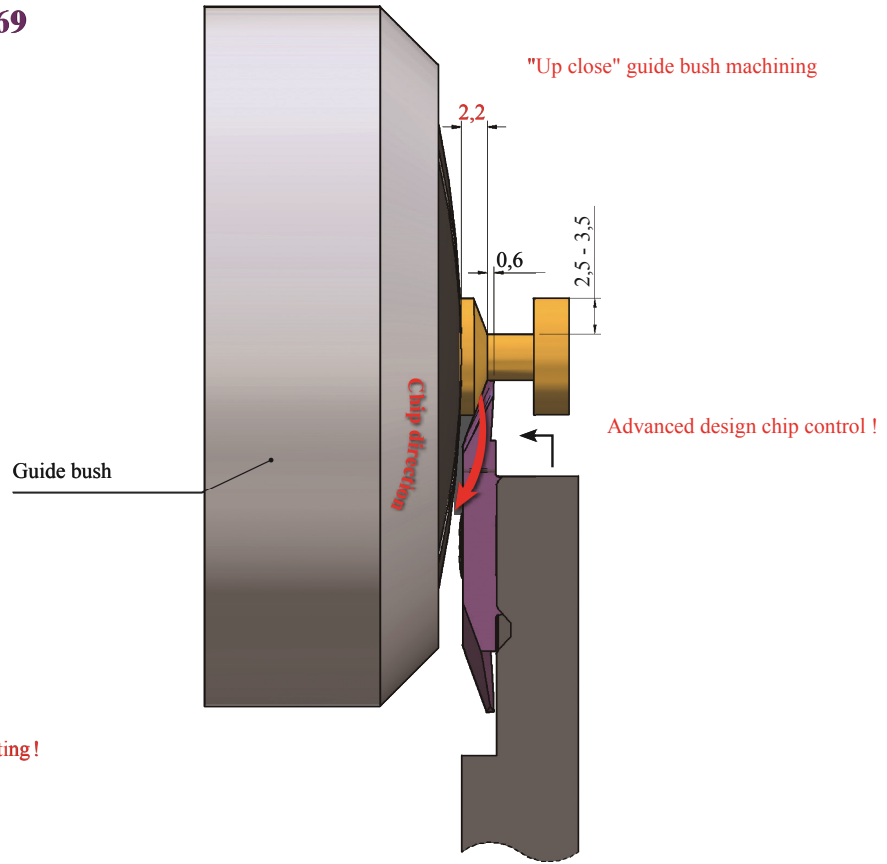
860RP+ - r	Back turning insert 0° with radius	e	L	r	Article nr.	B140U
		1,5	5	0,1	860RP+1,5 - r 0,1 -	✓
		1,5	5	0,2	860RP+1,5 - r 0,2 -	✓
		2,0	6	0,1	860RP+2,0 - r 0,1 -	✓
		2,0	6	0,2	860RP+2,0 - r 0,2 -	✓

861Rb	Back turning insert with «parisian cut»	e	L	Article nr.	B140U
		1,0	3	861Rb1,0	✓
		1,2	3	861Rb1,2	✓
		1,5	3	861Rb1,5	✓
		2,0	5	861Rb2,0	✓
		2,5	6	861Rb2,5	✓

861Rb - r	Back turning insert with «parisian cut» and radius	e	L	r	Article nr.	B140U
		1,5	3	0,1	861Rb1,5 - r 0,1 -	✓
		1,5	3	0,2	861Rb1,5 - r 0,2 -	✓
		2,0	5	0,1	861Rb2,0 - r 0,1 -	✓
		2,0	5	0,2	861Rb2,0 - r 0,2 -	✓
		2,5	6	0,1	861Rb2,5 - r 0,1 -	✓
		2,5	6	0,2	861Rb2,5 - r 0,2 -	✓

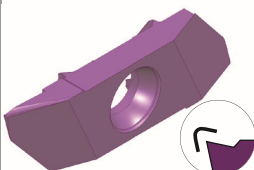
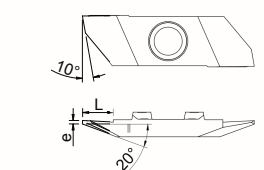
### Advantages of geometry 869

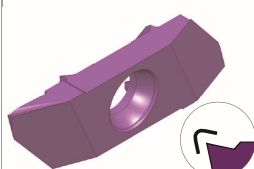
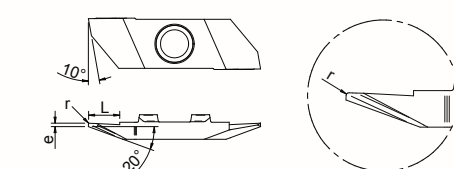
Back turning for rough machining

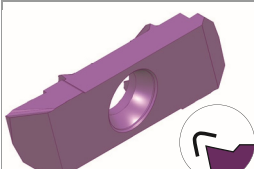
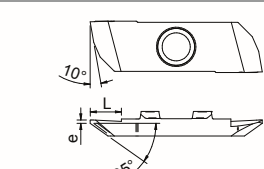


Rigid geometrie !

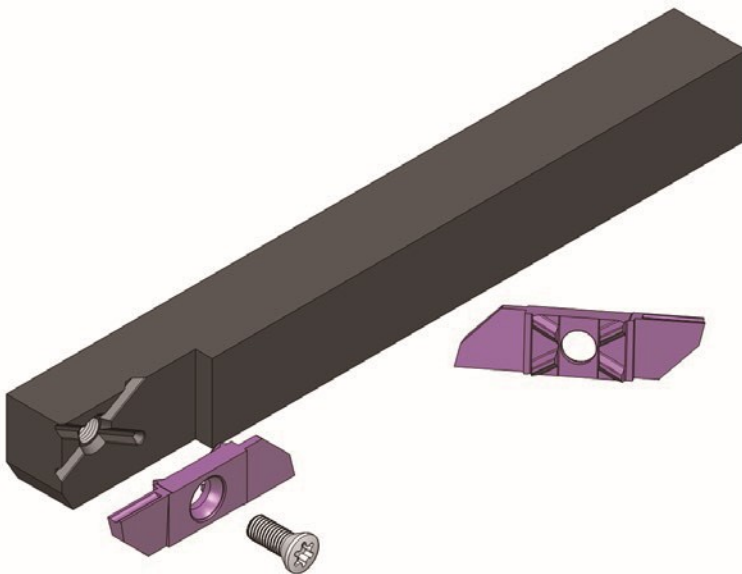
Very long tool life thanks to the BI100 coating!

863Rb - 20°	Back turning insert 20° with chip roller	e	L	Article nr.	BI40U
		0,6	5	863Rb0,6 - 20° -	✓

863Rb - r - 20°	Back turning insert 20° with chip roller and radius	e	L	r	Article nr.	BI40U
		0,6	5	0,05	863Rb0,6 - r 0,05 - 20° -	✓
		0,6	5	0,1	863Rb0,6 - r 0,1 - 20° -	✓
		0,6	5	0,2	863Rb0,6 - r 0,2 - 20° -	✓

863Rb - 35°	Back turning insert 35° with chip roller	e	L	Article nr.	BI40U
		0,6	5	863Rb0,6 - 35° -	✓

# 800 line



## 800

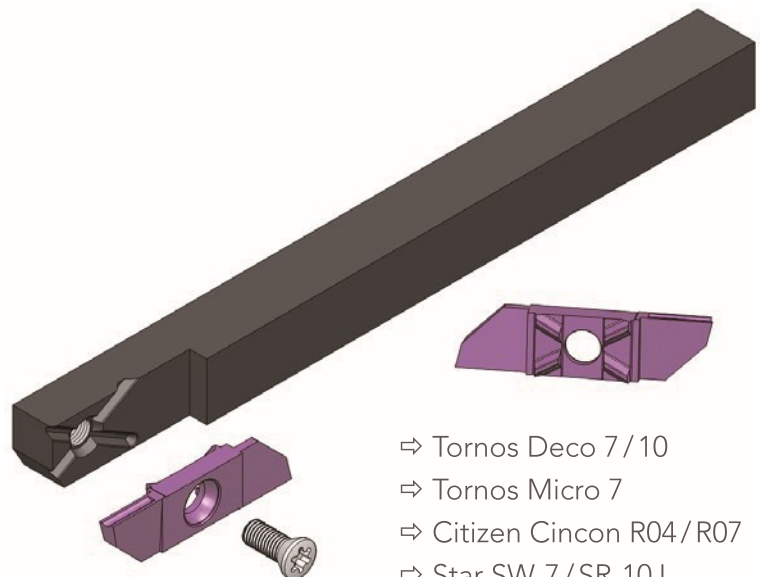
Inserts for 10x10, 12x12,  
16x16 mm section tool-holders.

→ Ø 18 mm

## 800-8

Cut off inserts (height 7,9 mm)  
only for 8x8 mm section tool-holders.

→ Ø 12 mm



- ⇒ Tornos Deco 7 / 10
- ⇒ Tornos Micro 7
- ⇒ Citizen Cincon R04 / R07
- ⇒ Star SW-7 / SR-10J



Coating of inserts

Designation	Description
K20	Without coating
BI40F BI55	AlTiN, universal
BI40U	AlTiN, new generation
TIN	TiN

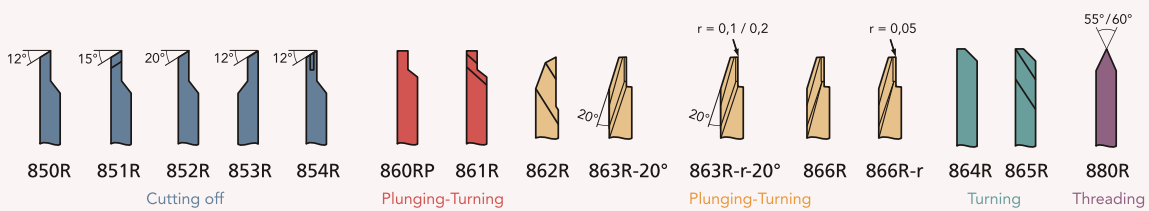
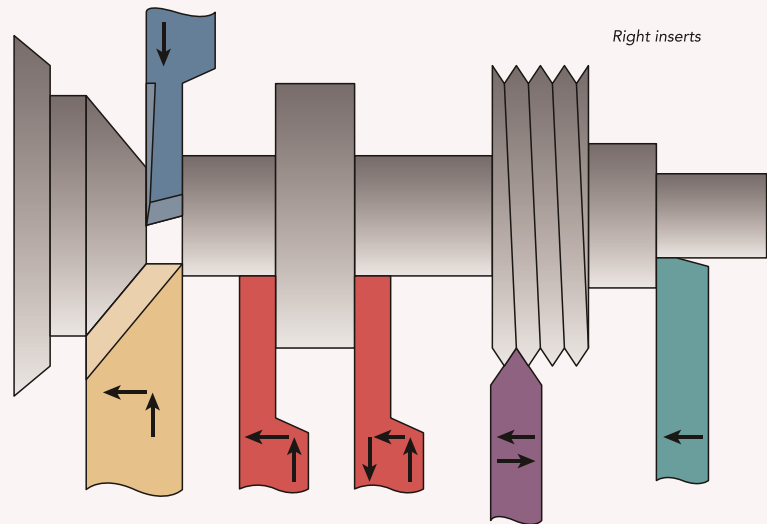
Insert 800 : field of application

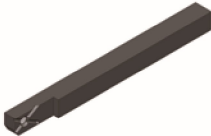
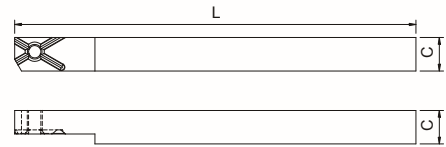
Maximum cutting-off

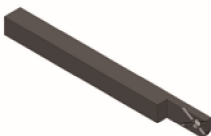
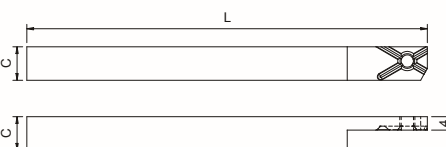
Ø 18 mm


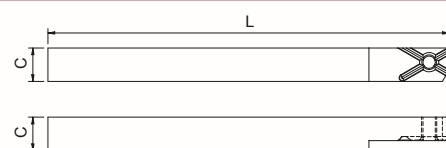
Maximum turning

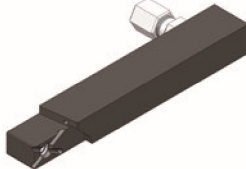
ap 5 mm




8xxR	Right tool-holder	Section C	Length L	Article nr.
		10 x 10	124	810R
		12 x 12	124	812R
		16 x 16	124	816R
		20 x 20	100	820R

8xxR4	Right «Pick-up» tool-holder	Section C	Length L	Article nr.
		10 x 10	124	810R4
		12 x 12	124	812R4
		16 x 16	124	816R4
		<i>Use with 853R inserts</i>		

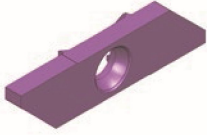
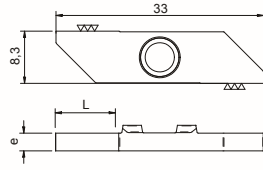
8xxL	Left tool-holder	Section C	Length L	Article nr.
		10 x 10	124	810L
		12 x 12	124	812L
		16 x 16	124	816L
		20 x 20	100	820L

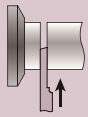
Tool-holders with internal coolant	
	See the «Tool-holders with internal coolan» documentation for further information.

100-1	Key	Article nr.
	Torx 15	100-1


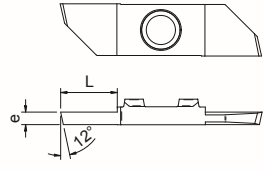
100-4	Screw for standard tool-holder	Article nr.
	M4,5 x 10,5	100-4


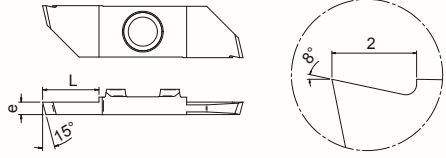
Blank

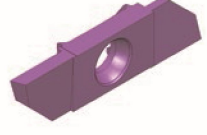
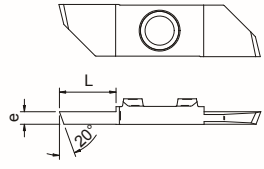
840R / L	Blank insert	R			L			K20	BI40F BI55
		e	L	Article nr.	e	L	Article nr.		
		1,7	5,0	840R1,7	1,7	5,0	840L1,7	✓	✓
		2,2	9,5	840R2,2	2,2	9,5	840L2,2	✓	✓
		2,8	—	840R2,8	2,8	—	840L2,8	✓	✓

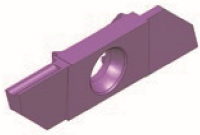
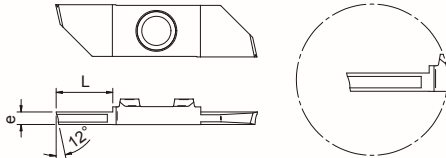


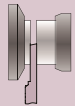
Cutting off Ø 18 mm

850R / L	Cutting insert 12°	R			L			BI40F BI55
		e	L	Article nr.	e	L	Article nr.	
		0,8	5,0	850R0,8	1,0	5,0	850L1,0	✓
		1,0	5,0	850R1,0	1,5	7,5	850L1,5	✓
		1,2	6,0	850R1,2	2,0	9,0	850L2,0	✓
		1,5	7,5	850R1,5	2,5	9,0	850L2,5	✓
		1,8	7,5	850R1,8				✓
		2,0	9,0	850R2,0				✓
		2,5	9,0	850R2,5				✓

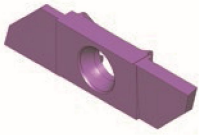
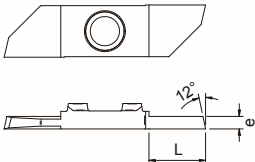
851R	Cutting insert 15° with chip breaker	R			BI40U
		e	L	Article nr.	
		1,5	7,5	851R1,5	✓
		2,0	9,0	851R2,0	✓

852R	Cutting insert 20°	R			BI40F BI55
		e	L	Article nr.	
		1,0	6,0	852R1,0	✓
		1,2	6,0	852R1,2	✓
		1,5	7,5	852R1,5	✓
		2,0	9,0	852R2,0	✓

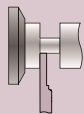
854R / L	Cutting insert with chip roller	R			L			BI40F BI55
		e	L	Article nr.	e	L	Article nr.	
		1,0	5,0	854R1,0	1,0	5,0	854L1,0	✓
		1,5	7,5	854R1,5	1,5	7,5	854L1,5	✓
		2,0	9,0	854R2,0	2,0	9,0	854L2,0	✓
		2,5	9,0	854R2,5	2,5	9,0	854L2,5	✓



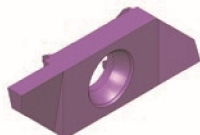
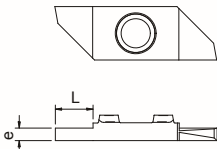
Opposite cutting off  $\varnothing$  18 mm


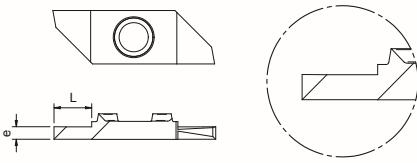
853R	Opposite cutting insert	e	L	Article nr.	BI40F BI55
		1,0	5,0	853R1,0	✓
		1,2	6,0	853R1,2	✓
		1,5	7,5	853R1,5	✓
		2,0	9,0	853R2,0	✓
		2,5	9,0	853R2,5	✓

Use with 8xxL tool-holders



Back turning

860RP / LP	Back turning insert 0°	R			L			BI40F BI55
		e	L	Article nr.	e	L	Article nr.	
		1,0	4,0	860RP1,0	1,0	4,0	860LP1,0	✓
		1,5	5,0	860RP1,5	1,5	5,0	860LP1,5	✓
		2,0	5,0	860RP2,0	2,0	5,0	860LP2,0	✓
		2,5	6,0	860RP2,5	2,5	6,0	860LP2,5	✓

861R / L	Back turning insert with «parisian cut»	R			L			BI40F BI55
		e	L	Article nr.	e	L	Article nr.	
		1,0	3,0	861R1,0	1,5	3,0	861L1,5	✓
		1,2	3,0	861R1,2	2,0	5,0	861L2,0	✓
		1,5	3,0	861R1,5	2,5	6,0	861L2,5	✓
		1,8	5,0	861R1,8				✓
		2,0	5,0	861R2,0				✓
		2,5	6,0	861R2,5				✓

862R	Back turning insert with «parisian cut»	e	L	Article nr.	BI40F BI55
		0,5	5,0	862R0,5	✓
		1,0	5,0	862R1,0	✓

863R - 20°	Back turning insert 20° with chip roller	e	L	Article nr.	BI40U
		0,6	5,0	863R0,6 - 20° -	✓

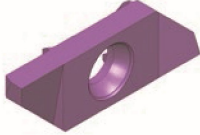
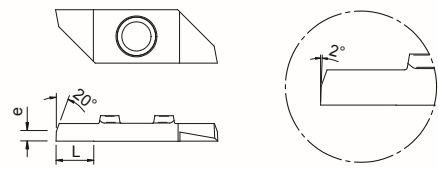
863R - r - 20°	Back turning insert 20° with chip roller and radius	e	L	r	Article nr.	BI40U
		0,6	5,0	0,1	863R0,6 - r 0,1 - 20° -	✓
		0,6	5,0	0,2	863R0,6 - r 0,2 - 20° -	✓

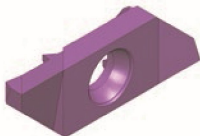
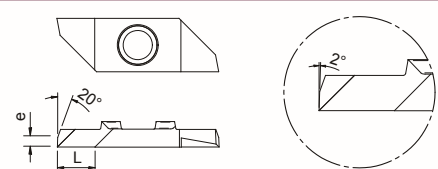
866R	Back turning insert with «W» chip roller	A	B	L	Article nr.	BI40F BI55	TIN
		0,5	1,3	2,5	866R2,5	✓	✓

866R - r	Back turning insert with «W» chip roller and radius	A	B	L	r	Article nr.	BI40F BI55	TIN
		0,5	1,3	2,5	0,05	866R2,5 - r 0,05 -	✓	✓




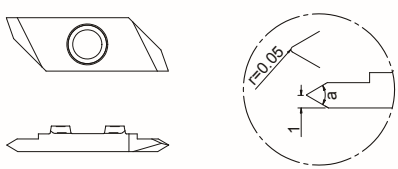
Front turning

864R	Front turning insert	e	L	Article nr.	BI40F BI55
		1,5	6,0	864R	✓

865R	Front turning insert with «parisian cut»	e	L	Article nr.	BI40F BI55
		1,5	6,0	865R	✓



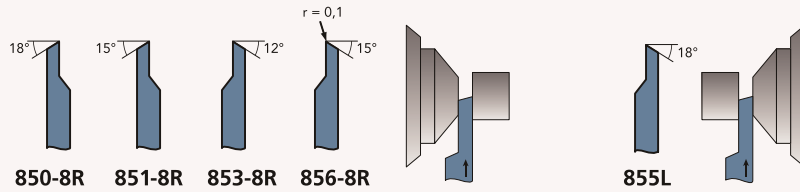
Threading

880R	Threading insert with partial profile	a	Article nr.	BI40F BI55
		55°	880R - 55° -	✓
		60°	880R - 60° -	✓

## Inserts 800-8 : field of application

Maximum cutting-off

Ø 12 mm



Cutting off, right inserts

Cutting off, left insert

Cutting of with 8x8 mm tool-holders !

Ideal for cutting on :


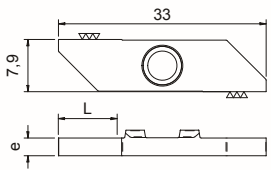
- Tornos Deco 7 / 10
- Tornos Micro 7
- Citizen Cincon R04
- Citizen Cincon R07
- Star SW-7
- Star SR-10J

For cutting on cam controlled machines.

These inserts are 7,9 mm high and only fit on 8 x 8 mm tool-holders.

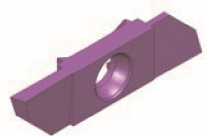
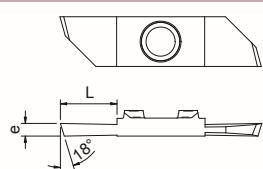
<p><b>808R</b></p> 	<p>Right tool-holder</p> 	<p>Section C</p> <p>8 x 8</p>	<p>Length L</p> <p>124</p>	<p>Article nr.</p> <p>808R</p> <p><i>Use with inserts 841R, 850-8 and 851-8R</i></p>
<p><b>808L</b></p> 	<p>Left tool-holder</p> 	<p>Section C</p> <p>8 x 8</p>	<p>Length L</p> <p>124</p>	<p>Article nr.</p> <p>808L</p> <p><i>Use with inserts 841L, 855L and 853-8R</i></p>
<p><b>808L3</b></p> 	<p>Left tool-holder</p> 	<p>Section C</p> <p>8 x 8</p>	<p>Length L</p> <p>90</p>	<p>Article nr.</p> <p>808L3</p> <p><i>Use with inserts 850-8R</i></p>
<p><b>100-4c</b></p> 	<p>Screw for 8x8 mm tool-holder</p> <p>M4,5 x 7</p>	<p>Article nr.</p> <p>100-4c</p>		

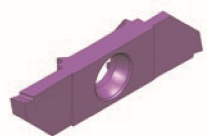
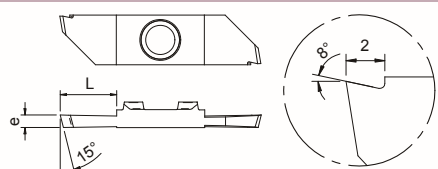
Blank

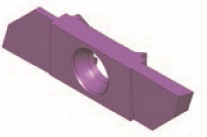
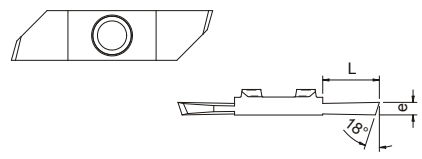
841R / L	Blank insert	R			L			K20	BI40U
		e	L	Article nr.	e	L	Article nr.		
		2,2	9,5	841R2,2	1,7	5,0	841L1,7	✓	✓
		2,8	—	841R2,8	2,2	9,5	841L2,2	✓	✓
					2,8	—	841L2,8		



Cutting off Ø 12 mm

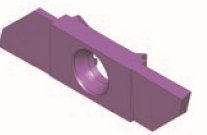
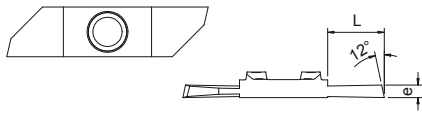
850-8R	Cutting insert 18°	e	L	Article nr.	BI40U
		1,0	5,0	850-8R1,0	✓
		1,2	6,0	850-8R1,2	✓
		1,5	7,0	850-8R1,5	✓
		2,0	8,0	850-8R2,0	✓

851-8R	Cutting insert 15° with chip breaker	e	L	Article nr.	BI40U
		1,2	6,0	851-8R1,2	✓
		1,5	7,0	851-8R1,5	✓
		2,0	8,0	851-8R2,0	✓

855L	Cutting insert 18°	e	L	Article nr.	BI40F BI55	BI40U
		1,2	6,0	855L1,2	✓	✓
		1,5	7,5	855L1,5	✓	✓
		1,8	7,5	855L1,8	✓	✓
		2,0	9,0	855L2,0	✓	✓



Opposite cutting off Ø 12 mm

853-8R	Opposite cutting insert	e	L	Article nr.	BI40U
		1,2	6,0	853-8R1,2	✓
		1,5	7,0	853-8R1,5	✓
		2,0	8,0	853-8R2,0	✓
				Use with 808L tool-holders	