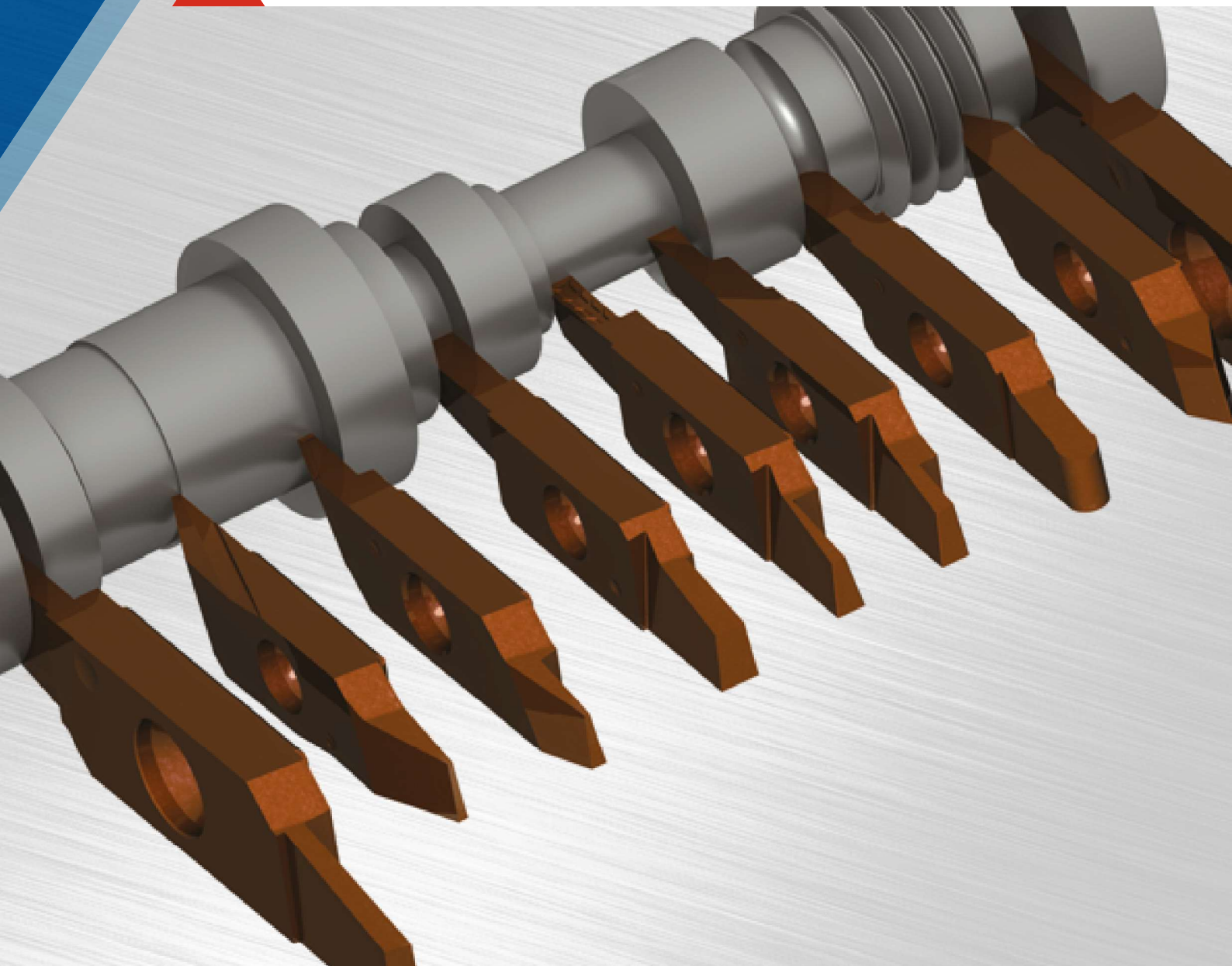


DIAMETAL

Swiss Cutting Tool

TURNDEC

High-precision turning tools



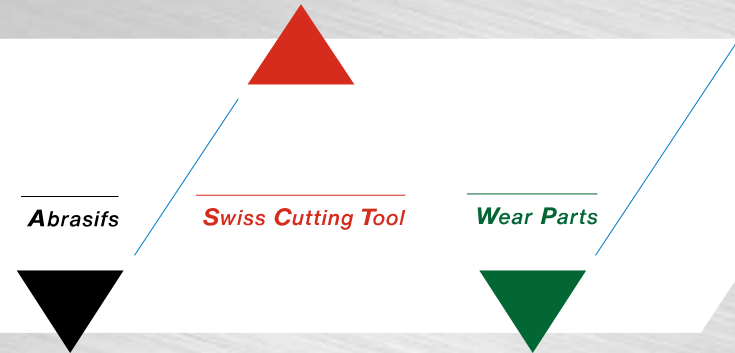
simply **D**ifferent

simply Different

The DIAMETAL group combines **three main fields of expertise** and high-precision industrial know-how that has been constantly evolving since **1936**.

Different through **its history and its rich experience**, the group provides the **international market** with standard or customized solutions in **three main strong fields**.

DIAMETAL **leverages its core competencies** (expertise, tools, methods, parameters) in the manufacturing of each product. And it **simply** makes the **D**ifference.



Watch industry
Medical
Aerospace
Machine tools
Dental
Connectors
Micromechanics
Automotive

Excellent services
Expertise in machining processes
Custom-made and standard tools
High-precision and high-performance tools

DIAMETA

since 1936



PICTOGRAMMES

Markets



Micromechanics



Automotive



Watch industry



Aerospace



Medical



Machine tools



Dental



General mechanics



Connectors

Function



Toolholder



Ground clearance angle



Right-hand machining



Left-hand machining



Chipbreaker

Application



Application table



The table of process parameters

INSERTS' CODING

System	Specification	Application	Size	Type	Cutting geometry	Dimension	Coated
TURNDEC	FINECUT Mini	SD	6	R/L	TB CP	E x L x R	D 60

TURNDEC

▶		Application table	8
▶		The table of process parameters	10
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▶		Grooving	17
▶		Parting	22
▶		Turning	28
▶		Radius grooving	32
▶		Threading	33

TURNDEC FINECUT

▶		Application table of TURNDEC FINECUT	37
▶		Toolholder of TURNDEC FINECUT	39
▶		Parting : TURNDEC FINECUT	40
▶		Turning : TURNDEC FINECUT	41
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CUTTING PARAMETERS

Turning

	Materials	ISO	f [mm/U]	Un-coated	D30	D60	D100
P1	Free-cutting steel	P	0,01-0,15	70-140	120-200	120-200	170-280
P2	Lead-free free-cutting steel		0,01-0,15	70-140	120-200	120-200	170-280
P3	Unalloyed steel (Rm < 800 N/mm ²)		0,02-0,15	50-100	80-150	80-150	90-180
P4	Low alloy steel (Rm < 900 N/mm ²)		0,01-0,10	40-80	80-140	80-140	90-170
P5	High alloy steel (Rm < 1200 N/mm ²)		0,01-0,08	30-70	50-100	50-100	70-170
M1	Ferritic stainless steel	M	0,01-0,08		60-120	60-120	90-150
M2	Martensitic stainless steel		0,01-0,08		60-120	60-120	90-150
M3	Austenitic stainless steel		0,01-0,08		60-120	60-120	90-150
K1	Cast iron	K	0,06-0,12			110-160	150-200
N1	Aluminum	N	0,01-0,20	200-2000	200-1000	200-1000	
N2	Aluminum alloys		0,01-0,20		180-800	180-800	
N3	Brass, Bronze		0,01-0,20	120-250			
N4	Lead-free brass		0,01-0,20	120-250			
N5	Copper		0,01-0,20	120-250			
N6	Precious metals		0,01-0,10	150-1500			
N7	Platinum / Palladium		0,01-0,10				
N8	Plastics		0,02-0,12	200-1200			
S1	Titanium	S	0,01-0,08		50-80	60-90	70-110
S2	Titanium alloys		0,01-0,08		50-80	60-90	70-110
S3	Super alloys (Cr, Co, Ni)		0,01-0,08		50-80	60-90	70-110
H1	Hardened steel (< 55 HRC)	H				30-80	40-90
H2	Hardened steel (> 55 HRC)					30-80	30-70

The feed rate always depends on the insert geometry.

The above values are indicative

CUTTING PARAMETERS

Parting

	Materials	ISO	f [mm/U]	Un-coated	D30	D60	D100
P1	Free-cutting steel	P	0,01-0,08	70-140	80-150	80-150	150-280
P2	Lead-free free-cutting steel		0,01-0,08	70-140	80-150	80-150	150-280
P3	Unalloyed steel (Rm < 800 N/mm ²)		0,01-0,06	50-100	80-150	70-120	90-180
P4	Low alloy steel (Rm < 900 N/mm ²)		0,01-0,06	40-80	80-140	60-100	80-170
P5	High alloy steel (Rm < 1200 N/mm ²)		0,01-0,04	30-70	50-100	40-80	50-170
M1	Ferritic stainless steel	M	0,01-0,08		60-80	60-100	100-160
M2	Martensitic stainless steel		0,01-0,08		60-80	60-100	100-160
M3	Austenitic stainless steel		0,01-0,08		60-80	60-100	100-160
K1	Cast iron	K	0,04-0,10			110-160	120-180
N1	Aluminum	N	0,02-0,20	200-2000		200-1000	
N2	Aluminum alloys		0,02-0,20		150-300	180-800	
N3	Brass, Bronze		0,01-0,12	150-300	300-600		
N4	Lead-free brass		0,01-0,10	150-300	300-600		
N5	Copper		0,01-0,10	120-250			
N6	Precious metals		0,01-0,08	100-300			
N7	Platinum / Palladium		0,01-0,08				
N8	Plastics		0,01-0,12	150-1000			
S1	Titanium	S	0,01-0,06			30-70	60-90
S2	Titanium alloys		0,01-0,06			30-70	60-90
S3	Super alloys (Cr, Co, Ni)		0,01-0,06			30-70	60-90
H1	Hardened steel (< 55 HRC)	H				30-80	40-90
H2	Hardened steel (> 55 HRC)					30-80	30-70

The feed rate always depends on the insert geometry.

The above values are indicative

TOPDEC



FEATURES

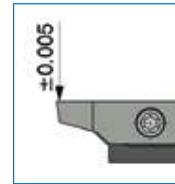
Discover the strong points of our tools

NEW



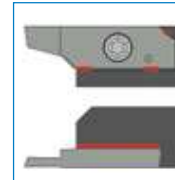
SD TD: The chipbreaker for difficult materials

The new SD TD insert allows for better segmentation and/or fracture of the chips and thus improve the productivity and quality.



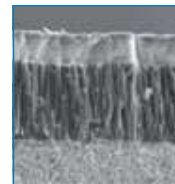
Repeatability of the process

All our inserts are ground and guarantee continuity of the process without interruption.



1 screw, 3 support points... perfect rigidity

Our single-screw fastening system allows you to quickly change the insert and assures the rigidity and stability during the machining process.



Very high-quality carbide insert

The combination of a top high quality cemented carbides with a special coating, which are optimized for your needs, increases the service life of the tools for your applications

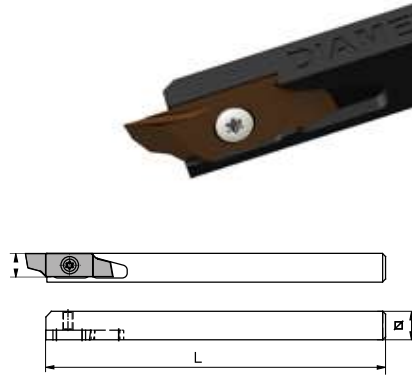


Quality of the cutting edge

Due to our expertise in the development and production of abrasive tools, we have a perfect mastery of grinding the cutting edges of our tools.

TURNDEC

Precision toolholder



TUHAL6 mini Toolholder

Type	∅ x L	Art. No
L	7 × 7 × 110	• 381 932
L	8 × 8 × 110	• 378 819
L	10 × 10 × 120	• 378 813
L	12 × 12 × 120	• 378 814

TUHAL8 Toolholder

L	10 × 10 × 120	• 374 662
L	12 × 12 × 120	• 374 663
L	16 × 16 × 120	• 374 664
L	20 × 20 × 120	• 383 910

TUHAL10 Toolholder

R	10 × 10 × 120	• 432 151
R	12 × 12 × 120	• 432 152
R	16 × 16 × 120	• 432 153

TORX Screw

Type	Art. No	Toolholder
TP 7 M 2.5 × 6.5	• 381 683	TUHAL6
TP 15 M 3.5 × 9.0	• 374 757	TUHAL8
TP 15 M 4.0 × 10.0	• 431 980	TUHAL10

Type	∅ x L	Art. No
R	7 × 7 × 110	• 381 933
R	8 × 8 × 110	• 378 820
R	10 × 10 × 120	• 378 816
R	12 × 12 × 120	• 378 817
R	16 × 16 × 120	• 404 104

R	10 × 10 × 120	• 374 665
R	12 × 12 × 120	• 374 666
R	16 × 16 × 120	• 374 667
R	20 × 20 × 120	• 383 790

Screwdriver

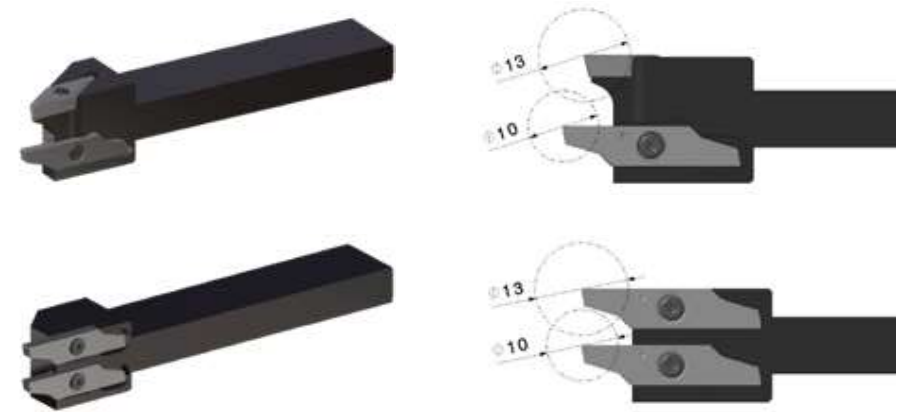
Type	Art. No
TP 7	• 436 799
TP 15	• 436 801



- Available
- Delivery time: 1 to 3 weeks

DUALDEC

Double the number of tools on your machine



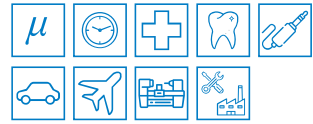
DUALHAL Toolholder

Dimensions	TURNDEC mini R TURNDEC mini R	TOPDEC SDJCR 93° TURNDEC mini R	TOPDEC SVJCR 93° TURNDEC mini R
8 × 8 × 100	• 430 901		
8 × 10 × 100		• 430 904	• 431 012
10 × 10 × 100	• 430 902	• 430 905	• 431 013
12 × 12 × 100	• 430 903	• 430 906	• 431 015

Other dimensions are available on request

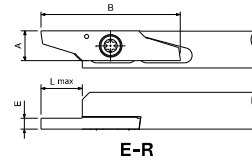
- Available
- Delivery time: 1 to 3 weeks

E
Blank insert



P1	P2	P3	P4	P5	M1	M2	M3	K1	N1	N2	N3
N4	N5	N6	N7	N8	S1	S2	S3	H1	H2		

Roughing >>>
Finishing >>>



E6-L & E6-R

Type	E	L max	A	B	Uncoated Art. No
L	2.40	7.0	5.6	25.0	• 381 634
R	2.40	7.0	5.6	25.0	• 381 635

E8-L & E8-R

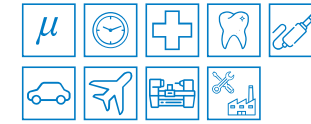
L	2.95	11.0	8.0	37.5	• 374 756
R	2.95	11.0	8.0	37.5	• 374 755

E10-R

R	3.95	17.0	10.0	59.0	• 432 185
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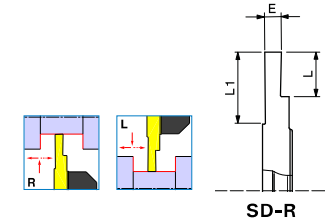


SD
Grooving / Turning



P1	P2	P3	P4	P5	M1	M2	M3	K1	N1	N2	N3
N4	N5	N6	N7	N8	S1	S2	S3	H1	H2		

Roughing >>>
Finishing >>>



SD6-L & SD6-R

Type	E	L	L1	Uncoated Art. No	D30 Art. No	D60 Art. No	D100 Art. No
L	0.50	2.00	3.00	• 437 338		• 381 636	
L	0.80	2.50	3.50	• 437 341	• 427 029	• 381 637	
L	1.00	3.00	4.00	• 437 343		• 381 638	
L	1.20	4.00	5.00	• 437 346		• 381 639	
L	1.50	4.00	5.00	• 437 349	• 426 706	• 381 640	
L	2.00	5.00	6.00	• 437 351	• 427 032	• 381 641	
R	0.50	2.00	3.00	• 437 353		• 381 642	
R	0.80	2.50	3.50	• 437 356	• 427 030	• 381 643	
R	1.00	3.00	4.00	• 437 358		• 381 644	
R	1.20	4.00	5.00	• 437 361		• 381 645	
R	1.50	4.00	5.00	• 437 364	• 427 031	• 381 646	• 434 570
R	2.00	5.00	6.00	• 428 537	• 427 033	• 381 647	• 434 571



SD8-L & SD8-R

L	1.50	5.00	7.00	• 374 670	• 427 059	• 374 673	
L	2.00	5.00	7.00	• 374 669	• 427 061	• 374 672	
L	2.50	6.00	8.00	• 374 668	• 427 063	• 374 671	
R	1.50	5.00	7.00	• 374 691	• 427 060	• 374 694	
R	2.00	5.00	7.00	• 374 690	• 427 062	• 374 693	
R	2.50	6.00	8.00	• 374 689	• 427 064	• 374 692	

Other dimensions and conditioning of the cutting edge and/or coating are available on request

- Available
- Delivery time: 1 to 3 weeks

simply Different
Form
for customer-specific inserts

TURNDEC
E6sy

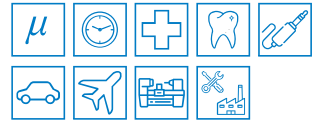


Other dimensions and conditioning of the cutting edge and/or coating are available on request

- Available
- Delivery time: 1 to 3 weeks

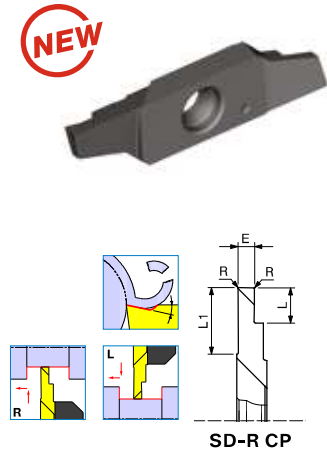
SD CP

Grooving / Turning
with optimized chipbreaker



P1	P2	P3	P4	P5	M1	M2	M3	K1	N1	N2	N3
N4	N5	N6	N7	N8	S1	S2	S3	H1	H2		

Roughing >>>
Finishing >>>



SD6-R CP

Type	E	L	L1	R	Uncoated Art. No	D30 Art. No	D60 Art. No	D100 Art. No
R	0.80	2.00	6.00	-	• 436 533	• 431 766	• 431 767	• 436 551
R	1.00	2.50	6.00	0.08	• 436 534	• 431 769	• 431 770	• 436 552
R	1.50	3.00	6.00	-	• 436 535	• 431 772	• 431 773	• 436 553
R	1.50	3.00	6.00	0.08	• 436 536	• 431 775	• 431 776	• 436 554
R	2.00	4.00	6.00	-	• 436 537	• 431 778	• 431 779	• 436 555



SD8-R CP

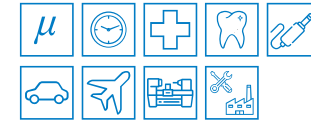
R	1.50	4.00	8.00	0.08	• 436 538	• 431 781	• 431 782	• 436 556
R	2.00	5.00	8.00	-	• 436 539	• 431 784	• 431 785	• 436 557
R	2.00	5.00	8.00	0.20	• 436 540	• 431 787	• 431 788	• 436 558
R	2.50	6.00	8.00	-	• 436 541	• 431 790	• 431 791	• 436 559

Other dimensions and conditioning of the cutting edge and/or coating are available on request

- Available
- Delivery time: 1 to 3 weeks

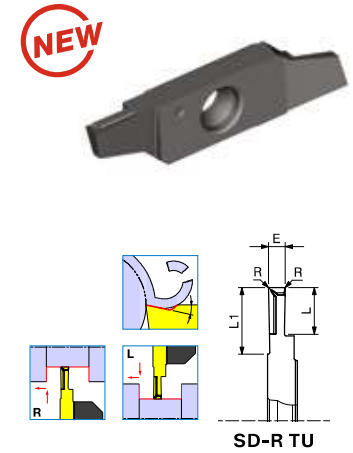
SD TU

Grooving / Turning
with optimized chipbreaker



P1	P2	P3	P4	P5	M1	M2	M3	K1	N1	N2	N3
N4	N5	N6	N7	N8	S1	S2	S3	H1	H2		

Roughing >>>
Finishing >>>



SD6-R TU

Type	E	L	L1	R	Uncoated Art. No	D30 Art. No	D60 Art. No	D100 Art. No
R	1.00	2.50	6.00	0.01	• 436 501	• 432 613	• 432 614	• 436 565
R	1.50	4.00	6.00	0.01	• 436 502	• 432 616	• 432 617	• 436 566
R	1.50	4.00	6.00	0.08	• 436 503	• 432 619	• 432 620	• 436 567
R	2.00	4.50	6.00	0.01	• 436 504	• 432 622	• 432 623	• 436 568
R	2.00	4.50	6.00	0.08	• 436 505	• 432 625	• 432 626	• 436 569



SD8-R TU

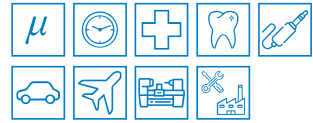
R	1.50	4.00	8.00	0.03	• 436 506	• 432 628	• 432 629	• 436 570
R	2.00	5.00	8.00	0.08	• 436 507	• 432 631	• 432 632	• 436 571
R	2.00	5.00	8.00	0.20	• 436 508	• 432 634	• 432 635	• 436 572
R	2.50	6.00	8.00	0.03	• 436 509	• 432 637	• 432 638	• 436 573
R	2.50	6.00	8.00	0.08	• 436 510	• 432 640	• 432 641	• 436 574
R	2.50	6.00	8.00	0.20	• 436 511	• 432 643	• 432 644	• 436 575

Other dimensions and conditioning of the cutting edge and/or coating are available on request

- Available
- Delivery time: 1 to 3 weeks

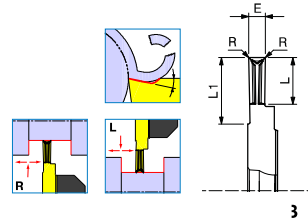
SD TB

Grooving / Turning
with optimized chipbreaker



P1	P2	P3	P4	P5	M1	M2	M3	K1	N1	N2	N3
N4	N5	N6	N7	N8	S1	S2	S3	H1	H2		

Roughing >>>
Finishing >



SD6- R TB

Type	E	L	L1	R	Uncoated Art. No	D30 Art. No	D60 Art. No	D100 Art. No
R	1.50	4.00	6.00	0.03	● 436 512	● 432 646	● 432 647	● 436 576
R	1.50	4.00	6.00	0.08	● 436 513	● 432 649	● 432 650	● 436 577
R	2.00	4.50	6.00	0.03	● 436 514	● 432 652	● 432 653	● 436 578
R	2.00	4.50	6.00	0.08	● 436 515	● 432 655	● 432 656	● 436 579



SD8-R TB

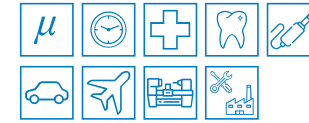
R	1.50	4.00	8.00	0.08	● 436 516	● 432 658	● 432 659	● 436 580
R	2.00	5.00	8.00	0.08	● 436 517	● 432 661	● 432 662	● 436 581
R	2.00	5.00	8.00	0.15	● 436 518	● 432 664	● 432 665	● 436 582
R	2.00	6.00	8.00	0.08	● 436 519	● 432 667	● 432 668	● 436 583
R	2.00	6.00	8.00	0.15	● 436 520	● 432 670	● 432 671	● 436 584

Other dimensions and conditioning of the cutting edge and/or coating are available on request

- Available
- Delivery time: 1 to 3 weeks

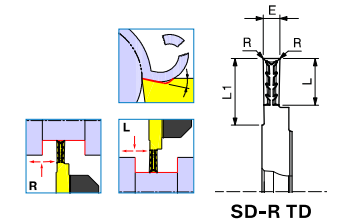
SD TD

Grooving / Turning
with optimized chipbreaker



P1	P2	P3	P4	P5	M1	M2	M3	K1	N1	N2	N3
N4	N5	N6	N7	N8	S1	S2	S3	H1	H2		

Roughing >>>
Finishing >



SD6-R TD

Type	E	L	L1	R	Uncoated Art. No	D30 Art. No	D60 Art. No	D100 Art. No
R	1.00	2.50	6.00	0.01	● 436 521	● 432 673	● 432 674	● 436 585
R	1.50	4.00	6.00	0.01	● 436 522	● 432 676	● 432 677	● 436 586
R	1.50	4.00	6.00	0.08	● 436 523	● 432 679	● 432 680	● 436 587
R	2.00	4.50	6.00	0.01	● 436 524	● 432 682	● 432 683	● 436 588
R	2.00	4.50	6.00	0.08	● 436 525	● 432 685	● 432 686	● 436 589



SD8-R TD

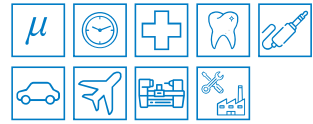
R	1.50	4.00	8.00	0.03	● 436 526	● 432 688	● 432 689	● 436 590
R	1.50	4.00	8.00	0.08	● 436 527	● 432 691	● 432 692	● 436 591
R	2.00	5.00	8.00	0.08	● 436 528	● 432 694	● 432 695	● 436 592
R	2.00	5.00	8.00	0.20	● 436 529	● 432 697	● 432 698	● 436 593
R	2.50	6.00	8.00	0.03	● 436 530	● 432 700	● 432 701	● 436 594
R	2.50	6.00	8.00	0.08	● 436 531	● 432 703	● 432 704	● 436 595
R	2.50	6.00	8.00	0.20	● 436 532	● 432 706	● 432 707	● 436 596

Other dimensions and conditioning of the cutting edge and/or coating are available on request

- Available
- Delivery time: 1 to 3 weeks

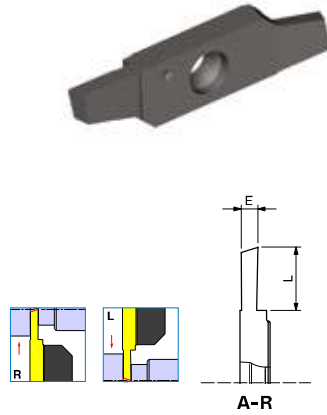
A

Parting



P1	P2	P3	P4	P5	M1	M2	M3	K1	N1	N2	N3
N4	N5	N6	N7	N8	S1	S2	S3	H1	H2		

Roughing >>>
Finishing >>>



A6-L & A6-R

Type	E	L	Uncoated Art. No	D30 Art. No	D60 Art. No	D100 Art. No
L	0.75	2.70	• 437 373		• 381 649	
L	1.00	3.70	• 437 378	• 427 038	• 381 650	
L	1.25	4.70	• 437 380	• 428 649	• 381 651	
L	1.50	5.70	• 437 383	• 426 704	• 404 930	
L	2.00	6.70	• 437 386		• 381 652	
R	0.75	2.70	• 435 886		• 381 654	
R	1.00	3.70	• 435 273	• 427 039	• 381 655	
R	1.25	4.70	• 437 396	• 436 031	• 381 656	
R	1.50	5.70	• 437 398	• 427 040	• 404 934	
R	2.00	6.70	• 435 274		• 381 657	

A8-L & A8-R

L	1.50	8.70	• 374 676	• 427 071	• 374 679	
L	2.00	9.70	• 374 675	• 427 073	• 374 678	
L	2.50	10.70	• 374 674	• 427 075	• 374 677	
R	1.50	8.70	• 374 697	• 427 072	• 374 700	
R	2.00	9.70	• 374 696	• 427 074	• 374 699	
R	2.50	10.70	• 374 695	• 427 076	• 374 698	

A10-R

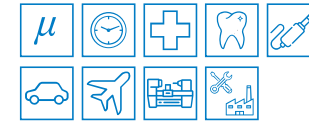
R	1.50	16.00	• 435050	• 432 171	• 432 172	• 436 600
R	2.00	16.00	• 435051	• 432 174	• 432 175	• 436 601
R	2.50	16.00	• 435052	• 432 177	• 432 178	• 436 602
R	3.00	16.00	• 435053	• 432 180	• 432 181	• 436 603
R	3.50	16.00	• 435054	• 432 183	• 432 184	• 436 604

Other dimensions and conditioning of the cutting edge and/or coating are available on request

- Available
- Delivery time: 1 to 3 weeks

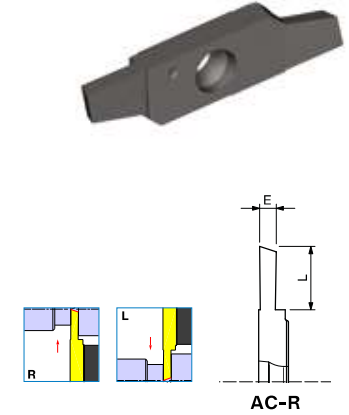
AC

Parting counter spindle



P1	P2	P3	P4	P5	M1	M2	M3	K1	N1	N2	N3
N4	N5	N6	N7	N8	S1	S2	S3	H1	H2		

Roughing >>>
Finishing >>>



A6C-L & A6C-R

Type	E	L	Uncoated Art. No	D30 Art. No	D60 Art. No	D100 Art. No
L	0.75	2.70	• 437 415		• 381 659	
L	1.00	3.70	• 437 419	• 427 045	• 381 660	
L	1.25	4.70	• 437 421	• 428 524	• 381 661	
L	1.50	5.70	• 384 871	• 427 047	• 404 933	
L	2.00	6.70	• 437 425		• 381 662	
R	0.75	2.70	• 437 429		• 381 664	
R	1.00	3.70	• 437 433	• 427 046	• 381 665	
R	1.25	4.70	• 437 435		• 381 666	
R	1.50	5.70	• 437 438	• 427 048	• 404 934	
R	2.00	6.70	• 437 440		• 381 667	

A8C-L & A8C-R

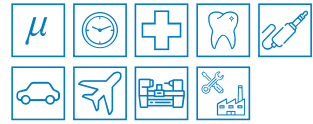
L	1.50	8.70	• 437 443	• 427083	• 377 859	• 436 054
L	2.00	9.70	• 437 444	• 427085	• 377 858	
L	2.50	10.70	• 437 446	• 427087	• 377 857	
R	1.50	8.70	• 437 448	• 427084	• 377 856	
R	2.00	9.70	• 437 450	• 427086	• 377 855	
R	2.50	10.70	• 437 452	• 427088	• 377 854	

Other dimensions and conditioning of the cutting edge and/or coating are available on request

- Available
- Delivery time: 1 to 3 weeks

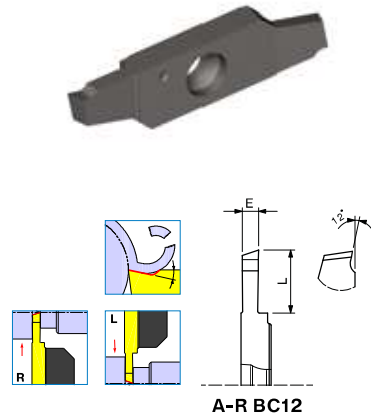
A BC12

Parting with optimized chipbreaker



P1	P2	P3	P4	P5	M1	M2	M3	K1	N1	N2	N3
N4	N5	N6	N7	N8	S1	S2	S3	H1	H2		

Roughing >>>
Finishing >>>



A6-L & A6-R BC12

Type	E	L	Uncoated Art. No	D30 Art. No	D60 Art. No	D100 Art. No	
L	0.75	2.70	• 437 454		• 417 603		
L	1.00	3.70	• 437 457		• 417 604		
L	1.25	4.70	• 437 459		• 417 605		
L	1.50	5.70	• 437 460		• 417 606		
L	2.00	6.70	• 437 461		• 417 607		
R	0.75	2.70	• 437 463		• 417 608		
R	1.00	3.70	• 437 464		• 417 609		
R	1.25	4.70	• 437 465		• 417 610		
R	1.50	5.70	• 437 467		• 417 611		
R	2.00	6.70	• 437 468		• 417 612		

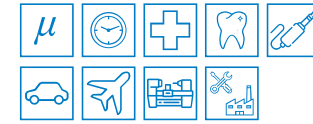
BC12 : Good chip control

Other dimensions and conditioning of the cutting edge and/or coating are available on request

- Available
- Delivery time: 1 to 3 weeks

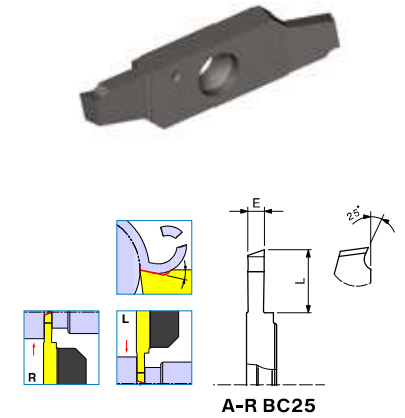
A BC25

Parting with optimized chipbreaker



P1	P2	P3	P4	P5	M1	M2	M3	K1	N1	N2	N3
N4	N5	N6	N7	N8	S1	S2	S3	H1	H2		

Roughing >>>
Finishing >>>



A6-L & A6-R BC25

Type	E	L	Uncoated Art. No	D30 Art. No	D60 Art. No	D100 Art. No	
L	0.75	2.70	• 437 469		• 417 613		
L	1.00	3.70	• 437 470		• 417 614		
L	1.25	4.70	• 437 472		• 417 615		
L	1.50	5.70	• 437 473		• 417 616		
L	2.00	6.70	• 437 474		• 417 617		
R	0.75	2.70	• 437 475		• 417 618		
R	1.00	3.70	• 437 477		• 417 619		
R	1.25	4.70	• 437 478		• 417 620		
R	1.50	5.70	• 437 480		• 417 621		
R	2.00	6.70	• 437 481		• 417 623		

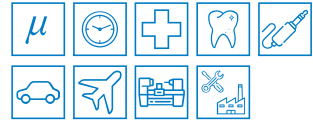
BC25 : For sticky materials with long chips

Other dimensions and conditioning of the cutting edge and/or coating are available on request

- Available
- Delivery time: 1 to 3 weeks

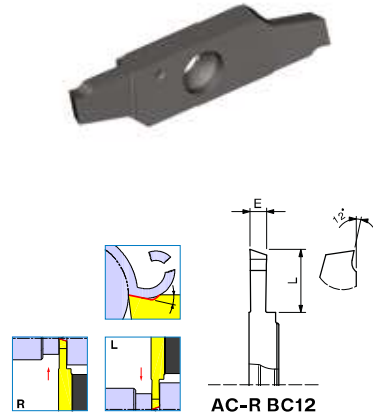
AC BC12

Parting counter spindle with optimized chipbreaker



P1	P2	P3	P4	P5	M1	M2	M3	K1	N1	N2	N3
N4	N5	N6	N7	N8	S1	S2	S3	H1	H2		

Roughing	▶▶
Finishing	▶▶



A6C-L & A6C-R BC12

Type	E	L		Uncoated Art. No	D30 Art. No	D60 Art. No	D100 Art. No	
L	0.75	2.70		• 437 483		• 417 624		
L	1.00	3.70		• 437 484		• 417 625		
L	1.25	4.70		• 437 485		• 417 626		
L	1.50	5.70		• 437 486		• 417 627		
L	2.00	6.70		• 437 487		• 417 628		
R	0.75	2.70		• 437 488		• 417 629		
R	1.00	3.70		• 437 489		• 417 630		
R	1.25	4.70		• 437 490		• 417 631		
R	1.50	5.70		• 437 491		• 417 632		
R	2.00	6.70		• 437 492		• 417 633		

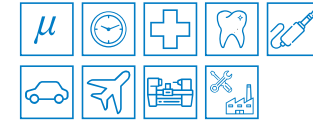
BC12 : Good chip control

Other dimensions and conditioning of the cutting edge and/or coating are available on request

- Available
- Delivery time: 1 to 3 weeks

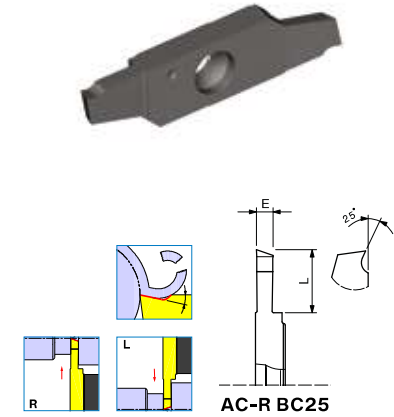
AC BC25

Parting counter spindle with optimized chipbreaker



P1	P2	P3	P4	P5	M1	M2	M3	K1	N1	N2	N3
N4	N5	N6	N7	N8	S1	S2	S3	H1	H2		

Roughing	▶▶
Finishing	▶▶



A6C-L & A6C-R BC25

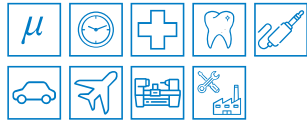
Type	E	L		Uncoated Art. No	D30 Art. No	D60 Art. No	D100 Art. No	
L	0.75	2.70		• 437 493		• 417 634		
L	1.00	3.70		• 437 494		• 417 635		
L	1.25	4.70		• 437 495		• 417 636		
L	1.50	5.70		• 437 496		• 417 637		
L	2.00	6.70		• 437 497		• 417 638		
R	0.75	2.70		• 437 498		• 417 639		
R	1.00	3.70		• 437 499		• 417 640		
R	1.25	4.70		• 437 500		• 417 641		
R	1.50	5.70		• 437 501		• 417 642		
R	2.00	6.70		• 437 502		• 417 643		

BC25 : For sticky materials with long chips

Other dimensions and conditioning of the cutting edge and/or coating are available on request

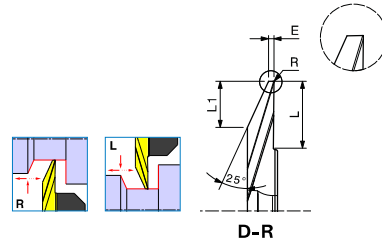
- Available
- Delivery time: 1 to 3 weeks

D Back turning



P1	P2	P3	P4	P5	M1	M2	M3	K1	N1	N2	N3
N4	N5	N6	N7	N8	S1	S2	S3	H1	H2		

Roughing	▶
Finishing	▶▶



D6-L & D6-R

Type	E	L	L1	R	Uncoated Art. No	D30 Art. No	D60 Art. No	D100 Art. No
L	0.50	6.00	4.00	-	• 437 503		• 381 668	
L	0.50	6.00	4.00	0.05	• 437 504		• 389 959	
R	0.50	6.00	4.00	-	• 425 771	• 436 118	• 381 669	• 437 964
R	0.50	6.00	4.00	0.05	• 437 505		• 389 958	• 437 959



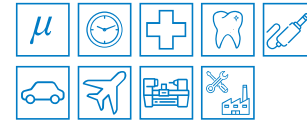
D8-L & D8-R

L	0.50	6.80	5.00	-	• 374 680		• 374 681	• 436 055
L	0.50	6.80	5.00	0.10	• 408 423		• 389 961	
R	0.50	6.80	5.00	-	• 437 506		• 374 702	• 436 064
R	0.50	6.80	5.00	0.10	• 437 507		• 389 960	

Other dimensions and conditioning of the cutting edge and/or coating are available on request

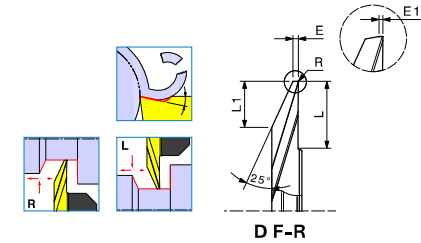
- Available
- Delivery time: 1 to 3 weeks

DF Back turning with optimized chipbreaker



P1	P2	P3	P4	P5	M1	M2	M3	K1	N1	N2	N3
N4	N5	N6	N7	N8	S1	S2	S3	H1	H2		

Roughing	▶
Finishing	▶▶



D6F-L & D6F-R

Type	E	E1	L	L1	R	Uncoated Art. No	D30 Art. No	D60 Art. No	D100 Art. No
L	0.50	0.10	6.00	4.00	-	• 437 508	• 427 051	• 381 670	
L	0.50	0.10	6.00	4.00	0.05	• 437 509		• 390 276	
R	0.50	0.10	6.00	4.00	-	• 435 887	• 427052	• 381 671	• 434 795
R	0.50	0.10	6.00	4.00	0.05	• 437 510		• 390 277	



D8F-L & D8F-R

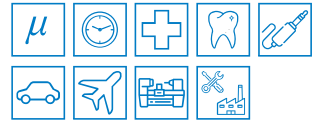
L	0.50	0.10	6.80	5.00	-	• 437 511	• 427 091	• 379666	
L	0.50	0.10	6.80	5.00	0.05	• 408 424		• 390278	
R	0.50	0.10	6.80	5.00	-	• 396 261	• 427 092	• 377 851	
R	0.50	0.10	6.80	5.00	0.05	• 437 512		• 390 279	

Other dimensions and conditioning of the cutting edge and/or coating are available on request

- Available
- Delivery time: 1 to 3 weeks

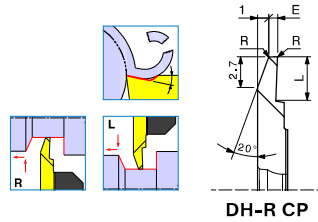
DH CP

Back turning
with optimized chipbreaker



P1	P2	P3	P4	P5	M1	M2	M3	K1	N1	N2	N3
N4	N5	N6	N7	N8	S1	S2	S3	H1	H2		

Roughing	▶▶
Finishing	▶▶▶



DH-R CP

DH6-R CP

Type	E	L	R	Uncoated Art. No	D30 Art. No	D60 Art. No	D100 Art. No
R	0.50	3.00	-	• 436 542	• 431 793	• 431 794	• 436 560
R	0.50	3.00	0,08	• 436 543	• 431 796	• 431 797	• 436 561
R	0.80	4.00	-	• 436 544	• 431 799	• 431 800	• 436 562
R	1.00	4.00	-	• 436 545	• 431 802	• 431 803	• 436 563
R	1.20	5.00	-	• 436 546	• 431 805	• 431 806	• 436 564

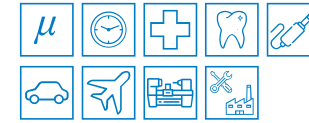


Other dimensions and conditioning of the cutting edge and/or coating are available on request

- Available
- Delivery time: 1 to 3 weeks

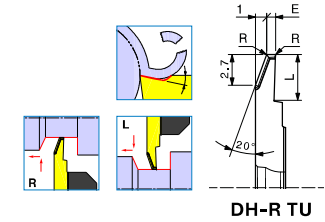
DH TU

Back turning
with optimized chipbreaker



P1	P2	P3	P4	P5	M1	M2	M3	K1	N1	N2	N3
N4	N5	N6	N7	N8	S1	S2	S3	H1	H2		

Roughing	▶▶▶
Finishing	▶



DH-R TU

DH6-R TU

Type	E	L	R	Uncoated Art. No	D30 Art. No	D60 Art. No	D100 Art. No
R	1.00	4.00	-	• 436 613	• 436 605	• 436 606	• 436 608
R	1.00	4.00	0,08	• 436 614	• 436 609	• 436 610	• 436 612

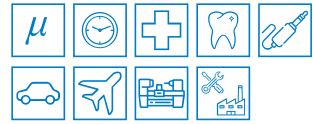


Other dimensions and conditioning of the cutting edge and/or coating are available on request

- Available
- Delivery time: 1 to 3 weeks

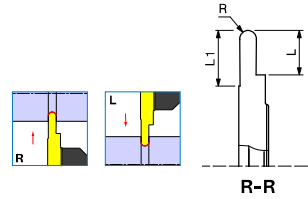
R

Radius grooving



P1	P2	P3	P4	P5	M1	M2	M3	K1	N1	N2	N3
N4	N5	N6	N7	N8	S1	S2	S3	H1	H2		

Roughing	▶▶
Finishing	▶▶



R6-L & R6-R

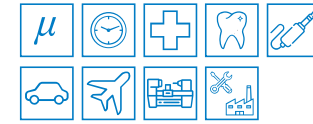
Type	L	L1	R	Uncoated Art. No	D30 Art. No	D60 Art. No	D100 Art. No
L	2.00	3.00	0.25	• 437 513		• 395 910	
L	3.00	4.00	0.50	• 437 514		• 395 911	
L	3.00	4.00	0.60	• 437 515		• 395 912	
L	4.00	5.00	0.75	• 437 516		• 395 913	
L	4.00	5.00	0.80	• 437 517		• 395 914	
L	5.00	6.00	1.00	• 437 518		• 395 915	
R	2.00	3.00	0.25	• 437 519		• 395 900	
R	3.00	4.00	0.50	• 437 520		• 395 901	
R	3.00	4.00	0.60	• 437 521		• 395 902	
R	4.00	5.00	0.75	• 437 522		• 395 903	
R	4.00	5.00	0.80	• 437 523		• 395 904	
R	5.00	6.00	1.00	• 437 524		• 395 905	

Other dimensions and conditioning of the cutting edge and/or coating are available on request

- Available
- Delivery time: 1 to 3 weeks

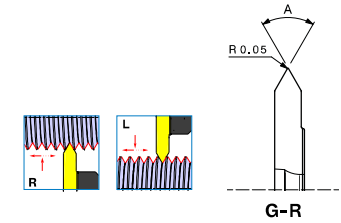
G

Threading



P1	P2	P3	P4	P5	M1	M2	M3	K1	N1	N2	N3
N4	N5	N6	N7	N8	S1	S2	S3	H1	H2		

Roughing	▶▶
Finishing	▶▶



G6-L & G6-R

Type	A	Uncoated Art. No	D30 Art. No	D60 Art. No	D100 Art. No
L	55°	• 437 525		• 381 672	
L	60°	• 437 526		• 381 673	
R	55°	• 437 527		• 381 674	
R	60°	• 437 528		• 381 675	

for threads > M4 and G1/8"

Type	A	Uncoated Art. No	D30 Art. No	D60 Art. No	D100 Art. No
L	55°	• 437 529		• 374 688	
L	60°	• 437 530		• 374 687	
R	55°	• 437 531		• 374 706	
R	60°	• 437 532		• 374 705	

for threads > M4 and G1/8"

Other dimensions and conditioning of the cutting edge and/or coating are available on request

- Available
- Delivery time: 1 to 3 weeks

TURNDEC FINECUT

Precision Turning Tools
for Microtechnology



- ▶ Tool-center height accuracy of +/- 0.005 mm
- ▶ Optimized geometry with sharp cutting edge
- ▶ Extremely stable fixation of the insert on the support
- ▶ **TURNDEC** – custom-made inserts
E6Sy

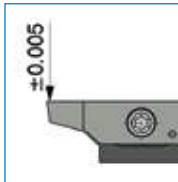
FEATURES

Discover the strengths of our tools for microtechnology



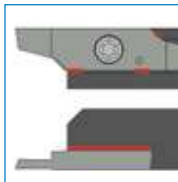
Cutting edge recovery after coating

Rectified design after coating to guarantee an ultra-sharp cutting edge.



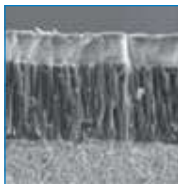
Repeatability of the process

All our inserts are ground and guarantee continuity of the process without interruption.



1 screw, 3 support points... perfect rigidity

Our single-screw fastening system allows you to quickly change the insert and use it even if a sharp part breaks off.



Very high-quality carbide insert

The combination of a top high quality cemented carbides with a special coating, which are optimized for your needs, increases the service life of the tools for your applications

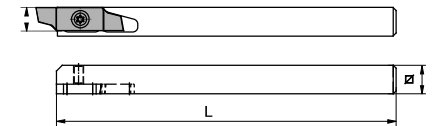


Quality of cutting sharpness

Thanks to our expertise in the development and production of abrasive tools, we have a perfect mastery of grinding the cutting edges of our tools.

TURNDEC FINECUT

Precision toolholder



TUHAL6 mini Toolholder for cam machines

Type	Ø x L	Art. No
L	7 × 7 × 110	• 381 932
L	8 × 8 × 110	• 378 819
L	10 × 10 × 120	• 378 813
L	12 × 12 × 120	• 378 814

TUHAL6 mini Toolholder for CNC machines

Type	Ø x L	Art. No
R	7 × 7 × 110	• 381 933
R	8 × 8 × 110	• 378 820
R	10 × 10 × 120	• 378 816
R	12 × 12 × 120	• 378 817
R	16 × 16 × 120	• 404 104

TORX Screw

Type	Art. No
TP 7 M 2.5 × 6.5	• 381 683

Screwdriver

Type	Art. No
TP 7	• 436 799



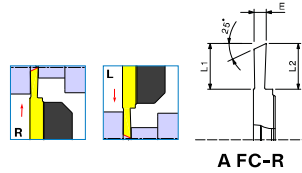
- Available
- Delivery time: 1 to 3 weeks

A FC Parting



P1	P2	P3	P4	P5	M1	M2	M3	K1	N1	N2	N3
N4	N5	N6	N7	N8	S1	S2	S3	H1	H2		

Roughing	
Finishing	▶▶



A6FC-R & A6FC-L – Fully coated

Type	E	L1	L2	Uncoated Art. No	D30 Art. No	D60 Art. No	D100 Art. No
R	0.80	4.0	3.0	437 533	426 962	426 965	
R	1.00	4.0	3.0	437 534	426 963	426 966	
R	1.20	4.0	3.0	437 535	426 964	426 967	
L	0.80	4.0	3.0	437 536	426 902	426 905	
L	1.00	4.0	3.0	437 537	426 903	426 906	
L	1.20	4.0	3.0	437 538	426 904	426 907	

R = CNC machine
L = Automatic cam-controlled lathe

A6FC-R & A6FC-L – Ground clearance angle



Type	E	L1	L2	Uncoated Art. No	D30 Art. No	D60 Art. No	D100 Art. No
R	0.80	4.0	3.0	437 539	426 968	426 971	
R	1.00	4.0	3.0	437 540	426 969	426 972	
R	1.20	4.0	3.0	437 541	426 970	426 973	
L	0.80	4.0	3.0	437 542	426 908	426 911	
L	1.00	4.0	3.0	437 543	426 909	426 912	
L	1.20	4.0	3.0	437 544	426 910	426 913	

R = CNC machine
L = Automatic cam-controlled lathe

Both ground clearance angles on request.
Other dimensions and conditioning of the cutting edge and/or coating are available on request

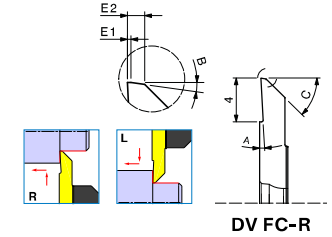
- Available
- Delivery time: 1 to 3 weeks

DV FC Front turning



P1	P2	P3	P4	P5	M1	M2	M3	K1	N1	N2	N3
N4	N5	N6	N7	N8	S1	S2	S3	H1	H2		

Roughing	▶▶
Finishing	▶▶



DV6FC-R & DV6FC-L – Fully coated

Type	E1	E2	A	B	C	Uncoated Art. No	D30 Art. No	D60 Art. No	D100 Art. No
R	0.03	-	3°	-	45°	437 545	426 974	426 978	
R	0.10	-	3°	-	45°	437 546	426 975	426 979	
R	0.03	0.10	3°	8°	45°	437 547	426 976	426 980	
R	0.10	0.50	3°	8°	45°	437 548	426 977	426 981	
L	0.03	-	3°	-	45°	437 549	426 914	426 918	
L	0.10	-	3°	-	45°	437 550	426 915	426 919	
L	0.03	0.10	3°	8°	45°	437 551	426 916	426 920	
L	0.10	0.50	3°	8°	45°	437 552	426 917	426 921	

R = CNC machine
L = Automatic cam-controlled lathe

DV6FC-R & DV6FC-L – Ground clearance angle



Type	E1	E2	A	B	C	Uncoated Art. No	D30 Art. No	D60 Art. No	D100 Art. No
R	0.03	-	3°	-	45°	437 553	426 982	426 986	
R	0.10	-	3°	-	45°	437 554	426 983	426 987	
R	0.03	0.10	3°	8°	45°	437 555	426 984	426 988	
R	0.10	0.50	3°	8°	45°	437 556	426 985	426 989	
L	0.03	-	3°	-	45°	437 557	426 922	426 926	
L	0.10	-	3°	-	45°	437 558	426 923	426 927	
L	0.03	0.10	3°	8°	45°	437 559	426 924	426 928	
L	0.10	0.50	3°	8°	45°	437 657	426 925	426 929	

R = CNC machine
L = Automatic cam-controlled lathe

Both ground clearance angles on request.
Other dimensions and conditioning of the cutting edge and/or coating are available on request

- Available
- Delivery time: 1 to 3 weeks

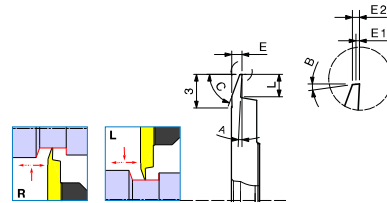
DH-R FC

Back turning



P1	P2	P3	P4	P5	M1	M2	M3	K1	N1	N2	N3
N4	N5	N6	N7	N8	S1	S2	S3	H1	H2		

Roughing	>>>
Finishing	>>>



DH-R FC

DH6FC-R – Fully coated

Type	E	E1	E2	A	B	C	L	Uncoated Art. No	D30 Art. No	D60 Art. No	D100 Art. No
R	0.80	0.10	-	3°	-	45°	2.20	437 560	426 990	426 998	
R	0.80	0.03	-	3°	-	70°	2.20	437 561	426 991	426 999	
R	0.80	0.10	-	3°	-	70°	2.20	437 562	426 992	427 000	
R	0.80	0.03	0.10	3°	8°	70°	2.20	437 563	426 993	427 001	
R	1.00	0.10	-	3°	-	45°	2.70	437 564	426 994	427 002	
R	1.00	0.03	-	3°	-	70°	2.70	437 565	426 995	427 003	
R	1.00	0.10	-	3°	-	70°	2.70	437 566	426 996	427 004	
R	1.00	0.03	0.10	3°	8°	70°	2.70	437 567	426 997	427 005	

R = CNC machine

DH6FC-R – Ground clearance angle

Type	E	E1	E2	A	B	C	L	Uncoated Art. No	D30 Art. No	D60 Art. No	D100 Art. No
R	0.80	0.10	-	3°	-	45°	2.20	437 568	427 006	427 014	
R	0.80	0.03	-	3°	-	70°	2.20	437 569	427 007	427 015	
R	0.80	0.10	-	3°	-	70°	2.20	437 570	427 008	427 016	
R	0.80	0.03	0.10	3°	8°	70°	2.20	437 571	427 009	427 017	
R	1.00	0.10	-	3°	-	45°	2.70	437 572	427 010	427 018	
R	1.00	0.03	-	3°	-	70°	2.70	437 573	427 011	427 019	
R	1.00	0.10	-	3°	-	70°	2.70	437 574	427 012	427 020	
R	1.00	0.03	0.10	3°	8°	70°	2.70	428 493	427 013	427 021	

R = CNC machine

Both ground clearance angles on request.
Other dimensions and conditioning of the cutting edge and/or coating are available on request



- Available
- Delivery time: 1 to 3 weeks

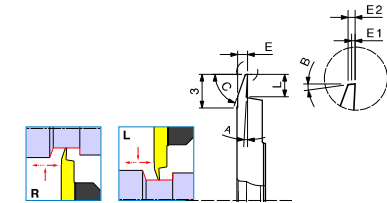
DH-L FC

Back turning



P1	P2	P3	P4	P5	M1	M2	M3	K1	N1	N2	N3
N4	N5	N6	N7	N8	S1	S2	S3	H1	H2		

Roughing	>>>
Finishing	>>>



DH-L FC

DH6FC-L – Fully coated

Type	E	E1	E2	A	B	C	L	Uncoated Art. No	D30 Art. No	D60 Art. No	D100 Art. No
L	0.80	0.10	-	3°	-	45°	2.20	437 575	426 930	426 938	
L	0.80	0.03	-	3°	-	70°	2.20	437 576	426 931	426 939	
L	0.80	0.10	-	3°	-	70°	2.20	437 577	426 932	426 940	
L	0.80	0.03	0.10	3°	8°	70°	2.20	437 578	426 933	426 941	
L	1.00	0.10	-	3°	-	45°	2.70	437 579	426 934	426 942	
L	1.00	0.03	-	3°	-	70°	2.70	437 580	426 935	426 943	
L	1.00	0.10	-	3°	-	70°	2.70	437 581	426 936	426 944	
L	1.00	0.03	0.10	3°	8°	70°	2.70	437 582	426 937	426 945	

L = Automatic cam-controlled lathe

DH6FC-L – Ground clearance angle

Type	E	E1	E2	A	B	C	L	Uncoated Art. No	D30 Art. No	D60 Art. No	D100 Art. No
L	0.80	0.10	-	3°	-	45°	2.20	437 583	426 946	426 954	
L	0.80	0.03	-	3°	-	70°	2.20	437 843	426 947	426 955	
L	0.80	0.10	-	3°	-	70°	2.20	437 585	426 948	426 956	
L	0.80	0.03	0.10	3°	8°	70°	2.20	437 586	426 949	426 957	
L	1.00	0.10	-	3°	-	45°	2.70	437 587	426 950	426 958	
L	1.00	0.03	-	3°	-	70°	2.70	437 588	426 951	426 959	
L	1.00	0.10	-	3°	-	70°	2.70	437 589	426 952	426 960	
L	1.00	0.03	0.10	3°	8°	70°	2.70	437 844	426 953	426 961	

L = Automatic cam-controlled lathe

Both ground clearance angles on request.
Other dimensions and conditioning of the cutting edge and/or coating are available on request



- Available
- Delivery time: 1 to 3 weeks

SV FC
Front grooving

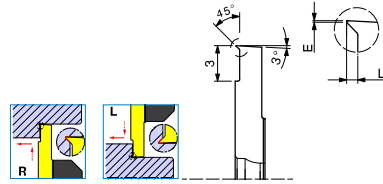


NEW



P1	P2	P3	P4	P5	M1	M2	M3	K1	N1	N2	N3
N4	N5	N6	N7	N8	S1	S2	S3	H1	H2		

Roughing	
Finishing	▶▶



SV-R FC

SV6FC-R

Type	E	L	Uncoated Art. No	D30 Art. No	D60 Art. No	D100 Art. No	
R	0.03	0.20	● 436 497	● 431 711	● 431 755	● 436 547	
R	0.05	0.30	● 436 498	● 431 757	● 431 758	● 436 548	

R = CNC machine

Both ground clearance angles on request.
Other dimensions and conditioning of the cutting edge and/or coating are available on request

- Available
- Delivery time: 1 to 3 weeks

SH FC
Back grooving

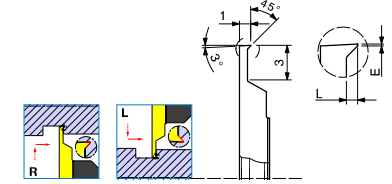


NEW



P1	P2	P3	P4	P5	M1	M2	M3	K1	N1	N2	N3
N4	N5	N6	N7	N8	S1	S2	S3	H1	H2		

Roughing	
Finishing	▶▶



SH-R FC

SH6FC-R

Type	E	L	Uncoated Art. No	D30 Art. No	D60 Art. No	D100 Art. No	
R	0.03	0.20	● 436 499	● 431 760	● 431 761	● 436 549	
R	0.05	0.30	● 436 500	● 431 763	● 431 764	● 436 550	

R = CNC machine

Both ground clearance angles on request.
Other dimensions and conditioning of the cutting edge and/or coating are available on request

- Available
- Delivery time: 1 to 3 weeks

OUR SERVICES

To improve your productivity



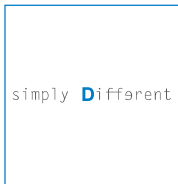
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- ▶ Education, training and technical assistance to the clients
- ▶ Application development, database processing and extensive testings for the clients
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simply **D**ifferent

TURNDEC
EASY

Request Order

▶ Customer data :

Customer : _____ Contact : _____

Location : _____ Date : _____

▶ Type of machine :

▶ Toolholder :

_____ X _____

▶ Material :

No : _____

Designation : _____

▶ Coated :

D30 D60 D100

Others

Designation : _____

If no information, we will choose the right coating for you.

▶ Execution :

Right Left

▶ Size :

Turndec 6 mini

Turndec 8

Turndec 10

▶ Draw the desired geometry :

▶ Number of inserts :

▶ Number of toolholder :

▶ Customer's signature :

Return the form by mail to the following address: DIAMETAL Group, Solothurnstrasse 136, 2504 Biel/Bienne or by E-mail at sales@diametal.com

DIAMETAL DIAMOND

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Our notorious expertise in the manufacture of tools in natural diamond (monocrystalline), synthetic and synthetic diamond (polycrystalline - PCD or CVD) and PCBN covers a wide range of machining applications. Our tools stand out, among others, in the production of the most delicate components, as well as in the machining of state-of-the-art parts required in the aerospace industry.

DIAMETAL Diamond is committed to working closely with its customers to meet all their diamond tooling needs. Our ability to offer specialized tools is unbeatable by any other manufacturer in the world. Therefore, whether it's diamond milling cutters which are essential for micromachining, or configurations specifically adapted to unprecedented applications, our expertise becomes your advantage.

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Our tools are suitable for the following industrial tasks:

- ▶ Turning Guillochage
- ▶ Drilling
- ▶ Cutting
- ▶ Turning and general machining processes



simply Different

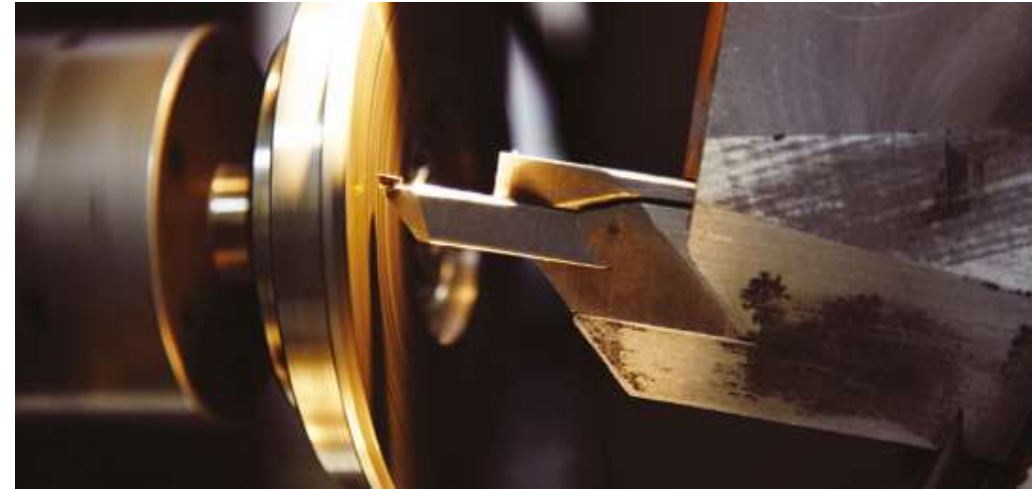
DIAMETAL

Swiss Cutting Tool

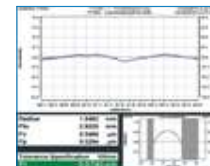
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CH 2504 Biel/Bienne
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Fax +41 32 344 33 44
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PROFILOMETER

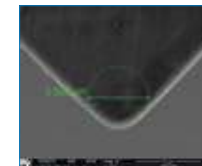


Resolution
0,2 nm

Accuracy
2,0 nm Pt

Inspection capacity
100 tools per day

ELECTRON MICROSCOPE

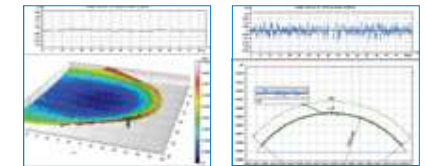


Optical resolution
3 nm

Inspection capacity
20 - 30 tools per day

Magnification
150 000 times

INTERFEROMETER - CORRELATION AND CONSISTENCY



Measuring range
40 mm

Resolution
0,1 nm

Inspection capacity
> 50 tools per day

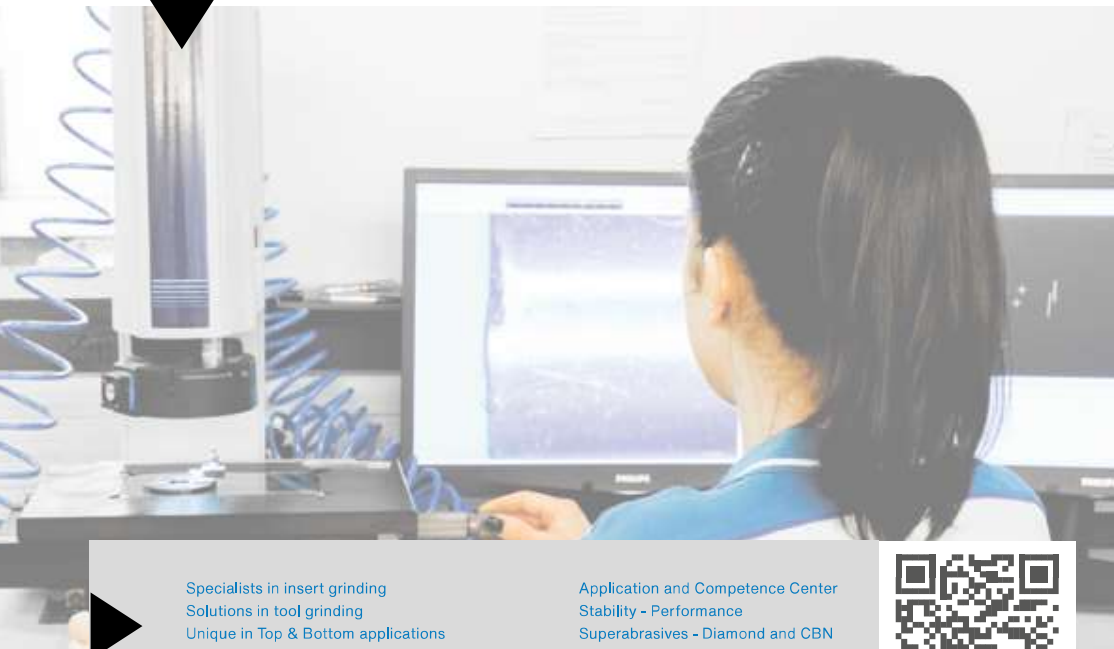
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Abrasifs



Abrasifs

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and best materials



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