

GROOVE-TURN

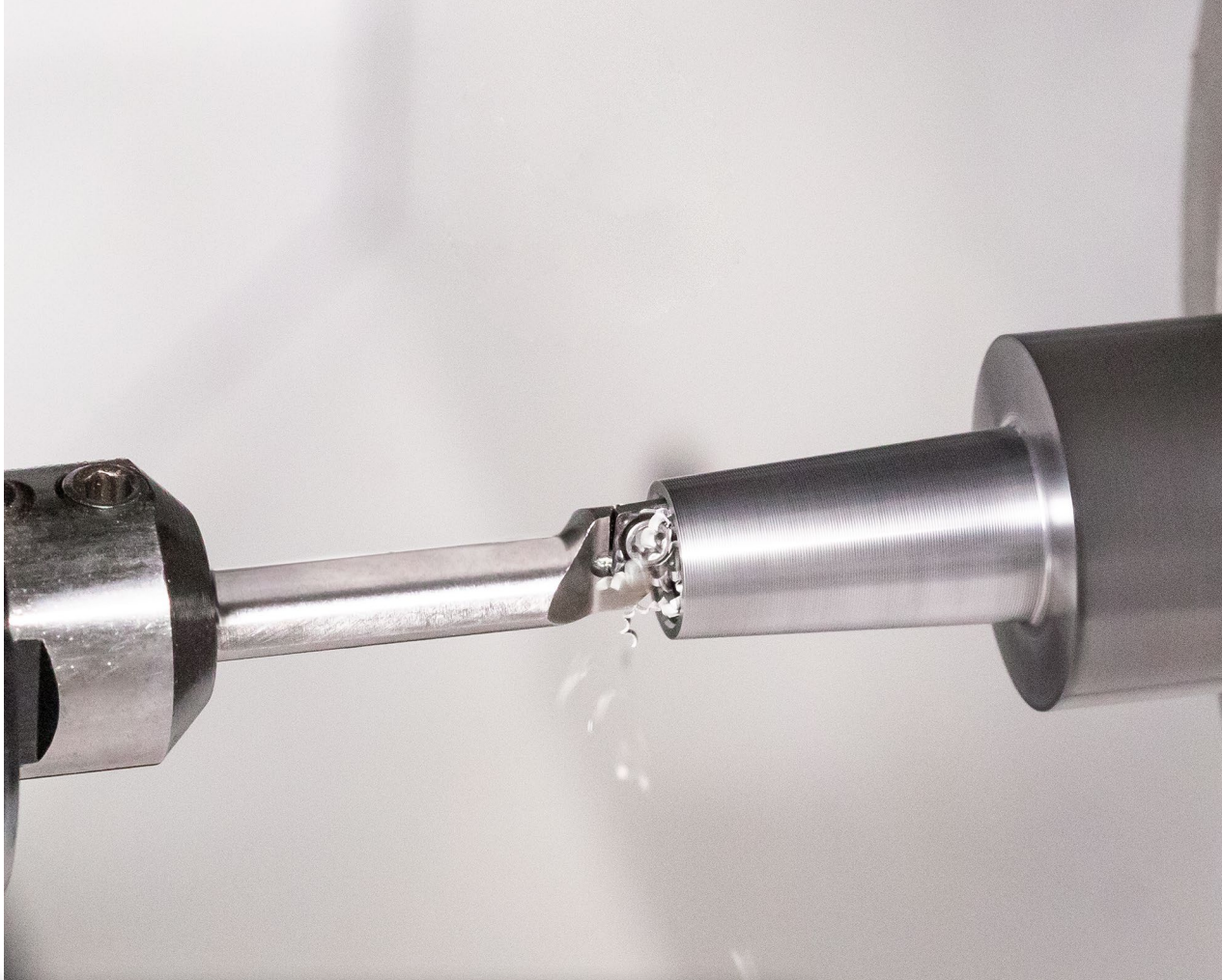
22-2024

MAY 2024

METRIC

# NPA

New Product Announcement



Small Diameter



Cost Effective Inserts



High Productivity Inserts



## **PICCOINDEX**

INDEXABLE INSERTS

# New PICCO Boring Bars with Indexable Inserts



Small Diameter



Cost Effective Inserts



High Productivity Inserts

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**PICCOINDEX**  
INDEXABLE INSERTS

## Highlights

**Introducing the Latest Range of PICCO Boring Bars, Specifically Engineered for Securely Clamping Compact Indexable Inserts to Optimize Internal Machining**

ISCAR is expanding its product range for the miniature industry by introducing a new line of solid carbide and steel PICCO boring bars. These bars are tailored for small indexable ISO inserts.

The new PICCO-INDEX boring bars can be clamped on PICCO / MG PCO (PASSCUT), PICCO ACE (ACECUT) holders.



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## PICCOINDEX

INDEXABLE INSERTS

### Features

- Clamping CCGT/CCGW 03 inserts for turning / boring applications with  $\varnothing 4.5$  /  $\varnothing 6$ mm minimum bore diameter.
- Clamping WBMT/WBGT 06 type inserts for turning / boring applications with  $\varnothing 6.5$ mm minimum bore diameter.
- Clamping 06IR/IL inserts for threading applications with  $\varnothing 7.3$ mm minimum bore diameter.
- Internal coolant directed to the cutting zone.
- Designations – PICIN...

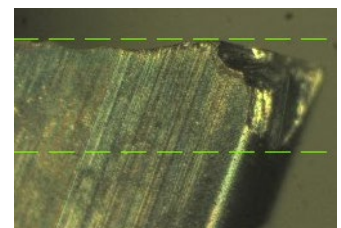
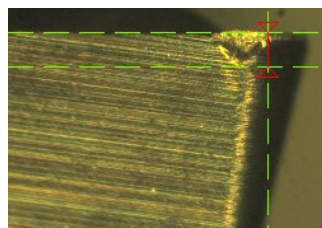
### Advantages

- Suitable for rough, semi-finishing and finishing operations of small parts.
- Excellent chip control even under low cutting conditions.
- Very economical solution compared to traditional PICCO inserts.

### TEST REPORTS

**Application:** Turning  
**Part Material:** SAE 4340  
**Bore Diameter:** 6mm  
**Coolant Pressure:** 10Bar

|                          | PICCOINDEX            | PICCOCUT               |
|--------------------------|-----------------------|------------------------|
| Toolholder               | PICCO ACE 16-6        | PICCO ACE 16-6         |
| Boring Bar               | PICIN 06-T25-SCLCR-03 | -                      |
| Insert                   | CCGT 03X102-F1P IC908 | PICCO R 050.6-25 IC908 |
| Cutting Speed Vc (m/min) | 90                    | 90                     |
| Feed (mm/rev)            | 0.05                  | 0.05                   |
| Depth of Cut ap (mm)     | 0.2                   | 0.2                    |
| Tool Life (min)          | 28                    | 28                     |
| Chip Type                | Excellent             | Long and tangled       |
| Wear Type                | Flank wear            | Edge break             |


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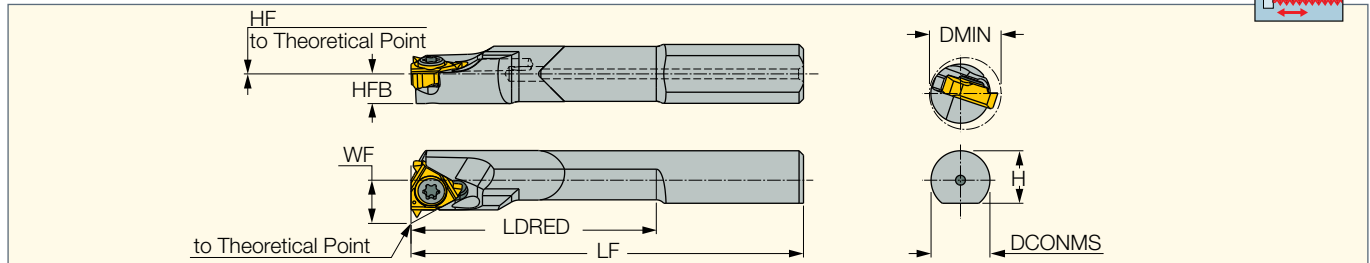
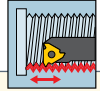
### PICCOINDEX

INDEXABLE INSERTS

#### PICIN-MGSIR/L

Solid Carbide PICCO Tools Carrying Internal Laydown Threading Inserts

<https://www.iscar.com/eCatalog/Family.aspx?fnum=4676&mapp=TH&GFSTYP=M&srch=1>



| Designation            | DCONMS | LF    | LDRED | H   | HFB | WF   | DMIN | HF  | CSP <sup>(1)</sup> | MIID <sup>(2)</sup> |           |       |
|------------------------|--------|-------|-------|-----|-----|------|------|-----|--------------------|---------------------|-----------|-------|
| PICIN E06-T25-MGSIL-06 | 6.00   | 40.00 | 25.0  | 5.4 | 3.0 | 4.41 | 7.30 | 0.0 | 1                  | 06IL A 55           | SR 14-552 | T-6/5 |
| PICIN E06-T25-MGSIR-06 | 6.00   | 40.00 | 25.0  | 5.4 | 3.0 | 4.41 | 7.30 | 0.0 | 1                  | 06IR A 55           | SR 14-552 | T-6/5 |

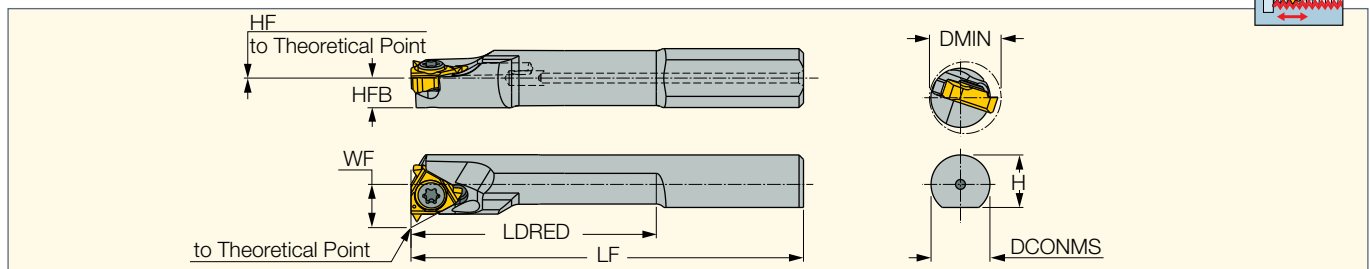
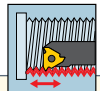
- B-steel shank with coolant hole, CB-carbide shank with coolant hole
- All toolholders provide 1.5° helix angle, either via the pocket or the anvil supplied
- For GTGA inserts, use anvil AL 16-0

<sup>(1)</sup> 0 - Without coolant supply, 1 - With coolant supply

<sup>(2)</sup> Master insert identification

#### PICIN-A-SIR/L

PICCO Tools on which Internal Laydown Threading Inserts are mounted



| Designation            | DCONMS | LF    | LDRED | H   | HFB | WF   | DMIN | HF  | CSP <sup>(1)</sup> | MIID <sup>(2)</sup> |           |       |
|------------------------|--------|-------|-------|-----|-----|------|------|-----|--------------------|---------------------|-----------|-------|
| PICIN A06-T15-SIR-06   | 6.00   | 30.00 | 15.0  | 5.4 | 3.0 | 4.41 | 7.30 | 0.1 | 1                  | 06IL A 55           | SR 14-552 | T-6/5 |
| PICIN A06-T25-SIR/L-06 | 6.00   | 40.00 | 25.0  | 5.4 | 3.0 | 4.41 | 7.30 | 0.1 | 1                  | 06IL/R A 55         | SR 14-552 | T-6/5 |

- B-steel shank with coolant hole, CB-carbide shank with coolant hole
- All toolholders provide 1.5° helix angle, either via the pocket or the anvil supplied
- For GTGA inserts, use anvil AL 16-0

<sup>(1)</sup> 0 - Without coolant supply, 1 - With coolant supply

<sup>(2)</sup> Master insert identification

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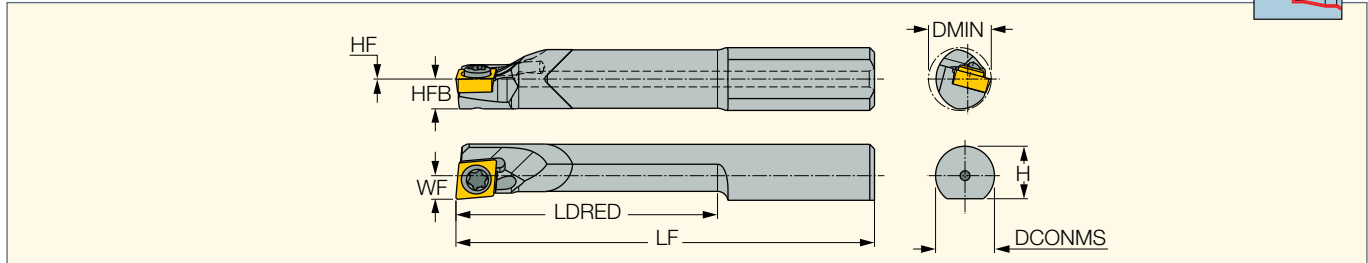
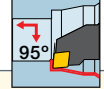
### PICCOINDEX

INDEXABLE INSERTS

#### PICIN-SCLCR/L

Solid Carbide PICCO Tools Carrying 80° Rhombic Inserts

<https://www.iscar.com/eCatalog/Family.aspx?fnun=4675&mapp=IS&GFSTYP=M&srch=1>



| Designation              | DCONMS | DMIN | LDRED | LF    | WF   | H   | HF  | HFB | CSP <sup>(1)</sup> | MIID <sup>(2)</sup> |
|--------------------------|--------|------|-------|-------|------|-----|-----|-----|--------------------|---------------------|
| PICIN E05-T20-SCLCR/L-03 | 5.00   | 4.50 | 20.0  | 35.00 | 1.85 | 4.5 | 0.0 | 2.1 | 1                  | CCGT 03X101-F1P     |
| PICIN E05-T30-SCLCR/L-03 | 5.00   | 4.50 | 30.0  | 45.00 | 1.85 | 4.5 | 0.0 | 2.1 | 1                  | CCGT 03X101-F1P     |
| PICIN E06-T25-SCLCR/L-03 | 6.00   | 6.00 | 25.0  | 40.00 | 2.25 | 5.4 | 0.0 | 2.9 | 1                  | CCGT 03X101-F1P     |
| PICIN E06-T35-SCLCR/L-03 | 6.00   | 6.00 | 35.0  | 50.00 | 2.25 | 5.4 | 0.0 | 2.9 | 1                  | CCGT 03X101-F1P     |

<sup>(1)</sup> 0 - Without coolant supply, 1 - With coolant supply

<sup>(2)</sup> Master insert identification

#### Spare Parts

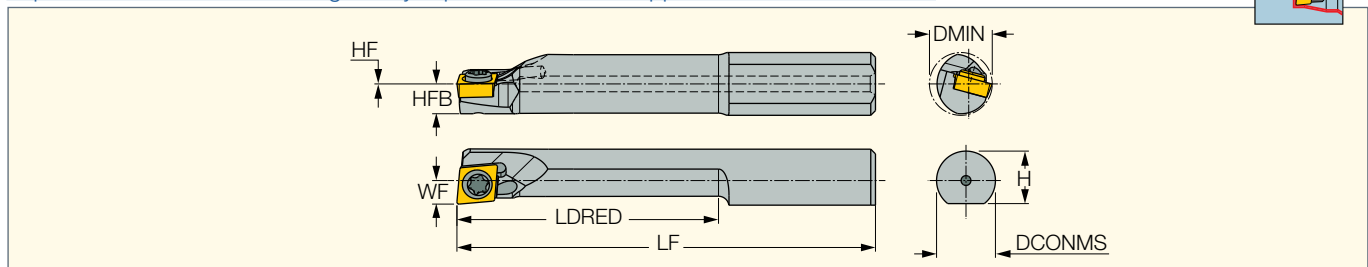
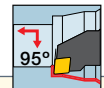


| Designation   | Screw    | Key   |
|---------------|----------|-------|
| PICIN-SCLCR/L | CSTA-1.6 | T-6/5 |

#### PICIN-A-SCLCR/L

PICCO Tools on which 80° Rhombic Inserts are Mounted

<https://www.iscar.com/eCatalog/Family.aspx?fnun=5168&mapp=IS&GFSTYP=M&srch=1>



| Designation              | DCONMS | LF    | LDRED | H   | HFB | WF   | DMIN | HF  | CSP <sup>(1)</sup> | MIID <sup>(2)</sup> |
|--------------------------|--------|-------|-------|-----|-----|------|------|-----|--------------------|---------------------|
| PICIN A05-T10-SCLCR/L-03 | 5.00   | 25.00 | 10.0  | 4.5 | 2.1 | 1.85 | 4.50 | 0.0 | 1                  | CCGT 03X101-F1P     |
| PICIN A05-T20-SCLCR/L-03 | 5.00   | 35.00 | 20.0  | 4.5 | 2.1 | 1.85 | 4.50 | 0.0 | 1                  | CCGT 03X101-F1P     |
| PICIN A06-T15-SCLCR/L-03 | 6.00   | 30.00 | 15.0  | 5.4 | 2.9 | 2.25 | 6.00 | 0.0 | 1                  | CCGT 03X101-F1P     |
| PICIN A06-T25-SCLCR/L-03 | 6.00   | 40.00 | 25.0  | 5.4 | 2.9 | 2.25 | 6.00 | 0.0 | 1                  | CCGT 03X101-F1P     |

<sup>(1)</sup> 0 - Without coolant supply, 1 - With coolant supply

<sup>(2)</sup> Master insert identification

#### Spare Parts



| Designation     | Screw    | Key   |
|-----------------|----------|-------|
| PICIN-A-SCLCR/L | CSTA-1.6 | T-6/5 |

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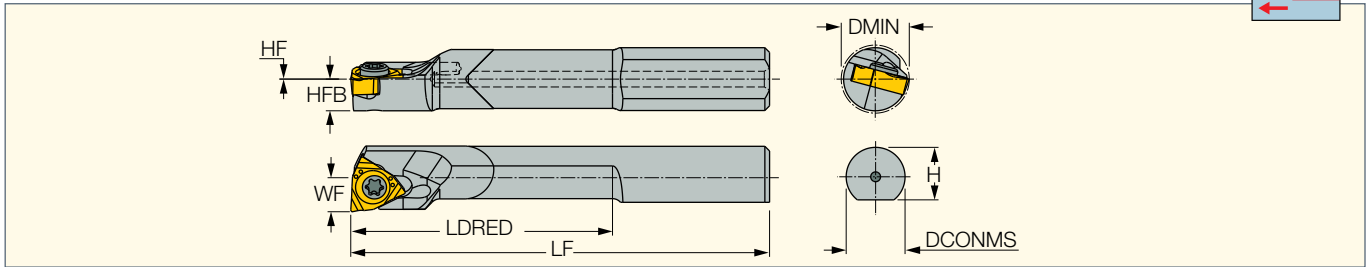
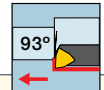
METRIC

**PICCOINDEX**  
INDEXABLE INSERTS

### PICIN-SWUBR/L

Solid Carbide PICCO Tools Carrying Small WBMT/WBGT Trigon Inserts

<https://www.iscar.com/eCatalog/Family.aspx?fnum=4677&mapp=IS&GFSTYP=M&srch=1>



| Designation            | DCONMS | DMIN | LDRED | LF    | WF   | H   | HF  | HFB | CSP <sup>(1)</sup> | MIID <sup>(2)</sup> |           |       |
|------------------------|--------|------|-------|-------|------|-----|-----|-----|--------------------|---------------------|-----------|-------|
| PICIN E06-T25-SWUBL-06 | 6.00   | 6.50 | 25.0  | 40.00 | 3.25 | 5.4 | 0.0 | 3.0 | 1                  | WBMT 060101R        | SR 14-552 | T-6/5 |
| PICIN E06-T25-SWUBR-06 | 6.00   | 6.50 | 25.0  | 40.00 | 3.25 | 5.4 | 0.0 | 3.0 | 1                  | WBMT 060101L        |           |       |
| PICIN E06-T35-SWUBL-06 | 6.00   | 6.50 | 35.0  | 50.00 | 3.25 | 5.4 | 0.0 | 3.0 | 1                  | WBMT 060101R        | SR 14-552 | T-6/5 |
| PICIN E06-T35-SWUBR-06 | 6.00   | 6.50 | 35.0  | 50.00 | 3.25 | 5.4 | 0.0 | 3.0 | 1                  | WBMT 060101L        |           |       |

• Use right-hand WBMT 06...R inserts on left-hand tools and left-hand WBMT 06...L inserts on right-hand tools.

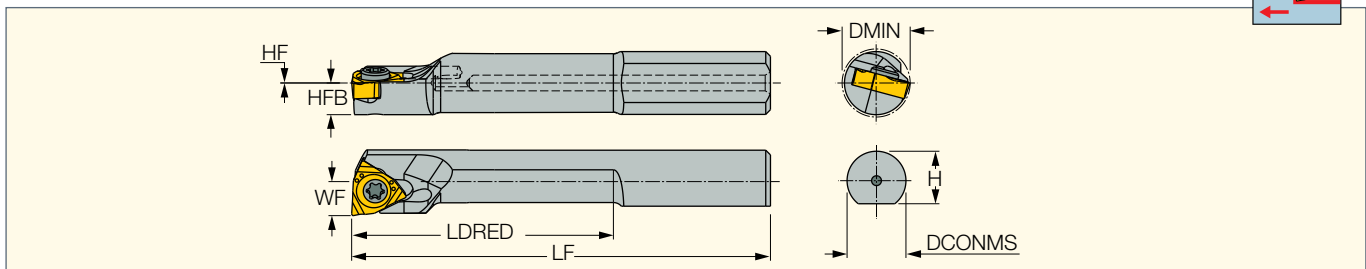
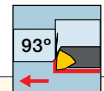
<sup>(1)</sup> 0 - Without coolant supply, 1 - With coolant supply

<sup>(2)</sup> Master insert identification

### PICIN-A-SWUBR/L

PICCO Tools on which Small WBMT/WBGT Trigon Inserts are mounted

<https://www.iscar.com/eCatalog/Family.aspx?fnum=5170&mapp=IS&GFSTYP=M&srch=1>



| Designation            | DCONMS | LF    | LDRED | H   | HFB | WF   | DMIN | HF  | CSP <sup>(1)</sup> | MIID <sup>(2)</sup> |           |       |
|------------------------|--------|-------|-------|-----|-----|------|------|-----|--------------------|---------------------|-----------|-------|
| PICIN A06-T15-SWUBL-06 | 6.00   | 30.00 | 15.0  | 5.4 | 3.0 | 3.25 | 6.50 | 0.0 | 1                  | WBMT 060101R        | SR 14-552 | T-6/5 |
| PICIN A06-T15-SWUBR-06 | 6.00   | 30.00 | 15.0  | 5.4 | 3.0 | 3.25 | 6.50 | 0.0 | 1                  | WBMT 060101L        | SR 14-552 | T-6/5 |
| PICIN A06-T25-SWUBL-06 | 6.00   | 40.00 | 25.0  | 5.4 | 3.0 | 3.25 | 6.50 | 0.0 | 1                  | WBMT 060101R        | SR 14-552 | T-6/5 |
| PICIN A06-T25-SWUBR-06 | 6.00   | 40.00 | 25.0  | 5.4 | 3.0 | 3.25 | 6.50 | 0.0 | 1                  | WBMT 060101L        | SR 14-552 | T-6/5 |

• Use right-hand WBMT 06...R inserts on left-hand tools and left-hand WBMT 06...L inserts on right-hand tools.

<sup>(1)</sup> 0 - Without coolant supply, 1 - With coolant supply

<sup>(2)</sup> Master insert identification