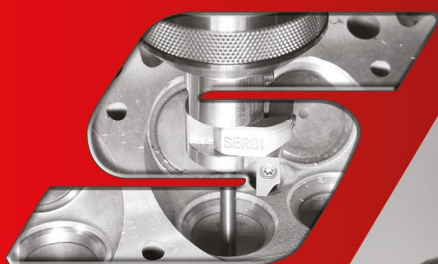




SERDI

SEAT AND GUIDE MACHINES VALVE REFACER PRESSURE
TESTER GRINDING MACHINES SEAT AND GUIDE
MACHINES VALVE REFACER PRESSURE TESTER
GRINDING MACHINES SEAT AND GUIDE MACHINES
VALVE REFACER PRESSURE TESTER GRINDING
MACHINES SEAT AND GUIDE MACHINES VALVE
REFACER PRESSURE TESTER GRINDING
SEAT AND GUIDE MACHINES VALVE REFACER
PRESSURE TESTER GRINDING MACHINES

TOOLING FOR VALVE SEATS



seat and guide machines

VOIGT - Werkzeugmaschinen

www.voigt-werkzeugmaschinen.de

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www.facebook.com/serdi.machines

SERDI profile cutters are designed on a modern CAD system, and then produced according to exact seat specification on a CNC profile grinder. Every single cutter is quality controlled on state-of-art equipment before delivery.

Original style

A1


Standard Cutting Bit for almost any conventional valve seat profile

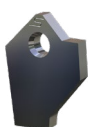
AL10

AL11

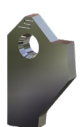
AL12

AL13


Counterboring Cutting Bit for valve seat counterbore machining

B1


For wide seat profile machining on large diameter valve seat

B2


For wide seat profile machining on smaller diameter valve seat

B4


For small valve seat diameter such as motorcycle heads with a deep seat

New generation style

E1

E2


Standard Cutting Bits for almost any small valve seat profile
(E1 fits S2700 - E2 fits S2710/S2711/S2731)

E3


Cutting bit for wide seat profile machining
(Fits S2710/S2711/S2730)

D1


Counterboring cutting bit for small diameter seat pocket machining
(Fits S2700)

D2

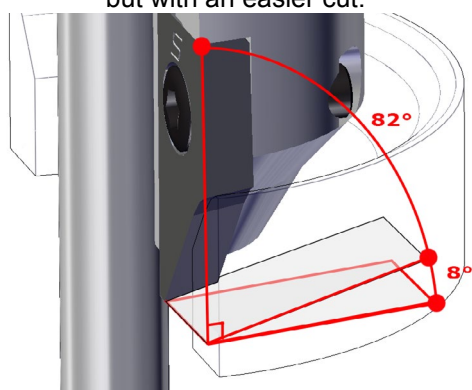

Counterboring cutting bit for valve seat machining (Fits S2710/S2711/S2731)

TECHNICAL NOTES :

- Do not use a 0° bit on a 8° Bit Holder or the opposite.
- If used as above mentioned, the back of the bit will touch the seat when machining or the bit will be too fragile in the second case.
- The original bit sharpener can be used with the New Style Cutting Bits using SERDI adapter tooling bracket (Reference : 021960)

0° Rake Cutting Angle (Negative):

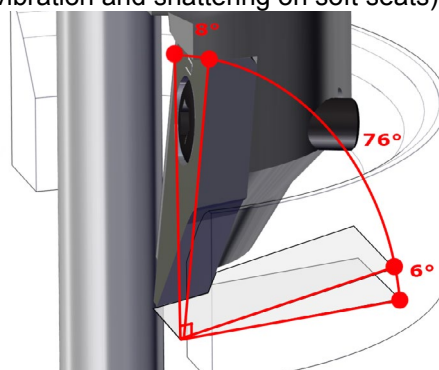
The bit is perpendicular to the cutting surface (as the SERDI Original Style Tooling). The 0° angle tooling can cut different hardness seats (soft & medium) up to 45 Rockwell. The cutting parameters for the 0° angle tooling can remain the same as the SERDI Original Style Tooling but with an easier cut.



8° Rake Cutting Angle (Positive):

The bit is 8° from the perpendicular to the cutting surface.

The 8° angle tooling is especially design to cut hard seats 45 Rockwell and up. The cutting bit is more aggressive on the seat so the vertical pressure decrease and run at a lower Rpm. SERDI recommends using this type of tooling only on hard seats (Risk of vibration and shattering on soft seats).



SEERD/ cutting system «SCS» tooling range for seats machining

Capacity (seat Ø)	Ø16 to Ø25 mm Ø0.630" to Ø 0.980"	Ø20 to Ø30 mm Ø0.787" to Ø1.181"	Ø28 to Ø40mm Ø1.102" to Ø1.570"	Ø35 to Ø70 mm Ø1.380" to Ø2.760"	Ø60 to Ø120 mm Ø2.360" to Ø4.720"
Tool-holder	S5700 Ref 019583	S5710 Ref 014154			S5731 Ref 020762
Cutting bit holder	S2700 0° rake angle Ref 921228	S2710 0° rake angle Ref 919409	S2710 8° rake angle Ref 019409	S2711 0° rake angle Ref 918768	S2730 0° rake angle Ref 919513
Pilot	CL type pilot Ø 9.52 mm - 3/8" shank 190 mm - 7.5" length	CL type pilot Ø 9.52 mm - 3/8" shank 190 mm - 7.5" length			E type pilot Ø 20 mm - .78" shank
Cutting bit	E1/D1 8° draft angle Ref 0xxxxx		D2/E2/E3 14° draft angle Ref 0xxxxx	D2/E2/E3 8° draft angle Ref 9xxxxx	D2/E2/E3 14° draft angle Ref 0xxxxx
			S2711 8° rake angle Ref 018768		D2/E2/E3 8° draft angle Ref 9xxxxx



SEED/ cutting system «TRI» tooling range for seats machining

Machining capacity	Ø16 to Ø25 mm Ø0.630" to Ø 0.980"	Ø20 to Ø40 mm Ø0.787" to Ø1.181"	Ø35 to Ø70mm Ø1.102" to Ø1.570"	Ø60 to Ø120 mm Ø2.360" to Ø4.720"
--------------------	--------------------------------------	-------------------------------------	------------------------------------	--------------------------------------

Tool-holder

S5700
Ref 019583

S5710
Ref 014154

S5731
Ref 020762

Cutting bit holder

Pilot

Cutting bit

CL type pilot

Ø 9.52 mm - 3/8" shank
190 mm - 7.5" length

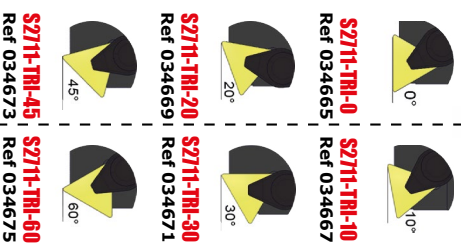
**FULL FACE
CBN BIT**
6mm
Ø 3.97 mm
Ref 031742 .24"



CL type pilot

Ø 9.52 mm - 3/8" shank
190 mm - 7.5" length

**FULL FACE
CBN BIT**
11mm
Ø 6.35 mm
Ø 1/4"
Ref 033223

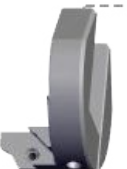
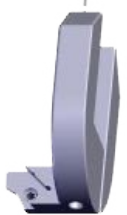
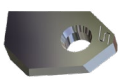
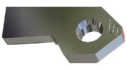
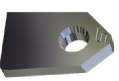
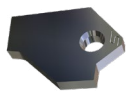


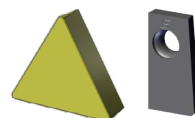
E type pilot

Ø 20 mm - .78" shank



SEED/ original cutting system tooling range for seats machining

Capacity (seat Ø)	Ø18 to Ø30 mm Ø0.70" to Ø 1.180"	Ø28 to Ø42 mm Ø1.100" to Ø1.650"	Ø40 to Ø58mm Ø1.570" to Ø2.280"	Ø40 to Ø60 mm Ø1.570" to Ø2.360"	Ø58 to Ø80 mm Ø2.280" to Ø3.150"
Tool-holder	S5100 Ref 010021 				S5300 Ref 404079 
Cutting bit holder	S2000 Ref 303390  S2001 Ref 303391  S2002 Ref 303392 				S2003 Ref 303393  S2004 Ref 303394 
Pilot	G1 type pilot Ø 9.52 mm - 3/8" shank Ø 3.5 to Ø 14 mm 190 mm - 7.5" length 				
Cutting bit	A1  AL10  AL11  AL12  B1  B2  B4  AL13 				


019583 SERDI 5700

- 753323 Pilot tightening screw (HC M5x10) x 1
 753313 Tightning screw for cutting bit holder (HC M5x8) x 2



Only for cutting bit holder #2700

For the entire range of SERDI seat and guide machines

Accommodates any pilot size with Ø 9.52mm - 3/8" shank

014154 SERDI 5710

- 753332 Pilot tightening screw (HC M5x12) x 1
 753313 Tightening screw for cutting bit holder (HC M5x8) x 4



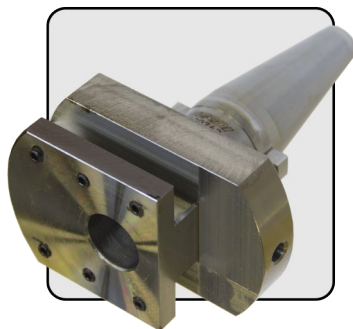
Only for cutting bit holder #2700, #2710 and #2711

For the entire range of SERDI seat and guide machines

Accommodates any pilot size with Ø 9.52mm - 3/8" shank

020762 SERDI 5731

- 753350 Pilot tightening screw (HC M5x20) x 1
 753313 Tightening screw for cutting bit holder (HC M5x8) x 6



Only for cutting bit holder #2730

For the entire range of SERDI seat and guide machines, except SERDI 3.0, SERDI 1.1 and SERDI 3.5

Accommodates any pilot size with Ø 20mm - 0.787" shank

021565 SERDI 5710+2"

- 753332 Pilot tightening screw (HC M5x12) x 1
 753313 Tightening screw for cutting bit holder (HC M5x8) x 4



Only for cutting bit holder #2700, #2710 and #2711

For the entire range of SERDI seat and guide machines

Accommodates any pilot size with Ø 9.52mm - 3/8" shank



010021 SERDI 5100

753313 Pilot tightening screw (HC M5x8) x 1

753313 Tightening screw for cutting bit holder (HC M5x8) x 2



Only for cutting bit holder #2000, #2001, #2002

For the entire range of SERDI seat and guide machines

**Accommodates any pilot size with Ø 9.52mm - 3/8" shank
Accommodates the entire range of milling cutters for valve seat
pocket counterboring**

404079 SERDI 5300

753313 Pilot tightening screw (HC M5x8) x 1

753313 Tightening screw for cutting bit holder (HC M5x8) x 2



Only for cutting bit holder #2003, #2004

For the entire range of SERDI seat and guide machines

Accommodates any pilot size with Ø 9.52mm - 3/8" shank

304443 SERDI 5100 + 2"

753313 Pilot tightening screw (HC M5x8) x 1

753313 Tightening screw for cutting bit holder (HC M5x8) x 2



Only for cutting bit holder #2000, #2001, #2002

For the entire range of SERDI seat and guide machines

**Accommodates any pilot size with Ø 9.52mm - 3/8" shank
Accommodates the entire range of milling cutters for valve seat
pocket counterboring**

002879 SERDI 5100 + 6"

753340 Pilot tightening screw (HC M5x16) x 1

753313 Tightening screw for cutting bit holder (HC M5x8) x 2



Only for cutting bit holder #2000, #2001, #2002

For the entire range of SERDI seat and guide machines

Accommodates any pilot size with Ø 9.52mm - 3/8" shank



002884 SERDI 5300 + 6"

753340 Pilot tightening screw (HC M5x16) x 1

753313 Tightening screw for cutting bit holder (HC M5x8) x 2



Only for cutting bit holder #2003, #2004

For the entire range of SERDI seat and guide machines

Accommodates any pilot size with Ø 9.52mm - 3/8" shank

Tool holders

Special

024527 SERDI 57 MC

753313 Pilot tightening screw (HC M5x8) x 1



Only for SERDI milling cutters

For the entire range of SERDI seat and guide machines

Accommodates any pilot size with Ø 9.52mm - 3/8" shank

Accommodates the entire range of milling cutter for valve seat pocket counterboring

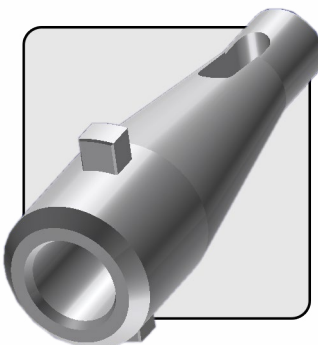
006903 SERDI 3100



Chuck: Morse Taper 2

For Ø2.5 mm to Ø16 mm (3/32" to 5/8") drills

404115 SERDI 3200



Adaptator ISO 30 (fits in SERDI spindles) to Morse Taper 2

Cutting bit holders

SCS



921228 SERDI 2700

- 753340 Adjusting diameter screw (HC M5x16) x 1
- 021145 Torx screw T15 (HC M3.5x9.5) x 1



Only for tool holder #5700 and #5710

Negative 0° rake angle: accomodates carbide cutting bits D1 part #0XXXX (E2 for particular applications only)



Ø 16 to 30 mm
Ø 0.630" to 1.181"

919409 SERDI 2710 - 0°

- 753350 Adjusting diameter screw (HC M5x20) x 1
- 021144 Tightening screw for cutting bit holder (HC M3.5x11) x 4



Only for tool holder #5710

Negative 0° rake angle: accomodates carbide cutting bits E2, E3, D2 part #9xxxxx



Ø 28 to 40 mm
Ø 1.102" to 1.570"

019409 SERDI 2710 - 8°

- 753350 Adjusting diameter screw (HC M5x20) x 1
- 021144 Tightening screw for cutting bit holder (HC M3.5x11) x 4



Only for tool holder #5710

Positive 8° rake angle: accomodates carbide cutting bits E2, E3, D2 part #0xxxxx





918768 SERDI 2711 - 0°

- 753370 Adjusting diameter screw (HC M5x30) x 1
021144 Torx screw T15 (HC M3.5x11) x 1



Only for tool holder #5710

Negative 0° rake angle: accomodates carbide cutting bits E2, E3, D2 part #9xxxxx



Ø 35 to 70 mm
Ø 1.38" to 2.76"

018768 SERDI 2711 - 8°

- 753370 Adjusting diameter screw (HC M5x30) x 1
021144 Torx screw T15 (HC M3.5x11) x 1



Only for tool holder #5710

Positive 8° rake angle: accomodates carbide cutting bits E2, E3, D2 part #0xxxxx

919513 SERDI 2730 - 0°

- 753370 Pilot tightening screw (HC M5x30) x 1
021144 Torx screw T15 (HC M3.5x11) x 1



Only for tool holder #5731

Negative 0° rake angle: accomodates carbide cutting bits E2, E3, D2 part #9xxxxx



Ø 60 to 120 mm
Ø 2.36" to 4.72"

019513 SERDI 52310- 8°

- 753370 Pilot tightening screw (HC M5x30) x 1
021144 Torx screw T15 (HC M3.5x11) x 1



Only for tool holder #5731

Positive 8° rake angle: accomodates carbide cutting bits E2, E3, D2 part #0xxxxx

Cutting bit holders

Original tooling



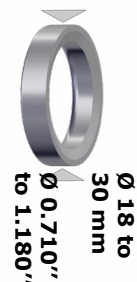
303390 SERDI 2000

- 753220 Adjusting diameter screw (HC M4x10) x 1
757010 Torx screw T8 (HC M3x10) x 1



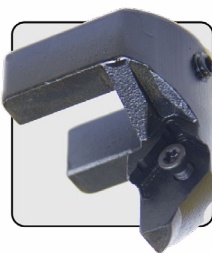
Only for tool holder #5100

Accommodates carbide cutting bit A and B type



303391 SERDI 2001

- 753230 Adjusting diameter screw (HC M4x12) x 1
757010 Torx screw T8 (HC M3x10) x 1



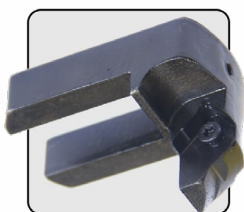
Only for tool holder #5100

Accommodates carbide cutting bit A and B type



303392 SERDI 2002

- 753240 Adjusting diameter screw (HC M4x16) x 1
757010 Torx screw T8 (HC M3x10) x 1



Only for tool holder #5100

Accommodates carbide cutting bit A and B type



303393 SERDI 2003

- 753415 Adjusting diameter screw (HC M6x16) x 1
757010 Torx screw T8 (HC M3x10) x 1



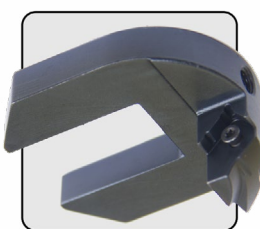
Only for tool holder #5300

Accommodates carbide cutting bit A and B type



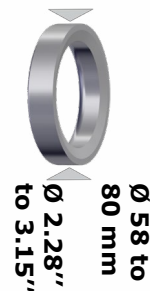
303394 SERDI 2004

- 753425 Adjusting diameter screw (HC M6x20) x 1
757010 Torx screw T8 (HC M3x10) x 1



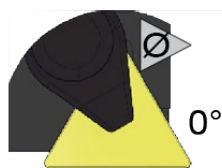
Only for tool holder #5300

Accommodates carbide cutting bit A and B type



035777 S2700 TRI-0

753340 Adjusting diameter screw (HC M5x16) x 1
031738 Bit clamp + screw (CHC M3)

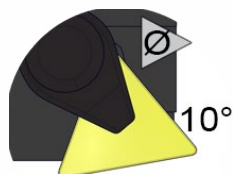


For tool holder #5700 and #5710

0° single angle tip holder for triangular cutting bit 6 mm edges 031742 (order separately).

035778 S2730 TRI-10

753340 Adjusting diameter screw (HC M5x16) x 1
031738 Bit clamp + screw (CHC M3)

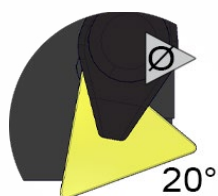


For tool holder #5700 and #5710

10° single angle tip holder for triangular cutting bit 6 mm edges 031742 (order separately).

035779 S2730 TRI-20

753340 Adjusting diameter screw (HC M5x16) x 1
031738 Bit clamp + screw (CHC M3)

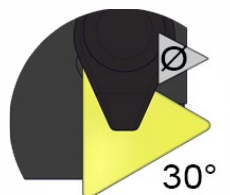


For tool holder #5700 and #5710

20° single angle tip holder for triangular cutting bit 6 mm edges 031742 (order separately).

035780 S2730 TRI-30

753340 Adjusting diameter screw (HC M5x16) x 1
031738 Bit clamp + screw (CHC M3)



For tool holder #5700 and #5710

30° single angle tip holder for triangular cutting bit 6 mm edges 031742 (order separately).

035781 S2730 TRI-45

753340 Adjusting diameter screw (HC M5x16) x 1
031738 Bit clamp + screw (CHC M3)



For tool holder #5700 and #5710

45° single angle tip holder for triangular cutting bit 6 mm edges 031742 (order separately).

035782 S2730 TRI-60

753340 Adjusting diameter screw (HC M5x16) x 1
031738 Bit clamp + screw (CHC M3)

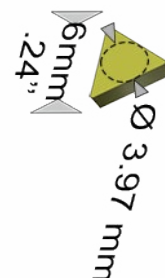


For tool holder #5700 and #5710

60° single angle tip holder for triangular cutting bit 6 mm edges 031742 (order separately).



Ø with S5700
 - mini Ø16 mm - 0.630"
 - maxi Ø25 mm - 0.980"
Ø with S5710
 - mini Ø20 mm
 - maxi Ø40 mm



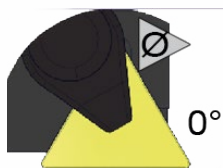
Cutting bit holders

TRI



034665 S2711 TRI-0

753370 Adjusting diameter screw (HC M5x30) x 1
032263 Bit clamp + screw (CHC M4)

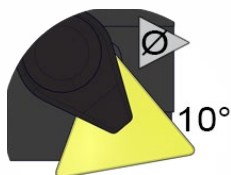


Only for tool holder #5710

0° single angle tip holder for triangular cutting bit 11 mm edges 033223 (order separately).

034667 S2711 TRI-10

753370 Adjusting diameter screw (HC M5x30) x 1
032263 Bit clamp + screw (CHC M4)

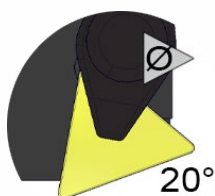


Only for tool holder #5710

10° single angle tip holder for triangular cutting bit 11 mm edges 033223 (order separately).

034669 S2711 TRI-20

753370 Adjusting diameter screw (HC M5x30) x 1
032263 Bit clamp + screw (CHC M4)

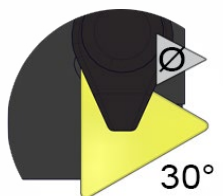


Only for tool holder #5710

20° single angle tip holder for triangular cutting bit 11 mm edges 033223 (order separately).

034671 S2711 TRI-30

753370 Adjusting diameter screw (HC M5x30) x 1
032263 Bit clamp + screw (CHC M4)

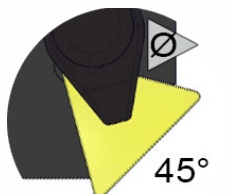


Only for tool holder #5710

30° single angle tip holder for triangular cutting bit 11 mm edges 033223 (order separately).

034673 S2711 TRI-45

753370 Adjusting diameter screw (HC M5x30) x 1
032263 Bit clamp + screw (CHC M4)

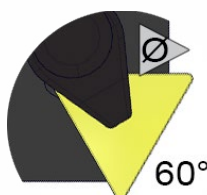


Only for tool holder #5710

45° single angle tip holder for triangular cutting bit 11 mm edges 033223 (order separately).

034675 S2711 TRI-60

753370 Adjusting diameter screw (HC M5x30) x 1
032263 Bit clamp + screw (CHC M4)

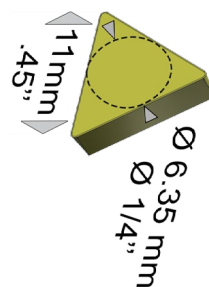


Only for tool holder #5710

60° single angle tip holder for triangular cutting bit 11 mm edges 033223 (order separately).



Ø with S5710
- mini Ø35 mm
- maxi Ø70 mm



034664 S2730 TRI-0

753370 Adjusting diameter screw (HC M5x30) x 1
 032263 Bit clamp + screw (CHC M4)

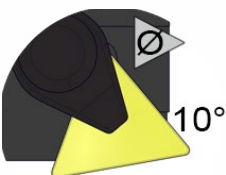


Only for tool holder #5731

0° single angle tip holder for triangular cutting bit 11 mm edges 033223 (order separately).

034666 S2730 TRI-10

753370 Adjusting diameter screw (HC M5x30) x 1
 032263 Bit clamp + screw (CHC M4)

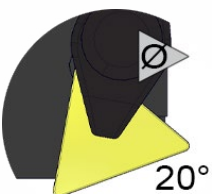


Only for tool holder #5731

10° single angle tip holder for triangular cutting bit 11 mm edges 033223 (order separately).

034668 S2730 TRI-20

753370 Adjusting diameter screw (HC M5x30) x 1
 032263 Bit clamp + screw (CHC M4)

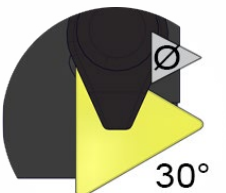


Only for tool holder #5731

20° single angle tip holder for triangular cutting bit 11 mm edges 033223 (order separately).

034670 S2730 TRI-30

753370 Adjusting diameter screw (HC M5x30) x 1
 032263 Bit clamp + screw (CHC M4)

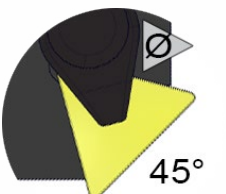


Only for tool holder #5731

30° single angle tip holder for triangular cutting bit 11 mm edges 033223 (order separately).

034672 S2730 TRI-45

753370 Adjusting diameter screw (HC M5x30) x 1
 032263 Bit clamp + screw (CHC M4)

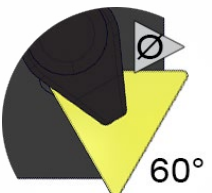


Only for tool holder #5731

45° single angle tip holder for triangular cutting bit 11 mm edges 033223 (order separately).

034674 S2730 TRI-60

753370 Adjusting diameter screw (HC M5x30) x 1
 032263 Bit clamp + screw (CHC M4)

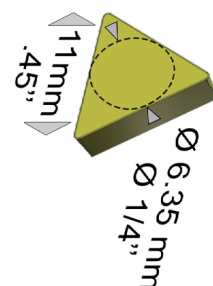


Only for tool holder #5731

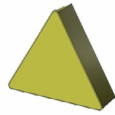
60° single angle tip holder for triangular cutting bit 11 mm edges 033223 (order separately).



Ø with S5731
 - mini Ø60 mm
 - maxi Ø120 mm



Cutting bit holders screw drivers



012205 T15 torx screw driver



The SERDI standard Torx Screw driver for new style tooling

582501 T8 torx screw driver



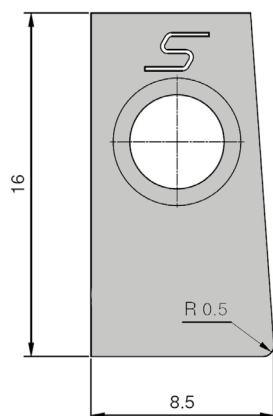
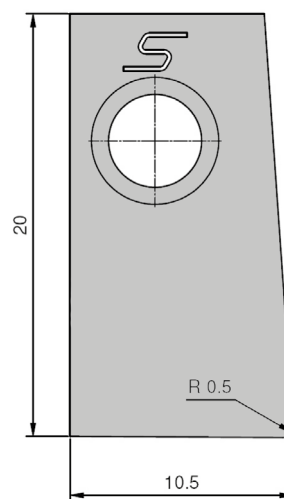
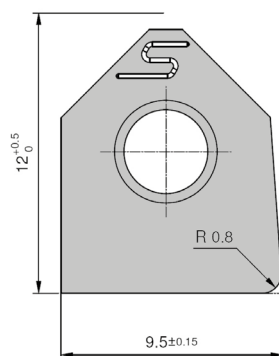
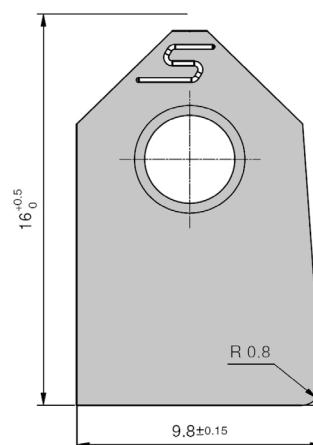
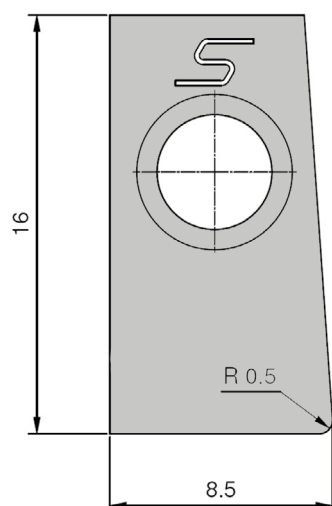
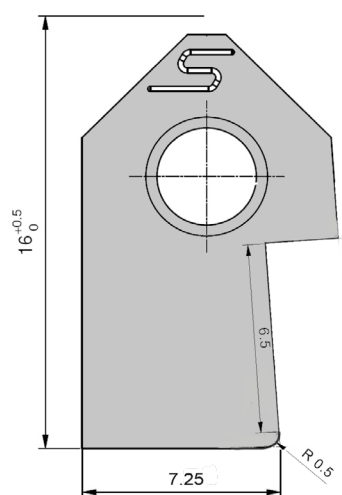
The SERDI standard Torx Screw driver for original style tooling

025166 Hexagonal 3mm screw driver



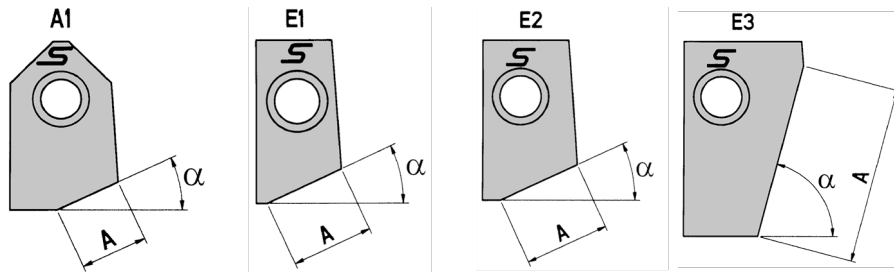
The SERDI standard hexagonal screw driver for TRI tooling to use with the clamp 032263



Cutting bit D1
019584

Cutting bit D2
- 017323 (0° cutting)
- 917323 (8° cutting)

Cutting bit AL11
005168

Cutting bit AL12
005164

Cutting bit AL10
304604

Cutting bit L12
013344


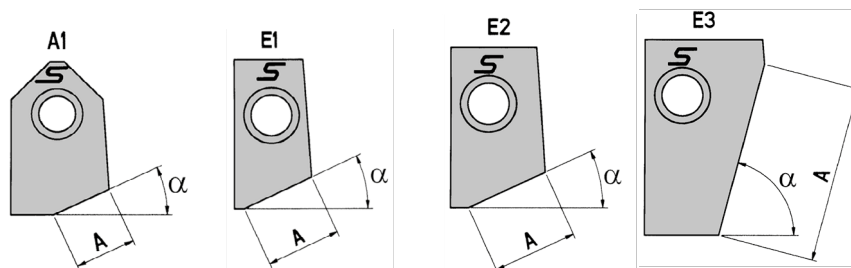
Standard cutting bits - the most popular profiles (see price lists) are registered in red.

Cutting bits **single angle**



	α Degree	A		A1	E1	E2 -0°	E2 -8°	E3 -0°	E3 -8°	Original SERDI part
		mm	inch							
1	7	8,00	0,3150	014203	022369					
2	7	9,00	0,3543			922371	022371			
3	8	6,00	0,2362	000586	022370					100-A1
4	8	9,00	0,3543			922177	022177			
5	10	8,00	0,3150		022372					
6	10	9,00	0,3543	018151		922373	022373			
7	11	6,00	0,2362	000587	022374					101-A1
8	11	9,00	0,3543			922178	022178			
9	15	6,00	0,2362	000588						102-A1
10	15	8,00	0,3150	000106	022375					SC500
11	15	9,00	0,3543			921966	021966			
12	15	9,50	0,3740	014202						
13	15	11,00	0,4331					921968	021968	
14	20	6,00	0,2362	000590						103-A1
15	20	8,00	0,3150		022376					SC501
16	20	9,00	0,3543	025292		921967	021967			
17	20	11,50	0,4528					921969	021969	
18	20	10,10	0,3976	000648						117-AL12
19	25	8,00	0,3150	000592	022377					104-A1
20	25	9,00	0,3543			921880	021880			
21	30	8,00	0,3150		022378					105-A1 / SC502
22	30	9,00	0,3543	000593		920618	020618			
23	30	12,00	0,4724					921487	021487	
24	30.25	8,00	0,3150		022381					
25	30.25	9,00	0,3543	019152		922380	022380			
26	31	8,00	0,3150	016669	022383					
27	31	9,00	0,3543			922382	022382			
28	32	8,00	0,3150	000595	022384					106-A1
29	32	10,00	0,3937			922179	022179			
30	35	8,00	0,3150	000596	022385					107-A1
31	35	9,00	0,3543			921739	021739			
32	40	8,00	0,3150		022386					
33	40	10,00	0,3937	000653		922387	022387			120-AL12
34	45	6,00	0,2362	000597						108-A1
35	45	9,00	0,3543	000647	022379					116-A1 / SC503
36	45	10,50	0,4134			920619	020619			
37	45	16,00	0,6299					921488	021488	
38	45.25	8,00	0,3150	019153	022388					SC504
39	45.25	10,00	0,3937			922389	022389			
40	45.40	10,50	0,4134			921486	021486			

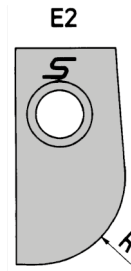
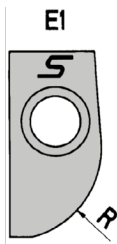
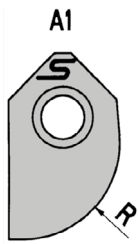




	α Degree	A		A1	B1	E1	E2 -0°	E2 -8°	E3 -0°	E3 -8°	Original SERDI part
		mm	inch								
1	50	8	0,3150			022390					114-A1
2	50	9	0,3543	000645							
3	50	10	0,3937				922391	022391			
4	55	8	0,3150	000861		022392					201-A1
5	55	12	0,4724				922181	022181			
6	60	8	0,3150	000862		022394					202-A1
7	60	9	0,3543	000865							SC505
8	60	12	0,4724				922182	022182			
9	60	16	0,6299						926995	026995	
10	65	8	0,3150			022395					
11	65	9	0,3543	011837							
12	65	11	0,4331				922393	022393			
13	67	7	0,2756	000867							203-A1
14	67	8	0,3150			022399					
15	67	12	0,4724				922183	022183			
16	70	8	0,3150	025842		022397					204-A1
17	70	12	0,4724			021299	921299	021199			
18	70	16	0,6299		019154				922396	022396	
19	70	16.8	0,6496								SC506-B3
20	75	7	0,2756	000871							205-A1
21	75	8	0,3150	000872		022398					SC507
22	75	12	0,4724				922185	022185			
23	75	16.4	0,6457		013377						SC508-B3
24	75	19	0,7480						922408	022408	
25	78	7	0,2756	000952							216-AL12
26	78	8	0,3150			022409					
27	78	12	0,4724				922410	022410			
28	80	8	0,3150	000951		022411					215-AL12
29	80	12	0,4724	025217			922412	022412			SC509-B3
30	82	7	0,2756	000874							206-A1
31	82	8	0,3150			022400					
32	82	11.5	0,4527	025364			922186	022186	923370	023370	SC510-B3
33	83	8	0,3150	006735		022413					
34	83	12	0,4724				922414	022414			
35	88	7	0,2756	007263							
36	88	8	0,3150			022415					
37	88	12	0,4724				922416	022416			

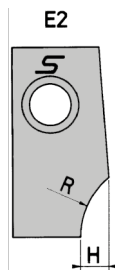
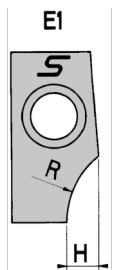
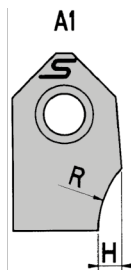
Standard cutting bits - the most popular profiles (see price lists) are registered in **red**.

Cutting bits **single convex radius**



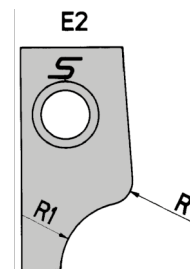
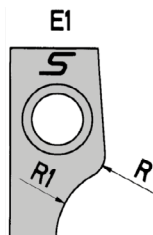
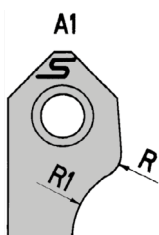
Radius		A1	E1	E2 -0°	E2 -8°	Original SERDI part
mm	inch					
4.5	0,1772	001653	022417	922418	022418	504-A1
5	0,1969	001673	022419	922089	022089	522-A1
7	0,2756	001660	022420	922421	022421	511-A1
8	0,3150	001675	022422	922423	022423	527-A1
27	1,0630	001668	022424	922425	022425	518-A1

Cutting bits **single concave radius cutting bits**



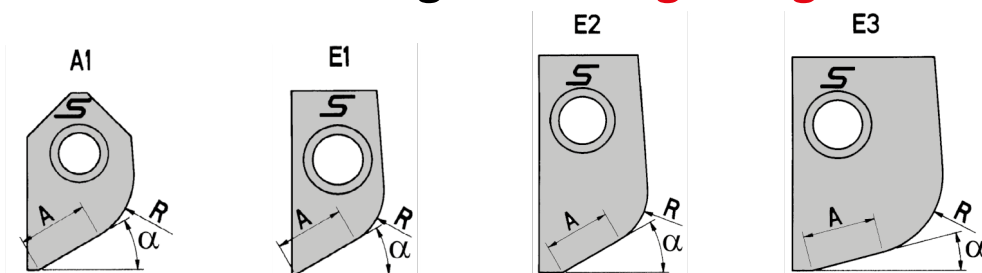
Radius		H		A1	E1	E2 -0°	E2 -8°	Original SERDI part
mm	inch	mm	inch					
8	0,3150	2.00	0,0787	018952	018953			
8	0,3150	3.00	0,1181	008661	022427	922428	022428	
12	0,4724	2.00	0,0787	001649				501-A1
12	0,4724	2.40	0,0945	017301				
12	0,4724	2.50	0,0984		022429	922430	022430	

Cutting bits **twin radius cutting bits**



Radius R1		Radius R		A1	E1	E2 -0°	E2 -8°	Original SERDI part
mm	inch	mm	inch					
5	0,1969	2	0,0787	001655	022431	922432	022432	506-A1
6	0,2362	2	0,0787	017935	022433	922434	022434	

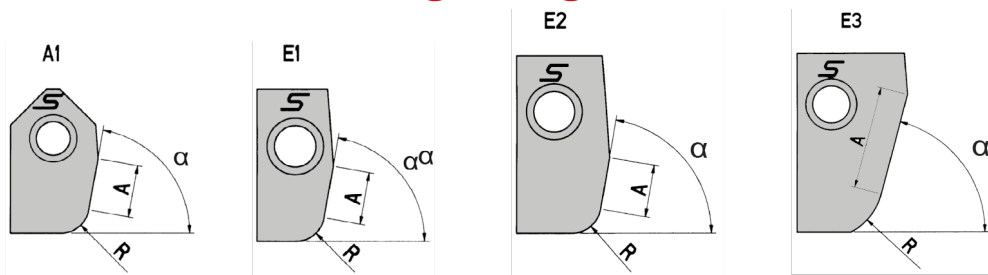




	α Degree	A		R		A1	E1	E2		E3		Original SERDI part
		mm	inch	mm	inch			-0°	-8°	-0°	-8°	
1	15	3,00	0,1181	6.5	0.2559	001665	022435	922436	022436			516-A1
2	15	2,90	0,1142	7	0,2756		022437					
3	15	4,00	0,1575	7	0,2756	019155		922438	022438			SC618
4	15	5,00	0,1969	5	0,1969	025200	025365	927113	027113			SC616
5	15	5,20	0,2047	4	0,1575		022439					
6	15	5,50	0,2165	4	0,1575	012835		922440	022440			SC614
7	15	6,40	0,2520	7	0,2756	013328						SC620
8	15	6,50	0,2559	7	0,2756					922442	022442	
9	20	3,00	0,1181	12	0,4724	001664	022441	922443	022443			515-A1
10	20	4,00	0,1575	2	0,0787	006784	022444	922446	022446			508-A1
11	28	4,00	0,1575	5	0,1969		022445					523-A1
12	28	5,60	0,2205	5	0,1969	005335						
13	28	7,00	0,2756	5	0,1969			922448	022448			
14	30	4,40	0,1732	7	0,2756	019156	022447	922449	022449			SC619
15	30	5,70	0,2244	4	0,1575	019157	022450	922482	022482			SC615
16	30	6,00	0,2362	5	0,1969	019158	022483	922484	022484			SC617
17	30	7,00	0,2756	1	0,0394		022485					
18	30	8,00	0,3150	1	0,0394			922486	022486			
19	30	9,00	0,3543	1	0,0394	000646						115-A1
20	32	5,00	0,1969	5	0,1969	006966	022487	922488	022488			514-A1
21	45	5,00	0,1969	10	0,3937	000600	022489	922490	022490			109-A1

Standard cutting bits - the most popular profiles (see price lists) are registered in **red**.

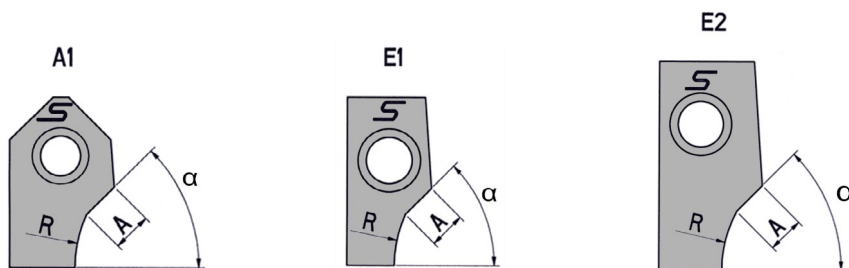
Cutting bits 1 radius with straight angle



	α Degree	A		R		A1	B1	E1	E2 -0°	E2 -8°	E3 -0°	E3 -8°	Original SERDI part
		mm	inch	mm	inch								
1	45	3,00	0,1181	1	0,0394	001662		022491	922492	022492			512-A1
2	71	6,00	0,2362	2.5	0,0984			022494					
3	71	10,00	0,3937	2.5	0,0984	001674			922493	022493			525-B3
4	75	5,00	0,1969	12	0,4724			022495					
5	75	5,50	0,2165	12	0,4724	001667			922496	022496			517-A1
6	75	10,00	0,3937	1.5	0,0591	000406			922498	022498			524-B3
7	75	4,00	0,1575	7	0,2756			026283					
8	75	8,00	0,3150	7	0,2756				925472	025472			SC621B3
9	75	12,00	0,4724	7	0,2756		009225		935278	035278	922499	022499	
10	77	4,00	0,1575	2.5	0,0984	001652		022426	922321	022321			503-A1
11	80	5,50	0,2165	3	0,1181	010730		022520	922521	022521			513-A1
12	80	4,00	0,1575	7	0,2756			025080					
13	80	9,00	0,3543	7	0,2756		013926				922522	022522	SC622B3

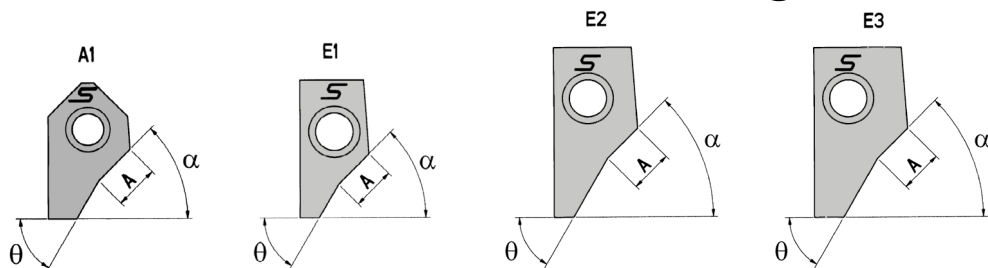
Standard cutting bits - the most popular profiles (see price lists) are registered in red.

Cutting bits single concave radius - 1 angle



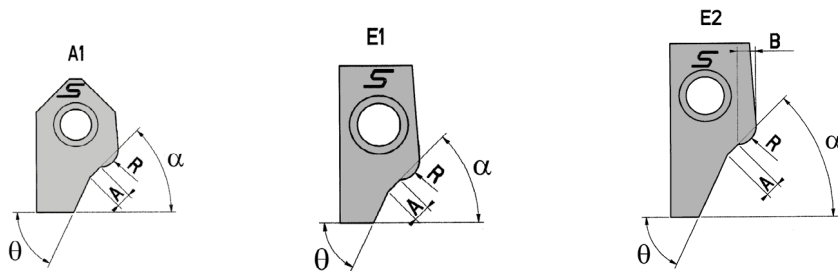
	α Degree	A		R		A1	E1	E2 -0°	E2 -8°	Original SERDI part
		mm	inch	mm	inch					
22	45	3,50	0,1378	12	0,4724	001651	022523			502-A1
23	45	3,50	0,1378	12	0,4724			922524	022524	
24	45	4,00	0,1575	5	0,1969	005465	022525	922526	022526	44003-A1
25	45	4,00	0,1575	6	0,2362	001628	022527	922528	022528	44004-A1
26	48	2,70	0,1063	10	0,3937	005720	022533	922534	022534	
27	48	2,80	0,1102	8	0,3150	005719	022529	922530	022530	



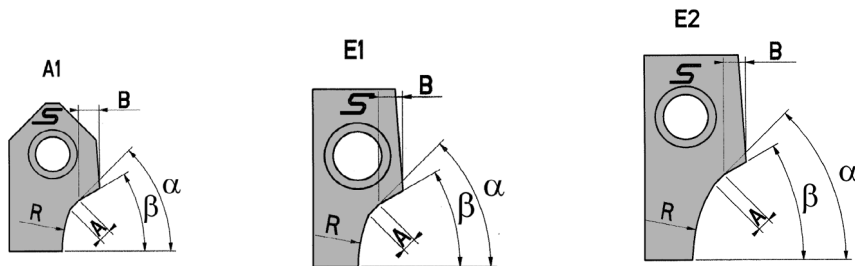


	α Degree	A		θ Degree	A1	E1	E2 -0°	E2 -8°	E3 -0°	E3 -8°	Original SERDI part
		mm	inch								
1	10	1,00	0,0394	20	000574				922535	022535	008-B3
2	15	1,00	0,0394	30	000573	022584	922536	022536			007-A1
3	20	3,20	0,1260	60	000968	022586	922585	022585			23001-A1
4	25	2,50	0,0984	45	001642	022588	922587	022587			46002-A1
5	30	3,00	0,1181	45	001174	022590	922589	022589			33005-A1
6	30	3,00	0,1181	50	001171	022592	922591	022591			33001-A1
7	30	5,00	0,1969	60	005272	022594	922593	022593			35001-A1
8	35	3,80	0,1496	60	015130	022596	922595	022595			
9	45	3,60	0,1417	60	015129	022598	922597	022597			
10	45	5,00	0,1969	60	001637	022600	922601	022601	922599	022599	45001-B1
11	45	5,00	0,1969	60	001638	022600	922601	022601			45002-A1
12	45	7,00	0,2756	60	001645				922603	022603	47001-B1
13	60	2,00	0,0787	75	001656	022602	922605	022605			507-A1
14	60	6,50	0,2559	20	006967	022604	922607	022607			001-B1
15	60	6,50	0,2559	30	000571	022606	922609	022609			003-A1
16	75	5,00	0,1969	30	006968	022608	922611	022611			002-A1
17	75	6,50	0,2559	15	000572	022610	922613	022613			004-A1

Cutting bits **tw**in angles one radius



	α Degree	A		R		θ Degree	A1	E1	E2 -0°	E2 -8°	Original SERDI part
		mm	inch	mm	inch						
1	30	2,20	0,0866	2,50	0,0984	70	006218	022612	922615	022615	32016-A1
2	30	3,50	0,1378	0,60	0,0236	60	007016	022614	922617	022617	33009-A1
3	45	1,00	0,0394	6,00	0,2362	65	001272	022616	922619	022619	41006-A1
4	45	1,20	0,0472	6,00	0,2362	65	001297	022618	922621	022621	41034-A1
5	45	1,30	0,0512	6,30	0,2480	65	001324	022620	922623	022623	41063-A1
6	45	1,50	0,0591	6,00	0,2362	60	001354	022624	922625	022625	41090-A1
7	45	1,70	0,0669	2,00	0,0787	65	005459	022626	922627	022627	41130-A1
8	45	2,70	0,1063	2,50	0,0984	60	001570	022628	922629	022629	42067-A1
9	45	2,80	0,1102	2,00	0,0787	65	001571	022638	922639	022639	42069-A1
10	45	3,00	0,1181	0,60	0,0236	60	001615	022640	922641	022641	43005-A1
11	45	3,50	0,1378	0,60	0,0236	60	007017	022642	922643	022643	43009-A1

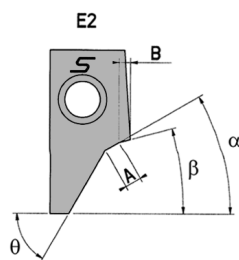
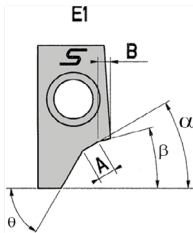
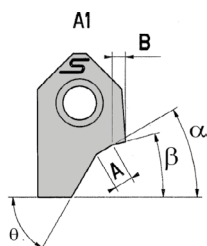


	α Degree	A		B		θ Degree	R		A1	E1	E2 -0°	E2 -8°	Original SERDI part
		mm	inch	mm	inch		mm	inch					
12	30	1,00	0,0394	1,93	0,0760	15	12	0,4724	001091	022644	922645	022645	31002-A1
13	35	1,00	0,0394	1,93	0,0760	15	12	0,4724	001189	022646	922647	022647	35102-A1
14	45	1,00	0,0394	1,53	0,0602	40	5	0,1969	001285	022648	922649	022649	41023-A1
15	45	1,00	0,0394	1,53	0,0602	40	12	0,4724	000432	022650	922651	022651	41022-A1
16	45	1,00	0,0394	1,93	0,0760	15	12	0,4724	001283	022652	922284	022284	41019-A1
17	45	1,20	0,0472	4,00	0,1575	40	7.5	0,2953	001298	022654	922653	022653	41035-A1
17	45	1,30	0,0512	2,15	0,0846	30	12	0,4724	019160		922519	022519	HP1953-B1
18	45	1,30	0,0512	2,15	0,0846	30	12	0,4724	001323	022497	922655	022655	41062-B2
19	45	1,50	0,0591	1,53	0,0602	40	12	0,4724	001368	022656	922657	022657	41100-A1
20	45	1,50	0,0591	1,56	0,0614	30	12	0,4724	006115	022658	922659	022659	41171-A1
21	45	1,50	0,0591	1,93	0,0760	15	12	0,4724	001363	022660	922661	022661	41098-A1
22	45	1,65	0,0650	1,27	0,0500	30	10.8	0,4252	019161	022662	922663	022663	HP1583-A1

Standard cutting bits - the most popular profiles (see price lists) are registered in **red**.



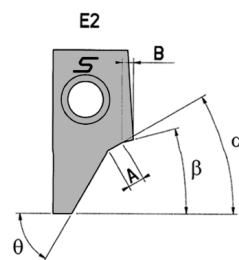
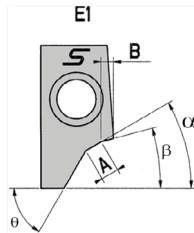
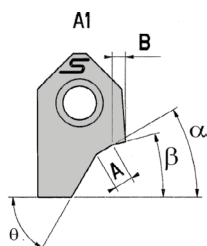
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	α Degree	A		B		β Degree	θ Degree	A1	E1	E2 -0°	E2 -8°	Original SERDI part
1	30	1.00	0,0394	1.40	0,0551	15	60	001126	022664	921285	021285	310-A1
2	30	1.30	0,0512	1.00	0,0394	15	45	019162	022666	922665	022665	SC300
3	30	1.30	0,0512	2.00	0,0787	15	45	011648	022668	922667	022667	SC301
4	30	1.30	0,0512	2.00	0,0787	15	60	019163	022670	922669	022669	SC302
5	30	1.50	0,0591	1.00	0,0394	20	60	017140	022672	922671	022671	15E30D60-A1
6	30	1.50	0,0591	1.40	0,0551	15	45	019164	022676	922673	022673	SC303
7	30	1.50	0,0591	1.40	0,0551	15	60	000551	022674	921286	021286	315-A1
8	30	1.50	0,0591	1.80	0,0709	15	45	000756	025367	925188	025188	SC304
9	30	1.50	0,0591	1.80	0,0709	15	60	000757	022678	922675	022675	15J30U60-A1
10	30	1.50	0,0591	2.00	0,0787	2	75	019165	022680	922677	022677	15K30S75-A1
11	30	1.50	0,0591	2.00	0,0787	15	60	012367	025368	927114	027114	SC305
12	30	1.60	0,0630	1.20	0,0472	15	45	019166	022688	922679	022679	SC306
13	30	1.60	0,0630	1.60	0,0630	15	65	001108	022690	921289	021289	31021-A1
14	30	1.60	0,0630	1.80	0,0709	15	45	024903	025369	927044	027044	SC307
15	30	1.60	0,0630	1.80	0,0709	15	52	000797	022692	922687	022687	SC308
16	30	1.60	0,0630	2.00	0,0787	15	45	000800	022694	922689	022689	SC309
17	30	1.60	0,0630	2.00	0,0787	15	60	019167	022696	922691	022691	SC310
18	30	1.60	0,0630	2.20	0,0866	15	60	000279	025371	925370	025370	SC311
19	30	1.80	0,0709	1.20	0,0472	15	45	023396				18F30U45-A1
20	30	1.80	0,0709	1.30	0,0512	20	52	011265	022698	922693	022693	
21	30	1.80	0,0709	2.00	0,0787	15	45	019168	022700	922695	022695	SC312
22	30	1.90	0,0748	1.00	0,0394	15	45	000824	022702	922697	022697	SC313
23	30	1.90	0,0748	1.40	0,0551	15	60	001132	022704	922699	022699	319-A1
24	30	1.90	0,0748	1.80	0,0709	15	60	000843	022706	922701	022701	19J30U60-A1
25	30	1.90	0,0748	2.00	0,0787	15	60	006256	022708	922703	022703	SC314
26	30	2.00	0,0787	1.20	0,0472	15	45	012833	022710	922705	022705	SC315
27	30	2.00	0,0787	1.40	0,0551	0	60	000899	022712	922707	022707	20G30R60-A1
28	30	2.00	0,0787	1.40	0,0551	15	60	001165	022714	921287	021287	320-A1
29	30	2.00	0,0787	2.00	0,0787	15	45	019169	022716	922353	022353	SC316
30	30	2.20	0,0866	1.40	0,0551	15	60	018092	022718	922709	022709	322-A1
31	30	2.20	0,0866	2.00	0,0787	15	60	019170	022720	922711	022711	SC317
32	30	2.30	0,0906	1.80	0,0709	15	60	000988	022722	922713	022713	23J30U60-A1
33	30	2.40	0,0945	2.60	0,1024	18	56	019171	022724	922715	022715	24N30C56-A1
34	30	2.50	0,0984	1.40	0,0551	15	60	001168	022730	921288	021288	325-A1
35	30	3.00	0,1181	1.40	0,0551	15	60	001179	022732	921737	021737	330-A1
36	30	3.28	0,1291	2.79	0,1098	15	45	023048				
37	30	3.80	0,1496	3.00	0,1181	20	45	024925	025372	924962	024962	SC318
38	30	4.00	0,1575	1.40	0,0551	15	60	001186	022734	922721	022721	340-B2

Standard cutting bits - the most popular profiles (see price lists) are registered in red.

Cutting bits **three angles - 45°**

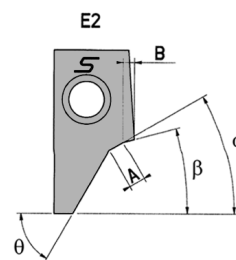
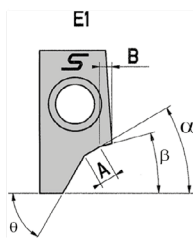
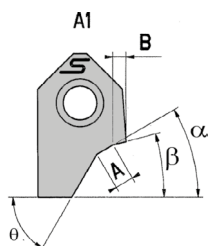


	α Degree	A mm inch	B mm inch	β Degree	θ Degree	A1	E1	E2 -0°	E2 -8°	Original SERDI part
1	45	0.50 0,0197	2.00 0,0787	30	75	010620	022725	922723	022723	05K45X75-A1
2	45	0.85 0,0335	1.73 0,0681	30	67	001247	022729	922727	022727	40871-A1
3	45	1.00 0,0394	1.00 0,0394	35	65	000607	022731	922733	022733	10E45F65-A1
4	45	1.00 0,0394	1.40 0,0551	25	60	001365	022806	921269	021269	410-A1
5	45	1.00 0,0394	1.20 0,0472	30	60	000612	022736	922735	022735	SC001
6	45	1.00 0,0394	1.60 0,0630	35	52	025006	025341	925340	025340	SC035
7	45	1.00 0,0394	1.60 0,0630	35	60	000621	025343	925342	025342	SC036
8	45	1.00 0,0394	1.80 0,0709	30	60	000634	022726	922831	022831	10J45X60-A1
9	45	1.00 0,0394	2.00 0,0787	30	60	006351	022728	922833	022833	SC002
10	45	1.00 0,0394	2.40 0,0945	30	60	019173	022832	922835	022835	10M45X60-A1
11	45	1.10 0,0433	1.80 0,0709	30	60	000651	022834	922837	022837	11J45X60-A1
12	45	1.20 0,0472	1.40 0,0551	25	60	001480	022836	921733	021733	412-A1
13	45	1.30 0,0512	1.20 0,0472	30	60	012735	022838	922839	022839	SC003
14	45	1.30 0,0512	1.60 0,0630	30	60	021856	022840	922841	022841	SC004
15	45	1.30 0,0512	2.00 0,0787	30	60	000693	022842	922843	022843	SC006
16	45	1.30 0,0512	2.00 0,0787	37	52	000691	022844	922845	022845	SC005
17	45	1.40 0,0551	1.50 0,0591	30	60	016408				
18	45	1.50 0,0591	1.00 0,0394	15	60	000726	022846	922847	022847	15E45U60-A1
19	45	1.50 0,0591	1,36 0,0535	37	53	001359				15J45G53-A1
20	45	1.50 0,0591	1.40 0,0551	25	60	000552	022848	921282	021282	415-A1
21	45	1.50 0,0591	1.40 0,0551	30	52	019174	022850	922849	022849	15G45X52-A1
22	45	1.50 0,0591	1.40 0,0551	30	60	008605	022852	922851	022851	SC037
23	45	1.50 0,0591	1.80 0,0709	15	60	000768	022858	922857	022857	SC008
24	45	1.50 0,0591	1.80 0,0709	25	60	000770	022854	922853	022853	15J45V60-A1
25	45	1.50 0,0591	1.80 0,0709	30	52	012736	022860	922859	022859	SC009
26	45	1.50 0,0591	1.80 0,0709	30	60	000772	022856	922855	022855	15J45X60-A1
27	45	1.50 0,0591	1.80 0,0709	37	52	000764	022862	922861	022861	SC007
28	45	1.50 0,0591	2.00 0,0787	30	60	000778	022864	922863	022863	SC010
29	45	1.50 0,0591	3.00 0,1181	30	60	009476	025361	927018	027018	SC011
30	45	1.60 0,0630	1.00 0,0394	30	60	000789	022866	922865	022865	16E45X60-A1
31	45	1.60 0,0630	1.20 0,0472	30	52	000791	025344	927011	027011	SC012
32	45	1.60 0,0630	1.20 0,0472	30	60	000792	022868	922867	022867	SC013
33	45	1.60 0,0630	1.40 0,0551	30	60	019175	022872	922871	022871	SC014
34	45	1.60 0,0630	1.60 0,0630	15	60	019176	022874	922873	022873	SC015
35	45	1.60 0,0630	1.60 0,0630	30	52	025215	025345	927127	027127	SC016
36	45	1.60 0,0630	1.60 0,0630	30	60	000796	022870	922869	022869	SC017
37	45	1.60 0,0630	1.80 0,0709	30	52	000798	022878	922877	022877	SC018
38	45	1.60 0,0630	2.00 0,0787	15	60	000801	022876	922875	022875	SC019
39	45	1.60 0,0630	2.00 0,0787	30	52	012831	022881	922882	022882	SC020

Standard cutting bits - the most popular profiles (see price lists) are registered in red.



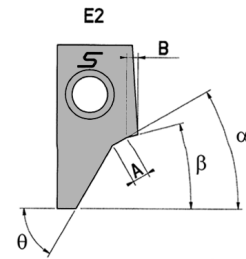
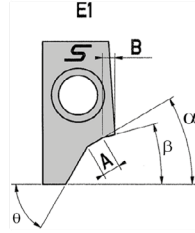
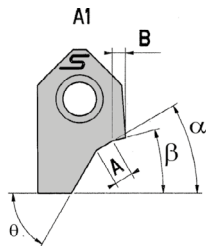
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	α Degree	A		B		β Degree	θ Degree	A1	E1	E2 -0°	E2 -8°	Original SERDI part
		mm	inch	mm	inch							
1	45	1.60	0,0630	2.00	0,0787	30	60	000802	022880	922879	022879	SC021
2	45	1.60	0,0630	2.00	0,0787	35	55	023445	025347	925346	025346	SC038
3	45	1.60	0,0630	3.00	0,1181	30	60	024914	025349	925348	025348	SC022
4	45	1.70	0,0669	1.40	0,0551	23	67	012751	022886	922885	022885	
5	45	1.70	0,0669	1.40	0,0551	25	67	025629				17G45V67-A1
6	45	1.70	0,0669	1.60	0,0630	15	65	001452	022884	922883	022883	41212-A1
7	45	1.80	0,0709	1.00	0,0394	15	60	005336	022888	922887	022887	18E45U60-A1
8	45	1.80	0,0709	3.00	0,1181	30	60	025069	025351	925350	025350	SC023
9	45	1.90	0,0748	1.20	0,0472	30	52	024900	025352	927094	027094	SC024
10	45	1.90	0,0748	1.20	0,0472	30	60	000833	022892	922891	022891	SC025
11	45	1.90	0,0748	1.40	0,0551	25	60	001508	022890	922889	022889	419-A1
12	45	1.90	0,0748	1.40	0,0551	30	60	000837	022894	922893	022893	19G45X60-A1
13	45	1.90	0,0748	1.60	0,0630	30	60	000841	022898	922897	022897	SC026
14	45	1.90	0,0748	1.80	0,0709	30	52	000851	022912	922899	022899	SC027
15	45	1.90	0,0748	1.80	0,0709	30	60	000852	022896	922895	022895	19J45X60-A1
16	45	1.90	0,0748	2.00	0,0787	30	52	019177	022916	922915	022915	SC028
17	45	1.90	0,0748	2.00	0,0787	35	55	023457	025354	925353	025353	SC039
18	45	1.90	0,0748	2.00	0,0787	30	60	000854	022914	922913	022913	SC029
19	45	2.00	0,0787	0.70	0,0276	20	52	011266	022918	922917	022917	
20	45	2.00	0,0787	1.00	0,0394	15	75	001526	022920	922919	022919	42020-A1
21	45	2.00	0,0787	1.20	0,0472	0	70	001539	022922	922921	022921	42030-A1
22	45	2.00	0,0787	1.20	0,0472	30	60	019178	022924	922923	022923	20F45X60-A1
23	45	2.00	0,0787	1.40	0,0551	25	60	001588	022926	918769	018769	420-A1
24	45	2.00	0,0787	1.40	0,0551	30	60	000912	022928	922925	022925	20G45X60-A1
25	45	2.00	0,0787	1.50	0,0591	30	60	001509	022930	922927	022927	42001-A1
26	45	2.00	0,0787	1.60	0,0630	15	62	001535	022932	922929	022929	42026-A1
27	45	2.00	0,0787	1.60	0,0630	30	70	023384	025356	925355	025355	SC030
28	45	2.00	0,0787	1.60	0,0630	30	75	023385	023669	925357	025357	SC031
29	45	2.00	0,0787	1.80	0,0709	30	60	000927	022934	922931	022931	20J45X60-A1
30	45	2.00	0,0787	2.00	0,0787	15	75	000930				20K45U55-A1
31	45	2.00	0,0787	2.00	0,0787	30	60	000931	022936	922933	022933	20K45X60-A1
32	45	2.10	0,0827	1.00	0,0394	33	52	024992				
33	45	2.20	0,0866	1.40	0,0551	30	60	000962	025359	925358	025358	SC032
34	45	2.30	0,0906	1.40	0,0551	25	60	001608	022938	922935	022935	423-A1
35	45	2.30	0,0906	2.00	0,0787	30	60	000997	025360	927100	027100	SC033
36	45	2.50	0,0984	1.40	0,0551	25	60	001609	022940	921283	021283	425-A1
37	45	2.50	0,0984	2.00	0,0787	30	60	012832	022942	922937	022937	SC034
38	45	3.00	0,1181	1.40	0,0551	25	60	001625	022944	921738	021738	430-A1
39	45	3.00	0,1181	3.00	0,1181	15	60	000566	022946	922939	022939	30Q45U60-A1

Standard cutting bits - the most popular profiles (see price lists) are registered in red.

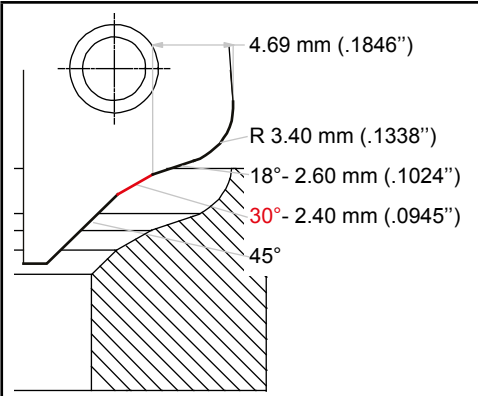
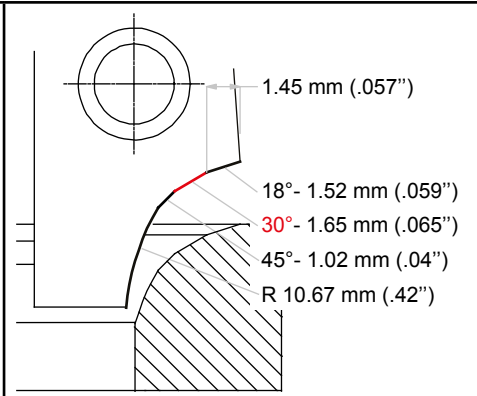
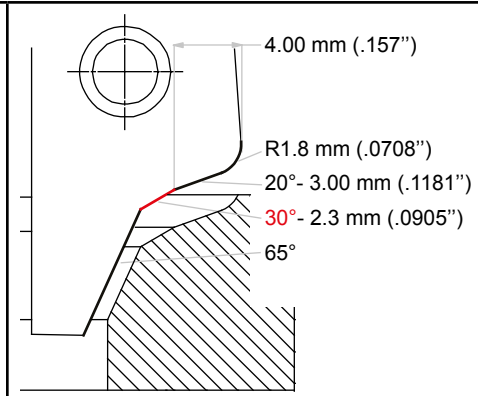
Cutting bits miscellaneous angles

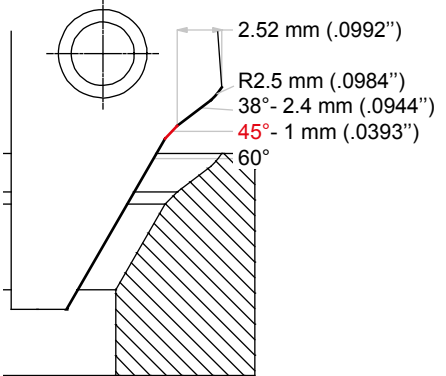
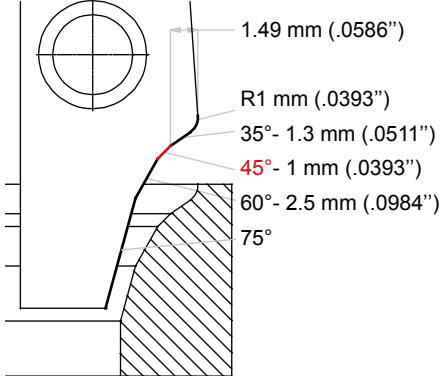
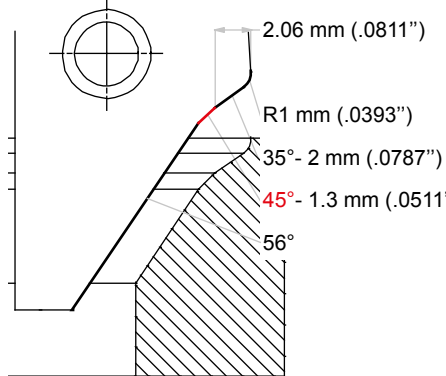
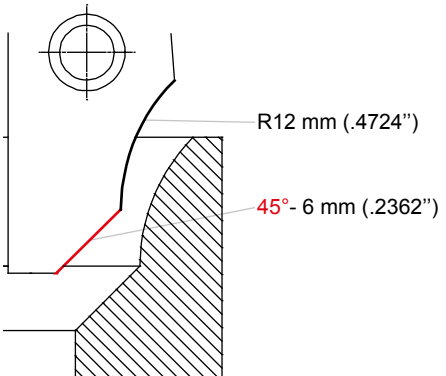
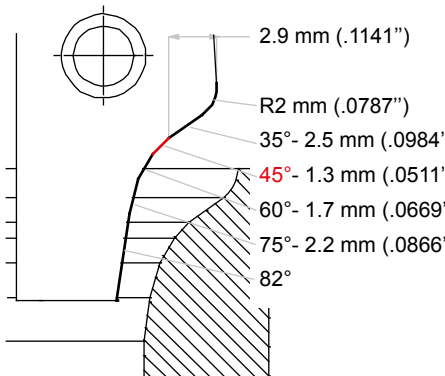
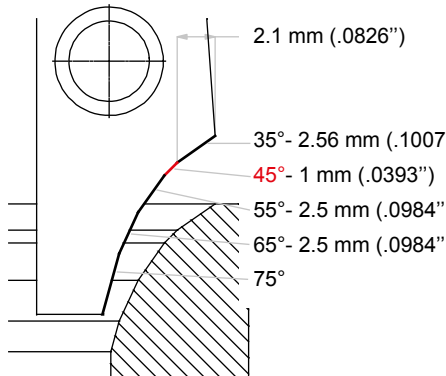
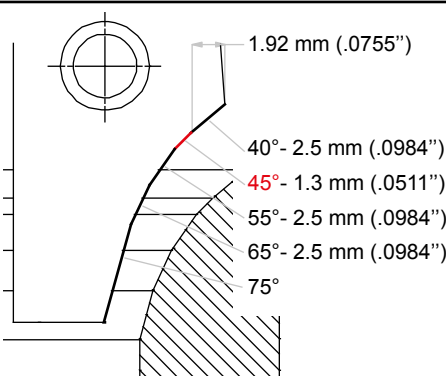
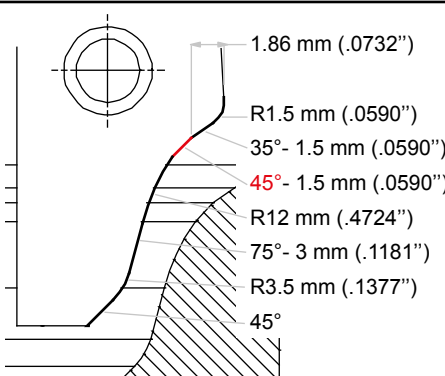
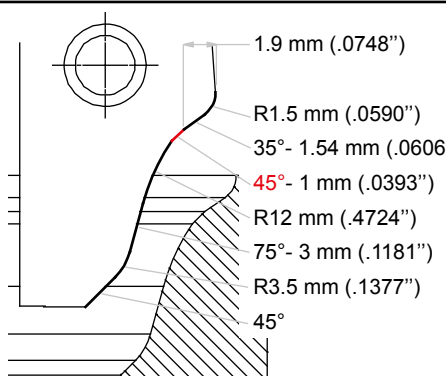


	α Degree	A		B		β Degree	θ Degree	A1	E1	E2 -0°	E2 -8°	Original SERDI part
		mm	inch	mm	inch							
1	20,00	2.00	0.0787	1.80	0.0709	0	60	000597				
2	20,00	4.00	0.1575	1.60	0.0630	5	65	011526		922941	022941	40H20A65-A1
3	20,25	2.70	0.1063	2.80	0.1102	15	60	019180				27P20.25U60-A1
4	30,25	1.90	0.0748	1.60	0.0630	18	42	019181	022948	922945	022945	19H30.25C42-A1
5	31,00	1.50	0.0591	1.40	0.0551	11	60	023429				15G31B60-A1
6	31,00	2.90	0.1142	2.00	0.0787	15	60	019182	022950	922947	022947	29K31U60-A1
7	37,50	1.60	0.0630	1.40	0.0551	30	60	019509	025362	925189	025189	SC400
8	37,50	1.60	0.0630	2.00	0.0787	30	60	025216	025363	925103	025103	SC401
9	37,50	1.90	0.0748	1.40	0.0551	30	60	019183	022952	922949	022949	SC402
10	37,50	2.00	0.0787	2.00	0.0787	30	60	024913	022954	922951	022951	SC403
11	37,50	2.10	0.0827	1.40	0.0551	18	52	019186	022956	922953	022953	SC404
12	37,50	2.20	0.0866	1.20	0.0472	30	60	019187	022958	922955	022955	22F37.5X60-A1
13	45,25	1.50	0.0591	1.80	0.0709	15	60	012737	022960	922957	022957	15J45.25U60-A1
14	45,25	1.50	0.0591	1.80	0.0709	30	60	019188	022968	922959	022959	15J45.25X60-A1
15	45,25	1.50	0.0591	1.80	0.0709	33	52	019189	022970	922961	022961	
16	45,25	1.50	0.0591	2.00	0.0787	25	52	019190	022972	922967	022967	15K45.25V52-A1
17	45,25	1.50	0.0591	2.20	0.0866	8	60	011645	022974	922969	022969	15L45.25T60-A1
18	45,25	1.60	0.0630	2.00	0.0787	15	60	019191	022976	922971	022971	16K45.25U60-A1
19	45,25	1.60	0.0630	2.00	0.0787	25	52	024904				16K45.25V52-A1
20	45,25	1.90	0.0748	1.00	0.0394	33	52	019192	022978	922973	022973	
21	45,25	1.90	0.0748	1.80	0.0709	30	60	019193	022980	922975	022975	19J45.25X60-A1
22	45,25	1.90	0.0748	1.80	0.0709	33	52	019194	022982	922977	022977	
23	45,25	2.00	0.0787	1.00	0.0394	30	70	019195	022984	922979	022979	20E45.25X70-A1
24	45,25	2.00	0.0787	1.00	0.0394	30	75	019196	022986	922981	022981	20E45.25X75-A1
25	45,25	2.30	0.0906	1.80	0.0709	15	60	011646	022988	922983	022983	23J45.25U60-A1
26	45,25	2.30	0.0906	1.80	0.0709	25	52	019197	022990	922985	022985	23J45.25V52-A1
27	45,25	2.30	0.0906	1.80	0.0709	25	60	019198	022991	922987	022987	23J45.25V60-A1
28	45,25	2.30	0.0906	1.80	0.0709	33	52	019199	022992	922989	022989	
29	45,25	2.60	0.1024	1.80	0.0709	25	52	024905				26J45.25V52-A1

Standard cutting bits - the most popular profiles (see price lists) are registered in red.

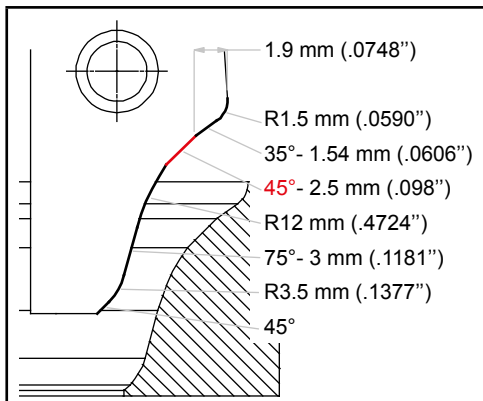
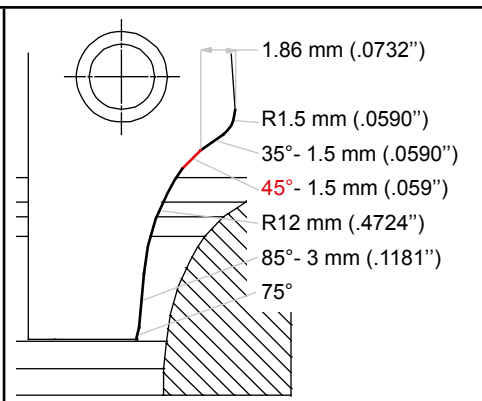
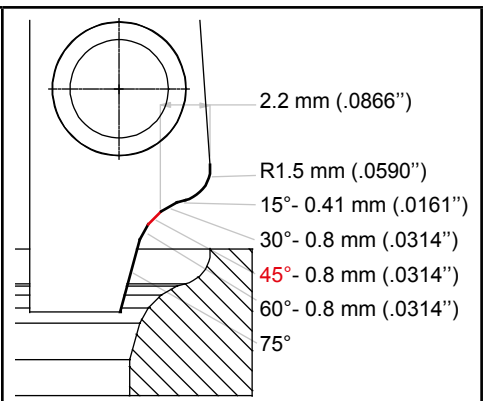
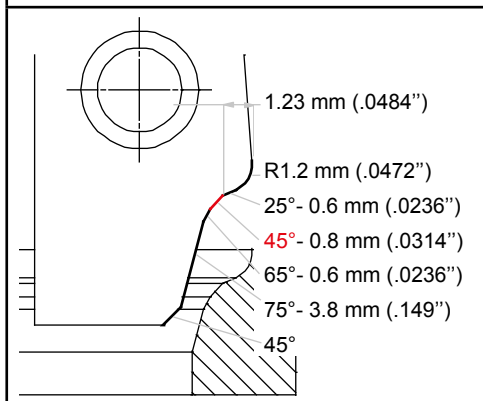
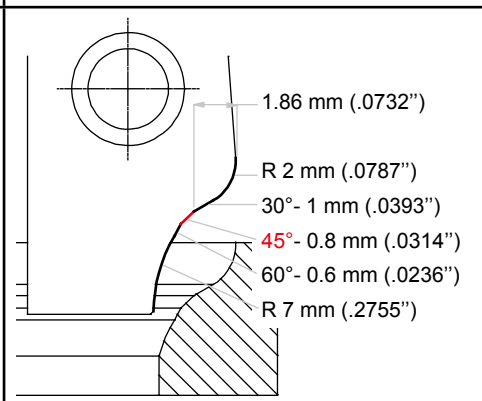
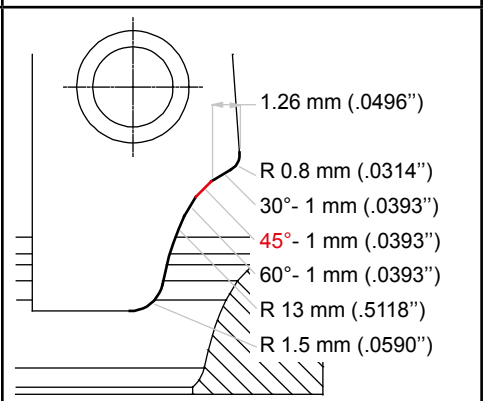
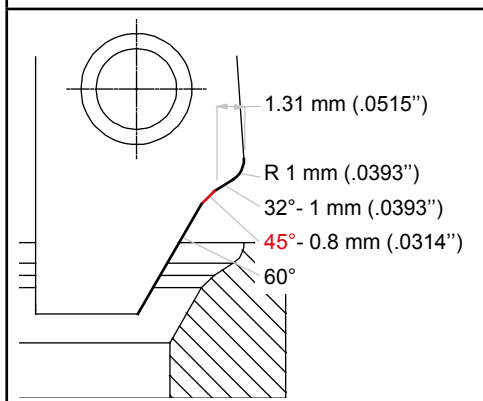
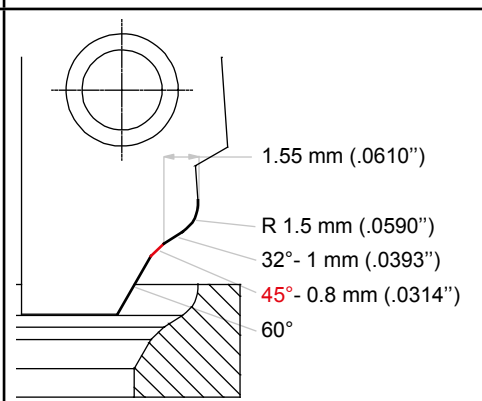
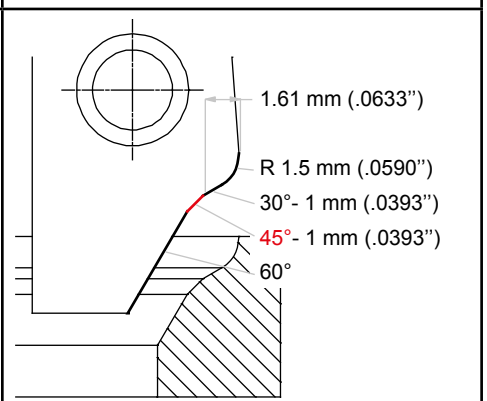


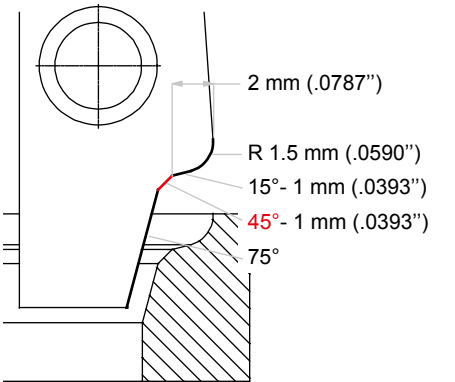
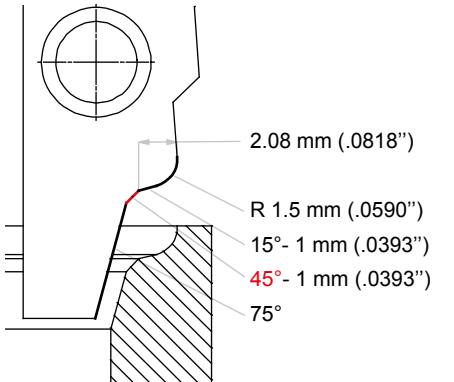
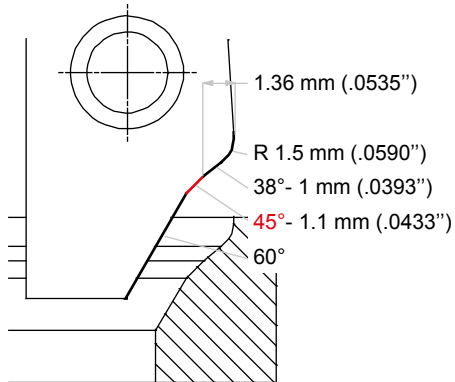
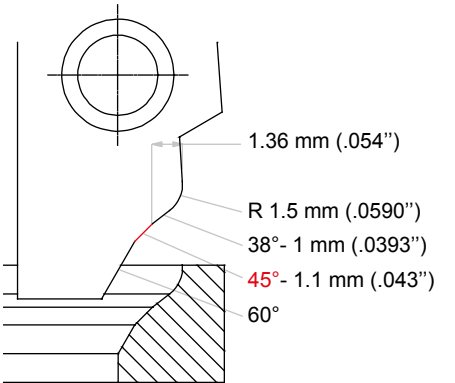
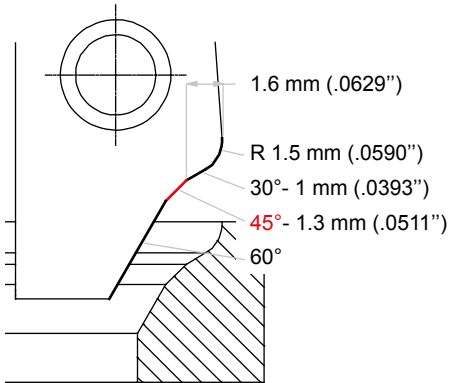
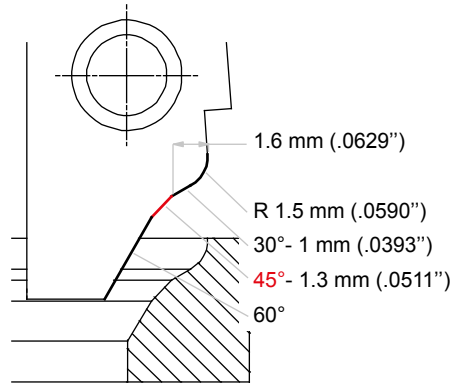
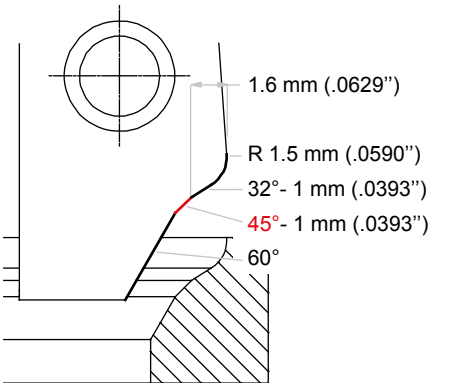
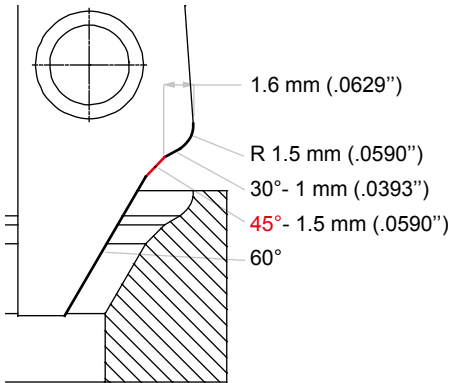
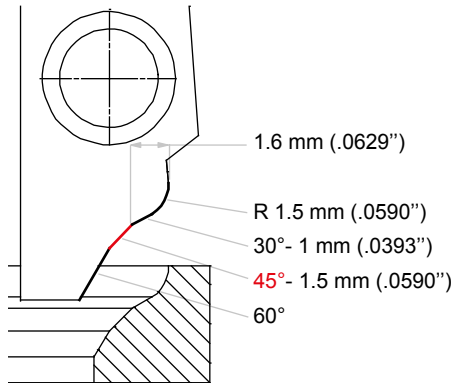
 4.69 mm (.1846") R 3.40 mm (.1338") 18° - 2.60 mm (.1024") 30° - 2.40 mm (.0945") 45° - 922717 EMDSC45-E2 022717 EMDSC45-E2 019172 EMDSC45-A1	 1.45 mm (.057") 18° - 1.52 mm (.059") 30° - 1.65 mm (.065") 45° - 1.02 mm (.04") R 10.67 mm (.42") - 028101 SC652-A1	 4.00 mm (.157") R1.8 mm (.0708") 20° - 3.00 mm (.1181") 30° - 2.3 mm (.0905") 65° - 025077 HP2706-B1

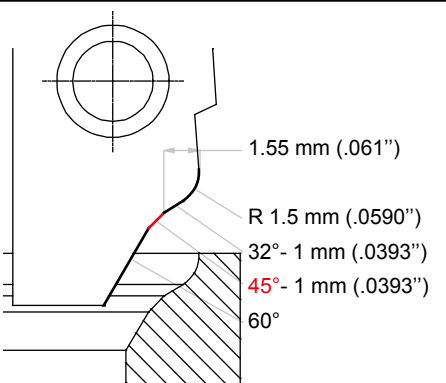
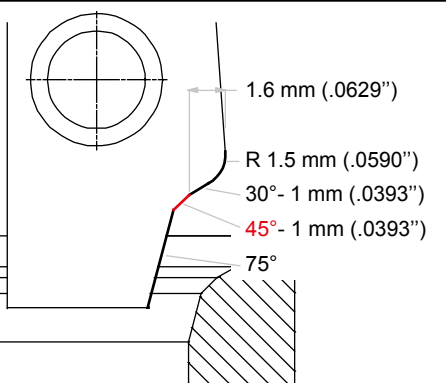
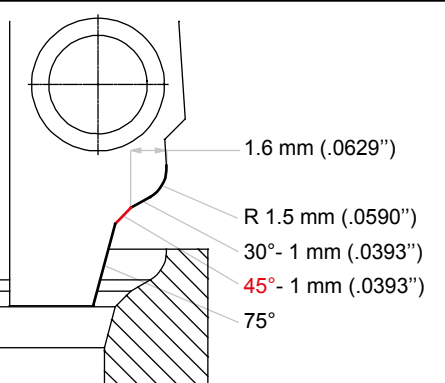
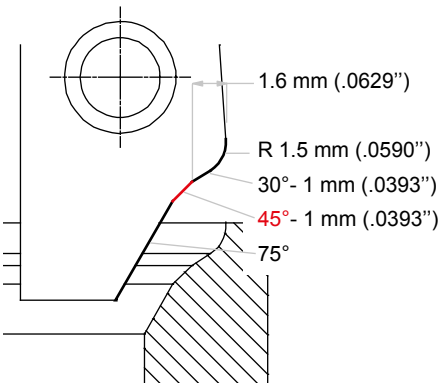
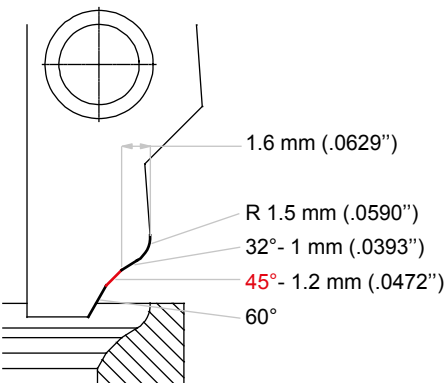
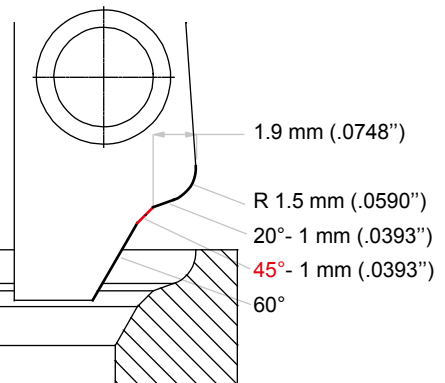
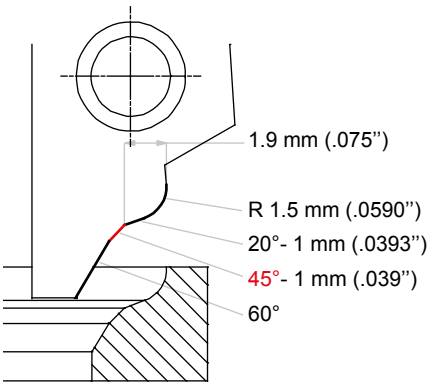
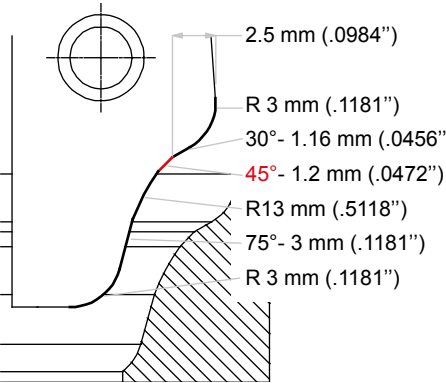
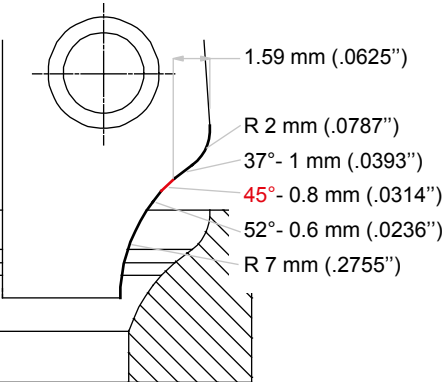
 2.52 mm (.0992") R2.5 mm (.0984") 38°- 2.4 mm (.0944") 45°- 1 mm (.0393") 60° 025448 ADS600-E1 924189 ADN600-E2 024189 ADP600-E2 013338 SC600-B1	 1.49 mm (.0586") R1 mm (.0393") 35°- 1.3 mm (.0511") 45°- 1 mm (.0393") 60°- 2.5 mm (.0984") 75° 025459 ADS601-E1 924190 ADN601-E2 024190 ADP601-E2 013342 SC601-B1	 2.06 mm (.0811") R1 mm (.0393") 35°- 2 mm (.0787") 45°- 1.3 mm (.0511") 56° 025460 ADS602-E1 924191 ADN602-E2 024191 ADP602-E2 013337 SC602-B1
 R12 mm (.4724") 45°- 6 mm (.2362") - - 927058 ADN603-E2 027058 ADP603-E3 013343 SC603-B1	 2.9 mm (.1141") R2 mm (.0787") 35°- 2.5 mm (.0984") 45°- 1.3 mm (.0511") 60°- 1.7 mm (.0669") 75°- 2.2 mm (.0866") 82° - - 925463 ADN604-E2 025463 ADP604-E2 013924 SC604-B1	 2.1 mm (.0826") 35°- 2.56 mm (.1007") 45°- 1 mm (.0393") 55°- 2.5 mm (.0984") 65°- 2.5 mm (.0984") 75° - - 925487 ADN605-E2 025487 ADP605-E2 013332 SC605-B2
 1.92 mm (.0755") 40°- 2.5 mm (.0984") 45°- 1.3 mm (.0511") 55°- 2.5 mm (.0984") 65°- 2.5 mm (.0984") 75° - - 927021 ADN606-E2 027021 ADP606-E2 001318 SC606-B1	 1.86 mm (.0732") R1.5 mm (.0590") 35°- 1.5 mm (.0590") 45°- 1.5 mm (.0590") R12 mm (.4724") 75°- 3 mm (.1181") R3.5 mm (.1377") 45° 026069 ADS607-E1 921301 ADN607-E2 021301 ADP607-E2 013327 SC607-B1	 1.9 mm (.0748") R1.5 mm (.0590") 35°- 1.54 mm (.0606") 45°- 1 mm (.0393") R12 mm (.4724") 75°- 3 mm (.1181") R3.5 mm (.1377") 45° 026070 ADS608-E1 921302 ADN608-E2 021302 ADP608-E2 019205 SC608-B1

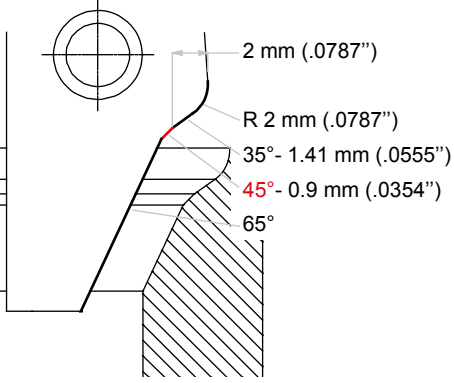
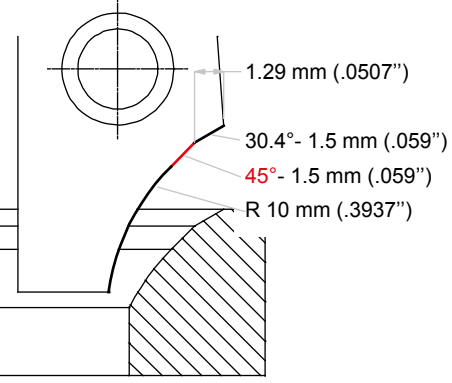
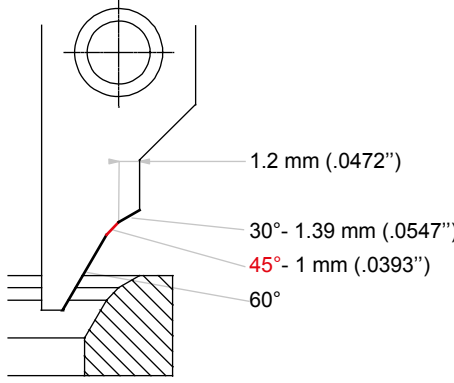
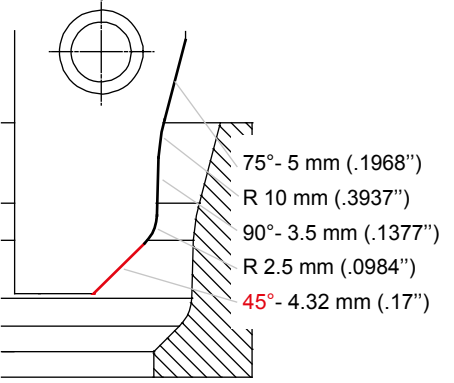
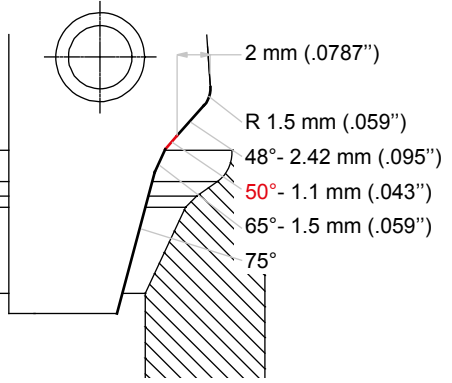
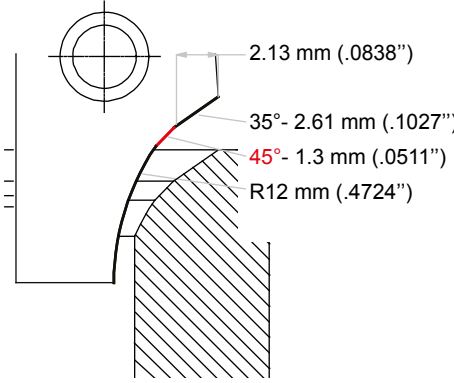
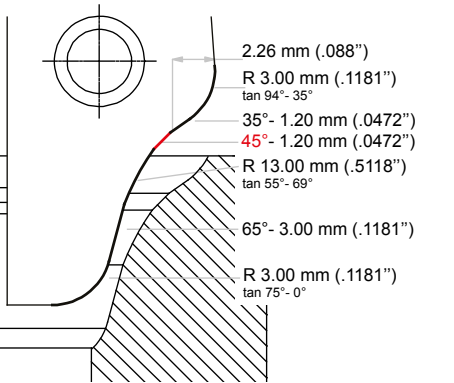
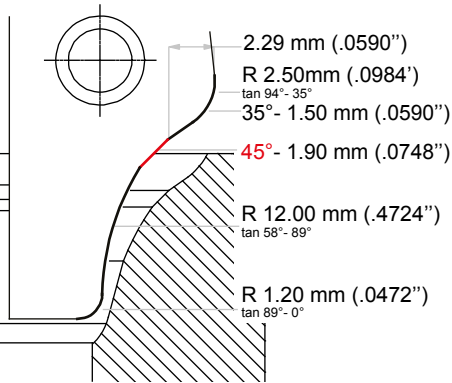
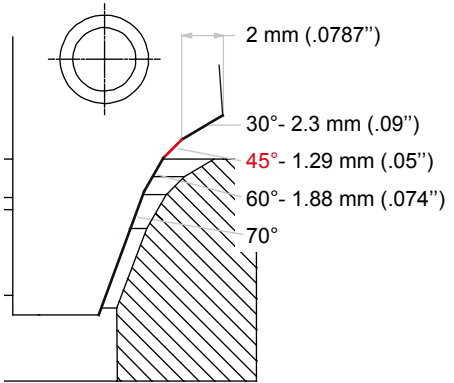
Standard cutting bits - the most popular profiles (see price lists) are registered in **red**.



 1.9 mm (.0748") R1.5 mm (.0590") 35°- 1.54 mm (.0606") 45°- 2.5 mm (.098") R12 mm (.4724") 75°- 3 mm (.1181") R3.5 mm (.1377") 45° - 925489 ADN609-E2 025489 ADP609-E2 025219 SC609-B1	 1.86 mm (.0732") R1.5 mm (.0590") 35°- 1.5 mm (.0590") 45°- 1.5 mm (.0590") R12 mm (.4724") 85°- 3 mm (.1181") 75° - 927023 ADN610-E3 027023 ADP610-E3 013923 SC610-B1	 2.2 mm (.0866") R1.5 mm (.0590") 15°- 0.41 mm (.0161") 30°- 0.8 mm (.0314") 45°- 0.8 mm (.0314") 60°- 0.8 mm (.0314") 75° 022270 ADS611-E1 925462 ADN611-E2 025462 ADP611-E2 013925 SC611-A1
 1.23 mm (.0484") R1.2 mm (.0472") 25°- 0.6 mm (.0236") 45°- 0.8 mm (.0314") 65°- 0.6 mm (.0236") 75°- 3.8 mm (.149") 45° 026284 ADS612-E1 925464 ADN612-E2 025464 ADP612-E2 024938 SC612-A1	 1.86 mm (.0732") R 2 mm (.0787") 30°- 1 mm (.0393") 45°- 0.8 mm (.0314") 60°- 0.6 mm (.0236") R 7 mm (.2755") 45° 022272 ADS613-E1 925465 ADN613-E2 025465 ADP613-E2 009806 SC613-A1	 1.26 mm (.0496") R 0.8 mm (.0314") 30°- 1 mm (.0393") 45°- 1 mm (.0393") 60°- 1 mm (.0393") R 13 mm (.5118") R 1.5 mm (.0590") 45° 025001 ADS623-E1 923369 ADN623-E2 023369 ADP623-E2 012834 SC623-A1
 1.31 mm (.0515") R 1 mm (.0393") 32°- 1 mm (.0393") 45°- 0.8 mm (.0314") 60° 026282 ADS624-E1 927024 ADN624-E2 027024 ADP624-E2 019523 SC624-A1	 1.55 mm (.0610") R 1.5 mm (.0590") 32°- 1 mm (.0393") 45°- 0.8 mm (.0314") 60° 026028 ADS625-E1 927012 ADN625-E2 027012 ADP625-E2 025192 SC625-A2	 1.61 mm (.0633") R 1.5 mm (.0590") 30°- 1 mm (.0393") 45°- 1 mm (.0393") 60° 023049 ADS626-E1 924016 ADN626-E2 024016 ADP626-E2 001260 SC626-A1

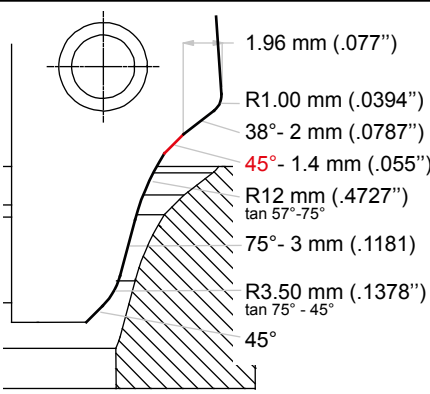
 2 mm (.0787") R 1.5 mm (.0590") 15° - 1 mm (.0393") 45° - 1 mm (.0393") 75° 025468 ADS627-E1 925469 ADN627-E2 025469 ADP627-E2 014887 SC627-A1	 2.08 mm (.0818") R 1.5 mm (.0590") 15° - 1 mm (.0393") 45° - 1 mm (.0393") 75° 026031 ADS628-E1 927031 ADN628-E2 027031 ADP628-E2 025220 SC628-A2	 1.36 mm (.0535") R 1.5 mm (.0590") 38° - 1 mm (.0393") 45° - 1.1 mm (.0433") 60° 025083 ADS629-E1 927128 ADN629-E2 027128 ADP629-E2 024943 SC629-A1
 1.36 mm (.054") R 1.5 mm (.0590") 38° - 1 mm (.0393") 45° - 1.1 mm (.043") 60° 026257 ADS630-E1 927118 ADN630-E2 027118 ADP630-E2 024901 SC630-A2	 1.6 mm (.0629") R 1.5 mm (.0590") 30° - 1 mm (.0393") 45° - 1.3 mm (.0511") 60° 025089 ADS631-E1 925471 ADN631-E2 025471 ADP631-E2 025490 SC631-A1	 1.6 mm (.0629") R 1.5 mm (.0590") 30° - 1 mm (.0393") 45° - 1.3 mm (.0511") 60° 025420 ADS632-E1 925473 ADN632-E2 025473 ADP632-E2 021857 SC632-A2
 1.6 mm (.0629") R 1.5 mm (.0590") 32° - 1 mm (.0393") 45° - 1 mm (.0393") 60° 026258 ADS633-E1 927064 ADN633-E2 027064 ADP633-E2 025474 SC633-A1	 1.6 mm (.0629") R 1.5 mm (.0590") 30° - 1 mm (.0393") 45° - 1.5 mm (.0590") 60° 025476 ADS634-E1 925477 ADN634-E2 025477 ADP634-E2 009474 SC634-A1	 1.6 mm (.0629") R 1.5 mm (.0590") 30° - 1 mm (.0393") 45° - 1.5 mm (.0590") 60° 025184 ADS635-E1 925478 ADN635-E2 025478 ADP635-E2 021859 SC635-A2

 1.55 mm (.061'') R 1.5 mm (.0590'') 32° - 1 mm (.0393'') 45° - 1 mm (.0393'') 60° 026194 ADS637-E1 927106 ADN637-E2 027106 ADP637-E2 024615 SC637-A2	 1.6 mm (.0629'') R 1.5 mm (.0590'') 30° - 1 mm (.0393'') 45° - 1 mm (.0393'') 75° 025479 ADS638-E1 925249 ADN638-E2 025249 ADP638-E2 021860 SC638-A1	 1.6 mm (.0629'') R 1.5 mm (.0590'') 30° - 1 mm (.0393'') 45° - 1 mm (.0393'') 75° 025480 ADS639-E1 927089 ADN639-E2 027089 ADP639-E2 021858 SC639-A2
 1.6 mm (.0629'') R 1.5 mm (.0590'') 30° - 1 mm (.0393'') 45° - 1 mm (.0393'') 75° 025481 ADS640-E1 927025 ADN640-E2 027025 ADP640-E2 025081 SC640-A1	 1.6 mm (.0629'') R 1.5 mm (.0590'') 32° - 1 mm (.0393'') 45° - 1.2 mm (.0472'') 60° 026032 ADS641-E1 927033 ADN641-E2 027033 ADP641-E2 021861 SC641-A2	 1.9 mm (.0748'') R 1.5 mm (.0590'') 20° - 1 mm (.0393'') 45° - 1 mm (.0393'') 60° 025483 ADS642-E1 925484 ADN642-E2 025484 ADP642-E2 028015 SC642-A1
 1.9 mm (.075'') R 1.5 mm (.0590'') 20° - 1 mm (.0393'') 45° - 1 mm (.039'') 60° 025485 ADS643-E1 927034 ADN643-E2 027034 ADP643-E2 030124 SC643-A2	 2.5 mm (.0984'') R 3 mm (.1181'') 30° - 1.16 mm (.0456'') 45° - 1.2 mm (.0472'') R13 mm (.5118'') 75° - 3 mm (.1181'') R 3 mm (.1181'') - 927115 ADN644-E2 027115 ADP644-E2 022129 SC644-B1	 1.59 mm (.0625'') R 2 mm (.0787'') 37° - 1 mm (.0393'') 45° - 0.8 mm (.0314'') 52° - 0.6 mm (.0236'') R 7 mm (.2755'') 025000 ADS645-E1 927130 ADN645-E2 027130 ADP645-E2 022130 SC645-A1

 2 mm (.0787") R 2 mm (.0787") 35° - 1.41 mm (.0555") 45° - 0.9 mm (.0354") 65° 025493 ADS646-E1 925494 ADN646-E2 025494 ADP646-E2 024986 SC646-B1	 1.29 mm (.0507") 30.4° - 1.5 mm (.059") 45° - 1.5 mm (.059") R 10 mm (.3937") - - 925691 ADN647-E2 025691 ADP647-E2 025222 SC647-A1	 1.2 mm (.0472") 30° - 1.39 mm (.0547") 45° - 1 mm (.0393") 60° 027998 ADS648-E1 927999 ADN648-E2 027999 ADP648-E2 013378 SC648-B4
 75° - 5 mm (.1968") R 10 mm (.3937") 90° - 3.5 mm (.1377") R 2.5 mm (.0984") 45° - 4.32 mm (.17") - - 924192 ADN649-E3 024192 ADP649-E3 023437 SC649-B3	 2 mm (.0787") R 1.5 mm (.059") 48° - 2.42 mm (.095") 50° - 1.1 mm (.043") 65° - 1.5 mm (.059") 75° - - - - - - 035013 SC650-B1	 2.13 mm (.0838") 35° - 2.61 mm (.1027") 45° - 1.3 mm (.0511") R12 mm (.4724") - - 922519 HP1953-E2 022519 HP1953-E2 019160 HP1953-B1
 2.26 mm (.088") R 3.00 mm (.1181") tan 94° - 35° 35° - 1.20 mm (.0472") 45° - 1.20 mm (.0472") R 13.00 mm (.5118") tan 55° - 69° 65° - 3.00 mm (.1181") R 3.00 mm (.1181") tan 75° - 0° - - - - - - 024897 HP2944-B1	 2.29 mm (.0590") R 2.50 mm (.0984") tan 94° - 35° 35° - 1.50 mm (.0590") 45° - 1.90 mm (.0748") R 12.00 mm (.4724") tan 58° - 89° R 1.20 mm (.0472") tan 89° - 0° - - - - - - 025268 HP3343-B1	 2 mm (.0787") 30° - 2.3 mm (.09") 45° - 1.29 mm (.05") 60° - 1.88 mm (.074") 70° - - - - - - 025269 HP3344-B1

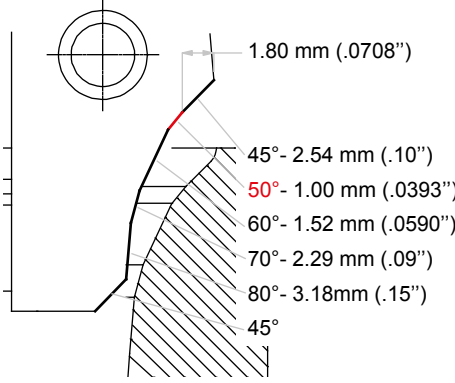
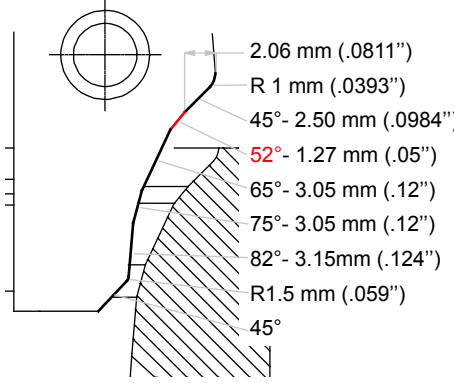
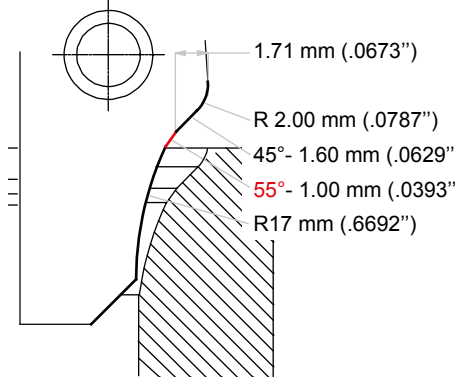
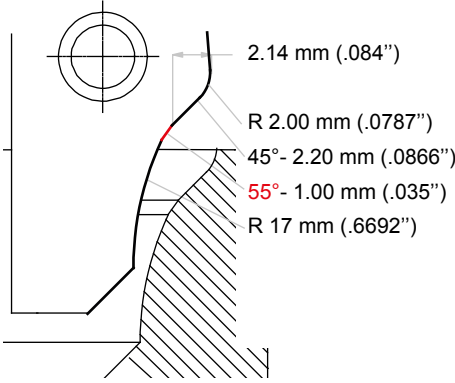
Standard cutting bits - the most popular profiles (see price lists) are registered in **red**.



 1.96 mm (.077'') R1.00 mm (.0394'') 38° - 2 mm (.0787'') 45° - 1.4 mm (.055'') R12 mm (.4727'') tan 57°-75° 75° - 3 mm (.1181) R3.50 mm (.1378'') tan 75° - 45° 45° - - - - - - 030182 HP2113-B1		

Cutting bits performance 50°-52°-55°



 1.80 mm (.0708") 45° - 2.54 mm (.10") 50° - 1.00 mm (.0393") 60° - 1.52 mm (.0590") 70° - 2.29 mm (.09") 80° - 3.18mm (.15") 45° - - - 025887 SC653-B1	 2.06 mm (.0811") R 1 mm (.0393") 45° - 2.50 mm (.0984") 52° - 1.27 mm (.05") 65° - 3.05 mm (.12") 75° - 3.05 mm (.12") 82° - 3.15mm (.124") R1.5 mm (.059") 45° - - - 025714 HP2977-B1	 1.71 mm (.0673") R 2.00 mm (.0787") 45° - 1.60 mm (.0629") 55° - 1.00 mm (.0393") R17 mm (.6692") - - - 024819 SC656-B1
 2.14 mm (.084") R 2.00 mm (.0787") 45° - 2.20 mm (.0866") 55° - 1.00 mm (.035") R 17 mm (.6692") - - - 029668 SC658-B1		



A1 type order form

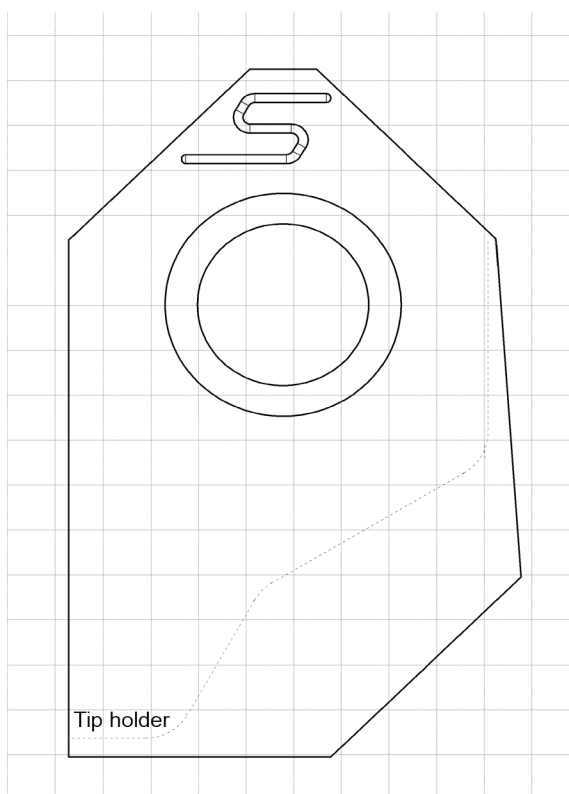
Customer name: _____

Contact name: _____

Tel: _____ Date: _____

1mm
0.039"
☐

A1



Negative rake angle
8° draft angle

☐ special draft angle: _____

☐ intake

☐ exhaust

Cylinder head model -
engine type:

Additional request:

Please draw the requested profile on the above blank and indicate the segments n°

Segment n°	Length	Angle	Radius	Tan 1	Tan 2
1					
2					
3					
4					
5					
6					
7					
8					
9					

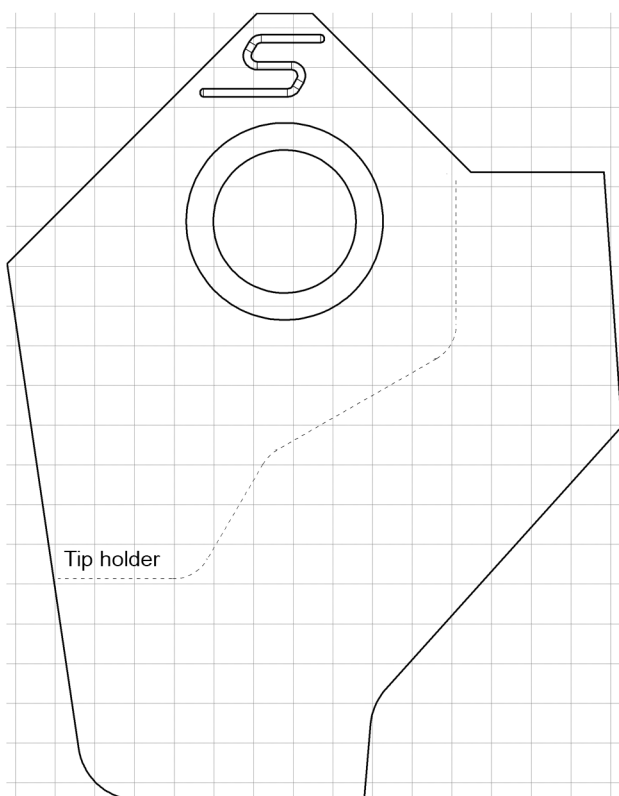
B1 type order form

Customer name: _____

Contact name: _____

Tel: _____ Date: _____

1mm
0.039"



B1

Negative rake angle
8° draft angle

- ☐ intake
☐ exhaust

Cylinder head model -
engine type:

Additional request:

Please draw the requested profile on the above blank and indicate the segments n°

Segment n°	Length	Angle	Radius	Tan 1	Tan 2
1					
2					
3					
4					
5					
6					
7					
8					
9					

D1 type order form

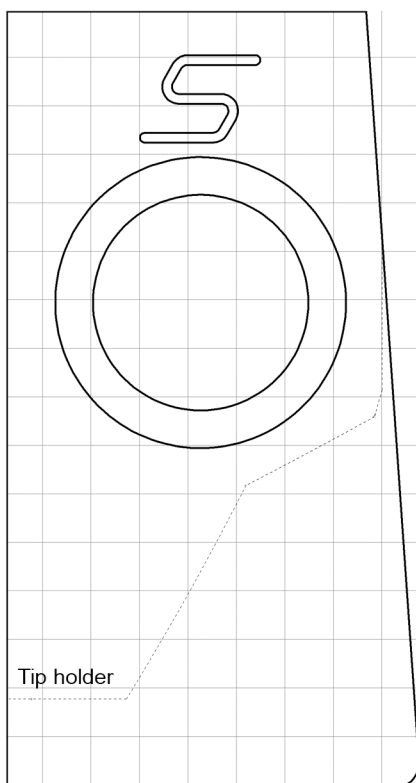
Customer name: _____

Contact name: _____

Tel: _____ Date: _____

1mm
0.039"

D1



Negative rake angle
8° draft angle

- ☐ intake
☐ exhaust

Cylinder head model -
engine type:

Additional request:

Please draw the requested profile on the above blank and indicate the segments n°

Segment n°	Length	Angle	Radius	Tan 1	Tan 2
1					
2					
3					
4					
5					
6					
7					
8					
9					

E2 type order form

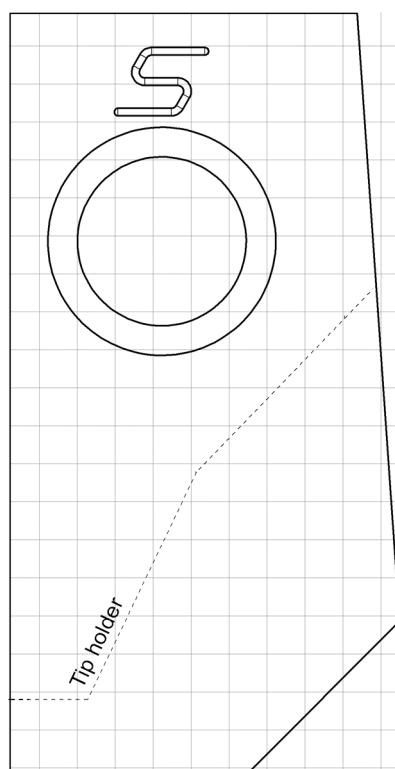
Customer name: _____

Contact name: _____

Tel: _____ Date: _____

1mm
0.039" ☐

E2



☐ Negative rake angle
8° draft angle (#9XXXXXX)

☐ Positive 8° rake angle
14° draft angle (#0XXXXX)

☐ intake
☐ exhaust

Cylinder head model -
engine type:

Additional request:

Please draw the requested profile on the above blank and indicate the segments n°

Segment n°	Length	Angle	Radius	Tan 1	Tan 2
1					
2					
3					
4					
5					
6					
7					
8					
9					

E3 type order form

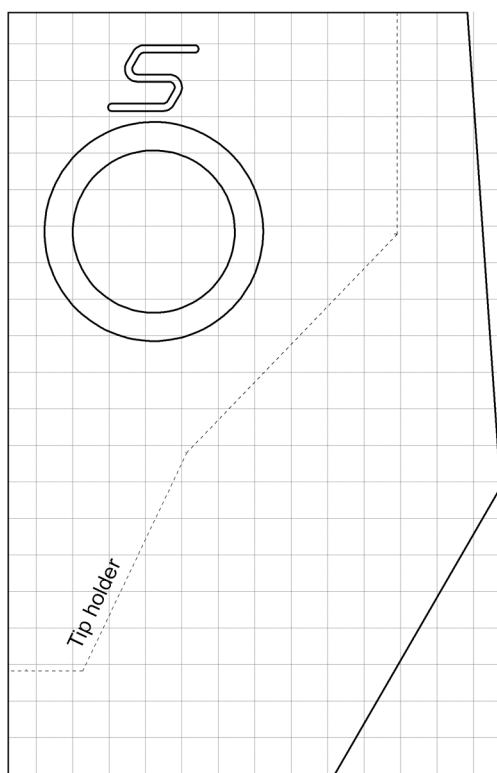
Customer name: _____

Contact name: _____

Tel: _____ Date: _____

1mm
0.039"
☐

E3



☐ Negative rake angle
8° draft angle (#9XXXXX)

☐ Positive 8° rake angle
14° draft angle (#0XXXXX)

☐ intake
☐ exhaust

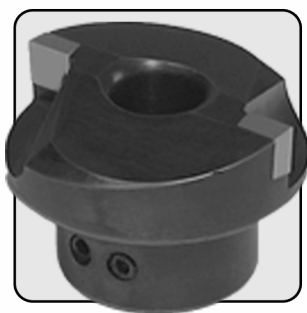
Cylinder head model -
engine type:

Additional request:

Please draw the requested profile on the above blank and indicate the segments n°

Segment n°	Length	Angle	Radius	Tan 1	Tan 2
1					
2					
3					
4					
5					
6					
7					
8					
9					

Brazed milling heads cutters

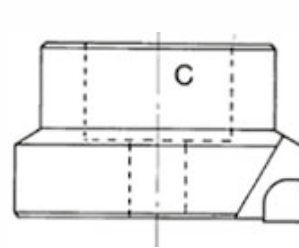
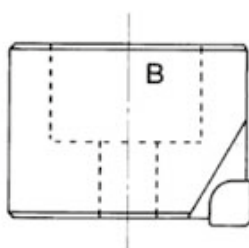
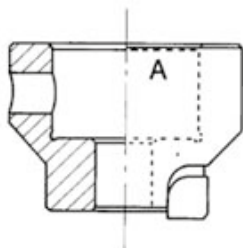


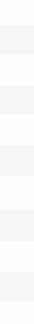
Milling cutter for valve seat pocket counterboring.

To use with **SERDI 5100F** and **SERDI 57 MC** tool holders.

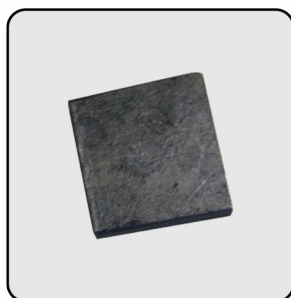
To each “**FS**” milling head corresponds an “**SS**” valve seat insert.
No Press Fit Adjustment Required.

The mentioned diameters are the external diameter of the seats. The milling cutter achieves a counterbore giving an interference fit of 0.16 mm on the diameter.

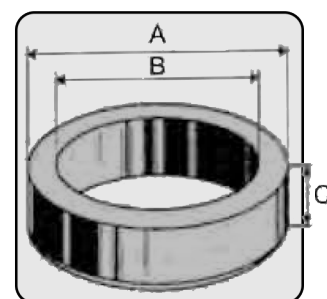


Metric Milling Head								
001738	FS 993	A	20 mm		001751	FS 1005	A	33 mm
001739	FS 994	A	21 mm		001752	FS 1006	A	34 mm
001740	FS 995	A	22 mm		001753	FS 1007	A	35 mm
001741	FS 996	A	23 mm		001754	FS 1008	A	36 mm
001742	FS 997	A	24 mm		001755	FS 1009	A	37 mm
001743	FS 998	A	25 mm		001756	FS 1010	A	38 mm
001744	FS 999	A	26 mm		001757	FS 1011	A	39 mm
001745	FS 1000	A	27 mm		001758	FS 1012	A	40 mm
001746	FS 1001	A	28 mm		001759	FS 1013	A	41 mm
001747	FS 1001S	A	29 mm		001760	FS 1014	B	42 mm
001748	FS 1002	A	30 mm		001761	FS 1015	B	43 mm
001749	FS 1003	A	31 mm		001762	FS 1016	C	44 mm
001750	FS 1004	A	32 mm		001763	FS 1017	C	45 mm

001799 Square for milling head



	Reference	Seat Diameter A		Seat Diameter B		Seat Dimension C	
		mm	inch	mm	inch	mm	inch
1	005983	20,00	0,7874	14,00	0,5512	10,00	0,3937
2	005984	20,50	0,8071	14,00	0,5512	10,00	0,3937
3	005985	21,00	0,8268	15,00	0,5906	10,00	0,3937
4	005986	21,50	0,8465	15,00	0,5906	10,00	0,3937
5	005987	22,00	0,8661	16,00	0,6299	10,00	0,3937
6	005988	22,50	0,8858	16,00	0,6299	10,00	0,3937
7	005989	23,00	0,9055	17,00	0,6693	10,00	0,3937
8	005990	23,50	0,9252	17,00	0,6693	10,00	0,3937
9	005991	24,00	0,9449	18,00	0,7087	10,00	0,3937
10	005992	24,50	0,9646	18,00	0,7087	10,00	0,3937
11	005993	25,00	0,9843	19,00	0,7480	10,00	0,3937
12	005994	25,50	1,0039	19,00	0,7480	10,00	0,3937
13	005995	26,00	1,0236	20,00	0,7874	10,00	0,3937
14	005996	26,50	1,0433	20,00	0,7874	10,00	0,3937
15	005997	27,00	1,0630	21,00	0,8268	10,00	0,3937
16	005998	27,50	1,0827	21,00	0,8268	10,00	0,3937
17	005999	28,00	1,1024	22,00	0,8661	10,00	0,3937
18	006000	28,50	1,1220	22,00	0,8661	10,00	0,3937
19	006001	29,00	1,1417	23,00	0,9055	10,00	0,3937
20	006002	29,50	1,1614	23,00	0,9055	10,00	0,3937
21	010483	30,00	1,1811	20,00	0,7874	10,00	0,3937
22	006003	30,00	1,1811	23,00	0,9055	10,00	0,3937
23	006004	30,50	1,2008	23,00	0,9055	10,00	0,3937
24	010484	31,00	1,2205	21,00	0,8268	10,00	0,3937
25	006005	31,00	1,2205	24,00	0,9449	10,00	0,3937
26	006006	31,50	1,2402	24,00	0,9449	10,00	0,3937
27	010485	32,00	1,2598	22,00	0,8661	10,00	0,3937
28	006007	32,00	1,2598	25,00	0,9843	10,00	0,3937
29	006008	32,50	1,2795	25,00	0,9843	10,00	0,3937
30	010486	33,00	1,2992	23,00	0,9055	10,00	0,3937
31	006009	33,00	1,2992	26,00	1,0236	10,00	0,3937
32	006010	33,50	1,3189	26,00	1,0236	10,00	0,3937
33	010487	34,00	1,3386	24,00	0,9449	10,00	0,3937
34	006011	34,00	1,3386	27,00	1,0630	10,00	0,3937
35	006012	34,50	1,3583	27,00	1,0630	10,00	0,3937
36	010488	35,00	1,3780	25,00	0,9843	10,00	0,3937
37	006013	35,00	1,3780	28,00	1,1024	10,00	0,3937
38	006014	35,50	1,3976	28,00	1,1024	10,00	0,3937
39	010489	36,00	1,4173	26,00	1,0236	10,00	0,3937
40	006015	36,00	1,4173	29,00	1,1417	10,00	0,3937
41	006016	36,50	1,4370	29,00	1,1417	10,00	0,3937
42	010490	37,00	1,4567	27,00	1,0630	10,00	0,3937
43	006017	37,00	1,4567	30,00	1,1811	10,00	0,3937
44	006018	37,50	1,4764	30,00	1,1811	10,00	0,3937
45	010491	38,00	1,4961	28,00	1,1024	10,00	0,3937
46	006019	38,00	1,4961	31,00	1,2205	10,00	0,3937
47	006020	38,50	1,5157	31,00	1,2205	10,00	0,3937
48	010492	39,00	1,5354	29,00	1,1417	10,00	0,3937
49	006021	39,00	1,5354	32,00	1,2598	10,00	0,3937
50	013756	39,10	1,5394	33,00	1,2992	7,00	0,2756
51	006022	39,50	1,5551	32,00	1,2598	10,00	0,3937

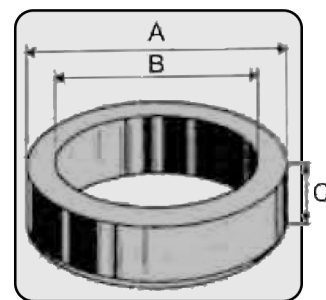


Valve seat inserts **all carburations***

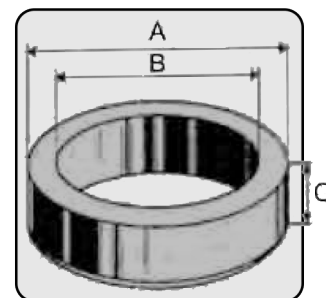
***except LPG**



Reference	Seat Diameter A		Seat Diameter B		Seat Dimension C	
	mm	inch	mm	inch	mm	inch
1 010493	40,00	1,5748	29,00	1,1417	10,00	0,3937
2 014964	40,00	1,5748	30,00	1,1811	9,50	0,3740
3 006023	40,00	1,5748	32,00	1,2598	10,00	0,3937
4 010990	40,00	1,5748	32,00	1,2598	11,00	0,4331
5 013761	40,25	1,5846	34,00	1,3386	7,00	0,2756
6 006024	40,50	1,5945	32,00	1,2598	10,00	0,3937
7 010494	41,00	1,6142	30,00	1,1811	10,00	0,3937
8 006025	41,00	1,6142	33,00	1,2992	10,00	0,3937
9 006026	41,50	1,6339	33,00	1,2992	10,00	0,3937
10 010495	42,00	1,6535	31,00	1,2205	10,00	0,3937
11 006027	42,00	1,6535	34,00	1,3386	10,00	0,3937
12 006028	42,50	1,6732	34,00	1,3386	10,00	0,3937
13 010496	43,00	1,6929	32,00	1,2598	10,00	0,3937
14 012806	43,00	1,6929	35,00	1,3780	7,50	0,2953
15 006029	43,00	1,6929	35,00	1,3780	10,00	0,3937
16 006030	43,50	1,7126	35,00	1,3780	10,00	0,3937
17 010497	44,00	1,7323	33,00	1,2992	10,00	0,3937
18 006031	44,00	1,7323	36,00	1,4173	10,00	0,3937
19 010498	44,50	1,7520	30,00	1,1811	10,00	0,3937
20 006032	44,50	1,7520	36,00	1,4173	10,00	0,3937
21 010499	45,00	1,7717	34,00	1,3386	12,00	0,4724
22 006033	45,00	1,7717	37,00	1,4567	12,00	0,4724
23 013757	45,10	1,7756	39,00	1,5354	9,00	0,3543
24 013755	45,15	1,7776	37,00	1,4567	6,50	0,2559
25 006034	45,50	1,7913	37,00	1,4567	12,00	0,4724
26 013753	45,65	1,7972	37,00	1,4567	7,50	0,2953
27 010500	46,00	1,8110	34,00	1,3386	12,00	0,4724
28 013758	46,00	1,8110	38,00	1,4961	8,50	0,3346
29 006035	46,00	1,8110	38,00	1,4961	12,00	0,4724
30 006036	46,50	1,8307	38,00	1,4961	12,00	0,4724
31 010344	47,00	1,8504	35,00	1,3780	9,00	0,3543
32 010501	47,00	1,8504	36,00	1,4173	12,00	0,4724
33 012807	47,00	1,8504	39,00	1,5354	7,50	0,2953
34 006037	47,00	1,8504	39,00	1,5354	12,00	0,4724
35 006038	47,50	1,8701	39,00	1,5354	12,00	0,4724
36 013760	47,60	1,8740	41,00	1,6142	7,00	0,2756
37 010502	48,00	1,8898	37,00	1,4567	12,00	0,4724
38 009803	48,00	1,8898	38,00	1,4961	11,00	0,4331
39 006039	48,00	1,8898	40,00	1,5748	12,00	0,4724
40 010506	48,50	1,9094	40,00	1,5748	12,00	0,4724
41 010503	49,00	1,9291	38,00	1,4961	12,00	0,4724
42 006040	49,00	1,9291	41,00	1,6142	12,00	0,4724
43 009804	49,50	1,9488	42,00	1,6535	11,00	0,4331
44 010504	50,00	1,9685	38,00	1,4961	12,00	0,4724
45 010345	50,00	1,9685	39,00	1,5354	12,00	0,4724
46 006041	50,00	1,9685	41,00	1,6142	12,00	0,4724
47 010507	51,00	2,0079	42,00	1,6535	12,00	0,4724
48 010508	51,00	2,0079	49,00	1,9291	12,00	0,4724
49 009729	52,00	2,0472	40,00	1,5748	12,00	0,4724
50 007175	52,00	2,0472	43,00	1,6929	12,00	0,4724
51 013752	52,15	2,0531	42,00	1,6535	7,50	0,2953

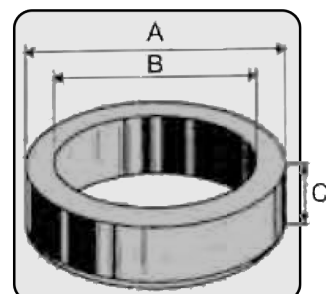


Reference	Seat Diameter A		Seat Diameter B		Seat Dimension C	
	mm	inch	mm	inch	mm	inch
1 010509	53,00	2,0866	41,00	1,6142	12,00	0,4724
2 011657	53,00	2,0866	42,00	1,6535	10,50	0,4134
3 013687	53,25	2,0965	42,00	1,6535	10,50	0,4134
4 010510	54,00	2,1260	42,00	1,6535	12,00	0,4724
5 013754	54,15	2,1319	46,00	1,8110	6,50	0,2559
6 010511	55,00	2,1654	43,00	1,6929	13,00	0,5118
7 010346	55,00	2,1654	44,00	1,7323	12,00	0,4724
8 010512	56,00	2,2047	44,00	1,7323	13,00	0,5118
9 018395	56,20	2,2126	46,50	1,8307	9,50	0,3740
10 009730	57,00	2,2441	45,00	1,7717	12,00	0,4724
11 010513	57,00	2,2441	45,00	1,7717	13,00	0,5118
12 010514	58,00	2,2835	46,00	1,8110	13,00	0,5118
13 010515	59,00	2,3228	47,00	1,8504	13,00	0,5118
14 010516	60,00	2,3622	46,00	1,8110	13,00	0,5118
15 014782	61,00	2,4016	47,00	1,8504	13,00	0,5118
16 015781	61,00	2,4016	49,00	1,9291	11,50	0,4528
17 014783	62,00	2,4409	48,00	1,8898	13,00	0,5118
18 015782	62,00	2,4409	50,00	1,9685	11,50	0,4528
19 014784	63,00	2,4803	49,00	1,9291	13,00	0,5118
20 014785	64,00	2,5197	50,00	1,9685	13,00	0,5118
21 014786	65,00	2,5591	51,00	2,0079	13,00	0,5118



Valve seat inserts **chrome turbo**

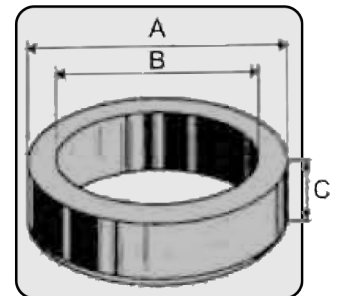
Reference	Seat Diameter A		Seat Diameter B		Seat Dimension C	
	mm	inch	mm	inch	mm	inch
1 SS0993-B	20,00	0,7874	12,00	0,4724	7,50	0,2953
2 SS0994-B	21,00	0,8268	13,00	0,5118	7,50	0,2953
3 SS0995-B	22,00	0,8661	14,00	0,5511	7,50	0,2953
4 SS0996-B	23,00	0,9055	15,00	0,5906	7,50	0,2953
5 SS0997-B	24,00	0,9449	16,00	0,6299	8,00	0,3150
6 SS0998-B	25,00	0,9843	17,00	0,6693	8,00	0,3150
7 SS1000-B	27,00	1,0630	19,00	0,7480	8,00	0,3150
8 SS1001-B	28,00	1,1024	20,00	0,7874	8,00	0,3150
9 SS1016-B	44,00	1,7323	34,00	1,3386	9,50	0,3740
10 SS1023-B	51,00	2,0079	40,00	1,5748	10,50	0,4134
11 SS1028-B	56,00	2,2047	45,00	1,7717	11,00	0,4331
12 SS1031-B	59,00	2,3228	48,00	1,8898	11,00	0,4331
13 SS1032-B	60,00	2,3622	48,00	1,8898	11,50	0,4528
14 SS1036-B	64,00	2,5197	52,00	2,0472	11,50	0,4528



Valve seat inserts **nickel gas special LPG**



Reference	Seat Diameter A		Seat Diameter B		Seat Dimension C	
	mm	inch	mm	inch	mm	inch
1 SS1001-A	28,00	1,1024	20,00	0,7874	8,00	0,3150
2 SS1002-A	30,00	1,1811	22,00	0,8661	8,50	0,3346
3 SS1003-A	31,00	1,2205	23,00	0,9055	8,50	0,3346
4 SS1004-A	32,00	1,2598	24,00	0,9449	8,50	0,3346
5 SS1005-A	33,00	1,2992	25,00	0,9843	8,50	0,3346
6 SS1006-A	34,00	1,3386	26,00	1,0236	8,50	0,3346
7 SS1007-A	35,00	1,3780	26,00	1,0236	9,00	0,3543
8 SS1008-A	36,00	1,4173	27,00	1,0630	9,00	0,3543
9 SS1009-A	37,00	1,4567	28,00	1,1024	9,00	0,3543
10 SS1010-A	38,00	1,4961	29,00	1,1417	9,00	0,3543
11 SS1011-A	39,00	1,5354	30,00	1,1811	9,00	0,3543
12 SS1012-A	40,00	1,5748	30,00	1,1811	9,50	0,3740
13 SS1013-A	41,00	1,6142	31,00	1,2205	9,50	0,3740
14 SS1014-A	42,00	1,6535	32,00	1,2598	9,50	0,3740
15 SS1015-A	43,00	1,6929	33,00	1,2992	9,50	0,3740
16 SS1016-A	44,00	1,7323	34,00	1,3386	9,50	0,3740
17 SS1017-A	45,00	1,7717	34,50	1,3583	10,00	0,3937
18 SS1018-A	46,00	1,8110	35,50	1,3976	10,00	0,3937
19 SS1019-A	47,00	1,8504	36,50	1,4370	10,00	0,3937
20 SS1020-A	48,00	1,8898	37,50	1,4764	10,00	0,3937
21 SS1021-A	49,00	1,9291	38,50	1,5157	10,00	0,3937
22 SS1022-A	50,00	1,9685	39,00	1,5354	10,50	0,4134
23 SS1023-A	51,00	2,0079	40,00	1,5748	10,50	0,4134
24 SS1024-A	52,00	2,0472	41,00	1,6142	10,50	0,4134
25 SS1025-A	53,00	2,0866	42,00	1,6535	10,50	0,4134
26 SS1026-A	54,00	2,1260	43,00	1,6929	10,50	0,4134
27 SS1027-A	55,00	2,1654	44,00	1,7323	11,00	0,4331
28 SS1028-A	56,00	2,2047	45,00	1,7717	11,00	0,4331
29 SS1029-A	57,00	2,2441	46,00	1,8110	11,00	0,4331
30 SS1030-A	58,00	2,2835	47,00	1,8504	11,00	0,4331
31 SS1031-A	59,00	2,3228	48,00	1,8898	11,00	0,4331
32 SS1032-A	60,00	2,3622	48,00	1,8898	11,50	0,4528
33 SS1033-A	61,00	2,4016	49,00	1,9291	11,50	0,4528
34 SS1034-A	62,00	2,4409	50,00	1,9685	11,50	0,4528
35 SS1035-A	63,00	2,4803	51,00	2,0079	11,50	0,4528
36 SS1036-A	64,00	2,5197	52,00	2,0472	11,50	0,4528
37 SS1037-A	65,00	2,5591	53,00	2,0866	11,50	0,4528
38 SS1038-A	68,00	2,6772	55,00	2,1654	12,00	0,4724
39 SS1039-A	70,00	2,7559	57,00	2,2441	12,00	0,4724



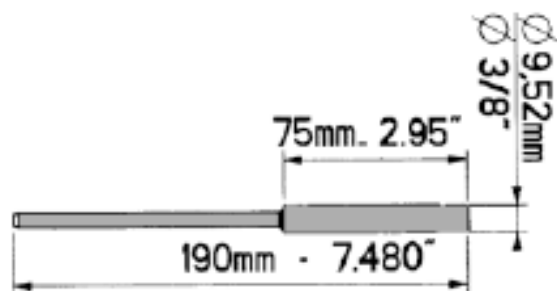


The range of genuine SERDI Tungsten Carbide Pilots guarantees unmatched centering accuracy.

SERDI pilots range starts from $\varnothing 3.5$ mm / .140" to $\varnothing 20$ mm / .787" in 0,005 mm / .0002" increments.

The tolerance on the centering diameter is ± 0.002 mm / .00007".

The standard shank of 9.52 mm / .375" makes these pilots compatible with most of the competitors machines on the market today.



Pilots CL type

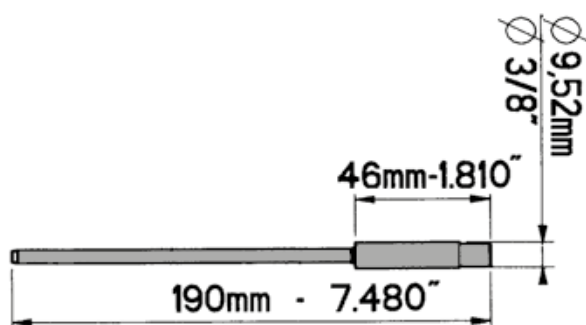
Carbide Long shank, for Tool Holder # :
5100 – 5300 – 5700 – 5710

CL pilot available from:

- $\varnothing 3.5$ mm / 0,138" to $\varnothing 14$ mm / 0.550" maximum

Standard length 190mm / 7.480"

For a $\varnothing 9.02$ mm pilot, order part # : CL 9.02



Pilots CS type

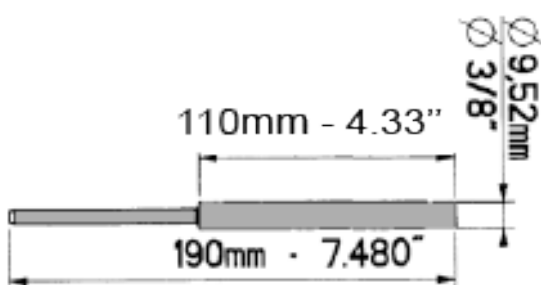
Carbide Short pilot, for Serdi Micro 2000 and Micro-Magnet

CS pilot available from:

- $\varnothing 3.5$ mm / 0,138" to $\varnothing 14$ mm / 0.550" maximum

Standard length 190mm / 7.480"

For a $\varnothing 6.20$ mm pilot, order part # : CL 6.20



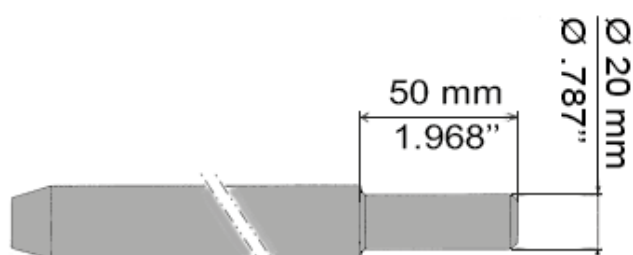
Pilots CLS type

Carbide Longer Shank pilot for an improved rigidity on small diameters.

CLS pilot available from:

- $\varnothing 3.5$ mm / 0,138" to $\varnothing 7$ mm / 0.550" maximum

Standard length 190mm / 7.480"



Pilots E type

Hardened steel or carbide. For Tool Holder # : **5731**
For marine, locomotive and heavy duty applications :

CL pilot available from

- $\varnothing 14$ mm / 0.551" to $\varnothing 22,50$ mm / 0.886" maximum

Standard lengths: **225mm** / 8.858", **250mm** / 9.483" and **300mm** / 11.811"

For a $\varnothing 15.00$ mm pilot with length of 225 mm, order part # : E15.00-225 and indicate the material

CSD pilot order form

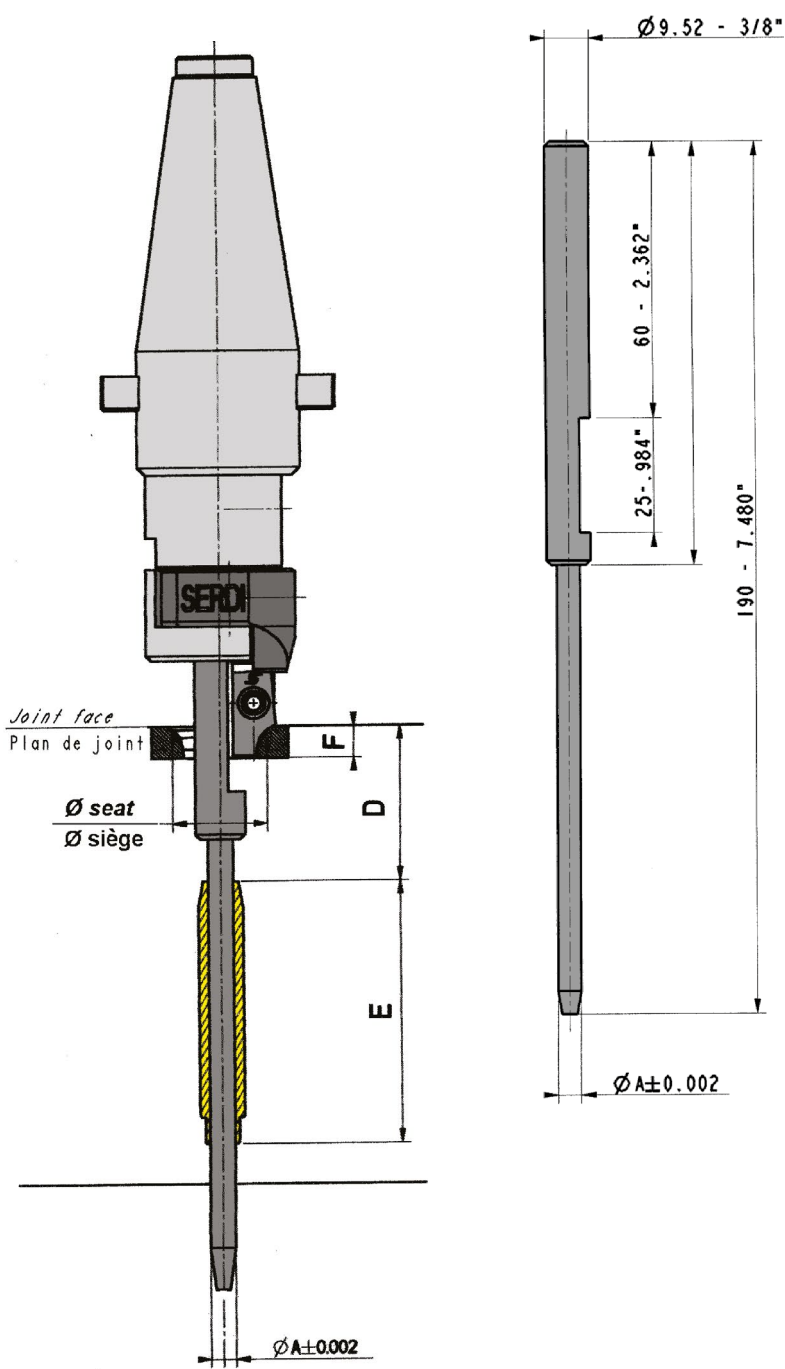
Customer name: _____

Contact name: _____

Tel: _____

Date: _____

SIGNATURE



Carbide **S**mall **D**iameter

Allows to improve the rigidity of pilots for guides of small diameters.

Accommodates only :

- tool holders **5700** and bit holders **2700**
- tool holders **5710** and bit holders **2710**

Pilot diameter **ØA:** ±0.002

Seat inner diameter

D dimension

E dimension

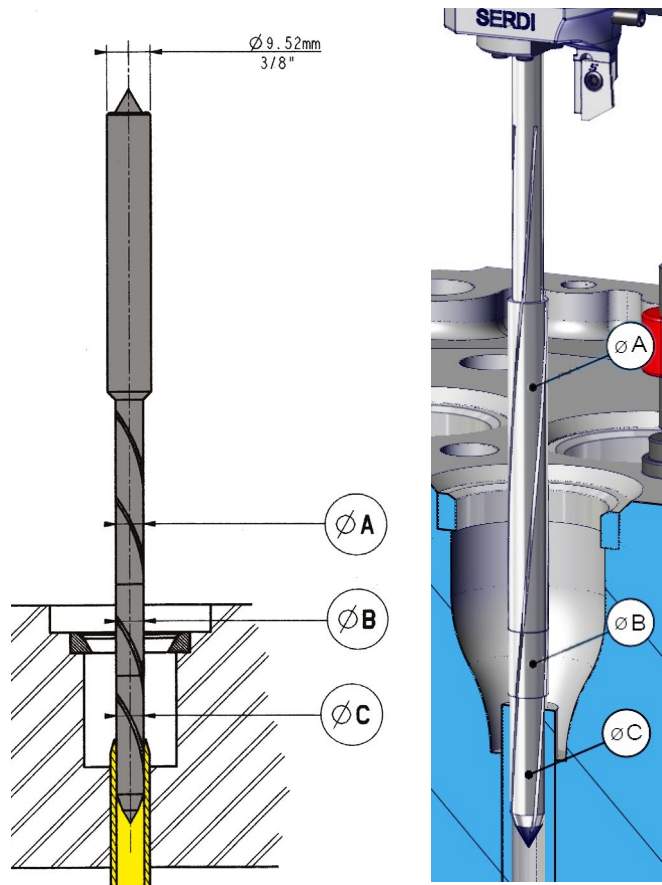
F dimension

Quantity to order

☐ exhaust

☐ intake

Motor type



SERDI Reamer Special 3 stage

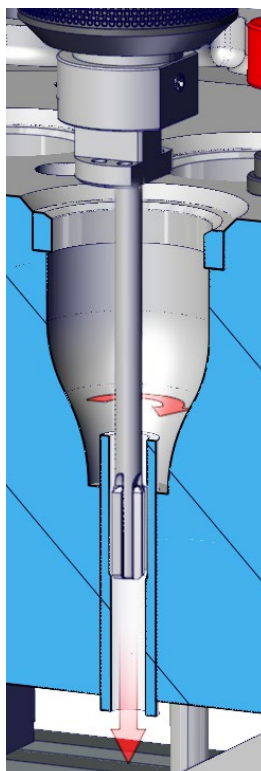
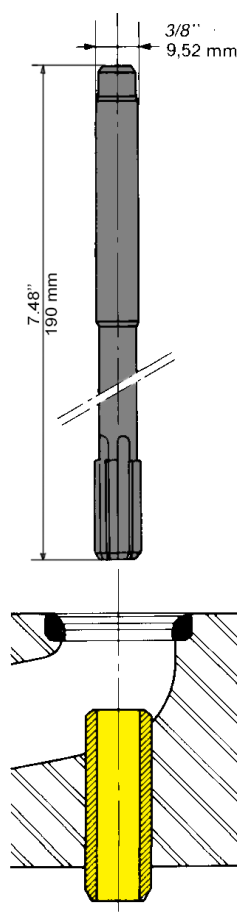
Carbide reamer for valve guide and valve seat finishing in one spindle travel and/or guide housing and seat pocket counterboring.

- 1- The front section **C** is a pilot for centering into the unfinished diameter.
- 2- The section **B** ream the guide to size in H7 tolerance.
- 3- After a quick re-centering, the second pilot, section **A**, drives the spindle in perfect alignment with the newly reamed guide.
- 4- Keeping the spindle feeding down, the valve seat is machined perfectly concentric to the guide

Fits any tool-holder Ø 9.52 mm / 3/8".
Fits on Newen shanks.

For more info, ask for our Technical Bulletin n°57
To order, please see the next page

Reamers **RN type**



SERDI Reamer Normal

Carbide reamer for valve guide or guide housing finishing.

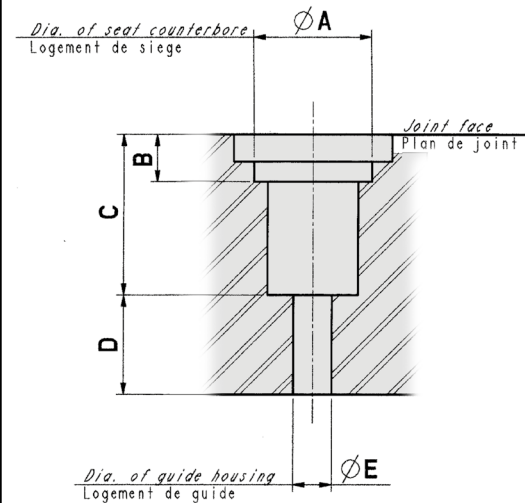
A preliminary centering with a pilot in the used guide is necessary.

Any diameter from 6mm to 16mm in 0.01mm increment in H7 tolerance.

Fits any tool holder with a
Ø 9.52 mm / 3/8"

For more info, ask for our Technical Bulletin n°57
For a Ø 6.99 mm reamer, order part # : RN 6.99

Reamers Order form for guide housing reamer - RS type



Customer name: _____

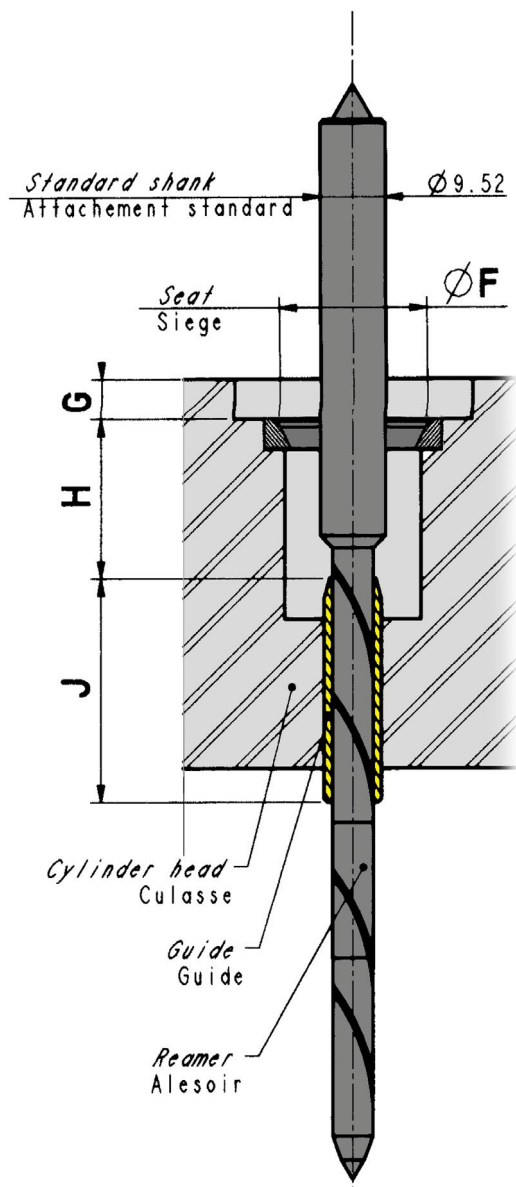
Tel: _____ Date: _____

Dimensions (mm)

A	B	C	D	E	
				before reaming	after reaming

Cylinder head material: ☐ aluminium ☐ intake

Reamers Order form for ID guide reamer - RS type



Dimensions (mm)

F	G	H	J

Cylinder head material: ☐ aluminium ☐ cast iron

Guide material

Diameter and tolerance of guide before reaming

Diameter and tolerance of guide after reaming

Quantity to order

☐ exhaust

☐ intake

Motor type



customerservice@serdi-usa.com
1-800-447-3790 (toll free)

notes

This image shows a single page from a notebook or ledger. The page is white with rounded corners and features horizontal ruling lines spaced evenly down its length. There are no vertical margin lines, and the page is completely blank except for the lines.

customerservice@serdi-usa.com
1-800-447-3790 (toll free)

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General conditions of sale

MACHINES SERDI S.A.

All prices are quoted in EURO and are enduser's net prices.
All prices are to be understood : EX-WORKS (EXW incoterms 2010) ANNECY
For any other incoterms, we shall submit our best quotation upon request.

PAYMENT TERMS :

If no specific payment terms have been agreed upon, payment is to be understood as «irrevocable letter of credit»

Our Bank name and address are as follows :

CREDIT LYONNAIS
UAC LYON 1 ENTREPRISES
UMBC 23130 SERVICE COMEX
136, Cours LAFAYETTE
LYON CEDEX 03

INSPECTION :

If independent inspection should be required (SGS, BUREAU VERITAS, CALEB BRETT or similar) it will be charged to the importer's.

GUARANTEE :

MACHINES SERDI guarantees all parts of its equipment, to the original purchaser, for one full year from date of shipment (except as provided below) against defects in material or workmanship, when the equipment is installed in strict accordance with its particular specifications. MACHINES SERDI will repair and/or replace free of charge (Ex works) all such defective parts, ONLY when returned to the factory in Annecy France, with shipping charges PREPAID. This guarantee DOES NOT COVER damage caused by accident, abuse or faulty installation nor repair or replacement of parts worn or consumed in normal operation of the machine. Additionally, this guarantee does not cover such items as Diamond Tools, Ball Bearings, Grinding Wheels, Belts, Carbide Tool Bits and other accessory items, except at the discretion of MACHINES SERDI. This guarantee is at no time construed to mean the entire machine.

CANCELLATION OF ORDER :

Cancellation of order must be in writing and returned to the factory before shipment.

SHORTAGE OR LOST GOODS :

Any claims for shortages or loss must be reported within 10 days from receipt of shipment. Claims for transit loss or damage are the responsibility of the carrier according to the incoterm required by the importer.

RETURN MERCHANDISE POLICY :

- Merchandise may not be returned to MACHINES SERDI without written or verbal approval.
- Customer MUST contact the Export Departement to receive authorization.
- Merchandise authorized for return must be returned at customer's charge along with a copy of the invoice(s) or delivery note.
- Returning the goods DOES NOT guarantee credit.
- Credit for return merchandise is at the sole discretion of MACHINES SERDI.
- Credit if any will be issued ONLY after inspection of returned goods.

PRICES AND TERMS ARE SUBJECT TO CHANGE WITHOUT NOTICE



SERDI

seat and guide machines



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74012 Annecy Cedex
France



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Email: export@serdi.com

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Mooresville
North Carolina 28117
USA



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customerservice@serdi-usa.com

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Aviation



Stationary engines:



Marine:



Racing:



Motorcycle:



Automotive:



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- Werkzeugmaschinen

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