



STROJÍRNY
POLDI



HSS METALL CUTTING TOOLS



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The information contained in this catalogue are based on the current product design and manufacturing proceses and is for informative purposes only.

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since 1889
"Great history. Excellent future"



**STROJÍRNY
POLDI**



TOOL BITS

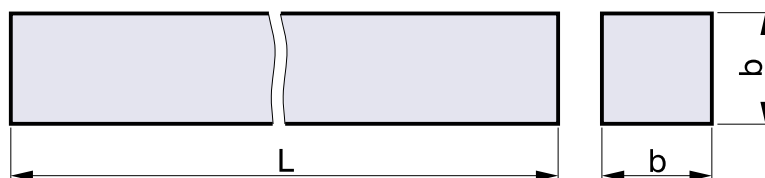
SECTION		STEEL GRADE	TOLERANCE
	223690	HSS	h 14
		HSSE Co5	h 14
		HSSE Co10	h 13
	223691	HSS	h 14
		HSSE Co10	h 13
	223692	HSS	h 14
		HSSE Co10	h 13, h 8
	223693	HSS	h 14
		HSSE Co10	h 13 / DIN h 12/
	223694	HSS	h 11 / k 13
		HSSE Co10	h 11 / k 13
	223695	HSS	h 12
		HSSE Co10	h 12

Alternative workmanship e.g. faces under different angles with tools 223690, 223691, 223693, different section and length tolerances and different hardness values, are possible as well. Please contact us.

LENGTH TOLERANCE	HARDNESS
± 2 mm	HSS min. 63 HRc
	HSSE Co5 min. 63 HRc
	HSSE Co10 min. 65 HRc



SQUARE SECTION
code 223690
FORM B



HSS
HSSE Co5
HSSE Co10

b x b	L								
	63	80	100	125	150	160	200	250	300
4x4									
5x5									
6x6									
7x7									
8x8									
10x10									
12x12									
14x14									
16x16									
18x18									
20x20									
25x25									
32x32									
40x40									

Note:
Dimensions in metric

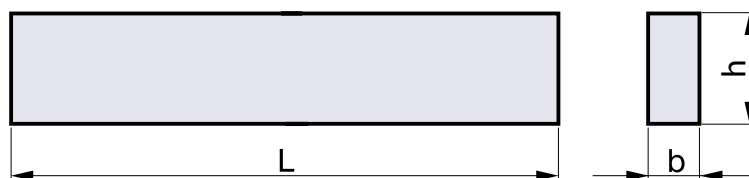
b x b	L							
	2 1/2	3	4	5	6	8	10	12
5/32x5/32								
3/16x3/16								
1/4x1/4								
5/16x5/16								
3/8x3/8								
7/16x7/16								
1/2x1/2								
5/8x5/8								
3/4x3/4								
1x1								
1 1/4x1 1/4								



ORDERING PROCEDURE:

Tool bit 223690, b x b x L, steel grade, number of pieces

RECTANGULAR SECTION
code 223691
FORM D



HSS
 HSSE Co10

h x b	L						
	63	80	100	125	150	160	200
6x4							
8x2							
3							
4							
5							
10x3							
4							
5							
6							
8							
12x3							
4							
5							
6							
8							
10							
14x3							
4							
5							
6							
8							
10							
15x3							
4							
5							
6							
8							
10							
12							
16x3							
4							
5							
6							
8							
10							
12							
18x3							
4							

RECTANGULAR SECTION
code 223691
FORM D

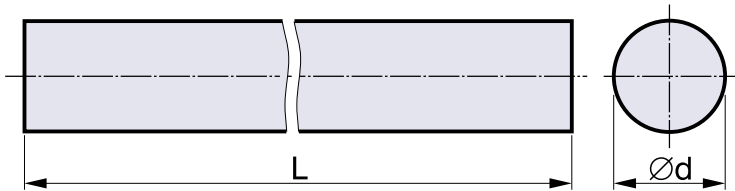
h x b	L						
	100	125	150	160	200	250	300
18x5							
6							
8							
10							
12							
20x3							
4							
5							
6							
8							
10							
12							
14							
16							
25x5							
6							
8							
10							
12							
16							
20							
30x6							
8							
10							
12							
15							
20							
25							
32x6							
8							
10							
12							
16							
40x6							
8							
10							
12							
50x8							
10							
12							

NOTE:
All products can be delivered also with dimensions in inches. Please contact us.



ORDERING PROCEDURE:
Tool bit 223691, h x b x L, steel grade, number of pieces

CIRCULAR SECTION
code 223692
FORM A



HSS
HSSE Co10

Ød	L								
	40	63	80	100	125	150	160	200	250
3									
4									
5									
6									
8									
10									
12									
14									
16									
18									
20									
25									
30									

NOTE:

All products can be delivered also with dimensions in inches. Please contact us.

ORDERING PROCEDURE:



Tool bit 223692, d x L, steel grade, number of pieces (for HSS Co10 please provide also the required tolerance)

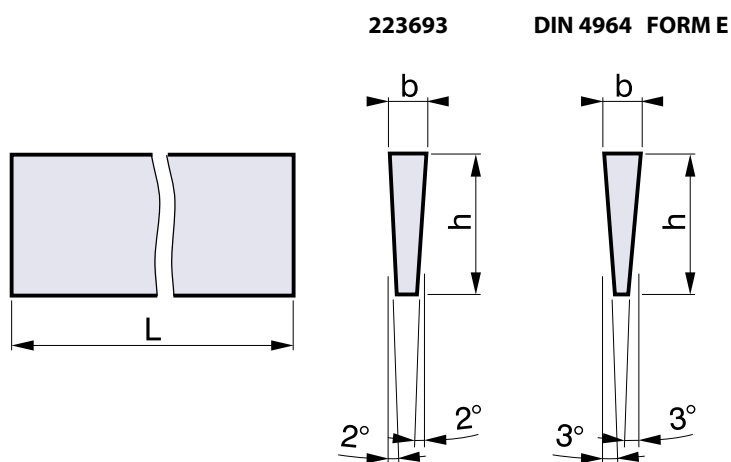
REGULAR TRAPEZOIDAL SECTION

code 223693

FORM E

PARTING OFF BLADES

DOUBLE BEVEL

HSS
HSSE Co10

h x b	L						
	80	100	125	150	160	200	250
6x1,6							
8x2							
10x2,5							
12x3							
15x3							
15x4							
16x3							
16x4							
18x3							
18x4							
20x3							
20x4							
20x5							
25x5							
25x6							
32x8							
40x10							

NOTE:

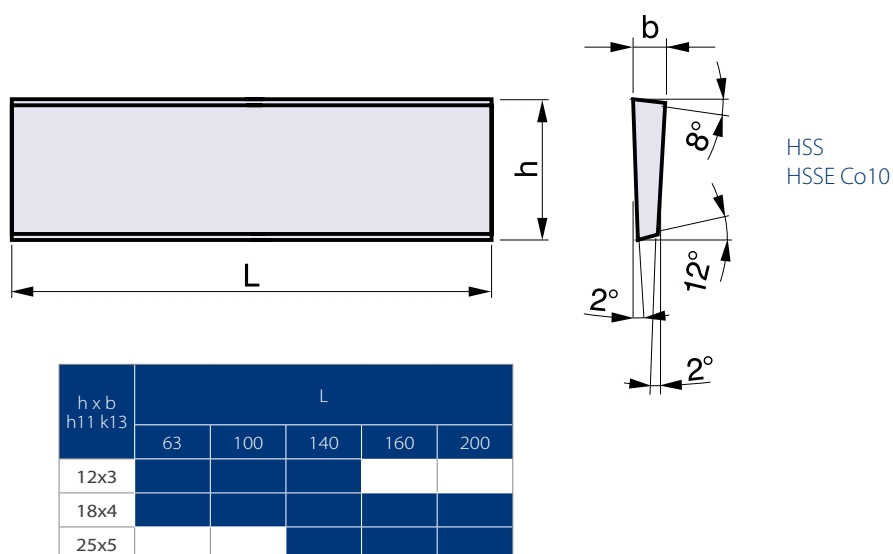
All products can be delivered also with dimensions in inches. Please contact us.

**ORDERING PROCEDURE:**

Tool bit 223693 or DIN 4964 FORM E, h x b x L, steel grade, number of pieces

PARTING OFF BLADES DOUBLE BEVEL

IRREGULAR TRAPEZOIDAL SECTION code 223694



ORDERING PROCEDURE:

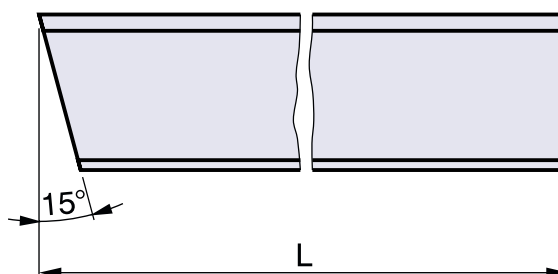
Cutting-off tool 223694, h x b x L, steel grade, number of pieces



PARTING OFF BLADES

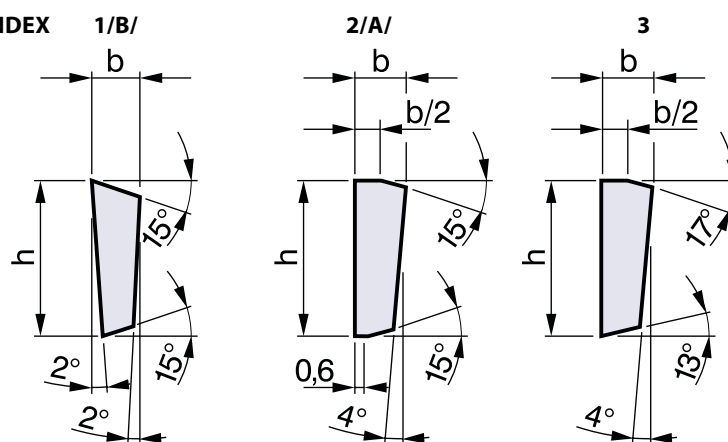
IRREGULAR TRAPEZOIDAL SECTION code 223695 INDEX-FORM

HSS
HSSE Co10



h x b	L					
	85	100	120	140	160	200
12x3						
12x4						
12x5						
16x3						
16x4						
16x6						
18x4						
18x6						
20x3						
20x4						
20x5						
20x6						
25x4						
25x6						

INDEX



NOTE:

All products can be delivered also with dimensions in inches.
Please contact us.

ORDERING PROCEDURE:

Cutting-off tool 223695, h x b x L, INDEX, steel grade, number of pieces





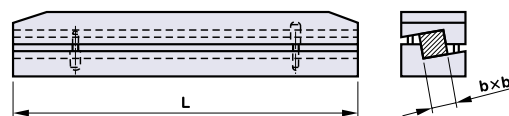
TOOL HOLDERS



TOOL BITS HOLDER
code 241598
FORM knife B



NUMBER	b x b
0	4 - 6
1	7 - 9
2	10 - 12
3	13 - 16
4	17 - 19



ORDERING PROCEDURE:

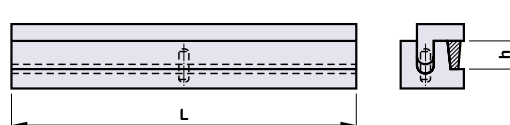
Holder 241598, number, number of pieces



TOOL BITS HOLDER
code 241599
BIT FORM E



NUMBER	h
1	6
2	8 - 10
3	12 - 18
4	20 - 25
5	32 - 40



ORDERING PROCEDURE:

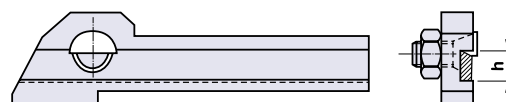
Holder 241599, number, number of pieces .



CUTTING-OFF TOOL HOLDER
FOR TOOLS INDEX FORM
223695



NUMBER	h
1	12
2	16
3	18
4	20
5	25
6	1/2"
7	5/8"
8	3/4"
9	7/8"
10	1"



ORDERING PROCEDURE:

Holder FOR TOOLS INDEX FORM 223695, number, number of pieces



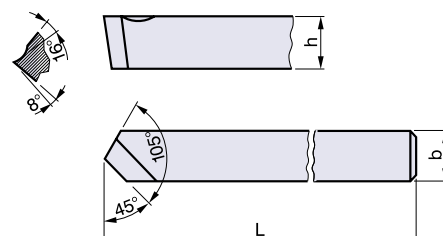


TURNING TOOLS



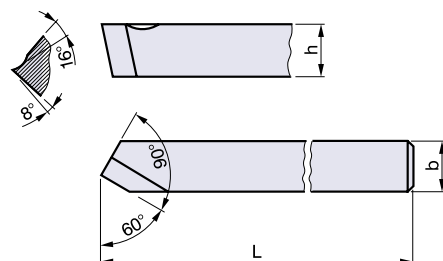
STRAIGHT ROUGHER – 45°
code 223514 - right
code 223515 - left

h	b	L	WORKMANSHIP
10	10	90	compact
12	12	100	
16	16	110	butt welded or with cutting tip HSS
20	20	125	
25	25	140	
32	32	170	
40	40	200	
50	32	240	



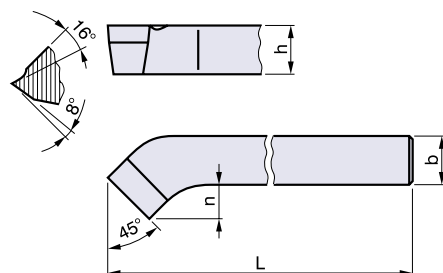
STRAIGHT ROUGHER – 60°
code 223516 - right
code 223517 - left

h	b	L	WORKMANSHIP
10	10	90	compact
12	12	100	
16	16	110	butt welded or with cutting tip HSS
20	20	125	
25	25	140	
32	32	170	
40	40	200	
50	32	240	



BENT ROUGHER
code 223520 - right
code 223521 - left

h	b	n	L	WORKMANSHIP
10	10	6	90	compact
12	12	8	100	
16	16	10	110	butt welded or with cutting tip HSS
20	20	14	125	
25	25	18	140	
32	32	22	170	
40	40	28	200	
50	32	22	240	



TURNING TOOLS

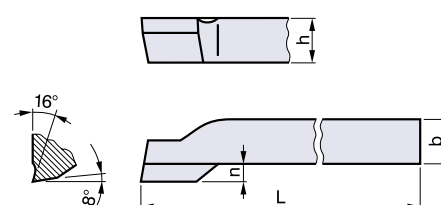
SIDE TOOL

code 223524 - right

code 223525 - left



h	b	n	L	WORKMANSHIP
10	10	4	90	compact
12	12	5	100	
16	16	6	110	butt welded or with cutting tip HSS
20	20	8	125	
25	25	10	140	
32	32	12	170	
40	40	14	200	

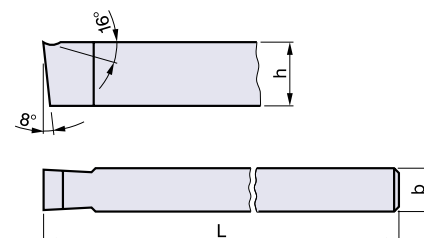


GROOVING TOOL

code 223530



h	b	L	WORKMANSHIP
20	12	125	butt welded or with cutting tip HSS
25	16	140	
32	20	170	
40	25	200	
50	32	240	

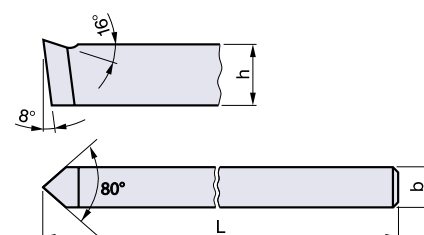


SMOOTHING TOOL

code 223532



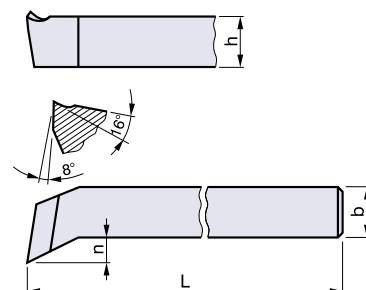
h	b	L	WORKMANSHIP
16	10	110	compact
20	12	125	butt welded or with cutting tip HSS
25	16	140	
32	20	170	
40	25	200	





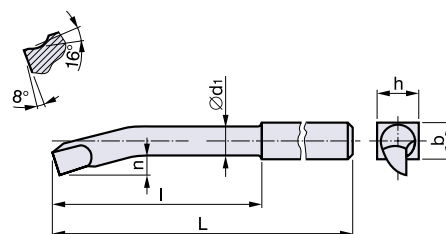
CORNER TOOL
code 223534 - right
code 223535 - left

h	b	n	L	WORKMANSHIP
10	10	5	90	compact
12	12	6	100	
16	16	8	110	butt welded or with cutting tip HSS
20	20	10	125	
25	25	12	140	
32	32	16	170	
40	40	20	200	compact
16	10	5	110	
20	12	6	125	butt welded or with cutting tip HSS
25	16	8	140	
32	20	10	170	
40	25	12	200	



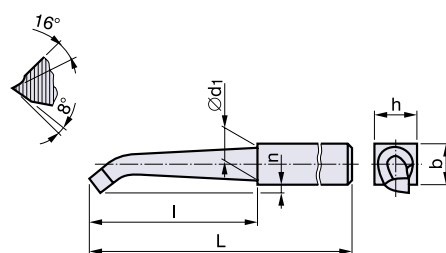
INSIDE ROUGHER
code 223540

h	b	Ød1	n	l	L	WORKMANSHIP
25	25	20	10	125	300	butt welded nebo or with cutting tip
32	32	25	12	160	355	



INSIDE ROUGHER
code 223542

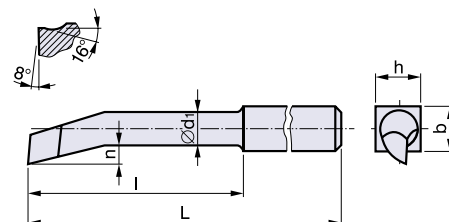
h	b	Ød1	n	l	L	WORKMANSHIP
10	10	8	3	40	100	compact
12	12	10	3,5	50	125	
16	16	13		63	140	butt welded or with cutting tip HSS
20	20	16	4	80	160	



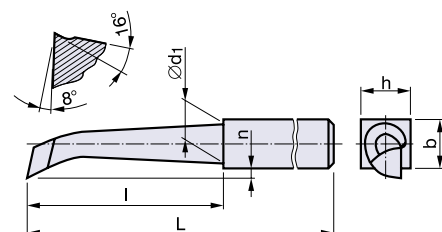
TURNING TOOLS


INSIDE CORNER TOOL
code 223544

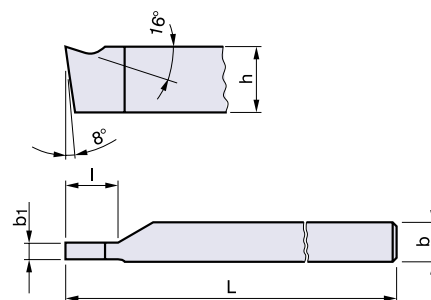
h	b	Ød1	n	l	L	WORKMANSHIP
25	25	20	10	125	300	butt welded or with cutting tip HSS
32	32	25	12	160	355	


INSIDE CORNER TOOL
code 223548


h	b	Ød1	n	l	L	WORKMANSHIP
10	10	8	3	40	100	compact
12	12	10	3,5	50	125	
16	16	13		63	140	butt welded or with cutting tip HSS
20	20	16	4	80	160	


PARTING TOOL
code 223550 - right
code 223551 - left

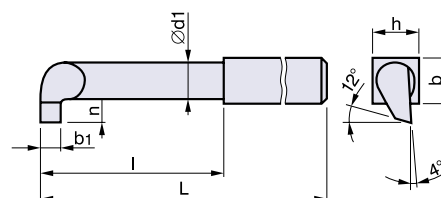

h	b	l	b1	L	WORKMANSHIP
16	10	14	4	110	compact
20	12	16	5	125	butt welded
25	16	20	6	140	
32	20	25	8	170	
40	25	32	10	200	
50	32	40	12	240	or with cutting tip





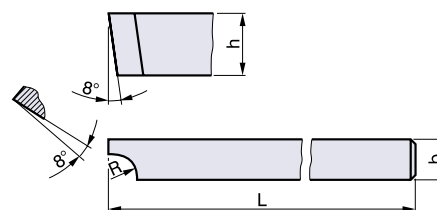
RECESSING TOOL code 223552

h	b	Ød1	l	n	b1	L	WORKMANSHIP
10	10	8	50	6	4	150	compact
12	12	10	63	8	5	180	
16	16	14	80	10	6	220	butt welded
20	20	18	100	12	8	250	
25	25	22	125	16	10	300	
32	32	30	160	18	12	355	



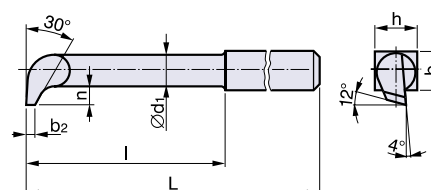
ROUND-NOSED TOOL code 223562 - right code 223563 - left

h	b	R	L	WORKMANSHIP
16	10	2	110	compact
		2,5		
		3		
		4		
20	12	5	125	butt welded or with cutting tip HSS
		6		
		8		
25	16	10	140	
32	20	12	170	
40	25	16	200	
50	32	18	240	



NECKING INSIDE THREADING TOOL code 223586

h	b	Ød1	l	n	b2	L	WORKMANSHIP
10	10	8	50	6	2	150	compact
12	12	10	63	8	2,5	180	

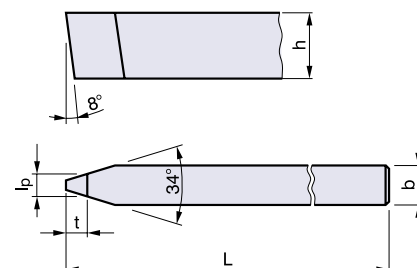


TURNING TOOLS



PULLEY KEYWAY TOOL
code 223590

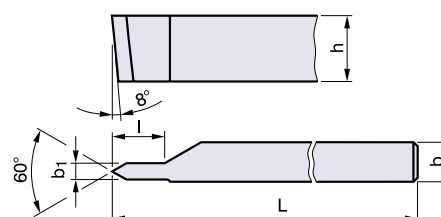
h	b	lp	t	L	WORKMANSHIP
20	12	8,5	9	125	butt welded or with cutting tip HSS
25	16	11	11	140	
32	20	14	14	170	
40	25	19	19	200	



THREADING TOOL
code 223312 - right
code 223313 - left



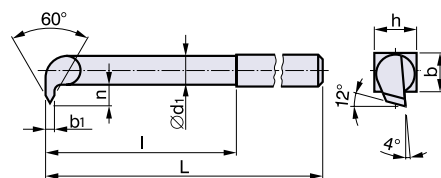
h	b	l	b1	L	WORKMANSHIP
16	10	14	4	110	compact
20	12	16	5	125	butt welded
25	16	20	6	140	
32	20	25	8	170	



INSIDE THREADING TOOL
code 223316



h	b	Ød1	l	n	b1	L	Workmanship
10	10	8	40	6	4	100	compact
12	12	10	50	8	5	125	
16	16	14	63	10	6	140	butt welded
20	20	18	80	12	8	160	
25	25	22	100	16	10	200	
32	32	30	125	18	12	250	







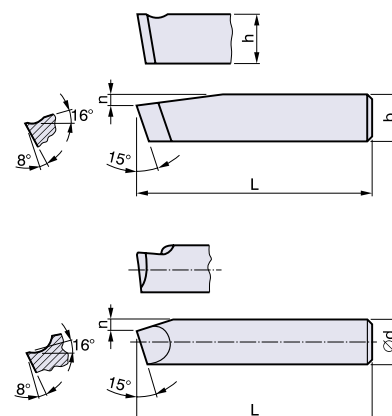
TURRET TOOLS

STRAIGHT ROUGER - 15°
code 223910 - right
code 223911 - left



$\varnothing d$ h 9	L	n
8	25	1,6
	32	
10	40	2,5
	63	
12	63	3,2
	80	
15	50	4
	80	
16	50	4
	80	
20	63	5
	100	

h h 11	b h 11	L	n
10	10	40	2,5
		63	
12	12	50	3,2
		80	
16	16	63	4
		100	
20	20	80	5
		125	

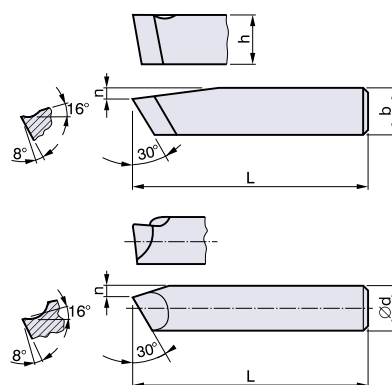


STRAIGHT ROUGER - 30°
code 223912 - right
code 223913 - left



$\varnothing d$ h 9	L	n
8	25	1,6
	32	
10	40	2,5
	63	
12	63	3,2
	80	
15	50	4
	80	
16	50	4
	80	
20	63	5
	100	

h h 11	b h 11	L	n
10	10	40	3
		63	
12	12	50	3,5
		80	
16	16	63	4
		100	
20	20	80	6
		125	

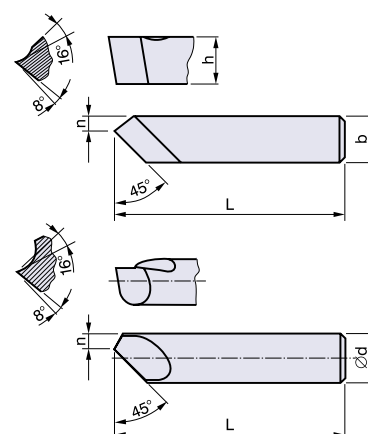


STRAIGHT ROUGER-45°
code 223914 - right
code 223915 - left



$\varnothing d$ h 9	L	n
8	32	2
10	40	2,5
	63	
12	63	3
	80	
15	50	4
	100	
16	50	4
	100	
20	63	5
	125	

h h 11	b h 11	L	n
10	10	40	4,5
		63	
12	12	50	5
		80	
16	16	63	6
		100	
20	20	80	8
		125	



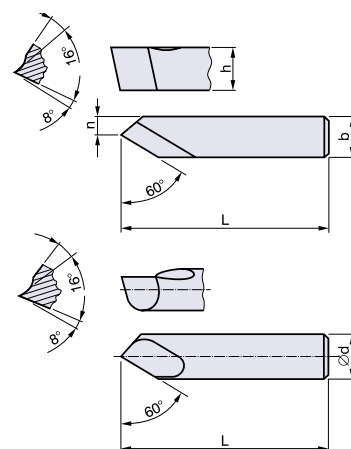
TURRET TOOLS



STRAIGHT ROUGHER - 60°
code 223916 - right
code 223917 - left

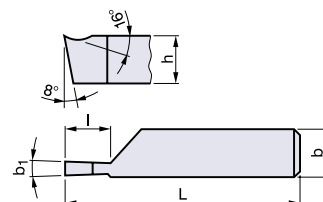
Ød h 9	L
8	32
10	40
12	63
15	63
16	100
20	125

h h 11	b h 11	L	n
10	10	40	5
		63	
12	12	50	6
		80	
16	16	63	8
		100	
20	20	80	10
		125	



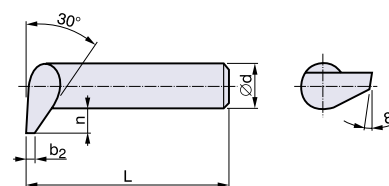
PARTING TOOL
code 223920 - right
code 223921 - left

h h 11	b h 11	L	l	b ₁
10	10	50	10	2,5
12	12	63	12	3
16	16	80	15	4
20	20	100	18	5



RECESSING TOOL
code 223922 - right
code 223923 - left

Ød h 9	L	n	b ₂
12	63	8	1,5
15	63	10	2,5
	100		
16	63	10	2,5
	100		
20	80	12	2,5
	125		

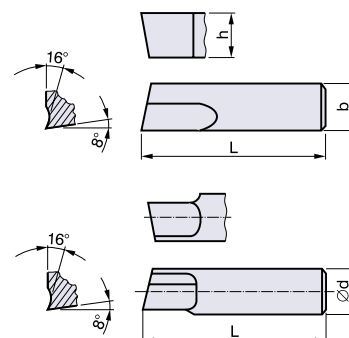




SIDE TOOL
code 223926 - right
code 223927 - left

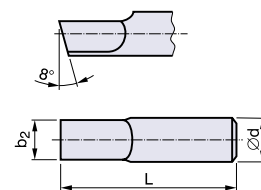
$\varnothing d$ h 9	L
8	32
10	40
12	63
15	50
16	100
20	63
	125

h h 11	b h 11	L
10	10	40
		63
12	12	50
		80
16	16	63
		100
20	20	80
		125



GROOVING TOOL
code 223930

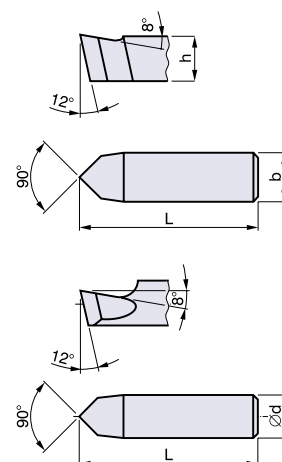
$\varnothing d$ h 9	L	b_2
8	25	7
	32	
10	40	9
	63	
12	63	10,5
15	50	12
	100	
16	50	13
	100	
20	63	16
	125	



SMOOTHING TOOL
code 223932

$\varnothing d$ h 9	L
8	25
	32
10	40
	63
12	63
15	50
	100
16	50
	100
20	63
	125

h h 11	b h 11	L
10	10	40
		63
12	12	50
		80
16	16	63
		100
20	20	80
		125



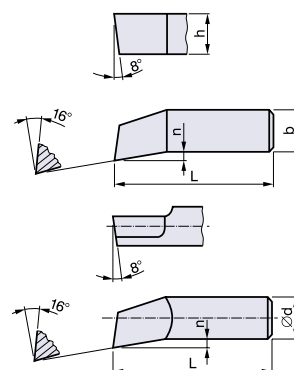
TURRET TOOLS



CORNER TOOL
code 223934 - right
code 223935 - left

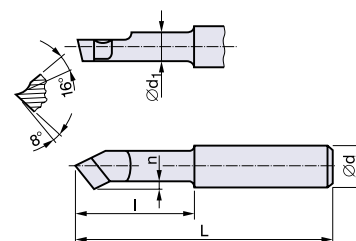
$\frac{h}{h_{11}}$	$\frac{b}{h_{11}}$	L	n
10	10	40	2
		63	
12	12	50	2,5
		80	
16	16	63	3,5
		100	
20	20	80	5
		125	

$\frac{\phi d}{h_9}$	L	N
12	63	2,5
	100	
16	63	3,5
	100	
20	80	5
	125	



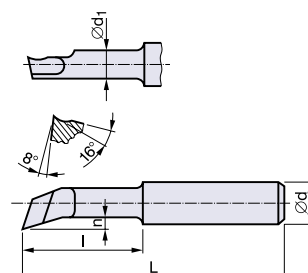
INSIDE ROUGHER
code 223940 - right
code 223941 - left

$\frac{\phi d}{h_9}$	L	ϕd_1	l	n
12	80	8	30	2
15	100	10	40	2,5
16	100	10	40	2,5
20	125	12	50	3,5



INSIDE CORNER TOOL
code 223944 - right
code 223945 - left

$\frac{\phi d}{h_9}$	L	ϕd_1	l	n
12	80	8	30	2
15	100	10	40	2,5
16	100	10	40	2,5
20	125	12	50	3

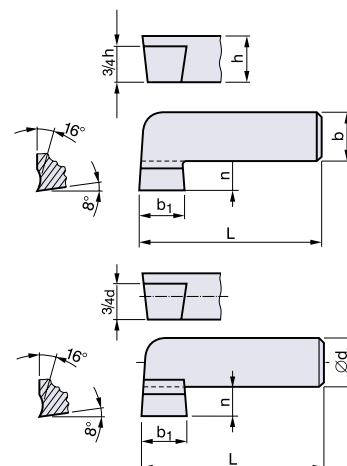




INSIDE BROAD-NOSE TOOL
code 223946 - right
code 223947 - left

$\frac{h}{h_{11}}$	$\frac{b}{h_{11}}$	L	b_1	n
12	12	50	12	10
		80		
16	16	63	15	12
		100		
20	20	80	20	16
		125		

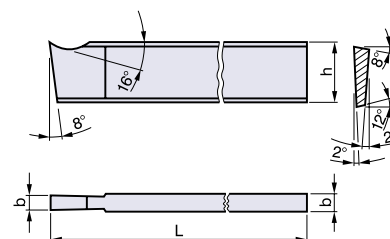
$\frac{\phi d}{h_9}$	L	b_1	n
12	63	12	10
	100		
15	63	15	12
	100		
16	63	15	12
	100		
20	80	20	16
	125		



CUTTING-OFF HOLDER TOOL
code 223554 - right
code 223555 - left



b	h	L
3	12	63
		100
4	18	63
		140
5	25	160

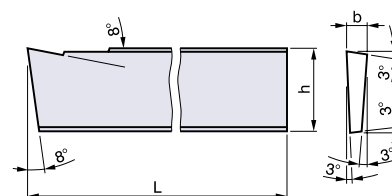


CUTTING-OFF HOLDER TOOL
code 223558



$\frac{b}{h_{12}}$	$\frac{h}{h_{11}}$	L
1,6	6	80
		100
2	8	80
		100
2,5	10	80
		100
3	12	80
		100
4	16	80
		100
		160

$\frac{b}{h_{12}}$	$\frac{h}{h_{11}}$	L
4	16	200
		80
5	20	80
		100
6	25	80
		100
8	32	160
		200
10	40	160
		200

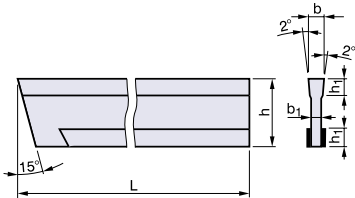


TURRET TOOLS



CUTTING-OFF HOLDER TOOL
code 223589

$\frac{b}{h_{12}}$	$\frac{h}{h_{12}}$	L	b_1	h_1
2,5	20	160	1,7	5
3			2,2	
3,5			2,7	
4			3,2	
4	25	200	3,1	6,5
5			4,1	







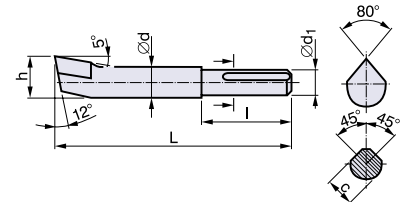
SLOTting TOOLS AND HOLDERS

227682 15 H35
SP 31



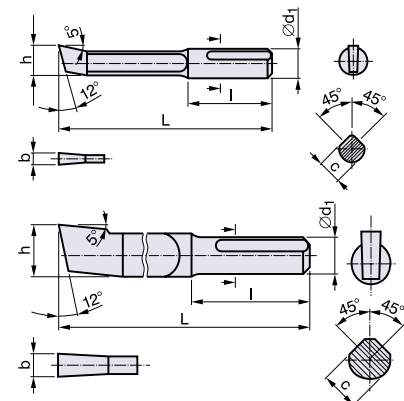
ROUGHING TOOL
code 223680

$\varnothing d$	L	h	$\varnothing d_1$ d11	l	c
14	105	18	12	40	11,6
20	150	25	18	56	17,4
25	220	32	22	80	21,2
32	280	40	30	100	29,0



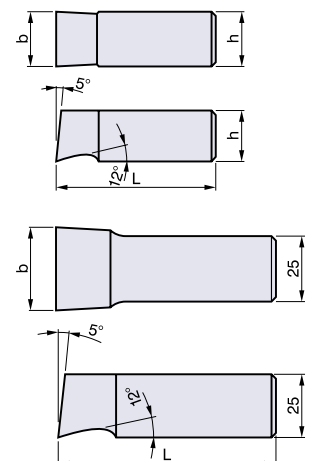
FLUTING TOOL
code 223681

b f8	h	L	$\varnothing d_1$ d11	l	c
2	6,5	70	12	40	11,6
3	7,5	75			
4	9	90			
5	11	100			
6	16	130	18	56	17,4
7	17	140			
8	19	150			
10	24	165	18	56	17,4
12	27	200	22	80	21,2
14	28	220			
16		240			
18	30	250			
20		260			



CROSS-FEED FLUTING TOOL
code 223682

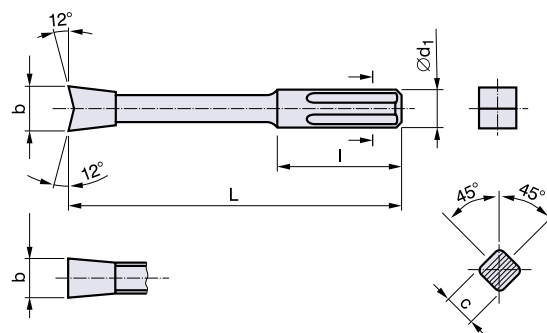
b f8	h h 11	L
8	8	26
10	10	
12	12	
14	14	40
16	16	
18	18	
20	20	55
22	22	65
25	25	
28	25	
32	25	75
36		
40		



TWO-LIPPED TOOL code 223683



b	L	$\varnothing d_1$ d11	l	c
8	85	12	40	11,2
10	95			
12	105			
16	140	18	56	16,8
20	180	22	80	20,4
25	220			
32	280	30	100	28



SLOTING TOOL HOLDER code 241025

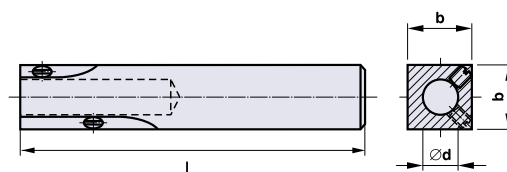
Tool type 223680

223681

223683



b x b	d	L
25x25	12	140
32x32	18	180
40x40	22	220
50x50	30	280

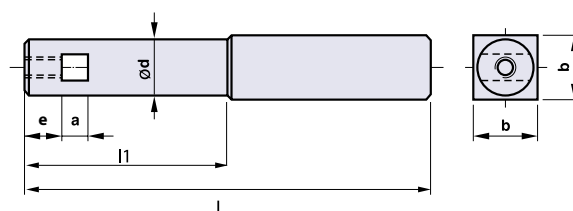


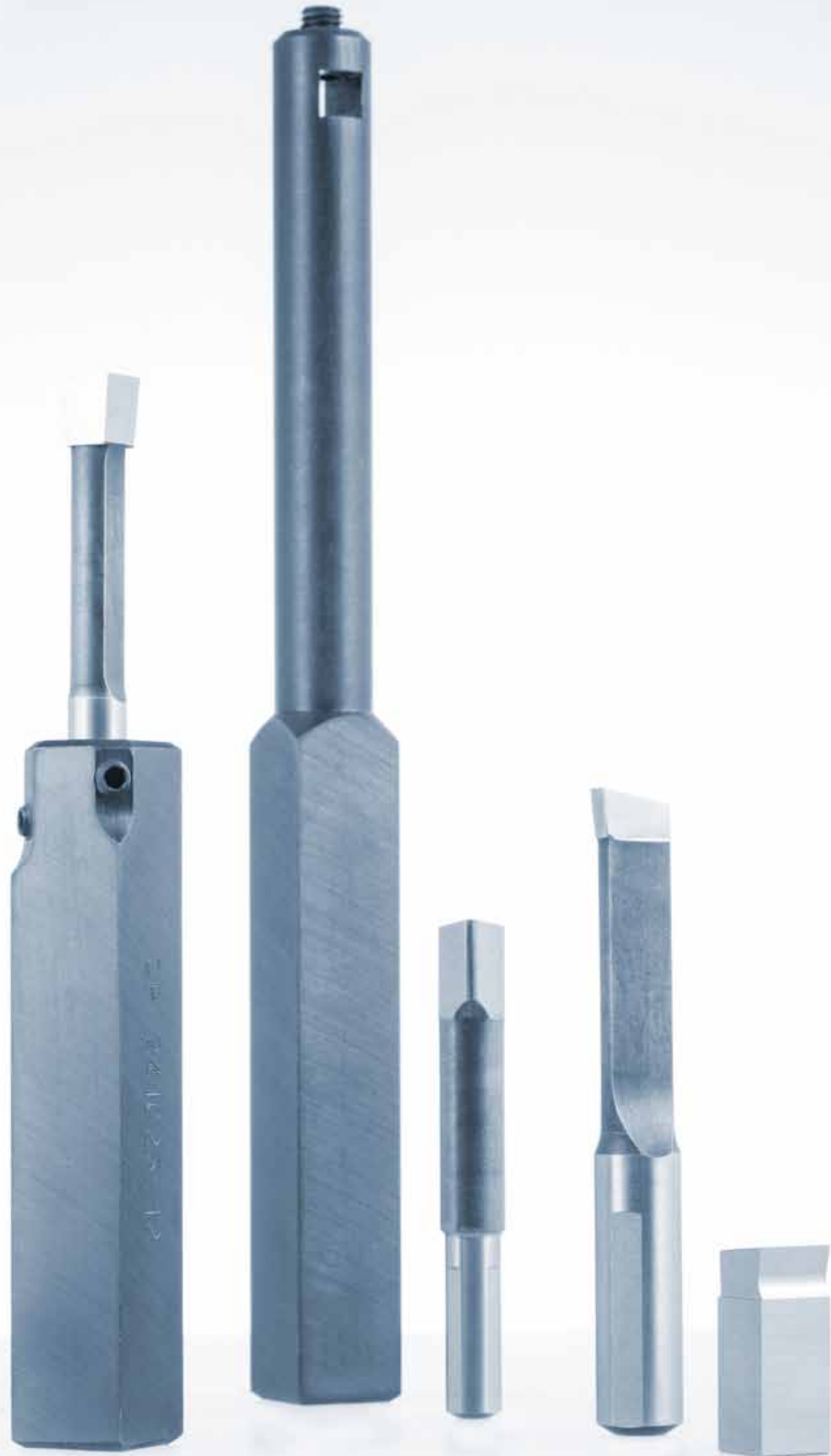
SLOTING TOOL HOLDER code 241026

Tools type 223682



b x b	a	e	Ød	L	l ₁
25x25	8	8	22	300	150
	10	10	22		
	12	10	24		
32x32	14	12	30	355	200
	16	12	30		
40x40	18	15	38	400	220
	20	15	38		
50x50	22	20	48	450	250
	25	20	48		





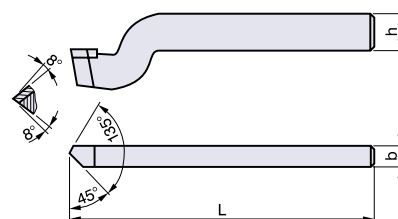


PLANNING TOOLS



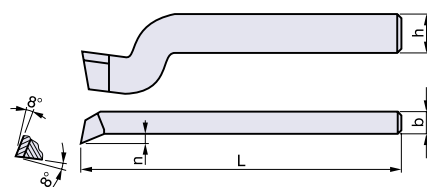
ROUGHING TOOL
code 223650 - right
code 223651 - left

h	b	L
25	16	250
32	20	300
40	25	400
50	32	500
63	40	500



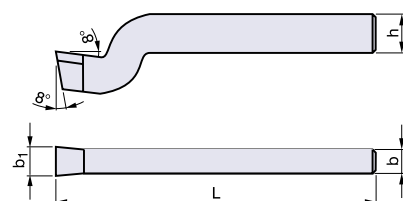
CORNER TOOL
code 223652 - right
code 223653 - left

h	b	L	n
25	16	250	7
32	20	300	8
40	25	400	10
50	32	500	12
63	40	500	16



SMOOTHING TOOL
code 223654

h	b	L	b ₁
25	16	250	20
32	20	300	25
40	25	400	32
50	32	500	40
63	40	500	50

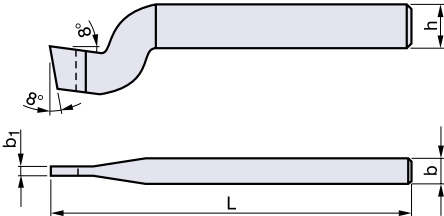


PLANNING TOOLS



PARTING TOOL
code 223655

h	b	L	b ₁
25	16	250	6
32	20	300	7
40	25	400	8
50	32	500	10
63	40	500	12,5





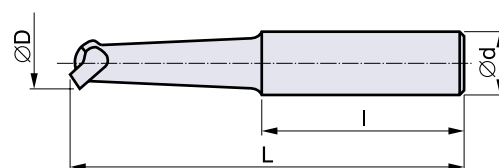


BORING TOOLS

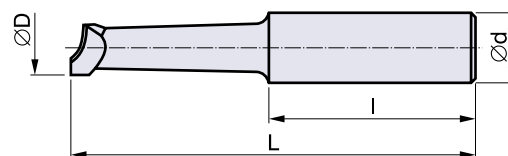




ROUGHING TOOL
code 221710



CORNER TOOL
code 221711



ORDERING NUMBER	Ø D	Ø d	L	l
10	4	4	40	20
11		6	50	25
12		8		
13		10		
14	5	8	50	25
15		10	60	30
16		6	50	
17	6	8	60	
18		10	70	35
19		12		
20	9	6	50	25
21		8	60	30
22		10	70	35
23		12		
25	13	8	60	30
26		10		
27		12		
30	15	8	70	53
31		10	90	40
32		12	80	35
35	9	16	70	
36	13		90	
37	15		110	50



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Karl Wittgenstein

STROJÍRNY POLDI, a.s.

Dubská 243, 272 03 Kladno – Dubí, Czech Republic
Phone: +420 313 115 110, Fax: +420 312 247 445
info@strojipoldi.com

Member of
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www.strojipoldi.com