UTILIS
multidec®
swiss type tools

ENGLISH

multidec®-5000

HIGH-PERFORMANCE PARTING-OFF TOOLS

INNOVATION

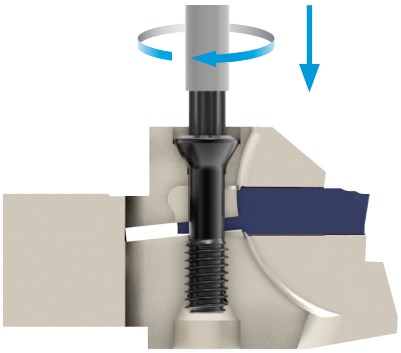
future since 1915

UTILIS®
Tooling for High Technology

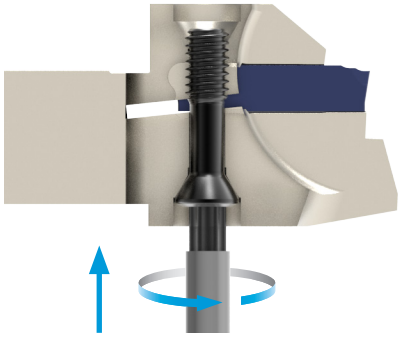
With multidec®-5000, UTILIS offers a range of outstanding high-performance parting-off tools that are developed and optimized for sliding headstock lathes. The 4 available chip breakers are designed to meet the highest requirements for efficient production, even in difficult-to-machine materials.
The multidec®-5000 tool holders are available without internal coolant or with internal coolant on insert chip breaker and front clearance. Thanks to the targeted coolant supply with high pressure, the chips are efficiently removed from the cutting edge. In addition, the cutting edge is efficiently cooled, considerably increasing insert life and enabling higher cutting parameters.

Advantages:
– 3 different cutting widths (1.5, 2.0 and 3.0 mm) for material-saving parting off
– 4 chip breakers and several carbide grades with modern coatings enable outstanding performance in every machining situation
– A large selection of holders from shank size 8 to 20 mm
– Holders with coolant on insert chip breaker and front clearance, starting with shank size 10 mm and insert width 1.5 mm
– Targeted coolant on insert front relief even with small workpiece diameters. Time-consuming alignment of coolant nozzles is no longer needed.
– Clamping by TORX® screw from top or bottom, enabling insert replacement inside the machine.
– Sophisticated design that prevents vibrations.
– High-quality manufacturing for a long service life with maximum performance.

Mounting options
Depending on the machine configuration, the clamping screw can be mounted on the top or bottom side, allowing easy access for changing the inserts.

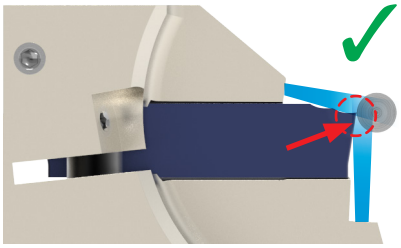


Top access

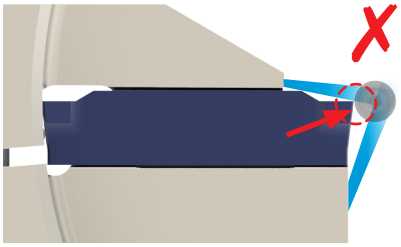


Bottom access

Targeted coolant
Both coolant outlets on chip breaker and on front clearance are precisely targetting the cutting edge.

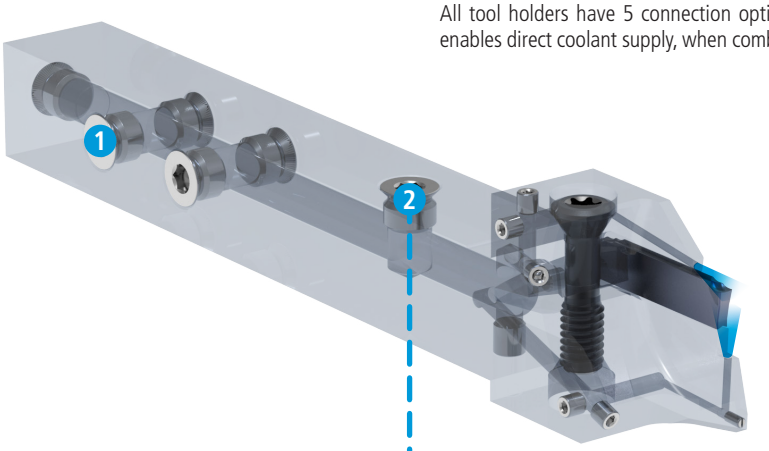


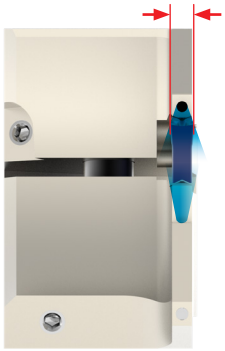
multidec®-5000
Even with very small diameters, the clearance coolant hits precisely the cutting edge. Coolant on front clearance allows tool life increase up to 150 %.



Competitors
The clearance coolant is ineffective, especially when machining small diameters.

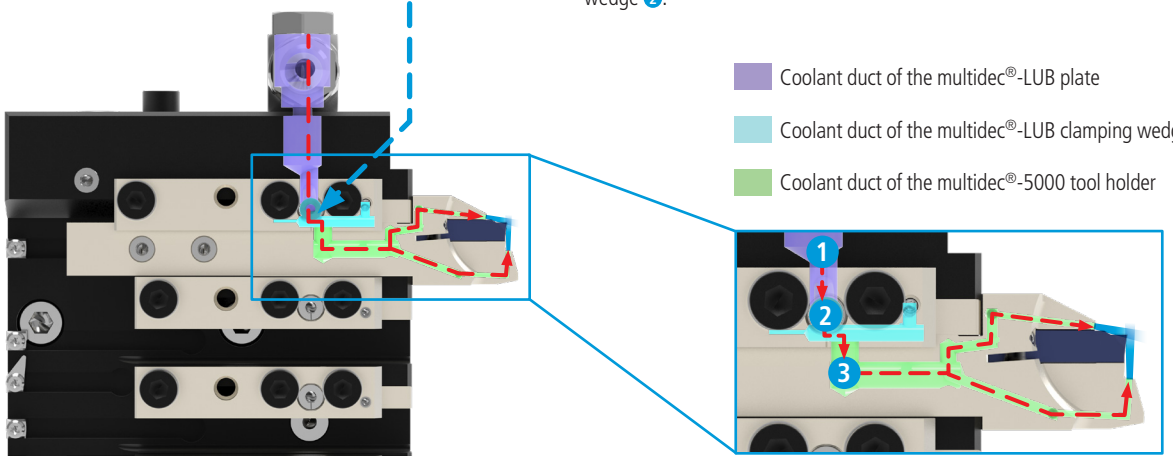
Parting-off tool multidec®-5000 with internal coolant "IC+" (IC-Plus)
All tool holders have 5 connection options ❶ for the coolant supply. An additional connection ❷ enables direct coolant supply, when combined with a multidec®-LUB tool plate.





Tool holders with internal coolant "IC+"
cutting width from 1.5 mm

Coolant supply without troublesome connections or hoses.
If the multidec®-5000 parting-off tool is combined with a multidec®-LUB tool plate, all coolant distributors and hoses are eliminated. Coolant is supplied directly to the tool ❸ from the multidec®-LUB tool holder plate ❶ via the multidec®-LUB clamping wedge ❷.



Legend

Dimensions
All dimensions are in millimeter (mm).

Page information
12… See page 12 and the following (example)

Availability
12345 Standard articles
12345 Standard articles, new in this catalog
12345 Discontinued articles

Material classification
The information on using multidec® tools refers to certain materials.
The materials to be machined are categorized in the same color throughout the entire catalog:

Steel
Stainless steel
Cast iron
Non-ferrous metals
High-alloy materials
Hard materials

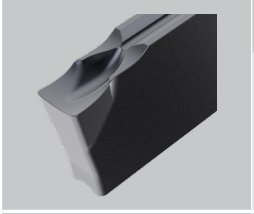
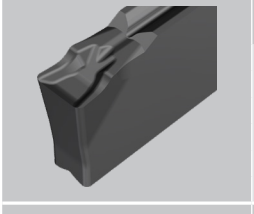
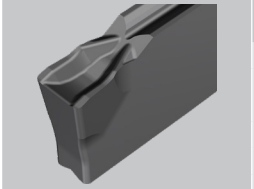
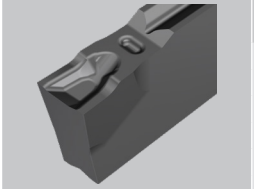
Order designation

Order designation	Grade
⚠ To the designation of the selected type of product, the desired cutting material code must be added.	○ ● – ○ ● ❶ HMP720
	Art. no.
5002-1.5-EN GT20 … ❶	**553692** ❷

❶ Order using order designation:
5002-1.5-EN GT20 HMP720

❷ Order using art. no.: **553692**

Insert selection and application — *multidec®-5000*

	Application	Chip breaker	Execution	Machining method
	Very smooth cut, low cutting forces Machining of sensitive parts and tubes For sticky and difficult to cut materials	**GT20**	**N** Neutral	P ● M ● K ○ N ○ S ● H –
	Fine to medium cut Excellent surface finish and chip control Very universal use	**C40**	**N** Neutral	P ● M ● K ● N ○ S ● H –
	Medium to heavy cut Excellent chip control Very good resistance to interrupted cut	**C60**	**N** Neutral	P ● M ○ K ● N – S – H –
	Fine to medium cut For parting off without counter spindle Good surface finish and chip control	**C30**	**R** Right	P ● M ● K – N – S ● H –

Designation system — *multidec®-5000*

Inserts

5002-2.0-EN C40 HMP725

- Grade: HMP725 (Carbide coated)
- Chip breaker
- Cutting edge design
- Parting off width (mm)
- Cutting geometry
- Product type

Holders

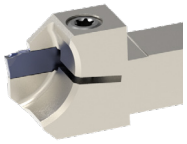
5000-2.0-12x100 R 26 IC+

- IC+ with integrated coolant on chip breaker and front clearance
- Max. parting-off diameter
- Execution
- Length (mm)
- Holders cross section (mm)
- Cutting width (mm)
- Product type

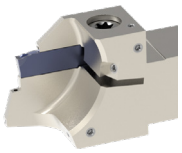
Inserts with neutral cut

Inserts with right-hand cut

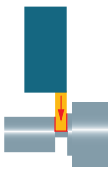
Tool holders



Tool holders with coolant "IC+" (IC-Plus)

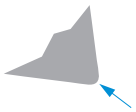


Replacement and spare parts

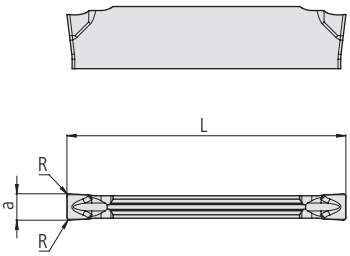


Very smooth cut, low cutting forces
Machining of sensitive parts and tubes
For sticky and difficult to cut materials

5002…-EN GT20



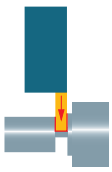
E: Insert with rounded cutting edge



Parting off width	Order designation	Grade		Dimensions						
		○	●							
		●	●							
		–	○							
		○	–							
		●	○							
		–	–							
a =		HMP720	HMP735	a ±0.04	R	L				
		Art. no.								
1.5	5002-1.5-EN GT20 …	553692	553693	1.5	0.15	17.8				
2.0	5002-2.0-EN GT20 …	553192	553194	2.0	0.20	21.1				

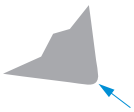
Information on grades
HMP720: Universal high-performance grade with high wear resistance and stable cutting edge
HMP735: Tough grade for difficult machining conditions, enables high feed rates

	Cutting speeds v_c (m/min)	Feeds f (mm/U) a =	
		1.5	2.0
P	80–160	0.02–0.10	0.02–0.12
M	70–140	0.02–0.08	0.02–0.10
K	90–150	0.03–0.10	0.04–0.12
N	120–300	0.03–0.12	0.04–0.15
S	50–90	0.02–0.08	0.02–0.10
H	–	–	–

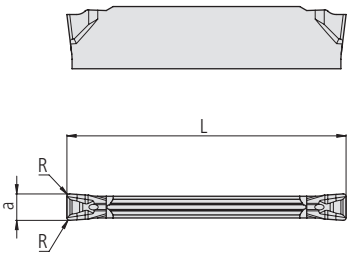


Fine to medium cut
Excellent surface finish and chip control
Very universal use

5002…-EN C40



E: Insert with rounded cutting edge



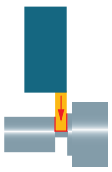
Parting off width	Order designation	Grade			Dimensions					
		○	●	●						
		●	●	○						
		○	●	●						
		○	–	–						
		●	●	○						
		–	–	–						
a =		HMP715	HMP725	HMP835	a ±0.04	R	L			
		Art. no.								
1.5	5002-1.5-EN C40 …	553674	553675	553676	1.5	0.05	17.8			
2.0	5002-2.0-EN C40 …	553677	553681	553683	2.0	0.2	21.1			
3.0	5002-3.0-EN C40 …		553688	553689	3.0	0.2	21.1			

Information on grades
HMP715: Very high wear resistance under stable machining conditions
HMP725: Universal high-performance grade with high wear resistance and stable cutting edge
HMP835: Tough grade for difficult machining conditions, enables high feed rates

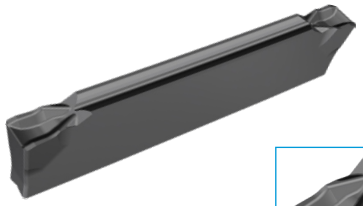
	Cutting speeds v_c (m/min)	Feeds f (mm/U) a = 1.5	2.0	3.0
P	80–160	0.02–0.12	0.03–0.15	0.04–0.18
M	70–140	0.02–0.10	0.03–0.12	0.04–0.15
K	90–150	0.03–0.10	0.04–0.12	0.04–0.15
N	120–300	0.03–0.12	0.04–0.15	–
S	50–90	0.02–0.08	0.03–0.10	0.03–0.12
H	–	–	–	–

Legend 3

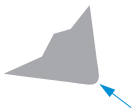
Inserts with neutral cut — *multidec®-5000*



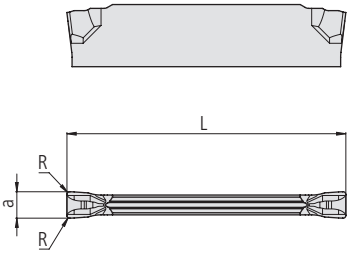
Medium to heavy cut
Excellent chip control
Very good resistance to interrupted cut



5002…-EN C60



E: Insert with rounded cutting edge



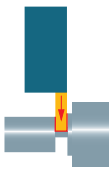
Parting off width	Order designation	Grade			Dimensions					
		○	●	●						
		●	●	○						
		○	●	●						
		–	–	–						
		–	–	–						
		–	–	–						
a =		HMP715	HMP725	HMP835	a ±0.04	R	L			
		Art. no.								
2.0	5002-2.0-EN C60 …	553685	553686	553687	2.0	0.2	21.1			
3.0	5002-3.0-EN C60 …		553690	553691	3.0	0.2	21.1			

Information on grades
HMP715: Very high wear resistance under stable machining conditions
HMP725: Universal high-performance grade with high wear resistance and stable cutting edge
HMP835: Tough grade for difficult machining conditions, enables high feed rates

Application range — *multidec®-5000*

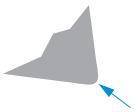
	Cutting speeds v_c (m/min)	Feeds f (mm/U) a = 2.0	Feeds f (mm/U) a = 3.0
P	80–160	0.03–0.15	0.04–0.20
M	70–140	0.03–0.12	0.04–0.18
K	90–150	0.03–0.15	0.04–0.20
N	–	–	–
S	–	–	–
H	–	–	–

Legend 3

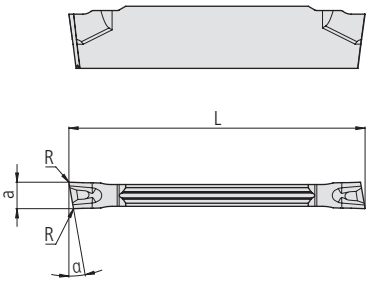


Fine to medium cut
For parting off without counter spindle
Good surface finish and chip control

5002…-ER-.. C30



E: Insert with rounded cutting edge

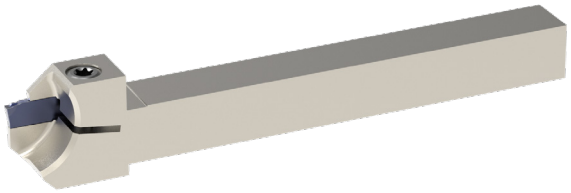


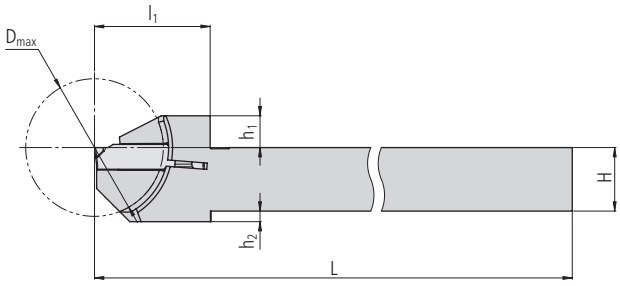
Parting off width	Order designation	Grade	Dimensions								
		● ● – – ● –									
a =		HMP725	a ±0.04	R	α	L					
		Art. no.									
2.0	5002-2.0-ER-10 C30 …	556838	2.0	0.03	10°	22.4					
	5002-2.0-ER-15 C30 …	556839	2.0	0.03	15°	22.4					
3.0	5002-3.0-ER-10 C30 …	556840	3.0	0.03	10°	22.4					
	5002-3.0-ER-15 C30 …	556841	3.0	0.03	15°	22.4					

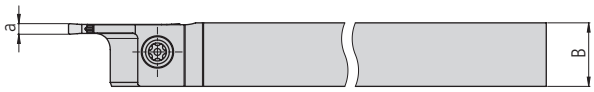
Information on grades
HMP725: Universal high-performance grade with high wear resistance and stable cutting edge

	Cutting speeds v_c (m/min)	Feeds f (mm/U) a = 2.0	Feeds f (mm/U) a = 3.0
P	80–160	0.02–0.08	0.03–0.10
M	70–140	0.02–0.08	0.03–0.10
K	–	–	–
N	–	–	–
S	50–90	0.02–0.08	0.03–0.10
H	–	–	–

Left-hand standard tool holder







5000… L ..

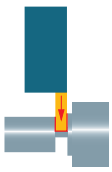
Cutting width a =	Order designation	Art. no.	Dimensions H	B	L	D_{max}	l_1	h_1	h_2			*
1.5	5000-1.5-08x100 L 16	556563	8	9	100	16	18	6	2			○
	5000-1.5-10x100 L 16	556083	10	10	100	16	18	6	2			●
	5000-1.5-12x100 L 22	553765	12	12	100	22	20	6	2			●
	5000-1.5-16x125 L 24	556796	16	16	125	24	22	6.5	0			●
2.0	5000-2.0-10x100 L 22	556087	10	10	100	22	22	6	2			●
	5000-2.0-12x100 L 26	556091	12	12	100	26	22	6	2			●
	5000-2.0-16x125 L 32	556809	16	16	125	32	27	6.5	0			●
	5000-2.0-20x125 L 40	556811	20	20	125	40	31	6.5	0			○
3.0	5000-3.0-12x100 L 26	556655	12	12	100	26	22	6	2			○
	5000-3.0-16x125 L 32	556858	16	16	125	32	27	6.5	0			○
	5000-3.0-16x125 L 40	553769	16	16	125	40	31	6.5	0			○
	5000-3.0-20x125 L 40	556862	20	20	125	40	31	6.5	0			○

5000… L .. INCH

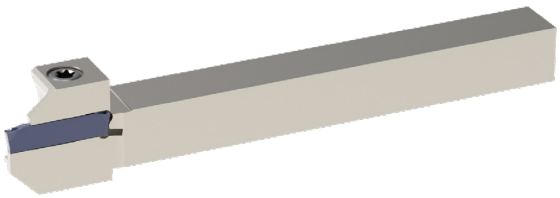
Cutting width a =	Order designation	Art. no.	Dimensions H Inch	H mm	B	L	D_{max}	l_1	h_1	h_2		*
1.5	5000-1.5-3/8"x100 L 16	556590	3/8"	9.525	9.525	100	16	18	6	2		○
	5000-1.5-1/2"x100 L 22	556596	1/2"	12.7	12.7	100	22	20	6	2		●
	5000-1.5-5/8"x125 L 24	556801	5/8"	15.875	15.875	125	24	22	6.5	0		○
2.0	5000-2.0-3/8"x100 L 22	556649	3/8"	9.525	9.525	100	22	22	6	2		○
	5000-2.0-1/2"x100 L 26	556651	1/2"	12.7	12.7	100	26	22	6	2		●
	5000-2.0-5/8"x125 L 32	556817	5/8"	15.875	15.875	125	32	27	6.5	0		○
	5000-2.0-3/4"x125 L 40	556819	3/4"	19.05	19.05	125	40	31	6.5	0		○
3.0	5000-3.0-1/2"x100 L 26	556659	1/2"	12.7	12.7	100	26	22	6	2		○
	5000-3.0-5/8"x125 L 32	556879	5/8"	15.875	15.875	125	32	27	6.5	0		○
	5000-3.0-5/8"x125 L 40	556881	5/8"	15.875	15.875	125	40	31	6.5	0		○
	5000-3.0-3/4"x125 L 40	556883	3/4"	19.05	19.05	125	40	31	6.5	0		○

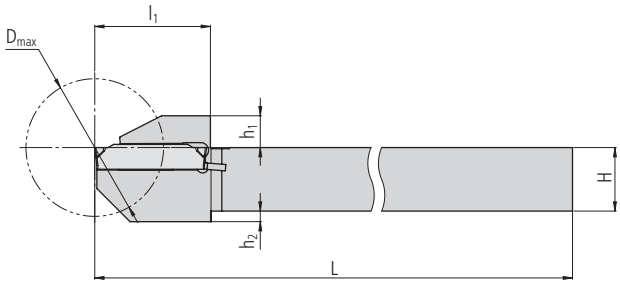
* ● Ex stock | ○ Inventory in progress

Legend 3



Right-hand standard tool holder





5000… R ..

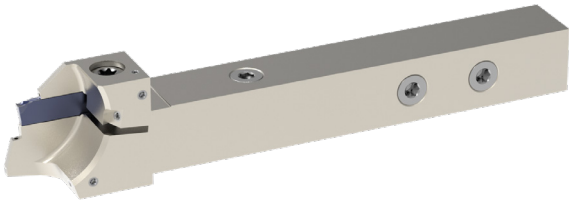
Cutting width a =	Order designation R	Art. no.	Dimensions H	B	L	D_{max}	l_1	h_1	h_2			*
1.5	5000-1.5-08x100 R 16	556562	8	9	100	16	18	6	2			○
	5000-1.5-10x100 R 16	556082	10	10	100	16	18	6	2			●
	5000-1.5-12x100 R 22	553763	12	12	100	22	20	6	2			●
	5000-1.5-16x125 R 24	556793	16	16	125	24	22	6.5	0			●
2.0	5000-2.0-10x100 R 22	556086	10	10	100	22	22	6	2			●
	5000-2.0-12x100 R 26	556090	12	12	100	26	22	6	2			●
	5000-2.0-16x125 R 32	556805	16	16	125	32	27	6.5	0			●
	5000-2.0-20x125 R 40	556807	20	20	125	40	31	6.5	0			○
3.0	5000-3.0-12x100 R 26	556653	12	12	100	26	22	6	2			○
	5000-3.0-16x125 R 32	556853	16	16	125	32	27	6.5	0			○
	5000-3.0-16x125 R 40	553767	16	16	125	40	31	6.5	0			○
	5000-3.0-20x125 R 40	556856	20	20	125	40	31	6.5	0			○

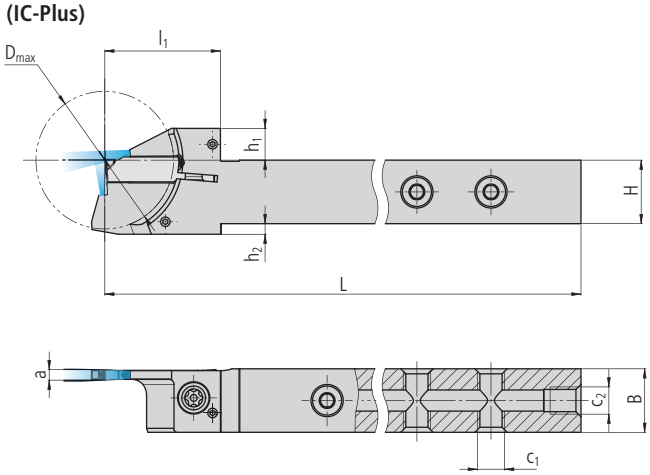
5000… R .. INCH

Cutting width a =	Order designation R	Art. no.	Dimensions H Inch	H mm	B	L	D_{max}	l_1	h_1	h_2		*
1.5	5000-1.5-3/8"x100 R 16	556575	⅜"	9.525	9.525	100	16	18	6	2		○
	5000-1.5-1/2"x100 R 22	556583	½"	12.7	12.7	100	22	20	6	2		●
	5000-1.5-5/8"x125 R 24	556798	⅝"	15.875	15.875	125	24	22	6.5	0		○
2.0	5000-2.0-3/8"x100 R 22	556645	⅜"	9.525	9.525	100	22	22	6	2		○
	5000-2.0-1/2"x100 R 26	556647	½"	12.7	12.7	100	26	22	6	2		●
	5000-2.0-5/8"x125 R 32	556813	⅝"	15.875	15.875	125	32	27	6.5	0		○
	5000-2.0-3/4"x125 R 40	556815	¾"	19.05	19.05	125	40	31	6.5	0		○
3.0	5000-3.0-1/2"x100 R 26	556657	½"	12.7	12.7	100	26	22	6	2		○
	5000-3.0-5/8"x125 R 32	556872	⅝"	15.875	15.875	125	32	27	6.5	0		○
	5000-3.0-5/8"x125 R 40	556875	⅝"	15.875	15.875	125	40	31	6.5	0		○
	5000-3.0-3/4"x125 R 40	556877	¾"	19.05	19.05	125	40	31	6.5	0		○

* ● Ex stock | ○ Inventory in progress

Left-hand tool holder with internal coolant "IC+" (IC-Plus)
with cooling of chip breaker and front clearance





5000… L .. IC+

Cutting width a =	Order designation L	Art. no.	Dimensions H	B	L	D_{max}	l_1	h_1	h_2	c_1	c_2	*
1.5	5000-1.5-10x100 L 16 IC+	554971	10	11	100	16	18	6	2	M5	M5	●
	5000-1.5-12x100 L 22 IC+	553766	12	12	100	22	20	6	2	M5	M5	●
	5000-1.5-16x125 L 24 IC+	556797	16	16	125	24	22	6.5	0	M5	G⅛	●
2.0	5000-2.0-10x100 L 22 IC+	556085	10	11	100	22	22	6	2	M5	M5	●
	5000-2.0-12x100 L 26 IC+	556089	12	12	100	26	22	6	2	M5	M5	●
	5000-2.0-16x125 L 32 IC+	556810	16	16	125	32	27	6.5	0	M5	G⅛	●
	5000-2.0-20x125 L 40 IC+	556812	20	20	125	40	31	6.5	0	M5	G⅛	○
3.0	5000-3.0-12x100 L 26 IC+	556656	12	12	100	26	22	6	2	M5	M5	○
	5000-3.0-16x125 L 32 IC+	556860	16	16	125	32	27	6.5	0	M5	G⅛	○
	5000-3.0-16x125 L 40 IC+	553770	16	16	125	40	31	6.5	0	M5	G⅛	○
	5000-3.0-20x125 L 40 IC+	556863	20	20	125	40	31	6.5	0	M5	G⅛	○

5000… L .. IC+ INCH

Cutting width a =	Order designation L	Art. no.	Dimensions H Inch	H mm	B	L	D_{max}	l_1	h_1	h_2	c_1	c_2	*
1.5	5000-1.5-3/8"x100 L 16 IC+	556594	⅜"	9.525	11	100	16	18	6	2	M5	M5	○
	5000-1.5-1/2"x100 L 22 IC+	556597	½"	12.7	12.7	100	22	20	6	2	M5	M5	●
	5000-1.5-5/8"x125 L 24 IC+	556802	⅝"	15.875	15.875	125	24	22	6.5	0	M5	G⅛	○
2.0	5000-2.0-3/8"x100 L 22 IC+	556650	⅜"	9.525	11	100	22	22	6	2	M5	M5	○
	5000-2.0-1/2"x100 L 26 IC+	556652	½"	12.7	12.7	100	26	22	6	2	M5	M5	●
	5000-2.0-5/8"x125 L 32 IC+	556818	⅝"	15.875	15.875	125	32	27	6.5	0	M5	G⅛	○
	5000-2.0-3/4"x125 L 40 IC+	556820	¾"	19.05	19.05	125	40	31	6.5	0	M5	G⅛	○
3.0	5000-3.0-1/2"x100 L 26 IC+	556661	½"	12.7	12.7	100	26	22	6	2	M5	M5	○
	5000-3.0-5/8"x125 L 32 IC+	556880	⅝"	15.875	15.875	125	32	27	6.5	0	M5	G⅛	○
	5000-3.0-5/8"x125 L 40 IC+	556882	⅝"	15.875	15.875	125	40	31	6.5	0	M5	G⅛	○
	5000-3.0-3/4"x125 L 40 IC+	556884	¾"	19.05	19.05	125	40	31	6.5	0	M5	G⅛	○

* ● Ex stock | ○ Inventory in progress

Scope of delivery: Holder without coolant connector

Item 300362

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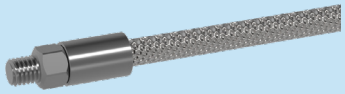
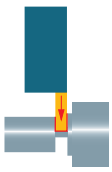
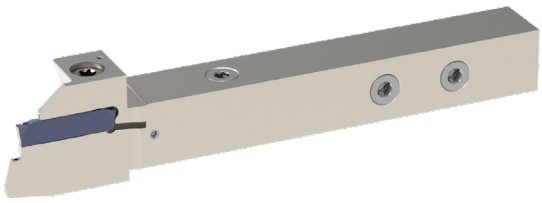
– Coolant system ..... 671…

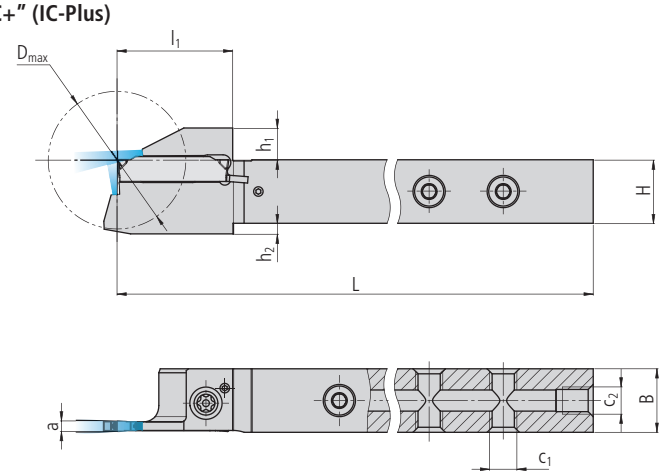


Legend 3



Right-hand tool holder with internal coolant "IC+" (IC-Plus)
with cooling of chip breaker and front clearance





5000… R .. IC+

Cutting width a =	Order designation R	Art. no.	Dimensions H	B	L	D_{max}	l_1	h_1	h_2	c_1	c_2	*
1.5	5000-1.5-10x100 R 16 IC+	556081	10	11	100	16	18	6	2	M5	M5	●
	5000-1.5-12x100 R 22 IC+	553764	12	12	100	22	20	6	2	M5	M5	●
	5000-1.5-16x125 R 24 IC+	556794	16	16	125	24	22	6.5	0	M5	G⅛	●
2.0	5000-2.0-10x100 R 22 IC+	556084	10	11	100	22	22	6	2	M5	M5	●
	5000-2.0-12x100 R 26 IC+	556088	12	12	100	26	22	6	2	M5	M5	●
	5000-2.0-16x125 R 32 IC+	556806	16	16	125	32	27	6.5	0	M5	G⅛	●
	5000-2.0-20x125 R 40 IC+	556808	20	20	125	40	31	6.5	0	M5	G⅛	○
3.0	5000-3.0-12x100 R 26 IC+	556654	12	12	100	26	22	6	2	M5	M5	○
	5000-3.0-16x125 R 32 IC+	556854	16	16	125	32	27	6.5	0	M5	G⅛	○
	5000-3.0-16x125 R 40 IC+	553768	16	16	125	40	31	6.5	0	M5	G⅛	○
	5000-3.0-20x125 R 40 IC+	556857	20	20	125	40	31	6.5	0	M5	G⅛	○

5000… R .. IC+ INCH

Cutting width a =	Order designation R	Art. no.	Dimensions H Inch	H mm	B	L	D_{max}	l_1	h_1	h_2	c_1	c_2	*
1.5	5000-1.5-3/8"x100 R 16 IC+	556579	⅜"	9.525	11	100	16	18	6	2	M5	M5	○
	5000-1.5-1/2"x100 R 22 IC+	556584	½"	12.7	12.7	100	22	20	6	2	M5	M5	●
	5000-1.5-5/8"x125 R 24 IC+	556800	⅝"	15.875	15.875	125	24	22	6.5	0	M5	G⅛	○
2.0	5000-2.0-3/8"x100 R 22 IC+	556646	⅜"	9.525	11	100	22	22	6	2	M5	M5	○
	5000-2.0-1/2"x100 R 26 IC+	556648	½"	12.7	12.7	100	26	22	6	2	M5	M5	●
	5000-2.0-5/8"x125 R 32 IC+	556814	⅝"	15.875	15.875	125	32	27	6.5	0	M5	G⅛	○
	5000-2.0-3/4"x125 R 40 IC+	556816	¾"	19.05	19.05	125	40	31	6.5	0	M5	G⅛	○
3.0	5000-3.0-1/2"x100 R 26 IC+	556658	½"	12.7	12.7	100	26	22	6	2	M5	M5	○
	5000-3.0-5/8"x125 R 32 IC+	556873	⅝"	15.875	15.875	125	32	27	6.5	0	M5	G⅛	○
	5000-3.0-5/8"x125 R 40 IC+	556876	⅝"	15.875	15.875	125	40	31	6.5	0	M5	G⅛	○
	5000-3.0-3/4"x125 R 40 IC+	556878	¾"	19.05	19.05	125	40	31	6.5	0	M5	G⅛	○

* ● Ex stock | ○ Inventory in progress

Scope of delivery: Holder without coolant connector

Legend ... 3

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– Coolant system ... 671…

Illustration	Description	Dimensions	Order designation	Art. no.	Tool holders
	TORX® screw	M4 × 16 T15	MSP 40160 T15 WN-093	556448	5000… (H ≤ 12 mm) 5000… (H ≤ ½")
		M5 × 19 T20	MSP 50190 T20 WN-115	556447	5000… (H ≥ 16 mm) 5000… (H ≥ ⅝")
	Screw plug	M5	MSP VSR M5 IB2.5	150262	5000… IC+
		G⅛	MSP VSR G1/8 IB5	153989	

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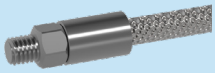
– TORX® screwdrivers 703…
– Coolant system 671…



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Article 300969

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You will find a wide range of universal milling tools in the multidec®-MILL product range.

Article 400925

multidec®-CARE – From the idea to the machine

You have an order or an idea, and you want to know how to implement it?
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Article 400885

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