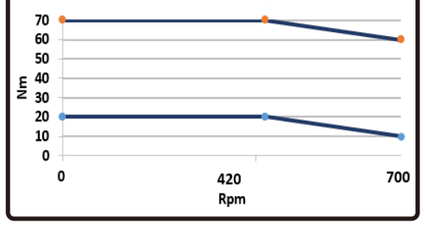
THL 4.0/4.5

SPINDLE SPECIFICATIONS

Yaskawa 1.0kw servo motor, maximum torque 70NM with reducer.

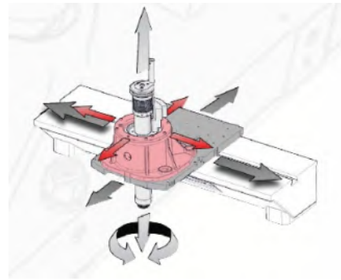
Rigid heavy duty motor spindl of 3.15in/80mm diameter for machineing without chatter .

MOTOR SPINDLE TORQUE CURVE



TRIPLE AIR CUSHION

Triple air cushion and built-in motorspindle decreases dramatically the freefloating parts weight during centeringwhich improves speed and accuracy.

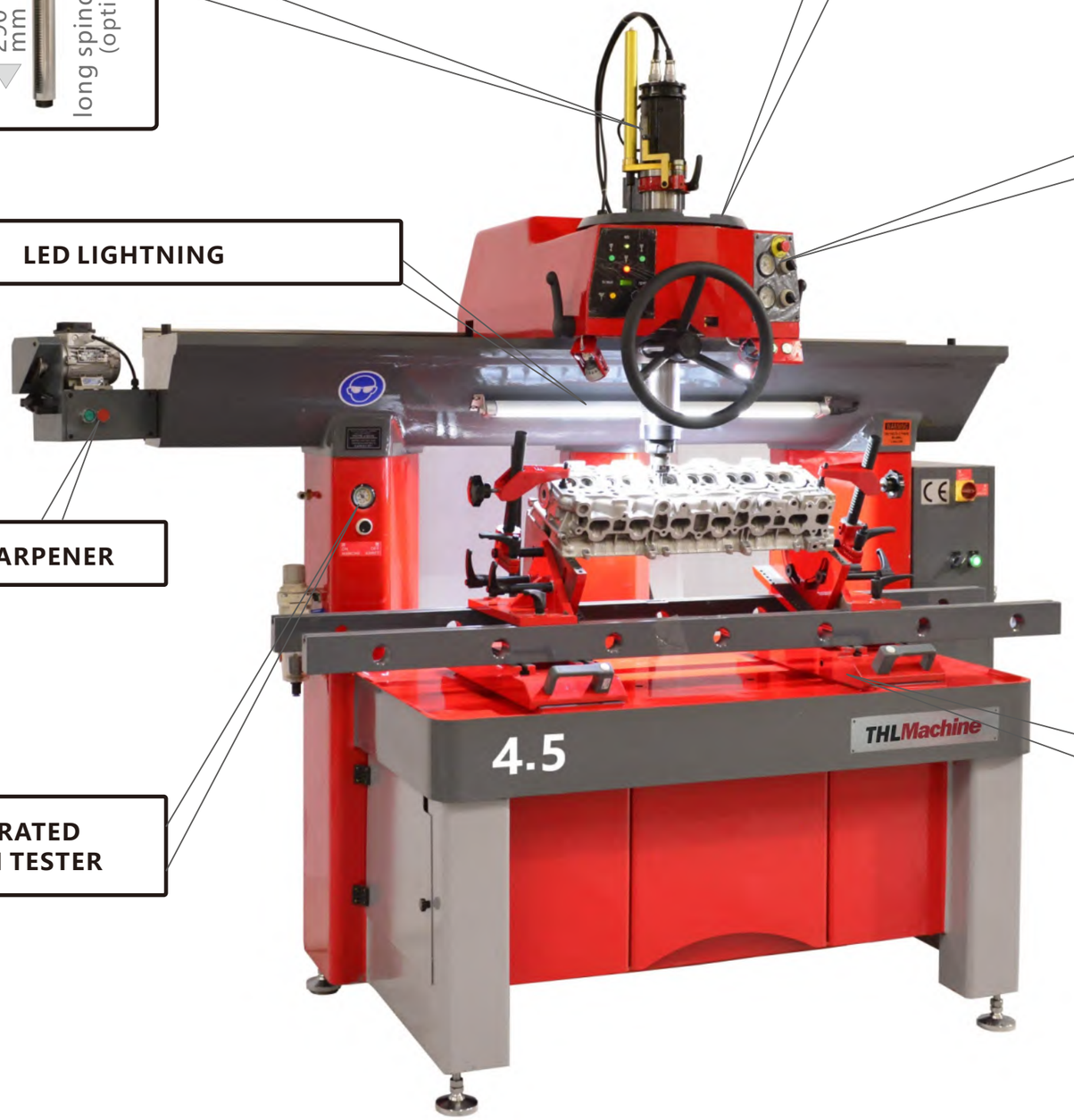


CONTROL PANEL

LED LIGHTNING

TOOL SHARPENER

INTEGRATED VACUUM TESTER



PARKING AREA

This extra length on the beam is available to ease the mounting and unmounting of large and heavy cylinder heads on the floating table.

AIR FLOATING SUPPORT TABLE

Crosswise work piece tilting +42° to -15°
Parallels can be manually moved back and forth on 150 mm. Then they are locked by two powerful pneumatic jacks.

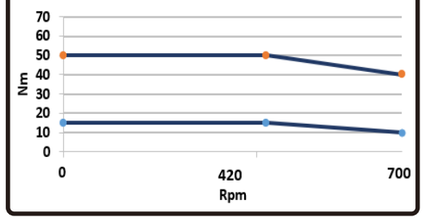
THL 3.0

SPINDLE SPECIFICATIONS

Yaskawa 0.75kw servo motor, maximum torque 50NM with reducer.

Rigid heavy duty motor spindl of 3.15in/80mm diameter for machineing without chatter .

MOTOR SPINDLE TORQUE CURVE



250 mm

standard spindle stroke

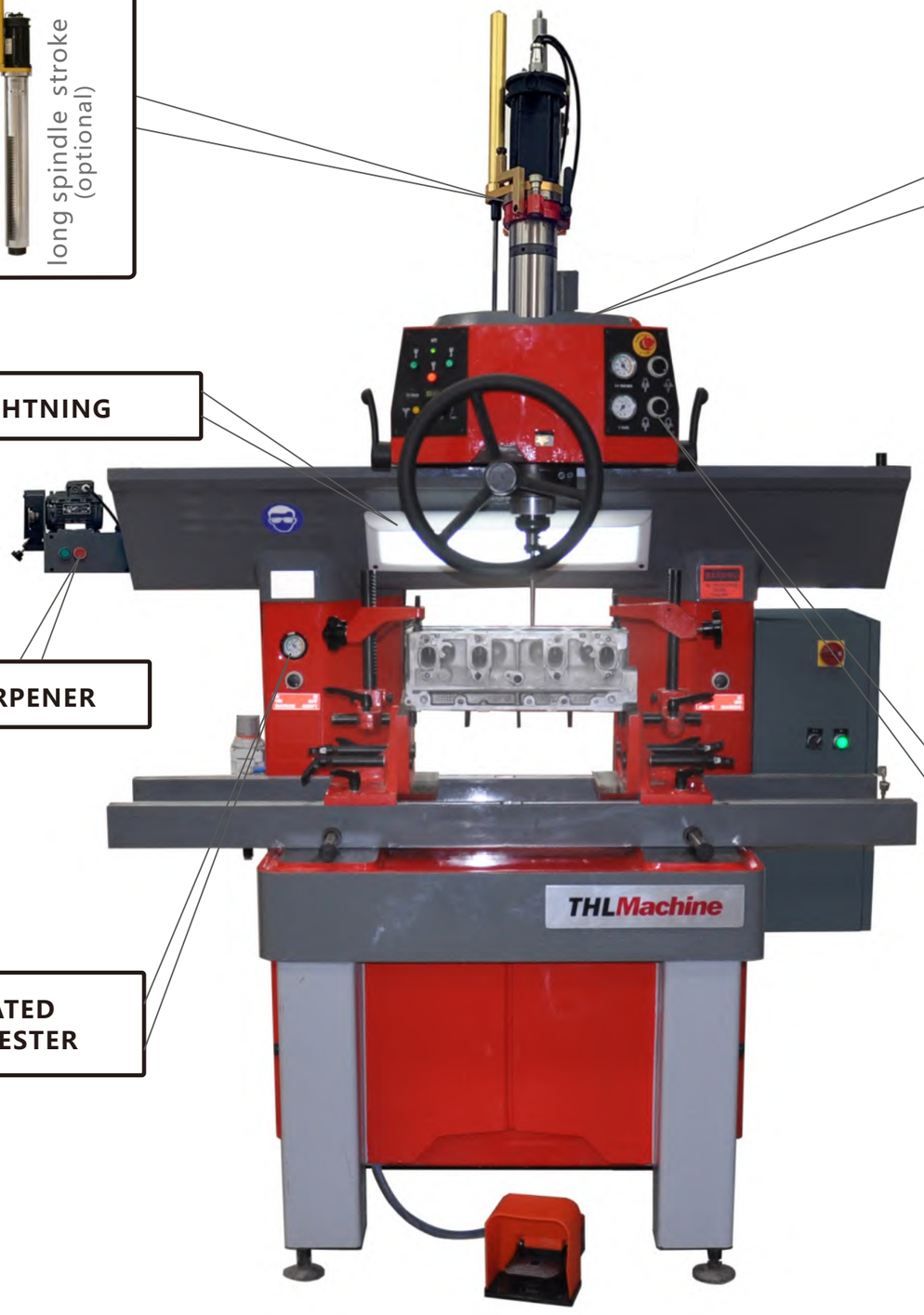
290 mm

long spindle stroke (optional)

LED LIGHTNING

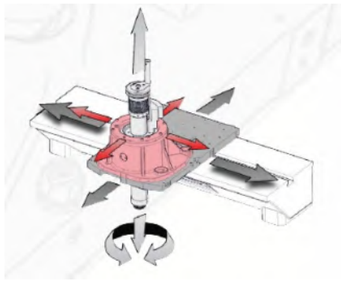
TOOL SHARPENER

INTEGRATED VACUUM TESTER



TRIPLE AIR CUSHION

Triple air cushion and built-in motorspindle decreases dramatically the freefloating parts weight during centeringwhich improves speed and accuracy.



CONTROL PANEL

Yaskawa servo motor and driver
SME penumatic component
Schneider electronic component

SPACE REQUIREMENT

THL3.0 Width : 1500 mm
THL4.0 Width : 1550 mm
THL4.5 Width : 2000 mm
Depth : 1150 mm
Height : 2320 mm
Net weight approx. : 1500 Kg

MAXIMUM CYLINDER HEAD SIZE

Length (on parallels with standard 190 mm pilot) : unlimited
Width (on parallels with standard 190 mm pilot) : 500 mm
Heigth (on parallels with standard 190 mm pilot) : 330 mm

MACHINING CAPACITY

Valve seat capacity : 16 to 120 mm
THL3.0 :16-70mm
THL4.0 :16-70mm
THL4.5 :16-120mm

HEAD STROKE

THL 3.0 Lenghtwise : 990 mm
THL 4.0 Lenghtwise : 990 mm
THL 4.5 Lenghtwise : 1440 mm
Crosswise : 35mm
Centering plane air cushion travel : 14 mm

SPINDLE

Spindle sleeve diameter : 80 mm
Spindle speed : 0 to 700 rpm
Maximum torque :
THL3.0/4.0 :50 Nm THL4.5 :70 Nm
Rated torque :
THL3.0/4.0 :15 Nm THL4.5 :21Nm
Travel : 250 mm
With extended spindle travel : 290 mm
Power : 0.75/1.0kw servo motor
Angular stroke : 5°

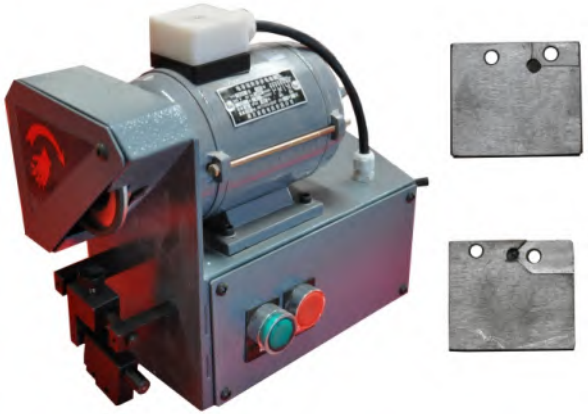
CONNECTIONS

Electric power supply : 4kVA 230V AC-IPh-50/60 Hz
Pneumatic air supply : 6 bars
Maximum air flow : 400 l/min - 15 CFM
Noise level at 400 rpm : 72 Dba
Noise level at 1200 rpm : 82 Dba

Standard Accessories

Tool Holder

Fixture



Carbide bit sharpener

Tool setting device

vaccum pad

Optional Accessories

Roll Over Fixture

Counterbore Micrometer

Bubble Level

Serdi Holder and Chuck

S5731

S2730

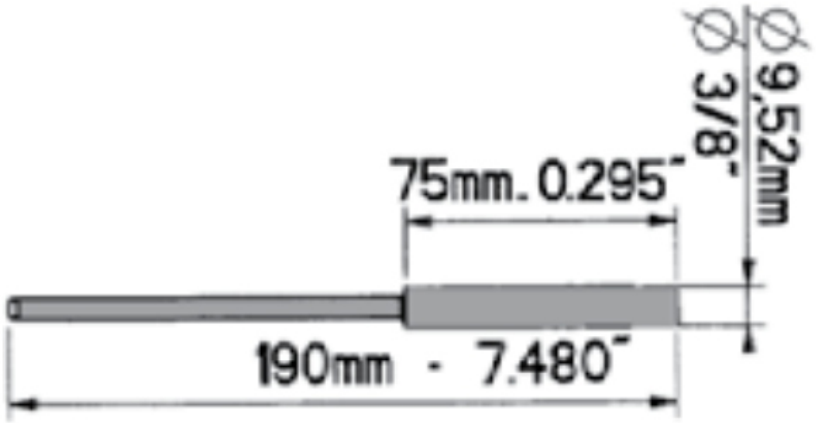
Optional Accessories

Pilots CL type

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

CL pilot available from:
- ***Ø 3.5 mm*** / 0,138'' to **Ø 14mm** / 0.550'' maximum

Standard length 190mm / 7.480''



opriginal 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	**CL 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** **AL13** **B1** **B2** **B4**				

cutting system 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	**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		**S2710** 8°rake angle Ref 019409	**S2711** 8°rake angle Ref 018768	**E type pilot** Ø 20 mm - .78'' shank **S2730** 8°rake angle Ref 019513
Cutting bit		**E1/D1** 8° draft angle Ref 0xxxxx	**D2/E2/E3** 8° draft angle Ref 9xxxxx **D2/E2/E3** 14° draft angle Ref 0xxxxx		**D2/E2/E3** 8° draft angle Ref 9xxxxx **D2/E2/E3** 14° draft angle Ref 0xxxxx

Tooling for seat and guide 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)**

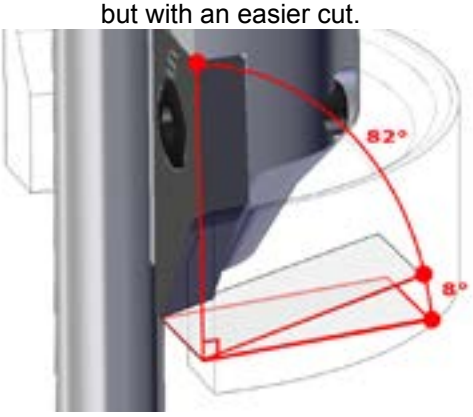
D2

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)

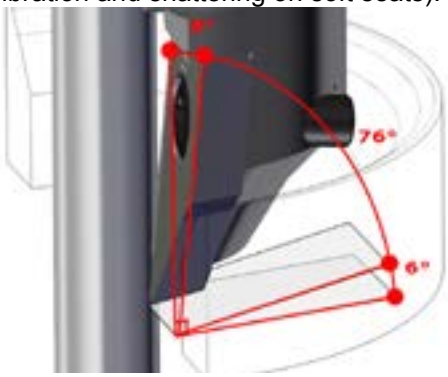
0° Rake Cutting Angle (Negative):

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).



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

Accomodates 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

Accomodates 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

Accomodates 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

Accomodates any pilot size with Ø 9.52mm - 3/8'' shank

Tool holders
Original style

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

Accomodates any pilot size with Ø 9.52mm - 3/8'' shank
Accomodates 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

Accomodates 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

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

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

Accomodates any pilot size with Ø 9.52mm - 3/8'' shank

006903 SERDI 3100

Chuck: Morse Taper 2

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

404115 SERDI 3200

Adaptator IS0 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 5731 - 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 5731 - 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

Accomodates 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

Accomodates 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

Accomodates 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

Accomodates 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

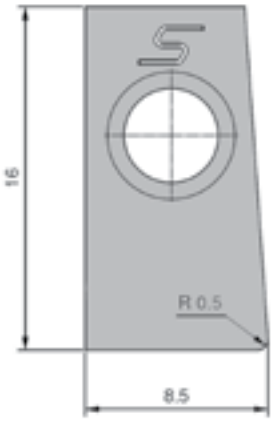
Only for tool holder #5300

Accomodates carbide cutting bit A and B type

Cutting bits counterboring

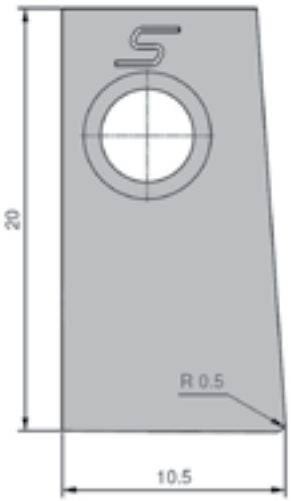
Cutting bit D1

019584



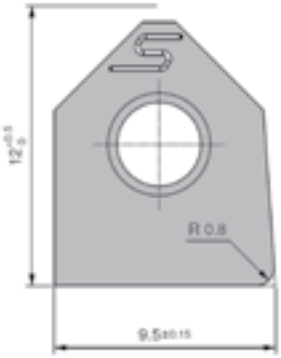
Cutting bit D2

- 017323 (0° rake) -917323 (8° rake)



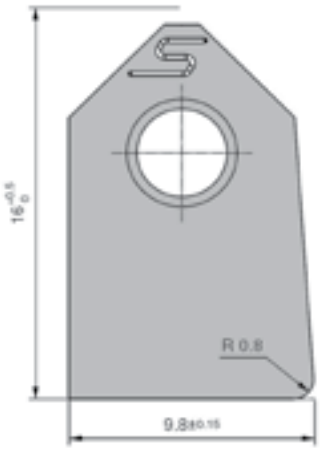
Cutting bit AL11

005168



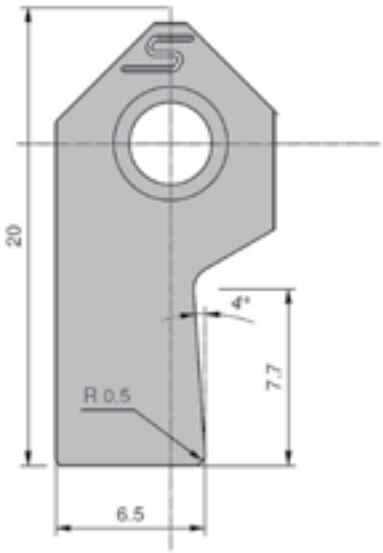
Cutting bit AL12

005164



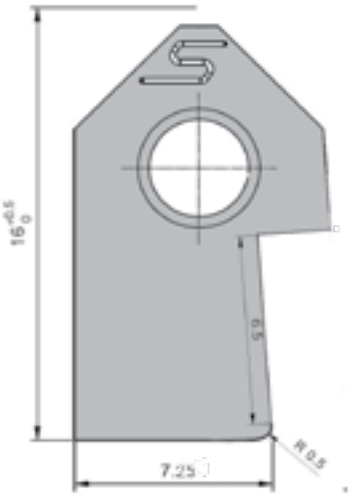
Cutting bit AL10

304604



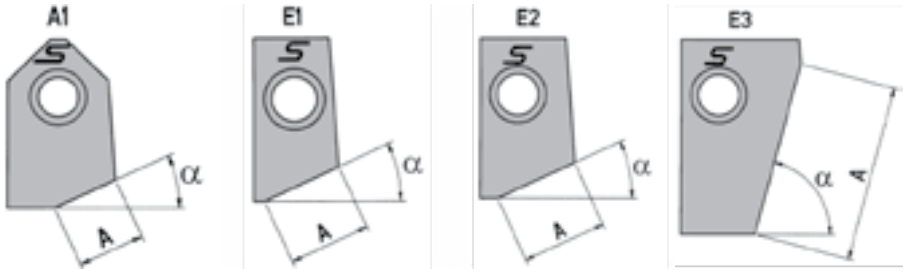
Cutting bit L12

013344



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

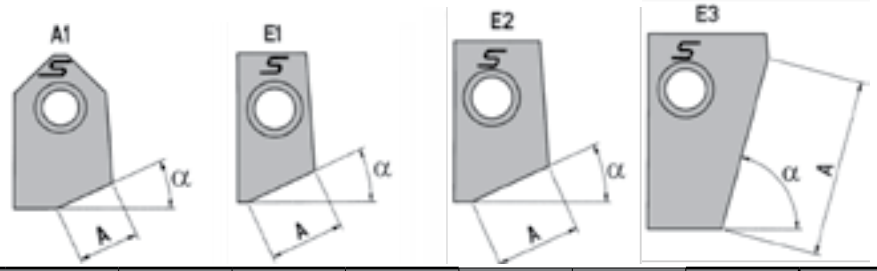
Cutting bits single angle



	α Degree	A mm	A *inch*	A1	E1	E2 -0°	E2 -8°	E3 -0°	E3 -8°	Original SERDI part
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			

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

Cutting bits single angle



	α Degree	A mm	A inch	A1	E1	E2 -0°	E2 -8°	E3 -0°	E3 -8°	Original SERDI part
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*			921299	021199			
18	**70**	16	*0,6299*					922396	022396	
19	**70**	16.8	*0,6496*	019154						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			

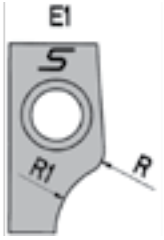
Cutting bits single convex radius

	Radius mm	Radius inch	A1	E1	E2 -0°	E2 -8°	Original SERDI part
1	**4.5**	*0,1772*	001653	022417	922418	022418	504-A1
2	**5**	*0,1969*	001673	022419	922089	022089	522-A1
3	**7**	*0,2756*	001660	022420	922421	022421	511-A1
4	**8**	*0,3150*	001675	022422	922423	022423	527-A1
5	**27**	*1,0630*	001668	022424	922425	022425	518-A1

Cutting bits single concave radius cutting bits

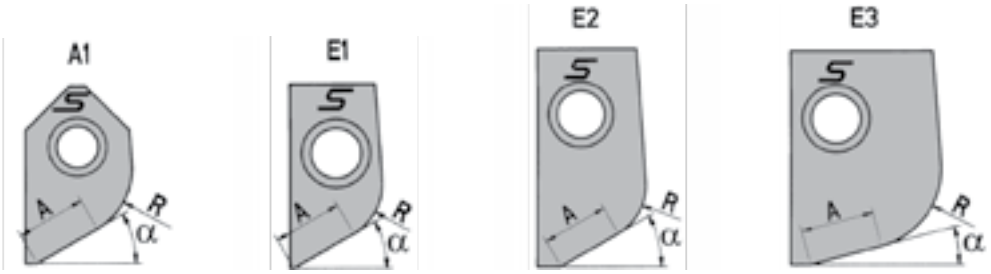
	Radius mm	Radius inch	H mm	H inch	A1	E1	E2 -0°	E2 -8°	Original SERDI part
6	**8**	*0,3150*	2.00	*0,0787*	018952	018953			
7	**8**	0,3150	3.00	*0,1181*	008661	022427	922428	022428	
8	**12**	0,4724	2.00	*0,0787*	001649				501-A1
9	**12**	0,4724	2.40	*0,0945*	017301				
10	**12**	0,4724	2.50	*0,0984*		022429	922430	022430	

Cutting bits twin radius cutting bits



	Radius R1 mm	Radius R1 inch	Radius R mm	Radius R inch	A1	E1	E2 -0°	E2 -8°	Original SERDI part
11	**5**	*0,1969*	2	*0,0787*	001655	022431	922432	022432	506-A1
12	**6**	0,2362	2	*0,0787*	017935	022433	922434	022434	

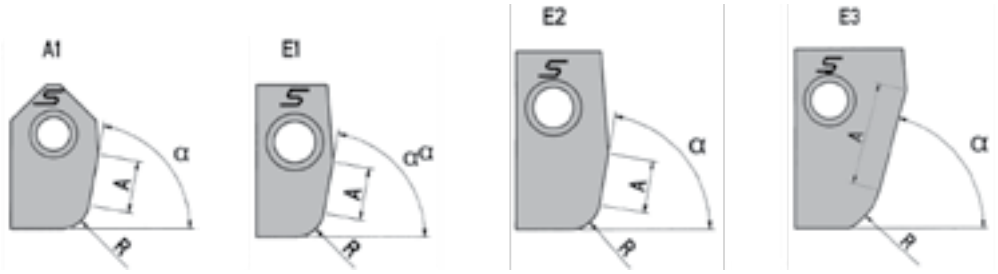
Cutting bits straight angle with 1 radius



	α	A		R		A1	E1	E2 -0°	E2 -8°	E3 -0°	E3 -8°	Original SERDI part
	Degree	mm	*inch*	mm	inch							
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

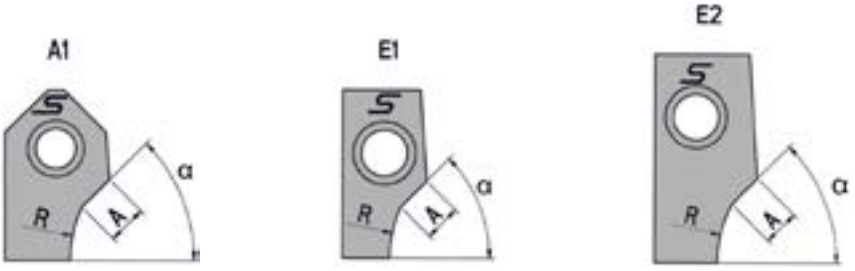
Standard cutting bits - the most popular profiles (see price lists) are registered in red.

Cutting bits 1 radius with straight angle



	α Degree	A mm	A inch	R mm	R inch	A1	E1	E2 -0°	E2 -8°	E3 -0°	E3 -8°	Original SERDI part
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			SC621-B3
9	**75**	12,00	*0,4724*	7	*0,2756*	009225				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	SC622-B3

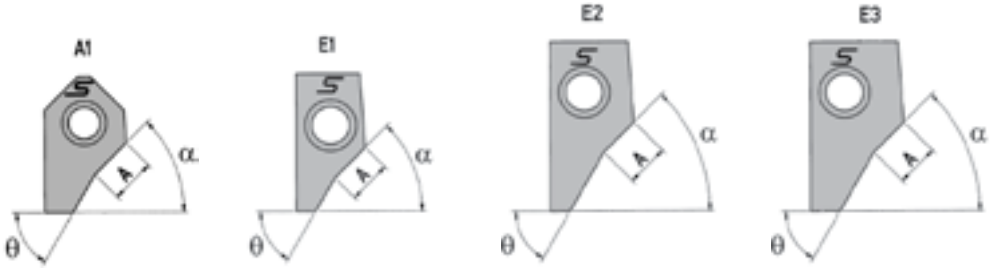
Cutting bits single concave radius - 1 angle



	α Degree	A mm	A inch	R mm	R inch	A1	E1	E2 -0°	E2 -8°	Original SERDI part
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	

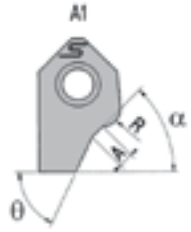
Standard cutting bits - the most popular profiles (see price lists) are registered in red.

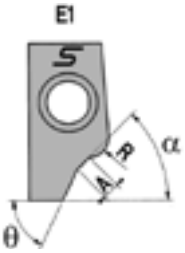
Cutting bits twin angles

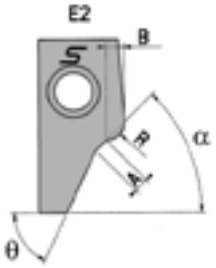


	α Degree	A mm	A *inch*	θ Degree	A1	E1	E2 -0°	E2 -8°	E3 -0°	E3 -8°	Original SERDI part
1	**10**	1,00	*0,0394*	20	000574				922535	022535	008-B3
2	**15**	1,00	*0,0394*	30	000573	022584	922536	022536			007-A1
3	**20**	3,20	*0,1260*	60	000968	022586	922585	022585			23001-A1
4	**25**	2,50	*0,0984*	45	001642	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

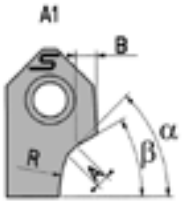
Cutting bits twin angles one radius

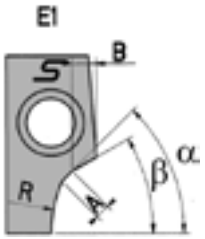


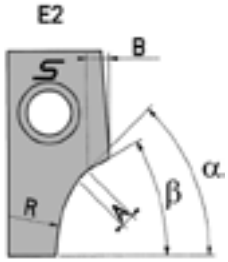




	α	A		R		θ	A1	E1	E2 -0°	E2 -8°	Original SERDI part
	Degree	mm	*inch*	mm	*inch*	Degree					
1	**30**	2,20	*0,0866*	2,50	*0,0984*	70	006218	022612	922615	022615	32016-A1
2	**30**	3,50	*0,1378*	0,60	*0,0236*	60	007016	022614	922617	022617	33009-A1
3	**45**	1,00	*0,0394*	6,00	*0,2362*	65	001272	022616	922619	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



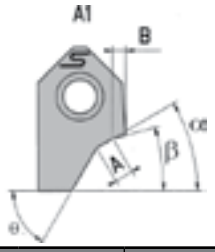


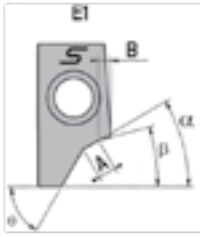


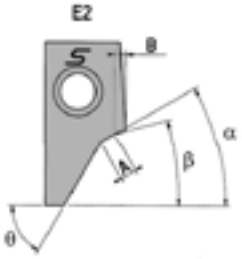
	α	A		B		θ	R		A1	E1	E2 -0°	E2 -8°	Original SERDI part
	Degree	mm	*inch*	mm	*inch*	Degree	mm	*inch*					
12	**30**	1.00	*0,0394*	1,93	*0,0760*	15	12	0,4724	001091	022644	922645	022645	31002-A1
13	**35**	1.00	*0,0394*	1,93	*0,0760*	15	12	0,4724	001189	022646	922647	022647	35102-A1
14	**45**	1,00	*0,0394*	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.

Cutting bits three angles - 30°



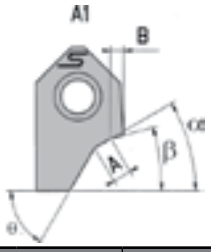


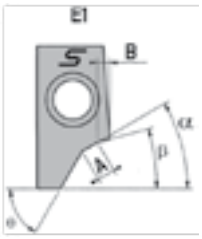


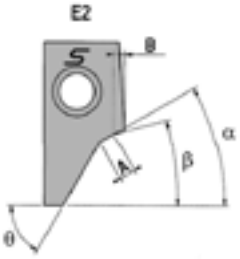
	α Degree	A mm	A *inch*	B mm	B *inch*	β Degree	θ Degree	A1	E1	E2 -0°	E2 -8°	Original SERDI part
1	**30**	1.00	*0,0394*	1.40	*0,0551*	15	60	001126	022664	921285	021285	310-A1
2	**30**	1.30	*0,0512*	1.00	*0,0394*	15	45	019162	022666	922665	022665	SC300
3	**30**	1.30	*0,0512*	2.00	*0,0787*	15	45	011648	022668	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°



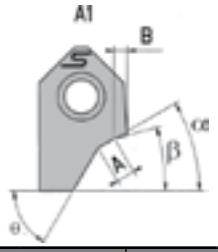


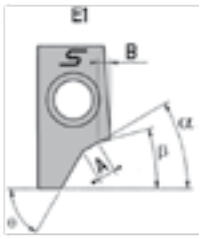


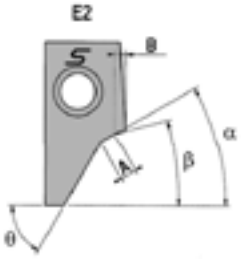
	α	A		B		β	θ	A1	E1	E2 -0°	E2 -8°	Original SERDI part
	Degree	mm	*inch*	mm	*inch*	Degree	Degree					
1	**45**	0.50	*0,0197*	2.00	*0,0787*	30	75	010620	022725	922723	022723	05K45X75-A1
2	**45**	0.85	*0,0335*	1.73	*0,0681*	30	67	001247	022729	922727	022727	40871-A1
3	**45**	1.00	*0,0394*	1.00	*0,0394*	35	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.

Cutting bits three angles - 45°



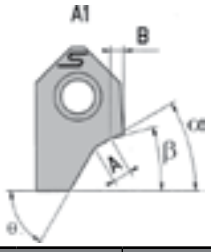


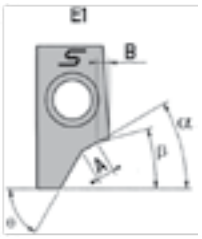


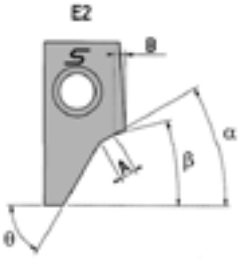
	α	A		B		β	θ	A1	E1	E2 -0°	E2 -8°	Original SERDI part
	Degree	mm	*inch*	mm	*inch*	Degree	Degree					
1	**45**	1.60	0,0630	2.00	*0,0787*	30	60	000802	022880	922879	022879	SC021
2	**45**	1.60	0,0630	2.00	*0,0787*	35	55	023445	025347	925346	025346	SC038
3	**45**	1.60	0,0630	3.00	*0,1181*	30	60	024914	025349	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



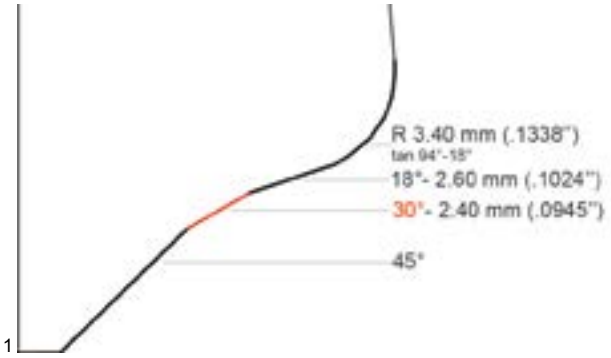




	α Degree	A mm	A *inch*	B mm	B *inch*	β Degree	θ Degree	A1	E1	E2 -0°	E2 -8°	Original SERDI part
1	**20,00**	2.00	*0.0787*	1.80	*0.0709*	0	60	000597				
2	**20,00**	4.00	*0,1575*	1.60	*0,0630*	5	65	011526		922941	022941	40H20A65-A1
3	**20,25**	2.70	*0,1063*	2.80	*0,1102*	15	60	019180				27P20.25U60-A1
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

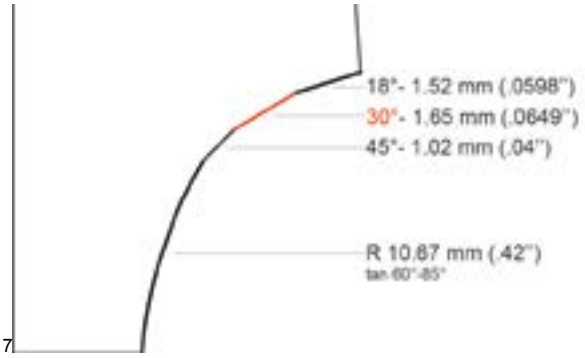
Standard cutting bits - the most popular profiles (see price lists) are registered in red.

Cutting bits performance 30°



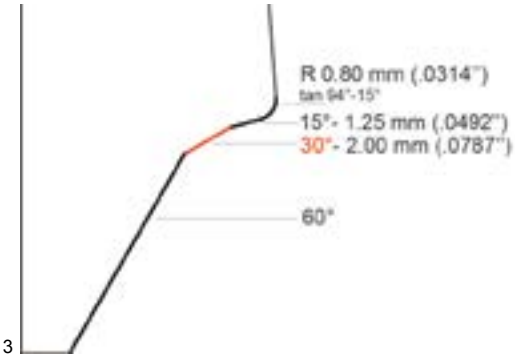
1

A1	E2-0°	E2-8°	Original SERDI part
019172	922717	022717	EMDSC45 - A1



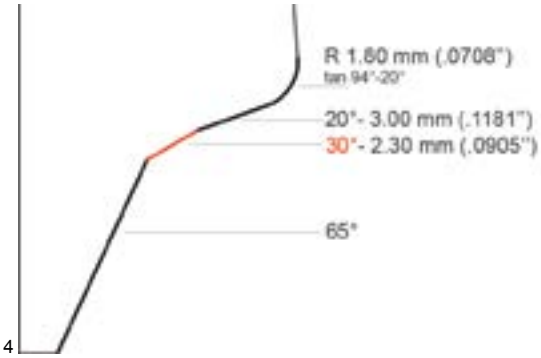
7

A1	Original SERDI part
028101	SC652-A1



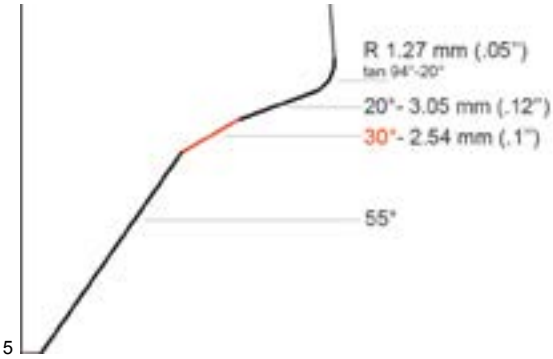
3

A1	E2-0°	E2-8°	Original SERDI part
000925	927111	024191	20J30U60R0.8



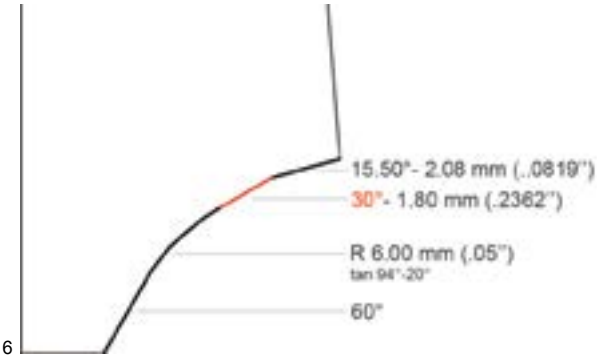
4

B1	Original SERDI part
025077	HP2706-B1



5

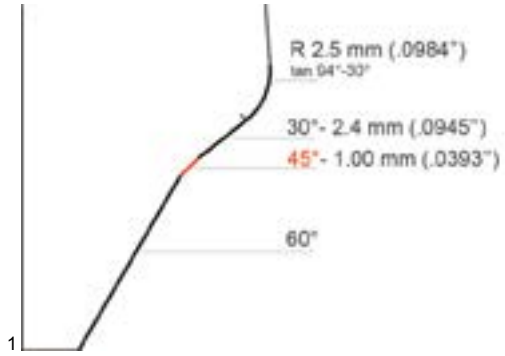
B1	Original SERDI part
028908	HP2934-B1



6

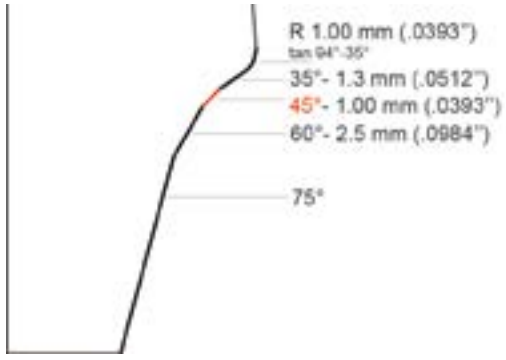
A1	Original SERDI part
026840	HP1472-A1

Cutting bits performance 45°



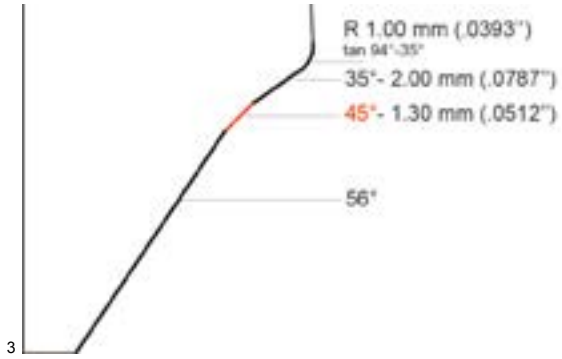
1

B1	E1	E2-0°	E2-8°	Original SERDI part
013338	025448	924189	024189	SC600 / H1.1N1-B1



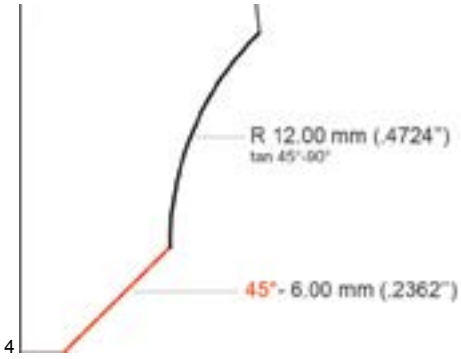
2

B1	E1	E2-0°	E2-8°	E3-0°	E3-8°	Or. SERDI part
013342	005221	924190	024190	927056	027056	SC601/H1N1B1



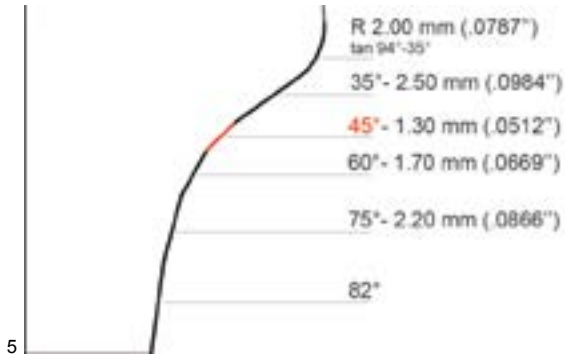
3

B1	E1	E2-0°	E2-8°	Original SERDI part
013337	025460	924191	024191	SC602 / H1X1-B1



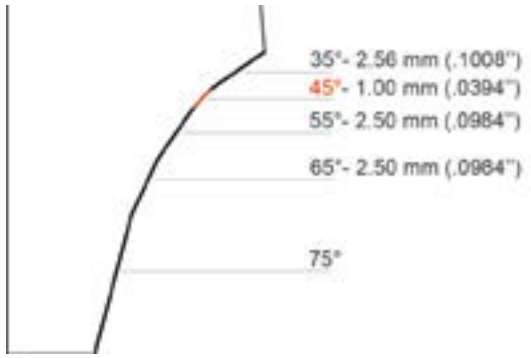
4

B1	E2-0°	E2-8°	Original SERDI part
013343	927058	027058	SC603 / H1X2-B1



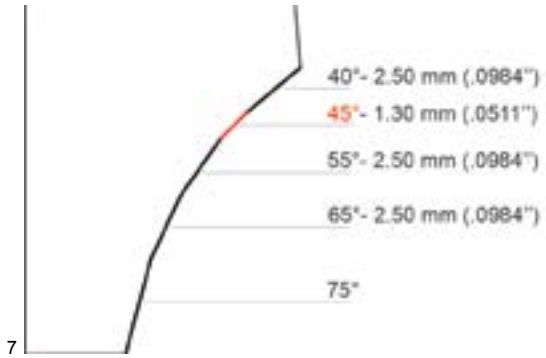
5

B1	E2-0°	E2-8°	E3-0°	E3-8°	Original SERDI part
013924	925463	025463	927020	027020	SC604 / HP2028-B1



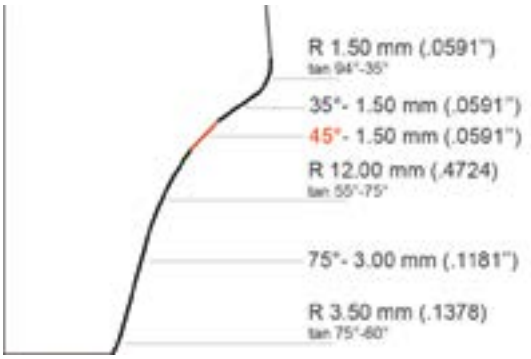
6

B1	E2-0°	E2-8°	E3-0°	E3-8°	Original SERDI part
025461	925487	025487	923361	023361	SC605 / HP2029-B1



7

B1	E1	E2-0°	E2-8°	Original SERDI part
001318	025523	927021	027021	SC606 / 41055-B1

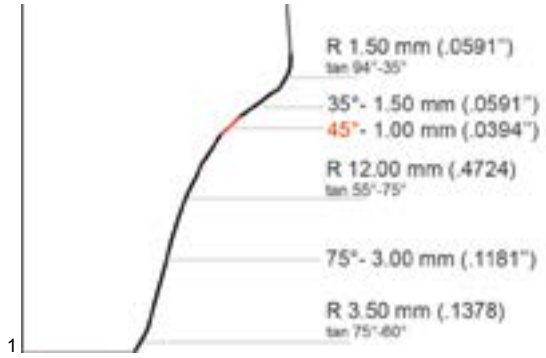


8

B1	E1	E2-0°	E2-8°	E3-0°	E3-8°	Original SERDI part
013327	025524	921301	021301	927022	027022	SC607 S9024-B1

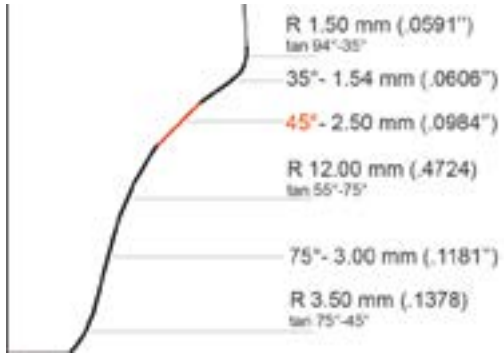
Standard cutting bits - the most popular profiles (see price lists) are registered in red.

Cutting bits performance 45°



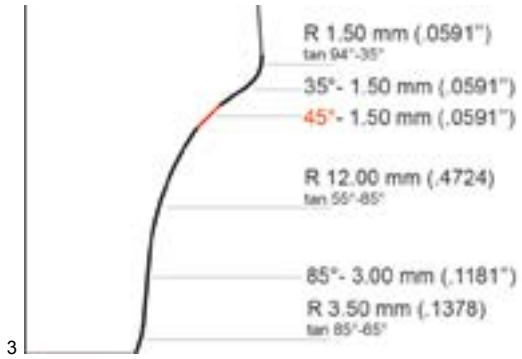
1

B1	E1	E2-0°	E2-8°	E3-0°	E3-8°	Original SERDI part
019205	026070	921302	021302	927061	027061	SC608 S9026-B1



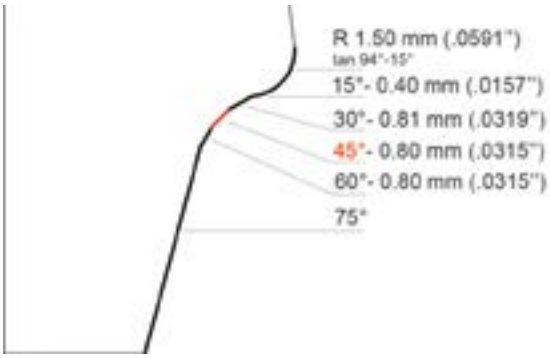
2

B1	E2-0°	E2-8°	Original SERDI part
025219	925489	025489	SC609 / HP1625-B1



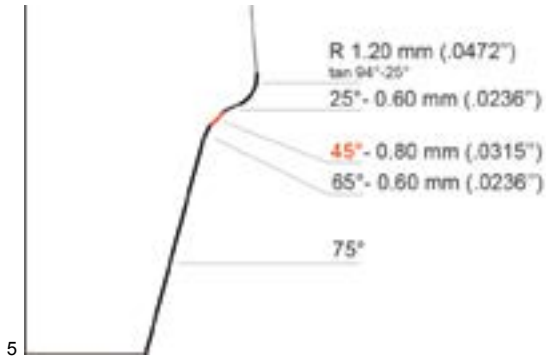
3

B1	E3-0°	E3-8°	Original SERDI part
013923	927023	027023	SC610 / HP1750-B1



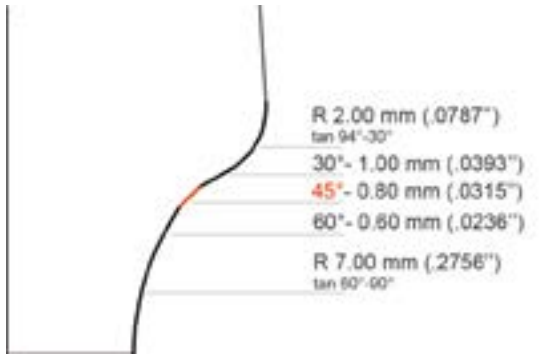
4

B1	E1	E2-0°	E2-8°	Original SERDI part
013925	022270	925462	025462	SC611 / HP1126-A1



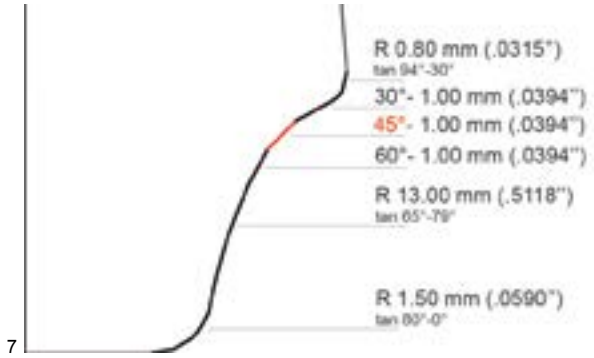
5

A1	E1	E2-0°	E2-8°	Original SERDI part
024938	026284	925464	025464	SC612 / HP1179-A1



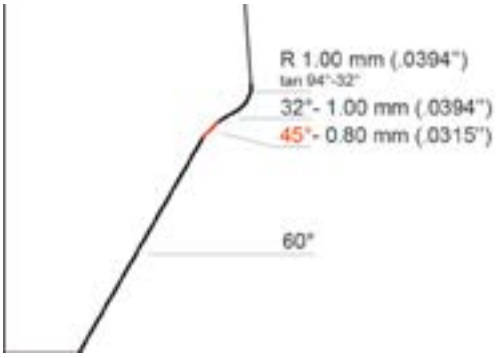
6

B1	E2-0°	E2-8°	E2-0°	Original SERDI part
009806	022272	925465	025465	SC605 / HP2029-B1



7

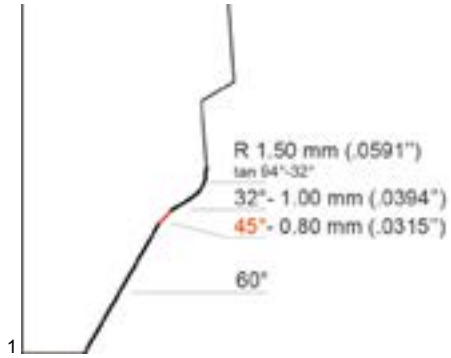
A1	E1	E2-0°	E2-8°	Original SERDI part
012834	025001	923369	023369	SC623 / HP10965-A1



8

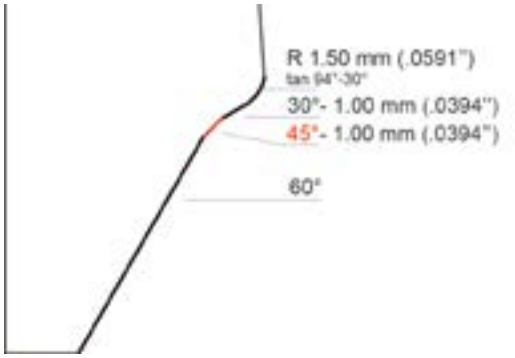
B1	E1	E2-0°	E2-8°	Original SERDI part
019523	026282	927024	027024	SC624 / 40805-A1

Cutting bits performance 45°



1

A1	E1	E2-0°	E2-8°	Original SERDI part
025192	026028	927012	027012	SC625 / 40805-A1

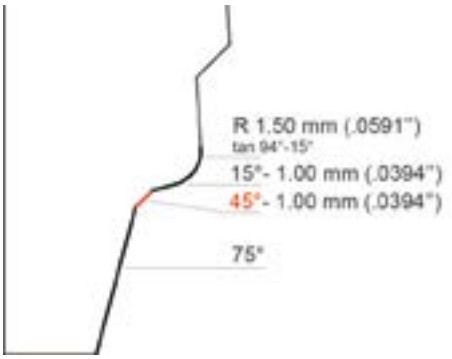


2

B1	E1	E2-0°	E2-8°	Original SERDI part
001260	023049	924016	024016	SC626 / 41001-A1

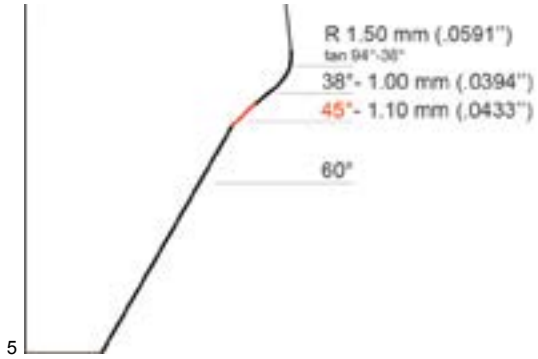
3

A1	E1	E2-0°	E2-8°	Original SERDI part
001266	025468	925469	025469	SC627 / 41026 - A1



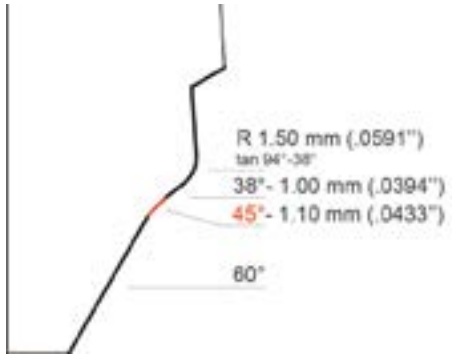
4

A1	E1	E2-0°	E2-8°	Original SERDI part
025220	026031	927031	027031	SC628 / 41003 - A2



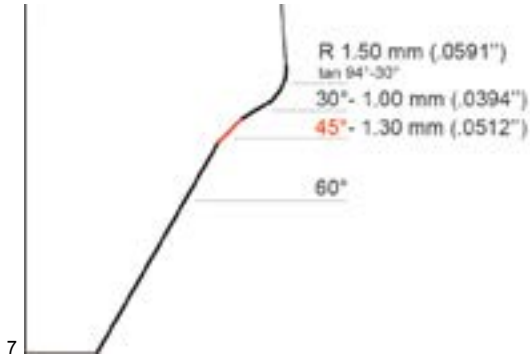
5

A1	E1	E2-0°	E2-8°	Original SERDI part
024943	025083	927128	027128	SC629 / 41026-A1



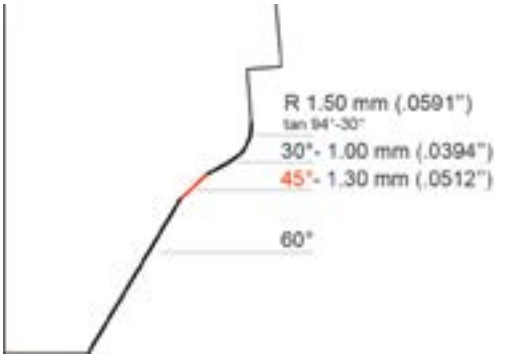
6

A1	E1	E2-0°	E2-8°	Original SERDI part
025461	026257	925487	025487	SC630 / 41026-A2



7

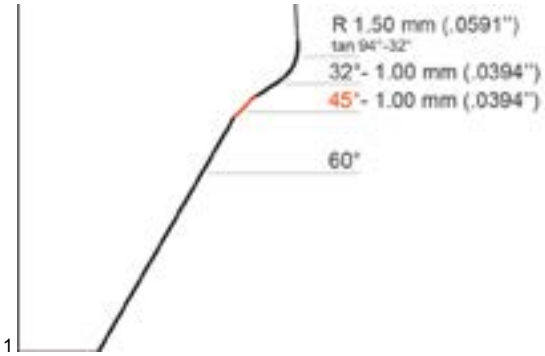
A1	E1	E2-0°	E2-8°	Original SERDI part
025490	025089	925471	025471	SC631 / 41046-A1



8

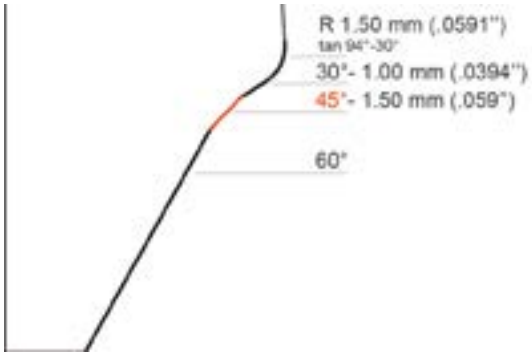
A1	E1	E2-0°	E2-8°	Original SERDI part
021857	025420	925473	025473	SC632 / 41046-A2

Cutting bits performance 45°



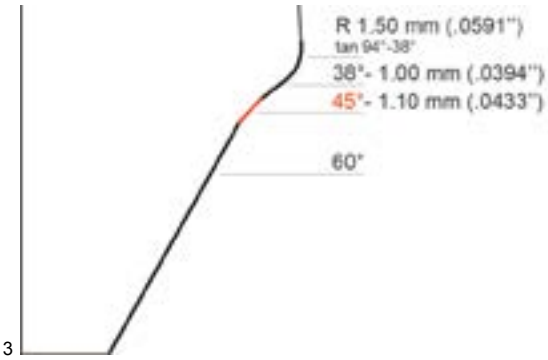
1

A1	E1	E2-0°	E2-8°	Original SERDI part
025474	026258	927064	027064	SC633 / 41065A1-SC636 / 41156A1



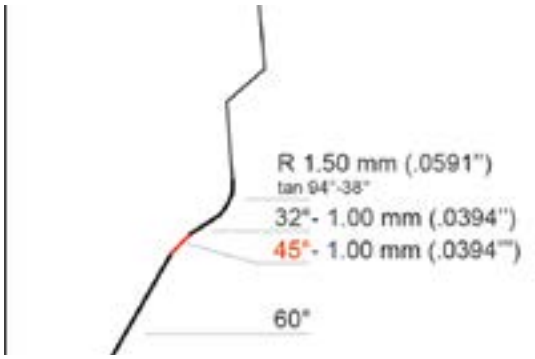
2

B1	E1	E2-0°	E2-8°	Original SERDI part
025475	025476	925477	025477	SC634/ 41091-A1



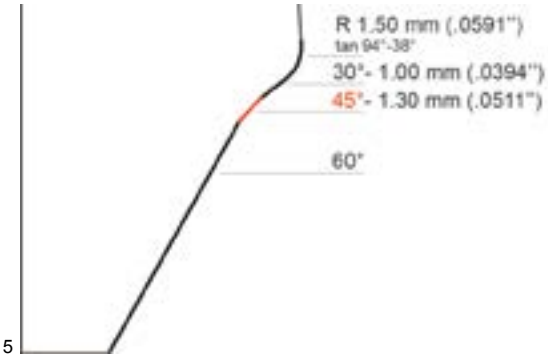
3

A1	E1	E2-0°	E2-8°	Original SERDI part
021859	025184	925478	025478	SC635 / 41091-A2



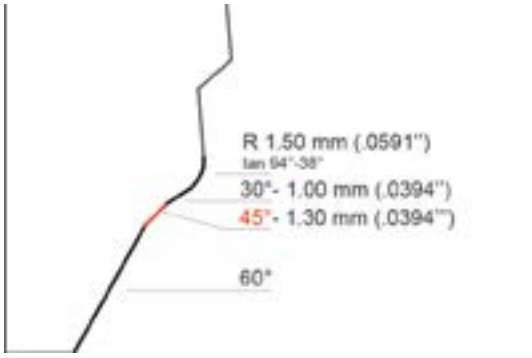
4

A1	E1	E2-0°	E2-8°	Original SERDI part
024615	026194	927106	027106	SC637 / 41156-A2



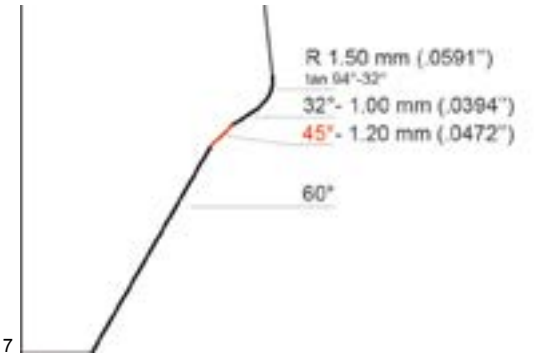
5

A1	E2-0°	E2-8°	Original SERDI part
021860	925429	025429	SC638 / 41181-A1



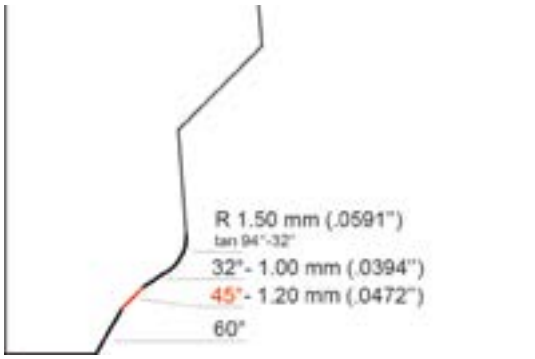
6

A1	E1	E2-0°	E2-8°	Original SERDI part
021858	025480	927089	027089	SC639 / 41181-A1



7

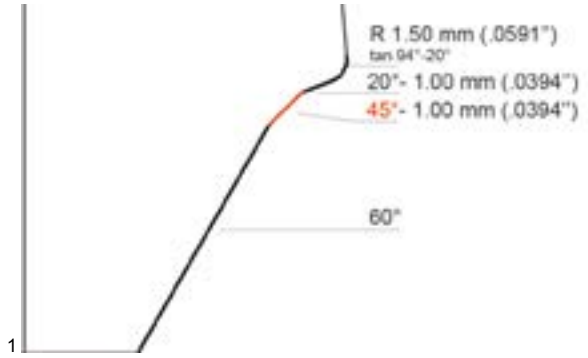
A1	E1	E2-0°	E2-8°	Original SERDI part
025081	025481	927025	027025	SC640 / 41182-A1



8

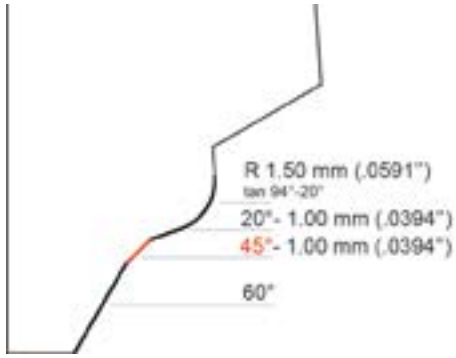
A1	E1	E2-0°	E2-8°	Original SERDI part
021861	025482	927033	027033	SC641 / 41182-A2

Cutting bits performance 45°



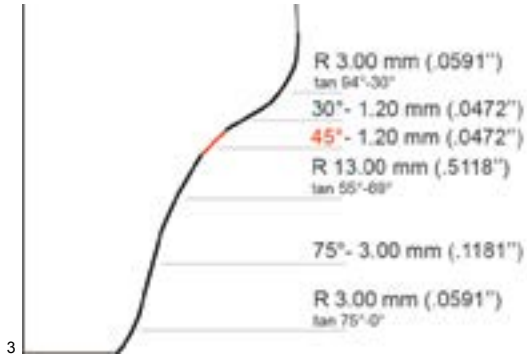
1

A1	E1	E2-0°	E2-8°	Original SERDI part
001446	025483	925484	025484	SC642 / 41200-A1



2

A1	E1	E2-0°	E2-8°	Original SERDI part
025221	025485	927034	027034	SC643 / 41200-A2



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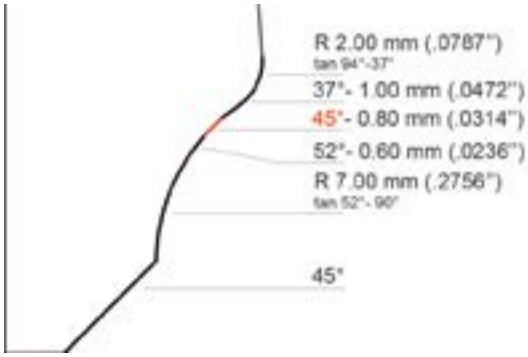
B1	E2-0°	E2-8°	Original SERDI part
022129	927115	027115	SC644 / HP1321- B1



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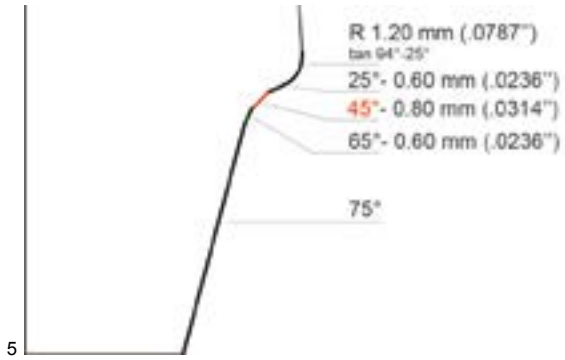
A1	E1	E2-0°	E2-8°	Original SERDI part
022130	025000	927130	027130	SC645 / HP1121 - A1



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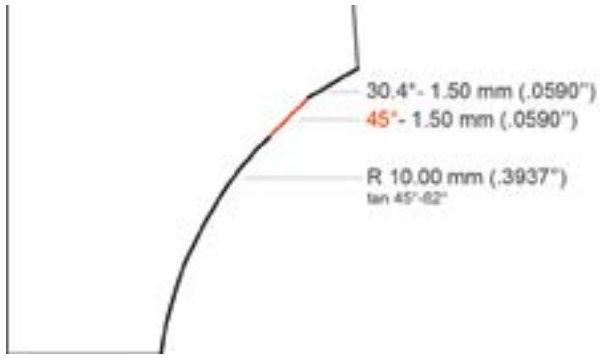
B1	E1	E2-0°	E2-8°	Original SERDI part
024986	025493	925494	025494	SC646



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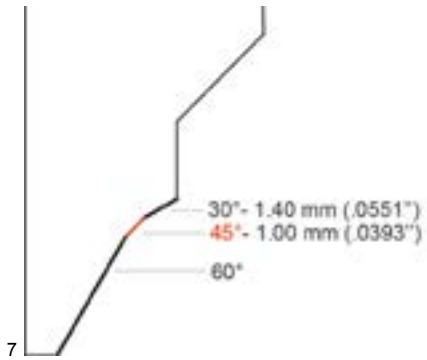
A1	E2-0°	E2-8°	Original SERDI part
025222	925691	025691	SC647



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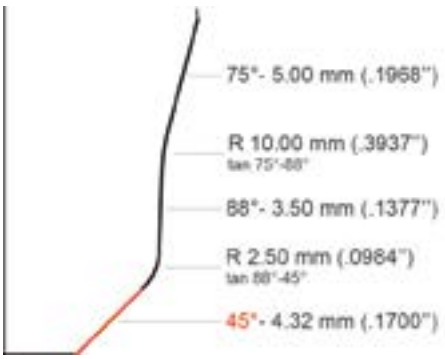
B4	E1	E2-0°	E2-8°	Original SERDI part
013378	027998	927999	027999	SC648 / 10F45X60B4



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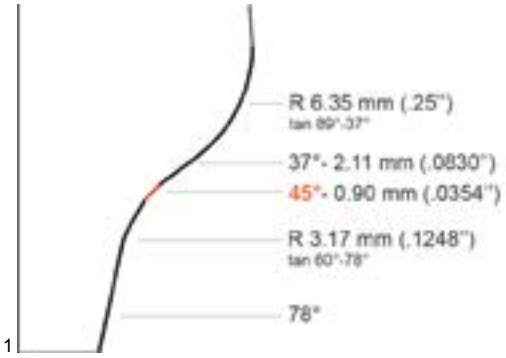
A1	E2-0°	E2-8°	Original SERDI part
023437	924192	024192	SC649

Cutting bits performance 45°



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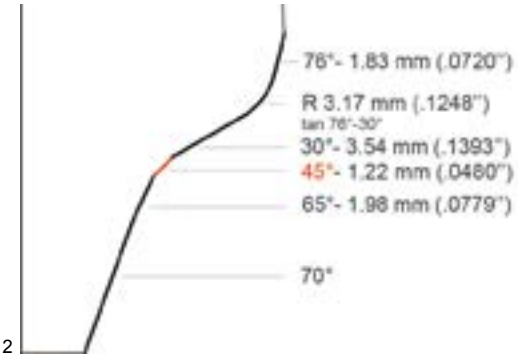
B1	Original SERDI part
012866	HP2157-B1



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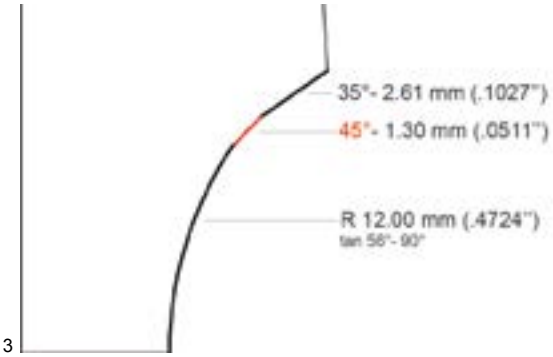
B1	Original SERDI part
012867	HP2156-B1



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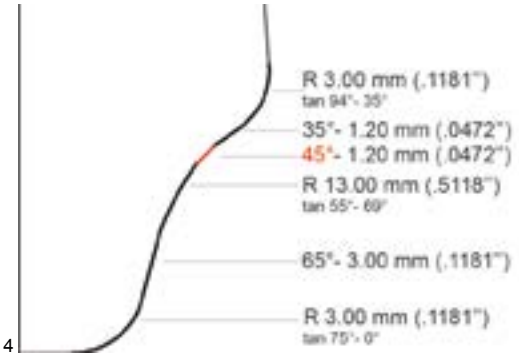
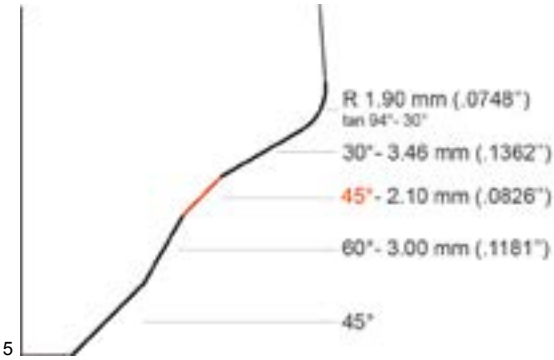
B1	E2-0°	E2-8°	Original SERDI part
019160	922519	022519	HP1953-B1



4

B1	Original SERDI part
024897	HP2944-B1



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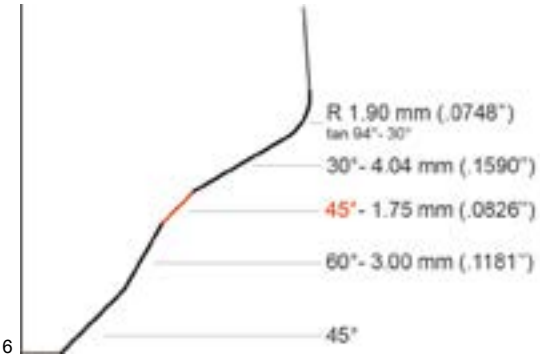
B1	Original SERDI part
024910	HP3157-B1



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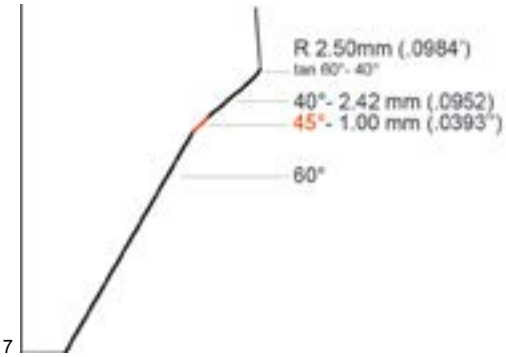
B1	Original SERDI part
024911	HP3158-B1



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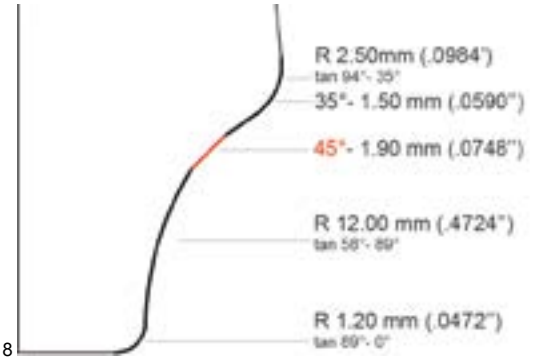
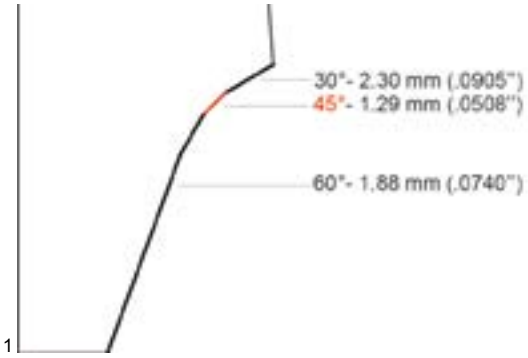
B1	E2-0°	E2-8°	Original SERDI part
025234	926914	026914	HP2353-B1



8

B1	Original SERDI part
025268	HP3343-B1

Cutting bits performance 45°



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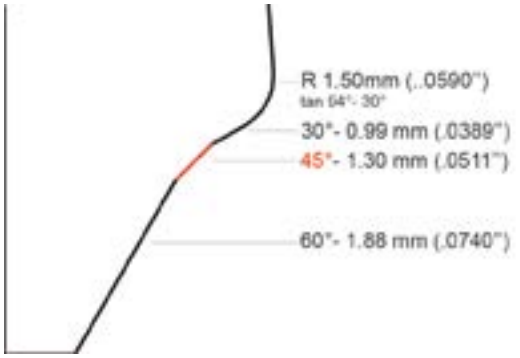
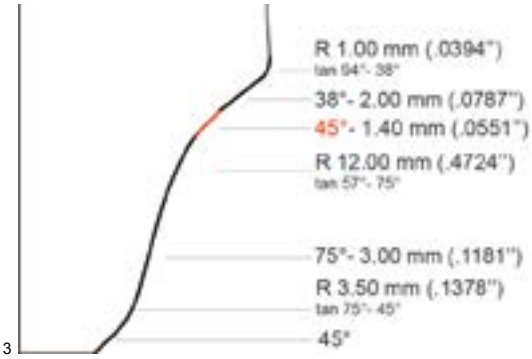
B1	Original SERDI part
025269	HP3344-B1



2

B1	E3-0°	E3-8°	Original SERDI part
025940	930501	030501	HP1984-B1



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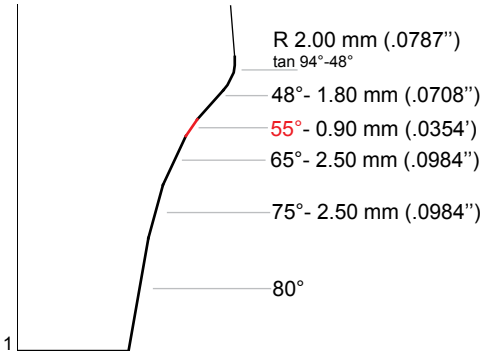
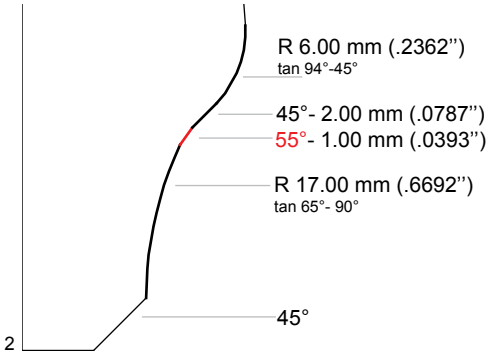
B1	Original SERDI part
030182	HP2113-B1

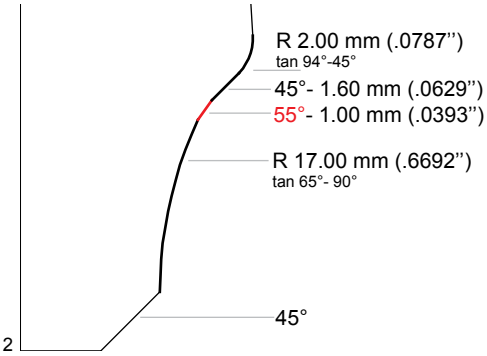
Cutting bits performance 55°

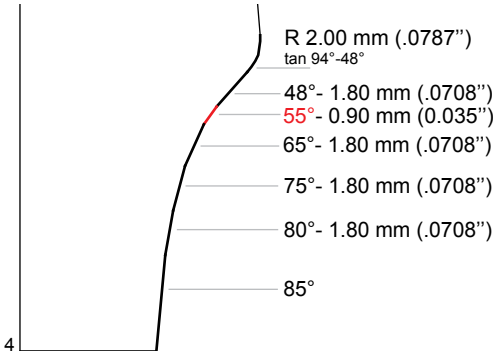


B1	Original SERDI part
024817	HP3475M-B1



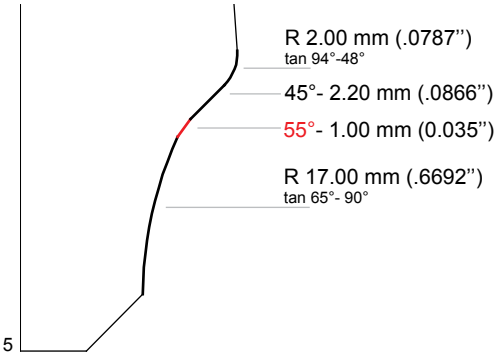
B1	Original SERDI part
025104	HP2013





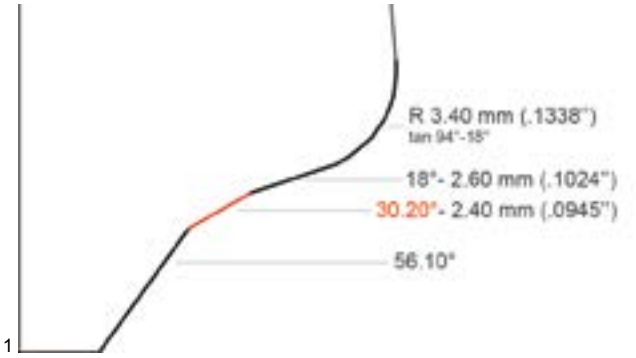
B1	Original SERDI part
024819	HP2013M

B1	
029617	



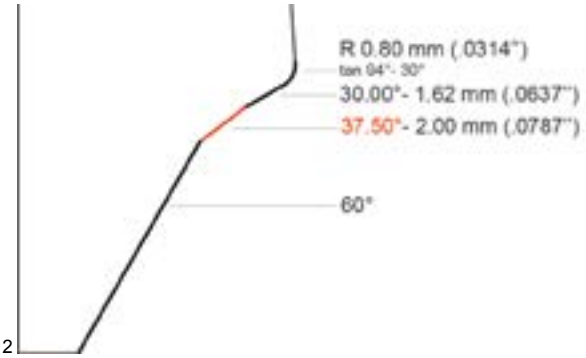
B1	
029668	

Cutting bits performance misc. angles



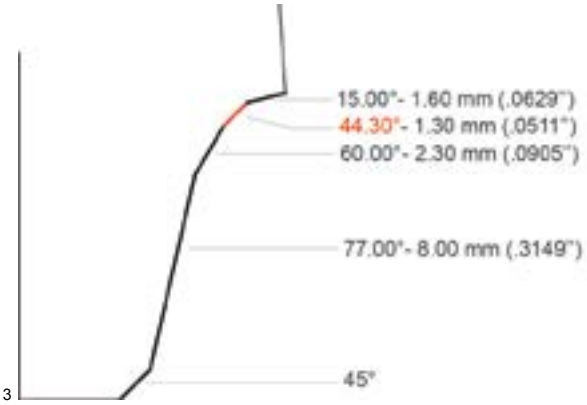
1

A1	E2-0°	E2-8°	Original SERDI part
013338	922719	022719	EMDSC56-A1



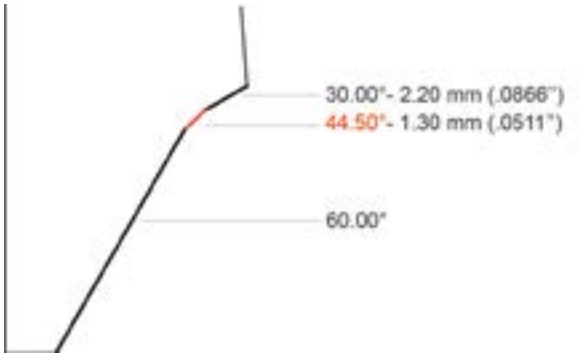
2

E2-0°	E2-8°	Original SERDI part
927110	027110	20J37.5X60R0.81

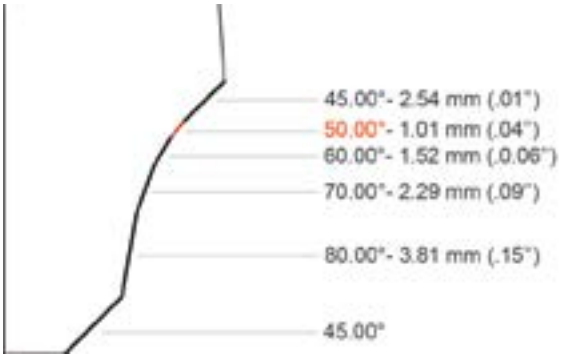


3

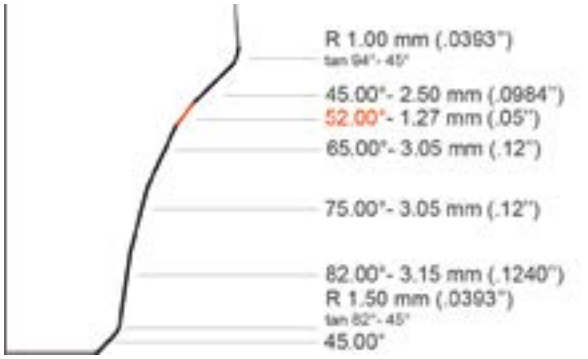
B1	Original SERDI part
012862	HP1988-B1



B1	Original SERDI part
025366	HP1900-B1

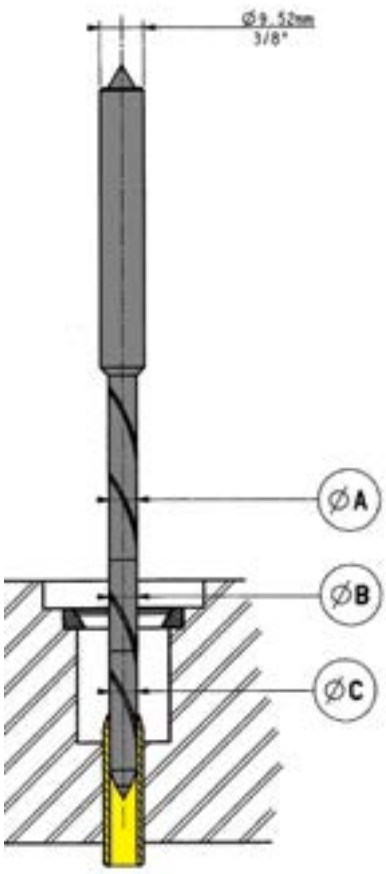


B1	Original SERDI part
025887	SC653



B1	Original SERDI part
025714	HP2977-B1

Reamers RS type



SERDI **R**eamer **S**pecial 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.

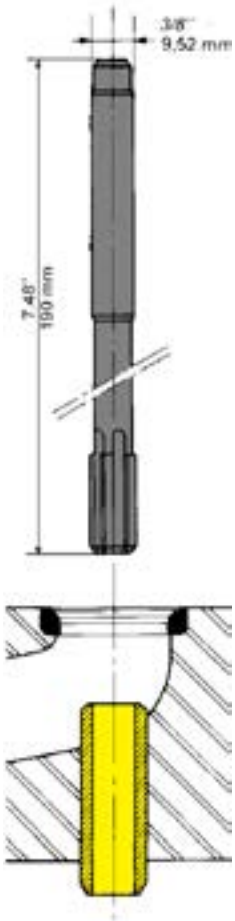
3- After a quick re-centering, the second pilot, section **A**, drives the spindle in perfect alignment with the newly reamed guide.

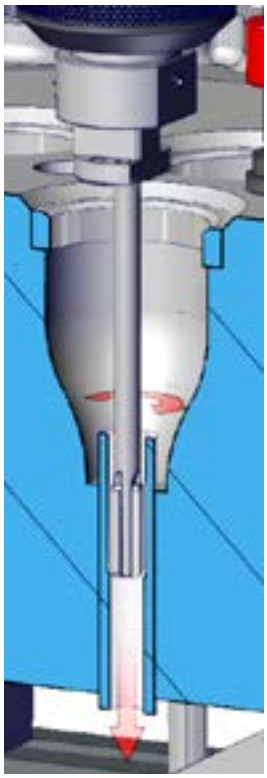
4- Keeping the spindle feeding down, the valve seat is machined perfectly concentric to the guide

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 **R**eamer **N**ormal

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*