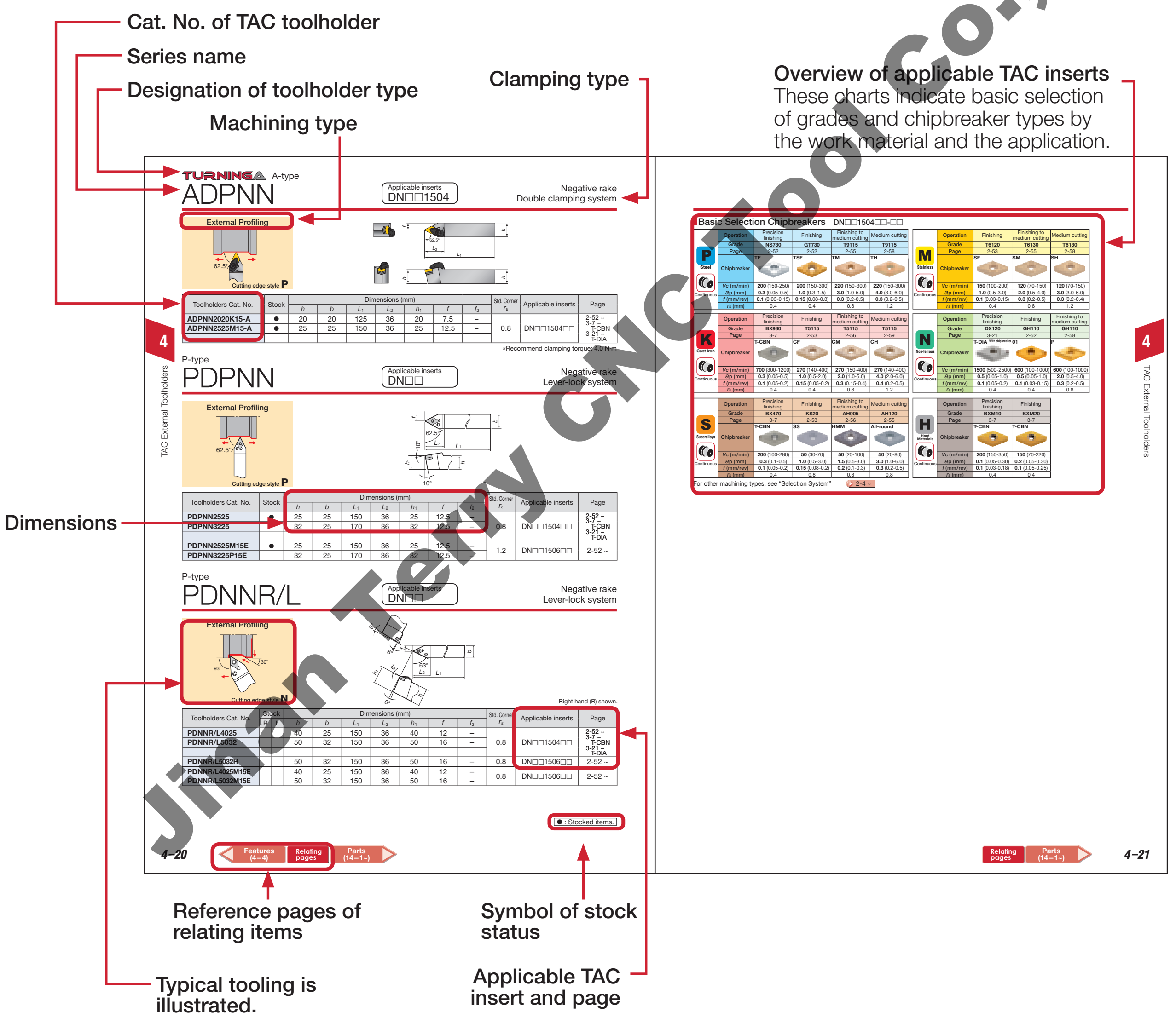
Chapter Composition of TAC External Toolholders

◆New and main products are arranged by the insert shape to be used. In the same group, they are arranged by the cutting edge style.
◆Other products are arranged by the series.



■Ordering information

● When ordering TAC toolholders, please specify Cat. No. and quantity.
Example: **ACLNR2525M12-A** 1 piece.
• Standard packing quantity is 1 piece.
• Inserts must be ordered separately.

Guidance

4 TAC External Toolholders

Products

Designation System for TAC Toolholders

❶ Clamping system

	Clamping system
A	Double Clamping
C	Clamp-on
D	One-Double
P	Lever-lock
JS	Screw-on
JT	Back clamping
M	Multi clamping
X	Double Clamping
S	Screw-on
T	Taper-lock

❸ Cutting edge style

Symbol	Shape	Offset
A	90°	Without
B	75°	Without
C	90°	Without
D	45°	Without
E	60°	Without
F	91°	With
G	91° / 91°	With
H	100°	With
I	76.5°	Without
J	93°	With
J2 *	93°	Without
K	75°	With
L	95° / 95°	With
L2 *	95° / 95°	Without
N	63°	Without
N3 *	63°	With
P *	62.5°	Without
P *	117.5°	Without
Q *	45°	With
S	45°	With
V	72.5°	Without
U	93°	With
X	100°	With
Y	80°	With
Z	93°	Without

No mark: ISO symbol
*mark: Tungaloy's symbol

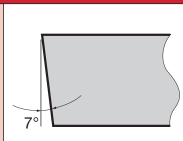
(Example) ❶ A W ❸ L N R

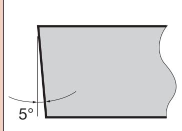
(Example) P ❷ T G ❹ N ❺ R

❷ Insert shape

	Insert shape
C	80° Rhombic
D	55° Rhombic
K	55° Parallelogram
R	Round
S	Square
T	Triangular
V	35° Rhombic
W	Trigon

❹ Relief angle of insert

C


B


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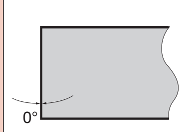
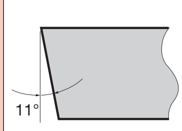
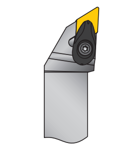


P


❺ Hand of tool

L


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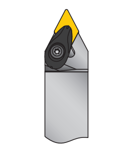
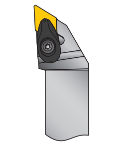
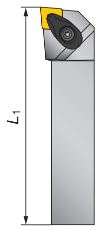


R


sales@jnterui.com

⑥ Height h (mm)	⑦ Width b (mm)
Shank size	

⑧ Holder length L_1 (mm)	
F	80
H	100
K	125
M	150
P	170
Q	180
R	200
S	250
T	300
U	350

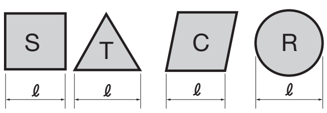


⑪ Added symbol	
RD	Ceramic insert with dimple
C	M-type for ceramic insert
A	Turning A

⑥	⑦	⑧			⑪
25	25	M	08	-	A
20	20	K	3		3
			⑨		⑩

⑨ Insert size (ℓ)

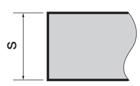
Symbol	Inscribed circle (mm)
3	9.525
4	12.7
5	15.875
6	19.05
8	25.4



In the ISO metric system, edge length of inserts is expressed by ℓ in 2 digits.

⑩ Insert thickness (s)

Symbol	Thickness (mm)
2	3.18
3	4.76



Turning Ace TURNINGA

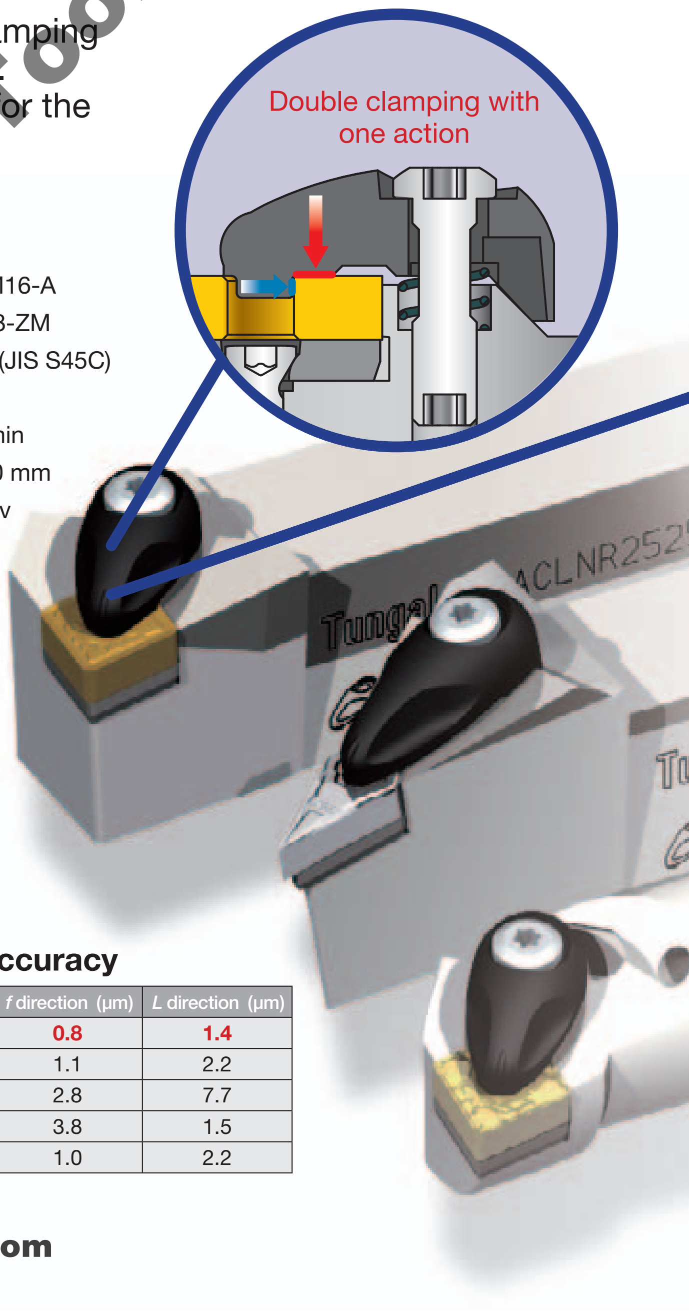
4-14 ~

Highly rigid “Double-Clamp” system provides remarkable stability and high accuracy!

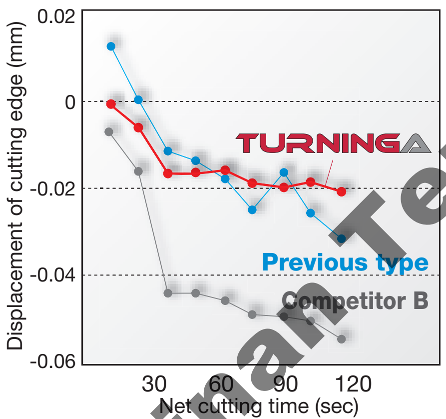
Simple and strong double-clamp system

Provides strong clamping force with one screw

Only one screw and one action delivers double clamping force by simultaneously pushing down and pulling.
This strong clamping force provides high stability for the cutting edge.

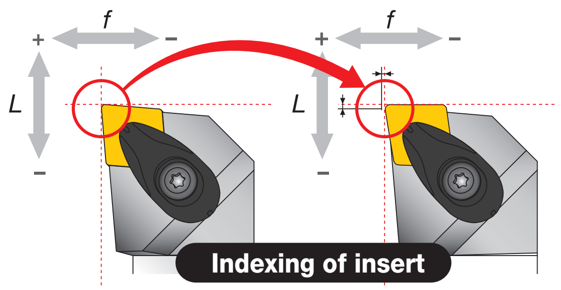


■ Comparison of cutting edge stability



Toolholder	: AVJNR2525M16-A
Insert	: VNMG160408-ZM
Work material	: Carbon steel (JIS S45C)
Machining mode	: Continuous
Cutting speed	: *Vc* = 150 m/min
Depth of cut	: *ap* = 1.0 ~ 2.0 mm
Feed	: *f* = 0.3 mm/rev

Higher indexing accuracy

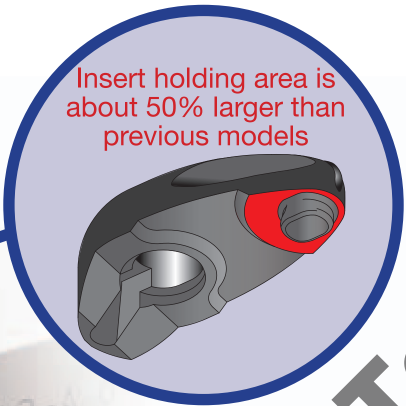


■ Indexing accuracy

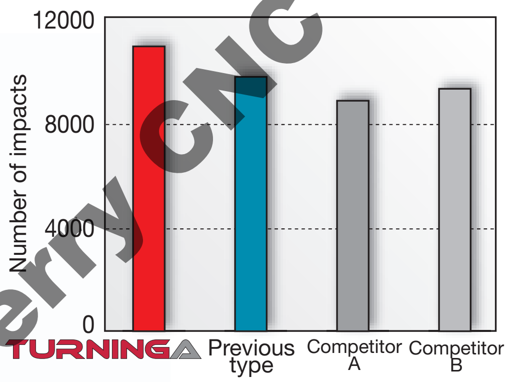
Type	*f* direction (μm)	*L* direction (μm)
TURNINGA	0.8	1.4
Previous type	1.1	2.2
Competitor A	2.8	7.7
Competitor B	3.8	1.5
Competitor C	1.0	2.2

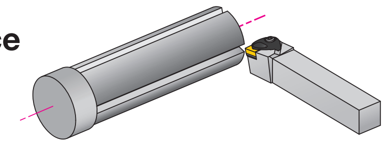
Unique clamp improves rigidity

Larger holding area enhances clamping force drastically. Higher rigidity provides excellent stability and reduces vibration.



■ **Comparison of impact resistance**



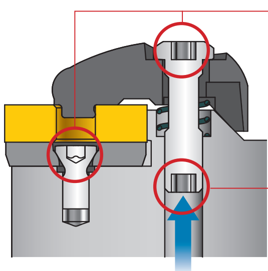


Toolholder	: ACLNR2525M12-A
Insert	: CNMG120408-TM
Grade	: T9115
Work material	: Carbon steel (JIS S45C)
Machining mode	: Interrupted
Cutting speed	: *Vc* = 200 m/min
Depth of cut	: *ap* = 1.0 ~ 2.0 mm
Feed	: *f* = 0.3 mm/rev

● Easy handling and maintenance

Only one wrench required

Only one wrench is required for the clamping screw and the shim screw.
Easy maintenance!



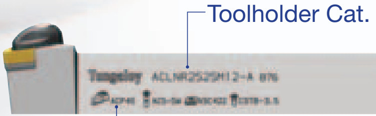
One wrench for both clamping and changing shim

Permits operation from underside

Marking

Parts Cat. No. are marked on the holder.

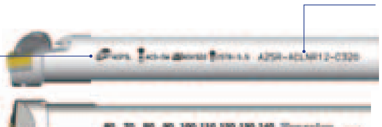
External-use toolholder



Toolholder Cat. No.

Parts Cat. No.
Clearly marked on the holder

Internal-use toolholders



Toolholder Cat. No.
(Min. bore diameter is included in Cat. No.)

The last three digits indicate min. bore diameter.
(Example : -D320 indicates 32.0 mm)

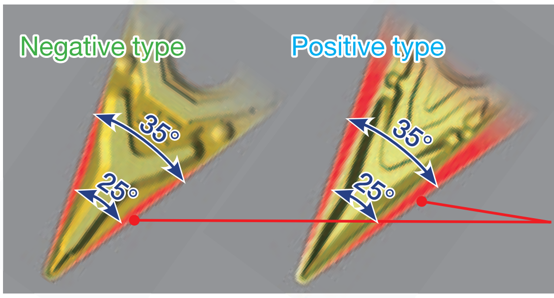
Scale of overhang length
Useful guide for setting the toolholder

Profiling inserts

Y-PRO SERIES

PATENT PENDING

A new concept in profiling!
Inserts with a 25° corner angle to expand machining possibilities!!



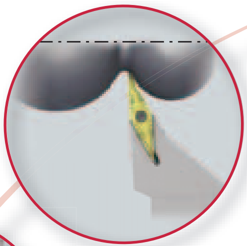
VNMG / VBMT → Y Pro series

35° ⇒ 25°

This angle reduction contributes to reducing customer costs

Suitable for a wide range of machining applications

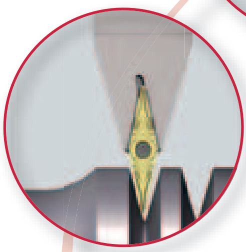
The new Y-Pro series expands the machining range of Taper cutting, undercutting and "V" grooving applications.



Negative Positive

Spherical profiling

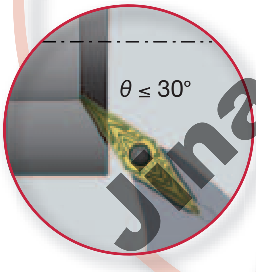
Enlarged clearance expands the interference avoidance area.



Negative Positive

"V" grooving

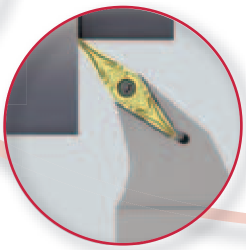
Suitable for various "V" grooving applications



Positive

Face profiling

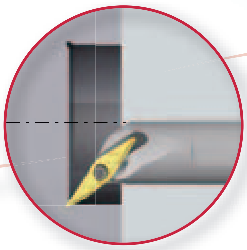
Allows drastic productivity and capability improvements



Positive

External undercutting

Allows a range of undercut forms to be machined



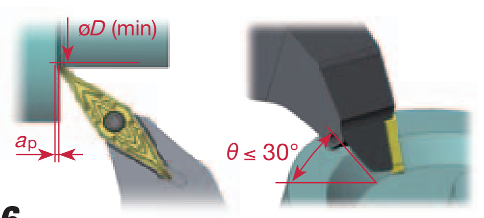
Positive

Internal undercutting and profiling

Allows undercutting of small diameters.

Comparison of undercutting capability

Reduced tool interference



Y Pro series / YWMT type

Corner r_ε	a_p (mm)	øD (mm)
0.2	0.5	ø10
	1.0	ø16
0.4	0.5	ø15
	1.0	ø18
0.8	0.5	ø21
	1.0	ø26

Corner angle 35° / VBMT type

Corner r_ε	a_p (mm)	øD (mm)
0.4	0.5	ø25
	1.0	ø30
0.8	0.5	ø45
	1.0	ø55

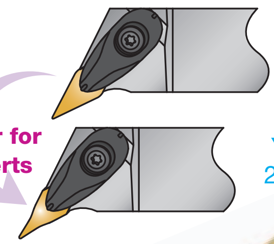
Improves the capability of small diameter machining!

YNMG type – Extremely capable and flexible insert

Negative

YNMG inserts are applicable for existing external and internal toolholders.

The Y-Pro series improves the application range for under cutting, V-grooving and taper machining.



Corner radius $r\varepsilon$
0.4 mm ⇒ 6.1 mm

Corner radius $r\varepsilon$
0.8 mm ⇒ 4.7 mm

For detailed applicability to toolholders, see "Instruction for use" in our leaflet. When using competitor's toolholders, the applicability should be checked in advance.

YWMT type - for a variety of machining processes

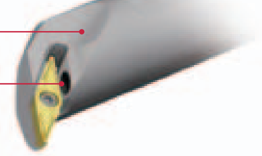
Positive

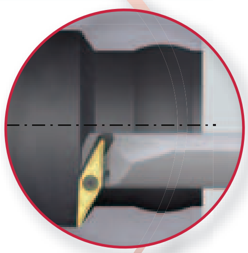
■External toolholders

Vastly reduced tool interference in facing and undercutting.

■Internal toolholders

By using the specialized "Stream Jet Bar" series of boring toolholders, excellent chip evacuation is guaranteed with its internal coolant supply.





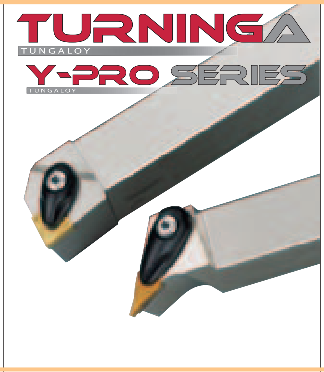
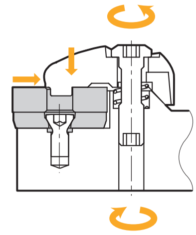
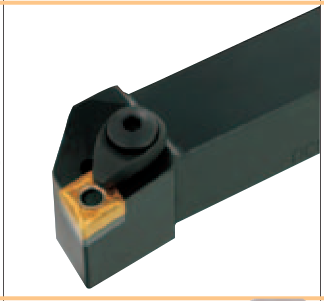
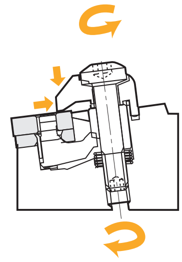
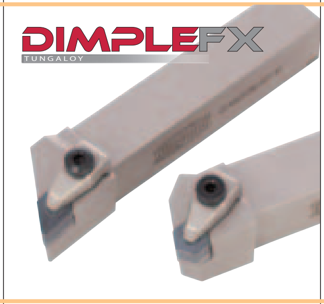
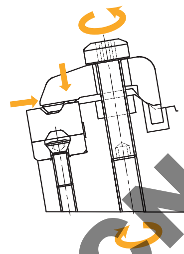
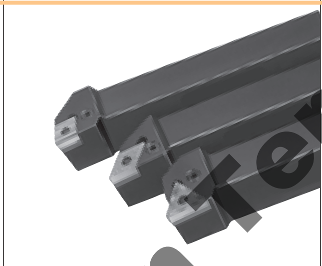
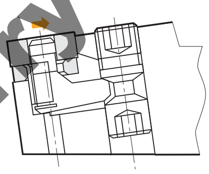
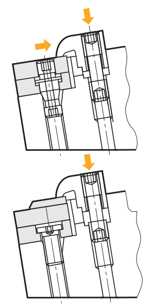
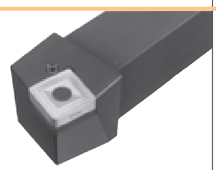
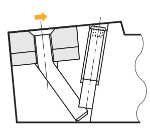
Positive

Internal profiling

Compared to 35°positive insert, can handle smaller bore diameters.

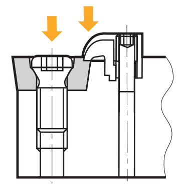
Structures and Features of External TAC Toolholders

Negative

Turning A **A** Double clamping 1st Choice 4-14 ~			● Improved rigidity allows excellent cutting edge positioning accuracy and extended tool life. ● Enlarged engaging area with the insert contributes to excellent cutting edge positioning, even when using a VNMG type insert (35° corner angle) whose cutting edge tends to displace. ● Simple clamping mechanism allows low cost tooling. Insert can be clamped with only one wrench.
D "One-Double" High rigidity 4-14 ~			● Easy and reliable clamping through a one action, double clamping operation. The single action of tightening the clamping screw results in a double action via the clamp and lever that securely fastens the insert into position. ● Unsurpassed stability at the cutting point.
DimpleFX **C** Double clamping for dimple ceramic insert High rigidity 4-36 ~			● Pulling down at dimple and pressing the insert top, Highly rigid double clamping system, ● Just "one" screw is needed for clamping. Easy handling and rigid clamping ● Easy operation in upside-down position
P Lever lock General 4-15 ~			● High indexing accuracy due to a 2 face restraining mechanism and exhibits excellent performance with NC lathe and special purpose machines.
M Multi clamping 4-46 ~			● Insert holding mechanism is combination of lock-pin system and clamp-on system. ● Toolholders specifically for use with a ceramics insert are also available. ● A wide range of styles and sizes of toolholders and inserts are available.
H Retract-pin Heavy duty 4-56 ~			● TAC toolholders for extra heavy use

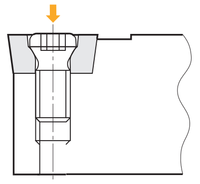
Positive

TurnFeed
X
Double Clamping (Screw-on / clamp)
High feed
4-42 ~



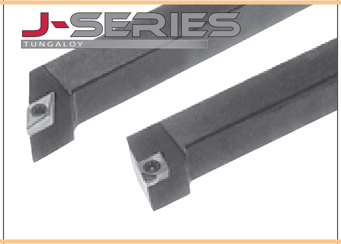
- Allows super high feed machining. Amazingly 8 times the productivity.
- The double clamping mechanism of the clamping screw and the clamp can securely clamp the insert.

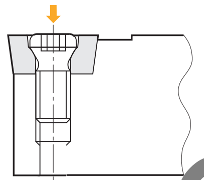
S
Screw-on
4-42 ~



- Simple clamping mechanism.
- Smart shape without overhang area.
- Good cutting action by using positive inserts.

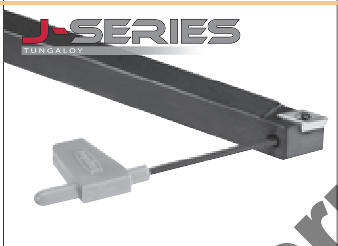
J
Screw-on
Small lathes
4-69 ~

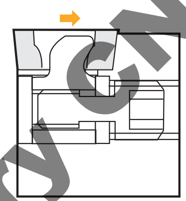




- Available in small to medium shank sizes and abundant cutting edge styles.
- Secure insert fastening by highly durable Torx screw.
- The shank of J type toolholders is ground on all four faces.

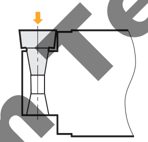
JT
Back clamping
Small lathes
4-69 ~





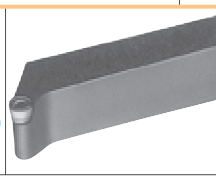
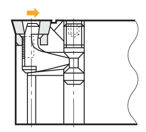
- Good operability for indexing the insert in limited space such as on gang tooling type lathes.
- Good handling allows wrenching the clamping screw from back side of the toolholder.
- Available shank height: 8, 10, 12 and 16 mm

T
Taper-lock
General
4-65

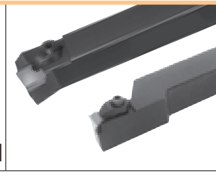
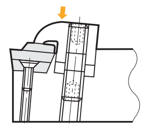
- Simplest mechanism composed only of an insert and toolholder.
- Can be used by simply pushing the insert into the tapered hole of the toolholder.
- The cavity formed on the top of the insert allows freer cutting action and chatterless machining.
- Inserts are available in ø5, ø6, and ø8 mm diameters.

P
Lever lock
General
4-66

- Positive rake round insert is clamped through lever lock type clamping mechanism with high indexing, accuracy.
- Used for external, face, profile cutting and high feed is possible with excellent surface finish.
- Insert diameters: ø10,12,16, 20, 25 mm

C
Clamp-on
General
4-67 ~

- General purpose, clamp-on system, positive rake toolholders.
- Strong insert clamping and excellent indexing accuracy.
- The positive rake design allows freer cutting action.

Types and Applications of TAC Toolholders

Negative

Application	Turning Facing	External profiling					Turning			
Cutting edge style / Type	L 95°	J 93°		N 63°	V 72.5°	P 62.5°	A 91°	G 91°	B·R 75°	
Turning A Double clamping	80° CN□□ ACLNR/L □12-A □16-A □19-A 4-14 80° WN□□ AWLNR/L □06-A □08-A 4-17	55° DN□□ ADJNR/L □15-A □1506-A 4-18 60° TN□□ ATJNR/L □16-A 4 -24	35° VN□□ AVJNR/L □16-A 4-30 25° YNMG AVJNR/L □16-A 4-30		35° VN□□ AVVNN □16-A 4-30 25° YNMG AVVNN □16-A 4-30	55° DN□□ ADPNN □15-A 4-20		60° TN□□ ATGNR/L □16-A □22-A 4-22	90° SN□□ ASBNR/L □12-A □15-A □19-A 4-25	
D One-Double	80° CN□□ DCLNR/L □12 □16 □19 4-14 80° WN□□ DWLNR/L □06 □08 4-17	55° DN□□ DDJNR/L □15 □1506 4-18						60° TN□□ DTGNR/L □16 □22 4-22	90° SN□□ DSBNR/L □12 □15 □19 4-25	
C Double clamping for dimple ceramic insert	80° CNGD CCLNR □1207-RD 4-36	55° DNGD CDJNR/L □1507-RD 4-36		55° DNGD CDNNN □1507-RD 4-37	35° VNGD CVVNN □1607-RD 4-37					
P Lever lock	80° CN□□ PCLNR/L □09 □12 □16 □19 4-15	55° DN□□ PDJNR/L □11 □15 □1506 4-18		55° DN□□ PDNNR/L □15 □1506 4-20		55° DN□□ PDPNN □15 □1506 4-20		60° TN□□ PTGNR/L □16 □22 □27 4-22	90° SN□□ PSBNR/L □09 □12 □15 □19 □25 4-25 100° CN□□ PCBNR/L □12 □16 □19 4-16	
M Multi clamping	80° CN□□ MCLNR/L □12 □16 □19 4-46 80° CN□□ MCLNR/L □12 4-46 80° WN□□ MWLNR/L □08 □10 □13 4-46	35° VN□□ MVJNR/L □16 4-49 25° YNMG MVJNR/L □16 4-49 60° TN□□ MTJNR/L □16 □22 4-47	55° DN□□ MDJNR/L □11 □15 □1506 4-47 55° DN□□ MDJNR/L □15 4-47 60° TN□□ MTJNR/L □16 □22 4-47		35° VN□□ MVVNN □16 4-50 25° YNMG MVVNN □16 4-50	55° DN□□ MDPNN □11 □15 □1506 4-47 55° DN□□ MDPNN □15 4-47		60° TN□□ MTGNR/L □16 □22 □27 □33 4-48 60° TN□□ MTGNR/L □16 □22 4-48	90° SN□□ MSBNR/L □12 4-50 90° SN□□ MSBNR/L □12 4-50	
C Clamp-on		55° KNMX CKJNR/L □16 4-55		55° KNMX CKNNR/L □16 4-55				60° TN□□ CTGNR/L □16 4-54	90° SN□□ CSBNR/L □12 4-54	
H Retract-pin									90° SNMM HSRNR/L □31 4-56	
JT Back clamping	80° CN□□ JTCL2NR/L □09 4-80	55° DN□□ JTDJ2NR/L □11 4-80					60° TN□□ JTTANR/L □16 4-80			

	Turning Chamfering		Turning/Facing Chamfering	Facing			Profiling		External profiling
	E 60°	D 45°	S 45°	K 75°	F 91°	C 90°	X 100°	Q·H 45° [*1] [*1]	Special
		90° SN□□ ASDNN □12-A 4-26	90° SN□□ ASSNR/L □12-A □15-A □19-A 4-28	90° SN□□ ASKNR/L □12-A 4-27	60° TN□□ ATFNR/L □16-A □22-A 4-23			55° DN□□ ADQNR/L □15-A □1506-A 4-19 35° VN□□ AVQNR/L □16-A 4-30 60° TN□□ ATQNR/L □16-A 4-24 25° YNMG AVQNR/L □16-A 4-30	- RN□□ ARGNR/L □12-A 4-32
		90° SN□□ DSDNN □12 4-26	90° SN□□ DSSNR/L □12 4-28	90° SN□□ DSKNR/L □12 4-27	60° TN□□ DTFNR/L □16 □22 4-23			55° DN□□ DDQNR/L □15 □1506 4-19	- RN□□ DRGNR/L □12 4-32
			90° SNGD CSSNR/L □1207-RD 4-36 90° HNGD CHSNR/L □0507-RD 4-37						
		90° SN□□ PSDNN □09 □12 □15 4-26	90° SN□□ PSSNR/L □09 □12 □15 □19 4-28	90° SN□□ PSKNR/L □09 □12 □19 □25 4-27	60° TN□□ PTFNR/L □16 □22 □27 4-23 80° CN□□ PCFNR/L □12 4-15			55° DN□□ PDQNR/L □15 □1506 4-19	- RNMG PRGNR/L □09 □12 4-32
	60° TN□□ MTENN □16 □22 4-49	90° SN□□ MSDNN □12 4-50 90° SN□□ MSDNN □12 4-50	90° SN□□ MSSNR/L □12 4-50 90° SN□□ MSSNR/L □12 4-50	90° SN□□ MSKNR/L □12 4-50 90° SN□□ MSKNR/L □12 4-50	60° TN□□ MTFNR/L □16 □22 □27 4-49 60° TN□□ MTFNR/L □16 □22 □27 4-49			55° DN□□ MDQNR/L □11 □15 □1506 4-47 25° YNMG MVQNR/L □16 4-49 55° DN□□ MDQNR/L □15 4-47 60° TN□□ MTQNR/L □16 □22 4-48 35° VN□□ MVQNR/L □16 4-49 60° TN□□ MTQNR/L □16 □22 4-48	- RN□□ MRGNR/L □12 4-51 80° RN□□ MRGNR/L □12 4-51
		90° SN□□ CSDNN □12 4-54	90° SN□□ CSSNR/L □12 4-54	90° SN□□ CSKNR/L □12 4-54	60° TN□□ CTFNR/L □16 4-54				

Note:*1 marked Q and H style are Tungaloy Standard.

Types and Applications of TAC Toolholders

Positive

Application	Turning Facing	External profiling			Turning			Turning Facing	Turning Chamfering	
Cutting edge style / Type	L 95°	J 93°	V 72.5°	N 62.5°	A 91°	G 91°	B·R 75°	X 20°	D 45°	
X Double clamping (Screw-on/clamp)								80° WPMT XWXPR/L □09 4-42		
P Lever lock										
C Clamp-on						60° TP□□ CTGPR/L □16 4-67	90° SP□□ CSBPR/L □09 □12 4-67		90° SP□□ CSDPN □09 □12 4-67	
J Screw-on 8-1	80° CC□□ JSCLCR/L □06 □09 4-70 80° CC□□ JSCL2CR/L *2 □06 □09 4-69 35° VP□□ JSVL2PR/L □08 4-79	55° DC□□ JSDJCR/L □07 □11 4-73 55° DC□□ JSDJ2CR/L *2 □07 4-72 35° VB□□ JSVJBR/L □11 4-77 35° VB□□ JSVJ2BR/L □11 4-77		55° DC□□ JSDNCN □07 □11 4-73 55° DC□□ JSDN3CR/L *3 □07 □11 4-74	80° CC□□ JSCACR/L □06 □09 4-70 60° TC□□ JSTACR/L □08 □11 4-76 35° VB□□ JSVABR/L □11 4-78	80° CC□□ JSCGCR/L □06 □09 4-71				
S Screw-on	80° CC□□ SCLCR/L □06 □09 □12 4-57 80° CC□□ SCL2CR/L *2 □06 4-57	55° DC□□ SDJCR/L □11 4-58 55° DC□□ SDJ2CR/L *2 □07 4-57 35° VC□□ SVJCR/L □16 4-59 25° YWMT SYJBR/L □16 4-42	35° VC□□ SVVCN □16 4-60	55° DC□□ SDNCN □07 □11 4-58 55° DC□□ SDN3CR/L *3 □07 □11 4-58	60° TC□□ STACR/L □08 □09 □11 □16 4-59 60° TP□□ STAPR/L (Tungaloy Standard) □11 4-59	80° CC□□ SCGCR/L □06 □09 4-57			90° SC□□ SSDCN □07 □09 4-60 90° SP□□ SSDPN (Tungaloy Standard) □07 □09 4-60	
JT Back clamping	80° CC□□ JTCL2CR/L □06 □09 4-69	55° DC□□ JTDJ2CR/L □07 □11 4-72			60° TC□□ JTTACR/L □08 □11 4-76					
T Taper-lock										

*2: L2 and J2: 0 offsetting　*3 63°

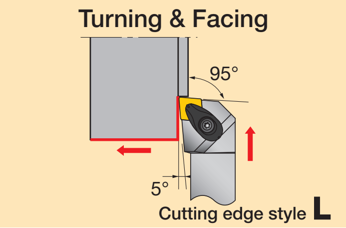
	Turning/Facing Chamfering	Facing			Profiling				External profiling	Back turning	Front turning Reverse turning
	S 45°	K 75°	F 91°	C 90°	Q·H *1 *1 45° (Q) 17.5° (H)	H 100°	I 76.5°	P 117.5°	Special		
									- RCM□ PRGCR/L □10 □12 □16 □20 □25 4-66 - RCM□ PRDCN □10 □12 □16 □20 □25 4-66		
	90° SP□□ CSSPR/L □09 □12 4-68	90° SP□□ CSKPR/L □09 □12 4-67	60° TP□□ CTFPR/L □16 4-67	60° TP□□ CTCPR/L □16 4-67							
			80° CC□□ JSCFCR/L □06 □09 4-71 55° DC□□ JSDFCR/L □07 □11 4-74					35° VP□□ JSVP2PR/L □08 □11 4-79		JXBR JSXBR/L □8 4-82 JTBR JSTBR/L □3 4-83 JTBR3 JS□□K-TBL 3 4-83 J10ER JSEGR/L □10 4-84	JX□□ JSXGR/L □8 4-81 55° DC□□ JS□□K-SDUCL 07 11 4-75
			80° CC□□ SCFCR/L □06 □09 4-57 55° DC□□ SDFCR/L □07 □11 4-58		35° VC□□ SVQCR/L □16 4-59 55° DC□□ SDQCR/L □11 4-58 35° VCG□ SVHCR/L □08 4-60 25° YWMT SYQBR/L □16 4-43	25° YWMT SYHBR/L □16 4-43	25° YWMT SYIBN □16 4-43		- RCMT SRACR/L □05 □06 □08 4-61 - RCMT SRGCR/L □05 □06 □08 □10 4-61 - RCMT SRDCN □06 □08 □10 4-62	Note: JSXB R/L type is also used for JXT-type threading inserts.	Note: JSXG R/L type is also used for JXG-type Grooving inserts.
									- RT□□ TRACN □05 □06 □08 4-65 - RT□□ TRDCN □05 □06 □08 4-65		

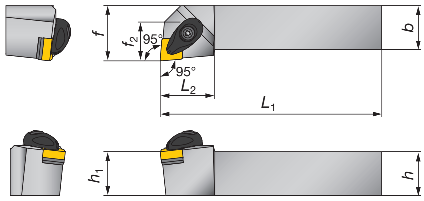
Note:*1 marked Q and H style are Tungaloy Standard.

ACLNR/L

Applicable inserts
CN□□

Negative rake
Double clamping system





Right hand (R) shown.

Toolholders Cat. No.	Stock		Dimensions (mm)							Std. Corner r_ε	Applicable inserts	Page
	R	L	h	b	L_1	L_2	h_1	f	f_2			
ACLNR/L2020K12-A	●	●	20	20	125	26	20	25	19	0.8	CN□□1204□□	2-42 ~ 3-7 ~ T-CBN 3-21 ~ T-DIA
ACLNR/L2525M12-A	●	●	25	25	150	30	25	32	21			
ACLNR/L3225P12-A	●	●	32	25	170	30	32	32	21			
ACLNR/L2525M16-A	●	●	25	25	150	31	25	32	22	1.2	CN□□1606□□	2-45 ~
ACLNR/L3225P16-A	●	●	32	25	170	31	32	32	22			
ACLNR/L3232P16-A	●	●	32	32	170	31	32	40	22			
ACLNR/L3232P19-A	●	●	32	32	170	40	32	40	25	1.2	CN□□1906□□	2-45 ~
ACLNR/L4040S19-A	●	●	40	40	250	40	40	50	25			

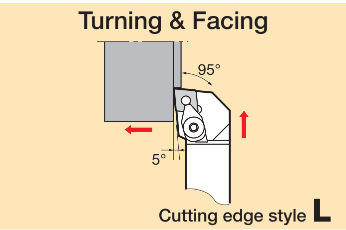
*Recommend clamping torque: 4.0 N·m

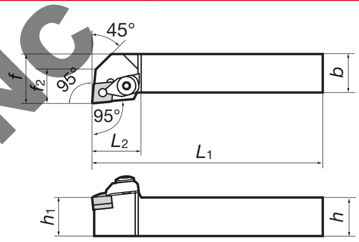
D-type

DCLNR/L

Applicable inserts
CN□□

Negative rake
"One-Double" system





Right hand (R) shown.

Toolholders Cat. No.	Stock		Dimensions (mm)							Std. Corner r_ε	Applicable inserts	Page
	R	L	h	b	L_1	L_2	h_1	f	f_2			
DCLNR/L2020K12	●	●	20	20	125	30	20	25	18	0.8	CN□□1204□□ (Except for 57-type chipbreaker inserts)	2-42 ~ 3-7 ~ T-CBN 3-21 ~ T-DIA
DCLNR/L2525M12	●	●	25	25	150	30	25	32	18			
DCLNR/L3225P12	●	●	32	25	170	30	32	32	18			
DCLNR/L3225P16			32	25	170	40	32	32	22	1.2	CN□□1606□□ (Except for 57-type chipbreaker inserts)	2-45 ~
DCLNR/L3232P16			32	32	170	40	32	40	22			
DCLNR/L3232P19			32	32	170	45.5	32	40	25	1.2	CN□□1906□□ (Except for 57-type chipbreaker inserts)	2-45 ~
DCLNR/L4040R19			40	40	200	45.5	40	50	25			

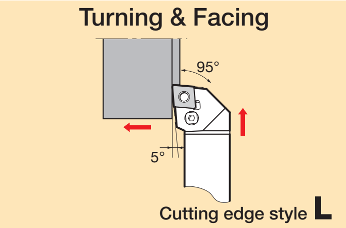
● : Stocked items.

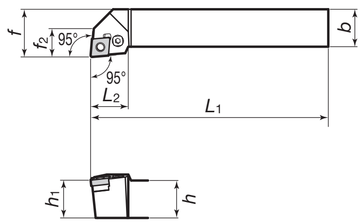
P-type

PCLNR/L

Applicable inserts
CN□□

Negative rake
Lever-lock system





Right hand (R) shown.

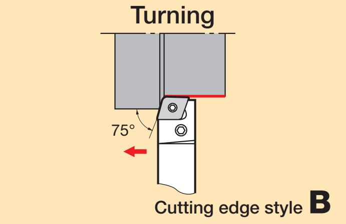
Toolholders Cat. No.	Stock		Dimensions (mm)							Std. Corner r_ε	Applicable inserts	Page
	R	L	h	b	L_1	L_2	h_1	f	f_2			
PCLNR/L1616H09	●	●	16	16	100	20	16	20	15	0.8	CN□□0903□□	2-42 ~
PCLNR/L2020K09	●	●	20	20	125	20	20	25	15			
PCLNR/L2525M09	●	●	25	25	150	20	25	32	15			
PCLNR/L1616H12E	●	●	16	16	100	26	16	20	–	0.8	CN□□1204□□	2-42 ~ 3-7 ~ T-CBN 3-21 ~ T-DIA
PCLNR/L2020K12E	●	●	20	20	125	28	20	25	18			
PCLNR/L2525M12E	●	●	25	25	150	28	25	32	18			
PCLNR/L3225P12E	●	●	32	25	170	28	32	32	18			
PCLNR/L2525M16E	●	●	25	25	150	31	25	25	–	1.2	CN□□1606□□	2-45 ~
PCLNR/L3225P16E		●	32	25	150	31	32	32	–			
PCLNR/L3232P16E	●		32	32	170	31	32	40	–			
PCLNR/L3232P19E	●	●	32	32	170	40	32	40	25	1.2	CN□□1906□□	2-42 ~
PCLNR/L4040R19E			40	40	200	40	40	50	25			

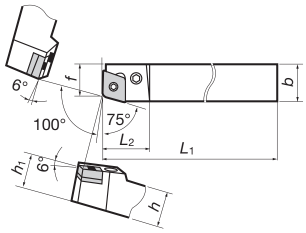
● : Stocked items.

PCBNR/L

Applicable inserts CN□□

Negative rake
Lever-lock system





Right hand (R) shown.

Toolholders Cat. No.	Stock R	Stock L	h	b	L_1	L_2	h_1	f	f_2	Std. Corner r_ε	Applicable inserts	Page
PCBNR/L2020K12E	●	●	20	20	125	28	20	17	–	0.8	CN□□1204□□	2-42 ~
PCBNR/L2525M12E	●	●	25	25	150	28	25	22	–			
PCBNR/L2525M16E	●		25	25	150	35	25	22	–	1.2	CN□□1606□□	2-45 ~
PCBNR/L3225P16E			32	25	170	35	32	22	–			
PCBNR/L3232P16E			32	32	170	35	32	27	–			
PCBNR/L3232P19E	●		32	32	170	40	32	27	–	1.2	CN□□1906□□	2-45 ~

*100° corners are used. ● : Stocked items.

Basic Selection Chipbreakers CN□□1204□□-□□

P Steel – Continuous

Operation	Precision finishing	Finishing	Finishing to medium cutting	Medium cutting
Grade	NS730	GT730	T9115	T9115
Page	2-42	2-42	2-45	2-48
Chipbreaker	TF	TSF	TM	TH
Vc (m/min)	**200** (150-250)	**200** (150-300)	**220** (150-300)	**220** (150-300)
ap (mm)	**0.3** (0.05-0.5)	**1.0** (0.3-1.5)	**3.0** (1.0-5.0)	**4.0** (3.0-6.0)
f (mm/rev)	**0.1** (0.03-0.15)	**0.15** (0.08-0.3)	**0.3** (0.2-0.5)	**0.3** (0.2-0.6)
r_ε (mm)	0.4	0.4	0.8	1.2

M Stainless – Continuous

Operation	Finishing	Finishing to medium cutting	Medium cutting
Grade	T6120	T6130	T6130
Page	2-42	2-46	2-49
Chipbreaker	SF	SM	SH
Vc (m/min)	**150** (100-200)	**120** (70-150)	**120** (70-150)
ap (mm)	**1.0** (0.5-3.0)	**2.0** (0.5-4.0)	**3.0** (3.0-6.0)
f (mm/rev)	**0.1** (0.03-0.15)	**0.3** (0.2-0.5)	**0.3** (0.2-0.5)
r_ε (mm)	0.4	0.8	1.6

K Cast Iron – Continuous

Operation	Precision finishing	Finishing	Finishing to medium cutting	Medium cutting
Grade	BX930	T5115	T5115	T5115
Page	3-7	2-43	2-46	2-49
Chipbreaker	T-CBN	CF	CM	CH
Vc (m/min)	**700** (300-1200)	**270** (140-400)	**270** (150-400)	**270** (140-400)
ap (mm)	**0.3** (0.05-0.5)	**1.0** (0.5-2.0)	**2.0** (1.0-5.0)	**4.0** (2.0-6.0)
f (mm/rev)	**0.1** (0.05-0.2)	**0.15** (0.05-0.2)	**0.3** (0.15-0.4)	**0.4** (0.2-0.6)
r_ε (mm)	0.4	0.4	0.8	1.2

N Non-ferrous – Continuous

Operation	Precision finishing	Finishing	Finishing to medium cutting
Grade	DX120	TH10	GH110
Page	3-21	2-42	2-48
Chipbreaker	T-DIA	01	P
Vc (m/min)	**1500** (500-2500)	**600** (100-1000)	**600** (100-1000)
ap (mm)	**0.5** (0.05-1.0)	**0.5** (0.05-1.0)	**2.0** (0.5-4.0)
f (mm/rev)	**0.1** (0.05-0.2)	**0.1** (0.03-0.15)	**0.3** (0.2-0.5)
r_ε (mm)	0.4	0.4	0.8

S Superalloys – Continuous

Operation	Precision finishing	Finishing to medium cutting	Medium cutting
Grade	BX470	AH905	AH120
Page	3-7	2-47	2-48
Chipbreaker	T-CBN	HMM	SA
Vc (m/min)	**200** (100-280)	**50** (20-100)	**50** (20-80)
ap (mm)	**0.3** (0.1-0.5)	**1.5** (0.5-3.0)	**2.0** (1.0-4.0)
f (mm/rev)	**0.1** (0.05-0.2)	**0.2** (0.1-0.3)	**0.3** (0.2-0.5)
r_ε (mm)	0.4	0.8	0.8

H Hard Materials – Continuous

Operation	Precision finishing	Finishing
Grade	BXM10	BXM20
Page	3-7	3-7
Chipbreaker	T-CBN	T-CBN
Vc (m/min)	**200** (150-350)	**150** (70-220)
ap (mm)	**0.1** (0.05-0.30)	**0.2** (0.05-0.30)
f (mm/rev)	**0.1** (0.03-0.18)	**0.1** (0.05-0.25)
r_ε (mm)	0.4	0.4

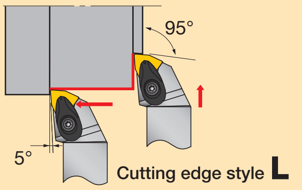
For other machining types, see "Selection System" 2-4 ~

AWLNR/L

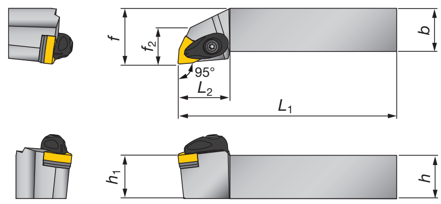
Applicable inserts
WN□□

Negative rake
Double clamping system

Turning & Facing



Cutting edge style **L**



Right hand (R) shown.

Toolholders Cat. No.	Stock		Dimensions (mm)							Std. Corner r_ε	Applicable inserts	Page
	R	L	h	b	L_1	L_2	h_1	f	f_2			
AWLNR/L2020K06-A	●	●	20	20	125	27	20	25	16	0.8	WN□□0604□□	2-80 ~
AWLNR/L2525M06-A	●	●	25	25	150	27	25	32	23			
AWLNR/L2020K08-A	●	●	20	20	125	30	20	25	19	0.8	WN□□0804□□	2-80 ~ 3-9 ~ T-CBN
AWLNR/L2525M08-A	●	●	25	25	150	30	25	32	21			
AWLNR/L3225P08-A	●	●	32	25	170	30	32	32	21			

*Recommend clamping torque: WN□□0604: 3.0 N·m, WN□□0804: 4.0 N·m

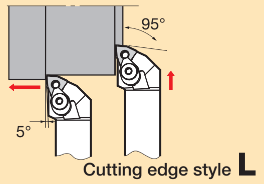
D-type

DWLNR/L

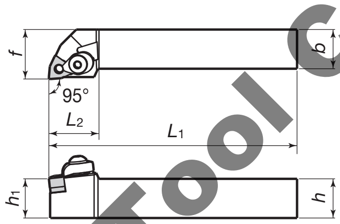
Applicable inserts
WN□□

Negative rake
"One-Double" system

Turning & Facing



Cutting edge style **L**



Right hand (R) shown.

Toolholders Cat. No.	Stock		Dimensions (mm)							Std. Corner r_ε	Applicable inserts	Page
	R	L	h	b	L_1	L_2	h_1	f	f_2			
DWLNR/L2020K06	●	●	20	20	125	25.5	20	25	–	0.8	WN□□0604□□	2-80 ~
DWLNR/L2525M06	●	●	25	25	150	26	25	32	–			
DWLNR/L2020K08	●	●	20	20	125	31	20	25	–	0.8	WN□□0804□□ (Except for 57-type chipbreaker inserts)	2-80 ~ 3-9 ~ T-CBN
DWLNR/L2525M08	●	●	25	25	150	31	25	32	–			
DWLNR/L3225P08	●	●	32	25	170	30	32	32	–			

Basic Selection Chipbreakers WN□□0804□□-□□

P Steel — Continuous

Operation	Precision finishing	Finishing	Finishing to medium cutting	Medium cutting
Grade	**NS730**	**GT730**	**T9115**	**T9115**
Page	2-80	2-80	2-83	2-85
Chipbreaker	TF	TSF	TM	TH
V_c (m/min)	**200** (150-250)	**200** (150-300)	**220** (150-300)	**220** (150-250)
a_p (mm)	**0.3** (0.05-0.5)	**1.0** (0.3-1.5)	**3.0** (1.0-5.0)	**4.0** (3.0-6.0)
f (mm/rev)	**0.1** (0.03-0.15)	**0.15** (0.08-0.3)	**0.3** (0.2-0.5)	**0.3** (0.2-0.5)
r_ε (mm)	0.4	0.4	0.8	1.2

M Stainless — Continuous

Operation	Finishing	Finishing to medium cutting	Medium cutting
Grade	**T6120**	**T6130**	**T6130**
Page	2-80	2-83	2-85
Chipbreaker	SF	SM	SH
V_c (m/min)	**150** (100-200)	**120** (70-150)	**120** (70-150)
a_p (mm)	**1.0** (0.5-3.0)	**2.0** (0.5-4.0)	**3.0** (3.0-6.0)
f (mm/rev)	**0.1** (0.03-0.15)	**0.3** (0.2-0.5)	**0.3** (0.2-0.5)
r_ε (mm)	0.4	0.8	1.6

K Cast Iron — Continuous

Operation	Precision finishing	Finishing	Finishing to medium cutting	Medium cutting
Grade	**BX930**	**T5115**	**T5115**	**T5115**
Page	3-9	2-81	2-84	2-86
Chipbreaker	T-CBN	CF	CM	CH
V_c (m/min)	**700** (300-1200)	**270** (140-400)	**270** (150-400)	**270** (140-400)
a_p (mm)	**0.3** (0.05-0.5)	**1.0** (0.5-2.0)	**2.0** (1.0-5.0)	**4.0** (2.0-6.0)
f (mm/rev)	**0.1** (0.05-0.2)	**0.15** (0.05-0.2)	**0.3** (0.15-0.4)	**0.4** (0.2-0.5)
r_ε (mm)	0.4	0.4	0.8	1.2

S Superalloys — Continuous

Operation	Precision finishing	Finishing to medium cutting	Medium cutting
Grade	**BX480**	**AH905**	**KS20**
Page	3-9	2-84	2-85
Chipbreaker	T-CBN	HMM	SA
V_c (m/min)	**200** (70-300)	**50** (20-100)	**50** (20-80)
a_p (mm)	**0.3** (0.1-0.5)	**1.5** (0.5-3.0)	**3.0** (1.0-6.0)
f (mm/rev)	**0.1** (0.05-0.2)	**0.2** (0.1-0.3)	**0.3** (0.2-0.5)
r_ε (mm)	0.4	0.8	0.8

H Hard Materials — Continuous

Operation	Precision finishing	Finishing
Grade	**BXM10**	**BXM20**
Page	3-9	3-9
Chipbreaker	T-CBN	T-CBN
V_c (m/min)	**200** (150-350)	**150** (70-220)
a_p (mm)	**0.1** (0.05-0.30)	**0.2** (0.05-0.30)
f (mm/rev)	**0.1** (0.03-0.18)	**0.1** (0.05-0.25)
r_ε (mm)	0.4	0.4

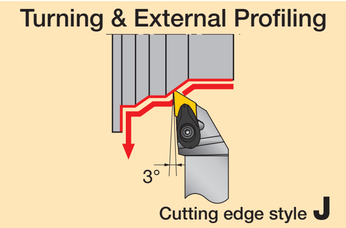
For other machining types, see "Selection System" 2-4 ~

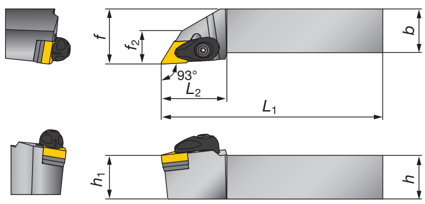
● : Stocked items.

ADJNR/L

Applicable inserts
DN□□

Negative rake
Double clamping sysetm





Right hand (R) shown.

Toolholders Cat. No.	Stock		Dimensions (mm)							Std. Corner r_ε	Applicable inserts	Page
	R	L	h	b	L_1	L_2	h_1	f	f_2			
ADJNR/L2020K15-A	●	●	20	20	125	36	20	25	17	0.8	DN□□1504□□	2-52 ~ 3-7 ~ T-CBN 3-21 ~ T-DIA
ADJNR/L2525M15-A	●	●	25	25	150	36	25	32	18			
ADJNR/L3225P15-A	●	●	32	25	170	36	32	32	18			
ADJNR/L2020K1506-A	●	●	20	20	125	36	20	25	17	0.8	DN□□1506□□	2-52 ~
ADJNR/L2525M1506-A	●	●	25	25	150	36	25	32	18			

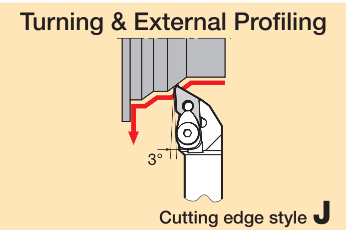
*Recommend clamping torque: 4.0 N·m

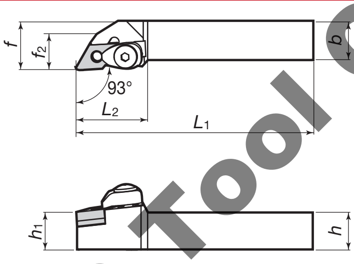
D-type

DDJNR/L

Applicable inserts
DN□□

Negative rake
"One-Double" system





Right hand (R) shown.

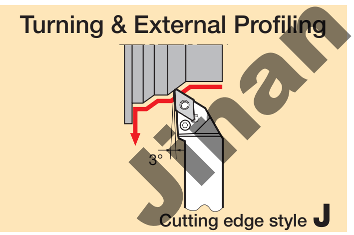
Toolholders Cat. No.	Stock		Dimensions (mm)							Std. Corner r_ε	Applicable inserts	Page
	R	L	h	b	L_1	L_2	h_1	f	f_2			
DDJNR/L2020K15	●	●	20	20	125	38	20	25	19	0.8	DN□□1504□□ (Except for 57-type chipbreaker inserts)	2-52 ~ 3-7 ~ T-CBN 3-21 ~ T-DIA
DDJNR/L2525M15	●	●	25	25	150	38	25	32	19			
DDJNR/L3225P15	●	●	32	25	170	38	32	32	19			
DDJNR/L2020K1506	●	●	20	20	125	38	20	25	19	0.8	DN□□1506□□ (Except for 57-type chipbreaker inserts)	2-52 ~
DDJNR/L2525M1506	●	●	25	25	150	38	25	32	19			
DDJNR/L3225P1506	●	●	32	25	170	38	32	32	19			

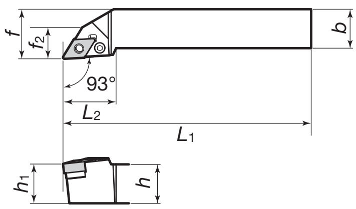
P-type

PDJNR/L

Applicable inserts
DN□□

Negative rake
Lever-lock system





Right hand (R) shown.

Toolholders Cat. No.	Stock		Dimensions (mm)							Std. Corner r_ε	Applicable inserts	Page
	R	L	h	b	L_1	L_2	h_1	f	f_2			
PDJNR/L1616H11	●	●	16	16	100	27	16	20	16	0.8	DN□□1104□□	2-52 ~
PDJNR/L2020K11	●	●	20	20	125	27	20	25	16			
PDJNR/L2525M11	●	●	25	25	150	27	25	32	19			
PDJNR/L2020	●	●	20	20	125	32	20	25	19	0.8	DN□□1504□□	2-52 ~ 3-7 ~ T-CBN 3-21 ~ T-DIA
PDJNR/L2520	●	●	25	20	150	32	25	25	19			
PDJNR/L2525	●	●	25	25	150	32	25	32	19			
PDJNR/L3225	●	●	32	25	170	32	32	32	19			
PDJNR/L3232			32	32	170	32	32	40	19			
PDJNR/L2020K15E	●		20	20	125	32	20	25	–	1.2	DN□□1506□□	2-52 ~
PDJNR/L2525M15E	●	●	25	25	150	32	25	32	–			
PDJNR/L3225P15E	●		32	25	170	32	32	34	–			
PDJNR/L3232P15E			32	32	170	32	32	40	32			

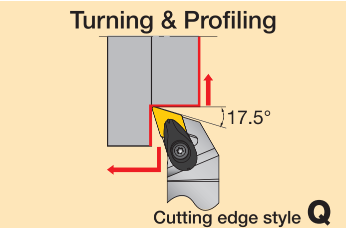
● : Stocked items.

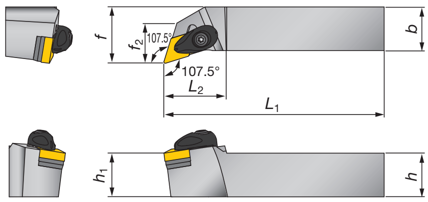
Features (4–4)
Relating pages
Parts (14–1~)

ADQNR/L

Applicable inserts
DN□□

Negative rake
Double clamping system





Right hand (R) shown.

Toolholders Cat. No.	Stock		Dimensions (mm)							Std. Corner	Applicable inserts	Page
	R	L	h	b	L_1	L_2	h_1	f	f_2	r_ε		
ADQNR/L2020K15-A	●	●	20	20	125	32	20	25	21	0.8	DN□□1504□□	2-52 ~ 3-7 ~ T-CBN 3-21 ~ T-DIA
ADQNR/L2525M15-A	●	●	25	25	150	36	25	32	23			
ADQNR/L2020K1506-A	●	●	20	20	125	32	20	25	21	0.8	DN□□1506□□	2-52 ~
ADQNR/L2525M1506-A	●	●	25	25	150	36	25	32	23			

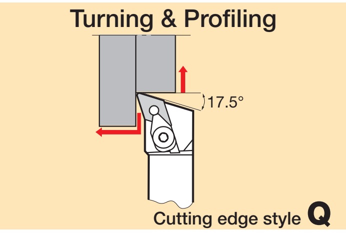
*Recommend clamping torque: 4.0 N·m

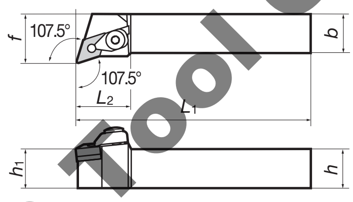
D-type

DDQNR/L

Applicable inserts
DN□□

Negative rake
"One-Double" system





Right hand (R) shown.

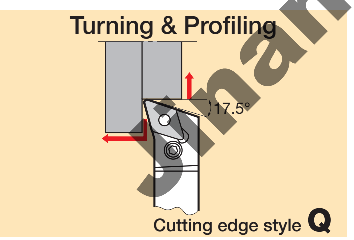
Toolholders Cat. No.	Stock		Dimensions (mm)							Std. Corner	Applicable inserts	Page
	R	L	h	b	L_1	L_2	h_1	f	f_2	r_ε		
DDQNR/L2020K15	●	●	20	20	125	35	20	25	–	0.8	DN□□1504□□ (Except for 57-type chipbreaker inserts)	2-52 ~ 3-7 ~ T-CBN 3-21 ~ T-DIA
DDQNR/L2525M15	●	●	25	25	150	35	25	32	–			
DDQNR/L3225P15	●	●	32	25	170	35	32	32	–			
DDQNR/L2020K1506	●	●	20	20	125	35	20	25	–	0.8	DN□□1506□□ (Except for 57-type chipbreaker inserts)	2-52 ~
DDQNR/L2525M1506	●	●	25	25	150	35	25	32	–			
DDQNR/L3225P1506	●	●	32	25	170	35	32	32	–			

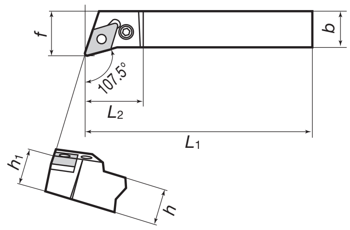
P-type

PDQNR/L

Applicable inserts
DN□□

Negative rake
Lever-lock system





Right hand (R) shown.

Toolholders Cat. No.	Stock		Dimensions (mm)							Std. Corner	Applicable inserts	Page
	R	L	h	b	L_1	L_2	h_1	f	f_2	r_ε		
PDQNR/L2020			20	20	125	32	20	25	–	0.8	DN□□1504□□	2-52 ~ 3-7 ~ T-CBN 3-21 ~ T-DIA
PDQNR/L2525	●	●	25	25	150	32	25	32	–			
PDQNR/L3225			32	25	170	32	32	32	–			
PDQNR/L3232			32	32	170	32	32	40	–			
PDQNR/L2020K15E			20	20	125	32	20	25	–	1.2	DN□□1506□□	2-52 ~
PDQNR/L2525M15E			25	25	150	32	25	32	–			
PDQNR/L3225P15E			32	25	170	32	32	32	–			
PDQNR/L3232P15E			32	32	170	32	32	40	–			

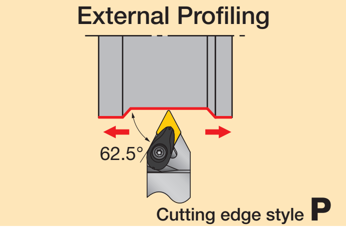
● : Stocked items.

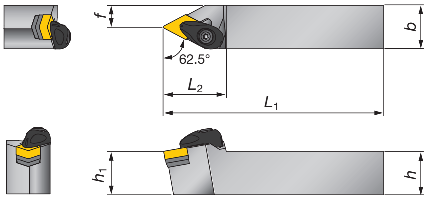
TURNINGA A-type

ADPNN

Applicable inserts
DN□□1504

Negative rake
Double clamping system





Toolholders Cat. No.	Stock	Dimensions (mm)							Std. Corner r_ε	Applicable inserts	Page
		h	b	L_1	L_2	h_1	f	f_2			
ADPNN2020K15-A	●	20	20	125	36	20	7.5	–	0.8	DN□□1504□□	2-52 ~ 3-7 ~ T-CBN 3-21 ~ T-DIA
ADPNN2525M15-A	●	25	25	150	36	25	12.5	–			

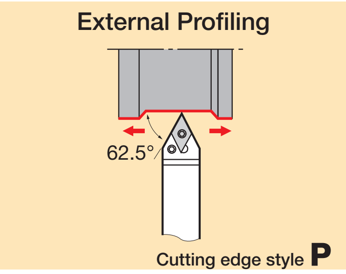
*Recommend clamping torque: 4.0 N·m

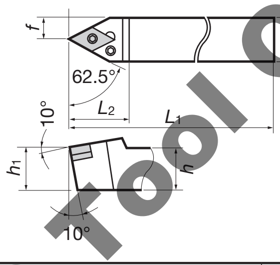
P-type

PDPNN

Applicable inserts
DN□□

Negative rake
Lever-lock system





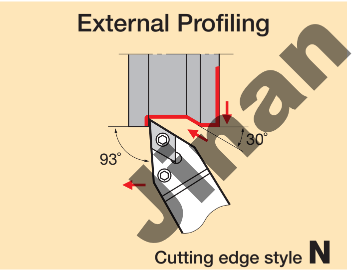
Toolholders Cat. No.	Stock	Dimensions (mm)							Std. Corner r_ε	Applicable inserts	Page
		h	b	L_1	L_2	h_1	f	f_2			
PDPNN2525	●	25	25	150	36	25	12.5	–	0.8	DN□□1504□□	2-52 ~ 3-7 ~ T-CBN 3-21 ~ T-DIA
PDPNN3225		32	25	170	36	32	12.5	–			
PDPNN2525M15E	●	25	25	150	36	25	12.5	–	1.2	DN□□1506□□	2-52 ~
PDPNN3225P15E		32	25	170	36	32	12.5	–			

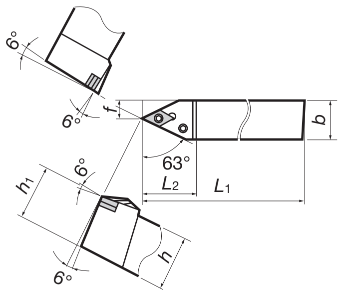
P-type

PDNNR/L

Applicable inserts
DN□□

Negative rake
Lever-lock system





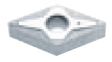
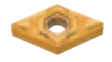
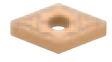
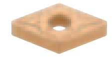
Right hand (R) shown.

Toolholders Cat. No.	Stock R	Stock L	Dimensions (mm) h	b	L_1	L_2	h_1	f	f_2	Std. Corner r_ε	Applicable inserts	Page
PDNNR/L4025			40	25	150	36	40	12	–	0.8	DN□□1504□□	2-52 ~ 3-7 ~ T-CBN 3-21 ~ T-DIA
PDNNR/L5032			50	32	150	36	50	16	–			
PDNNR/L5032H			50	32	150	36	50	16	–	0.8	DN□□1506□□	2-52 ~
PDNNR/L4025M15E			40	25	150	36	40	12	–	0.8	DN□□1506□□	2-52 ~
PDNNR/L5032M15E			50	32	150	36	50	16	–			

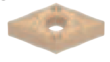
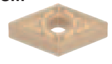
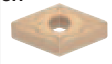
● : Stocked items.

Basic Selection Chipbreakers DN□□1504□□-□□

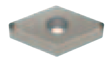
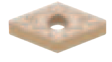
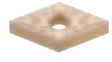
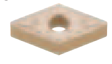
P Steel — Continuous

Operation	Precision finishing	Finishing	Finishing to medium cutting	Medium cutting
Grade	NS730	GT730	T9115	T9115
Page	2-52	2-52	2-55	2-58
Chipbreaker	TF 	TSF 	TM 	TH 
Vc (m/min)	**200** (150-250)	**200** (150-300)	**220** (150-300)	**220** (150-300)
ap (mm)	**0.3** (0.05-0.5)	**1.0** (0.3-1.5)	**3.0** (1.0-5.0)	**4.0** (3.0-6.0)
f (mm/rev)	**0.1** (0.03-0.15)	**0.15** (0.08-0.3)	**0.3** (0.2-0.5)	**0.3** (0.2-0.5)
rε (mm)	0.4	0.4	0.8	1.2

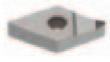
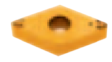
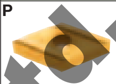
M Stainless — Continuous

Operation	Finishing	Finishing to medium cutting	Medium cutting
Grade	T6120	T6130	T6130
Page	2-53	2-55	2-58
Chipbreaker	SF 	SM 	SH 
Vc (m/min)	**150** (100-200)	**120** (70-150)	**120** (70-150)
ap (mm)	**1.0** (0.5-3.0)	**2.0** (0.5-4.0)	**3.0** (3.0-6.0)
f (mm/rev)	**0.1** (0.03-0.15)	**0.3** (0.2-0.5)	**0.3** (0.2-0.4)
rε (mm)	0.4	0.8	1.2

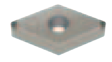
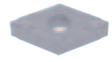
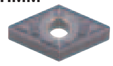
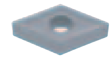
K Cast Iron — Continuous

Operation	Precision finishing	Finishing	Finishing to medium cutting	Medium cutting
Grade	BX930	T5115	T5115	T5115
Page	3-7	2-53	2-56	2-59
Chipbreaker	T-CBN 	CF 	CM 	CH 
Vc (m/min)	**700** (300-1200)	**270** (140-400)	**270** (150-400)	**270** (140-400)
ap (mm)	**0.3** (0.05-0.5)	**1.0** (0.5-2.0)	**2.0** (1.0-5.0)	**4.0** (2.0-6.0)
f (mm/rev)	**0.1** (0.05-0.2)	**0.15** (0.05-0.2)	**0.3** (0.15-0.4)	**0.4** (0.2-0.5)
rε (mm)	0.4	0.4	0.8	1.2

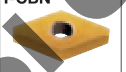
N Non-ferrous — Continuous

Operation	Precision finishing	Finishing	Finishing to medium cutting
Grade	DX120	GH110	GH110
Page	3-21	2-52	2-58
Chipbreaker	T-DIA With chipbreaker 	01 	P 
Vc (m/min)	**1500** (500-2500)	**600** (100-1000)	**600** (100-1000)
ap (mm)	**0.5** (0.05-1.0)	**0.5** (0.05-1.0)	**2.0** (0.5-4.0)
f (mm/rev)	**0.1** (0.05-0.2)	**0.1** (0.03-0.15)	**0.3** (0.2-0.5)
rε (mm)	0.4	0.4	0.8

S Superalloys — Continuous

Operation	Precision finishing	Finishing	Finishing to medium cutting	Medium cutting
Grade	BX470	KS20	AH905	AH120
Page	3-7	2-53	2-56	2-55
Chipbreaker	T-CBN 	SS 	HMM 	All-round 
Vc (m/min)	**200** (100-280)	**50** (30-70)	**50** (20-100)	**50** (20-80)
ap (mm)	**0.3** (0.1-0.5)	**1.0** (0.5-3.0)	**1.5** (0.5-3.0)	**3.0** (1.0-6.0)
f (mm/rev)	**0.1** (0.05-0.2)	**0.15** (0.08-0.2)	**0.2** (0.1-0.3)	**0.3** (0.2-0.5)
rε (mm)	0.4	0.8	0.8	0.8

H Hard Materials — Continuous

Operation	Precision finishing	Finishing
Grade	BXM10	BXM20
Page	3-7	3-7
Chipbreaker	T-CBN 	T-CBN 
Vc (m/min)	**200** (150-350)	**150** (70-220)
ap (mm)	**0.1** (0.05-0.30)	**0.2** (0.05-0.30)
f (mm/rev)	**0.1** (0.03-0.18)	**0.1** (0.05-0.25)
rε (mm)	0.4	0.4

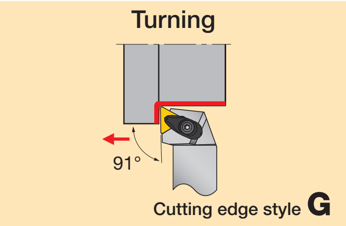
For other machining types, see “Selection System” 2-4 ~

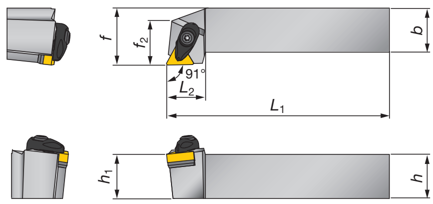
TURNINGA A-type

ATGNR/L

Applicable inserts
TN□□

Negative rake
Double clamping system





Right hand (R) shown.

Toolholders Cat. No.	Stock		Dimensions (mm)							Std. Corner r_ε	Applicable inserts	Page
	R	L	h	b	L_1	L_2	h_1	f	f_2			
ATGNR/L2020K16-A	●	●	20	20	125	22	20	25	22	0.8	TN□□1604□□	2-70 ~ 3-8 ~ T-CBN 3-21 ~ T-DIA
ATGNR/L2525M16-A	●	●	25	25	150	22	25	32	25			
ATGNR/L2525M22-A	●	●	25	25	150	26	25	32	26	0.8	TN□□2204□□	2-70 ~

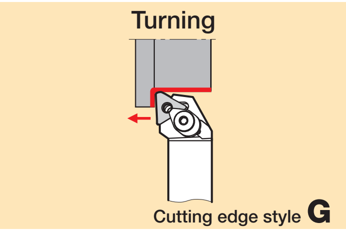
*Recommend clamping torque: TN□□1604: 3.0 N·m, TN□□2204: 4.0 N·m

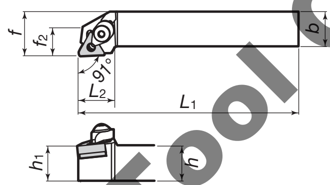
D-type

DTGNR/L

Applicable inserts
TN□□

Negative rake
"One-Double" system





Right hand (R) shown.

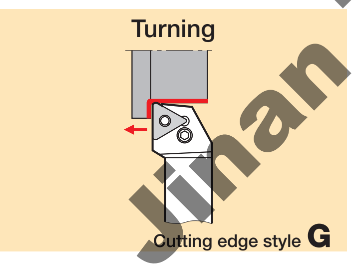
Toolholders Cat. No.	Stock		Dimensions (mm)							Std. Corner r_ε	Applicable inserts	Page
	R	L	h	b	L_1	L_2	h_1	f	f_2			
DTGNR/L2020K16	●	●	20	20	125	21	20	25	16	0.8	TN□□1604□□ (Except for 57-type chipbreaker inserts)	2-70 ~ 3-8 ~ T-CBN 3-21 ~ T-DIA
DTGNR/L2525M16	●	●	25	25	150	21	25	32	21			
DTGNR/L2525M22	●	●	25	25	150	28	25	32	25	0.8	TN□□2204□□ (Except for 57-type chipbreaker inserts)	2-70 ~

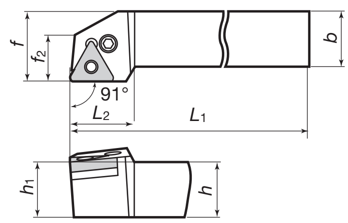
P-type

PTGNR/L

Applicable inserts
TN□□

Negative rake
Lever-lock system





Right hand (R) shown.

Toolholders Cat. No.	Stock		Dimensions (mm)							Std. Corner r_ε	Applicable inserts	Page
	R	L	h	b	L_1	L_2	h_1	f	f_2			
PTGNR/L1616H16E	●	●	16	16	100	22	16	20	16	0.8	TN□□1604□□	2-70 ~ 3-8 ~ T-CBN 3-21 ~ T-DIA
PTGNR/L2020K16E	●	●	20	20	125	22	20	25	16			
PTGNR/L2525M16E	●	●	25	25	150	22	25	32	21			
PTGNR/L3225P16E			32	25	170	22	32	32	21			
PTGNR/L2525M22E	●	●	25	25	150	28	25	32	24	0.8	TN□□2204□□	2-70 ~
PTGNR/L3225P22E	●	●	32	25	170	28	32	32	24			
PTGNR/L3232P22E	●		32	32	170	28	32	40	28			
PTGNR/L3232P27E			32	32	170	35	32	40	30	1.2	TN□□2706□□	

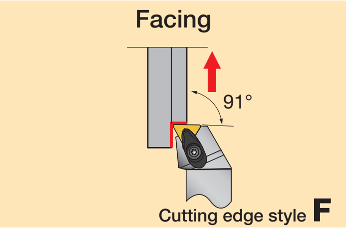
● : Stocked items.

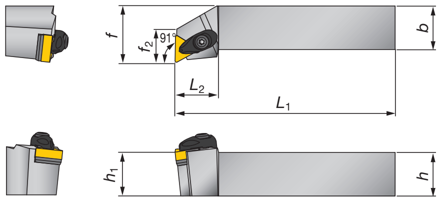
A-type

ATFNR/L

Applicable inserts
TN□□

Negative rake
Double clamping system





Right hand (R) shown.

Toolholders Cat. No.	Stock		Dimensions (mm)							Std. Corner	Applicable inserts	Page
	R	L	h	b	L_1	L_2	h_1	f	f_2	r_ε		
ATFNR/L2020K16-A	●	●	20	20	125	25	20	25	18	0.8	TN□□1604□□	2-70 ~ 3-8 ~ T-CBN 3-21 ~ T-DIA
ATFNR/L2525M16-A	●	●	25	25	150	25	25	32	19			
ATFNR/L2525M22-A	●	●	25	25	150	29	25	32	23	0.8	TN□□2204□□	2-70 ~

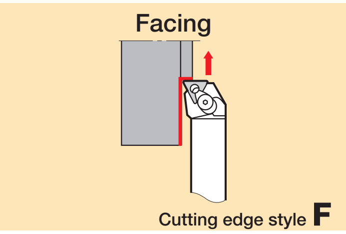
*Recommend clamping torque: TN□□1604: 3.0 N·m, TN□□2204: 4.0 N·m

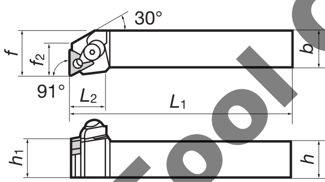
D-type

DTFNR/L

Applicable inserts
TN□□

Negative rake
"One-Double" system





Right hand (R) shown.

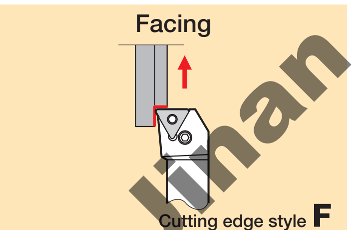
Toolholders Cat. No.	Stock		Dimensions (mm)							Std. Corner	Applicable inserts	Page
	R	L	h	b	L_1	L_2	h_1	f	f_2	r_ε		
DTFNR/L2020K16	●	●	20	20	125	23	20	25	18.5	0.8	TN□□1604□□	2-70 ~ 3-8 ~ T-CBN 3-21 ~ T-DIA
DTFNR/L2525M16	●	●	25	25	150	23	25	32	20			
DTFNR/L2525M22	●	●	25	25	150	31	25	32	24	0.8	TN□□2204□□	2-70 ~

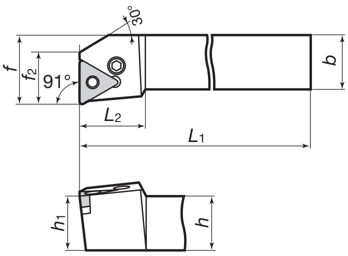
P-type

PTFNR/L

Applicable inserts
TN□□

Negative rake
Lever-lock system





Right hand (R) shown.

Toolholders Cat. No.	Stock		Dimensions (mm)							Std. Corner	Applicable inserts	Page
	R	L	h	b	L_1	L_2	h_1	f	f_2	r_ε		
PTFNR/L1616H16E	●	●	16	16	100	22	16	20	18	0.8	TN□□1604□□	2-70 ~ 3-8 ~ T-CBN 3-21 ~ T-DIA
PTFNR/L2020K16E	●	●	20	20	125	22	20	25	17.5			
PTFNR/L2525M16E	●	●	25	25	150	22	25	32	20			
PTFNR/L3225P16E	●	●	32	25	170	22	32	32	20			
PTFNR/L2525M22E	●	●	25	25	150	28	25	32	24	0.8	TN□□2204□□	2-70 ~
PTFNR/L3225P22E	●	●	32	25	170	28	32	32	24			
PTFNR/L3232P27E			32	32	170	31	32	40	30	1.2	TN□□2706□□	
PTFNR/L4040P27E			40	40	200	31	40	50	30			

● : Stocked items.

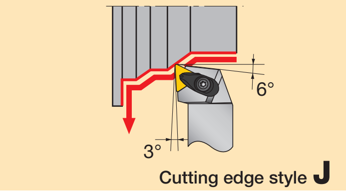
Features (4–4) Relating pages Parts (14–1~)

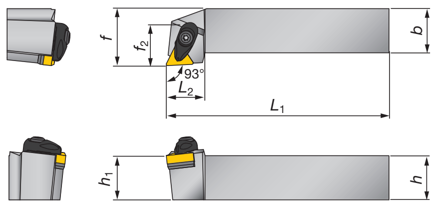
ATJNR/L

Applicable inserts
TN□□1604

Negative rake
Double clamping system

Turning • External Profiling





Right hand (R) shown.

Toolholders Cat. No.	Stock R	Stock L	h	b	L_1	L_2	h_1	f	f_2	Std. Corner r_ε	Applicable inserts	Page
ATJNR/L2020K16-A	●	●	20	20	125	22	20	25	23	0.8	TN□□1604□□	2-70 ~ 3-8 ~ T-CBN 3-21 ~ T-DIA
ATJNR/L2525M16-A	●	●	25	25	150	22	25	32	25			

*Recommend clamping torque: 3.0 N·m

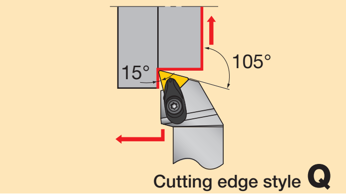
A-type

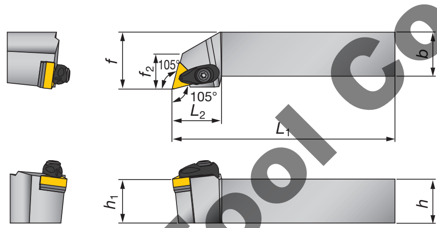
ATQNR/L

Applicable inserts
TN□□1604

Negative rake
Double clamping system

External Profiling



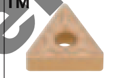
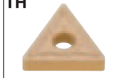


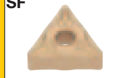
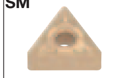
Right hand (R) shown.

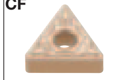
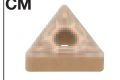
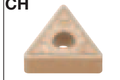
Toolholders Cat. No.	Stock R	Stock L	h	b	L_1	L_2	h_1	f	f_2	Std. Corner r_ε	Applicable inserts	Page
ATQNR/L2020K16-A	●	●	20	20	125	28	20	25	18	0.8	TN□□1604□□	2-70 ~ 3-8 ~ T-CBN 3-21 ~ T-DIA
ATQNR/L2525M16-A	●	●	25	25	150	28	25	32	20			

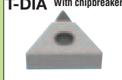
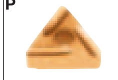
*Recommend clamping torque: 3.0 N·m

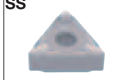
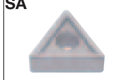
Basic Selection Chipbreakers TN□□1604□□-□□

P Steel, Continuous	Operation	Precision finishing	Finishing	Finishing to medium cutting	Medium cutting
	Grade	NS730	GT730	T9115	T9115
	Page	2-70	2-71	2-74	2-77
	Chipbreaker	TF 	TSF 	TM 	TH 
	Vc (m/min)	**200** (150-250)	**200** (150-300)	**200** (150-300)	**220** (150-300)
	ap (mm)	**0.3** (0.05-0.5)	**1.0** (0.3-1.5)	**3.0** (1.0-5.0)	**4.0** (3.0-6.0)
	f (mm/rev)	**0.1** (0.03-0.15)	**0.15** (0.08-0.3)	**0.3** (0.2-0.5)	**0.3** (0.2-0.5)
	r_ε (mm)	0.4	0.4	0.8	1.2

M Stainless, Continuous	Operation	Finishing	Finishing to medium cutting
	Grade	T6120	T6130
	Page	2-71	2-74
	Chipbreaker	SF 	SM 
	Vc (m/min)	**150** (100-200)	**120** (70-150)
	ap (mm)	**1.0** (0.5-3.0)	**2.0** (0.5-4.0)
	f (mm/rev)	**0.1** (0.03-0.15)	**0.3** (0.2-0.4)
	r_ε (mm)	0.4	0.8

K Cast Iron, Continuous	Operation	Precision finishing	Finishing	Finishing to medium cutting	Medium cutting
	Grade	BX930	T5115	T5115	T5115
	Page	3-8	2-72	2-75	2-77
	Chipbreaker	T-CBN 	CF 	CM 	CH 
	Vc (m/min)	**700** (300-1200)	**270** (140-400)	**270** (150-400)	**270** (140-400)
	ap (mm)	**0.3** (0.05-0.5)	**1.0** (0.5-2.0)	**2.0** (1.0-5.0)	**4.0** (2.0-6.0)
	f (mm/rev)	**0.1** (0.05-0.2)	**0.15** (0.05-0.2)	**0.3** (0.15-0.4)	**0.4** (0.2-0.6)
	r_ε (mm)	0.4	0.4	0.8	1.2

N Non-ferrous, Continuous	Operation	Precision finishing	Finishing	Finishing to medium cutting
	Grade	DX120	GH110	GH110
	Page	3-21	2-70	2-76h
	Chipbreaker	T-DIA With chipbreaker 	01 	P 
	Vc (m/min)	**1500** (500-2500)	**600** (100-1000)	**600** (100-1000)
	ap (mm)	**0.5** (0.05-1.0)	**0.5** (0.05-1.0)	**2.0** (0.5-4.0)
	f (mm/rev)	**0.1** (0.05-0.2)	**0.1** (0.03-0.15)	**3.0** (0.2-0.5)
	r_ε (mm)	0.4	0.4	0.8

S Superalloys, Continuous	Operation	Precision finishing	Finishing	Finishing to medium cutting	Medium cutting
	Grade	BX470	KS20	AH905	AH120
	Page	3-8	2-71	2-75	2-76
	Chipbreaker	T-CBN 	SS 	HMM 	SA 
	Vc (m/min)	**200** (100-280)	**50** (30-70)	**50** (20-100)	**50** (20-80)
	ap (mm)	**0.3** (0.1-0.5)	**1.0** (0.5-3.0)	**1.5** (0.5-3.0)	**2.0** (1.0-4.0)
	f (mm/rev)	**0.1** (0.05-0.2)	**0.1** (0.03-0.15)	**0.2** (0.1-0.3)	**0.3** (0.2-0.5)
	r_ε (mm)	0.4	0.4	0.8	0.8

H Hard Materials, Continuous	Operation	Precision finishing	Finishing
	Grade	BXM10	BXM20
	Page	3-8	3-8
	Chipbreaker	T-CBN 	T-CBN 
	Vc (m/min)	**200** (150-350)	**150** (70-220)
	ap (mm)	**0.1** (0.05-0.30)	**0.2** (0.05-0.30)
	f (mm/rev)	**0.1** (0.03-0.18)	**0.1** (0.05-0.25)
	r_ε (mm)	0.4	0.4

For other machining types, see “Selection System” 2-4 ~

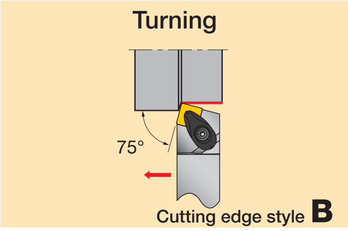
● : Stocked items.

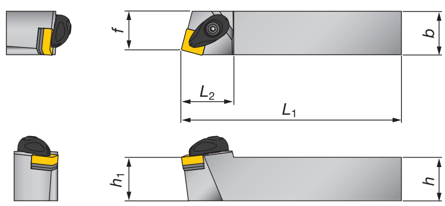
TURNING A-type

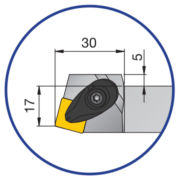
ASBNR/L

Applicable inserts
SN□□

Negative rake
Double clamping system







Enlarged view of 2020 type

Right hand (R) shown.

Toolholders Cat. No.	Stock		Dimensions (mm)							Std. Corner	Applicable inserts	Page
	R	L	h	b	L_1	L_2	h_1	f	f_2	r_ε		
ASBNR/L2020K12-A	●	●	20	20	125	30	20	17	–	0.8	SN□□1204□□	2-61 ~, 3-8 ~ T-CBN 3-21 ~ T-DIA
ASBNR/L2525M12-A	●	●	25	25	150	30	25	22	–			
ASBNR/L2525M15-A	●	●	25	25	150	42.5	25	22	–	1.2	SN□□1506□□	2-64 ~
ASBNR/L3232P15-A	●	●	32	32	170	42.5	32	27	–			
ASBNR/L3232P19-A	●	●	32	32	170	47.5	32	27	–	1.2	SN□□1906□□	2-64 ~
ASBNR/L4040S19-A	●	●	40	40	250	47.5	40	35	–			

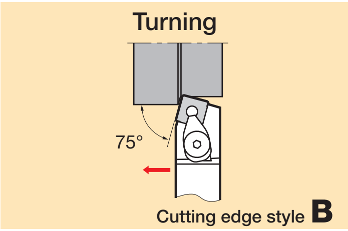
*Recommend clamping torque: 4.0 N·m

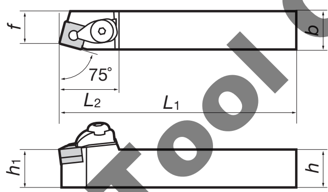
D-type

DSBNR/L

Applicable inserts
SN□□

Negative rake
"One-Double" system





Right hand (R) shown.

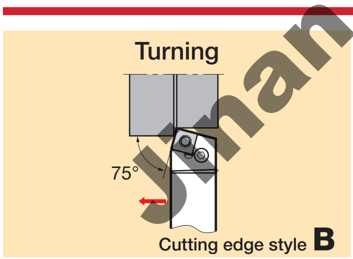
Toolholders Cat. No.	Stock		Dimensions (mm)							Std. Corner	Applicable inserts	Page
	R	L	h	b	L_1	L_2	h_1	f	f_2	r_ε		
DSBNR/L2020K12	●	●	20	20	125	35	20	17	–	0.8	SN□□1204□□ (Except for 57-type chipbreaker inserts)	2-61 ~ 3-8 ~ T-CBN 3-21 ~ T-DIA
DSBNR/L2525M12	●	●	25	25	150	35	25	22	–			
DSBNR/L3225P15			32	25	170	42.5	32	22	–	1.2	SN□□1506□□ (Except for 57-type chipbreaker inserts)	2-64 ~
DSBNR/L3232P15			32	32	170	42.5	32	27	–			
DSBNR/L3232P19			32	32	170	47.5	32	27	–	1.2	SN□□1906□□ (Except for 57-type chipbreaker inserts)	2-64 ~
DSBNR/L4040R19			40	40	200	47.5	40	35	–			

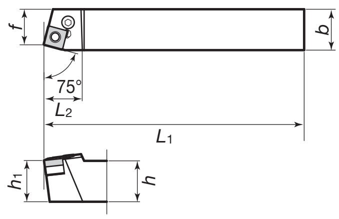
P-type

PSBNR/L

Applicable inserts
SN□□

Negative rake
Lever-lock system





Right hand (R) shown.

Toolholders Cat. No.	Stock		Dimensions (mm)							Std. Corner	Applicable inserts	Page
	R	L	h	b	L_1	L_2	h_1	f	f_2	r_ε		
PSBNR/L1616H09E			16	16	100	22	16	13	–	0.8	SN□□0903□□	2-61 ~
PSBNR/L2020K12E	●	●	20	20	125	28	20	17	–	0.8	SN□□1204□□	2-61 ~ 3-8 ~ T-CBN 3-21 ~ T-DIA
PSBNR/L2525M12E	●	●	25	25	150	24	25	22	–			
PSBNR/L3225P12E	●	●	32	25	170	28	32	22	–			
PSBNR/L2525M15E	●	●	25	25	150	35	25	22	–	1.2	SN□□1506□□	2-64 ~
PSBNR/L3225P15E			32	25	170	35	32	22	–			
PSBNR/L3232P15E	●	●	32	32	170	35	32	27	–			
PSBNR/L3232P19E	●	●	32	32	170	40	32	27	–	1.2	SN□□1906□□	2-64 ~
PSBNR/L4040R19E			40	40	200	40	40	35	–			
PSBNR/L5050T25E			50	50	300	48	50	43	–	2.4	SN□□2507□□	2-64 ~

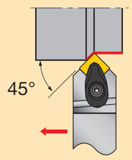
● : Stocked items.

ASDNN

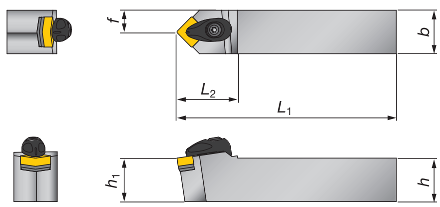
Applicable inserts
SN□□1204□□

Negative rake
Double clamping system

Turning & Chamfering



Cutting edge style **D**



Toolholders Cat. No.	Stock	Dimensions (mm)							Std. Corner	Applicable inserts	Page
		h	b	L_1	L_2	h_1	f	f_2	r_ε		
ASDNN2020K12-A	●	20	20	125	35	20	10	–	0.8	SN□□1204□□	2-61 ~ 3-8 ~ T-CBN 3-21 ~ T-DIA
ASDNN2525M12-A	●	25	25	150	35	25	12.5	–			

*Recommend clamping torque: 4.0 N·m

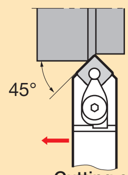
D-type

DSDNN

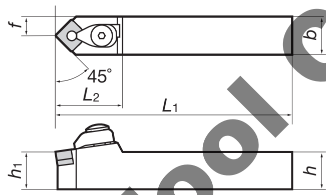
Applicable inserts
SN□□1204

Negative rake
"One-Double" system

Turning & Chamfering



Cutting edge style **D**



Toolholders Cat. No.	Stock	Dimensions (mm)							Std. Corner	Applicable inserts	Page
		h	b	L_1	L_2	h_1	f	f_2	r_ε		
DSDNN2020K12	●	20	20	125	36	20	10	–	0.8	SN□□1204□□ (Except for 57-type chipbreaker inserts)	2-61 ~ 3-8 ~ T-CBN 3-21 ~ T-DIA
DSDNN2525M12	●	25	25	150	36	25	12.5	–			

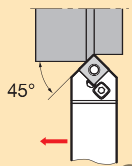
P-type

PSDNN

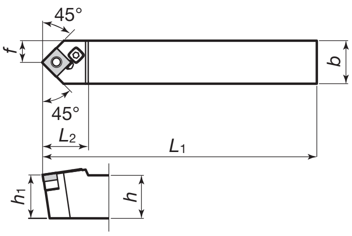
Applicable inserts
SN□□

Negative rake
Lever-lock system

Turning & Chamfering



Cutting edge style **D**



Toolholders Cat. No.	Stock	Dimensions (mm)							Std. Corner	Applicable inserts	Page
		h	b	L_1	L_2	h_1	f	f_2	r_ε		
PSDNN1616H09E		16	16	100	22	16	8.0	–	0.8	SN□□0903□□	2-61 ~
PSDNN2020K12E	●	20	20	125	30	20	10.3	–	0.8	SN□□1204□□	2-61 ~ 3-8 ~ T-CBN 3-21 ~ T-DIA
PSDNN2525M12E	●	25	25	150	30	25	12.8	–			
PSDNN3225P12E	●	32	25	170	30	32	12.8	–			
PSDNN3232P15E		32	32	170	–	32	–	–	1.2	SN□□1506□□	2-64 ~

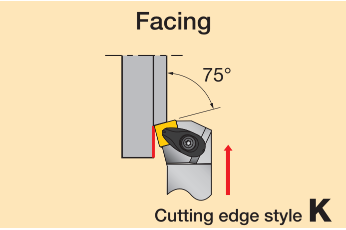
● : Stocked items.

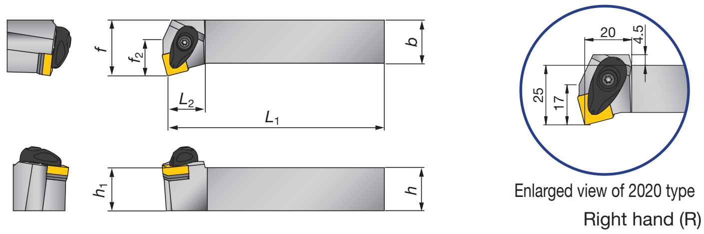
ASKNR/L

Applicable inserts
SN□□1204□□

Negative rake
Double clamping system

Facing





Enlarged view of 2020 type

Right hand (R) shown.

Toolholders Cat. No.	Stock		Dimensions (mm)							Std. Corner r_ε	Applicable inserts	Page
	R	L	h	b	L_1	L_2	h_1	f	f_2			
ASKNR/L2020K12-A	●	●	20	20	125	20	20	25	17	0.8	SN□□1204□□	2-61 ~ 3-8 ~ T-CBN 3-21 ~ T-DIA
ASKNR/L2525M12-A	●	●	25	25	150	22	25	32	21			

*Recommend clamping torque: 4.0 N·m

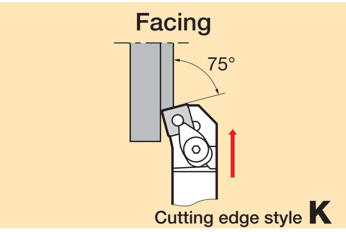
D-type

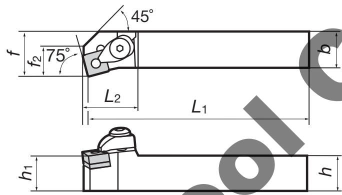
DSKNR/L

Applicable inserts
SN□□1204

Negative rake
"One-Double" system

Facing





Right hand (R) shown.

Toolholders Cat. No.	Stock		Dimensions (mm)							Std. Corner r_ε	Applicable inserts	Page
	R	L	h	b	L_1	L_2	h_1	f	f_2			
DSKNR/L2020K12	●	●	20	20	125	31	20	25	17	0.8	SN□□1204□□ (Except for 57-type chipbreaker inserts)	2-61 ~ 3-8 ~ T-CBN 3-21 ~ T-DIA
DSKNR/L2525M12	●	●	25	25	150	31	25	32	17			

● : Stocked items.

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Features (4–4) | Relating pages | Parts (14–1~)

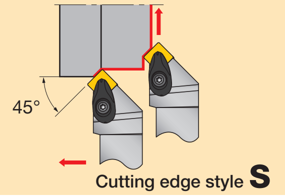
A-type

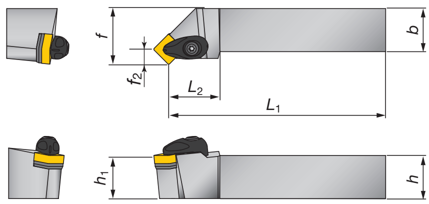
ASSNR/L

Applicable inserts
SN□□

Negative rake
Double clamping system

Turning & Facing & Chamfering





Right hand (R) shown.

Toolholders Cat. No.	Stock R	Stock L	h	b	L_1	L_2	h_1	f	f_2	Std. Corner r_ε	Applicable inserts	Page
ASSNR/L2020K12-A	●	●	20	20	125	30	20	25	8.3	0.8	SN□□1204□□	2-61 ~
ASSNR/L2525M12-A	●	●	25	25	150	30	25	32				
ASSNR/L2525M15-A	●	●	25	25	150	25	25	32	10.3	1.2	SN□□1506□□	2-64 ~
ASSNR/L3232P15-A	●	●	32	32	170	25	32	40				
ASSNR/L3232P19-A	●	●	32	32	170	27.5	32	40	12.5	1.2	SN□□1906□□	2-64 ~
ASSNR/L4040S19-A	●	●	40	40	250	27.5	40	50				

*Recommend clamping torque: 4.0 N·m

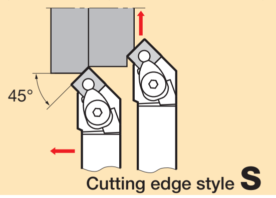
D-type

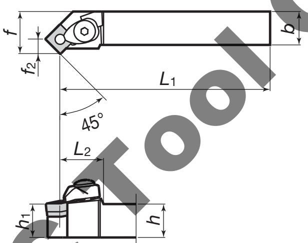
DSSNR/L

Applicable inserts
SN□□1204

Negative rake
"One-Double" system

Turning & Facing & Chamfering





Right hand (R) shown.

Toolholders Cat. No.	Stock R	Stock L	h	b	L_1	L_2	h_1	f	f_2	Std. Corner r_ε	Applicable inserts	Page
DSSNR/L2020K12	●	●	20	20	125	34.3	20	25	8.3	0.8	SN□□1204□□ (Except for 57-type chipbreaker inserts)	2-61 ~
DSSNR/L2525M12	●	●	25	25	150	34.3	25	32				

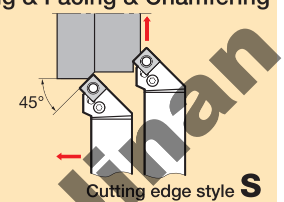
P-type

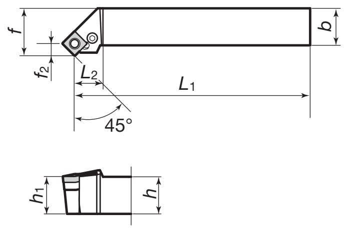
PSSNR/L

Applicable inserts
SN□□

Negative rake
Lever-lock system

Turning & Facing & Chamfering





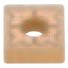
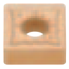
Right hand (R) shown.

Toolholders Cat. No.	Stock R	Stock L	h	b	L_1	L_2	h_1	f	f_2	Std. Corner r_ε	Applicable inserts	Page
PSSNR/L1616H09E	●		16	16	94	16	16	20	6.1	0.8	SN□□0903□□	2-61 ~
PSSNR/L2020K12E	●	●	20	20	116	21	20	25	8.3	0.8	SN□□1204□□	2-61 ~
PSSNR/L2525M12E	●	●	25	25	141	21	25	32				
PSSNR/L3225P12E	●	●	32	25	161	21	32	32				
PSSNR/L2525M15E	●	●	25	25	140	25	25	32	10.2	1.2	SN□□1506□□	2-64 ~
PSSNR/L3225P15E			32	25	160	25	32	32				
PSSNR/L3232P15E			32	32	160	25	32	40				
PSSNR/L3232P19E	●		32	32	157.5	27.5	32	40	12.5	1.2	SN□□1906□□	2-64 ~
PSSNR/L4040R19E			40	40	187.5	27.5	40	50				

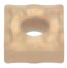
● : Stocked items.

Basic Selection Chipbreakers SN□□1204□□-□□

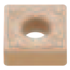
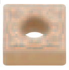
P Steel — Continuous

Operation	Precision finishing	Finishing	Finishing to medium cutting	Medium cutting
Grade	**NS730**	**GT730**	**T9115**	**T9115**
Page	2-61	2-61	2-64	2-67
Chipbreaker	TF 	TSF 	TM 	TH 
V_c (m/min)	**200** (150-250)	**200** (150-300)	**220** (150-300)	**220** (150-300)
a_p (mm)	**0.3** (0.05-0.5)	**1.0** (0.3-1.5)	**3.0** (1.0-5.0)	**4.0** (3.0-6.0)
f (mm/rev)	**0.1** (0.03-0.15)	**0.15** (0.08-0.3)	**0.3** (0.2-0.5)	**0.3** (0.2-0.5)
r_ε (mm)	0.4	0.4	0.8	1.2

M Stainless — Continuous

Operation	Finishing	Finishing to medium cutting	Medium cutting
Grade	**T6120**	**T6130**	**T6130**
Page	2-62	2-64	2-67
Chipbreaker	SF 	SM 	SH 
V_c (m/min)	**150** (100-200)	**120** (70-150)	**120** (70-150)
a_p (mm)	**1.0** (0.5-3.0)	**2.0** (0.5-4.0)	**3.0** (3.0-6.0)
f (mm/rev)	**0.1** (0.03-0.15)	**0.3** (0.2-0.4)	**0.3** (0.2-0.3)
r_ε (mm)	0.4	0.8	1.6

K Cast Iron — Continuous

Operation	Precision finishing	Finishing	Finishing to medium cutting	Medium cutting
Grade	**BX930**	**T5115**	**T5115**	**T5115**
Page	3-8	2-62	2-65	2-67
Chipbreaker	T-CBN 	CF 	CM 	CH 
V_c (m/min)	**700** (300-1200)	**270** (140-400)	**270** (150-400)	**270** (140-400)
a_p (mm)	**0.3** (0.05-0.5)	**1.0** (0.5-2.0)	**2.0** (1.0-5.0)	**4.0** (2.0-6.0)
f (mm/rev)	**0.1** (0.05-0.2)	**0.15** (0.05-0.2)	**0.3** (0.15-0.4)	**0.4** (0.2-0.6)
r_ε (mm)	0.4	0.4	0.8	1.2

N Non-ferrous — Continuous

Operation	Precision finishing	Finishing to medium cutting
Grade	**DX140**	**GH110**
Page	3-21	2-66
Chipbreaker	T-DIA 	P 
V_c (m/min)	**1500** (500-2500)	**600** (100-1000)
a_p (mm)	**0.5** (0.05-1.0)	**2.0** (0.5-4.0)
f (mm/rev)	**0.1** (0.05-0.2)	**0.3** (0.2-0.5)
r_ε (mm)	0.4	0.8

S Superalloys — Continuous

Operation	Finishing	Finishing to medium cutting	Medium cutting
Grade	**BX480**	**AH905**	**AH120**
Page	3-8	2-65	2-66
Chipbreaker	T-CBN 	HMM 	SA 
V_c (m/min)	**200** (70-300)	**50** (20-100)	**50** (20-80)
a_p (mm)	**0.3** (0.1-0.5)	**1.5** (0.5-3.0)	**2.0** (1.0-4.0)
f (mm/rev)	**0.1** (0.05-0.3)	**0.2** (0.1-0.3)	**0.3** (0.2-0.5)
r_ε (mm)	0.4	0.8	0.8

H Hard Materials — Continuous

Operation	Finishing
Grade	**BXM20**
Page	3-8
Chipbreaker	T-CBN 
V_c (m/min)	**150** (70-220)
a_p (mm)	**0.2** (0.05-0.30)
f (mm/rev)	**0.1** (0.05-0.25)
r_ε (mm)	0.4

For other machining types, see "Selection System" 2-4 ~

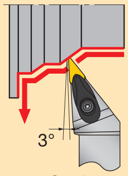
Relating pages Parts (14–1~)

AVJNR/L

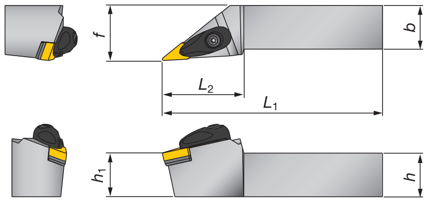
Applicable inserts
VN / YN□□1604

Negative rake
Double clamping system

Turning & External Profiling



Cutting edge style J



Right hand (R) shown.

Toolholders Cat. No.	Stock		Dimensions (mm)							Std. Corner r_ε	Applicable inserts	Page
	R	L	h	b	L_1	L_2	h_1	f	f_2			
AVJNR/L2020K16-A	●	●	20	20	125	43	20	25	–	0.8	VN□□1604□□ YN□□1604□□	2-87 ~ 2-91 ~ 3-9 ~ T-CBN 3-21 ~ T-DIA
AVJNR/L2525M16-A	●	●	25	25	150	46	25	32	–			

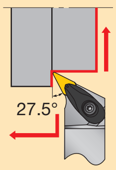
*Recommend clamping torque: 3.0 N·m

AVQNR/L

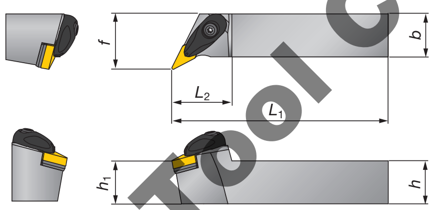
Applicable inserts
VN / YN□□1604

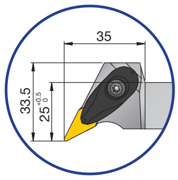
Negative rake
Double clamping system

Profiling



Cutting edge style Q





Enlarged view of 2020 type

Right hand (R) shown.

Toolholders Cat. No.	Stock		Dimensions (mm)							Std. Corner r_ε	Applicable inserts	Page
	R	L	h	b	L_1	L_2	h_1	f	f_2			
AVQNR/L2020K16-A	●	●	20	20	125	35	20	25	–	0.8	VN□□1604□□ YN□□1604□□	2-87 ~ 2-91 ~ 3-9 ~ T-CBN 3-21 ~ T-DIA
AVQNR/L2525M16-A	●	●	25	25	150	35	25	32	–			

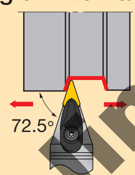
*Recommend clamping torque: 3.0 N·m

AVVNN

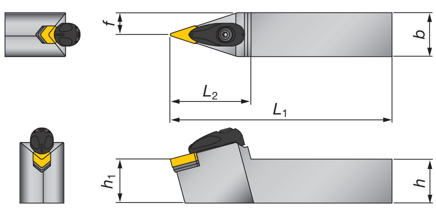
Applicable inserts
VN / YN□□1604

Negative rake
Double clamping system

Turning & External Profiling



Cutting edge style V



Toolholders Cat. No.	Stock	Dimensions (mm)							Std. Corner r_ε	Applicable inserts	Page
		h	b	L_1	L_2	h_1	f	f_2			
AVVNN2020K16-A	●	20	20	125	46	20	10	–	0.8	VN□□1604□□ YN□□1604□□	2-87 ~ 2-91 ~ 3-9 ~ T-CBN 3-21 ~ T-DIA
AVVNN2525M16-A	●	25	25	150	46	25	12.5	–			

*Recommend clamping torque: 3.0 N·m

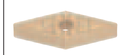
● : Stocked items.

Basic Selection Chipbreakers VN□□1604□□-□□

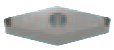
P Steel — Continuous

Operation	Precision finishing	Finishing	Finishing to medium cutting
Grade	NS730	GT730	T9115
Page	2-87	2-87	2-89
Chipbreaker	TF 	TSF 	TM 
V_c (m/min)	**200** (150-250)	**200** (150-300)	**180** (150-300)
a_p (mm)	**0.3** (0.05-0.5)	**1.0** (0.3-1.5)	**2.0** (1.0-4.0)
f (mm/rev)	**0.1** (0.03-0.15)	**0.15** (0.08-0.3)	**0.3** (0.2-0.4)
r_ε (mm)	0.4	0.4	0.8

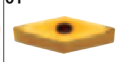
M Stainless — Continuous

Operation	Finishing	Finishing to medium cutting
Grade	T6120	T6130
Page	2-87	2-89
Chipbreaker	SF 	SM 
V_c (m/min)	**150** (100-200)	**120** (70-150)
a_p (mm)	**1.0** (0.5-3.0)	**2.0** (0.5-4.0)
f (mm/rev)	**0.1** (0.03-0.15)	**0.3** (0.2-0.4)
r_ε (mm)	0.4	0.8

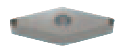
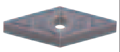
K Cast Iron — Continuous

Operation	Precision finishing	Finishing	Finishing to medium cutting
Grade	BX930	T5115	T5115
Page	3-9	2-88	2-89
Chipbreaker	T-CBN 	CF 	CM 
V_c (m/min)	**700** (300-1200)	**270** (140-400)	**270** (150-400)
a_p (mm)	**0.3** (0.05-0.5)	**1.0** (0.5-2.0)	**2.0** (1.0-4.0)
f (mm/rev)	**0.1** (0.05-0.2)	**0.15** (0.05-0.2)	**0.3** (0.15-0.4)
r_ε (mm)	0.4	0.4	0.8

N Non-ferrous — Continuous

Operation	Precision finishing	Finishing
Grade	DX120	GH110
Page	3-21	2-87
Chipbreaker	T-DIA With chipbreaker 	01 
V_c (m/min)	**1500** (500-2500)	**600** (100-1000)
a_p (mm)	**0.5** (0.05-1.0)	**0.5** (0.05-1.0)
f (mm/rev)	**0.1** (0.05-0.2)	**0.1** (0.03-0.15)
r_ε (mm)	0.4	0.2

S Superalloys — Continuous

Operation	Precision finishing	Finishing	Finishing to medium cutting
Grade	BX470	BX480	AH905
Page	3-9	3-9	2-90
Chipbreaker	T-CBN 	T-CBN 	HMM 
V_c (m/min)	**200** (100-280)	**200** (70-300)	**50** (20-100)
a_p (mm)	**0.3** (0.1-0.5)	**0.3** (0.1-0.5)	**1.5** (0.5-3.0)
f (mm/rev)	**0.1** (0.05-0.2)	**0.1** (0.05-0.3)	**0.2** (0.1-0.3)
r_ε (mm)	0.4	0.4	0.8

H Hard Materials — Continuous

Operation	Precision finishing	Finishing
Grade	BXM10	BXM20
Page	3-9	3-9
Chipbreaker	T-CBN 	T-CBN 
V_c (m/min)	**200** (150-350)	**150** (70-220)
a_p (mm)	**0.1** (0.05-0.30)	**0.2** (0.05-0.30)
f (mm/rev)	**0.1** (0.03-0.18)	**0.1** (0.05-0.25)
r_ε (mm)	0.4	0.4

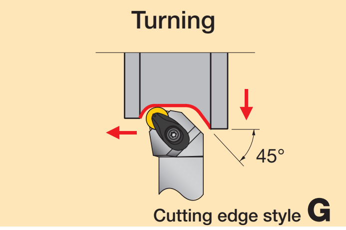
For other machining types, see “Selection System” 2-4 ~

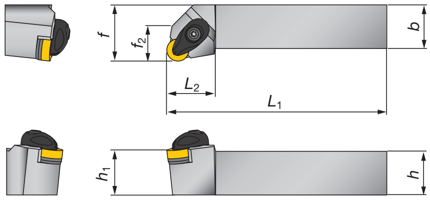
A-type

ARGNR/L

Applicable inserts
RN□□120400

Negative rake
Double clamping system





Right hand (R) shown.

Toolholders Cat. No.	Stock		Dimensions (mm)							Std. Corner	Applicable inserts	Page
	R	L	h	b	L_1	L_2	h_1	f	f_2	r_ε		
ARGNR/L2525M12-A	●	●	25	25	150	28	25	32	20	6.35	RN□□120400	2-92 ~

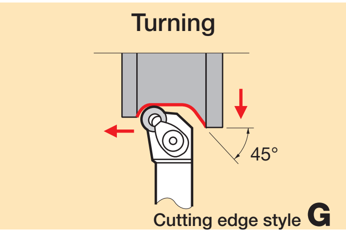
*Recommend clamping torque: 4.0 N·m

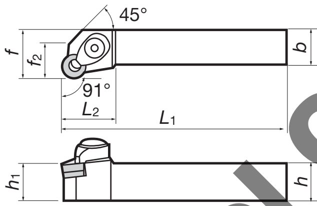
D-type

DRGNR/L

Applicable inserts
RN□□120400

Negative rake
"One-Double" system





Right hand (R) shown.

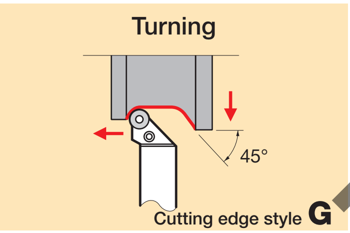
Toolholders Cat. No.	Stock		Dimensions (mm)							Std. Corner	Applicable inserts	Page
	R	L	h	b	L_1	L_2	h_1	f	f_2	r_ε		
DRGNR/L2525M12	●	●	25	25	150	28	25	32	18	6	RN□□120400	2-92 ~

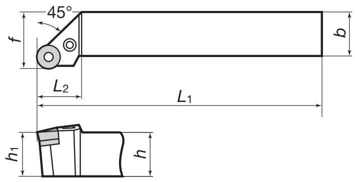
P-type

PRGNR/L

Applicable inserts
RN□□

Negative rake
Lever-lock system





Right hand (R) shown.

Toolholders Cat. No.	Stock		Dimensions (mm)							Std. Corner	Applicable inserts	Page
	R	L	h	b	L_1	L_2	h_1	f	f_2	r_ε		
PRGNR/L2020K09E	●	●	20	20	125	19	20	25	–	4.5	RNMG090300-61	2-92 ~
PRGNR/L2525M09E	●	●	25	25	150	25	25	32	–			
PRGNR/L2525M12E	●	●	25	25	150	25	25	32	–	6	RN□□120400	2-92 ~

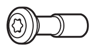
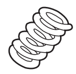
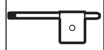
Basic Selection Chipbreakers RN□□1204□□-□□

	Operation	Finishing to medium cutting
P Steel	Grade	T9115
	Page	2-92
Continuous	Chipbreaker	61 
	V_c (m/min)	220 (150-300)
	a_p (mm)	1.0 (0.5-2.0)
	f (mm/rev)	0.8 (0.5-1.0)
	r_ε (mm)	–

● : Stocked items.

Parts

Parts for Turning A

Toolholder Cat. No.	Applicable inserts	Clamp	Clamp screw	Spring	Spring pin	Shim	Shim screw	Wrench	Recommended clamping torque (N·m)
									
ACLNR/L (External·Internal)	**CN□□1204□□**	ACP4S	ACS-5W	BP-7	SP-2.5	ASC422	CSTB-3.5	T-15F	4.0
	CN□□1606□□	ACP5S	ACS-6W	BP-8.8		ASC533	CSTB-5	KEYV-T20	6.4
	CN□□1906□□	ACP6S				ASC634			
ADJNR/L	**DN□□1504□□**	ACP4S	ACS-5W	BP-7	SP-2.5	ASD432	CSTB-3.5	T-15F	4.0
ADPNN									
ADQNR/L									
ADUNR/L (Internal)									
ADJNR/L	**DN□□1506□□**	ACP4S	ACS-5W	BP-7	SP-2.5	ASD423	CSTB-3.5	T-15F	4.0
ADQNR/L									
ADUNR/L (Internal)									
ATGNR/L	**TN□□2204□□**	ACP4S	ACS-5W	BP-7	SP-2.5	AST422	CSTB-3.5	T-15F	4.0
ATFNR/L									
ATJNR/L	**TN□□1604□□**	ACP3S	ACS-5W	BP-7	SP-2.5	AST322	CSTB-3.5	T-15F	3.0
ATGNR/L									
ATFNR/L (External·Internal)									
ATQNR/L									
ASBNR/L	**SN□□1204□□**	ACP4S	ACS-5W	BP-7	SP-2.5	ASS422	CSTB-3.5	T-15F	4.0
	SN□□1506□□	ACP5S	ACS-6W	BP-8.8		ASS533	CSTB-5	KEYV-T20	6.4
	SN□□1906□□	ACP6S				ASS634			
ASDNN	**SN□□1204□□**	ACP4S	ACS-5W	BP-7	SP-2.5	ASS422	CSTB-3.5	T-15F	4.0
ASSNR/L	**SN□□1204□□**	ACP4S	ACS-5W	BP-7	SP-2.5	ASS422	CSTB-3.5	T-15F	4.0
	SN□□1506□□	ACP5S	ACS-6W	BP-8.8		ASS533	CSTB-5	KEYV-T20	6.4
	SN□□1906□□	ACP6S				ASS634			
ASKNR/L (External·Internal)	**SN□□1204□□**	ACP4S	ACS-5W	BP-7	SP-2.5	ASS422	CSTB-3.5	T-15F	4.0
AVJNR/L	**VN□□1604□□** **YN□□1604□□**	ACP3L	ACS-5W	BP-7	SP-2.5	ASV322	CSTB-3.5	T-15F	3.0
AVVNN									
AVQNR/L									
AVUNR/L (Internal)									
AWLNR/L (External·Internal)	**WN□□0604□□**	ACP3S	ACS-5W	BP-7	SP-2.5	ASW322	CSTB-3.5	T-15F	3.0
AWLNR/L (External·Internal)	**WN□□0804□□**	ACP4S	ACS-5W	BP-7	SP-2.5	ASW422	CSTB-3.5	T-15F	4.0
ARGNR/L	**RN□□1204□□**	ACP4S	ACS-5W	BP-7	SP-2.5	ASR420	CSTB-3.5	T-15F	4.0

Note: Replacement parts of former A-type toolholders are not applicable to " TURNINGA " toolholders.

Parts

Parts for D-type

Toolholders Cat. No.		Applicable inserts Cat. No.	Shape	Shim	Spring pin	Lever	Clamp	Clamp screw	Piston	Spring	Wrench
DCLNR/L	2020K12 2525M12 3225P12	CN□□1204□□		LSC42	LSP4	DLCL43	DCPM-43	DLCS43	DPIS43	BP-10	P-3 P-4
	3225P16 3232P16	CN□□1606□□		ELSC53	LSP6C	DLCL54	DCPM-54	DLCS54	DPIS54	BP-13	P-4
	3232P19 4040R19	CN□□1906□□		ELSC63	LSP6	DLCL64	DCPM-64	DLCS64	DPIS64	BP-15	P-5
DWLNR/L	2020K06 2525M06	WN□□0604□□		LSW312	LSP3	LCL33	DCPM-33	DLCS33	DPIS33	BP-9	P-2.5 P-3
	2020K08 2525M08 3225P08	WN□□0804□□		LSW42	LSP4	DLCL43	DCPM-43	DLCS43	DPIS43	BP-10	P-3 P-4
DDJNR/L DDQNR/L	2020K15 2525M15 3225P15	DN□□1504□□		LSD42	LSP4	DLCL43	DCPM-43	DLCS43	DPIS43	BP-10	P-3 P-4
	2020K1506 2525M1506 3225P1506	DN□□1506□□		LSD42	LSP4	DLCL43	DCPM-43	DLCS43	DPIS44	BP-10	P-3 P-4
DTGNR/L DTFNR/L	2020K16 2525M16	TN□□1604□□		LST317	LSP3	LCL33	DCPM-33	DLCS33	DPIS33	BP-9	P-2.5 P-3
	2525M22	TN□□2204□□		LST42	LSP4	DLCL43	DCPM-43	DLCS43	DPIS43	BP-10	P-3 P-4
DSBNR/L	2020K12 2525M12	SN□□1204□□		LSS42	LSP4	DLCL43	DCPM-43	DLCS43	DPIS43	BP-10	P-3 P-4
	3225P15 3232P15	SN□□1506□□		ELSS53	LSP6C	DLCL54	DCPM-54	DLCS54	DPIS54	BP-13	P-4
	3232P19 4040R19	SN□□1906□□		ELSS63	LSP6	DLCL64	DCPM-64	DLCS64	DPIS64	BP-15	P-5
DSDNN DSKNR/L DSSNR/L	2020K12 2525M12	SN□□1204□□		LSS42	LSP4	DLCL43	DCPM-43	DLCS43	DPIS43	BP-10	P-3 P-4
DRGNR/L	2525M12	RN□□120400		LSR42	LSP4	DLCL43	DCPM-43	DLCS43	DPIS43	BP-10	P-3 P-4

Relating pages
Parts (14–1~)

Parts for P-type

Toolholders Cat. No.		Applicable inserts Cat. No.	Shape	Shim	Spring pin	Lever	Clamping screw	Wrench
PCLNR/L PCBNR/L	1616H09 2020K09 2525M09	CN□□0903□□		ELSC32	LSP3L	LCL33	LCS3	P-2.5
	1616H12E	CN□□1204□□		ELSC42	LSP4	LCL4	LCS4CA	P-3
	2020K12E 2525M12E 3225P12E			ELSC42	LSP4S	LCL43M	LCS4	P-3
	2525M16E 3225P16E 3232P16E	CN□□1606□□		ELSC53	LSP6C	LCL5	LCS5	P-3
	3232P19E 4040R19E	CN□□1906□□		ELSC63	LSP6	LCL6	LCS6	P-4
PDJNR/L PDQNR/L PDPNN	1616H11 2020K11 2525M11	DN□□1104□□		ELSD32	LSP3	LCL33L	LCS3	P-2.5
	2020 2520 2525 3225 3232	DN□□1504□□		ELSD42	LSP4S	LCL44	ELCS4	P-3
	2020K15E 2525M15E 3225P15E 3232P15E	DN□□1506□□		ELSD42	LSP4S	LCL44	ELCS4	P-3
PTGNR/L PTFNR/L	1616H16E 2020K16E 2525M16E 3225P16E	TN□□1604□□		ELST317	LSP3	LCL33	LCS3	P-2.5
	2525M22E 3225P22E 3232P22E	TN□□2204□□		ELST42	LSP4S	LCL43M	LCS3	P-3
	3232P27E 4040P27E	TN□□2706□□		ELST53	LSP6C	LCL54	LCS5	P-3
PSBNR/L PSDNN PSSNR/L	1616H09E	SN□□0903□□		ELSS32	LSP3L	LCL33	LCS3	P-2.5
	2020K12E 2525M12E 3225P12E	SN□□1204□□		ELSS42	LSP4S	LCL43M	LCS4	P-3
	2525M15E 3225P15E 3232P15E	SN□□1506□□		ELSS53	LSP5	LCL5	LCS5CA	P-3
	3232P19E 4040R19E	SN□□1906□□		ELSS63	LSP6	LCL6	LCS6	P-4
	5050T25E	SN□□2507□□		ELSS84	LSP8	LCL8	LCS8	P-5
PRGNR/L	2020K09E 2525M09E	RNMG090300-61		ELSR32	LSP3L	LCL33	LCS3	P-2.5
	2525M12E	RN□□120400		ELSR42	LSP4S	LCL43M	LCS4	P-3

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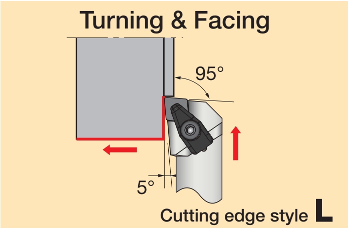
Relating pages Parts (14–1~)

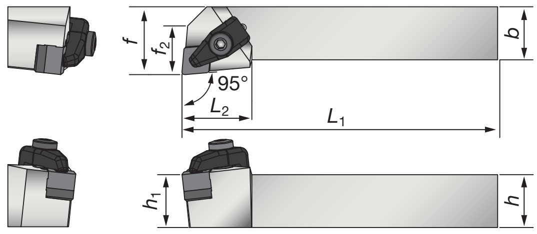
DIMPLEFX C-type for dimple inserts

CCLNR/L

Applicable inserts
CNGD1207□□

Negative rake
Double clamping system





Right hand (R) shown.

Toolholders Cat. No.	Stock	Dimensions (mm)							Std. Corner $r\varepsilon$	Applicable inserts	Page
		h	b	L_1	L_2	h_1	f	f_2			
CCLNR2525M1207-RD	●	25	25	150	33	25	32	23	1.2	CNGD1207□□	4-38
CCLNL2525M1207-RD	●	25	25	150	33	25	32	23	1.2		4-38
CCLNR3225P1207-RD	●	32	25	170	33	32	32	23	1.2		4-38

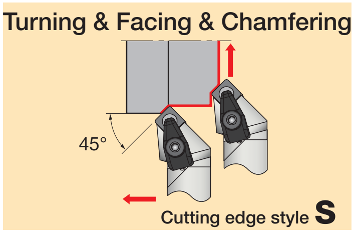
*Recommend clamping torque: 4.0 N·m

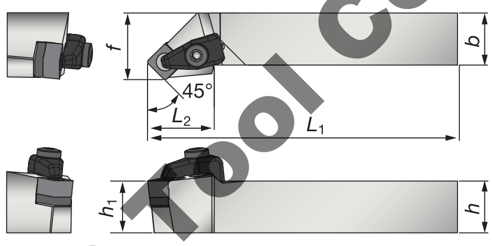
DIMPLEFX C-type for dimple inserts

CSSNR/L

Applicable inserts
SNGD1207□□

Negative rake
Double clamping system





Right hand (R) shown.

Toolholders Cat. No.	Stock	Dimensions (mm)							Std. Corner $r\varepsilon$	Applicable inserts	Page
		h	b	L_1	L_2	h_1	f	f_2			
CSSNR2525M1207-RD	●	25	25	150	32	25	32	–	1.2	SNGD1207□□	4-38
CSSNL2525M1207-RD	●	25	25	150	32	25	32	–	1.2		4-38

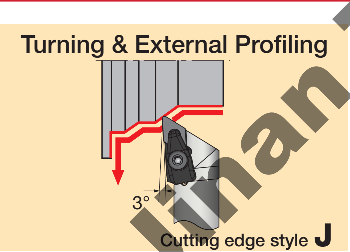
*Recommend clamping torque: 4.0 N·m

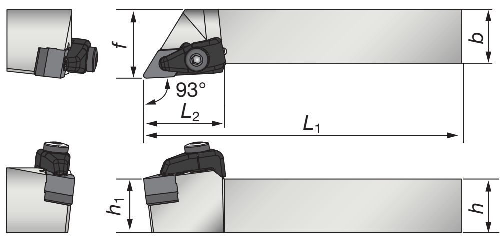
DIMPLEFX C-type for dimple inserts

CDJNR/L

Applicable inserts
DNGD1507□□

Negative rake
Double clamping system





Right hand (R) shown.

Toolholders Cat. No.	Stock	Dimensions (mm)							Std. Corner $r\varepsilon$	Applicable inserts	Page
		h	b	L_1	L_2	h_1	f	f_2			
CDJNR2525M1507-RD	●	25	25	150	38	25	32	–	1.2	DNGD1507□□	4-38
CDJNL2525M1507-RD	●	25	25	150	38	25	32	–	1.2		4-38
CDJNR3225P1507-RD	●	32	25	170	38	32	32	–	1.2		4-38

*Recommend clamping torque: 4.0 N·m

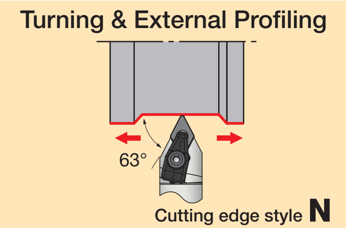
● : Stocked items.

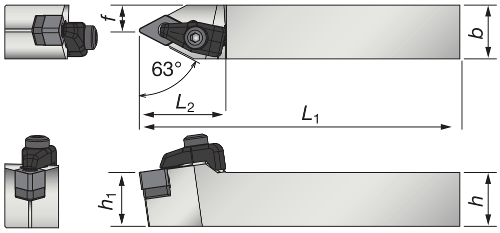
DIMPLEFX C-type for dimple inserts

CDNNN

Applicable inserts
DNGD1507□□

Negative rake
Double clamping system





Toolholders Cat. No.	Stock	Dimensions (mm)							Std. Corner $r\varepsilon$	Applicable inserts	Page
		h	b	L_1	L_2	h_1	f	f_2			
CDNNN2525M1507-RD	●	25	25	150	40	25	12.5	–	1.2	DNGD1507□□	4-38

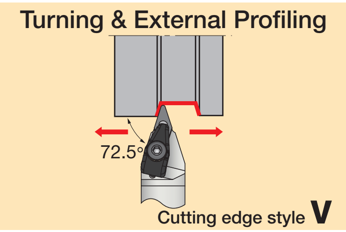
*Recommend clamping torque: 4.0 N·m

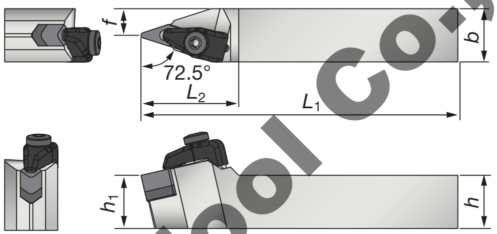
DIMPLEFX C-type for dimple inserts

CVVNN

Applicable inserts
VNGD160712

Negative rake
Double clamping system





Toolholders Cat. No.	Stock	Dimensions (mm)							Std. Corner $r\varepsilon$	Applicable inserts	Page
		h	b	L_1	L_2	h_1	f	f_2			
CVVNN2525M1607-RD	●	25	25	150	46	25	12.5	–	1.2	VNGD160712	4-38

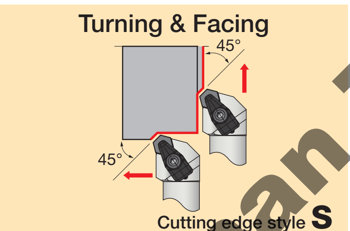
*Recommend clamping torque: 4.0 N·m

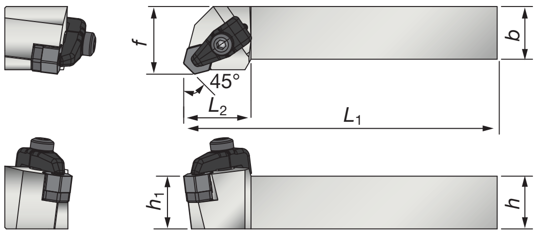
DIMPLEFX C-type for dimple inserts

CHSNR

Applicable inserts
HNGD0507□□

Negative rake
Double clamping system





Toolholders Cat. No.	Stock	Dimensions (mm)							Std. Corner $r\varepsilon$	Applicable inserts	Page
		h	b	L_1	L_2	h_1	f	f_2			
CHSNR2525M0507-RD	●	25	25	150	32	25	32	–	1.2	HNGD0507□□	4-38

*Recommend clamping torque: 4.0 N·m

● : Stocked items.

Inserts / Parts / Standard cutting conditions

Inserts for C-type

Application	Shape	Cat. No.	Stocked Grade FX105	Dimensions (mm) Inner circle ød	Thickness s	Hole dia. ød1	Corner radius rε
Finishing to medium cutting		CNGD120712	●	12.7	7.94	–	1.2
		CNGD120716	●	12.7	7.94	–	1.6
		SNGD120712	●	12.7	7.94	–	1.2
		SNGD120716	●	12.7	7.94	–	1.6
		DNGD150708	●	12.7	7.94	–	0.8
		DNGD150712	●	12.7	7.94	–	1.2
		DNGD150716	●	12.7	7.94	–	1.6
		VNGD160712	●	9.525	7.94	–	1.2
		HNGD050712	●	12.7	7.94	–	1.2
		HNGD050716	●	12.7	7.94	–	1.6

Note: Applicable only C-type toolholder for dimple.

Standard cutting conditions

Application	Grade	Work materials	Cutting speed Vc (m/min)	Depth of cut ap (mm)	Feed f (mm/rev)
K Cast Iron	FX105	Grey cast irons	700 (300 - 1000)	1.0 (0.05 - 3.0)	0.3 (0.05 - 0.6)
		Ductile cast irons	200 (100 - 300)	1.0 (0.05 - 3.0)	0.2 (0.05 - 0.4)

Parts for C-type

Toolholders Cat. No.	Applicable Inserts Cat. No.	Applicable Inserts Shape	Shim	Shim Screw	Clamp	Clamp Screw	Spring	Wrench
CCLNR2525M1207-RD	CNGD1207□□		CC44-A	BH5-10-A	CCP4-A	CCS4-A	BP-5-A	P-4 P-3
CCLNL2525M1207-RD								
CCLNR3225P1207-RD								
CSSNR2525M1207-RD	SNGD1207□□		CS44-A					
CSSNL2525M1207-RD								
CDJNR2525M1507-RD	DNGD1507□□		CD44-A					
CDJNL2525M1507-RD								
CDJNR3225P1507-RD								
CDNNN2525M1507-RD	DNGD1507□□							
CVVNN2525M1607-RD	VNGD160712		CV34-A	BH-4-10-A				
CHSNR2525M0507-RD	HNGD0507□□		CH44-A	BH-40050-A				

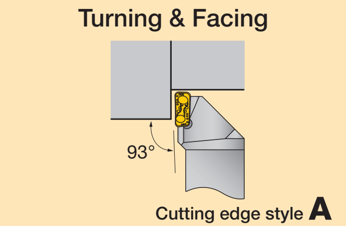
● : Stocked items.

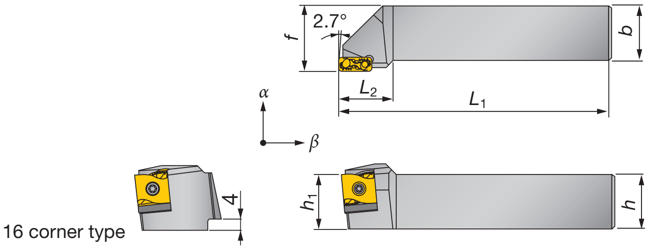
TURNTEC T-type

TLANR/L

Applicable inserts
LNMX□□□□□□

Negative rake
Screw-on system





Right hand (R) shown.

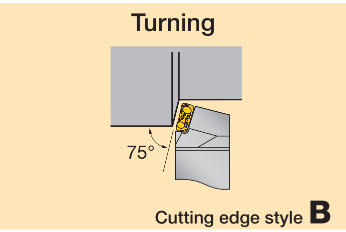
Toolholders Cat. No.	Stock		Dimensions (mm)								Applicable inserts	Page
	R	L	h	b	L_1	L_2	h_1	f	α	β		
TLANR/L1616H12	●	●	16	16	100	20	16	20	-6°	-6°	LNMX1204□□□R/L	4-40
TLANR/L1616M12S	●	●	16	16	150	20	16	20	-6°	-6°		
TLANR/L2020K12	●	●	20	20	125	20	20	25	-6°	-6°		
TLANR/L2525M12	●	●	25	25	150	20	25	30	-6°	-6°		
TLANR/L2020K16	●	●	20	20	125	25	20	25	-6°	-6°	LNMX1606□□□R/L	4-40
TLANR/L2525M16	●	●	25	25	150	25	25	30	-6°	-6°		
TLANR/L3232P16	●	●	32	32	170	35	32	37	-6°	-6°		
TLANR/L4040R16	●	●	40	40	200	35	40	47	-6°	-6°		
TLANR/L3232P24	●	●	32	32	170	35	32	38	-6°	-6°	LNMX2410□□□R/L	4-40
TLANR/L4040R24	●	●	40	40	200	40	40	47	-6°	-6°		
TLANR/L5050S24	●	●	50	50	250	40	50	57	-6°	-6°		

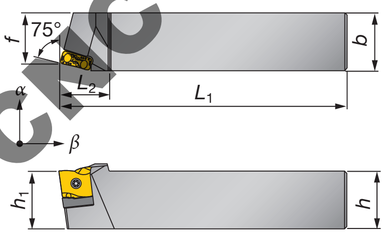
TURNTEC T-type

TLBNR/L

Applicable inserts
LNMX2410□□

Negative rake
Screw-on system





Right hand (R) shown.

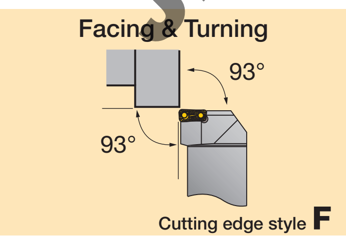
Toolholders Cat. No.	Stock		Dimensions (mm)								Applicable inserts	Page
	R	L	h	b	L_1	L_2	h_1	f	α	β		
TLBNR/L4040R24	●	●	40	40	200	35	40	35	-7.4°	-4.3°	LNMX2410□□□R/L	4-40

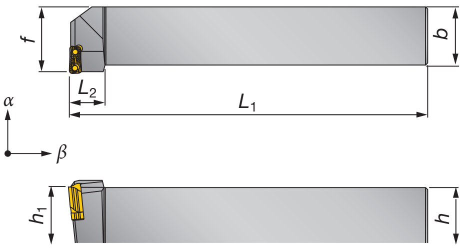
TURNTEC T-type

TLFNR/L

Applicable inserts
LNMX1606□□

Negative rake
Screw-on system





Right hand (R) shown.

Toolholders Cat. No.	Stock		Dimensions (mm)								Applicable inserts	Page
	R	L	h	b	L_1	L_2	h_1	f	α	β		
TLFNR/L2525M16	●	●	25	25	150	20	25	30	-6°	-6°	LNMX1606□□□L/R	4-40
TLFNR/L3232P16	●	●	32	32	170	20	32	37	-6°	-6°		

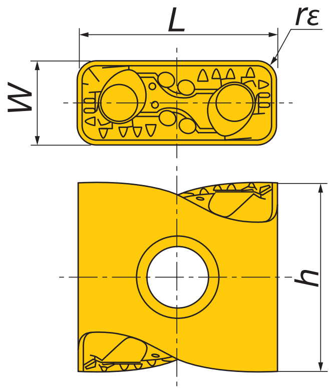
* The right hand insert (R) is used for the left hand toolholders (TLFNL □□ type), and the left hand insert (L) is used for the right hand toolholders (TLFNR □□ type).

● : Stocked items

Relating pages Parts (14–1~)

Inserts / Parts / Standard cutting conditions

Inserts for TurnTec



Right hand (R) shown.

Cat. No.	Stocked grades Coated						Dimensions (mm)			
	T9115		T9125		AH725		*W*	*L*	*h*	*rε*
	R	L	R	L	R	L				
LNMX120408R/L-TDR	●	●	●	●			4.8	12.0	11.6	0.8
LNMX120412R/L-TDR	●	●	●	●			4.8	12.0	11.6	1.2
LNMX160608R/L-TDR	●	●	●	●			6.4	16.2	13.5	0.8
LNMX160612R/L-TDR	●	●	●	●			6.4	16.2	13.5	1.2
LNMX160616R/L-TDR	●	●	●	●			6.4	16.2	13.5	1.6
LNMX241016R/L-TDR	●	★	●	★			9.4	24.0	20.5	1.6
LNMX241024R/L-TDR	●	★	●	★			9.4	24.0	20.5	2.4
LNMX160608R/L-MDR	●	●			★	★	6.4	16.2	13.5	0.8
LNMX160612R/L-MDR	★	★			★	★	6.4	16.2	13.5	1.2
LNMX120408R/L-TWR	★	★	★	★			4.8	12.0	11.6	0.8
LNMX120412R/L-TWR	★	★	★	★			4.8	12.0	11.6	1.2
LNMX160608R/L-TWR	★	★	★	★			6.4	16.2	13.5	0.8
LNMX160612R/L-TWR	★	★	★	★			6.4	16.2	13.5	1.2

● : Stocked items
★ : Available from 2013

Parts for TurnTec

Toolholders Cat. No.	Applicable inserts	Shim	Shim screw	Spring pin	Wrench for shim screw	clamping screw	Wrench
				–			
TLANR/L1616H12	**LNMX1204□□R/L**	TSL12R/L	CSTF-2L055-S	–	T-6F-S	CSTB-3.5L115-S	KEYV-T10
TLANR/L1616M12S							
TLANR/L2020K12							
TLANR/L2525M12							
TLANR/L2020K16	**LNMX1606□□R/L**	TSL16R/L	–	PSP-16	–	CSTB-4L115-S	KEYV-T15
TLANR/L2525M16							
TLANR/L3232P16							
TLANR/L4040R16							
TLANR/L3232P24	**LNMX2410□□R/L**	TSL24R/L	–	SP 16-L14	–	CSTB-5L163-S	KEYV-T20
TLANR/L4040R24							
TLANR/L5050S24							
TLBNR/L4040R24	**LNMX2410□□R/L**	TSL24R/L	–	SP 16-L14	–	CSTB-5L163-S	KEYV-T20
TLFNR/L2525M16	**LNMX1606□□L/R**	TSL16L/R	–	PSP-16	–	CSTB-4L115-S	KEYV-T15
TLFNR/L3232P16							

Relating pages Parts (14–1~)
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Standard cutting conditions

* Values in red shows the condition for facing

LNMX1204□□□-□□□

Work materials	Chip-breakers	Grades	Cutting speed vc (m/min)	Depth of cut: ap (mm) rε: 0.8	Depth of cut: ap (mm) rε: 1.2	Feed: f (mm/rev) rε: 0.8	Feed: f (mm/rev) rε: 1.2
Steels S45C, SCM415 etc. (C45, 18CrMo4 etc.)	TDR	T9115	120 - 250	0.5 - 5 0.5 - 2.2	0.8 - 5 0.8 - 2.2	0.15 - 0.6	0.25 - 0.8
		T9125	80 - 180				
	TWR	T9115	120 - 250	0.5 - 5 0.5 - 2.2	0.8 - 5 0.8 - 2.2	0.15 - 0.6	0.25 - 0.8
		T9125	80 - 180				
Stainless steels SUS304, SUS316 etc. (X5CrNi18-9, X5CrNiMo17-12-2 etc.)	TDR	T9115	100 - 180	0.5 - 5 0.5 - 2.2	0.8 - 5 0.8 - 2.2	0.15 - 0.6	0.25 - 0.8
		T9125	80 - 180				
	TWR	T9115	100 - 180	0.5 - 5 0.5 - 2.2	0.8 - 5 0.8 - 2.2	0.15 - 0.6	0.25 - 0.8
		T9125	80 - 180				

LNMX1606□□□-□□□

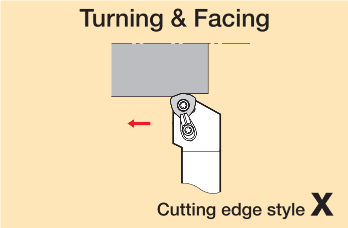
Work materials	Chip-breakers	Grades	Cutting speed vc (m/min)	Depth of cut: ap (mm) rε: 0.8	Depth of cut: ap (mm) rε: 1.2	Depth of cut: ap (mm) rε: 1.6	Feed: f (mm/rev) rε: 0.8	Feed: f (mm/rev) rε: 1.2	Feed: f (mm/rev) rε: 1.6
Steels S45C, SCM415 etc. (C45, 18CrMo4 etc.)	TDR	T9115	120 - 250	0.5 - 5 0.5 - 3.2	0.8 - 6 0.8 - 3.2	1 - 8 1 - 3.2	0.15 - 0.6	0.25 - 0.8	0.3 - 1
		T9125	80 - 180						
	TWR	T9115	120 - 250	0.5 - 5 0.5 - 3.2	0.8 - 6 0.8 - 3.2	-	0.15 - 0.6	0.25 - 0.8	-
		T9125	80 - 180						
Stainless steels SUS304, SUS316 etc. (X5CrNi18-9, X5CrNiMo17-12-2 etc.)	TDR	T9115	100 - 180	0.5 - 5 0.5 - 3.2	0.8 - 6 0.8 - 3.2	1 - 8 1 - 3.2	0.15 - 0.6	0.25 - 0.8	0.3 - 1
		T9125	80 - 180						
	MDR	T9115	100 - 150	1.5 - 6 0.5 - 3.2	1.5 - 7 0.8 - 3.2	-	0.1 - 0.5	0.15 - 0.7	-
		AH725	50 - 150						
	TWR	T9115	100 - 180	0.5 - 5 0.5 - 3.2	0.8 - 6 0.8 - 3.2	-	0.15 - 0.6	0.25 - 0.8	-
		T9125	80 - 180						

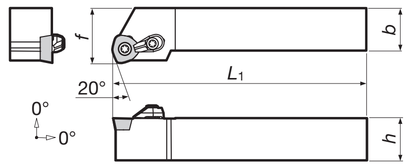
LNMX2410□□□-□□□

Work materials	Chip-breakers	Grades	Cutting speed vc (m/min)	Depth of cut: ap (mm) rε: 1.6	Depth of cut: ap (mm) rε: 2.4	Feed: f (mm/rev) rε: 1.6	Feed: f (mm/rev) rε: 2.4
Steels S45C, SCM415 etc. (C45, 18CrMo4 etc.)	TDR	T9115	120 - 250	4 - 15 1 - 4.5	5 - 15 1 - 4.5	0.3 - 1.0	0.3 - 1.1
		T9125	80 - 150				
Stainless steels SUS304, SUS316 etc. (X5CrNi18-9, X5CrNiMo17-12-2 etc.)	TDR	T9115	100 - 180	4 - 15 1 - 4.5	5 - 15 1 - 4.5	0.3 - 1.0	0.3 - 1.1
		T9125	80 - 150				

XWXPR/L

Positive rake
Double clamping system

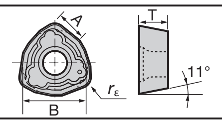




Right hand (R) shown.

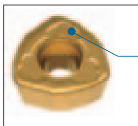
Cat. No.	Stock R	Stock L	h	b	L_1	f	Applicable inserts	Clamp set	Clamping screw	Wrench
XWXPR/L2525M09	●	●	25	25	150	32	WPMT090725ZPR/L-ML	CSY-20	CSTB-5	IP-20T
XWXPR/L3232P09	●	●	32	32	170	40				
XWXPR/L4040S09	●	●	40	40	250	50				

Inserts



Cat. No.	Accuracy	Honing	T9115	T9125	AH120	A	B	T	r_ε
WPMT090725ZPR-ML	M	With	●	●	●	9	15	7	2.5
WPMT090725ZPL-ML			●	●	●				

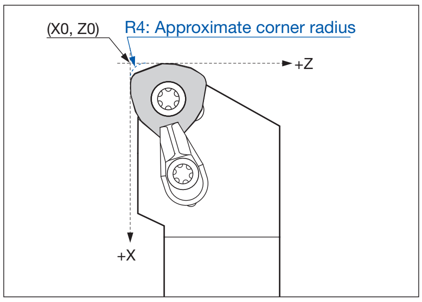
Note: Care should be taken not to confuse the hand of inserts to be used.



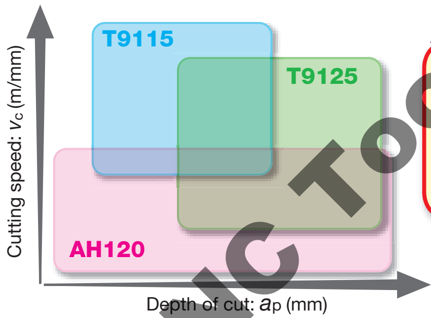
ML type chipbreaker

Letter "L" is marked on the rake face of left hand inserts, allowing easy distinction of the hand of inserts.

Zero point setting method



Application on areas



First choice

● **T9125**
- For low to medium speed machining and interrupted cutting.
- Excels in chipping and impact resistance.

● **T9115**
- For continuous machining at medium to high speeds.
- Excels in both wear and impact resistance.

● **AH120** (Complementary grade for stainless and mild steels)
- In machining stainless and mild steels, if chipping or breakage occurs, use AH120.

Standard cutting conditions

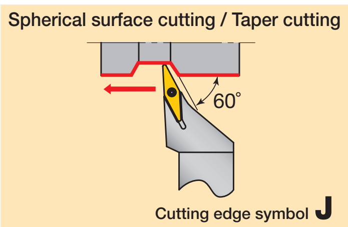
Work materials	Grades	Chipbreaker	Cutting speed v_c (m/min)	Depth of cut a_p (mm)	Feed f (mm/rev)
Mild and low carbon steels (JIS SS400, S25C, etc.) < 180 HB	**T9125**	**ML**	**150** (100 - 250)	0.5 - 2.5	1.5 (0.5 - 2.5)
Carbon and alloy steels (JIS S50C, SCM440, etc.) < 300HB	**T9115**		**150** (100 - 250)		
Stainless steels (JIS SUS304, SUS316, etc.) < 250 HB	**T9125**		**150** (100 - 250)		
Grey and ductile cast irons (JIS FC250, FCD400, etc.)	**AH120**		**150** (100 - 250)		

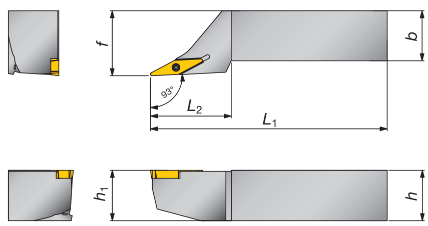
Note: When the side cutting edge is used for facing, the maximum feed is limited to within 1.0 mm/rev.

Y-PRO SERIES S-type

SYJBR/L

Positive rake
Screw-on system





Right hand (R) shown.

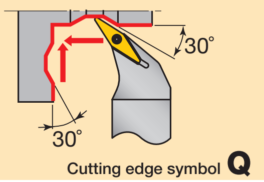
Toolholders Cat. No.	Stock R	Stock L	h	b	L_1	L_2	h_1	f	Std. Corner radius r_ε	Applicable insert	Clamping screw	Wrench
SYJBR/L2020K16	●	●	20	20	125	35	20	25	0.8	YWMT16T3□□	CSTB-2.5L080	T-8F
SYJBR/L2525M16	●	●	25	25	150	40	25	32				

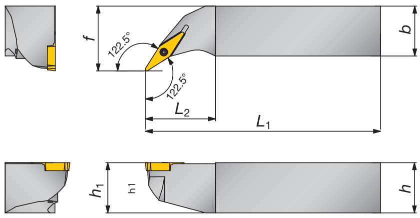
● : Stocked items.
▲ : Shortly unavailable

Y-PRO SERIES S-type SYQBR/L

Positive rake
Screw-on system

External & Undercutting





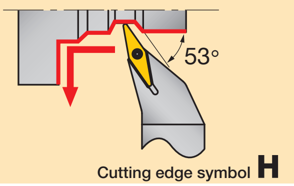
Right hand (R) shown.

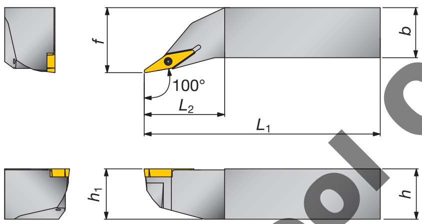
Toolholders Cat. No.	Stock R	Stock L	Dimensions (mm) h	b	L_1	L_2	h_1	f	Std. Corner radius r_ε	Applicable insert	Replacement parts: Clamping screw	Wrench
SYQBR/L2020K16	●	●	20	20	125	35	20	27	0.8	YWMT16T3□□	CSTB-2.5L080	T-8F
SYQBR/L2525M16	●	●	25	25	150	35	25	32				

Y-PRO SERIES S-type SYHBR/L

Positive rake
Screw-on system

External & Retracting





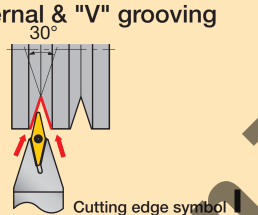
Right hand (R) shown.

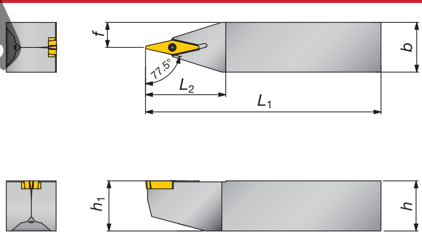
Toolholders Cat. No.	Stock R	Stock L	Dimensions (mm) h	b	L_1	L_2	h_1	f	Std. Corner radius r_ε	Applicable insert	Replacement parts: Clamping screw	Wrench
SYHBR/L2020K16	●	●	20	20	125	35	20	27	0.8	YWMT16T3□□	CSTB-2.5L080	T-8F
SYHBR/L2525M16	●	●	25	25	150	40	25	32				

Y-PRO SERIES S-type SYIBN

Positive rake
Screw-on system

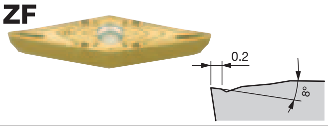
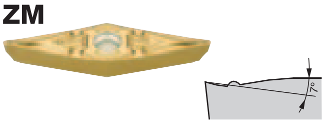
External & "V" grooving





Toolholders Cat. No.	Stock	Dimensions (mm) h	b	L_1	L_2	h_1	f	Std. Corner radius r_ε	Applicable insert	Replacement parts: Clamping screw	Wrench
SYIBN2020K16	●	20	20	125	32	20	10	0.8	YWMT16T3□□	CSTB-2.5L080	T-8F
SYIBN2525M16	●	25	25	150	40	25	12.5				

Inserts

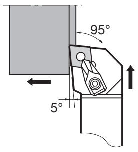
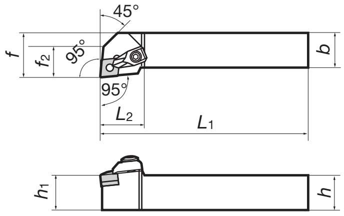
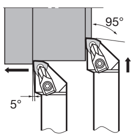
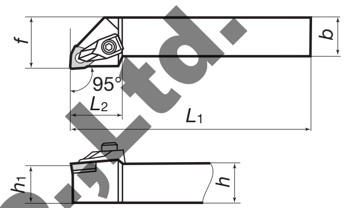
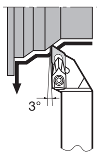
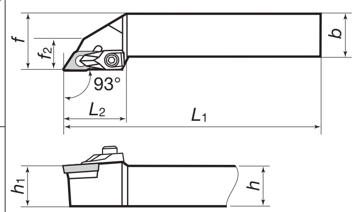
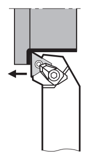
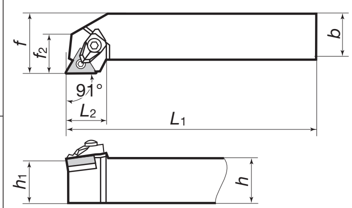
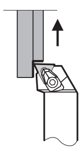
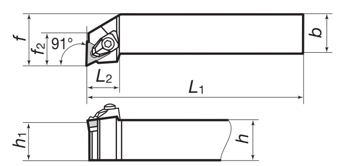
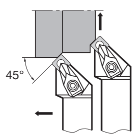
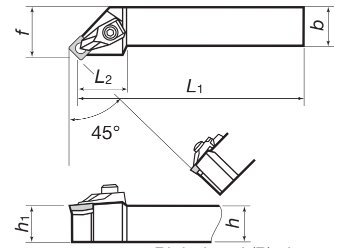
Chipbreaker symbol / Shape and section	Cat. No.	Accuracy	Stocked grades: Coated carbide T9125	Cermet GT730	Dimensions (mm) I.C. dia.	Thickness	Hole dia.(ø)	Corner radius
ZF 	**YWMT11T202-ZF**	M	●	●	4.679	2.78	2.3	0.2
	YWMT11T204-ZF		●	●				0.4
	YWMT16T302-ZF		●	●	7.018	3.97	2.86	0.2
	* **YWMT16T304-ZF**		●	●				0.4
	YWMT16T308-ZF		●	●				0.8
ZM 	**YWMT11T204-ZM**	M	●	●	4.679	2.78	2.3	0.4
	* **YWMT16T304-ZM**		●	●	7.018	3.97	2.86	0.4
	YWMT16T308-ZM		●	●				0.8

Note: Chipbreaker sections shown above are of * marked Cat. Nos.

● : Stocked items.
▲ : Shortly unavailable

Toolholders for External Turning

Negative rake
Clamp-on system

Tooling styles	Cat. No.	Stock R	Stock L	Dimensions (mm) h	b	L_1	L_2	h_1	f	f_2	Std. Corner r_ε	Applicable inserts	Shape
Turning • Facing **ACLNR/L**  Cutting edge style **L**	ACLNR/L2020K12			20	20	125	30	20	25	18	0.8	CN□□1204□□ (Except for 57-type chipbreaker inserts) 80° 2-42 ~	 Right hand (R) shown.
	ACLNR/L2525M12			25	25	150		25	32				
Turning • Facing **AWLNR/L**  Cutting edge style **L**	AWLNR/L2020K08			20	20	125	31	20	25	–	0.8	WN□□0804□□ (Except for 57-type chipbreaker inserts) 80° 2-80 ~	 Right hand (R) shown.
	AWLNR/L2525M08			25	25	150		25	32				
External profiling **ADJNR/L**  Cutting edge style **J**	ADJNR/L2020K15			20	20	125	37.5	20	25	19	0.8	DN□□1504(06)□□ Refer to 1) and 2) in next page. (Except for 57-type chipbreaker inserts) 55° 2-52 ~	 Right hand (R) shown.
	ADJNR/L2525M15			25	25	150		25	32				
Turning **ATGNR/L**  Cutting edge style **G**	ATGNR/L2020K16			20	20	125	21	20	25	16	0.8	TN□□1604□□ (Except for 57-type chipbreaker inserts) 60° 2-70 ~	 Right hand (R) shown.
	ATGNR/L2525M16			25	25	150		25	32	21			
Facing **ATFNR/L**  Cutting edge style **F**	ATFNR/L2020K16			20	20	125	21	20	25	18.5	0.8	TN□□1604□□ (Except for 57-type chipbreaker inserts) 60° 2-70 ~	 Right hand (R) shown.
	ATFNR/L2525M16			25	25	150		25	32	20			
Turning·Facing Chamfering **ASSNR/L**  Cutting edge style **S**	ASSNR/L2020K12			20	20	125	24.5	20	25	–	0.8	SN□□1204□□ (Except for 57-type chipbreaker inserts) 90° 2-61 ~	 Right hand (R) shown.
	ASSNR/L2525M12			25	25	150		25	32				

* Will be replaced by Turning A.

Relating pages Parts (14–1~)

Parts for A-type

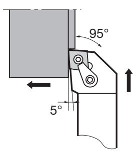
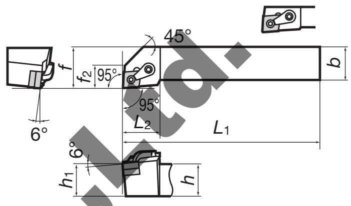
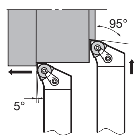
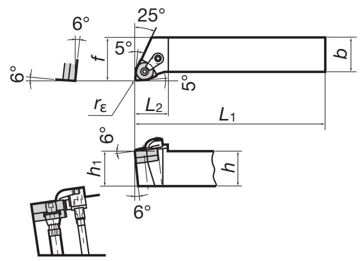
Toolholders Cat. No.		Applicable inserts Cat. No.	Shape	Shim	Spring pin	Spring	Clamp	Clamping screw	Wrench
ACLNR/L	2020K12 2525M12	CN□□1204□□		LSC42	LSP4	BP-9	ACP4	ACS4	P-4
AWLNR/L	2020K08 2525M08	WN□□0804□□		LSW42	LSP4	BP-9	ACP4	ACS4	P-4
ADJNR/L	2020K15 2525M15	DN□□1504(06)□□		LSD43[1)] LSD42[2)]	LSP4	BP-9	ACP4	ACS4	P-4
ATGNR/L ATFNR/L	2020K16 2525M16	TN□□1604□□		LST317	LSP3	BP-7	ACP3	ACS3	P-3
ASSNR/L	2020K12 2525M12	SN□□1204□□		LSS42	LSP4	BP-9	ACP4	ACS4	P-4

1) For 4.76 mm thick inserts
2) For 6.35 mm thick inserts

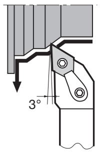
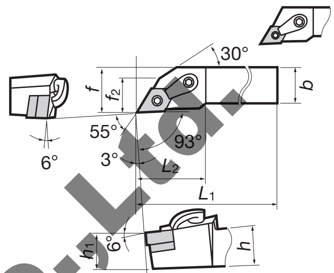
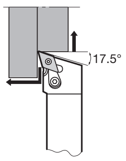
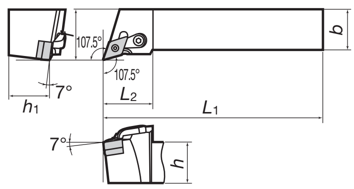
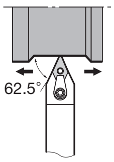
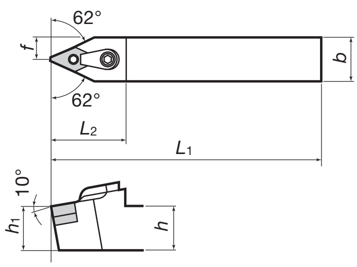
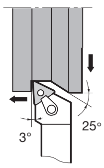
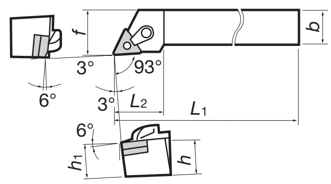
Relating pages
Parts (14–1~)

Toolholders for External Turning

Negative rake
Multi clamping system

Tooling styles	Cat. No.	Stock R	Stock L	Dimensions (mm) h	b	L_1	L_2	h_1	f	f_2	Std. Corner r_ε	Applicable inserts	Shape
Turning • Facing **MCLNR/L**  Cutting edge style L	MCLNR/L1616H12			16	16	100	32	16	20	–	0.8	CN□□1204□□ 80° 80° 2-42 ~ T-CBN 3-7 ~ T-DIA 3-21 ~	 Right hand (R) shown.
	MCLNR/L2020K12			20	20	125		20	25	18			
	MCLNR/L2525M12	●	●	25	25	150		25	32				
	MCLNR/L3225P12			32		170		32					
	MCLNR/L2020K12C			20	20	125	32	20	25	18	0.8	CN□□1207□□ 80° 2-51 CN□□1206□□ 80°	
	MCLNR/L2525M12C			25	25	150		25	32				
	MCLNR/L3225P12C			32		170		32					
	MCLNR/L2525M16			25	25	150	35	25	32	22	1.2	CN□□1606□□ 80° 2-45 ~ (CN□□1604□□)	
	MCLNR/L3225P16			32		170		32					
	MCLNR/L3232P16				32				40				
	MCLNR/L3232P19			32	32	170	36	32	40	30	1.2	CN□□1906□□ 80° 2-45 ~	
	MCLNR/L4040R19			40	40	200		40	50				
Turning • Facing **MWLNR/L**  Cutting edge style L	MWLNR/L2020K08	●		20	20	125	25	20	25	–	0.8	WN□□0804□□ 80° 2-80 ~ T-CBN 3-9 ~	 Right hand (R) shown.
	MWLNR/L2525M08	●	●	25	25	150		25	32				
	MWLNR/L3225P08			32		170		32					
	MWLNR/L2525M10			25	25	150	30	25	32	–	1.2	WN□□1006□□ 80° 2-85	
	MWLNR/L3225P10			32		170		32					
	MWLNR/L3232P10				32				40				
	MWLNR/L4040R10			40	40	200		40	50				
	MWLNR/L3232P13			32	32	170	38	32	40	–	1.2	WN□□1306□□ 80°	
	MWLNR/L4040R13			40	40	200		40	50				

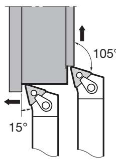
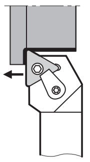
● : Stocked items.

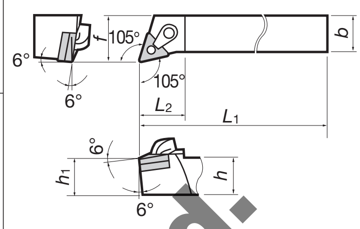
Tooling styles	Cat. No.	Stock R	Stock L	Dimensions (mm) h	b	L_1	L_2	h_1	f	f_2	Std. Corner r_ε	Applicable inserts	Shape
External profiling **MDJNR/L**  Cutting edge style **J**	MDJNR/L1616H11			16	16	100	30	16	20	–	0.8	DN□□1104□□ 55° 2-52 ~	
	MDJNR/L2020K15			20	20	125		20	25			DN□□1504□□ 55° 55°	
	MDJNR/L2525M15	●		25	25	150	38	25	32	19	0.8	DN□□1506□□ 55° 2-52 ~	
	MDJNR/L3225P15			32		170		32				T-CBN 3-7 ~	
	MDJNR/L3232P15				32				40			T-DIA 3-21 ~	
	MDJNR/L2020K15C			20	20	125		20	25				
	MDJNR/L2525M15C			25	25	150	38	25	32	19	0.8	DN□□1507□□ 55° 2-60 ~	
	MDJNR/L3225P15C			32		170		32				DN□□1506□□ 55° 2-52 ~	
	MDJNR/L3232P15C				32				40				Right hand (R) shown.
Profiling **MDQNR/L**  Cutting edge style **Q**	MDQNR/L1616H11			16	16	100	30	16	20	–	0.8	DN□□1104□□ 55° 2-52 ~	
	MDQNR/L2020K15			20	20	125		20	25			DN□□1504□□ 55° 55°	
	MDQNR/L2525M15			25	25	150	36	25	32	–	0.8	DN□□1506□□ 55° 2-52 ~	
	MDQNR/L3225P15			32		170		32				T-CBN 3-7 ~	
	MDQNR/L3232P15				32				40			T-DIA 3-21 ~	Right hand (R) shown.
External profiling **MDPNN**  Cutting edge style **P**	MDPNN1616H11			16	16	100	36	16	8		0.8	DN□□1104□□ 55° 2-52 ~	
	MDPNN2020K15			20	20	125		20	10			DN□□1504□□ 55° 55°	
	MDPNN2525M15	●		25	25	150	42	25	12.5	–	0.8	DN□□1506□□ 55° 2-52 ~	
	MDPNN3225P15			32		170		32				T-CBN 3-7 ~	
	MDPNN3232P15				32				16			T-DIA 3-21 ~	
External profiling **MTJNR/L**  Cutting edge style **J**	MTJNR/L2020K16			20	20	125		20	25			TN□□1603□□ TN□□1604□□ 60° 60°	
	MTJNR/L2525M16	●		25	25	150	28	25	32	–	0.8	2-70 ~	
	MTJNR/L3225P16			32		170		32				T-CBN 3-8 ~ T-DIA 3-21 ~	
	MTJNR/L2525M22			25	25	150		25	32				
	MTJNR/L3225P22			32		170	32	32		–	0.8	TN□□2204□□ 60° 60° 2-70 ~	
	MTJNR/L3232P22				32				40				Right hand (R) shown.

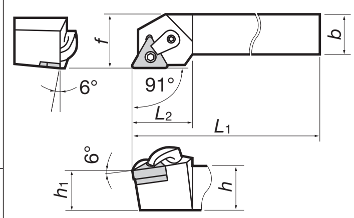
● : Stocked items.

Toolholders for External Turning

Negative rake
Multi clamping system

Tooling styles	Cat. No.	Stock R	Stock L	h	b	L_1	L_2	h_1	f	f_2	Std. Corner r_ε	Applicable inserts	Shape
Profiling MTQNR/L  Cutting edge style Q	MTQNR/L2020K16	●		20	20	125	26	20	25	–	0.8	TN□□1603□□ TN□□1604□□ 60° 60° 2-70 ~ T-CBN 3-8 ~ T-DIA 3-21 ~	
	MTQNR/L2525M16	●		25	25	150		25	32				
	MTQNR/L3225P16			32	25	170		32					
	MTQNR/L2525M22			25	25	150	32	25	32	–	0.8	TN□□2204□□ 60° 60° 2-70 ~	
	MTQNR/L3225P22			32		170		32					
	MTQNR/L3232P22				32				40				Right hand (R) shown.
Turning MTGNR/L  Cutting edge style G	MTGNR/L1616H16			16	16	100	28	16	20	–	0.8	TN□□1603□□ TN□□1604□□ 60° 60° 2-70 ~ T-CBN 3-8 ~ T-DIA 3-21 ~	
	MTGNR/L2020K16			20	20	125		20	25				
	MTGNR/L2525M16			25	25	150		25	32				
	MTGNR/L2020K16C			20	20	125	28	20	25	–	0.8	TN□□1607□□ 60° 2-79 ~	
	MTGNR/L2525M16C			25	25	150		25	32				
	MTGNR/L2525M22			25	25	150	32	25	32	–	0.8	TN□□2204□□ 60° 60° 2-70 ~	
	MTGNR/L3225P22			32		170		32					
	MTGNR/L3232P22				32				40				
	MTGNR/L2525M27			25	25	150	38	25	32	–	1.2	TN□□2706□□ 60°	
	MTGNR/L3232P27			32	32	170		32	40				
	MTGNR/L4040R27			40	40	200		40	50				
	MTGNR/L3232P33			32	32	170	40	32	40	–	1.2	TN□□3307□□ 60°	
	MTGNR/L4040R33			40	40	200		40	50				Right hand (R) shown.

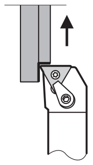
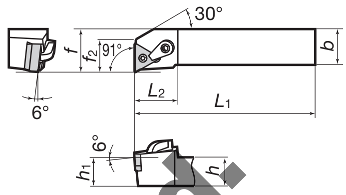
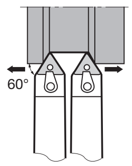
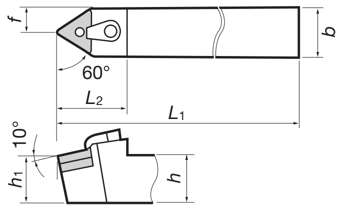
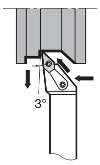
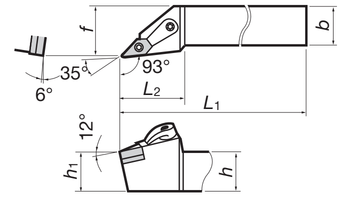
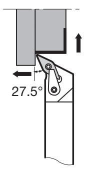
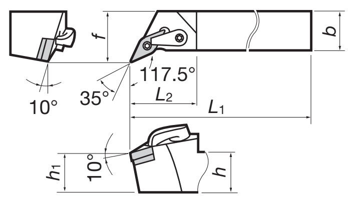




● : Stocked items.

Relating pages Parts (14–1~)

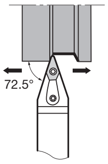
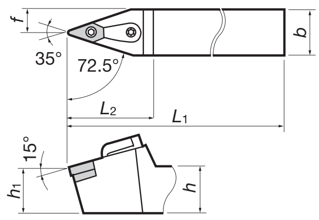
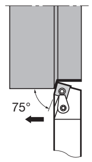
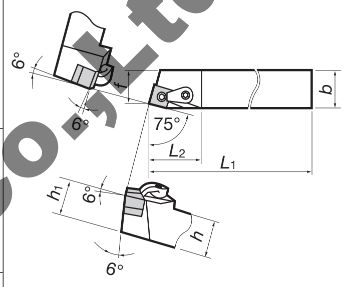
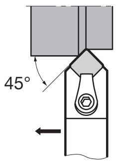
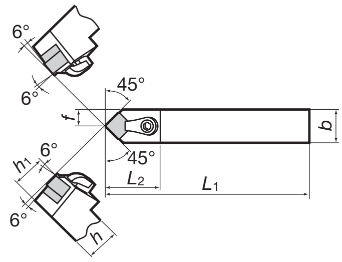
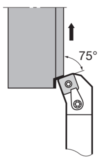
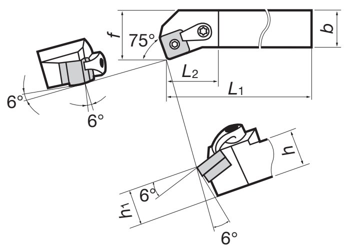
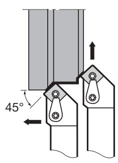
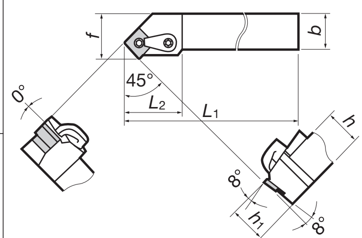
sales@jnterui.com

Tooling styles	Cat. No.	Stock R	Stock L	h	b	L_1	L_2	h_1	f	f_2	Std. Corner r_ε	Applicable inserts	Shape
Facing **MTFNR/L**  Cutting edge style **F**	MTFNR/L1616H16			16	16	100		16	20			TN□□1603□□ TN□□1604□□ 60° 60° 2-70 ~ T-CBN 3-8 ~ T-DIA 3-21 ~	
	MTFNR/L2020K16			20	20	125	28	20	25	18	0.8		
	MTFNR/L2525M16			25	25	150		25	32				
	MTFNR/L2020K16C			20	20	125	28	20	25	18	0.8	TN□□1607□□ 60° 2-79	
	MTFNR/L2525M16C			25	25	150		25	32				
	MTFNR/L2525M22			25	25	150	32	25	32	24	0.8	TN□□2204□□ 60° 60° 2-70 ~	
	MTFNR/L3225P22			32		170		32					
	MTFNR/L3232P27			32	32	170	31	32	40	30	1.2	TN□□2706□□ 60°	
	MTFNR/L4040R27			40	40	200		40	50				Right hand (R) shown.
Turning Chamfering **MTENN**  Cutting edge style **E**	MTENN2020K16			20	20	125	35	20	10	–	0.8	TN□□1603□□ TN□□1604□□ 60° 60° 2-70 ~ T-CBN 3-8 ~ T-DIA 3-21 ~	
	MTENN2525M16	●		25	25	150	35	25	12.5	–	0.8		
	MTENN3225P16			32		170		32					
	MTENN2525M22			25	25	150	38	25	12.5	–	0.8	TN□□2204□□ 60° 60° 2-70 ~	
	MTENN3225P22			32		170		32					
	MTENN3232P22				32				16				
External profiling **MVJNR/L**  Cutting edge style **J**	MVJNR/L2020K16	●	●	20	20	125	42	20	25	–	0.8	VN□□1604□□ 35° 2-87 ~ T-CBN 3-9 ~ T-DIA 3-21 ~ YNMG1604□□ 25° 2-91	
	MVJNR/L2525M16	●	●	25	25	150		25	32				
	MVJNR/L3225P16	●	●	32		170		32					
	MVJNR/L3232P16	●	●		32				40				Right hand (R) shown.
Profiling **MVQNR/L**  Cutting edge style **Q**	MVQNR/L2020K16	●	●	20	20	125	40	20	25	–	0.8	VN□□1604□□ 35° 2-87 ~ T-CBN 3-9 ~ T-DIA 3-21 ~ YNMG1604□□ 25° 2-91	
	MVQNR/L2525M16	●	●	25	25	150		25	32				
	MVQNR/L3225P16			32		170		32					
	MVQNR/L3232P16	●	●		32				40				Right hand (R) shown.

● : Stocked items.

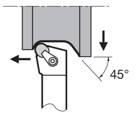
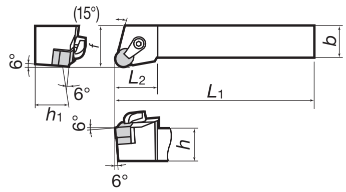
Toolholders for External Turning

Negative rake
Multi clamping system

Tooling styles	Cat. No.	Stock R	Stock L	h	b	L_1	L_2	h_1	f	f_2	Std. Corner r_ε	Applicable inserts	Shape
External profiling **MVVNN**  Cutting edge style **V**	MVVNN2020K16	●		20	20	125	48	20	10	–	0.8	VN□□1604□□ 35° 2-87 ~ T-CBN 3-9 ~ T-DIA 3-21 ~ YNMG1604□□ 25° 2-91	
	MVVNN2525M16	●		25	25	150	48	25	12.5	–	0.8		
	MVVNN3225P16	●		32	25	170	48	32	12.5	–	0.8		
Turning **MSBNR/L**  Cutting edge style **B**	MSBNR/L2020K12			20	20	125	32.5	20	17	–	0.8	SN□□1204□□ 90° 90° 2-61 ~ T-CBN 3-8 ~ T-DIA 3-21 ~	 Right hand (R) shown.
	MSBNR/L2525M12			25	25	150	32.5	25	22	–	0.8		
	MSBNR/L2020K12C			20	20	125	32.5	20	17	–	0.8	SN□□1207□□ 90° 2-69 SN□□1206□□ 90°	
	MSBNR/L2525M12C			25	25	150	32.5	25	22	–	0.8		
Turning Chamfering **MSDNN**  Cutting edge style **D**	MSDNN2020K12			20	20	125	34	20	10.0	–	0.8	SN□□1204□□ 90° 90° 2-61 ~ T-CBN 3-8 ~ T-DIA 3-21 ~	
	MSDNN2525M12			25	25	150	34	25	12.5	–	0.8		
	MSDNN2020K12C			20	20	125	34	20	10.0	–	0.8	SN□□1207□□ 90° 2-69 SN□□1206□□ 90°	
	MSDNN2525M12C			25	25	150	34	25	12.5	–	0.8		
Facing **MSKNR/L**  Cutting edge style **K**	MSKNR/L2020K12			20	20	125	29	20	25	–	0.8	SN□□1204□□ 90° 90° 2-61 ~ T-CBN 3-8 ~ T-DIA 3-21 ~	 Right hand (R) shown.
	MSKNR/L2525M12			25	25	150	29	25	32	–	0.8		
	MSKNR/L2020K12C			20	20	125	29	20	25	–	0.8	SN□□1207□□ 90° 2-69 SN□□1206□□ 90°	
	MSKNR/L2525M12C			25	25	150	29	25	32	–	0.8		
Turning·Facing Chamfering **MSSNR/L**  Cutting edge style **S**	MSSNR/L2020K12			20	20	133	34	20	25	–	0.8	SN□□1204□□ 90° 90° 2-61 ~ T-CBN 3-8 ~ T-DIA 3-21 ~	 Right hand (R) shown.
	MSSNR/L2525M12			25	25	158	34	25	32	–	0.8		
	MSSNR/L2020K12C			20	20	133	34	20	25	–	0.8	SN□□1207□□ 90° 2-69 ~ SN□□1206□□ 90°	
	MSSNR/L2525M12C			25	25	158	34	25	32	–	0.8		

●: Stocked items.

Relating pages Parts (14–1~)

Tooling styles	Cat. No.	Stock R	Stock L	Dimensions (mm) h	b	L_1	L_2	h_1	f	f_2	Std. Corner r_ε	Applicable inserts	Shape
Turning **MRGNR/L**  Cutting edge style **G**	MRGNR/L2020K12			20	20	125	28	20	25	(12)	–	RN□□120400 2-92	 Right hand (R) shown.
	MRGNR/L2525M12			25	25	150		25	32				
	MRGNR/L2020K12C			20	20	125	28	20	25	(12)	–	RNGN120700 2-93	
	MRGNR/L2525M12C			25	25	150		25	32				

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TAC External Toolholders

● : Stocked items.

Relating pages Parts (14–1~)

Replacement Parts for M-type

Replacement Parts for M-type TAC Toolholders

- When using the inserts shown in the shaded cells, the optional parts shown in the shaded cells are needed. You may purchase them separately.
- 1) Used for 1616H16. ● 2) Used for MSDNN. ● 3) Used for MDJNR/L ● 4) Used for MVVNN

Toolholders Cat. No		Applicable inserts Cat. No.	Shape	Shim	Lock pin	Shim screw	Clamp	Clamping screw	Chipbreaker piece	Lock pin Wrench	Wrench
MSBNR/L MSDNN MSKNR/L MSSNR/L	2020K12 2525M12	SN□□1204□□		MSS-432	MLP46	–	MCPM-21	MCS625-3	CBS-4M	P-2.5F	P-3
		SN□□1204□□			–	MSP-6.3			2) CBS-4MN	(P-2.5F)	P-3
	2020K12C 2525M12C	SN□□1207□□		MSS-432	–	MSP-6.3	MCPM-21	MCS625-3	CBS-4M 2) CBS-4MN	P-2.5F	P-3
		SN□□1206□□		MSS-442	MLP46L	–					
MTFNR/L MTGNR/L MTJNR/L MTQNR/L MTENN	1616H16 2020K16 2525M16 3225P16	TN□□1604□□		MST-322	MLP34L	–	1) MCPM-20 MCPM-21	1) MCS620-3 MCS625-3	CBT-3M	P-2F	P-3
		TN□□1604□□			–	MSP-5					
		TN□□1603□□		MST-332	MLP34L	–	1) MCPM-20 MCPM-21	1) MCS620-3 MCS625-3	CBT-3M	P-2F	P-3
		TN□□1603□□			–	MSP-5					
	2020K16C 2525M16C	TN□□1607□□		MST-322	–	MSP-5	MCPM-21	MCS625-3	CBT-3M	(P-2F)	P-3
	2525M22 3225P22 3232P22	TN□□2204□□		MST-432	MLP46	–	MCPM-9	MCS828-4	CBT-4M	P-2.5F	P-4
		TN□□2204□□			–	MSP-6.3					
	2525M27 3225P27 4040R27	TN□□2706□□		MST-533	MLP58	–	MCPM-12	MCS828-4	–	P-3	P-4
	3232P33 4040R33	TN□□3307□□		MST-644	MLP68L	–	MCPM-30	MCS825-4	–	P-3	P-4
MCLNR/L	1616H12 2020K12 2525M12 3225P12	CN□□1204□□		MSC-432	MLP46	–	MCPM-21	MCS625-3	CBC-4MN	P-2.5F	P-3
		CN□□1204□□			–	MSP-6.3					
	2020K12C 2525 3225P12C	CN□□1207□□		MSC-432	–	MSP-6.3	MCPM-21	MCS625-3	CBC-4MN	P-2.5F	P-3
		CN□□1206□□		MSC-442	MLP46L	–					
	2525M16 3225P16 3232P16	CN□□1606□□		MSC-533	MLP58	–	MCPM-12	MCS828-4	–	P-3	P-4
		CN□□1604□□		MSC-543							
	3232P19 4040R19	CN□□1906□□		MSC-634	MLP68	–	MCPM-12	MCS828-4	–	P-4	P-4
MDJNR/L MDPNN MDQNR/L	1616H11	DN□□1104□□		MSD-322	MLP34L	–	MCPM-20	MCS620-3	–	P-2F	P-3
	2020K15 2525M15 3225P15 3232P15	DN□□1506□□		MSD-432	MLP46L	–	MCPM-22	MCS625-3	3) CBD-4MR/L CBD-4MN	P-2.5F	P-3
		DN□□1504□□		MSD-442		–					
		DN□□1504□□		MSD-442	–	MSP-6.3					
	2020K15C 2525M15C 3225P15C 3232P15C	DN□□1507□□		MSD-432	–	MSP-6.3	MCPM-22	MCS625-3	3) CBD-4MR/L CBD-4MN	P-2.5F	P-3
		DN□□1506□□		MSD-442	MLP46L	–					

Replacement Parts for M-type

Toolholders Cat. No.		Applicable inserts Cat. No.	Shape	Shim	Lock pin	Shim screw	Clamp	Clamping screw	Chipbreaker piece	Lock pin Wrench	Wrench
MVJNR/L MVVNN MVQNR/L	2020K16 2525M16 3225P16 3232P16	VN□□1604□□		MSV-322	MLP34L	–	MCPM-22 MCPM-30 4)	MCS625-3 MCS828-4 4)	–	P-2F	P-3 P-4 4)
MRGNR/L	2020K12 2525M12	RN□□1204□□		MSR-43	MLP46	–	MCPM-21	MCS625-3	CBR-4MN	P-2.5F	P-3
		RN□□1204□□		MSR-43	–	MSP-6.3	MCPM-21	MCS625-3	CBR-4MN	P-2.5F	P-3
	2020K12C 2525M12C	RN□□1207□□		MSR-43	–	MSP-6.3	MCPM-21	MCS625-3	CBR-4MN	P-2.5F	P-3
		RN□□1206□□		MSR-44	MLP46L	–	MCPM-21	MCS625-3	CBR-4MN	P-2.5F	P-3
MWLNR/L	2020K08 2525M08 3225P08	WN□□0804□□		MSW-432	MLP46	–	MCPM-6	MCS520-2.5	–	P-2.5	P-2.5
	2525M10 3225P10 3232P10 4040R10	WN□□1006□□		MSW-533	MLP58	–	MCPM-21	MCS625-3	–	P-3	P-3
	3232P13 4040R13	WN□□1306□□		MSW-633	MLP68	–	MCPM-12	MCS828-4	–	P-4	P-4

Note : The shims are made of Tungaloy grade D30, and the chipbreaker pieces are of TX30.

List of Chipbreaker Pieces

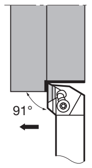
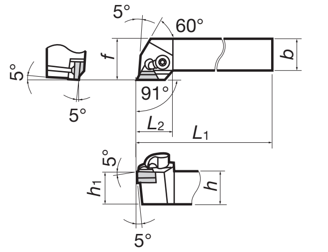
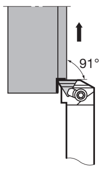
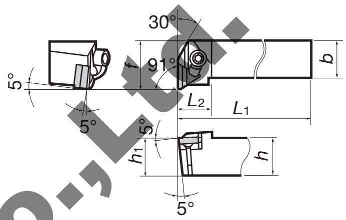
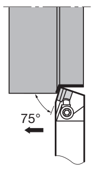
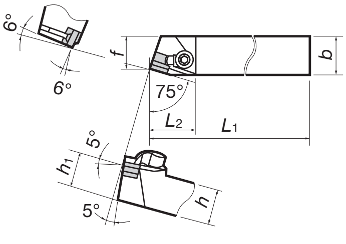
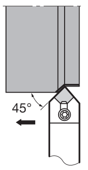
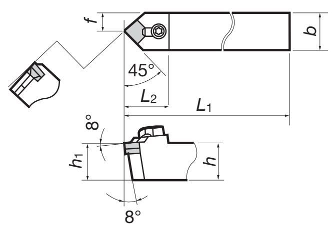
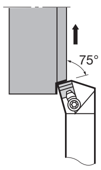
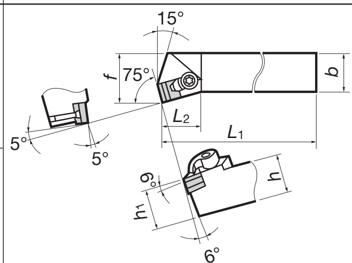
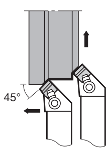
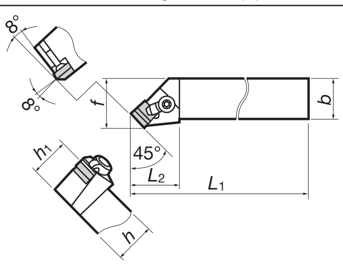
In addition to the standard chipbreaker pieces, optional chipbreaker pieces are available separately.
Select the proper one that is suitable for your cutting conditions.

Shape	Cat. No.	Applicable inserts	Dimensions(mm) A	Dimensions(mm) T	Chipbreaker width when assembled (mm)
	CBS-4S	SN□□1204□□ SN□□1207□□	11.6	2.5	1.5
	CBS-4M		10.6		2.5
	CBS-4L		9.1		4.0
	CBS-4SN	SN□□1204□□ SN□□1207□□	11.5	2.5	1.5
	CBS-4MN		10.5		2.5
	CBS-4LN		9.0		4.0
	CBT-3S	TN□□1604□□ TN□□1607□□	12.1	2.5	1.5
	CBT-3M		11.1		2.5
	CBT-3L		10.1		3.5
	CBT-4S	TN□□2204□□	16.9	2.5	1.5
	CBT-4M		15.9		2.5
	CBT-4L		14.4		3.5
	CBC-4SN	CN□□1204□□ CN□□1207□□	11.5	2.5	1.5
	CBC-4MN		10.5		2.5
	CBC-4LN		9.5		3.5
	CBD-4SR/L	DN□□1504□□ DN□□1506□□ DN□□1507□□	11.5	2.5	1.5
	CBD-4MR/L		10.5		2.5
	CBD-4LR/L		9.5		3.5
	CBD-4SN	DN□□1506□□	11.5	2.5	1.5
	CBD-4MN		10.5		2.5
	CBD-4LN		9.5		3.5
	CBR-4SN	RN□□1204□□	11.9	2.5	1.5
	CBR-4MN	RN□□1206□□	10.9		2.5

C-type

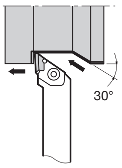
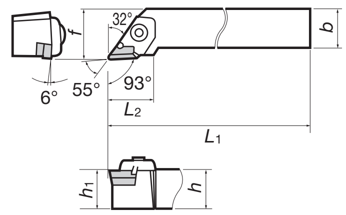
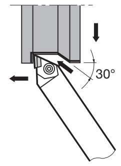
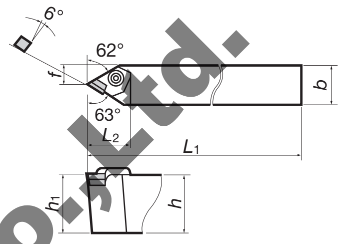
Toolholders for External Turning

Negative rake
Clamp-on system

Tooling styles	Cat. No.	Stock R	Stock L	Dimensions (mm) h	b	L_1	L_2	h_1	f	f_2	Std. Corner r_ε	Applicable inserts	Shape
Turning **CTGNR/L**  Cutting edge style **G**	CTGNR/L2020	●	●	20	20	125	28.5	20	25	–	0.8	TN□□1604□□ 60° 2-79	 Right hand (R) shown.
	CTGNR/L2525	●	●	25	25	150		25	32				
Facing **CTFNR/L**  Cutting edge style **F**	CTFNR/L2020	●	●	20	20	125	22	20	25	–	0.8	TN□□1604□□ 60° 2-79	 Right hand (R) shown.
	CTFNR/L2525	●	●	25	25	150		25	32				
Turning **CSBNR/L**  Cutting edge style **B**	CSBNR/L2020	●		20	20	125	31	20	17	–	0.8	SN□□1204□□ 90° 2-69	 Right hand (R) shown.
	CSBNR/L2525	●	●	25	25	150		25	22				
Turning Chamfering **CSDNN**  Cutting edge style **D**	CSDNN2020	●		20	20	125	32	20	10.0	–	0.8	SN□□1204□□ 90° 2-69	
	CSDNN2525	●		25	25	150		25	12.5				
Facing **CSKNR/L**  Cutting edge style **K**	CSKNR/L2020			20	20	125	25	20	25	–	0.8	SN□□1204□□ 90° 2-69	 Right hand (R) shown.
	CSKNR/L2525	●	●	25	25	150		25	32				
Turning·Facing Chamfering **CSSNR/L**  Cutting edge style **S**	CSSNR/L2020	●	●	20	20	125	31	20	25	–	0.8	SN□□1204□□ 90° 2-69	 Right hand (R) shown.
	CSSNR/L2525	●	●	25	25	150		25	32				

● : Stocked items.

Relating pages Parts (14–1~)

Tooling styles	Cat. No.	Stock R	Stock L	Dimensions (mm) h	b	L_1	L_2	h_1	f	f_2	Std. Corner r_ε	Applicable inserts	Shape
External profiling **CKJNR/L**  Cutting edge style **J**	CKJNR/L2525	●	●	25	25	150	32	25	32	–	0.8	KNMX1604□□ 55° 2-94	 Right hand (R) shown.
	CKJNR/L3232			32	32	170		32	40				
External profiling **CKNNR/L**  Cutting edge style **N**	CKNNR/L4025			40	25	150	37	40	15	–	0.8	KNMX1604□□ 55° 2-94	 Right hand (R) shown.
	CKNNR/L5032			50	32			50	16				

●: Stocked items.

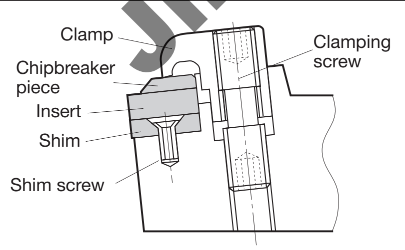
Parts of C-type

Toolholders Cat. No.		Applicable inserts Cat. No.	Shape	Chipbreaker piece	Shim	Shim screw	Clamp	Clamping screw	Wrench
CTGNR/L CTFNR	2020 2525	TN□□1604□□		NCT-2□	NAT-32	SM3×0.5×8	NF-84A	NDS-8A	P-4
CSBNR/L	2020 2525	SN□□1204□□		NCS-3□	NAS-42	SM3×0.5×8	NF-84A	NDS-8A	P-4
CSKNR/L CSSNR/L CSDNN	2020 2525	SN□□1204□□		NCS-3□N	NAS-42	SM3×0.5×8	NF-84A	NDS-8A	P-4

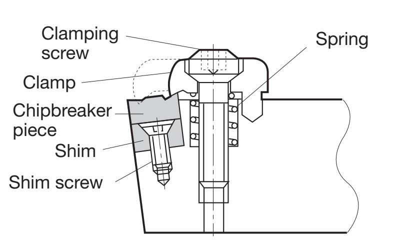
Toolholders Cat. No.		Applicable inserts Cat. No.	Shape	Shim	Clamping screw	Clamp	Spring	Pin	Shim screw	Wrench
CKJNR/L	2525 3232	KNMX1604□□		CSK54R/L	CTS-M6	CPK5R/L	SP913	BP-490	SM3×0.5×10	P-4
CKNNR/L	4025 5032									

Parts Assembly and Chipbreaker Pieces for C-type TAC Toolholders

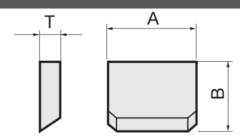
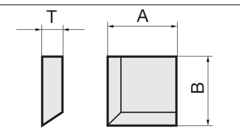
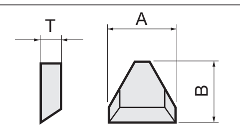
• **Parts assembly of negative rake type**



• **Parts assembly of CKJNR/L·ECKNNR/L-type**



• **List of chipbreaker piece for positive rake, C-type toolholders**

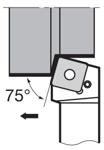
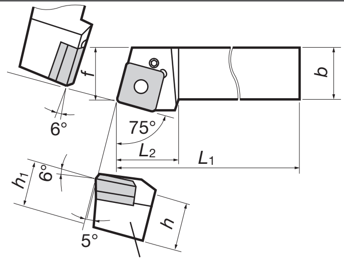
Shape	Cat. No.	Dimensions (mm) A	B	T	Chipbreaker width when assembled (mm)
	NCS-3L	12.7	8.7	2.5	4.0
	NCS-3M*		10.2		2.5
	NCS-3S		11.2		1.5
	NCS-3LN	8.7	8.7	2.5	4.0
	NCS-3MN*	10.2	10.2		2.5
	NCS-3SN	11.2	11.2		1.5
	NCT-2L	12.5	9.8	2.5	3.5
	NCT-2M*	13.6	10.8		2.5
	NCT-2S	14.8	11.8		1.5

Note: *marked items are standard parts. Shim is made of TX30 grade.

Relating pages Parts (14–1~)

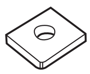
Toolholders for External Turning

Negative rake
Retract-pin system

Tooling styles	Cat. No.	Stock		Dimensions (mm)							Std. Corner	Applicable inserts	Shape
		R	L	h	b	L_1	L_2	h_1	f	f_2	r_ε		
Turning HSRNR/L  Cutting edge style R	HSRNR/L4040R	●	●	40	40	200	50	40	43	–	1.6	SNMM3109□□ 90° 2-68	 Right hand (R) shown.
	HSRNR/L5050S	●	●	50	50	250	60	50	53				

●: Stocked items.

Parts of H-type

Toolholders Cat. No.		Applicable inserts		Shim	Retract pin	Clamping screw	Wrench
		Cat. No.	Shape				
HSRNR/L	4040R	SNMM3109□□		NAS-04	SW99	LS-8	P-4
	5050S						

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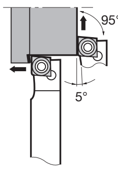
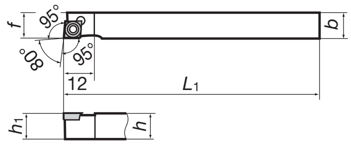
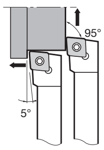
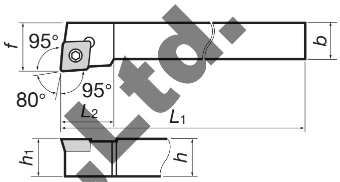
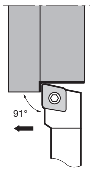
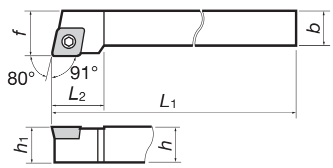
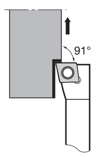
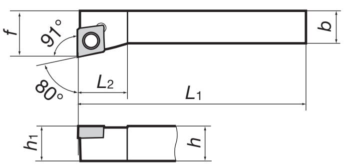
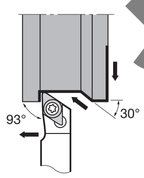
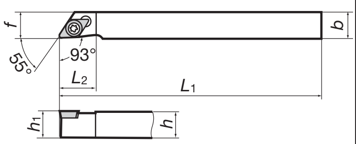
TAC External Toolholders

Relating pages Parts (14–1~)

Toolholders for External Turning

Applicable inserts CC/DC□□

Positive rake
Screw-on system

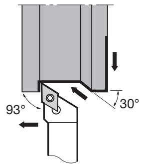
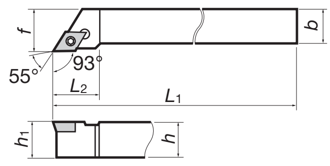
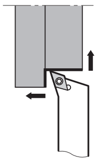
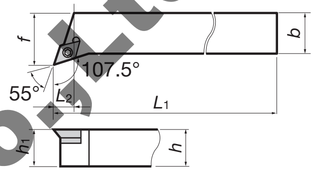
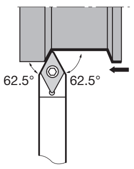
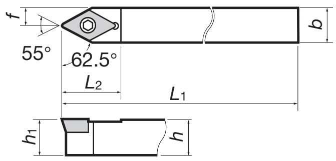
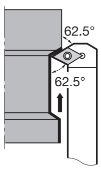
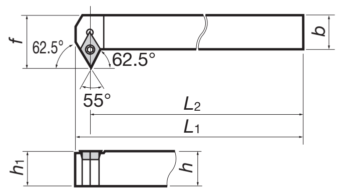
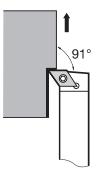
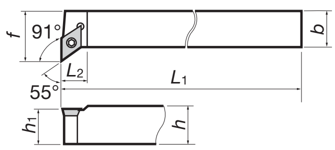
Tooling styles	Cat. No.	Stock R	Stock L	h	b	L_1	L_2	h_1	f	f_2	Std. Corner r_ε	Applicable inserts	Shape
Turning • Facing **SCL2CR/L**  Cutting edge style **L2**	SCL2CR/L1010H			10	10	100	12	10	10	–	0.4	CC□□0602□□ 80° 2-96 ~	Without offset  Right hand (R) shown.
	SCL2CR/L1010K06					125							
	SCL2CR/L1212H			12	12	100		12	12				
	SCL2CR/L1212K06					125							
Turning • Facing **SCLCR/L**  Cutting edge style **L**	SCLCR/L1212H			12	12	100	12	12	16	–	0.4	CC□□0602□□ 80° 2-96 ~	 Right hand (R) shown.
	SCLCR/L1616H			16	16	100	16	16	20	–	0.8	CC□□09T3□□ 80° 2-96 ~	
	SCLCR/L1616H09	●	●										
	SCLCR/L2020K12	●	●	20	20	125	20	20	25	–	0.8	CC□□1204□□ 80° 2-97 ~	
Turning **SCGCR/L**  Cutting edge style **G**	SCGCR/L1212H			12	12	100	12	12	16	–	0.4	CC□□0602□□ 80° 2-96 ~	 Right hand (R) shown.
	SCGCR/L1616H			16	16	100	16	16	20	–	0.8	CC□□09T3□□ 80° 2-96 ~	
Facing **SCFCR/L**  Cutting edge style **F**	SCFCR/L1212H			12	12	100	16	12	16	–	0.4	CC□□0602□□ 80° 2-96 ~	 Right hand (R) shown.
	SCFCR/L1616H			16	16	100	16	16	20	–	0.8	CC□□09T3□□ 80° 2-96 ~	
Turning·Profiling **SDJ2CR/L**  Cutting edge style **J2**	SDJ2CR/L1010H			10	10	100	14	10	10	–	0.4	DC□□0702□□ 55° 2-105 ~	Without offset  Right hand (R) shown.
	SDJ2CR/L1010K07					125							
	SDJ2CR/L1212H			12	12	100		12	12				
	SDJ2CR/L1212K07					125							

T-CBN 3-12 T-DIA 3-22 ~

● : Stocked items.

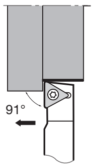
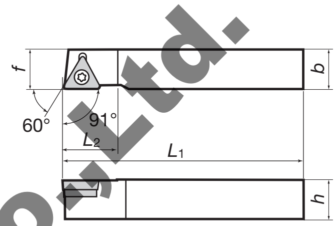
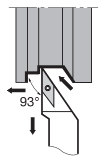
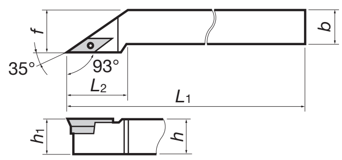
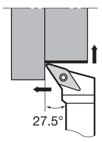
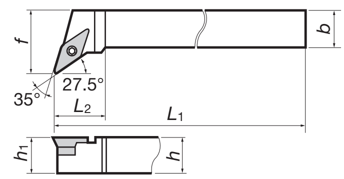
Toolholders for External Turning

Positive rake
Screw-on system

Tooling styles	Cat. No.	Stock R	Stock L	Dimensions (mm) h	b	L_1	L_2	h_1	f	f_2	Std. Corner r_ε	Applicable inserts	Shape
External profiling **SDJCR/L**  Cutting edge style **J**	SDJCR/L1212H			12	12	100	14	12	16	–	0.4	DC□□0702□□ 55° 2-105 ~	 Right hand (R) shown.
	SDJCR/L1616H			16	16	100	18	16	20	–	0.8	DC□□11T3□□ 55° 2-105 ~	
	SDJCR/L1616H11	●					20						
	SDJCR/L2020K11	●	●	20	20	125	20.5	20	25				
	SDJCR/L2525M11	●	●	25	25	150	21.5	25	32				
Profiling **SDQCR/L**  Cutting edge style **Q**	SDQCR/L2020K11	●	●	20	20	125	20.5	20	25	–		DC□□11T3□□ 55° 2-105 ~	 Right hand (R) shown.
	SDQCR/L2525M11	●		25	25	150	21.5	25	32				
Turning·Profiling **SDNCN**  Cutting edge style **N**	SDNCN1010H			10	10	100	14	10	5	–	0.4	DC□□0702□□ 55° 2-105 ~	
	SDNCN1010K07					125							
	SDNCN1212H			12	12	100		12	6				
	SDNCN1212K07					125							
	SDNCN1616H			16	16	100	21	16	8	–	0.8	DC□□11T3□□ 55° 2-105 ~	
	SDNCN1616H11	●											
	SDNCN2020K11	●		20	20	125		20	10				
	SDNCN2525M11	●		25	25	150		25	12.5				
External profiling **SDN3CR/L**  Cutting edge style **N3**	SDN3CR/L1212H			12	12	105	100	12	18	–	0.4	DC□□0702□□ 55° 2-105 ~	 Right hand (R) shown.
	SDN3CR/L1616H			16	16	107	100	16	25	–	0.8	DC□□11T3□□ 55° 2-105 ~	
Facing **SDFCR/L**  Cutting edge style **F**	SDFCR/L1212H			12	12	100	8	12	16	–	0.4	DC□□0702□□ 55° 2-105 ~	 Right hand (R) shown.
	SDFCR/L1616H			16	16	100	10.5	16	22	–	0.8	DC□□11T3□□ 55° 2-105 ~	

T-CBN 3-12 ~ T-DIA 3-22

● : Stocked items.

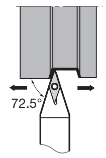
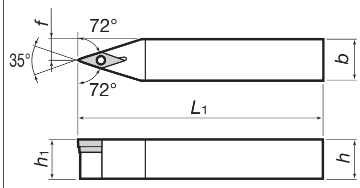
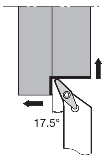
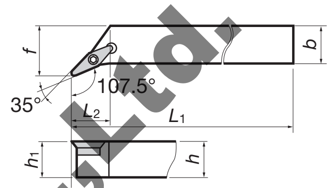
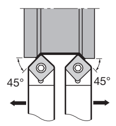
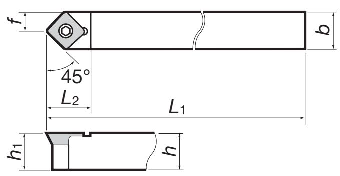
Tooling styles	Cat. No.	Stock R	Stock L	h	b	L_1	L_2	h_1	f	f_2	Std. Corner $r_ε$	Applicable inserts	Shape
Turning **STACR/L**  91° Cutting edge style **A**	STACR/L0808H			8	8	100	10.5	8	8	–	0.2	TC□□0802□□ 60° 2-120 ~	Without offset  Right hand (R) shown.
	STACR/L1010H			10	10			10	10				
	STACR/L1212H			12	12			12	12				
	STACR/L0808H09			8	8	100	10.5	8	8	–	0.4	TC□□0902□□ 60° 2-118 ~	
	STACR/L0808K09					125							
	STACR/L1010H09			10	10	100		10	10				
	STACR/L1010K09					125							
	STACR/L1212H11			12	12	100	12	12	12	–	0.4	TC□□1102□□ 60° 2-118 ~	
	STACR/L1212K11					125							
	STACR/L1616H16	●	●	16	16	100	22.5	16	16	–	0.8	TC□□16T3□□ 60° 2-118 ~	
	STAPR/L1616H			16	16	100	13	16	16	–		TPGA/M1103□□ 60° 2-127 ~	
External profiling **SVJCR/L**  93° Cutting edge style **J**	SVJCR/L1616H16	●	●	16	16	100	32	16	20	–	0.8	VC□□1604□□ 35° 2-135	 Right hand (R) shown.
	SVJCR/L2020K16	●	●	20	20	125		20	25				
	SVJCR/L2525M16	●	●	25	25	150	40	25	32				
	SVJCR/L3225P16			32	25	170		32					
Profiling **SVQCR/L**  27.5° Cutting edge style **Q**	SVQCR/L2020K16	●	●	20	20	125	35	20	27	–	0.8	VC□□1604□□ 35° 2-135	 Right hand (R) shown.
	SVQCR/L2525M16	●	●	25	25	150		25	32				
	SVQCR/L3225P16			32		170		32					

T-CBN 3-13 ~ T-DIA 3-22 ~

● : Stocked items.

Toolholders for External Turning

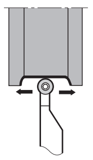
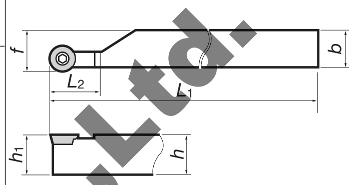
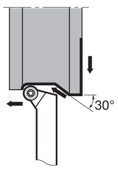
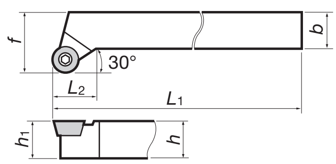
Positive rake
Screw-on system

Tooling styles	Cat. No.	Stock R	Stock L	Dimensions (mm) h	b	L_1	L_2	h_1	f	f_2	Std. Corner r_ε	Applicable inserts	Shape
External profiling **SVVCN**  Cutting edge style **V**	SVVCN2020K16	●		20	20	125	–	20	10	–	0.8	VC□□1604□□ 35° 2-135; T-CBN 3-13; T-DIA 3-22	
	SVVCN2525M16	●		25	25	150	–	25	12.5	–	0.8		
	SVVCN3225P16			32	25	170	–	32	12.5	–	0.8		
Profiling **SVHCR/L**  Cutting edge style **H**	SVHCR/L2020K22			20	20	125	33.8	20	25	–	0.8	VCG□2205□□ 35° 2-136	 Right hand (R) shown.
	SVHCR/L2525M22	●	●	25	25	150	33.8	25	32	–	0.8		
Turning Chamfering **SSDCN** **SSDPN**  Cutting edge style **D**	SSDCN1010H07			10	10	100	12	10	5	–	0.4	SC□□0702□□ 90° 2-113	
	SSDCN1010K07	●		10	10	125	12	10	5	–	0.4		
	SSDCN1212H09			12	12	100	15	12	6	–	0.8	SC□□09T3□□ 90° 2-112	
	SSDCN1212K09	●		12	12	125	15	12	6	–	0.8		
	SSDCN1616H09	●		16	16	100	15	16	8	–	0.8		
	SSDPN1010H	●		10	10	100	12	10	5	–	0.4	SPJP042TND2 SPMP042ERD 90° 11-20	
	SSDPN1212H	●		12	12	100	12	12	6	–	0.4		
	SSDPN1616H	●		16	16	100	14	16	8	–	0.8	SPJM322TND2 SPMM322ERD 90° 11-20	

T-CBN 3-13 ~

● : Stocked items.

Relating pages Parts (14–1~)

Tooling styles	Cat. No.	Stock R	Stock L	h	b	L_1	L_2	h_1	f	f_2	Std. Corner r_ε	Applicable inserts	Shape
Turning SRACR/L  Cutting edge style A	SRACR/L1010H05	●		10	10	100	10	10	10.3	–	–	RCMT0502M0 2-140	 Right hand (R) shown.
	SRACR/L1212H05	●	▲	12	12			12	12.3				
	SRACR/L1616H05	●	▲	16	16			16	16.3				
	SRACR/L2020K05	●	●	20	20	125		20	20.3				
	SRACR/L2525M05	●	●	25	25	150		25	25.3				
	SRACR/L1212H06	●	●	12	12	100	12	12	12.4	–	–	RC□T0602M0 2-140 ~	
	SRACR/L1616H06	●	●	16	16			16	16.4				
	SRACR/L2020K06	●	●	20	20	125		20	20.4				
	SRACR/L2525M06	●	●	25	25	150		25	25.4				
	SRACR/L1616H08	●	●	16	16	100	16	16	16.5	–	–	RC□T0803M0 2-140 ~	
	SRACR/L2020K08	●	●	20	20	125		20	20.5				
	SRACR/L2525M08	●	●	25	25	150		25	25.5				
Turning SRGCR/L  Cutting edge style G	SRGCR/L1212H05	●	▲	12	12	100	9.5	12	16	–	–	RCMT0502M0 2-140	 Right hand (R) shown.
	SRGCR/L1616H05	●	●	16	16			16	20				
	SRGCR/L2020K05	●	●	20	20	125	11.2	20	25				
	SRGCR/L2525M05	●	●	25	25	150	14.7	25	32				
	SRGCR/L1212H06	●	●	12	12	100	10	12	16	–	–	RC□T0602M0 2-140 ~	
	SRGCR/L1616H06	●	●	16	16			16	20				
	SRGCR/L2020K06	●	●	20	20	125	12	20	25				
	SRGCR/L2525M06	●	●	25	25	150	15	25	32				
	SRGCR/L1616H08	●	●	16	16	100	11	16	20	–	–	RC□T0803M0 2-140 ~	
	SRGCR/L2020K08	●	●	20	20	125	12.7	20	25				
	SRGCR/L2525M08	●	●	25	25	150	16.2	25	32				
	SRGCR/L2020K10	●	●	20	20	125	14	25	25	–	–	RC□T1003M0 2-140 ~	
	SRGCR/L2525M10	●	●	25	25	150	17.5	25	32				

● : Stocked items.
▲ : Shortly unavailable

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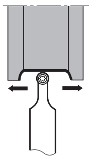
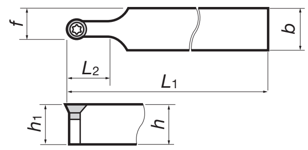
Relating pages Parts (14–1~)

Toolholders for External Turning

Positive rake
Screw-on system

Tooling styles	Cat. No.	Stock R	Stock L	h	b	L_1	L_2	h_1	f	f_2	Std. Corner r_ε	Applicable inserts	Shape
Turning Chamfering **SRDCN**  Cutting edge style **D**	SRDCN2020K06	●		20	20	125	12	20	13	–	–	RC□T0602M0 2-140 ~	
	SRDCN2525M06	●		25	25	150		25	15.5	–			
	SRDCN2020K08	●		20	20	125	16	20	14	–	–	RC□T0803M0 2-140 ~	
	SRDCN2525M08	●		25	25	150		25	16.5	–			
	SRDCN2020K10	●		20	20	125	20.3	25	15	–	–	RC□T1003M0 2-140	
	SRDCN2525M10	●		25	25	150			17.5	–			

● : Stocked items.

Relating pages Parts (14–1~)

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Replacement Parts for S-type

Toolholders Cat. No.		Applicable inserts Cat. No.	Shape	Clamping screw	Wrench	Shim	Shim screw	Wrench
SCL2CR/L	1010H 1010K06 1212H 1212K07	CC□□0602□□		CSTB-2.5L	T-8F	–	–	–
SCLCR/L SCGCR/L SCFCR/L	1212H	CC□□0602□□		CSTB-2.5	T-8F	–	–	–
	1616H	CC□□09T3□□		CSTB-4	T-15F	–	–	–
	1616H09	CC□□09T3□□		CSTB-3.5L	T-15F	SSC32	DTS5-3.5	P-3.5
	2020K12	CC□□1204□□		CSTB-4F	T-15F	SSC4T3	DTS6-4	P-4
SDJ2CR/L SDNCN SDJCR/L SDN3CR/L SDQCR/L SDFCR/L	1010H 1010K07 1212H 1212K07	DC□□0702□□		CSTB-2.5	T-8F	–	–	–
	1616H	DC□□11T3□□		CSTB-4	T-15F	–	–	–
	1616H11 2020K11 2525M11	DC□□11T3□□		CSTB-3.5L	T-15F	SSD32	DTS5-3.5	P-3.5
STACR/L	0808H 1010H 1212H	TC□□0802□□		CSTB-2.2	T-7F	–	–	–
	0808H09 0808K09 1010H09 1010K09	TC□□0902□□		CSTB-2.2	T-7F	–	–	–
	1212H11 1212K11	TC□□1102□□		CSTB-2.5	T-8F	–	–	–
	1616H16	TC□□16T3□□		CSTB-3.5L	T-15F	SST32	DTS5-3.5	P-3.5
STAPR/L	1616H	TPGA/M1103□□		CSTA-NO2L	T-8F	–	–	–
SVJCR/L SVQCR/L SVVCN	1616H16 2020K16 2525M16 3225P16	VC□□1604□□		CSTB-3.5L	T-15F	SSV32	DTS5-3.5	P-3.5
SVHCR/L	2020K22 2525M22	VCG□2205□□		CSTB-4.5L 110P	T-15F	SSV42	DTS6-4.5	P-4.5
SSDCN	1010H07 1010K07	SC□□0702□□		CSTB-3	T-9F	–	–	–
	1212H09 1212K09	SC□□09T3□□		CSTB-4	T-15F	–	–	–
	1616H09	SC□□09T3□□		CSTB-3.5L	T-15F	SSS32	DTS5-3.5	P-3.5

Relating pages Parts (14–1~)

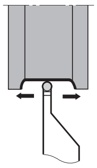
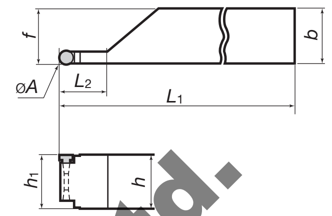
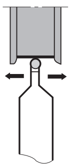
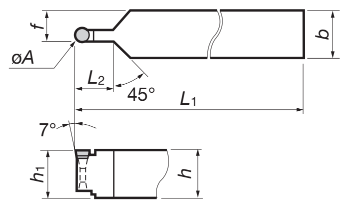
Replacement Parts for S-type

Toolholders Cat. No.		Applicable inserts Cat. No.	Shape	Clamping screw	Wrench	Shim	Shim screw	Wrench
SSDPN	1010H 1212H	SPJP/M042TND2		CSTA-NO3	T-9F	–	–	–
	1616H	SPJP/M322TND2		CSTA-NO5				
SRACR/L SRGCR/L SRDCN	1010H05 1212H05 1616H05 2020K05 2525M05	RCMT0502M0-61		CSTB-2.2R	T-7F	–	–	–
	1212H06 1616H06 2020K06 2525M06	RC□T0602M0		CSTB-2.5	T-8F			
	1616H08 2020K08 2525M08	RC□T0803M0		CSTB-3	T-9F			
	2020K10 2525M10	RC□T1003M0		CSTB-3.5L	T-15F	SSR32	DTS5-3.5	P-3.5

Relating pages Parts (14–1~)

Toolholders for External Turning

Positive rake
Taper lock system

Tooling styles	Cat. No.	Stock (R / L)	h	b	L_1	L_2	h_1	f	f_2	Std. Corner r_ε	Applicable inserts	Shape
Turning **TRACN**  Cutting edge style **A**	TRACN2020K05	●	20	20	125	20	20	20.31	5	–	RT05 ◯ 2-142	
	TRACN2525M05	●	25	25	150		25	25.31				
	TRACN2020K06	●	20	20	125	22	20	20.37	6	–	RT06 ◯ 2-142	
	TRACN2525M06	●	25	25	150		25	25.37				
	TRACN2525M08	●	25	25	150	25	25	25.52	8	–	RT08 ◯ 2-142	
Turning Chamfering **TRDCN**  Cutting edge style **D**	TRDCN2020K05	●	20	20	125	20	20	12.5	5	–	RT05 ◯ 2-142	
	TRDCN2525M05	●	25	25	150		25	15				
	TRDCN2020K06		20	20	125	22	20	13	6	–	RT06 ◯ 2-142	
	TRDCN2525M06	●		25	25	150	25	15.5				
	TRDCN2525M08		25	25	150	25	25	16.5	8	–	RT08 ◯ 2-142	

● : Stocked items.

4
TAC External Toolholders

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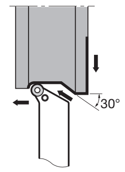
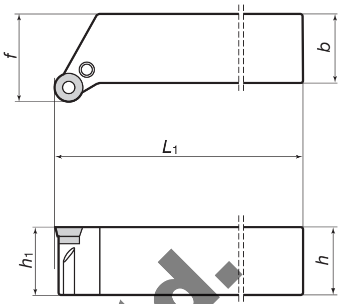
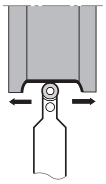
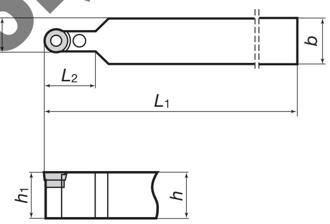
Relating pages Parts (14–1~)

Toolholders for External Turning

Positive rake
Lever lock system

Tooling styles	Cat. No.	Stock R	Stock L	h	b	L_1	L_2	h_1	f	f_2	Std. Corner r_ε	Applicable inserts	Shape
Turning PRGCR/L  Cutting edge style G	PRGCR/L2020K10	●	●	20	20	125	–	20	25	–	–	RCMM1003M0 2-141	 Right hand (R) shown.
	PRGCR/L2525M10			25	25	150		25	32				
	PRGCR/L2525M12	●	●	25	25	150	–	25	32	–	–	RCM□1204M0 2-141	
	PRGCR/L3225P16	●	●	32	25	170	–	32	32	–	–	RCM□1606M0 2-141	
	PRGCR/L3232P20	●	●	32	32	170	–	32	40	–	–	RCM□2006M0 2-141	
	PRGCR/L4040S25			40	40	250	–	40	50	–	–	RCM□2507M0 2-141	
Turning Chamfering PRDCN  Cutting edge style D	PRDCN2020K10	●		20	20	125	22	20	15	–	–	RCMM1003M0 2-141	
	PRDCN2525M12	●		25	25	150	24	25	18.5	–	–	RCM□1204M0 2-141	
	PRDCN3225P12	●		32		170		32					
	PRDCN3225P16	●		32	25	170	28	32	20.5	–	–	RCM□1606M0 2-141	
	PRDCN3232P20	●		32	32	170	32	32	26	–	–	RCM□2006M0 2-141	
	PRDCN4040R25	●		40	40	200	42	40	32.5	–	–	RCM□2507M0 2-141	

● : Stocked items.

Parts of P-type

Toolholders Cat. No.		Applicable inserts Cat. No.	Shape	Shim	Clamping-screw	Spring pin	Lever	Wrench
PRGCR/L PRDCN	2020K10 2525M10	RCM□1003M0	◎	LSR32C	LCS2	LSP3	LCL3C	P-2
	2525M12 3225P12	RCM□1204M0	◎	LSR42C	LCS3	LSP3	LCL4C	P-2.5
	3225P16	RCM□1606M0	◎	LSR53C	LCS5	LSP4	LCL5C	P-3
	3232P20	RCM□2006M0	◎	LSR63C	LCS5	LSP6C	LCL6C	P-3
	4040S25	RCM□2507M0	◎	LSR84C	LCS8C	LSP6	LCL8C	P-4

Relating pages Parts (14–1–)

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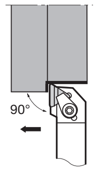
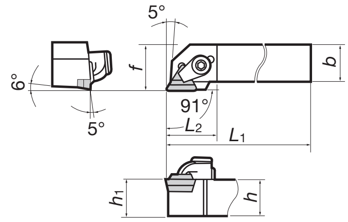
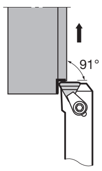
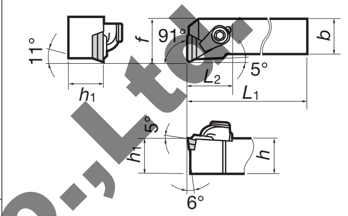
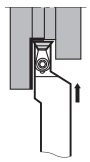
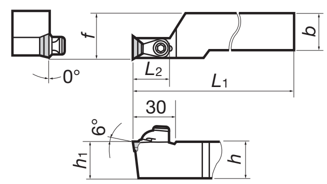
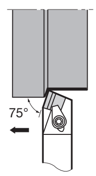
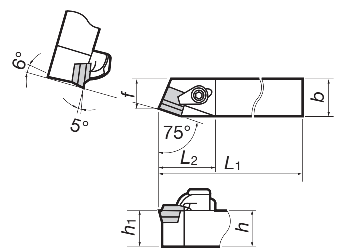
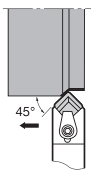
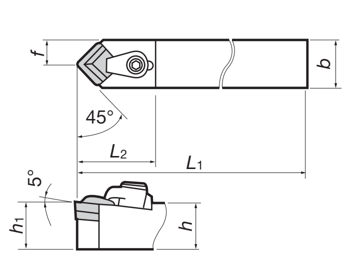
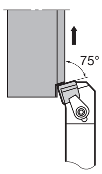
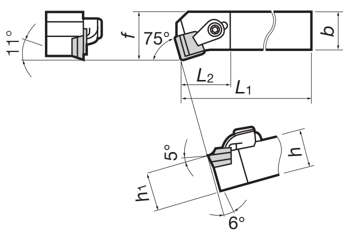
Toolholders for External Turning

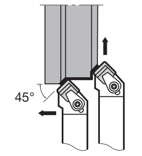
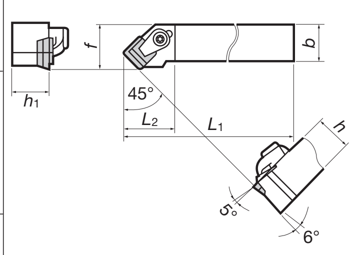
Positive rake
Clamp-on system

Tooling styles	Cat. No.	Stock R	Stock L	h	b	L_1	L_2	h_1	f	f_2	Std. Corner r_ε	Applicable inserts	Shape
Turning CTGPR/L  Cutting edge style G	CTGPR/L1616H3	●	●	16	16	100	23	16	20				 Right hand (R) shown.
	CTGPR/L2020K3	●	●	20	20	125	27	20	25	–	0.8	TP□□1603□□ 60° 2-130 ~	
	CTGPR/L2525M3	●	●	25	25	150		25	32				
Facing CTFPR/L  Cutting edge style F	CTFPR/L1616H3	●	●	16	16	100	23	16	20				 Right hand (R) shown.
	CTFPR/L2020K3	●	●	20	20	125	26	20	25	–	0.8	TP□□1603□□ 60° 2-130 ~	
	CTFPR/L2525M3	●	●	25	25	150		25	32				
Facing CTCPR/L  Cutting edge style C	CTCPR/L2020K3			20	20	125	25	20	25				 Right hand (R) shown.
	CTCPR/L2525M3	●	●	25	25	150	32	25	32	–	0.8	TP□□1603□□ 60° 2-130 ~	
	CTCPR/L3232P3			32	32	170	40	32	40				
Turning CSBPR/L  Cutting edge style B	CSBPR/L1616H3	●	●	16	16	100	25	16	13	–	0.4	SP□□0903□□ 90° 2-116 ~	 Right hand (R) shown.
	CSBPR/L2020K4	●	●	20	20	125	32	20	17	–	0.8	SP□□1203□□ 90° 2-116 ~	
	CSBPR/L2525M4	●	●	25	25	150		25	22				
Turning Chamfering CSDPN  Cutting edge style D	CSDPN1616H3	●		16	16	100	26	16	8			SP□□0903□□ 90° 2-116 ~	
	CSDPN2020K4	●		20	20	125	34	20	10	–	0.8	SP□□1203□□ 90° 2-116 ~	
	CSDPN2525M4	●		25	25	150		25	12.5				
Facing CSKPR/L  Cutting edge style K	CSKPR/L1616H3			16	16	100	23	16	20		0.8	SP□□0903□□ 90° 2-116 ~	 Right hand (R) shown.
	CSKPR/L2020K4			20	20	125	26	20	25	–	0.8	SP□□1203□□ 90° 2-116 ~	
	CSKPR/L2525M4			25	25	150		25	32				

● : Stocked items.

Toolholders for External Turning

Positive rake
Clamp-on system

Tooling styles	Cat. No.	Stock R	Stock L	h	b	L_1	L_2	h_1	f	f_2	Std. Corner r_ε	Applicable inserts	Shape
Turning·Facing Chamfering **CSSPR/L**  Cutting edge style **S**	CSSPR/L1616H3	●		16	16	105.5	23	16	20	–	0.8	SP□□0903□□ 90° ▶2-116 ~	 Right hand (R) shown.
	CSSPR/L2020K4	●		20	20	133	28	20	25	–	0.8	SP□□1203□□ 90° ▶2-116 ~	
	CSSPR/L2525M4	●		25	25	158		25	32				

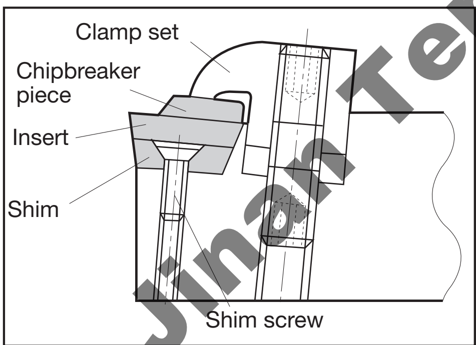
● : Stocked items.

Parts of C-type

Toolholders Cat. No.		Applicable inserts Cat. No.	Shape	Chipbreaker piece	Shim	Clamp set	Shim screw	Wrench
CTGPR/L CTFPR/L	1616H3	TP□□1603□□	△	CBT-3M	PAT-32	CSG-6L	SM3×0.5×8	P-3
	2020K3 2525M3					CSG-8		P-4
CTCPR/L	2020K3 2525M3 3232P3	TP□□1603□□	△	CBT-3M	PAT-32	CSW-2	SM3×0.5×8	P-4
CSBPR/L CSKPR/L CSSPR/L	1616H3	SP□□0903□□	□	CBS-3M	PAS-32	CSG-6L	SM2.5×0.45×8	P-3
	2020K4 2525M4	SP□□1203□□		CBS-4M	PAS-42	CSG-8	SM3×0.5×8	P-4
CSDPN	1616H3	SP□□0903□□	□	CBS-3M	PAS-32	CSG-6L	SM2.5×0.45×8	P-3
	2020K4 2525M4	SP□□1203□□		CBS-4MN	PAS-42	CSG-8	SM3×0.×8	P-4

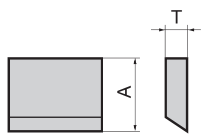
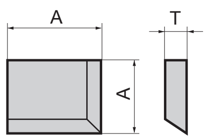
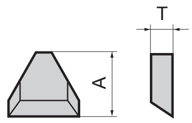
Parts Assembly and Chipbreaker Pieces for C-type TAC Toolholders

• Parts assembly of positive rake type



Note: Shim is made of D30 grade.

• List of chipbreaker piece for positive rake, C-type toolholders

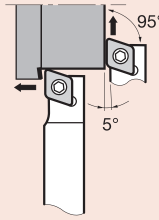
Shape	Cat. No.	Applicable insert	Dimensions(mm) A	Dimensions(mm) T	Chipbreaker width when assembled (mm)
	CBS-3S	SP□□0903□□	8.33	2	1.5
	CBS-3M*		7.33	2	2.5
	CBS-4S	SP□□1203□□	11.6	2.5	1.5
	CBS-4M*		10.6	2.5	2.5
	CBS-4L		9.1	2.5	4
	CBS-3SN	SP□□0903□□	8.33	2	1.5
	CBS-3MN*		7.33	2	2.5
	CBS-4SN	SP□□1203□□	11.6	2.5	1.5
	CBS-4MN*		10.6	2.5	2.5
	CBS-4LN		9.1	2.5	4
	CBT-3S	TP□□1603□□	12.1	2.5	1.5
	CBT-3M*		11.1	2.5	2.5
	CBT-3L		10.1	2.5	3.5

Note: *marked items are standard parts. Chipbreaker piece made of TX30 grade.

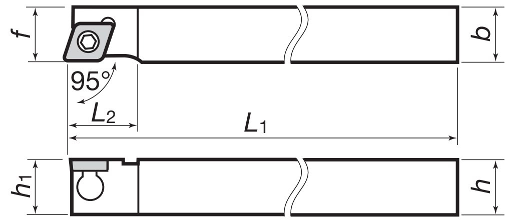
JTCL2CR/L

Without offset / Positive rake
Side clamping system

Turning / Facing



Cutting edge style **L2**



Right hand (R) shown

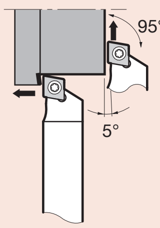
Cat. No.	Stock R	Stock L	Dimensions (mm) h	b	L_1	L_2	h_1	f	Standard corner radius $r\varepsilon$	Applicable inserts	Parts Clamp	Parts Clamping screw	Parts Wrench
JTCL2CR/L0810K06	●	●	8	10	125	12	8	10	0.4	CC□□0602	JCP-2	JDS-3525	P-2F
JTCL2CR/L1010K06	●	●	10	10	125	12	10	10	0.4				
JTCL2CR/L1212M09	●	●	12	12	150	16	12	12	0.8	CC□□09T3	JCP-3	JDS-5040	P-2.5F
JTCL2CR/L1616M09	●	●	16	16	150	16	16	16	0.8				

J-SERIES J-type / External Turning

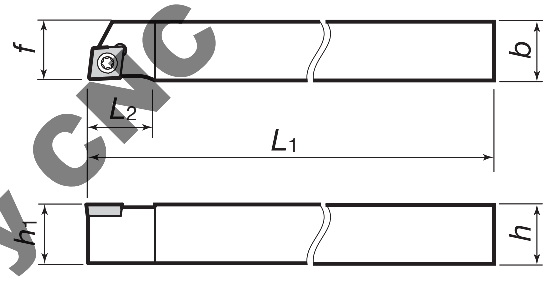
JSCL2CR/L

Without offset / Positive rake
Screw-on system

Turning / Facing



Cutting edge style **L2**

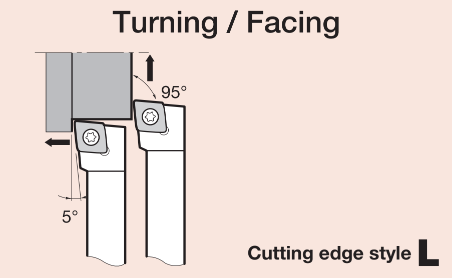


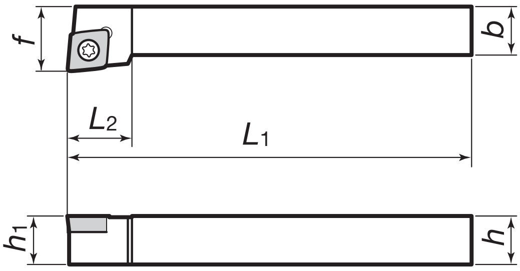
Right hand (R) shown

Cat. No.	Stock R	Stock L	Dimensions (mm) h	b	L_1	L_2	h_1	f	Standard corner radius $r\varepsilon$	Applicable inserts	Parts Clamping screw	Parts Wrench	Torque (N·m)
JSCL2CR/L1010K06	●	●	10	10	125	12	10	10	0.4	CC□□0602	CSTB-2.5	T-8F	1.2
JSCL2CR/L1212K06	●	●	12	12	125	12	12	12	0.4				

JSCLCR/L

Positive rake
Screw-on system





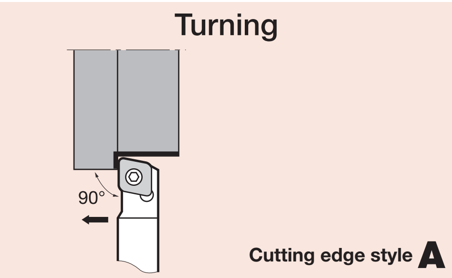
Right hand (R) shown

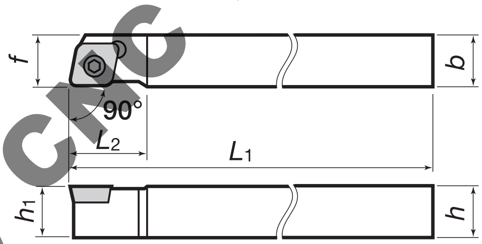
Cat. No.	Stock R	Stock L	Dimensions (mm) h	b	L_1	L_2	h_1	f	Standard corner radius $r\varepsilon$	Applicable inserts	Parts Clamping screw	Parts Wrench	Torque (N·m)
JSCLCR/L0808H06	●	●	8	8	100	12	8	10	0.4	CC□□0602	CSTB-2.5	T-8F	1.2
JSCLCR/L1010H06	●	●	10	10	100	12	10	12	0.4				
JSCLCR/L1212H09	●	●	12	12	100	16	12	16	0.8	CC□□09T3	CSTB-4SD	T-8F	1.2
JSCLCR/L1616H09	●	●	16	16	100	16	16	20	0.8				

J-SERIES J-type / External Turning

JSCACR/L

Without offset / Positive rake
Screw-on system



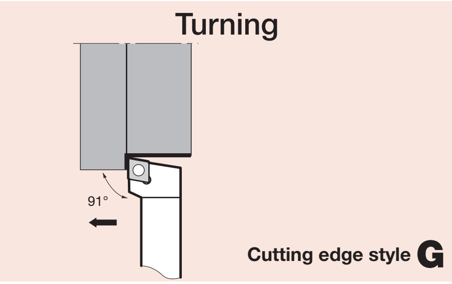


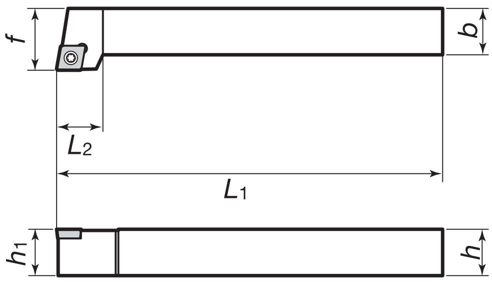
Right hand (R) shown

Cat. No.	Stock R	Stock L	Dimensions (mm) h	b	L_1	L_2	h_1	f	Standard corner radius $r\varepsilon$	Applicable inserts	Parts Clamping screw	Parts Wrench	Torque (N·m)
JSCACR/L0808H06	●	●	8	8	100	12	8	8	0.4	CC□□0602	CSTB-2.5	T-8F	1.2
JSCACR/L1010H06	●	●	10	10	100	12	10	10	0.4				
JSCACR/L1212H09	●	●	12	12	100	16	12	12	0.8	CC□□09T3	CSTB-4SD	T-8F	1.2

JSCGCR/L

Positive rake
Screw-on system





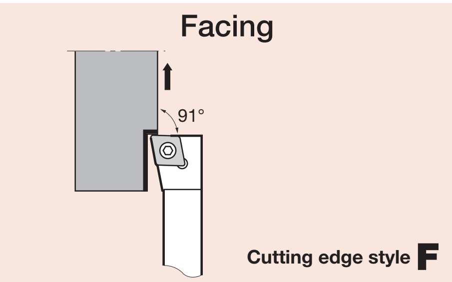
Right hand (R) shown

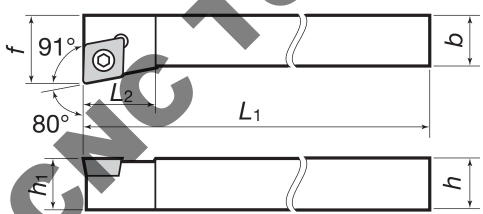
Cat. No.	Stock		Dimensions (mm)						Standard corner radius $r\varepsilon$	Applicable inserts	Parts		Torque (N·m)
	R	L	h	b	L_1	L_2	h_1	f			Clamping screw	Wrench	
JSCGCR/L1212H06	●	●	12	12	100	12	12	16	0.4	CC□□0602	CSTB-2.5	T-8F	1.2
JSCGCR/L1616H09	●	●	16	16	100	16	16	20	0.8	CC□□09T3	CSTB-4SD	T-8F	1.2

J-SERIES J-type / External Turning

JSCFCR/L

Positive rake
Screw-on system

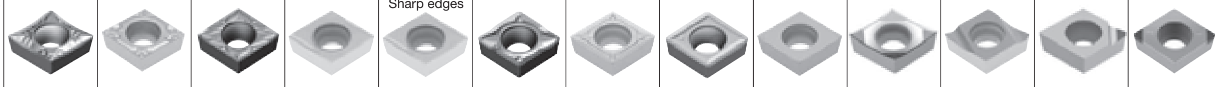




Right hand (R) shown

Cat. No.	Stock		Dimensions (mm)							Std. corner radius $r\varepsilon$	Applicable inserts	Parts		Torque (N·m)
	R	L	h	b	L_1	L_2	h_1	f	f_1			Clamping screw	Wrench	
JSCFCR/L1212H06			12	12	100	16	12	16	-	0.4	CC□□0602	CSTB-2.5	T-8F	1.2
JSCFCR/L1616H09			16	16	100	16	16	20	-	0.8	CC□□09T3	CSTB-4SD	T-8F	1.2

Basic Selection Chipbreakers CC□□0602 CC□□09T3

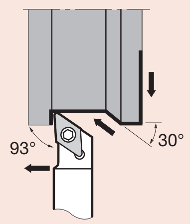
Operation	Precision finishing	Precision finishing	Finishing	Finishing to medium cutting	Finishing to medium cutting	Finishing to light cutting	Finishing to medium cutting	Cast Iron	Cast Iron	Aluminium alloy	Aluminium alloy	Aluminium alloy	Hard materials
Chipbreaker	JS	01	PSF	J10	FR/L-J10	PSS	PS	CM	–	AL	Angular	With chipbreaker	T-CBN
Page	2-99	2-96	2-96	2-100	2-99	2-97	2-97	2-97	2-101	2-98	2-100	3-22	3-12
Appearance / Toolholders					Sharp edges								
JTC*/JSC**06	CCGT0602**	CCGT0602**	CCMT0602**	CCGT0602**	CCGT0602**	CCMT0602**	CCMT0602**	CCMT0602**	CCMW0602**	CCGT0602**	CCGT0602**	CCMT0602**	2QP-CCGW0602**
JTC*/JSC**09	CCGT09T3**	CCGT09T3**	CCMT09T3**	CCGT09T3**	CCGT09T3**	CCMT09T3**	CCMT09T3**	CCMT09T3**	CCMW09T3**	CCGT09T3**	CCGT09T3**	CCMT09T3**	2QP-CCGW09T3**

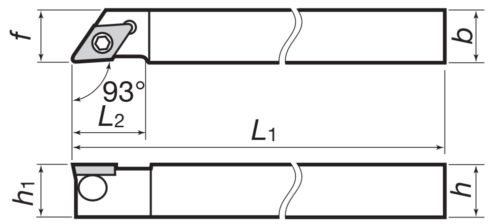
● : Stocked items.

JTDJ2CR/L

Without offset / Positive rake
Back clamping system

Turning / profiling





Right hand (R) shown

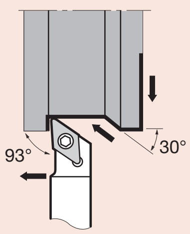
Cat. No.	Stock R	Stock L	Dimensions (mm) h	b	L_1	L_2	h_1	f	Standard corner radius r_ε	Applicable inserts	Parts Clamp	Clamping screw	Wrench
JTDJ2CR/L0810K07	●	●	8	10	125	14	8	10	0.4	DC□□0702	JCP-2	JDS-3525	P-2F
JTDJ2CR/L1010K07	●	●	10	10	125	14	10	10	0.4				
JTDJ2CR/L1212M11	●	●	12	12	150	18	12	12	0.8	DC□□11T3	JCP-3	JDS-5040	P-2.5F
JTDJ2CR/L1616M11	●	●	16	16	150	18	16	16	0.8				

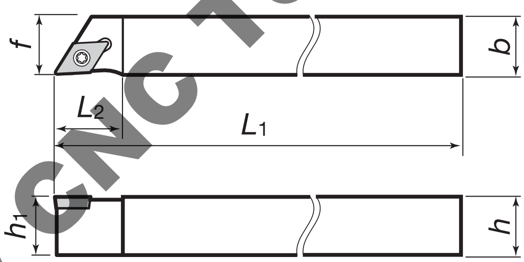
J-SERIES J-type / External Turning

JSDJ2CR/L

Without offset / Positive rake
Screw-on system

Profiling





Right hand (R) shown

Cat. No.	Stock R	Stock L	Dimensions (mm) h	b	L_1	L_2	h_1	f	Standard corner radius r_ε	Applicable inserts	Parts Clamping screw	Wrench	Torque (N·m)
JSDJ2CR/L1010K07	●	●	10	10	125	14	10	10	0.4	DC□□0702	CSTB-2.5	T-8F	1.2
JSDJ2CR/L1212K07	●	●	12	12	125	14	12	12	0.4				

Basic Selection Chipbreaker DC□□

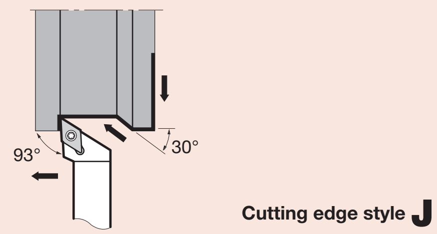
Relating pages
Cutting conditions (8–3)
Parts (14–1~)

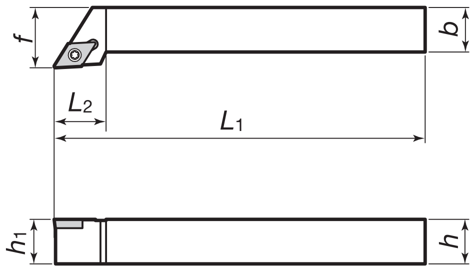
J-SERIES J-type / External Turning

JSDJCR/L

Positive rake
Screw-on system

Profiling





Right hand (R) shown

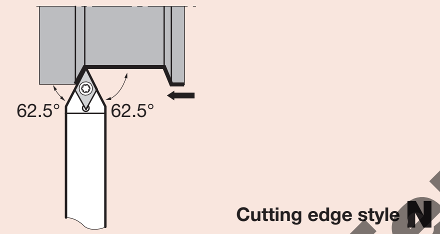
Cat. No.	Stock R	Stock L	Dimensions (mm) h	b	L_1	L_2	h_1	f	Standard corner radius $r\varepsilon$	Applicable inserts	Parts Clamping screw	Parts Wrench	Torque (N·m)
JSDJCR/L0808H07	●	●	8	8	100	14	8	10	0.4	DC□□0702	CSTB-2.5	T-8F	1.2
JSDJCR/L1212H07	●	●	12	12	100	14	12	16	0.4				
JSDJCR/L1010H11	●	●	10	10	100	18	10	12	0.8	DC□□11T3	CSTB-2.5	T-8F	1.2
JSDJCR/L1212H11	●	●	12	12	100	18	12	16	0.8				
JSDJCR/L1616H11	●	●	16	16	100	18	16	20	0.8		CSTB-4SD		

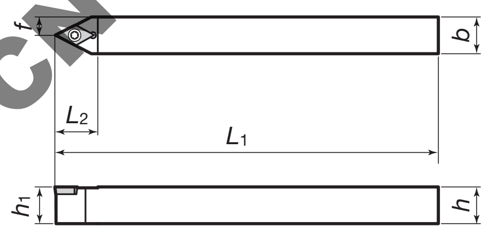
J-SERIES J-type / External Turning

JSDNCN

Positive rake
Screw-on system

Profiling





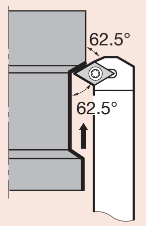
Cat. No.	Stock	Dimensions (mm) h	b	L_1	L_2	h_1	f	Standard corner radius $r\varepsilon$	Applicable inserts	Parts Clamping screw	Parts Wrench	Torque (N·m)
JSDNCN0808H07	●	8	8	100	14	8	4	0.4	DC□□0702	CSTB-2.5	T-8F	1.2
JSDNCN1010K07	●	10	10	125	14	10	5	0.4				
JSDNCN1212K07	●	12	12	125	14	12	6	0.4				
JSDNCN1212H11	●	12	12	100	21	12	6	0.8	DC□□11T3	CSTB-4SD	T-8F	1.2
JSDNCN1616H11	●	16	16	100	21	16	8	0.8				

Relating pages
Cutting conditions (8–3)
Parts (14–1~)

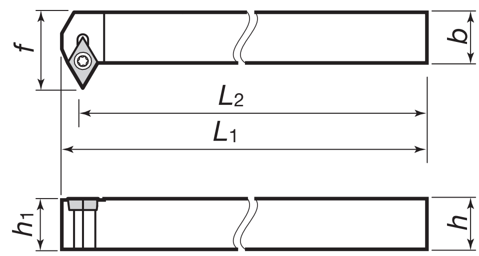
JSDN3CR/L

Positive rake
Screw-on system

Profiling



Cutting edge style **N3**



Right hand (R) shown

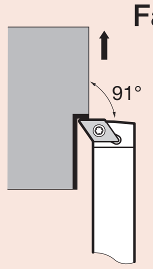
Cat. No.	Stock R	Stock L	Dimensions (mm) h	b	L_1	L_2	h_1	f	Standard corner radius $r\varepsilon$	Applicable inserts	Parts: Clamping screw	Parts: Wrench	Torque (N·m)
JSDN3CR/L1212H07	●	●	12	12	105	100	12	18	0.4	DC□□0702	CSTB-2.5	T-8F	1.2
JSDN3CR/L1616H11	●	●	16	16	107	100	16	25	0.8	DC□□11T3	CSTB-4SD	T-8F	1.2

J-SERIES J-type / External Turning

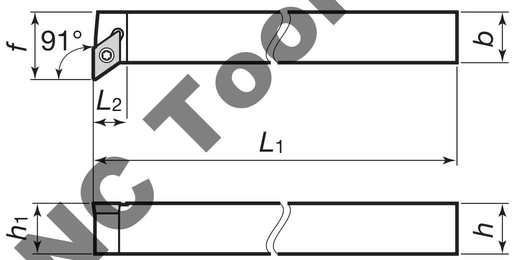
JSDFCR/L

Positive rake
Screw-on system

Facing



Cutting edge style **F**



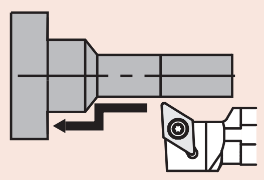
Right hand (R) shown

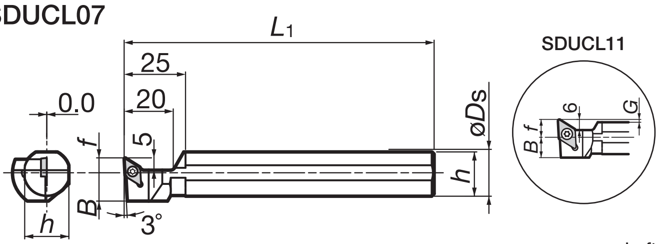
Cat. No.	Stock R	Stock L	Dimensions (mm) h	b	L_1	L_2	h_1	f	Standard corner radius $r\varepsilon$	Applicable inserts	Parts: Clamping screw	Parts: Wrench	Torque (N·m)
JSDFCR/L1212H07	●	●	12	12	100	8	12	16	0.4	DC□□0702	CSTB-2.5	T-8F	1.2
JSDFCR/L1616H11	●	●	16	16	100	10.5	16	22	0.8	DC□□11T3	CSTB-4SD	T-8F	1.2

JS-SDUCL

Positive rake
Screw-on system

Profiling



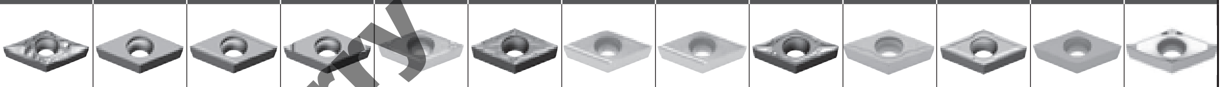


Left hand (L) shown.

Cat. No.	Stock R	Stock L	Dimensions (mm) øDs	f	L_1	L_2	h	B	G	Std. Corner $r\varepsilon$	Applicable inserts	Clamping screw	Wrench	Torque (N·m)
JS19K-SDUCL07		●	19.05	6	125	-	18	11.5	-	0.4	DC□□0702□□	CSTB-2.5	T-8F	1.2
JS20K-SDUCL07		●	20				19							
JS22K-SDUCL07		●	22				21							
JS19K-SDUCL11		●	19.05	10	125	-	18	11.5	1.525	0.8	DC□□11T3□□	CSTB-4SD	T-8F	1.2
JS20K-SDUCL11		●	20				19		1.0					
JS22K-SDUCL11		●	22	11			21		1.0					
JS25K-SDUCL11		●	25.4	12			24	12.7	0.7					

Basic Selection Chipbreakers DC□□0702 DC□□11T3

Operation	Precision finishing	Precision finishing	Precision finishing	Precision finishing	Precision finishing	Finishing	Finishing to medium cutting	Finishing to medium cutting	Finishing to light cutting	Finishing to medium cutting	Cast Iron	Cast Iron	Aluminium alloy
Chipbreaker	JS	JRP	JPP	JSP	01	PSF	J10	FR/L-J10	PSS	PS	CM	–	AL
Page	2-108	2-107	2-108	2-108	2-105	2-105	2-109	2-109	2-106	2-106	2-106	2-110	2-106
Appearance / Toolholders								Sharp edges					
JTD*/JSD**07	DCGT0702**	DCET0702**	DCET0702**	DCET0702**	DCGT0702**	DCMT0702**	DCGT0702**	DCGT0702**	DCMT0702**	DCMT0702**	DCMT0702**	DCMW0702**	DCGT0702**
JTD**11	DCGT11T3**	DCET11T3**	DCET11T3**	DCET11T3**	DCGT11T3**	DCMT11T3**	DCGT11T3**	DCGT11T3**	DCMT11T3**	DCMT11T3**	DCMT11T3**	DCMW11T3**	DCGT11T3**

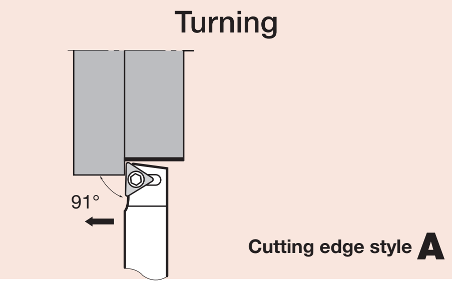


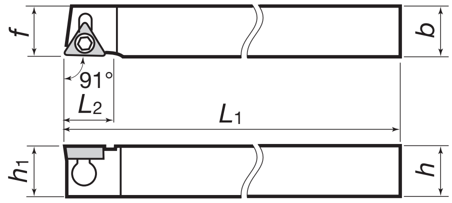
Operation	Aluminium alloy	Aluminium alloy	Hard materials
Chipbreaker	Angular	With chipbreaker	T-CBN
Page	2-107	3-22	3-12
Appearance / Toolholders			
JTD*/JSD**07	DCGT0702**	DCMT0702**	2QP-DCGW0702**
JTD**11	DCGT11T3**	DCMT11T3**	2QP-DCGW11T3**

J-SERIES JT-type / External Turning

JTTACR/L

Without offset / Positive rake
Back clamping system





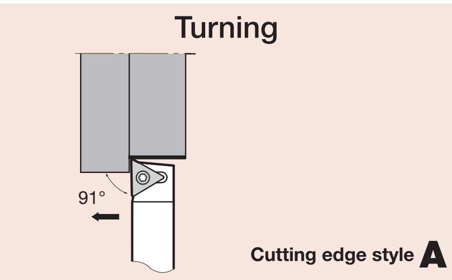
Right hand (R) shown

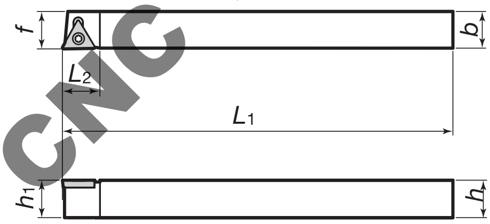
Cat. No.	Stock		Dimensions (mm)						Standard corner radius	Applicable inserts	Parts		
	R	L	h	b	L1	L2	h1	f	rε		Clamp	Clamping screw	Wrench
JTTACR/L0810K08	●	●	8	10	125	10	8	10	0.2	TC□□0802	JCP-1	JDS-3525	P-2F
JTTACR/L1010K08	●	●	10	10	125	10	10	10	0.2				
JTTACR/L1212M11	●	●	12	12	150	12	12	12	0.4	TC□□1102	JCP-2	JDS-3525	P-2F
JTTACR/L1616M11	●	●	16	16	150	12	16	16	0.4				

J-SERIES J-type / External Turning

JSTACR/L

Without offset / Positive rake
Screw-on system

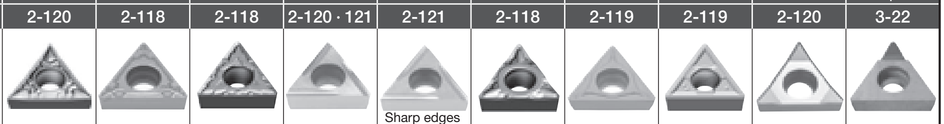




Right hand (R) shown

Cat. No.	Stock		Dimensions (mm)						Standard corner radius	Applicable inserts	Parts		Torque
	R	L	h	b	L1	L2	h1	f	rε		Clamping screw	Wrench	(N·m)
JSTACR/L0808K08	●	●	8	8	125	10	8	8	0.2	TC□□0802	CSTB-2L	T-6F	0.6
JSTACR/L1010K08	●	●	10	10	125	10	10	10	0.2				
JSTACR/L1212K11	●	●	12	12	125	12	12	12	0.4	TC□□1102	CSTB-2.5	T-8F	1.2
JSTACR/L1616H11	●	●	16	16	100	12	16	16	0.4				

Basic Selection Chipbreakers TC□□0802 TC□□1102

Operation	Precision finishing	Precision finishing	Finishing	Finishing to medium cutting	Finishing to medium cutting	Finishing to light cutting	Finishing to medium cutting	Cast Iron	Aluminium alloy	Aluminium alloy
Chipbreaker	JS	01	PSF	J08/J10	FR/L-J10	PSS	PS	CM	AL	With chipbreaker
Page	2-120	2-118	2-118	2-120 · 121	2-121	2-118	2-119	2-119	2-120	3-22
Appearance / Toolholders					Sharp edges					
JTT*/JST**08	–	–	–	TCGT0802**	TCGT0802**	–	–	–	–	TCMT0802**
JTT**/JST**11	TCGT1102**	TCGT1102**	TCGT1102**	TCGT1102**	TCGT1102**	TCMT1102**	TCMT1102**	TCMT1102**	TCGT1102**	TCMT1102**

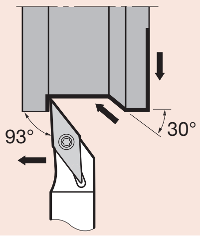
● : Stocked items.

Relating pages
Cutting conditions (8–3)
Parts (14–1~)

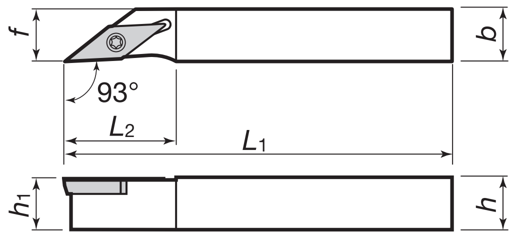
JSVJ2BR/L

Without offset / Positive rake
Screw-on system

Profiling



Cutting edge style **J2**



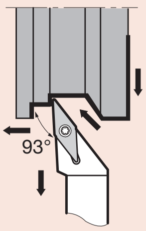
Right hand (R) shown

Cat. No.	Stock R	Stock L	Dimensions (mm) h	b	L_1	L_2	h_1	f	Standard corner radius $r\varepsilon$	Applicable inserts	Parts Clamping screw	Parts Wrench	Torque (N·m)
JSVJ2BR/L1010K11	●	●	10	10	125	21	10	10	0.2	VB□□1103	CSTB-2.5	T-8F	1.2
JSVJ2BR/L1212K11	●	●	12	12	125	21	12	12	0.2				
JSVJ2BR/L1616K11	●	●	16	16	125	21	16	16	0.2				

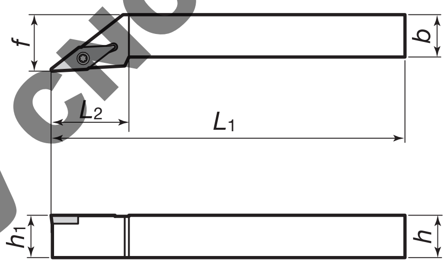
JSVJBR/L

Positive rake
Screw-on system

Profiling



Cutting edge style **J**



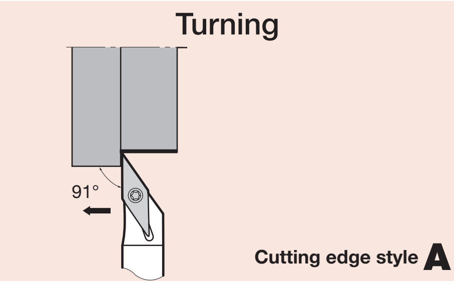
Right hand (R) shown

Cat. No.	Stock R	Stock L	Dimensions (mm) h	b	L_1	L_2	h_1	f	Standard corner radius $r\varepsilon$	Applicable inserts	Parts Clamping screw	Parts Wrench	Torque (N·m)
JSVJBR/L1010H11	●	●	10	10	100	20	10	12	0.4	VB□□1103	CSTB-2.5	T-8F	1.2
JSVJBR/L1212H11	●	●	12	12	100	22	12	16	0.4				
JSVJBR/L1616H11	●	●	16	16	100	22	16	20	0.4				

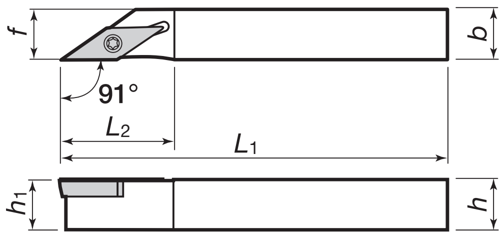
Related pages
Cutting conditions (8–3)
Parts (14–1~)

JSVABR/L

Without offset / Positive rake
Screw-on system



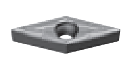
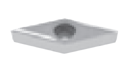
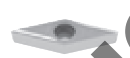
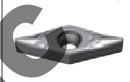
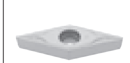
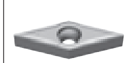
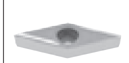
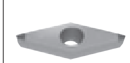
Without offset



Right hand (R) shown

Cat. No.	Stock R	Stock L	Dimensions (mm) h	b	L_1	L_2	h_1	f	Standard corner radius $r\varepsilon$	Applicable inserts	Parts Clamping screw	Parts Wrench	Torque (N·m)
JSVABR/L1010K11	●	●	10	10	125	21	10	10	0.2	VB□□1103	CSTB-2.5	T-8F	1.2
JSVABR/L1212K11	●	●	12	12	125	21	12	12	0.2				
JSVABR/L1616K11	●	●	16	16	125	21	16	16	0.2				

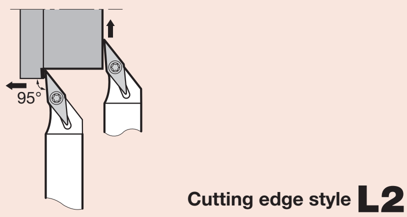
Basic Selection Chipbreakers VB□□1103

Operation	Precision finishing	Finishing	Finishing to medium cutting	Finishing to medium cutting	Finishing to light cutting	Finishing to medium cutting	Cast Iron	Aluminium alloy	Hard materials
Chipbreaker	JS	PSF	J10	FR/L-J10	PSS	PS	CM	J10	T-CBN
Page	2-134	2-133	2-134	2-134	2-133	2-133	2-133	2-134	3-13
Appearance / Toolholders			 Sharp edges						
JSV**11	VBGT1103**	VBMT1103**	VBGT1103**	VBGT1103**	VBMT1103**	VBMT1103**	VBGT1103**	VBGT1103**	2QP-VBGW1103**

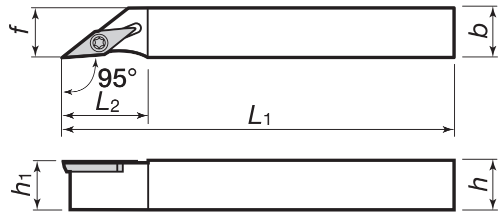
JSVL2PR/L

Without offset / Positive rake
Screw-on system

Turning / facing



Cutting edge style **L2**



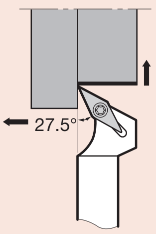
Right hand (R) shown

Cat. No.	Stock		Dimensions (mm)						Standard corner radius	Applicable inserts	Parts		Torque
	R	L	h	b	L_1	L_2	h_1	f	r_ε		Clamping screw	Wrench	(N·m)
JSVL2PR/L1010K08	●	●	10	10	125	16	10	10	0.2	VP□□0802	CSTB-2L	T-6F	0.6
JSVL2PR/L1212K08	●	●	12	12	125	16	12	12	0.2				
JSVL2PR/L1616K08	●	●	16	16	125	16	16	16	0.2				

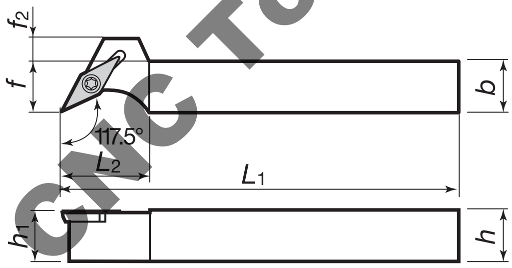
JSVP2PR/L

Positive rake
Screw-on system

Profiling



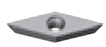
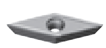
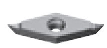
Cutting edge style **P2**



Right hand (R) shown

Cat. No.	Stock		Dimensions (mm)							Standard corner radius	Applicable inserts	Parts		Torque
	R	L	h	b	L_1	L_2	h_1	f	f_2	r_ε		Clamping screw	Wrench	(N·m)
JSVP2PR/L1010K08	●	●	10	10	125	16	10	10	4	0.2	VP□□0802	CSTB-2L	T-6F	0.6
JSVP2PR/L1212K08	●	●	12	12	125	16	12	12	2	0.2				
JSVP2PR/L1616K08	●	●	16	16	125	16	16	16	-	0.2				
JSVP2PR/L1010K11	●	●	10	10	125	20	10	10	8	0.2	VP□□1103	CSTB-2.5	T-8F	1.2
JSVP2PR/L1212K11	●	●	12	12	125	20	12	12	6	0.2				
JSVP2PR/L1616K11	●	●	16	16	125	20	16	16	4	0.2				

Basic Selection Chipbreakers VP□□

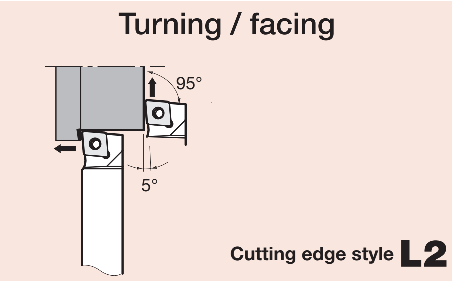
Operation	Precision finishing	Precision finishing	Precision finishing
Chipbreaker	JRP	JPP	JSP
Page	2-137	2-137	2-138
Appearance / Toolholders			
JSVP**08	VPET0802**	VPET0802**	VPET0802**
JSVP**11	VPET1103**	VPET1103**	VPET1103**

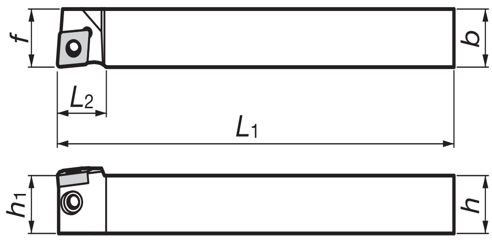
● : Stocked items.

Relating pages
Cutting conditions (8–3)
Parts (14–1~)

JTCL2NR/L

Without offset / Negative rake
Side clamping system





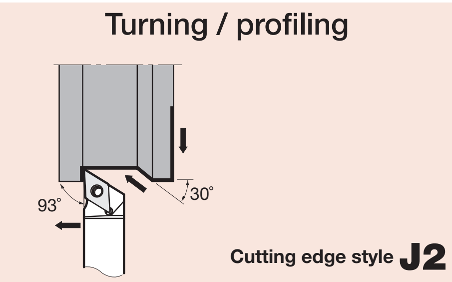
Right hand (R) shown

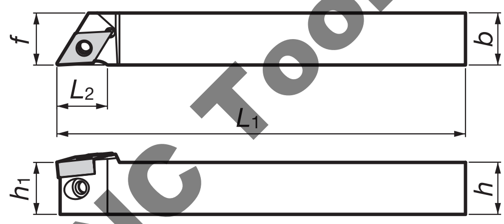
Cat. No.	Stock R	Stock L	h	b	L_1	L_2	h_1	f	Standard corner radius $r\varepsilon$	Applicable inserts	Parts: Clamp	Parts: Clamping screw	Parts: Wrench
JTCL2NR/L1216K09			12	16	125	15.6	12	16	0.4	CN□□0903 (2-42 ~)	JCP-3N	JDS-5040	P-2.5F
JTCL2NR/L1616K09			16	16	125	15.6	16	16	0.4				

J-SERIES JT-type / External Turning

JTDJ2NR/L

Without offset / Negative rake
Side clamping system





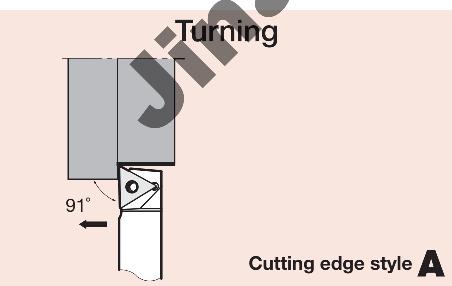
Right hand (R) shown

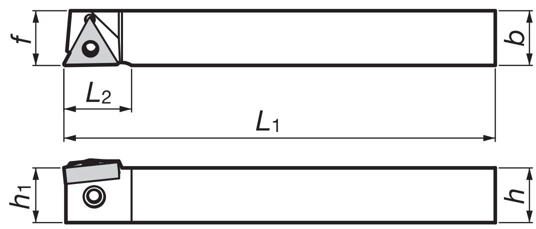
Cat. No.	Stock R	Stock L	h	b	L_1	L_2	h_1	f	Standard corner radius $r\varepsilon$	Applicable inserts	Parts: Clamp	Parts: Clamping screw	Parts: Wrench
JTDJ2NR/L1216K11			12	16	125	15.6	12	16	0.4	DN□□1104 (2-52 ~)	JCP-3N	JDS-5040	P-2.5F
JTDJ2NR/L1616K11			16	16	125	15.6	16	16	0.4				

J-SERIES JT-type / External Turning

JTTANR/L

Without offset / Negative rake
Side clamping system





Right hand (R) shown

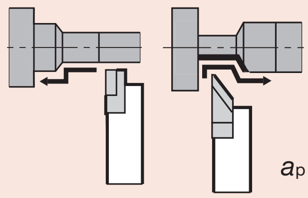
Cat. No.	Stock R	Stock L	h	b	L_1	L_2	h_1	f	Standard corner radius $r\varepsilon$	Applicable inserts	Parts: Clamp	Parts: Clamping screw	Parts: Wrench
JTTANR/L1216K16	●	●	12	16	125	19.8	12	16	0.4	TN□□1604 (2-70 ~)	JCP-3N	JDS-5040	P-2.5F
JTTANR/L1616K16	●	●	16	16	125	19.8	16	16	0.4				

● : Stocked items.

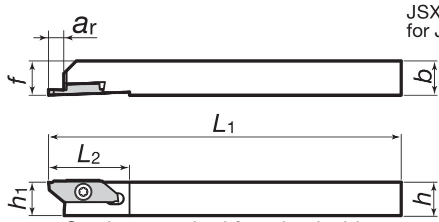
JSXGR/L

Without offset
Screw-on system

Front and reverse turning

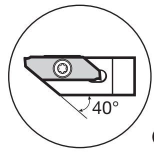


Front turning   Reverse turning



Can be wrenched from back side with double socket torx screw.

JSXGR/L-type toolholders are used for JXG-type grooving inserts.

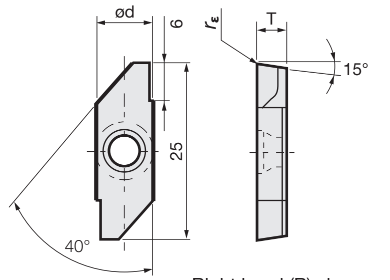


C-type

Right hand (R) shown.

Cat. No.	Stock R	Stock L	h	b	L_1	L_2	a_r	h_1	f	Applicable inserts	Clamping screw	Wrench	Wrench
JSXGR/L1010K8-C	●	●	10	10			6.7	10	10				
JSXGR/L1212K8-C	●	●	12	12				12	12	JXFR/L8□□□			
JSXGR/L1616K8	●	●	16	16	125	29		16	16		CSTB-4SD	T-8F	(T-8L)
JSXGR/L2020K8	●	●	20	20			6.5	20	20	JXRR/L8□□□			
JSXGR/L2525K8	●	●	25	25				25	25				∗Optional

Applicable inserts

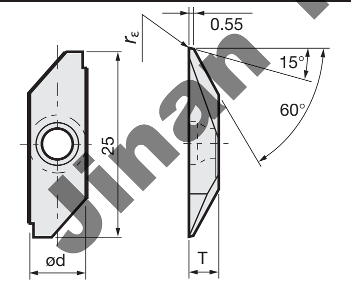


Right hand (R) shown.

JXF-type inserts (with sharp edges) for front turning

Cat. No.	ød	T	rε	Max. depth of cut	Coated J740 R	Coated J740 L	Cermet NS530 R	Cermet NS530 L	Cermet R	Cermet L	Uncoated TH10 R	Uncoated TH10 L
JXFR/L8000F	8	3.97	0.03	5.5	●		●				●	
JXFR/L8010F			0.1		●		●				●	

Applicable inserts



Right hand (R) shown.

JXR-type inserts (with sharp edges) for reverse turning

Cat. No.	ød	T	rε	Max. depth of cut	Coated J740 R	Coated J740 L	Cermet NS530 R	Cermet NS530 L	Cermet R	Cermet L	Uncoated TH10 R	Uncoated TH10 L
JXRR/L8000F	8	3.97	0.03	5.5	●		●				●	
JXRR/L8010F			0.1		●		●				●	

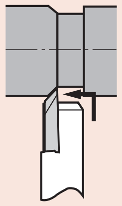
● : Stocked items.

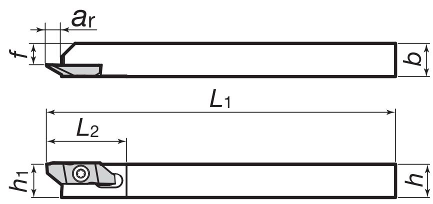
Related pages
Cutting conditions (8–3)
Parts (14–1–)

JSXBR/L

Without offset
Screw-on system

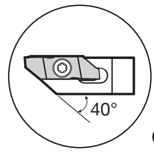
Back turning with large depth of cut





Can be wrenched from back side
with double socket torx screw.

JSXBR/L-type toolholders are also used
for JXT-type threading inserts.

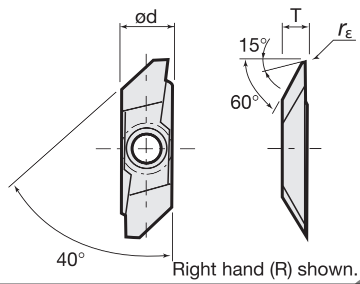


C-type

Right hand (R) shown.

Cat. No.	Stock R	Stock L	h	b	L_1	L_2	a_r	h_1	f	Applicable inserts	Clamping screw	Wrench	Wrench
JSXBR/L1010K8-C	●	●	10	10	125	29	6.7	10	5.7	JXBR/L8□□□	CSTB-4SD	T-8F	(T-8L)
JSXBR/L1212K8-C	●	●	12	12				12	7.7				
JSXBR/L1616K8	●	●	16	16			6.4	16	11.7				
JSXBR/L2020K8	●	●	20	20				20	15.7				
JSXBR/L2525K8	●	●	25	25				25	20.7				∗Optional

Applicable inserts



Right hand (R) shown.

JXB-type inserts (with sharp edges)

Cat. No.	ød	T	rε	Max. depth of cut	Coated J740 R	Coated J740 L	Cermet NS530 R	Cermet NS530 L	Cermet R	Cermet L	Uncoated TH10 R	Uncoated TH10 L
JXBR/L8000F	8	3.97	0.03	5.5	●	●	●				●	●
JXBR/L8005F			0.05		●	●					●	●
JXBR/L8010F			0.1		●	●	●				●	●
JXBR/L8015F			0.15		●	●					●	●

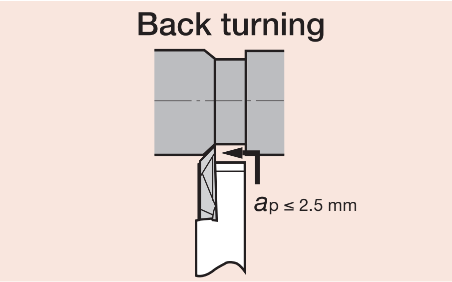
JXB-type inserts (with honed edges)

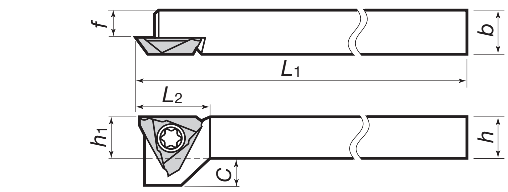
Cat. No.	ød	T	rε	Max. depth of cut	Coated J740 R	Coated J740 L	Cermet NS530 R	Cermet NS530 L	Cermet R	Cermet L	Uncoated TH10 R	Uncoated TH10 L
JXBR/L8005	8	3.97	0.05	5.5	●	●						
JXBR/L8010			0.1		●	●						
JXBR/L8015			0.15		●	●						

● : Stocked items.

JSTBR/L

Without offset
Screw-on system





Can be wrenched from back side
with double socket torx screw.

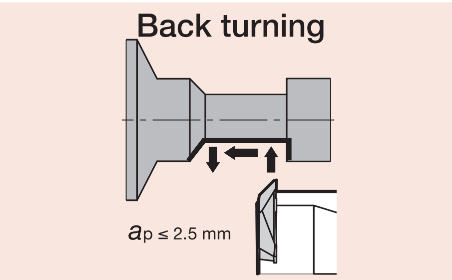
Right hand (R) shown.

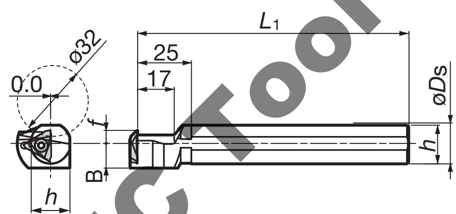
Cat. No.	Stock R	Stock L	Dimensions (mm) h	b	L_1	L_2	h_1	f	C	Applicable inserts	Clamping screw	Wrench	
JSTBR/L1010K3	●	●	10	10	125	15	10	6	5	JTBR/L3□□□	CSTB-4SD	T-8F	(T-8L) ∗Optional
JSTBR/L1212K3	●	●	12	12	125	15	12	8	3	JTBR/L3□□□	CSTB-4SD	T-8F	(T-8L) ∗Optional
JSTBR/L1616K3	●	●	16	16	125	15	16	12	-	JTBR/L3□□□	CSTB-4SD	T-8F	(T-8L) ∗Optional

J-SERIES J-type / External Turning

JS-TBL3

Positive rake
Screw-on system

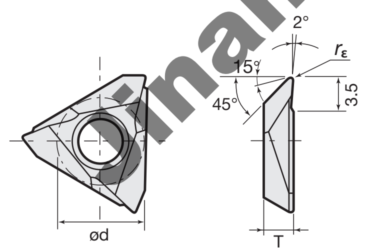




Cat. No.	Stock	Dimensions (mm) øDs	f	L_1	L_2	h	B	Applicable inserts	Clamping screw	Wrench
JS19K-TBL3	●	19.05	6	125	-	18	11.5	JTBR3□□□	CSTB-4S	T-15F
JS20K-TBL3	●	20	6	125	-	19	11.5	JTBR3□□□	CSTB-4S	T-15F
JS22K-TBL3	●	22	6	125	-	21	11.5	JTBR3□□□	CSTB-4S	T-15F
JS25K-TBL3	●	25.4	10	125	-	24	12.7	JTBR3□□□	CSTB-4S	T-15F

Notes: Left hand holder use right hand insert.

Applicable inserts



Right hand (R) shown.

JTB-type inserts (with sharp edges)

Cat. No.	Dimensions (mm) ød	T	rε	Max. depth of cut	Stock Coated J740 R	L	Coated cermet J530 R	L	Coated cermet R	L	Cermet NS530 R	L	Cermet R	L	Uncoated TH10 R	L
JTBR/L3000F	9.438	3.18	0.03	2.5	●	●					●	●			●	●
JTBR/L3005F	9.438	3.18	0.05	2.5	●	●					●	●			●	●
JTBR/L3010F	9.438	3.18	0.1	2.5	●	●					●	●			●	●
JTBR/L3015F	9.438	3.18	0.15	2.5	●											

JTB-type inserts (with honed edges)

Cat. No.	Dimensions (mm) ød	T	rε	Max. depth of cut	Stock Coated J740 R	L	Coated cermet J530 R	L	Coated cermet R	L	Cermet NS530 R	L	Cermet R	L	Uncoated TH10 R	L
JTBR/L3005	9.438	3.18	0.05	2.5	●	●	●	●								
JTBR/L3010	9.438	3.18	0.1	2.5	●	●	●	●								
JTBR/L3015	9.438	3.18	0.15	2.5												

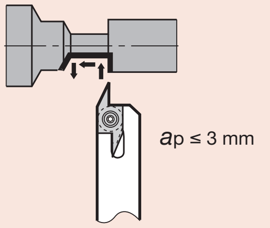
● : Stocked items.

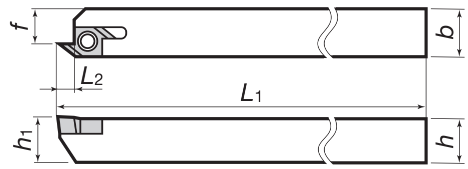
Relating pages
Cutting conditions (8–3)
Parts (14–1~)

JSEGR/L

Without offset
Screw-on system

Back turning

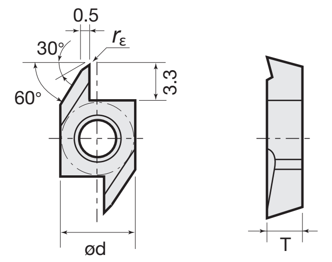




Right hand (R) shown.

Cat. No.	Stock R	Stock L	h	b	L_1	L_2	h_1	f	Applicable inserts	Clamping screw	Wrenches	Wrenches
JSEGR/L1010K10	●	●	10	10	125	3.3	10	7.5	J10ER/L□□□□□	CSTB-2.5	T-8F	(T-8L) ∗Optional
JSEGR/L1212K10	●	●	12	12	125	3.3	12	9.5	J10ER/L□□□□□	CSTB-2.5	T-8F	(T-8L) ∗Optional
JSEGR/L1616K10	●	●	16	16	125	3.3	16	13.5	J10ER/L□□□□□	CSTB-2.5	T-8F	(T-8L) ∗Optional

Applicable inserts



Right hand (R) shown.

J10E-type inserts (with sharp edges)

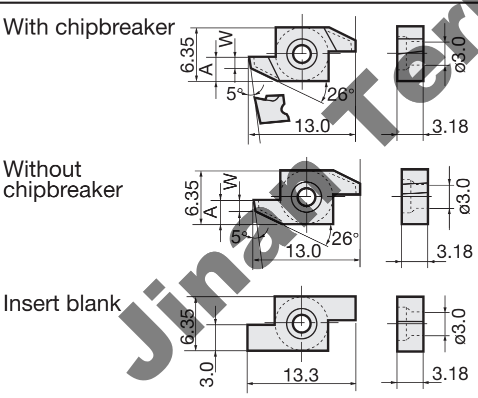
Cat. No.	ød	T	rε	Max. depth of cut	Coated J740 R	Coated J740 L	Coated cermet J530 R	Coated cermet J530 L	Coated cermet R	Coated cermet L	Cermet NS530 R	Cermet NS530 L	Cermet R	Cermet L	Uncoated TH10 R	Uncoated TH10 L
J10ER/L005BF	6.35	3.18	0.05	3	●	●					●	●			●	●
J10ER/L010BF	6.35	3.18	0.1	3	●	●					●	●			●	●
J10ER/L015BF	6.35	3.18	0.15	3												

J10E-type inserts (with honed edges)

Cat. No.	ød	T	rε	Max. depth of cut	Coated J740 R	Coated J740 L	Coated cermet J530 R	Coated cermet J530 L	Coated cermet R	Coated cermet L	Cermet NS530 R	Cermet NS530 L	Cermet R	Cermet L	Uncoated TH10 R	Uncoated TH10 L
J10ER/L005B	6.35	3.18	0.05	3	●	●	●	●								
J10ER/L010B	6.35	3.18	0.1	3	●	●	●	●								
J10ER/L015B	6.35	3.18	0.15	3												

Notes: Right hand holder use right hand insert and left hand holder use left hand insert.

Applicable inserts

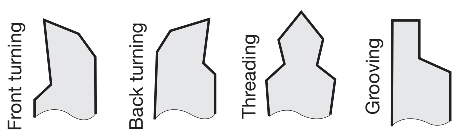


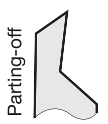
Right hand (R) shown.

Type	Cat. No.	W (mm)	A (mm)	Cermet NS530 R	Cermet NS530 L	Cermet R	Cermet L	Uncoated TH10 R	Uncoated TH10 L
With chipbreaker	10ER/L100BC	1	2.5	●					
With chipbreaker	10ER/L150BC	1.5	3	●					
Without chipbreaker	10ER/L100B	1	2.5					●	●
Without chipbreaker	10ER/L150B	1.5	3					●	●
Insert blank	10ER/L300	–	–	●				●	●

Notes: Right hand holder (SEGR~) use right hand insert (10ER~) and left hand holder (SEGL~) use left hand insert (10EL~).

Formed examples of insert blanks





Notes:
- Front relief angle, side relief angle, edge width can be ground depending on the application.
- Insert blanks can be formed to a profiling tool which has a width up to 3mm.

Standard cutting conditions

Operations	Work materials		Carbon steels	Stainless steels	Brass
Lateral feed (external turning)	Cutting speed (m/min)		~ 100	~ 50	~ 200
	Feed (mm/rev)	Roughing	~ 0.06	~ 0.03	~ 0.1
		Medium	~ 0.03	~ 0.025	~ 0.06
		Finishing	~ 0.02	~ 0.015	~ 0.04
Parting-off Grooving Forming	Cutting speed (m/min)		~ 80	~ 30	~ 150
	Feed (mm/rev)	Roughing	~ 0.02	~ 0.015	~ 0.05
		Medium	~ 0.015	~ 0.01	~ 0.03
		Finishing	~ 0.01	~ 0.008	~ 0.015

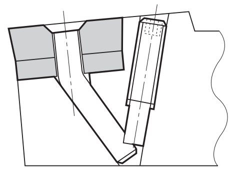
● : Stocked items.

Relating pages
Parts (14–1~)

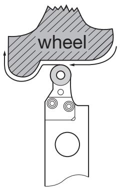
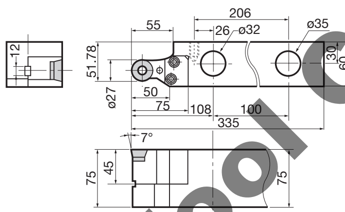
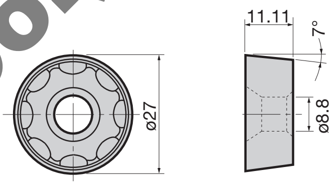
HRACR/L

Applicable inserts
RCMT2711M0-62

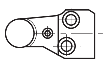
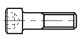
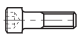
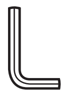
Positive rake

Appli	Type	Appearance	Clamping mechanism	Features
For railway wheel turning	H Draw-in pin type			• Easy maintenance cartridge type. • Specifically designed chipbreaker provides excellent impact resistance. • Excellent chip control and broad application area. • Can be used for general turning such as roll turning.

H-type for Turning Railway Wheels

Tooling styles	Cat. No.	Stock R	Stock L	Applicable inserts	Shape	Shape of inserts
Turning • Profiling HRACR/L 	HRACR/L7560×27			RCMT2711M0-62	 Right hand (R) shown.	

Parts of H-type

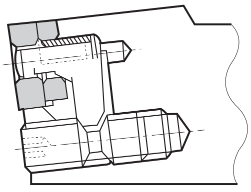
Cat. No.	Cartridge	Hex.socket head screw	Key	Shim	Hex. socket head screw	Wrench
						
HRACR/L7560×27	HD27R/L	M8×55 (For cartridge)	HK01	HSR27	M4×12 (For key)	P-6

Note: Shim is made of D30 grade.

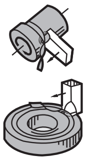
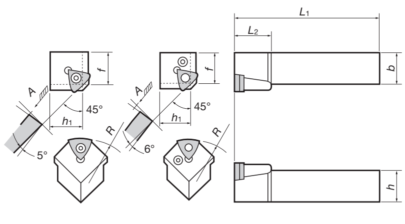
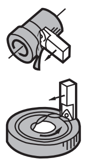
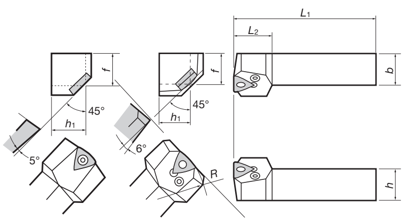
Relating pages Parts (14–1~)

PTVN/PTHN

Negative rake
Lever-lock system

Appli.	Type	Appearance	Clamping mechanism	Features
For Finishing	**MS** Screw-on type or Lever-lock type		 Lever-lock type shown	• A revolutionary turning tool with an inclined and curved cutting edge used for finishing. • Can produce a high quality surface finish at a feed rate ten times as great as the feed rate for conventional turning. • Hand of tool is neutral. • Can be used for turning difficult materials such as stainless steel.

MS-type for Finishing (Negative rake • Lever-lock type)

Tooling styles	Cat. No.	Stock	Dimensions (mm)							Applicable inserts	Shape
			h	b	L_1	L_2	h_1	f	R		
O.D. and I.D. Turning and Facing **PTVN**  Vertical type	**PTVN2525M50**		25	25	150	32	25	25	50	TNGA2204-50	 Viewed from A
	PTVN3232P50		32	32	170	36	32	32			
	PTVN2525M100		25	25	150	32	25	25	100	TNGA2204-100	
	PTVN3232P100		32	32	170	36	32	32			
	PTVN2525M300		25	25	150	32	25	25	300	TNGA2204-300	
	PTVN3232P300		32	32	170	36	32	32			
O.D. and I.D. Turning and Facing **PTHN**  Horizontal type	**PTHN2525M50**		25	25	150	32	25	25	50	TNGA2204-50	
	PTHN3232P50		32	32	170	36	32	32			
	PTHN2525M100		25	25	150	32	25	25	100	TNGA2204-100	
	PTHN3232P100		32	32	170	36	32	32			
	PTHN2525M300		25	25	150	32	25	25	300	TNGA2204-300	
	PTHN3232P300		32	32	170	36	32	32			

Relating pages
Parts (14–1~)

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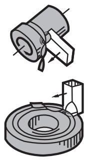
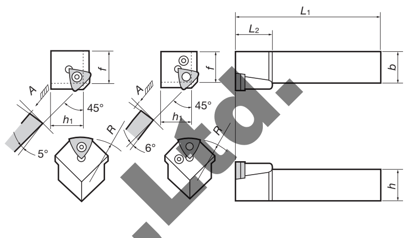
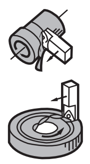
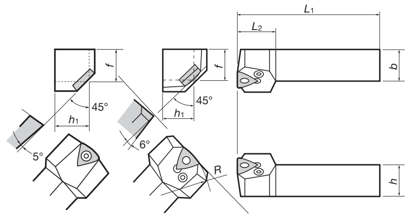
STVP/HP

Negative rake
Screw-on system

MS-type for Finishing (Positive rake • Screw-on type)

Tooling styles	Cat. No.	Stock	Dimensions (mm)							Applicable inserts	Shape
			h	*b*	*L*1	*L*2	*h*1	*f*	*R*		
O.D. and I.D. Turning and Facing **STVP**  Vertical type	STVP2525M50		25	25	150	32	25	25	50	TPGA2204-50	
	STVP3232P50		32	32	170	36	32	32			
	STVP2525M100		25	25	150	32	25	25	100	TPGA2204-100	
	STVP3232P100		32	32	170	36	32	32			
	STVP2525M300		25	25	150	32	25	25	300	TPGA2204-300	
	STVP3232P300		32	32	170	36	32	32			
O.D. and I.D. Turning and Facing **STHP**  Horizontal type	STHP2525M50		25	25	150	32	25	25	50	TPGA2204-50	
	STHP3232P50		32	32	170	36	32	32			
	STHP2525M100		25	25	150	32	25	25	100	TPGA2204-100	
	STHP3232P100		32	32	170	36	32	32			
	STHP2525M300		25	25	150	32	25	25	300	TPGA2204-300	
	STHP3232P300		32	32	170	36	32	32			

Parts of MS-type

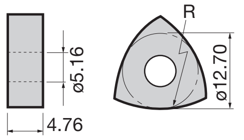
Parts of MS-type

Toolholders Cat. No.		Applicable inserts Cat. No.	Shape	Shim	Lever	Clamping screw	Spring	Wrench
PTVN PTHN	2525M50 3232P50	TNGA2204-50		LST42K	LCL4	LCS4K	LSP4	P-3
	2525M100 3232P100	TNGA2204-100						
	2525M300 3232P300	TNGA2204-300						
STVP STHP	2525M50 3232P50	TPGA2204-50		–	–	CSTA-5S	–	T-15F
	2525M100 3232P100	TPGA2204-100						
	2525M300 3232P300	TPGA2204-300						

Applicable inserts

• Negative inserts

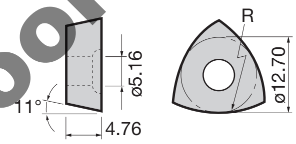
TNGA



Cat. No.	Cutting edge R (mm)	Stocked grades Cermet NS530	Stocked grades Uncoated TH10
TNGA2204-300	300	●	●
TNGA2204-100	100		●
TNGA2204-50	50		

• Positive inserts

TPGA



Cat. No.	Cutting edge R (mm)	Stocked grades Cermet NS530	Stocked grades Uncoated TH10
TPGA2204-300	300	●	●
TPGA2204-100	100	●	●
TPGA2204-50	50		●

Standard cutting conditions

Operation	Toolholder type	Cutting edge R	Finishing: Cutting speed Vc (m/min)	Finishing: Feed f(mm/rev)	Finishing: Depth of cut ap (mm)
External or Internal	STHP, PTVN or PTVN	50 100 300	~ 300 (180)	~ 1.5 ~ 2.5 ~ 3.0	~ 0.1
	STVP or PTVN	50 100 300	~ 300 (180)	~ 1.5 ~ 2.0 ~ 4.0	~ 0.1 ~ 0.05 ~ 0.05
Facing	STHP or PTHN	50 100 300	~ 300 (180)	~ 1.5 ~ 2.5 ~ 8.0	~ 0.3 ~ 0.2 ~ 0.1
	STVP or PTVN	50 100 300	~ 300 (180)	~ 1.5 ~ 2.5 ~ 8.0	~ 0.1 ~ 0.05 ~ 0.05

Note: Please use proper cutting conditions by shape of workpiece and others.
Note: Cutting speeds in parentheses are for cutting stainless steel.

● : Stocked items.

Relating pages Parts (14–1~)

MEMO