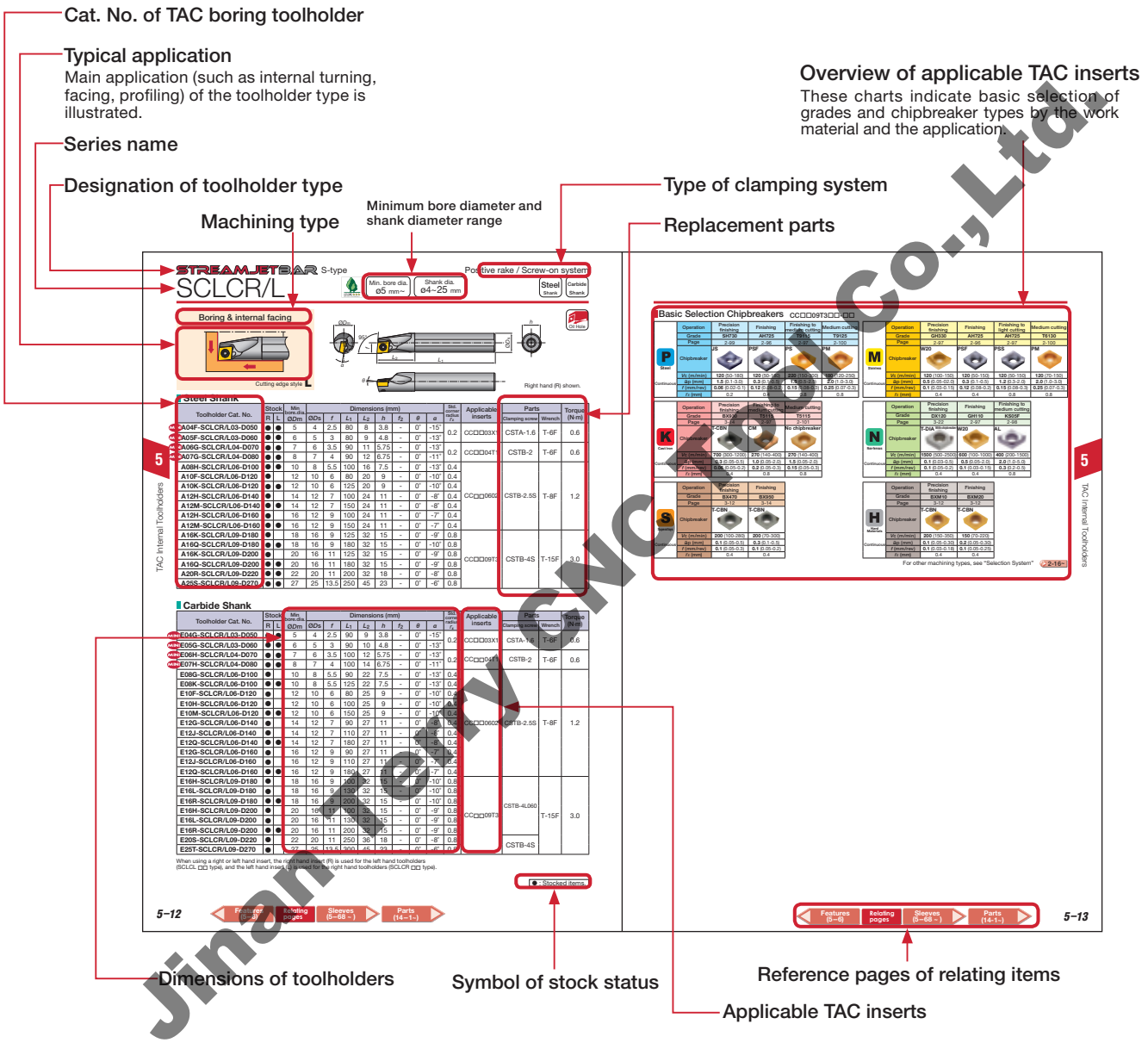
Chapter Composition of TAC Internal Toolholders

◆Products are arranged by the series as follows: Stream Jet Bars → General purpose TAC boring toolholders
◆In the same series, they are arranged by the insert shape to be used. In the same group, they are arranged by the cutting edge style.



■ Meaning of icons

● Min. bore diameter ● Shank diameter

Min. bore dia. ø5 mm

Shank dia. ø4~25 mm

● Shank material

Steel Shank | Carbide Shank | Tsuppari-Ichiban Shank

● Coolant through

Oli Hole

■ Ordering information

● When ordering TAC boring toolholders, please specify Cat. No. and quantity.

Example: **A16Q-STUPR1103-D180** 1 piece

- Standard packing quantity is 1 piece
- Inserts must be ordered separately.

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Guidance

■ Designation system for TAC internal toolholders ····· 5-2
■ Outline of new TAC boring toolholder, “DoMiniTurn” ····· 5-4
■ Outline of new TAC boring toolholder, “StreamJetBar” ····· 5-6
■ Clamping mechanism and features of TAC boring toolholders····· 5-9
■ “Stream Jet Bars” overview ····· 5-10
■ Machining method of internal spherical surface ····· 5-26

5 TAC Internal Toolholders

Products

■ **“Stream Jet Bar”**

SCLCR/L type	(CC□□ inserts)	Boring & internal facing	5–12
SCLPR/L type	(CP□□ inserts)	Boring & internal facing	5–14
SDQCR/L • SDUCR/L type	(DC□□ inserts	Boring & internal profiling	5–16
SDZCR/L type	(DC□□ inserts)	Internal retracting	5–17
SSKPR/L type	(SP□□ inserts)	Through boring	5–18
STFCR/L type	(TC□□ inserts)	Blind hole boring	5–19
STFPR/L type	(TP□□ inserts)	Blind hole boring	5–20
STUPR/L type	(TP□□ inserts)	Boring	5–21
SVQBR/L • SVUBR/L type	(VB□□ inserts)	Boring & internal profiling	5–22
SVZBR/L type	(VB□□ inserts)	Internal retracting	5–23
SVJBR/L type	(VB□□ inserts)	Internal sphere cutting	5–23
SVQCR/L • SVUCR/L type	(VC□□ inserts)	Boring & internal profiling	5–24
SVZCR/L type	(VC□□ inserts)	Internal retracting	5–25
SVJCR/L type	(VC□□ inserts)	Internal sphere cutting	5–25
SWUBR/L type	(WB□□ inserts)	Boring	5–27
SEZPR/L type	(EP□□ inserts)	Internal retracting	5–28
SEXPR/L type	(EP□□ inserts)	Boring & internal facing	5–28
SYQBR/L type	(YW□□ inserts)	Internal undercut & profiling	5–30
SYUBR/L type	(YW□□ inserts)	Boring & internal profiling	5–30

■ **“DoMiniTurn”**

SWLXR/L type	(WX□□ inserts)	Boring & internal facing	5–31
SDXXR/L type	(DX□□ inserts)	Boring & internal profiling	5–31
SDZXR/Ltype	(DX□□ inserts)	Internal retracting	5–32

■ **“Stream Jet Bar”**

PCLNR/L type	(CN□□ inserts)	Boring & internal facing	5–34
PDUNR/L type	(DN□□ inserts)	Internal profiling	5–35
PDZNR/L type	(DN□□ inserts)	Internal retracting	5–35
PSKNR/L type	(SN□□ inserts)	Through boring	5–36
PTFNR/L • PTUNR/L type	(TN□□ inserts)	Boring	5–37
PVUNR/L type	(VN□□ inserts)	Boring & internal profiling	5–38
PWLNR/L type	(WN□□ inserts)	Boring & facing	5–39

■ **“Turning A”**

ACLNR/L type	(CN□□ inserts)	Boring & internal facing	5–40
ADUNR/L type	(DN□□ inserts)	Boring & internal facing	5–41
ASKNR/L type	(SN□□ inserts)	Through boring	5–42
ATFNR/L type	(TN□□ inserts)	Blind hole boring	5–43
AVUNR/L type	(VN□□ inserts)	Boring & internal profiling	5–44
AWLNR/L type	(WN□□ inserts)	Boring & internal facing	5–45

■ **“TurnTec”**

TLANR/L type	(LNMX inserts)	Boring & internal facing	5–46

■ **General purpose**

TAC boring toolholders	(TP□□, TN□□ inserts)	Boring / blind hole boring	5–48
TAC boring toolholders	(TP□□, TN□□ inserts)	Boring	5–51
TAC boring toolholders	(WB□□ inserts)	Boring	5–54
TAC boring toolholders	(C□□□ inserts)	Boring / internal facing	5–55
TAC boring toolholders	(WN□□ inserts)	Boring / internal facing	5–58
TAC boring toolholders	(EP□□, SP□□ inserts)	Boring / internal facing	5–59
TAC boring toolholders	(SN□□ inserts)	Boring / through boring	5–59
TAC boring toolholders	(DC□□, DN□□ inserts)	Boring / internal profiling	5–62
TAC boring toolholders	(VB□□, VC□□ inserts)	Boring / internal profiling	5–65
TAC boring toolholders	(DC□□, DN□□ inserts)	Boring / internal retracting	5–67

■ **Sleeves** ····· 5–68

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Designation System for TAC Internal Toolholders

A	Double clamping		
P	Lever-lock	C	Clamp-on
M	Multi clamping	S	Screw-on

④ Clamping system

C	80° Rhombic
D	55° Rhombic
K	55° Parallelogram
R	Round
S	Square
T	Triangular
V	35° Rhombic
Y	25° Rhombic (Non ISO)
W	Trigon

⑤ Insert shape

A	12	M	-	④ S	⑤ T
①	②	③			

① Bar composition

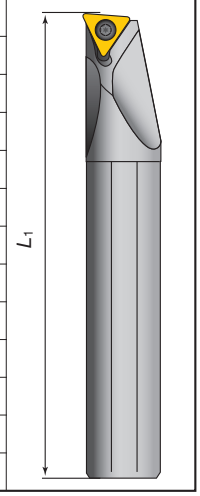
A	Steel shank with oil hole
E	Carbide shank with steel head & oil hole
C	Carbide shank with steel head
S	Steel shank
T	Steel shank reinforced with carbide plates ("Tsuppari-Ichiban")
JS	J series Steel shank

② Bar diameter

Bar diameter is shown in mm.

③ Toolholder length L_1 (mm)

F	80
G	90
H	100
J	110
K	125
L	130
M	150
P	170
Q	180
R	200
S	250
T	300
U	350



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⑥ Cutting edge style

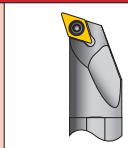
Symbol	Style	Offset							
A	90°	Without	G	91° / 91°	With	S	45°	With
						V	72.5°	Without
			J	93°	With	U	93°	With
B	75°	Without	K	75°	With	X *	100°	With
C	90°	Without	L	95° / 95°	With	Y	80°	With
D	45°	Without	N	63°	Without	Z	93°	Without
E	60°	Without	P *	62.5°	Without	Note *mark: Tungaloy standard No mark: ISO standard		
F	91°	With	Q *	45°	With			

⑦ Relief angle of insert

C	7°
B	5°
N	0°
P	11°
X	Special

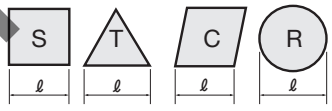
⑥	⑦		⑧	⑨		⑩	-	⑪
U	P	R	11	02		C	-	D140

⑧ Hand of tool

R	
L	

⑨ Insert size ℓ + (S)

For M, S, & C types conformed to ISO



"In ISO metric system, a two digit number indicates the edge length (R) of the insert to be used in mm.
If the insert thickness is different for the same edge length, add the thickness symbol (s) (two digit number).

In above example, TP"□□1102□□
ℓ s

⑩ Oil hole

Only "Tsuppari-Ichiban" holder

⑪ Min. bore diameter (mm)

Stream Jet Bar		Tsuppari-Ichiban	
D140	ø14.0	D14	ø14.0

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DOMTURN

Remarkable sharpness reduces cutting forces while the double sided insert increases the number of cutting edges !

Features

Uniquely designed double sided insert



Minimum bore diameter: ø12 mm
→ Economic advantages with twice the number of cutting edges

Advanced edge shape reduces the cutting forces
→ Similar design to positive type inserts to prevent chattering

One insert type for shank diameter range from ø10 mm ~ ø20 mm
→ Left & Right handed inserts with G-class accuracy create precision machining

Ideal grade series for various applications
→ **AH725** for general steel cutting, **GT530** with high wear resistance for fine surface finishes and the **NS530** for economic performance

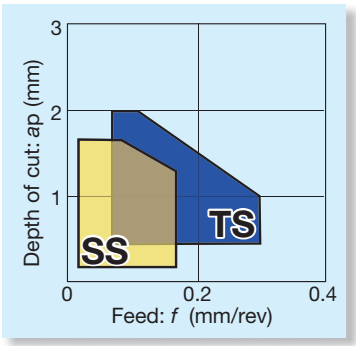
Originally designed exclusive insert

TS: general purpose
(Recommended for steel machining)

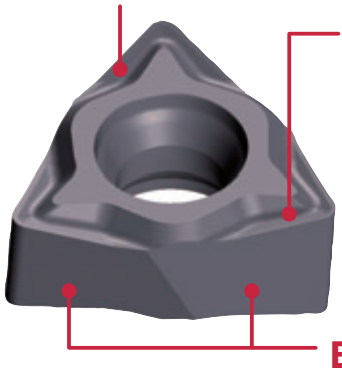
P Steel M Stainless K Cast Iron

SS: generates low cutting forces
(Recommended for stainless steel machining)

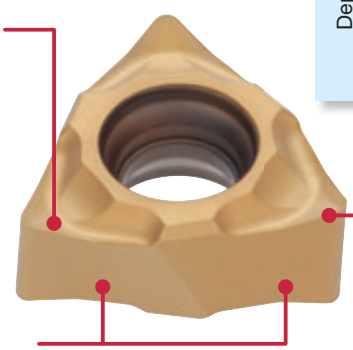
M Stainless P Steel K Cast Iron



Large inclination on edge
Reduces cutting forces and chattering



Wide chip-pocket
Prevents chip packing
Prevents the re-cutting of chips



Enhances the clamping rigidity
Uniquely designed shape to precisely fit to the toolholder

Large rake angle and optimum pocket shape
Drastically reduces cutting forces
Smooth chip evacuation

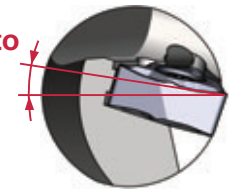
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High performance boring bars with optimum design

Excellent chip evacuation and high rigidity
(Same structure as StreamJetBar series)

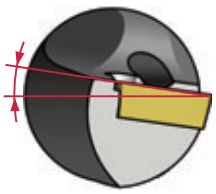
DOMTURN

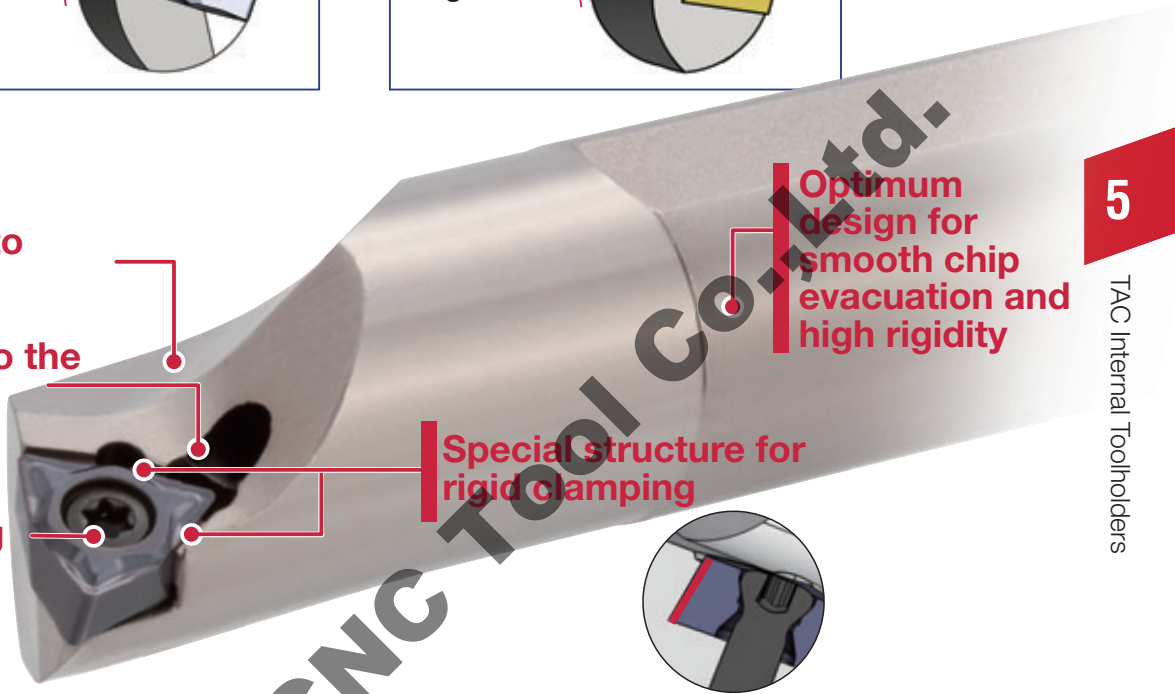
Similar to positive type



Conventional positive type insert

Small rake angle





Optimal space to evacuate chips

Oil hole direct to the cutting edge

Screw clamping with high rigidity

Special structure for rigid clamping

Optimum design for smooth chip evacuation and high rigidity

Dove-tail structure (wedge shape) creates high clamping force

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Cutting performance

Anti-vibration strength

Same strength level as positive type inserts

Steel shank
Cutting speed : *Vc* = 150 m/min
Work material : S45C / C45
Coolant : Wet (internal supply)

Overhang length: 36 mm (L/D = 3) Shank diameter: ø12 mm

DOMTURN

Depth of cut: ap (mm)	Feed: *f* (mm/rev)			
	0.05	0.10	0.15	0.20
2.0	OK	OK	OK	OK
1.5	OK	OK	OK	OK
1.0	OK	OK	OK	OK
0.5	OK	OK	OK	OK
ap / *f*				

Overhang length

Depth of cut: ap (mm)	Feed: *f* (mm/rev)			
	0.05	0.10	0.15	0.20
2.0	OK	OK	OK	OK
1.5	OK	OK	OK	OK
1.0	OK	OK	OK	OK
0.5	OK	OK	OK	OK
ap / *f*				

STREAMJETBAR

Extensive simulation analysis has enabled Tungaloy to develop a highly-rigid Stream Jet Bar with the ideal tool geometry for excellent chip evacuation.

New MINI

Stream Jet Bar MINI for small diameter machining applications!

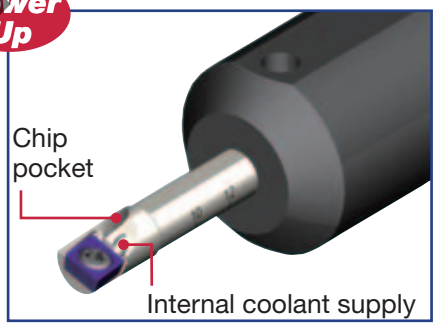


Features

1 Excellent performance for small diameter machining operations

- Minimum bore diameter from ø4.5 mm
- Steel & carbide shank available
- Straight shank type available
- Can be used with internal coolant supply
- Well designed chip pocket for excellent chip evacuation
- Easy to adjust overhang due to marked scale on shank
- Improved rigidity for minimizing bar deflection & chatter by FEM (Finite Element Method)
- Added Z cutting edge style for back boring

Power Up

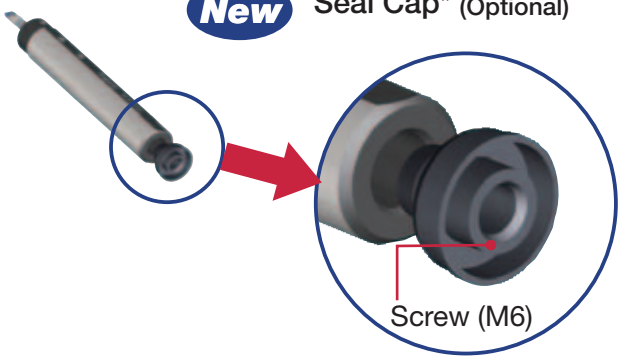


2 Applicable for a wide variety of machines

- Applicable sleeve for a variety of small lathes
- Supplied with Seal cap* (optional)
- Suitably designed sleeve for directed external coolant flow (see picture below)



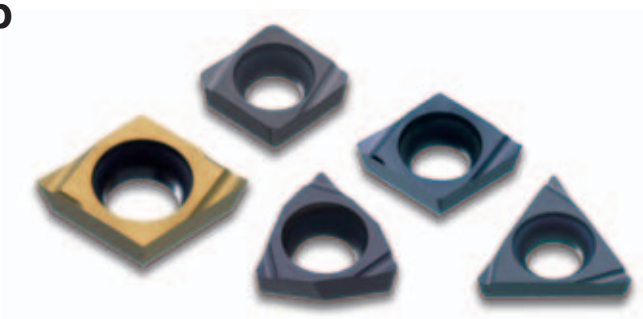
New Seal Cap* (Optional)



Attention: Please use the installation tools (e.g. a plastic hammer etc.), if difficult to ensure proper alignment

3 Stable tool life & excellent chip control

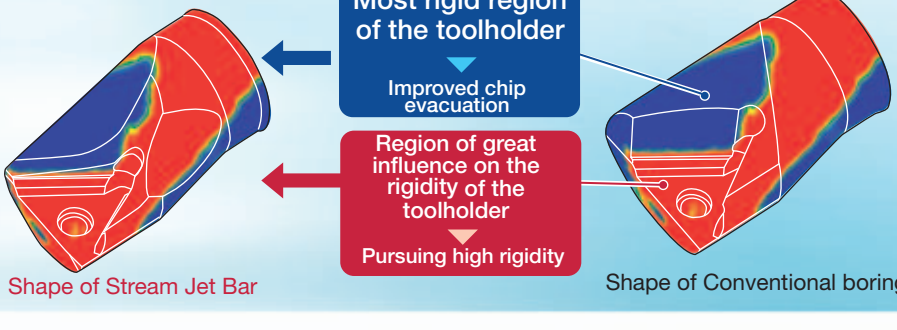
- W08 type chipbreaker
- Superior cutting edge due to fine grain carbide grade
- Two grades of inserts: **SH730** (for general purpose), **TH10** (for non-ferrous)
- Expansion of corner R0.1 spec on "**EPGT04**" & "**WBGT03**" insert types



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● Finite Analysis of the load transition





Increased rigidity for minimizing bar deflection & chatter

● **Rigidity in comparison to a conventional boring bar (Illustrations)**

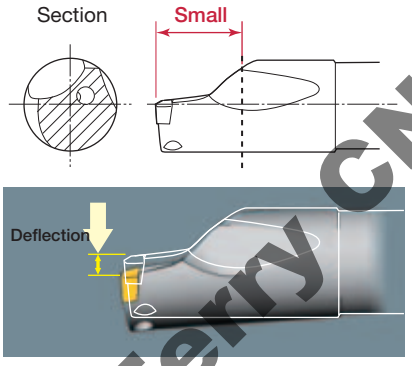
The rigidity of the bar in the direction of the principal force is maximized because the thickest portion of the head is located as close as possible to the cutting edge.
Note: Load 1000N (*Vc* = 150 m/min, *ap* = 1.5 mm, *f* = 0.2 mm/rev are assumed) A16Q-STUPR13-D180

Large head design provides both high rigidity & good chip evacuation.

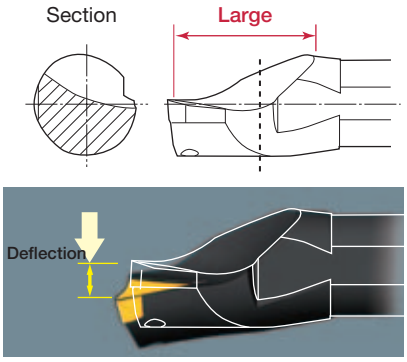


About 20% reduction in deflection compared to conventional bar

STREAMJETBAR



Conventional boring bar

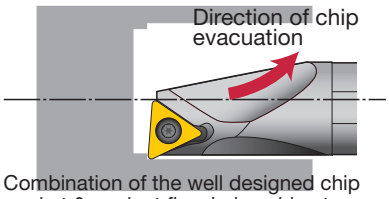


New pocket design for excellent chip evacuation

● **Cutting performance**

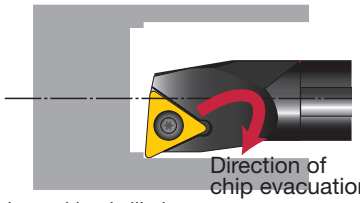
The excellent chip evacuation minimizes tool failure caused by re-cutting chips & poor chip control. Damage to the work surface from chips is also eliminated.

STREAMJETBAR



Combination of the well designed chip pocket & coolant flow helps chips to effectively evacuate.

Conventional boring bar



Chip packing is likely to occur.

The oil hole is positioned as close as possible to the cutting edge to ensure fluid is fed directly to the cutting point.

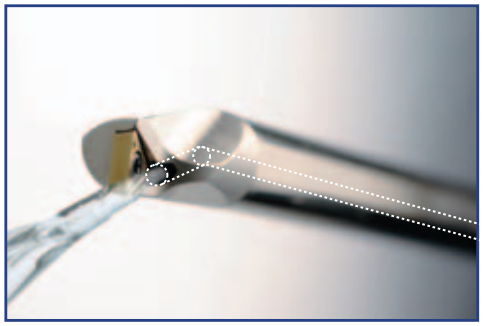
● **Oil hole design**

Distance between the cutting edge & the oil hole is minimized. (Distance is reduced by 50% compared to existing boring bars.)

● **Screw for oil hole***

In the case of not using the oil hole, a special screw can be inserted to prevent chip coiling (optional).

* Negative type only

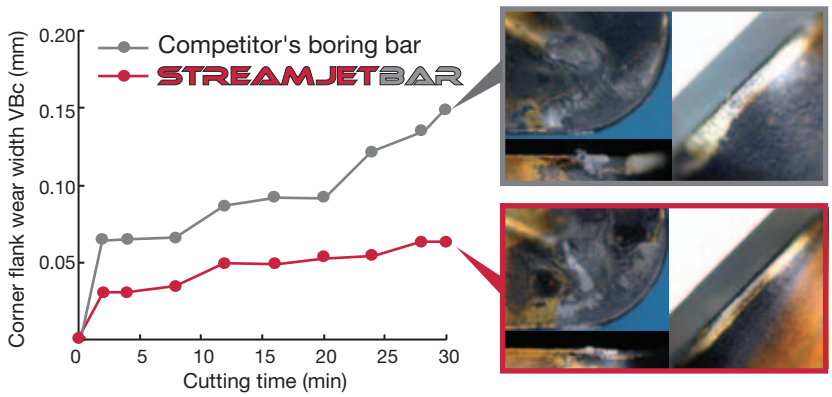


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STREAMJETBAR

Improved tool life

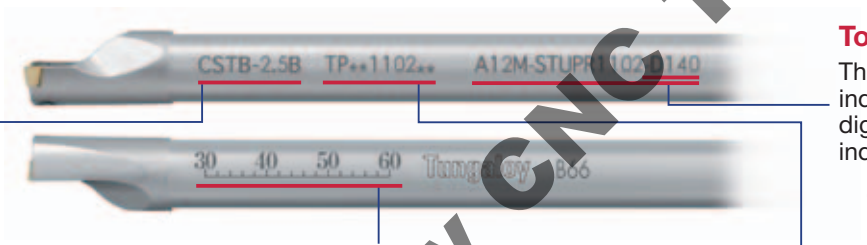
By supplying the optimum level of cutting fluid, flank wear & rake face wear are suppressed, considerably improving tool life.



Toolholder	: A16Q-STUPR1103-D180
Insert	: TPMT110304-PS (GT730)
Work material	: S45C (220HB)
	: Boring (ø30 ~ 50 mm)
Cutting speed	: *Vc* = 100 m/min
Depth of cut	: *ap* = 0.5 mm
Feed	: *f* = 0.2 mm/rev
Cutting fluid	: Wet

"Easy to use"

● Marking specifications



Toolholder Cat. No.
The minimum bore diameter is indicated in the Cat. No. The three-digit number at the end of the text indicates the minimum bore diameter.
(Example)-D140 → 14.0 mm

Applicable clamping screw Cat. No. (Positive type only)
If screw is missing, this detail simplifies locating a replacement with Cat. No.

Scale of overhang length
Useful for easy setting of the toolholder.

Applicable insert Cat. No.
Can identify the insert size & relief angle at a glance. Simplified tool management.

Carbide shank type

Combination of the highly rigid carbide shank & the head geometry can increase the tool rigidity & improve chip evacuation.



● Guide to L/D

Steel shank	Carbide shank
L/D ≤ 3	L/D ≤ 5

(Note) L : Overhang length, D: Shank diameter

● For precision boring

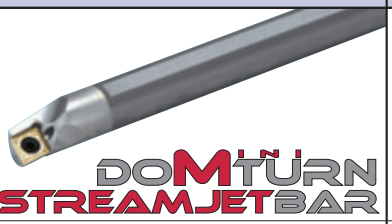
The increased rigidity suppresses chatter, producing excellent surface finishes.
Excellent chip evacuation minimizes damage to the surface caused by chip re-cutting. This further improves surface finish.

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Clamping Mechanism & Features of TAC Internal Toolholders

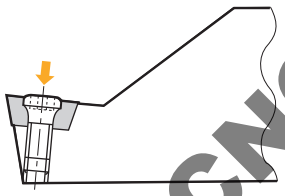
Shank material

Steel Shank	Carbide Shank	"Tsuppari-Ichiban"
		
● Economical. ● Min. bore dia: ø4.5 ~ ø63 mm. ● Screw-on, clamp-on, pin-lock & double clamping types are stocked.	● Finishing accuracy is good with excellent resistance to chatter. ● Screw-on & clamp-on types (min. bore dia: ø4.5 ~ ø34 mm) are standard stocked.	● Provides highly rigid shank reinforced with carbide plates. ● Good resistance to chatter. ● Low cost, close to steel shank. ● Min. bore dia: ø20 mm for P-type, ø14 mm for S-type. ● Also available in oil hole shank type.

Clamping system

S Screw-on

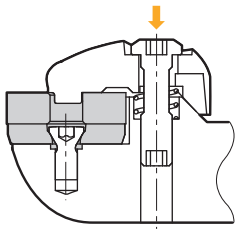




- Simple clamping mechanism.
- Smart shape without overhang area.
- Minimum bore diameter: ø4.5 mm.
- Good cutting action by using positive inserts.
- Carbide shanks that have excellent resistance to chatter.
- "Tsuppari-Ichiban" shanks (reinforced with carbide plates) are also stocked.

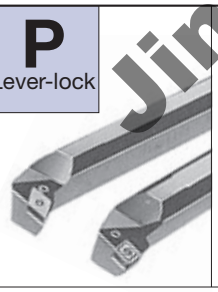
A Double clamping

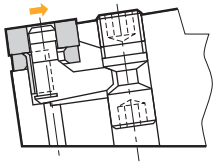




- Increased clamping rigidity contributes to superior cutting edge positioning accuracy & longer tool life.
- Enlarged insert holding area of the clamp allows more accurate cutting edge positioning. It delivers high performance even when using VNMG type (35° corner angle) inserts, which tend to destabilize cutting edge positioning.
- Simple structure keeps cost low. Easy clamping with only one wrench.

P Lever-lock

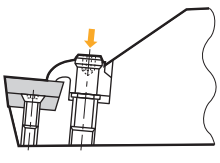




- Negative rake, lever-lock type, round shank boring bars.
- The insert is positively held into a two wall pocket, excelling in indexing accuracy.
- Minimum bore diameter: ø20 mm.
- "Tsuppari-Ichiban" shanks that are reinforced with carbide plates are also stocked.

C Clamp-on

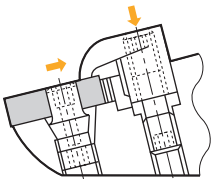




- Clamp-on type insert locking mechanism assures secure holding & accurate indexing.
- For inserts without a hole, it provides stronger cutting edge strength than S-type tools & can withstand heavier cutting conditions.
- Minimum bore diameter: ø16 mm

M Multi clamping





- Combination of lock-pin & top clamp provides positive insert holding & superior indexing accuracy.
- Suitable for medium to large diameter boring.
- Minimum bore diameter: ø32 mm

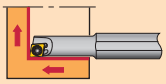
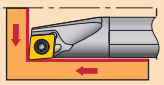
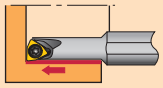
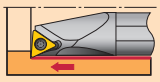
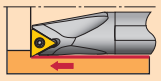
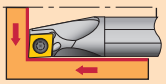
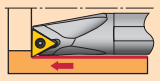
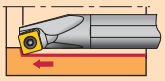
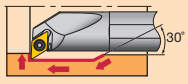
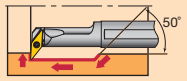
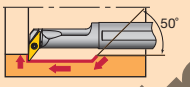
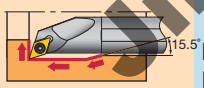
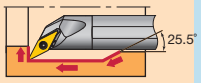
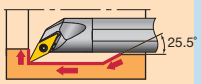
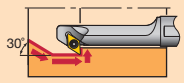
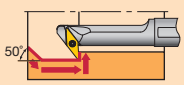
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List of StreamJetBar & DoMiniTurn

A wide range of styles & size applicable for a variety of tooling

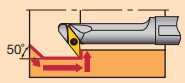
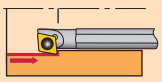
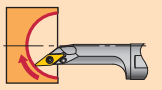
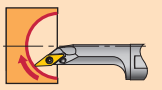
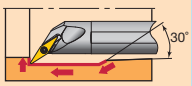
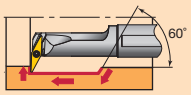
Positive type

STREAMJETBAR

Style	Shank type	Shank diameter	Minimum bore diameter (mm) 0 10 20 30 40 50
 **SEXPR/L** 5-28 Boring & internal facing Insert type: EP□□	Steel Carbide	ø4 ~ ø8 ø4 ~ ø8	ø4.5 ø7 ø4.5 ø7
 **SCLCR/L** 5-12 Boring & internal facing Insert type: CC□□	Steel Carbide	ø4 ~ ø25 ø4 ~ ø25	ø5 ø27 ø5 ø27
 **SWUBR/L** 5-27 Boring Insert type:WB□□	Steel Carbide	ø5 ~ ø8 ø5 ~ ø8	ø6 ø8 ø6 ø8
 **STUPR/L** 5-21 Boring Insert type: TP□□	Steel Carbide	ø7 ~ ø32 ø7 ~ ø25	ø8 ø34 ø8 ø27
 **STFPR/L** 5-20 Blind hole Boring Insert type: TP□□	Steel Carbide	ø8 ~ ø25 ø8 ~ ø20	ø10 ø27 ø10 ø22
 **SCLPR/L** 5-14 Boring & internal facing Insert type: CP□□	Steel Carbide	ø8 ~ ø25 ø8 ~ ø16	ø10 ø27 ø10 ø20
 **STFCR/L** 5-19 Blind hole Boring Insert type: TC□□	Steel Carbide	ø8 ~ ø25 ø8 ~ ø25	ø10 ø27 ø10 ø27
 **SSKPR/L** 5-18 Through boring Insert type: SP□□	Steel	ø16 ~ ø25	ø20 ø31
 **SDUCR/L** 5-16 Boring & internal profiling Insert type: DC□□	Steel Carbide	ø10 ~ ø25 ø10 ~ ø20	ø13 ø32 ø13 ø27
 **SVUCR/L** 5-24 Boring & internal profiling Insert type: VC□□	Steel Carbide	ø12 ~ ø40 ø12 ~ ø25	ø16 ø50 ø18 ø32
 **SVUBR/L** 5-22 Boring & internal profiling Insert type: VB□□	Steel Carbide	ø16 ~ ø25 ø16 ~ ø25	ø20 ø32 ø24.5 ø34
 **SDQCR/L** 5-16 Boring & internal profiling Insert type: DC□□	Steel Carbide	ø10~ ø25 ø10~ ø20	ø13 ø30 ø13 ø25
 **SVQCR/L** 5-24 Boring & internal profiling Insert type: VC□□	Steel Carbide	ø10~ ø40 ø10~ ø16	ø13.5 ø50 ø13.5 ø21.5
 **SVQBR/L** 5-22 Boring & internal profiling Insert type: VB□□	Steel Carbide	ø12 ~ ø25 ø12 ~ ø25	ø17 ø30.5 ø17 ø30.5
 **SDZCR/L** 5-17 Internal retracting Insert type: DC□□	Steel Carbide	ø12 ~ ø25 ø12 ~ ø16	ø14 ø25 ø18 ø22
 **SVZCR/L** 5-25 Internal retracting Insert type: VC□□	Steel	ø12	ø16

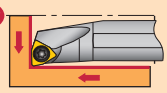
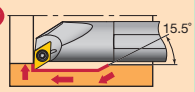
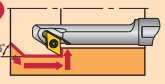
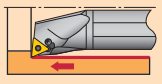
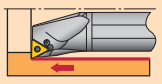
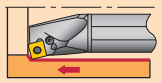
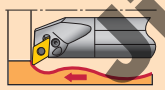
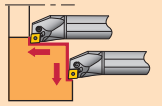
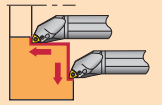
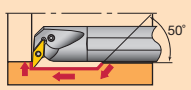
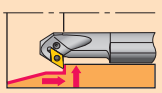
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sales@jnterui.com

Style		Shank type	Shank diameter	Minimum bore diameter (mm) 0 10 20 30 40 50
	**SVZBR/L** 5-23 Internal retracting Insert type: VE□□	Steel	ø16 ~ ø32	ø20 ~ ø40
	**SEZPR/L** 5-28 Internal retracting Insert type: EP□□	Steel Carbide	ø4 ~ ø5 ø4 ~ ø5	ø5.5 ~ ø6.5 ø5.5 ~ ø6.5
	**SVJCR/L** 5-25 Internal sphere cutting Insert type:VC□□	Steel	ø12 ~ ø16	ø16 ~ ø20
	**SVJBR/L** 5-23 Internal sphere cutting Insert type:VB□□	Steel	ø20 ~ ø25	ø25 ~ ø30
	**SYQBR/L** 5-30 Internal undercut & profiling Insert type:YW□□	Steel Carbide	ø12 ~ ø16 ø12 ~ ø16	ø17 ~ ø21.5 ø17 ~ ø21.5
	**SYUBR/L** 5-30 Boring & internal profiling Insert type: YW□□	Steel Carbide	ø16 ø12 ~ ø16	ø20 ø20 ~ ø24.5

Negative type

DOMTURN STREAMJETBAR

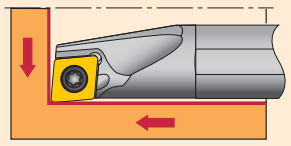
Style		Shank type	Shank diameter	Minimum bore diameter (mm) 0 10 20 30 40 50 60 70
New 	**SWLXR/L** 5-31 Boring and facing Insert type: **WXGU**	Steel Carbide	ø10 ~ ø20 ø10 ~ ø20	ø12 ~ ø22 ø12 ~ ø22
New 	**SDXXR/L** 5-31 Internal profiling Insert type: **DXGU**	Steel Carbide	ø10 ~ ø20 ø10 ~ ø20	ø13 ~ ø24 ø13 ~ ø24
New 	**SDZXR/L** 5-32 Internal retracting Insert type: **DXGU**	Steel Carbide	ø12 ~ ø20 ø12 ~ ø16	ø14 ~ ø20 ø18 ~ ø22
	**PTUNR/L** 5-37 Boring Insert type: TN□□	Steel	ø16 ~ ø32	ø20 ~ ø40
	**PTFNR/L** 5-37 Boring Insert type: TN□□	Steel	ø25 ~ ø50	ø32 ~ ø63
	**PSKNR/L** 5-36 Through boring Insert type: SN□□	Steel	ø32 ~ ø50	ø40 ~ ø63
	**PDUNR/L** 5-35 Internal profiling Insert type: DN□□	Steel	ø20 ~ ø50	ø25 ~ ø63
	**PCLNR/L** 5-34 Boring & internal facing Insert type: CN□□	Steel	ø16 ~ ø50	ø20 ~ ø63
	**PWLNR/L** 5-39 Boring & facing Insert type: WN	Steel	ø16 ~ ø40	ø20 ~ ø50
	**PVUNR/L** 5-38 Boring & Internal profiling Insert type: VN□□	Steel	ø25 ~ ø40	ø37 ~ ø50
	**PDZNR/L** 5-35 Internal retracting Insert type: DN□□	Steel	ø32 ~ ø50	ø40 ~ ø63

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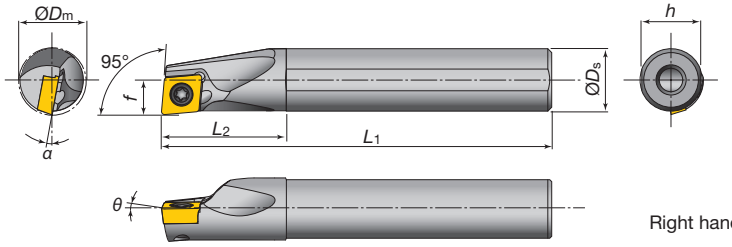
SCLCR/L

Min. bore dia. ø5 mm~ | Shank dia. ø4~25 mm | Steel Shank | Carbide Shank

Boring & internal facing



Cutting edge style **L**



Oil Hole

Right hand (R) shown.

Steel Shank

Toolholder Cat. No.	Stock R	Stock L	Min bore.dia. ØDm	Dimensions (mm) ØDs	f	L1	L2	h	f2	θ	α	Std. corner radius rε	Applicable inserts	Parts: Clamping screw	Parts: Wrench	Torque (N·m)
MINI A04F-SCLCR/L03-D050	●	●	5	4	2.5	80	8	3.8	-	0°	-15°	0.2	CC□□03X1	CSTA-1.6	T-6F	0.6
MINI A05F-SCLCR/L03-D060	●	●	6	5	3	80	9	4.8	-	0°	-13°					
MINI A06G-SCLCR/L04-D070	●	●	7	6	3.5	90	11	5.75	-	0°	-13°	0.2	CC□□04T1	CSTB-2	T-6F	0.6
MINI A07G-SCLCR/L04-D080	●	●	8	7	4	90	12	6.75	-	0°	-11°					
A08H-SCLCR/L06-D100	●	●	10	8	5.5	100	16	7.5	-	0°	-13°	0.4	CC□□0602	CSTB-2.5S	T-8F	1.2
A10F-SCLCR/L06-D120	●		12	10	6	80	20	9	-	0°	-10°	0.4				
A10K-SCLCR/L06-D120	●	●	12	10	6	125	20	9	-	0°	-10°	0.4				
A12H-SCLCR/L06-D140	●		14	12	7	100	24	11	-	0°	-8°	0.4				
A12M-SCLCR/L06-D140	●	●	14	12	7	150	24	11	-	0°	-8°	0.4				
A12H-SCLCR/L06-D160	●		16	12	9	100	24	11	-	0°	-7°	0.4				
A12M-SCLCR/L06-D160	●	●	16	12	9	150	24	11	-	0°	-7°	0.4				
A16K-SCLCR/L09-D180	●		18	16	9	125	32	15	-	0°	-9°	0.8	CC□□09T3	CSTB-4S	T-15F	3.0
A16Q-SCLCR/L09-D180	●	●	18	16	9	180	32	15	-	0°	-10°	0.8				
A16K-SCLCR/L09-D200	●		20	16	11	125	32	15	-	0°	-9°	0.8				
A16Q-SCLCR/L09-D200	●	●	20	16	11	180	32	15	-	0°	-9°	0.8				
A20R-SCLCR/L09-D220	●	●	22	20	11	200	32	18	-	0°	-8°	0.8				
A25S-SCLCR/L09-D270	●	●	27	25	13.5	250	45	23	-	0°	-6°	0.8				

Carbide Shank

Toolholder Cat. No.	Stock R	Stock L	Min bore.dia. ØDm	Dimensions (mm) ØDs	f	L1	L2	h	f2	θ	α	Std. corner radius rε	Applicable inserts	Parts: Clamping screw	Parts: Wrench	Torque (N·m)
MINI E04G-SCLCR/L03-D050	●	●	5	4	2.5	90	9	3.8	-	0°	-15°	0.2	CC□□03X1	CSTA-1.6	T-6F	0.6
MINI E05G-SCLCR/L03-D060	●	●	6	5	3	90	10	4.8	-	0°	-13°					
MINI E06H-SCLCR/L04-D070	●	●	7	6	3.5	100	12	5.75	-	0°	-13°	0.2	CC□□04T1	CSTB-2	T-6F	0.6
MINI E07H-SCLCR/L04-D080	●	●	8	7	4	100	14	6.75	-	0°	-11°					
E08G-SCLCR/L06-D100	●		10	8	5.5	90	22	7.5	-	0°	-13°	0.4	CC□□0602	CSTB-2.5S	T-8F	1.2
E08K-SCLCR/L06-D100	●	●	10	8	5.5	125	22	7.5	-	0°	-13°	0.4				
E10F-SCLCR/L06-D120	●		12	10	6	80	25	9	-	0°	-10°	0.4				
E10H-SCLCR/L06-D120	●		12	10	6	100	25	9	-	0°	-10°	0.4				
E10M-SCLCR/L06-D120	●	●	12	10	6	150	25	9	-	0°	-10°	0.4				
E12G-SCLCR/L06-D140	●		14	12	7	90	27	11	-	0°	-8°	0.4				
E12J-SCLCR/L06-D140	●		14	12	7	110	27	11	-	0°	-8°	0.4				
E12Q-SCLCR/L06-D140	●	●	14	12	7	180	27	11	-	0°	-8°	0.4				
E12G-SCLCR/L06-D160	●		16	12	9	90	27	11	-	0°	-7°	0.4				
E12J-SCLCR/L06-D160	●		16	12	9	110	27	11	-	0°	-7°	0.4				
E12Q-SCLCR/L06-D160	●	●	16	12	9	180	27	11	-	0°	-7°	0.4				
E16H-SCLCR/L09-D180	●		18	16	9	100	32	15	-	0°	-10°	0.8	CC□□09T3	CSTB-4L060	T-15F	3.0
E16L-SCLCR/L09-D180	●		18	16	9	130	32	15	-	0°	-10°	0.8				
E16R-SCLCR/L09-D180	●	●	18	16	9	200	32	15	-	0°	-10°	0.8				
E16H-SCLCR/L09-D200	●		20	16	11	100	32	15	-	0°	-9°	0.8				
E16L-SCLCR/L09-D200	●		20	16	11	130	32	15	-	0°	-9°	0.8				
E16R-SCLCR/L09-D200	●	●	20	16	11	200	32	15	-	0°	-9°	0.8				
E20S-SCLCR/L09-D220	●		22	20	11	250	36	18	-	0°	-8°	0.8		CSTB-4S		
E25T-SCLCR/L09-D270	●		27	25	13.5	300	45	23	-	0°	-6°	0.8				

When using a right or left hand insert, the right hand insert (R) is used for the left hand toolholders (SCLCL □□ type), and the left hand insert (L) is used for the right hand toolholders (SCLCR □□ type).

● : Stocked items.

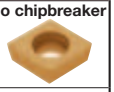
Jinan Terry CNC Tool Co.,Ltd.

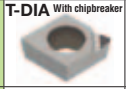
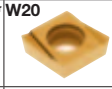
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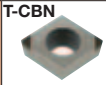
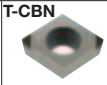
Basic Selection Chipbreakers CC□□09T3□□-□□

	Operation	Precision finishing	Finishing	Finishing to medium cutting	Medium cutting
P Steel	Grade	SH730	AH725	T9115	T9125
	Page	2-99	2-96	2-97	2-100
	Chipbreaker	JS 	PSF 	PS 	PM 
Continuous	*Vc* (m/min)	**120** (50-180)	**120** (50-180)	**220** (150-300)	**180** (120-250)
	ap (mm)	**1.5** (0.1-3.0)	**0.3** (0.1-0.5)	**1.5** (0.5-2.5)	**2.0** (1.0-3.0)
	f (mm/rev)	**0.06** (0.02-0.1)	**0.12** (0.08-0.2)	**0.15** (0.08-0.3)	**0.25** (0.07-0.3)
	*r*ε (mm)	0.2	0.4	0.8	0.8

	Operation	Precision finishing	Finishing	Finishing to light cutting	Medium cutting
M Stainless	Grade	GH330	AH725	AH725	T6130
	Page	2-97	2-96	2-97	2-100
	Chipbreaker	W20 	PSF 	PSS 	PM 
Continuous	*Vc* (m/min)	**120** (100-150)	**120** (50-150)	**120** (50-150)	**120** (70-150)
	ap (mm)	**0.5** (0.05-02.0)	**0.3** (0.1-0.5)	**1.2** (0.3-2.0)	**2.0** (1.0-3.0)
	f (mm/rev)	**0.1** (0.03-0.15)	**0.12** (0.08-0.2)	**0.15** (0.08-0.3)	**0.25** (0.07-0.3)
	*r*ε (mm)	0.4	0.4	0.8	0.8

	Operation	Precision finishing	Finishing to medium cutting	Medium cutting
K Cast Iron	Grade	BX930	T5115	T5115
	Page	3-14	2-97	2-101
	Chipbreaker	T-CBN 	CM 	No chipbreaker 
Continuous	*Vc* (m/min)	**700** (300-1200)	**270** (140-400)	**270** (140-400)
	ap (mm)	**0.3** (0.05-0.5)	**1.0** (0.05-2.0)	**1.5** (0.05-2.0)
	f (mm/rev)	**0.06** (0.05-0.2)	**0.2** (0.05-0.3)	**0.15** (0.05-0.3)
	*r*ε (mm)	0.4	0.8	0.8

	Operation	Precision finishing	Finishing	Finishing to medium cutting
N Non-ferrous	Grade	DX120	GH110	KS05F
	Page	3-22	2-97	2-98
	Chipbreaker	T-DIA With chipbreaker 	W20 	AL 
Continuous	*Vc* (m/min)	**1500** (500-2500)	**600** (100-1000)	**400** (200-1500)
	ap (mm)	**0.1** (0.03-0.5)	**0.5** (0.05-2.0)	**2.0** (1.0-5.0)
	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

	Operation	Precision finishing	Finishing
S Superalloys	Grade	BX470	BX950
	Page	3-12	3-14
	Chipbreaker	T-CBN 	T-CBN 
Continuous	*Vc* (m/min)	**200** (100-280)	**200** (70-300)
	ap (mm)	**0.1** (0.05-0.5)	**0.3** (0.1-0.5)
	f (mm/rev)	**0.1** (0.05-0.3)	**0.1** (0.05-0.2)
	*r*ε (mm)	0.4	0.4

	Operation	Precision finishing	Finishing
H Hard Materials	Grade	BXM10	BXM20
	Page	3-12	3-12
	Chipbreaker	T-CBN 	T-CBN 
Continuous	*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” 2-16~

Jinan Terry CNC Tool Co.,Ltd.

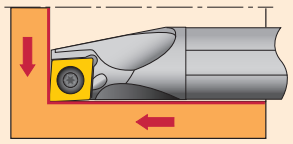
SCLPR/L

Min. bore dia. ø10 mm~

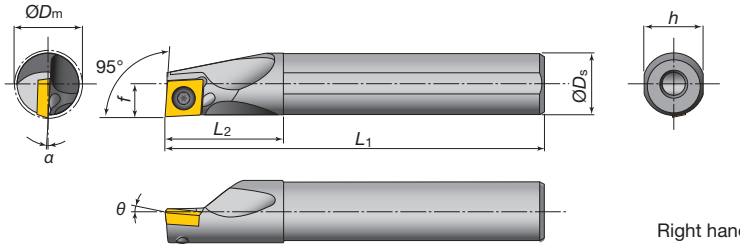
Shank dia. ø8~25 mm

Steel Shank | Carbide Shank

Boring & internal facing



Cutting edge style **L**



Oil Hole

Right hand (R) shown.

Steel Shank

Toolholder Cat. No.	Stock R	Stock L	Min bore.dia. ØDm	Dimensions (mm) ØDs	f	L_1	L_2	h	f_2	θ	α	Std. corner radius r_ε	Applicable inserts	Parts: Clamping screw	Parts: Wrench	Torque (N·m)
A08H-SCLPR/L06-D100	●	●	10	8	5.5	100	16	7.5	-	+5°	-8°	0.4	CP□□0602	CSTB-2.5S	T-8F	1.2
A10K-SCLPR/L06-D120	●	●	12	10	6	125	20	9	-	+5°	-5°	0.4	CP□□0602	CSTB-2.5S	T-8F	1.2
A10K-SCLPR/L08-D120	●	●	12	10	6	125	20	9	-	+5°	-5°	0.4	CP□□0802	CSTB-3L042	T-9F	1.4
A12M-SCLPR/L06-D140	●	●	14	12	7	150	24	11	-	+5°	-4°	0.4	CP□□0602	CSTB-2.5S	T-8F	1.2
A12M-SCLPR/L08-D140	●	●	14	12	7	150	24	11	-	+5°	-4°	0.4	CP□□0802	CSTB-3L050	T-9F	1.4
A12M-SCLPR/L08-D160	●	●	16	12	9	150	24	11	-	+5°	-3°	0.4				
A16Q-SCLPR/L09-D180	●	●	18	16	9	180	32	15	-	+5°	-3.5°	0.8				
A16Q-SCLPR/L09-D200	●	●	20	16	11	180	32	15	-	+5°	-3°	0.8	CP□□0903	CSTB-4L060	T-15F	3.0
A20R-SCLPR/L09-D220	●	●	22	20	11	200	36	18	-	+5°	-2°	0.8				
A25S-SCLPR/L09-D270	●	●	27	25	13.5	250	45	23	-	+5°	-1°	0.8				

Carbide Shank

Toolholder Cat. No.	Stock R	Stock L	Min bore.dia. ØDm	Dimensions (mm) ØDs	f	L_1	L_2	h	f_2	θ	α	Std. corner radius r_ε	Applicable inserts	Parts: Clamping screw	Parts: Wrench	Torque (N·m)
E08K-SCLPR/L06-D100	●	●	10	8	5.5	125	22	7.5	-	+5°	-8°	0.4	CP□□0602	CSTB-2.5S	T-8F	1.2
E10M-SCLPR/L06-D120	●	●	12	10	6	150	25	9	-	+5°	-5°	0.4	CP□□0602	CSTB-2.5S	T-8F	1.2
E10H-SCLPR/L08-D120	●		12	10	6	100	25	9	-	+5°	-5°	0.4	CP□□0802	CSTB-3L042	T-9F	1.4
E10M-SCLPR/L08-D120	●	●	12	10	6	150	25	9	-	+5°	-5°	0.4				
E12Q-SCLPR/L06-D140	●	●	14	12	7	180	27	11	-	+5°	-4°	0.4	CP□□0602	CSTB-2.5S	T-8F	1.2
E12G-SCLPR/L08-D140	●		14	12	7	90	27	11	-	+5°	-4°	0.4	CP□□0802	CSTB-3L050	T-9F	1.4
E12J-SCLPR/L08-D140	●		14	12	7	110	27	11	-	+5°	-4°	0.4				
E12Q-SCLPR/L08-D140	●	●	14	12	7	180	27	11	-	+5°	-4°	0.4				
E12G-SCLPR/L08-D160	●		16	12	9	90	27	11	-	+5°	-3°	0.4				
E12J-SCLPR/L08-D160	●		16	12	9	110	27	11	-	+5°	-3°	0.4				
E12Q-SCLPR/L08-D160	●	●	16	12	9	180	27	11	-	+5°	-3°	0.4				
E16H-SCLPR/L09-D180	●		18	16	9	100	32	15	-	+5°	-3.5°	0.8	CP□□0903	CSTB-4L060	T-15F	3.0
E16L-SCLPR/L09-D180	●		18	16	9	130	32	15	-	+5°	-3.5°	0.8				
E16R-SCLPR/L09-D180	●	●	18	16	9	200	32	15	-	+5°	-3.5°	0.8				
E16H-SCLPR/L09-D200	●		20	16	11	100	32	15	-	+5°	-3°	0.8				
E16L-SCLPR/L09-D200	●		20	16	11	130	32	15	-	+5°	-3°	0.8				
E16R-SCLPR/L09-D200	●	●	20	16	11	200	32	15	-	+5°	-3°	0.8				

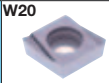
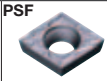
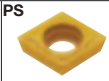
When using a right or left hand insert, the right hand (R) insert is used for the left hand toolholders (SCLPL □□ type), and the left hand insert (L) is used for the right hand toolholders (SCLPR □□ type).

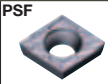
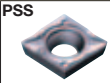
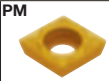
● : Stocked items.

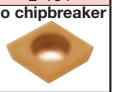
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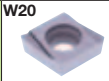
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Basic Selection Chipbreakers CP□□0903□□-□□

	Operation	Precision finishing	Finishing	Finishing to medium cutting	Medium cutting
P Steel	Grade	NS530	AH725	T9115	T9125
	Page	2-102	2-102	2-103	2-103
	Chipbreaker	W20 	PSF 	PS 	PM 
Continuous	*Vc* (m/min)	**200** (150-250)	**120** (50-180)	**220** (150-300)	**180** (120-250)
	ap (mm)	**0.5** (0.05-2.5)	**0.3** (0.1-0.5)	**1.5** (0.5-2.5)	**2.0** (1.0-3.0)
	f (mm/rev)	**0.1** (0.03-0.15)	**0.12** (0.08-0.2)	**0.15** (0.08-0.3)	**0.25** (0.07-0.3)
	*r*ε (mm)	0.4	0.4	0.8	0.8

	Operation	Finishing	Finishing to light cutting	Medium cutting
M Stainless	Grade	AH725	AH725	T6130
	Page	2-102	2-102	2-103
	Chipbreaker	PSF 	PSS 	PM 
Continuous	*Vc* (m/min)	**120** (50-150)	**120** (50-150)	**120** (70-150)
	ap (mm)	**0.3** (0.1-0.5)	**1.2** (0.3-2.0)	**2.0** (1.0-3.0)
	f (mm/rev)	**0.12** (0.08-0.2)	**0.15** (0.08-0.3)	**0.25** (0.07-0.3)
	*r*ε (mm)	0.4	0.8	0.8

	Operation	Finishing to medium cutting	Medium cutting
K Cast Iron	Grade	T5115	T5115
	Page	2-103	2-104
	Chipbreaker	CM 	No chipbreaker 
Continuous	*Vc* (m/min)	**270** (140-400)	**270** (140-400)
	ap (mm)	**1.0** (0.05-2.0)	**1.5** (0.05-2.0)
	f (mm/rev)	**0.2** (0.05-0.3)	**0.15** (0.05-0.3)
	*r*ε (mm)	0.8	0.8

	Operation	Finishing
N Non-ferrous	Grade	TH10
	Page	2-102
	Chipbreaker	W20 
Continuous	*Vc* (m/min)	**600** (100-1000)
	ap (mm)	**0.5** (0.05-2.0)
	f (mm/rev)	**0.1** (0.03-0.15)
	*r*ε (mm)	0.4

For other machining types, see “Selection System”

2-16~

Jinan Terry CNC Tool Co.,Ltd.

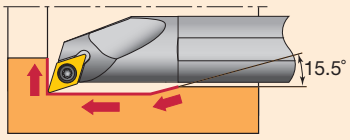
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STREAMJETBAR S-type SDQCR/L

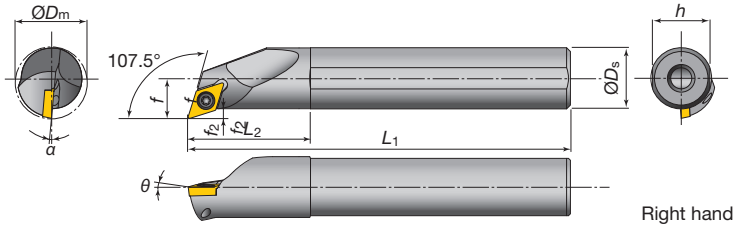
Positive rake / Screw-on system

Min. bore dia. ø13 mm~ | Shank dia. ø10~25 mm | Steel Shank | Carbide Shank

Boring & internal profiling



Cutting edge style **Q**



Oil Hole

Right hand (R) shown.

Steel Shank

Toolholder Cat. No.	Stock R	Stock L	Min bore.dia. ØDm	Dimensions (mm) ØDs	f	L_1	L_2	h	f_2	θ	α	Std. corner radius r_ε	Applicable inserts	Parts: Clamping screw	Parts: Wrench	Torque (N·m)
A10K-SDQCR/L07-D130	●	●	13	10	7.6	125	20	9	2.6	0°	-8°	0.4	DC□□0702	CSTB-2.5S	T-8F	1.2
A12M-SDQCR/L07-D160	●	●	16	12	8.6	150	24	11	2.6	0°	-6°	0.4				
A16Q-SDQCR/L07-D200	●	●	20	16	10.6	180	32	15	2.6	0°	-5°	0.4				
A20R-SDQCR/L11-D250	●	●	25	20	13.7	200	36	18	3.7	0°	-7°	0.8	DC□□11T3	CSTB-4S	T-15F	3.0
A25S-SDQCR/L11-D300	●	●	30	25	16.2	250	45	23	3.7	0°	-4°	0.8				

Carbide Shank

Toolholder Cat. No.	Stock R	Stock L	Min bore.dia. ØDm	Dimensions (mm) ØDs	f	L_1	L_2	h	f_2	θ	α	Std. corner radius r_ε	Applicable inserts	Parts: Clamping screw	Parts: Wrench	Torque (N·m)
E10H-SDQCR/L07-D130	●		13	10	7.6	100	25	9	2.5	0°	-8°	0.4	DC□□0702	CSTB-2.5S	T-8F	1.2
E10M-SDQCR/L07-D130	●	●	13	10	7.6	150	25	9	2.6	0°	-8°	0.4				
E12J-SDQCR/L07-D160	●		16	12	8.6	110	27	11	2.5	0°	-6°	0.4				
E12Q-SDQCR/L07-D160	●	●	16	12	8.6	180	27	11	2.6	0°	-6°	0.4				
E16L-SDQCR/L07-D200	●		20	16	10.6	130	32	15	2.5	0°	-5°	0.4				
E16R-SDQCR/L07-D200	●	●	20	16	10.6	200	32	15	2.6	0°	-5°	0.4				
E20S-SDQCR/L11-D250	●	●	25	20	13.7	250	36	18	3.7	0°	-7°	0.8	DC□□11T3	CSTB-4S	T-15F	3.0

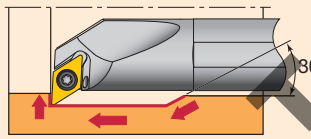
When using a right or left hand insert, the right hand insert (R) is used for the left hand toolholders (SDQCL □□ type), and the left hand insert (L) is used for the right hand toolholders (SDQCR □□ type).

STREAMJETBAR S-type SDUCR/L

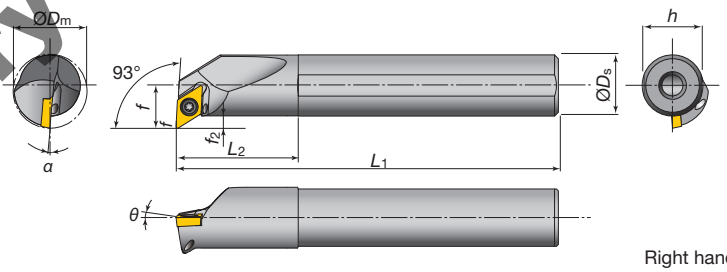
Positive rake / Screw-on system

Min. bore dia. ø13 mm~ | Shank dia. ø10~25 mm | Steel Shank | Carbide Shank

Boring & internal profiling



Cutting edge style **U**



Oil Hole

Right hand (R) shown.

Steel Shank

Toolholder Cat. No.	Stock R	Stock L	Min bore.dia. ØDm	Dimensions (mm) ØDs	f	L_1	L_2	h	f_2	θ	α	Std. corner radius r_ε	Applicable inserts	Parts: Clamping screw	Parts: Wrench	Torque (N·m)
A10K-SDUCR/L07-D130	●	●	13	10	7	125	20	9	2.0	0°	-10°	0.4	DC□□0702	CSTB-2.5S	T-8F	1.2
A12M-SDUCR/L07-D160	●	●	16	12	9.3	150	24	11	3.3	0°	-6°	0.4				
A16Q-SDUCR/L07-D200	●	●	20	16	11.3	180	32	15	3.3	0°	-5°	0.4		CSTB-2.5		
A20R-SDUCR/L11-D270	●	●	27	20	16.1	200	36	18	6.1	0°	-5°	0.8	DC□□11T3	CSTB-4S	T-15F	3.0
A25S-SDUCR/L11-D320	●	●	32	25	18.6	250	45	23	6.1	0°	-4°	0.8				

Carbide Shank

Toolholder Cat. No.	Stock R	Stock L	Min bore.dia. ØDm	Dimensions (mm) ØDs	f	L_1	L_2	h	f_2	θ	α	Std. corner radius r_ε	Applicable inserts	Parts: Clamping screw	Parts: Wrench	Torque (N·m)
E10H-SDUCR/L07-D130	●		13	10	7	100	25	9	1.9	5°	-3.5°	0.4	DC□□0702	CSTB-2.5S	T-8F	1.2
E10M-SDUCR/L07-D130	●	●	13	10	7	150	25	9	2.0	0°	-10°	0.4				
E12J-SDUCR/L07-D160	●		16	12	9.3	110	27	11	3.2	0°	-6°	0.4				
E12Q-SDUCR/L07-D160	●	●	16	12	9.3	180	27	11	3.3	0°	-6°	0.4				
E16L-SDUCR/L07-D200	●		20	16	11.3	130	32	15	3.2	0°	-5°	0.4				
E16R-SDUCR/L07-D200	●	●	20	16	11.3	200	32	15	3.3	0°	-5°	0.4		CSTB-2.5		
E20S-SDUCR/L11-D270	●		27	20	16.1	250	36	18	6.1	0°	-5°	0.8	DC□□11T3	CSTB-4S	T-15F	3.0

When using a right or left hand insert, the right hand insert (R) is used for the left hand toolholders (SDUCL type), and the left hand insert (L) is used for the right hand toolholders (SDUCR type).

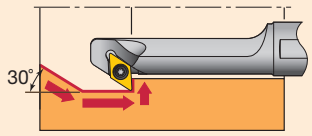
● : Stocked items.

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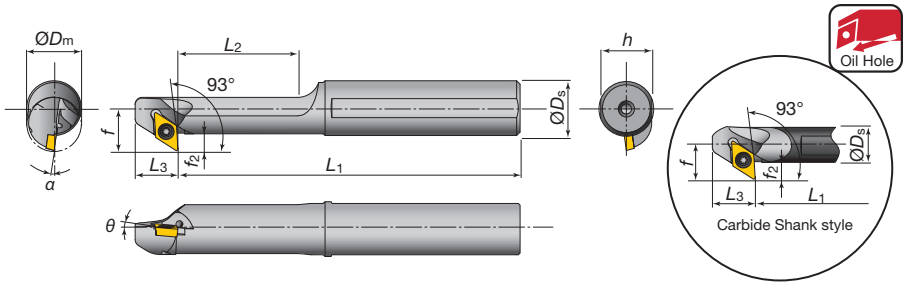
SDZCR/L

Min. bore dia. ø14 mm~ | Shank dia. ø12~25 mm | Steel Shank | Carbide Shank

Internal retracting



Cutting edge style **Z**



Right hand (R) shown.

Steel Shank

Toolholder Cat. No.	Stock R	Stock L	Min bore.dia. ØDm	ØDs	f	L1	L2	L3	h	f2	θ	α	Std. corner radius rε	Applicable inserts	Parts: Clamping screw	Parts: Wrench	Torque (N·m)
A12M-SDZCR/L07-D140	●	●	14	12	10.5	150	30	12.5	11	4.5	0°	-9°	0.4	DC□□0702	CSTB-2.5	T-8F	1.2
A16Q-SDZCR/L07-D160	●	●	16	16	12.5	180	35	12.5	15	4.5	0°	-8°	0.4				
A20R-SDZCR/L11-D200	●	●	20	20	15.5	200	40	15	18	5.5	0°	-8°	0.8	DC□□11T3	CSTB-4S	T-15F	3.0
A25S-SDZCR/L11-D250	●	●	25	25	18	250	50	15	23	5.5	0°	-6°	0.8				

Carbide Shank

Toolholder Cat. No.	Stock R	Stock L	Min bore.dia. ØDm	ØDs	f	L1	L2	L3	h	f2	θ	α	Std. corner radius rε	Applicable inserts	Parts: Clamping screw	Parts: Wrench	Torque (N·m)
E12Q-SDZCR/L07-D180	●	●	18	12	10.5	180	-	12.5	11	4.5	0°	-8°	0.4	DC□□0702	CSTB-2.5	T-8F	1.2
E16R-SDZCR/L07-D220	●	●	22	16	12.5	200	-	12.5	15	4.5	0°	-6°	0.4				

When using a right or left hand insert, the right hand insert (R) is used for the right hand toolholders (SDZCR □□ type), and the left hand insert (L) is used for the left hand toolholders (SDZCL □□ type).

Basic Selection Chipbreakers DC□□11T3□□-□□

	Operation	Precision finishing	Finishing	Finishing to medium cutting	Medium cutting
P Steel	Grade	**SH730**	**AH725**	**T9115**	**T9125**
	Page	2-108	2-105	2-106	2-109
	Chipbreaker	**JS**	**PSF**	**PS**	**PM**
Continuous	*Vc* (m/min)	**120** (50-180)	**120** (50-180)	**180** (120-250)	**180** (120-250)
	ap (mm)	**1.5** (0.1-3.0)	**0.3** (0.1-0.5)	**3.0** (0.5-2.5)	**2.0** (1.0-3.0)
	f (mm/rev)	**0.06** (0.02-0.1)	**0.12** (0.08-0.2)	**0.15** (0.08-0.3)	**0.25** (0.07-0.3)
	*r*ε (mm)	0.2	0.4	0.8	0.8

	Operation	Precision finishing	Finishing	Finishing to light cutting	Medium cutting
M Stainless	Grade	**GH330**	**AH725**	**AH725**	**T6130**
	Page	2-105	2-105	2-106	2-109
	Chipbreaker	**W15**	**PSF**	**PSS**	**PM**
Continuous	*Vc* (m/min)	**120** (100-150)	**120** (50-150)	**120** (50-150)	**120** (70-150)
	ap (mm)	**0.5** (0.05-2.0)	**0.3** (0.1-0.5)	**1.2** (0.3-2.0)	**2.0** (1.0-3.0)
	f (mm/rev)	**0.1** (0.03-0.15)	**0.12** (0.08-0.2)	**0.15** (0.08-0.3)	**0.25** (0.07-0.3)
	*r*ε (mm)	0.4	0.4	0.8	0.8

	Operation	Precision finishing	Finishing	Finishing to medium cutting	Medium cutting
K Cast Iron	Grade	**BX930**	**TH10**	**T5115**	**T5115**
	Page	3-14	2-105	2-106	2-110
	Chipbreaker	**T-CBN**	**W15**	**CM**	**No chipbreaker**
Continuous	*Vc* (m/min)	**700** (300-1200)	**70** (30-100)	**270** (140-400)	**270** (140-400)
	ap (mm)	**0.3** (0.05-0.5)	**0.5** (0.5-2.0)	**1.0** (0.05-2.0)	**1.0** (0.05-2.0)
	f (mm/rev)	**0.1** (0.05-0.2)	**0.1** (0.03-0.15)	**0.2** (0.05-0.3)	**0.2** (0.05-0.3)
	*r*ε (mm)	0.4	0.4	0.8	0.8

	Operation	Precision finishing	Finishing	Finishing
N Non-ferrous	Grade	**DX120**	**TH10**	**KF05F**
	Page	3-22	2-105	2-106
	Chipbreaker	**T-DIA** With chipbreaker	**W15**	**AL**
Continuous	*Vc* (m/min)	**1500** (500-2500)	**600** (100-1000)	**400** (200-1500)
	ap (mm)	**0.1** (0.03-0.5)	**1.0** (0.5-2.0)	**2.0** (1.0-5.0)
	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

	Operation	Precision finishing	Finishing
S Superalloys	Grade	**BX470**	**BX950**
	Page	3-12	3-14
	Chipbreaker	**T-CBN**	**T-CBN**
Continuous	*Vc* (m/min)	**200** (100-280)	**200** (70-300)
	ap (mm)	**0.1** (0.05-0.5)	**0.3** (0.1-0.5)
	f (mm/rev)	**0.1** (0.05-0.3)	**0.1** (0.05-0.3)
	*r*ε (mm)	0.4	0.4

	Operation	Precision finishing	Finishing
H Hard Materials	Grade	**BXM10**	**BXM20**
	Page	3-12	3-12
	Chipbreaker	**T-CBN**	**T-CBN**
Continuous	*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"
2-16~

● : Stocked items.

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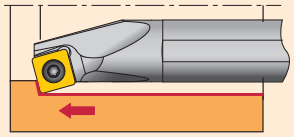
SSKPR/L

Min. bore dia. ø20 mm~

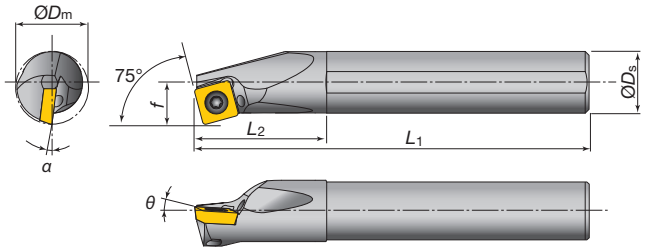
Shank dia. ø16~25 mm

Steel Shank

Through boring



Cutting edge style **K**



Oil Hole

Right hand (R) shown.

Steel Shank

Toolholder Cat. No.	Stock R	Stock L	Min bore.dia. ØDm	ØDs	f	L1	L2	h	f2	θ	a	Std. corner radius rε	Applicable inserts	Parts: Clamping screw	Parts: Wrench	Torque (N·m)
A16Q-SSKPR/L09-D200	●		20	16	11	180	32	15	-	+5°	-6°	0.8	SP□□0903	CSTB-4L060	T-15F	3.0
A20R-SSKPR/L09-D240	●		24	20	13	200	36	18	-	+5°	-2°	0.8				
A25S-SSKPR/L12-D310	●		31	25	17	250	45	23	-	+5°	-2°	0.8	SP□□1204	CSTB-5S	T-20F	6.0

When using a right or left hand insert, the right hand insert (R) is used for the left hand toolholders (SSKPL □□ type), and the left hand insert (L) is used for the right hand toolholders (SSKPR □□ type).

Basic Selection Chipbreakers SP□□0903□□-□□

	Operation	Precision finishing	Finishing	Finishing to medium cutting	Medium cutting
P Steel	Grade	NS530	GT730	T9115	T9125
	Page	2-114	2-114	2-114	2-114
	Chipbreaker	W15 	PS 	PS 	PS 
Continuous	Vc (m/min)	**200** (150-250)	**200** (150-300)	**220** (150-300)	**180** (120-250)
	ap (mm)	**0.5** (0.05-2.0)	**1.5** (0.5-2.5)	**1.5** (0.5-2.5)	**1.5** (0.5-3.0)
	f (mm/rev)	**0.1** (0.03-0.15)	**0.15** (0.08-0.3)	**0.15** (0.08-0.3)	**0.15** (0.08-0.3)
	rε (mm)	0.4	0.4	0.8	0.8

	Operation	Finishing	Finishing to medium cutting
M Stainless	Grade	T6120	T6130
	Page	2-114	2-114
	Chipbreaker	PS 	PS 
Continuous	Vc (m/min)	**150** (100-200)	**120** (70-150)
	ap (mm)	**1.5** (0.5-2.5)	**1.5** (0.5-2.5)
	f (mm/rev)	**0.15** (0.08-0.3)	**0.15** (0.08-0.3)
	rε (mm)	0.4	0.4

	Operation	Finishing	Finishing to medium cutting	Medium cutting
K Cast Iron	Grade	TH10	T5115	T5115
	Page	2-114	2-114	2-115
	Chipbreaker	W15 	CM 	No chipbreaker 
Continuous	Vc (m/min)	**70** (30-100)	**270** (140-400)	**270** (140-400)
	ap (mm)	**0.5** (0.05-2.0)	**1.0** (0.05-2.0)	**1.0** (0.05-2.0)
	f (mm/rev)	**0.1** (0.03-0.15)	**0.2** (0.05-0.3)	**0.2** (0.05-0.3)
	rε (mm)	0.4	0.8	0.8

For other machining types, see "Selection System"
2-16~

● : Stocked items.

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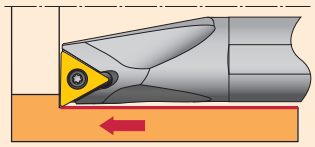
STFCR/L

Min. bore dia. ø10 mm~

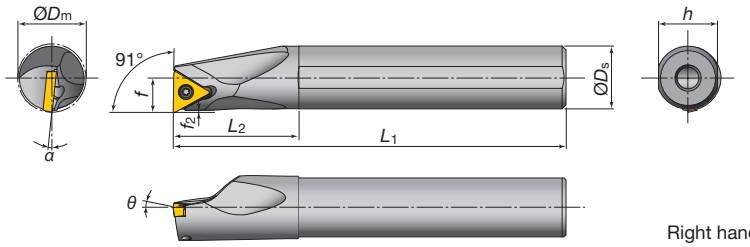
Shank dia. ø8~25 mm

Steel Shank | Carbide Shank

Blind hole boring



Cutting edge style **F**



Oil Hole

Right hand (R) shown.

Steel Shank

Toolholder Cat. No.	Stock R	Stock L	Min bore.dia. ØDm	ØDs	f	L1	L2	h	f2	θ	a	Std. corner radius rε	Applicable inserts	Parts: Clamping screw	Parts: Wrench	Torque (N·m)
A08H-STFCR/L09-D100			10	8	5.5	100	16	7.5	0.6	0°	-12°	0.4	TC□□0902	CSTB-2.2S	T-7F	0.9
A10K-STFCR/L09-D120			12	10	6.5	125	20	9	0.6	0°	-10°	0.4				
A10K-STFCR/L1102-D120			12	10	6.5	125	20	9	0.6	0°	-10°	0.4	TC□□1102	CSTB-2.5	T-8F	1.2
A10K-STFCR/L1103-D120	●	●	12	10	6.5	125	20	9	0.6	0°	-13°	0.4	TC□□1103	CSTB-2.5	T-8F	1.2
A12M-STFCR/L09-D140			14	12	7	150	24	11	0.5	0°	-8°	0.4	TC□□0902	CSTB-2.2	T-7F	0.9
A12M-STFCR/L1102-D140			14	12	7	150	24	11	0.5	0°	-8°	0.4	TC□□1102	CSTB-2.5	T-8F	1.2
A12M-STFCR/L1103-D140	●	●	14	12	7	150	24	11	0.5	0°	-10°	0.4	TC□□1103	CSTB-2.5	T-8F	1.2
A16Q-STFCR/L09-D180			18	16	9	180	32	15	0.6	0°	-6°	0.4	TC□□0902	CSTB-2.2	T-7F	0.9
A16Q-STFCR/L1102-D180			18	16	9	180	32	15	0.6	0°	-6°	0.4	TC□□1102	CSTB-2.5	T-8F	1.2
A16Q-STFCR/L1103-D180	●	●	18	16	9	180	32	15	0.5	0°	-7°	0.4	TC□□1103	CSTB-2.5	T-8F	1.2
A20R-STFCR/L1102-D220			22	20	11	200	36	18	0.5	0°	-4°	0.4	TC□□1102	CSTB-2.5	T-8F	1.2
A20R-STFCR/L16-D220			22	20	11	200	36	18	0.4	0°	-7°	0.8	TC□□16T3	CSTB-4M	T-15F	3.0
A25S-STFCR/L16-D270			27	25	13.5	250	45	23	0.4	0°	-5°	0.8				

Carbide Shank

Toolholder Cat. No.	Stock R	Stock L	Min bore.dia. ØDm	ØDs	f	L1	L2	h	f2	θ	a	Std. corner radius rε	Applicable inserts	Parts: Clamping screw	Parts: Wrench	Torque (N·m)
E08K-STFCR/L09-D100			10	8	5.5	125	22	7.5	0.6	0°	-12°	0.4	TC□□0902	CSTB-2.2S	T-7F	0.9
E10M-STFCR/L09-D120			12	10	6.5	150	25	9	0.6	0°	-10°	0.4				
E10M-STFCR/L1102-D120			12	10	6.5	150	25	9	0.6	0°	-10°	0.4	TC□□1102	CSTB-2.5	T-8F	1.2
E10M-STFCR/L1103-D120	●	●	12	10	6.5	150	25	9	0.7	0°	-13°	0.4	TC□□1103	CSTB-2.5	T-8F	1.2
E12Q-STFCR/L09-D140			14	12	7	180	27	11	0.6	0°	-8°	0.4	TC□□0902	CSTB-2.2	T-7F	0.9
E12Q-STFCR/L1102-D140			14	12	7	180	27	11	0.6	0°	-8°	0.4	TC□□1102	CSTB-2.5	T-8F	1.2
E12Q-STFCR/L1103-D140	●	●	14	12	7	180	27	11	0.5	0°	-10°	0.4	TC□□1103	CSTB-2.5	T-8F	1.2
E16R-STFCR/L09-D180			18	16	9	200	32	15	0.6	0°	-6°	0.4	TC□□0902	CSTB-2.2	T-7F	0.9
E16R-STFCR/L1102-D180			18	16	9	200	32	15	0.6	0°	-6°	0.4	TC□□1102	CSTB-2.5	T-8F	1.2
E16R-STFCR/L1103-D180	●	●	18	16	9	200	32	15	0.5	0°	-7°	0.4	TC□□1103	CSTB-2.5	T-8F	1.2
E20S-STFCR/L1102-D220			22	20	11	250	36	18	0.6	0°	-4°	0.4	TC□□1102	CSTB-2.5	T-8F	1.2
E20S-STFCR/L16-D220			22	20	11	250	36	18	0.6	0°	-7°	0.8	TC□□16T3	CSTB-4M	T-15F	3.0
E25T-STFCR/L16-D270			27	25	13.5	300	45	23	0.5	0°	-5°	0.8				

When using a right or left hand insert, the right hand insert (R) is used for the left hand toolholders (STFCL □□ type), and the left hand insert (L) is used for the right hand toolholders (STFCR □□ type).

Basic Selection Chipbreakers TC□□1102□□-□□

	Operation	Precision finishing	Finishing	Finishing to medium cutting	Medium cutting
P Steel	Grade	SH730	AH725	T9115	T9125
	Page	2-120	2-118	2-119	2-122
	Chipbreaker	JS	PSF	PS	PM
	Vc (m/min)	**120** (50-180)	**120** (50-180)	**220** (150-300)	**180** (120-250)
Continuous	ap (mm)	**1.5** (0.1-3.0)	**0.3** (0.1-0.5)	**1.5** (0.5-2.5)	**2.0** (1.0-3.0)
	f (mm/rev)	**0.06** (0.02-0.1)	**0.12** (0.08-0.2)	**0.15** (0.08-0.3)	**0.25** (0.07-0.3)
	rε (mm)	0.2	0.4	0.8	0.8

	Operation	Finishing	Finishing to light cutting	Medium cutting
M Stainless	Grade	AH725	AH725	T6130
	Page	2-118	2-118	2-122
	Chipbreaker	PSF	PSS	PM
	Vc (m/min)	**120** (50-150)	**120** (50-150)	**120** (70-150)
Continuous	ap (mm)	**0.3** (0.1-0.5)	**1.2** (0.3-2.0)	**1.5** (1.0-3.0)
	f (mm/rev)	**0.12** (0.08-0.2)	**0.15** (0.08-0.3)	**0.25** (0.07-0.3)
	rε (mm)	0.4	0.8	0.8

	Operation	Precision finishing	Finishing to medium cutting
N Non-ferrous	Grade	DX120	KS05F
	Page	3-22	2-120
	Chipbreaker	T-DIA With chipbreaker	AL
	Vc (m/min)	**1500** (500-2500)	**400** (200-1500)
Continuous	ap (mm)	**0.3** (0.03-0.5)	**2.0** (1.0-5.0)
	f (mm/rev)	**0.1** (0.05-0.2)	**0.3** (0.2-0.5)
	rε (mm)	0.4	0.8

For other machining types, see "Selection System"

2-16~

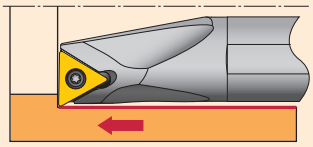
● : Stocked items.

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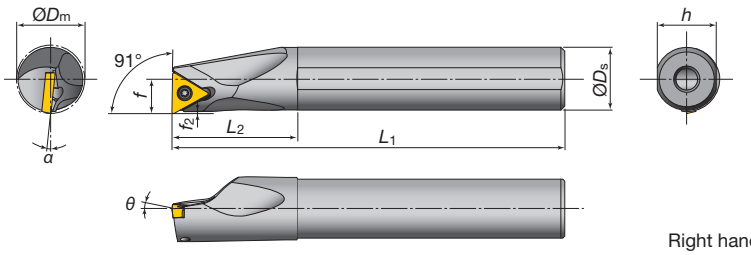
STFPR/L

Min. bore dia. ø10 mm~ | Shank dia. ø8~25 mm | Steel Shank | Carbide Shank

Blind hole boring



Cutting edge style **F**



Oil Hole

Right hand (R) shown.

Steel Shank

Toolholder Cat. No.	Stock R	Stock L	Min bore.dia. ØDm	ØDs	f	L1	L2	h	f2	θ	α	Std. corner radius rε	Applicable inserts	Parts: Clamping screw	Parts: Wrench	Torque (N·m)
A08H-STFPR/L09-D100	●	●	10	8	5.5	100	16	7.5	0.7	+5°	-8°	0.4	TP□□0902*	CSTB-2.2S	T-7F	0.9
A10K-STFPR/L1102-D120	●	●	12	10	6.5	125	20	9	0.7	+5°	-6°	0.4	TP□□1102*	CSTB-2.5B	T-8F	1.2
A10K-STFPR/L1103-D120			12	10	6.5	125	20	9	0.7	+5°	-7°	0.4	TP□□1103*	CSTB-3L050	T-9F	1.4
A12M-STFPR/L1102-D140	●	●	14	12	7	150	24	11	0.6	+5°	-4°	0.4	TP□□1102*	CSTB-2.5	T-8F	1.2
A12M-STFPR/L1103-D140			14	12	7	150	24	11	0.6	+5°	-4°	0.4	TP□□1103*	CSTB-3S	T-9F	1.4
A16Q-STFPR/L1103-D180			18	16	9	180	32	15	0.7	+5°	-2°	0.4				
A16Q-STFPR/L13-D180	●	●	18	16	9	180	32	15	0.7	+5°	-2°	0.4	TP□□1303*	CSTB-3S	T-9F	1.4
A20R-STFPR/L13-D220	●		22	20	11	200	36	18	0.8	+5°	-2°	0.4		CSTB-3		
A25S-STFPR/L16-D270	●		27	25	13.5	250	45	23	0.6	+5°	-1°	0.4	TP□□16T3*	CSTB-4M	T-15F	3.0

Carbide Shank

Toolholder Cat. No.	Stock R	Stock L	Min bore.dia. ØDm	ØDs	f	L1	L2	h	f2	θ	α	Std. corner radius rε	Applicable inserts	Parts: Clamping screw	Parts: Wrench	Torque (N·m)
E08K-STFPR/L09-D100	●	●	10	8	5.5	125	22	7.5	0.7	+5°	-8°	0.4	TP□□0902*	CSTB-2.2S	T-7F	0.9
E10M-STFPR/L1102-D120	●	●	12	10	6.5	150	25	9	0.7	+5°	-6°	0.4	TP□□1102*	CSTB-2.5B	T-8F	1.2
E10M-STFPR/L1103-D120			12	10	6.5	150	25	9	0.7	+5°	-7°	0.4	TP□□1103*	CSTB-3L050	T-9F	1.4
E12Q-STFPR/L1102-D140	●	●	14	12	7	180	27	11	0.6	+5°	-4°	0.4	TP□□1102*	CSTB-2.5	T-8F	1.2
E12Q-STFPR/L1103-D140			14	12	7	180	27	11	0.6	+5°	-4°	0.4	TP□□1103*	CSTB-3S	T-9F	1.4
E16R-STFPR/L1103-D180			18	16	9	200	32	15	0.7	+5°	-2°	0.4				
E16R-STFPR/L13-D180	●		18	16	9	200	32	15	0.7	+5°	-2°	0.4	TP□□1303*	CSTB-3S	T-9F	1.4
E20S-STFPR/L13-D220	●		22	20	11	250	36	18	0.8	+5°	-2°	0.4		CSTB-3		

When using a right or left hand insert, the right hand insert (R) is used for the left hand toolholders (STFPL □□ type), and the left hand insert (L) is used for the right hand toolholders (STFPR □□ type).
* Inserts of TPGH, TPGM and TPGA are not applicable.

Basic Selection Chipbreakers TP□□1102□□-□□

	Operation	Precision finishing	Finishing	Finishing to medium cutting	Medium cutting
P Steel	Grade	NS730	AH725	T9115	T9125
	Page	2-123	2-128	2-126	2-128
	Chipbreaker	01	PSF	PS	PM
Continuous	Vc (m/min)	200 (150-250)	120 (50-180)	180 (120-250)	180 (120-250)
	ap (mm)	0.5 (0.05-0.5)	0.3 (0.1-0.5)	3.0 (0.5-2.5)	2.0 (1.0-3.0)
	f (mm/rev)	0.1 (0.03-0.15)	0.12 (0.08-0.2)	0.15 (0.08-0.3)	0.25 (0.07-0.3)
	rε (mm)	0.4	0.4	0.8	0.8

	Operation	Precision finishing	Finishing	Finishing to light cutting	Medium cutting
M Stainless	Grade	GH330	AH725	AH725	T6130
	Page	2-124	2-123	2-125	2-128
	Chipbreaker	W15	PSF	PSS	PM
Continuous	Vc (m/min)	120 (100-150)	120 (50-150)	120 (50-150)	120 (70-150)
	ap (mm)	0.5 (0.05-2.0)	0.3 (0.1-0.5)	1.2 (0.3-2.0)	2.0 (1.0-3.0)
	f (mm/rev)	0.1 (0.03-0.15)	0.12 (0.08-0.2)	0.15 (0.08-0.3)	0.25 (0.07-0.3)
	rε (mm)	0.4	0.4	0.8	0.8

	Operation	Precision finishing	Finishing to medium cutting	Medium cutting
K Cast Iron	Grade	BX930	T5115	T5115
	Page	3-14	2-126	2-128
	Chipbreaker	T-CBN	CM	No chipbreaker
Continuous	Vc (m/min)	700 (300-1200)	270 (140-400)	270 (140-400)
	ap (mm)	0.3 (0.05-0.5)	1.0 (0.05-2.0)	1.0 (0.05-2.0)
	f (mm/rev)	0.1 (0.05-0.2)	0.2 (0.05-0.3)	0.2 (0.05-0.3)
	rε (mm)	0.4	0.8	0.8

	Operation	Precision finishing	Finishing
N Non-ferrous	Grade	DX140	GH110
	Page	3-22	2-124
	Chipbreaker	T-DIA	W15
Continuous	Vc (m/min)	1500 (500-2500)	600 (100-1000)
	ap (mm)	0.5 (0.05-1.0)	1.0 (0.5-2.0)
	f (mm/rev)	0.1 (0.05-0.2)	0.1 (0.03-0.15)
	rε (mm)	0.4	0.4

	Operation	Precision finishing	Finishing
S Superalloys	Grade	BX470	BX950
	Page	3-12	3-14
	Chipbreaker	T-CBN	T-CBN
Continuous	Vc (m/min)	200 (100-280)	200 (70-300)
	ap (mm)	0.1 (0.05-0.5)	0.3 (0.1-0.5)
	f (mm/rev)	0.1 (0.05-0.3)	0.1 (0.05-0.3)
	rε (mm)	0.4	0.4

	Operation	Precision finishing	Finishing
H Hard Materials	Grade	BXM10	BXM20
	Page	3-12	3-12
	Chipbreaker	T-CBN	T-CBN
Continuous	Vc (m/min)	200 (150-350)	150 (70-220)
	ap (mm)	0.1 (0.05-0.3)	0.2 (0.05-0.3)
	f (mm/rev)	0.1 (0.03-0.18)	0.1 (0.05-0.25)
	rε (mm)	0.4	0.4

● : Stocked items.

For other machining types, see "Selection System"

2-16~

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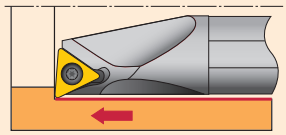
STUPR/L

Min. bore dia. ø8 mm~

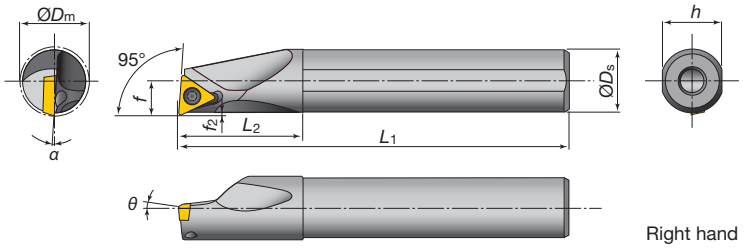
Shank dia. ø7~32 mm

Steel Shank | Carbide Shank

Boring



Cutting edge style **U**



Oil Hole

Right hand (R) shown.

Steel Shank

Toolholder Cat. No.	Stock		Min bore.dia.	Dimensions (mm)								Std. corner radius	Applicable inserts	Parts		Torque (N·m)
	R	L	ØDm	ØDs	f	L_1	L_2	h	f_2	θ	α	r_ε		Clamping screw	Wrench	
MINI A07G-STUPR/L07-D080	●	●	8	7	4	90	12	6.75	0.4	+5°	-10°	0.4	TP□□0701	CSTB-2.2L038	T-7F	0.9
A08H-STUPR/L07-D080	●	●	8	8	4	100	19.5	7.5	0.5	+5°	-10°	0.4	TP□□0701	CSTB-2.2L038	T-7F	0.9
A08H-STUPR/L09-D100	●	●	10	8	5.5	100	16	7.5	0.6	+5°	-8°	0.4	TP□□0902*	CSTB-2.2L038	T-7F	0.9
A10F-STUPR/L1102-D120	●		12	10	6.5	80	20	9	1.4	+5°	-6°	0.4	TP□□1102*	CSTB-2.5S	T-8F	1.2
A10K-STUPR/L1102-D120	●	●	12	10	6.5	125	20	9	0.7	+5°	-6°	0.4				
A10K-STUPR/L1103-D120	●	●	12	10	6.5	125	20	9	0.6	+5°	-10°	0.4	TP□□1103*	CSTB-3L050	T-9F	1.4
A12H-STUPR/L1102-D140	●		14	12	7	100	24	11	0.9	+5°	-4°	0.4	TP□□1102*	CSTB-2.5B	T-8F	1.2
A12M-STUPR/L1102-D140	●	●	14	12	7	150	24	11	0.7	+5°	-4°	0.4				
A12M-STUPR/L1103-D140	●	●	14	12	7	150	24	11	0.6	+5°	-6°	0.4	TP□□1103*	CSTB-3L050	T-9F	1.4
A12H-STUPR/L1102-D160	●		16	12	9	100	24	11	0.6	+5°	-3°	0.4	TP□□1102*	CSTB-2.5B	T-8F	1.2
A12M-STUPR/L1102-D160	●	●	16	12	9	150	24	11	0.6	+5°	-3°	0.4				
A16K-STUPR/L13-D180	●		18	16	9	125	32	15	0.9	+5°	-3°	0.4	TP□□1303*	CSTB-3S	T-9F	1.4
A16Q-STUPR/L1103-D180	●	●	18	16	9	180	32	15	0.8	+5°	-4°	0.4	TP□□1103*	CSTB-3S	T-9F	1.4
A16Q-STUPR/L13-D180	●	●	18	16	9	180	32	15	0.6	+5°	-3°	0.4	TP□□1303*	CSTB-3S	T-9F	1.4
A16K-STUPR/L13-D200	●		20	16	11	125	32	15	0.6	+5°	-3°	0.4	TP□□1303*	CSTB-3S	T-9F	1.4
A16Q-STUPR/L13-D200	●	●	20	16	11	180	32	15	0.6	+5°	-3°	0.4				
A20R-STUPR/L1103-D220	●	●	22	20	11	200	36	18	0.7	+5°	-2°	0.4	TP□□1103*			
A20R-STUPR/L13-D220	●	●	22	20	11	200	36	18	0.7	+5°	-2°	0.4	TP□□1303*	CSTB-3	T-9F	1.4
A25S-STUPR/L16-D270	●	●	27	25	13.5	250	45	23	0.5	+5°	-1°	0.8	TP□□16T3*	CSTB-4M	T-15F	3.0
A32T-STUPR/L16-D340	●	●	34	32	17	300	50	30	0.7	+5°	0°	0.8				

Carbide Shank

Toolholder Cat. No.	Stock		Min bore.dia.	Dimensions (mm)								Std. corner radius	Applicable inserts	Parts		Torque (N·m)
	R	L	ØDm	ØDs	f	L_1	L_2	h	f_2	θ	α	r_ε		Clamping screw	Wrench	
MINI E07H-STUPR/L07-D080	●	●	8	7	4	100	14	6.75	0.3	+5°	-10°	0.4	TP□□0701	CSTB-2.2L038	T-7F	0.9
E08G-STUPR/L07-D080	●		8	8	4	90	44.5	7.5	0.5	+5°	-10°	0.4	TP□□0701	CSTB-2.2L038	T-7F	0.9
E08K-STUPR/L07-D080	●	●	8	8	4	125	44.5	7.5	0.5	+5°	-10°	0.4				
E08G-STUPR/L09-D100	●		10	8	5.5	90	22	7	0.6	+5°	-8°	0.4	TP□□0902*	CSTB-2.2L038	T-7F	0.9
E08K-STUPR/L09-D100	●	●	10	8	5.5	125	22	7	0.6	+5°	-8°	0.4				
E10F-STUPR/L1102-D120	●		12	10	6.5	80	25	9	0.5	+5°	-6°	0.4	TP□□1102*	CSTB-2.5S	T-8F	1.2
E10H-STUPR/L1102-D120	●		12	10	6.5	100	25	9	0.6	+5°	-6°	0.4				
E10M-STUPR/L1102-D120	●	●	12	10	6.5	150	25	9	0.6	+5°	-6°	0.4				
E10M-STUPR/L1103-D120	●	●	12	10	6.5	150	25	9	0.7	+5°	-10°	0.4	TP□□1103*	CSTB-3L050	T-9F	1.4
E12G-STUPR/L1102-D140	●		14	12	7	90	27	11	0.9	+5°	-4°	0.4	TP□□1102*	CSTB-2.5S	T-8F	1.2
E12J-STUPR/L1102-D140	●		14	12	7	110	27	11	0.6	+5°	-4°	0.4		CSTB-2.5B	T-8F	1.2
E12Q-STUPR/L1102-D140	●	●	14	12	7	180	27	11	0.6	+5°	-4°	0.4				
E12Q-STUPR/L1103-D140	●	●	14	12	7	180	27	11	0.7	+5°	-6°	0.4	TP□□1103*	CSTB-3L050	T-9F	1.4
E12G-STUPR/L1102-D160	●		16	12	9	90	27	11	0.6	+5°	-3°	0.4	TP□□1102*	CSTB-2.5B	T-8F	1.2
E12J-STUPR/L1102-D160	●		16	12	9	110	27	11	0.6	+5°	-3°	0.4				
E12Q-STUPR/L1102-D160	●	●	16	12	9	180	27	11	0.6	+5°	-3°	0.4				
E16H-STUPR/L13-D180	●		18	16	9	100	32	15	0.9	+5°	-3°	0.4	TP□□1303*	CSTB-3S	T-9F	1.4
E16R-STUPR/L1103-D180	●	●	18	16	9	200	32	15	0.8	+5°	-4°	0.4	TP□□1103*	CSTB-3S	T-9F	1.4
E16L-STUPR/L13-D180	●		18	16	9	130	32	15	0.6	+5°	-3°	0.4	TP□□1303*	CSTB-3S	T-9F	1.4
E16R-STUPR/L13-D180	●	●	18	16	9	200	32	15	0.6	+5°	-3°	0.4				
E16H-STUPR/L13-D200	●		20	16	11	100	32	15	0.6	+5°	-3°	0.4				
E16L-STUPR/L13-D200	●		20	16	11	130	32	15	0.6	+5°	-3°	0.4				
E16R-STUPR/L13-D200	●	●	20	16	11	200	32	15	0.6	+5°	-3°	0.4				
E20S-STUPR/L1103-D220	●		22	20	11	250	36	18	0.7	+5°	-2°	0.4	TP□□1103*	CSTB-3S	T-9F	1.4
E20S-STUPR/L13-D220	●		22	20	11	250	36	18	0.6	+5°	-2°	0.4	TP□□1303*	CSTB-3	T-9F	1.4
E25T-STUPR/L16-D270	●		27	25	13.5	300	45	23	0.5	+5°	-1°	0.8	TP□□16T3*	CSTB-4M	T-15F	3.0

When using a right or left hand insert, the right hand insert (R) is used for the left hand toolholders (STUPL □□ type), and the left hand insert (L) is used for the right hand toolholders (STUPR □□ type).

* Inserts of TPGH, TPGM and TPGA are not applicable.

● : Stocked items.

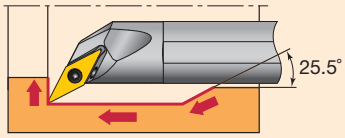
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STREAMJETBAR S-type SVQBR/L

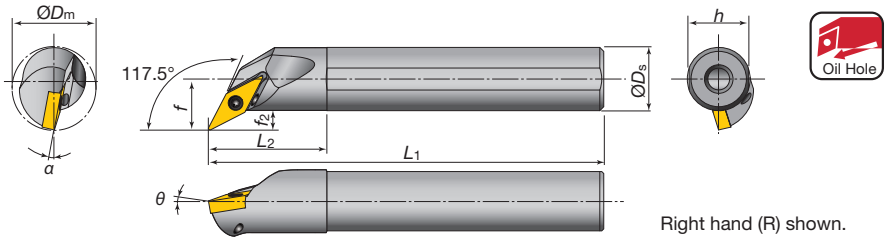
Positive rake / Screw-on system

Min. bore dia. ø17 mm~ | Shank dia. ø12~25 mm | Steel Shank | Carbide Shank

Boring & internal profiling



Cutting edge style **F**



Right hand (R) shown.

Steel Shank

Toolholder Cat. No.	Stock R	Stock L	Min bore.dia. ØDm	Dimensions (mm) ØDs	f	L1	L2	h	f2	θ	a	Std. corner radius rε	Applicable inserts	Parts Clamping screw	Parts Wrench	Torque (N·m)
A12M-SVQBR/L11-D170	●	●	17	12	10.5	150	24	11	4.5	-5°	-10°	0.4	VB□□1103	CSTB-2.5	T-8F	1.2
A16Q-SVQBR/L11-D215	●	●	21.5	16	13	180	30	15	5	-5°	-8°	0.4				
A20R-SVQBR/L11-D255	●	●	25.5	20	15	200	36	18	5	-5°	-6°	0.4				
A25S-SVQBR/L16-D305	●	●	30.5	25	17.5	250	45	23	5	-5°	-8°	0.8	VB□□1604	CSTB-3.5	T-15F	3.0

Carbide Shank

Toolholder Cat. No.	Stock R	Stock L	Min bore.dia. ØDm	Dimensions (mm) ØDs	f	L1	L2	h	f2	θ	a	Std. corner radius rε	Applicable inserts	Parts Clamping screw	Parts Wrench	Torque (N·m)
E12Q-SVQBR/L11-D170	●	●	17	12	10.5	180	27	11	4.5	-5°	-10°	0.4	VB□□1103	CSTB-2.5	T-8F	1.2
E16R-SVQBR/L11-D215	●	●	21.5	16	13	200	32	15	5	-5°	-8°	0.4				
E20S-SVQBR/L11-D255	●	●	25.5	20	15	250	36	18	5	-5°	-6°	0.4				
E25T-SVQBR/L16-D305	●	●	30.5	25	17.5	300	45	23	5	-5°	-8°	0.8	VB□□1604	CSTB-3.5	T-15F	3.0

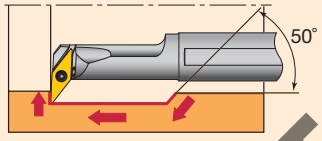
When using a right or left hand insert, the right hand insert (R) is used for the left hand toolholders (SVQBL type), and the left hand insert (L) is used for the right hand toolholders (SVQBR type).

STREAMJETBAR S-type SVUBR/L

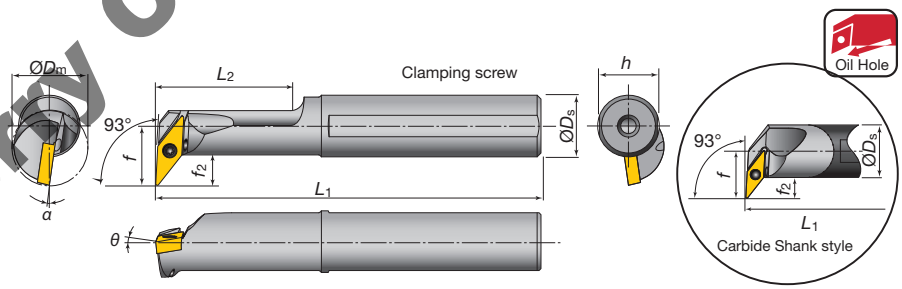
Positive rake / Screw-on system

Min. bore dia. ø20 mm~ | Shank dia. ø16~25 mm | Steel Shank | Carbide Shank

Boring & internal profiling



Cutting edge style **U**



Right hand (R) shown.

Steel Shank

Toolholder Cat. No.	Stock R	Stock L	Min bore.dia. ØDm	Dimensions (mm) ØDs	f	L1	L2	h	f2	θ	a	Std. corner radius rε	Applicable inserts	Parts Clamping screw	Parts Wrench	Torque (N·m)
A16Q-SVUBR/L11-D200	●	●	20	16	15.5	180	35	15	8	0°	-8°	0.4	VB□□1103	CSTB-2.5	T-8F	1.2
A20R-SVUBR/L11-D250	●	●	25	20	17.5	200	40	19	8	0°	-7°	0.4				
A25S-SVUBR/L16-D320	●	●	32	25	20.5	250	50	23	8.5	0°	-6°	0.8	VB□□1604	CSTB-3.5	T-15F	3.0

Carbide Shank

Toolholder Cat. No.	Stock R	Stock L	Min bore.dia. ØDm	Dimensions (mm) ØDs	f	L1	L2	h	f2	θ	a	Std. corner radius rε	Applicable inserts	Parts Clamping screw	Parts Wrench	Torque (N·m)
E16R-SVUBR/L11-D245	●	●	24.5	16	16	200	-	15	8	0°	-8°	0.4	VB□□1103	CSTB-2.5	T-8F	1.2
E20S-SVUBR/L11-D285	●	●	28.5	20	18	250	-	19	8	0°	-7°	0.4				
E25T-SVUBR/L16-D340	●	●	34	25	21	300	-	23	8.5	0°	-6°	0.8	VB□□1604	CSTB-3.5	T-15F	3.0

When using a right or left hand insert, the right hand insert (R) is used for the left hand toolholders (SVUBL □□ type), and the left hand insert (L) is used for the right hand toolholders (SVUBR □□ type).

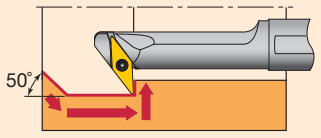
● : Stocked items.

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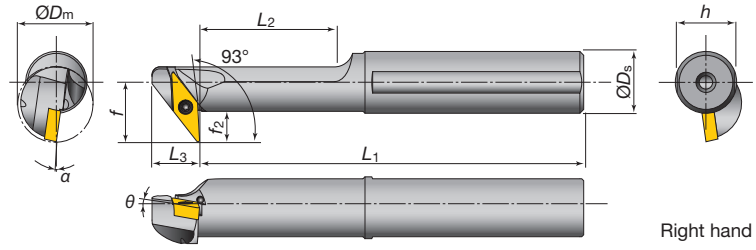
SVZBR/L

Min. bore dia. ø20 mm~ | Shank dia. ø16~32 mm | Steel Shank

Internal retracting



Cutting edge style **Z**



Right hand (R) shown.

Steel Shank

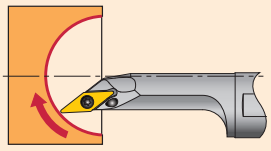
Toolholder Cat. No.	Stock R	Stock L	Min bore.dia. ØDm	Dimensions (mm) ØDs	f	L1	L2	L3	h	f2	θ	a	Std. corner radius rε	Applicable inserts	Parts: Clamping screw	Parts: Wrench	Torque (N·m)
A16Q-SVZBR/L11-D200	●	●	20	16	15.5	180	35	12.5	15	8	0°	-8°	0.4	VB□□1103	CSTB-2.5	T-8F	1.2
A20R-SVZBR/L11-D250	●	●	25	20	17.5	200	40	12.5	18	8	0°	-7°	0.4				
A25S-SVZBR/L16-D320	●	●	32	25	24	250	50	17.5	23	12	0°	-6°	0.8	VB□□1604	CSTB-3.5	T-15F	3.0
A32T-SVZBR/L16-D400	●	●	40	32	27.5	300	72	17.5	30	12	0°	-5°	0.8		CSTB-3.5L		

When using a right or left hand insert, the right hand insert (R) is used for the right hand toolholders (SVZBR type), and the left hand insert (L) is used for the left hand toolholders (SVZBL type).hh

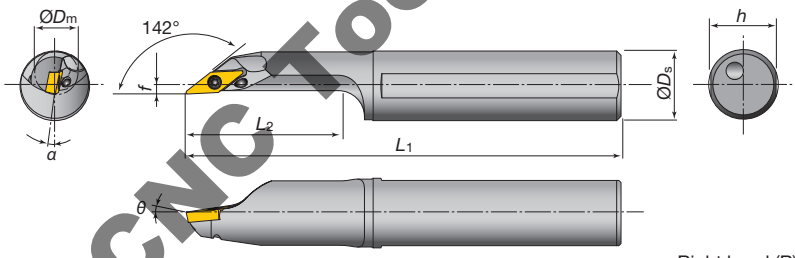
SVJBR/L

Min. bore dia. ø25 mm~ | Shank dia. ø20~25 mm | Steel Shank

Internal sphere cutting



Cutting edge style **J**



Right hand (R) shown.

Steel Shank

Toolholder Cat. No.	Stock R	Stock L	Min bore.dia. ØDm	Dimensions (mm) ØDs	f	L1	L2	h	f2	θ	a	Std. corner radius rε	Applicable inserts	Parts: Clamping screw	Parts: Wrench	Torque (N·m)
A20R-SVJBR/L11-D250	●	●	25	20	2	200	40	18	-	-5°	-5°	0.4	VB□□1103	CSTB-2.5	T-8F	1.2
A25S-SVJBR/L11-D300	●	●	30	25	3.5	250	50	23	-	-5°	-5°	0.4				

When using a right or left hand insert, the right hand insert (R) is used for the left hand toolholders (SVJBL type), and the left hand insert (L) is used for the right hand toolholders (SVJBR type).

How to use SVJC(B)R/L-type tools 5-24

Basic Selection Chipbreakers VB□□1103□□-□□

	Operation	Precision finishing	Finishing	Finishing to medium cutting	Medium cutting
P Steel	Grade	SH730	AH725	T9115	T9125
	Page	2-134	2-133	2-133	2-133
	Chipbreaker	JS	PSF	PS	PSS
Continuous	Vc (m/min)	**120** (50-180)	**120** (50-180)	**220** (150-300)	**180** (120-150)
	ap (mm)	**1.5** (0.1-3.0)	**0.3** (0.1-0.5)	**1.5** (0.5-2.5)	**1.5** (0.5-3.0)
	f (mm/rev)	**0.06** (0.02-0.1)	**0.12** (0.08-0.2)	**0.15** (0.08-0.3)	**0.15** (0.08-0.3)
	rε (mm)	0.2	0.4	0.4	0.8

	Operation	Precision finishing	Finishing	Finishing to light cutting
M Stainless	Grade	J740	AH725	AH725
	Page	2-134	2-133	2-133
	Chipbreaker	FR/L-J10 (Sharp edges)	PSF	PSS
Continuous	Vc (m/min)	**50** (10-100)	**120** (50-150)	**120** (50-150)
	ap (mm)	**1.0** (0.5-2.0)	**0.3** (0.1-0.5)	**1.2** (0.3-2.0)
	f (mm/rev)	**0.03** (0.01-0.05)	**0.12**(0.08-0.2)	**0.15** (0.08-0.3)
	rε (mm)	0.2	0.4	0.8

	Operation	Precision finishing	Finishing	Finishing to medium cutting
K Cast Iron	Grade	BX930	TH10	T5115
	Page	3-14	2-134	2-133
	Chipbreaker	T-CBN	J10	CM
Continuous	Vc (m/min)	**700** (300-1200)	**70** (30-100)	**270** (140-400)
	ap (mm)	**0.3** (0.05-0.5)	**1.0** (0.5-2.0)	**1.0** (0.05-2.0)
	f (mm/rev)	**0.1** (0.05-0.2)	**0.03** (0.01-0.05)	**0.2** (0.05-0.3)
	rε (mm)	0.4	0.4	0.8

	Operation	Precision finishing	Finishing
H Hard Materials	Grade	BXM10	BXM20
	Page	3-13	3-13
	Chipbreaker	T-CBN	T-CBN
Continuous	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"
2-16~

● : Stocked items.

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STREAMJETBAR S-type SVQCR/L

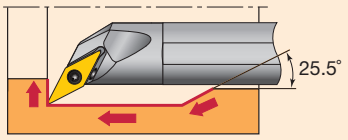
Positive rake / Screw-on system

Min. bore dia. ø13.5 mm~

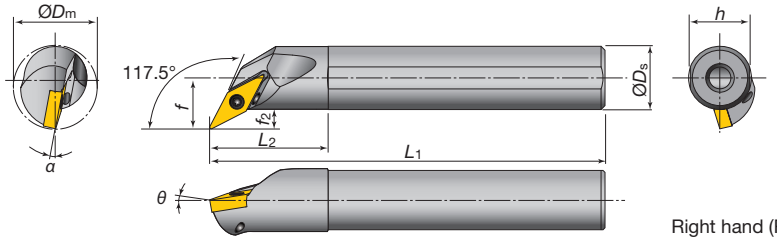
Shank dia. ø10~40 mm

Steel Shank | Carbide Shank

Boring & internal profiling



Cutting edge style Q



Oil Hole

Right hand (R) shown.

Steel Shank

Toolholder Cat. No.	Stock R	Stock L	Min bore.dia. ØDm	ØDs	f	L1	L2	h	f2	θ	a	Std. corner radius rε	Applicable inserts	Parts: Clamping screw	Parts: Wrench	Torque (N·m)
A10K-SVQCR/L08-D135	●	●	13.5	10	8	125	20	9	3	-5°	-8°	0.4	VC□□0802	CSTB-2L	T-6F	0.6
A16Q-SVQCR/L11-D215	●	●	21.5	16	13	180	30	15	4.9	-5°	-8°	0.4	VC□□1103	CSTB-2.5	T-8F	1.2
A25S-SVQCR/L16-D320			32	25	17	250	45	23	4.5	0°	-5°	0.8	VC□□1604	CSTB-3.5	T-15F	3.0
A32T-SVQCR/L16-D400			40	32	22	300	50	23	6	0°	-3°	0.8				
A40U-SVQCR/L16-D500			50	40	27	350	60	23	7	0°	-1°	0.8				

Carbide Shank

Toolholder Cat. No.	Stock R	Stock L	Min bore.dia. ØDm	ØDs	f	L1	L2	h	f2	θ	a	Std. corner radius rε	Applicable inserts	Parts: Clamping screw	Parts: Wrench	Torque (N·m)
E10M-SVQCR/L08-D135	●	●	13.5	10	8	150	25	9	3	-5°	-8°	0.4	VC□□0802	CSTB-2L	T-6F	0.6
E16R-SVQCR/L11-D215	●	●	21.5	16	13	200	32	15	4.9	-5°	-8°	0.4	VC□□1103	CSTB-2.5	T-8F	1.2

When using a right or left hand insert, the right hand insert (R) is used for the left hand toolholders (SVQCL □□ type), and the left hand insert (L) is used for the right hand toolholders (SVQCR □□ type).

STREAMJETBAR S-type SVUCR/L

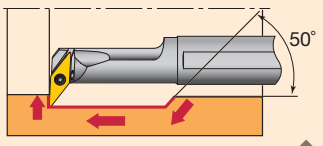
Positive rake / Screw-on system

Min. bore dia. ø16 mm~

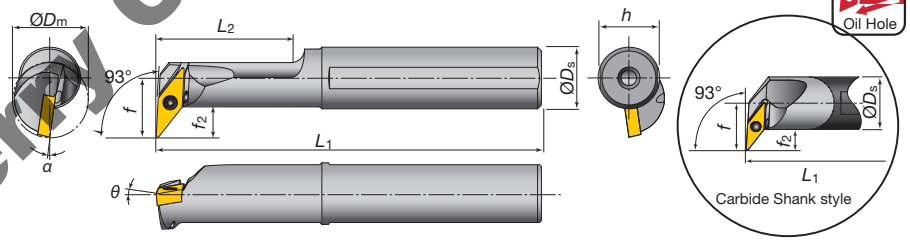
Shank dia. ø12~40 mm

Steel Shank | Carbide Shank

Boring & internal profiling



Cutting edge style U



Oil Hole

Right hand (R) shown.

Steel Shank

Toolholder Cat. No.	Stock R	Stock L	Min bore.dia. ØDm	ØDs	f	L1	L2	h	f2	θ	a	Std. corner radius rε	Applicable inserts	Parts: Clamping screw	Parts: Wrench	Torque (N·m)
A12M-SVUCR/L08-D160	●	●	16	12	11	150	30	11	5.5	0°	-8°	0.4	VC□□0802	CSTB-2L	T-6F	0.6
A25S-SVUCR/L16-D320	●	●	32	25	19	250	45	23	6.5	0°	-5°	0.8	VC□□1604	CSTB-3.5	T-15F	3.0
A32T-SVUCR/L16-D400			40	32	22	300	50	30	6	0°	-3°	0.8		CSTB-3.5L		
A40U-SVUCR/L16-D500			50	40	27	350	60	37	7	0°	-1°	0.8				

Carbide Shank

Toolholder Cat. No.	Stock R	Stock L	Min bore.dia. ØDm	ØDs	f	L1	L2	h	f2	θ	a	Std. corner radius rε	Applicable inserts	Parts: Clamping screw	Parts: Wrench	Torque (N·m)
E12Q-SVUCR/L08-D180	●	●	18	12	11.5	180	-	11	5.5	0°	-8°	0.4	VC□□0802	CSTB-2L	T-6F	0.6
E25T-SVUCR/L16-D320	●	●	32	25	19	300	-	23	6.5	0°	-5°	0.8	VC□□1604	CSTB-3.5	T-15F	3.0

When using a right or left hand insert, the right hand insert (R) is used for the left hand toolholders (SVUCL □□ type), and the left hand insert (L) is used for the right hand toolholders (SVUCR □□ type).

● : Stocked items.

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STREAMJETBAR S-type SVZCR/L

Positive rake / Screw-on system

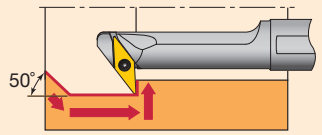
Min. bore dia. ø16 mm

Shank dia. ø12 mm

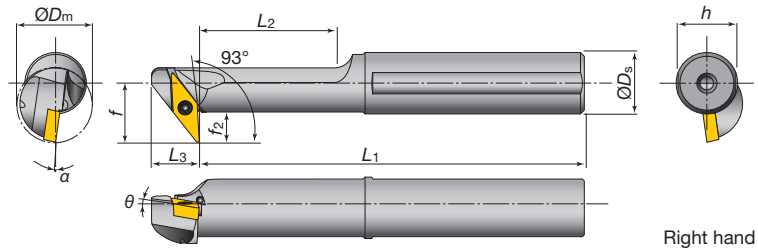
Steel Shank

Oil Hole

Internal retracting



Cutting edge style **Z**



Right hand (R) shown.

Steel Shank

Toolholder Cat. No.	Stock R	Stock L	Min bore.dia. ØDm	Dimensions (mm) ØDs	f	L1	L2	L3	h	f2	θ	a	Std. corner radius rε	Applicable inserts	Parts: Clamping screw	Parts: Wrench	Torque (N·m)
A12M-SVZCR/L08-D160	●	●	16	12	11	150	30	10	11	5.5	0°	-8°	0.4	VC□□0802	CSTB-2L	T-6F	0.6

When using a right or left hand insert, the right hand insert (R) is used for the right hand toolholders (SVZCR □□ type), and the left hand insert (L) is used for the left hand toolholders (SVZCL □□ type).

STREAMJETBAR S-type SVJCR/L

Positive rake / Screw-on system

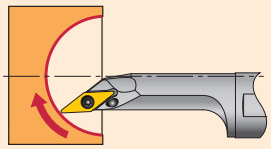
Min. bore dia. ø16 mm~

Shank dia. ø12~16 mm

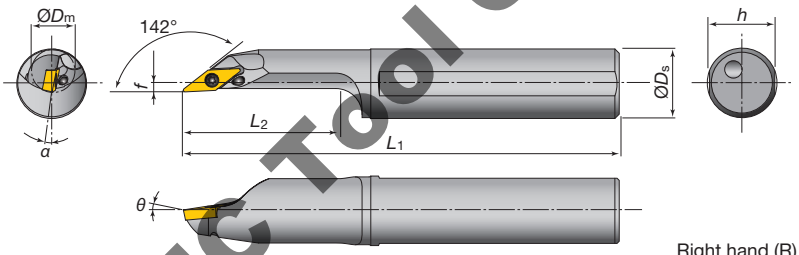
Steel Shank

Oil Hole

Internal sphere cutting



Cutting edge style **J**



Right hand (R) shown.

Steel Shank

Toolholder Cat. No.	Stock R	Stock L	Min bore.dia. ØDm	Dimensions (mm) ØDs	f	L1	L2	h	f2	θ	a	Std. corner radius rε	Applicable inserts	Parts: Clamping screw	Parts: Wrench	Torque (N·m)
A12M-SVJCR/L08-D160	●	●	16	12	2	150	28	11	-	-5°	-5°	0.4	VC□□0802	CSTB-2L	T-6F	0.6
A16Q-SVJCR/L08-D200	●	●	20	16	2	180	35	15	-	-5°	-5°	0.4				

When using a right or left hand insert, the right hand insert (R) is used for the left hand toolholders (SVJCL □□ type), and the left hand insert (L) is used for the right hand toolholders (SVJCR □□ type).

How to use SVJC(B)R/L-type tools 5-24

Basic Selection Chipbreakers VC□□0802□□-□□

	Operation	Finishing to medium cutting
P Steel	Grade	**AH725**
	Page	2-135
	Chipbreaker	PSF 
Continuous	Vc (m/min)	**120** (50-180)
	ap (mm)	**0.3** (0.1-0.5)
	f (mm/rev)	**0.12** (0.08-0.2)
	rε (mm)	0.4

	Operation	Finishing to medium cutting
M Stainless	Grade	**AH725**
	Page	2-135
	Chipbreaker	PSF 
Continuous	Vc (m/min)	**120** (50-150)
	ap (mm)	**0.3** (0.1-0.5)
	f (mm/rev)	**0.12** (0.08-0.2)
	rε (mm)	0.4

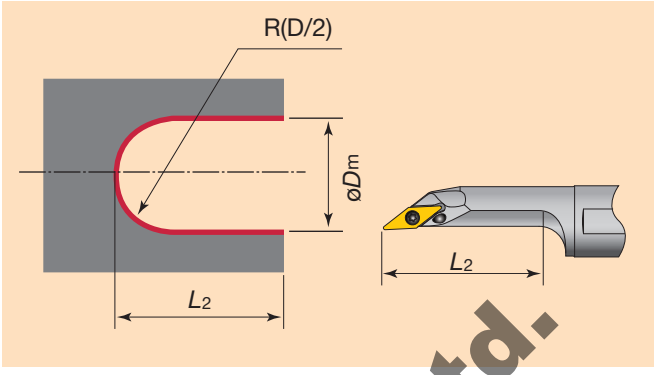
● : Stocked items.

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How to use SVJC(B)R/L-type tools

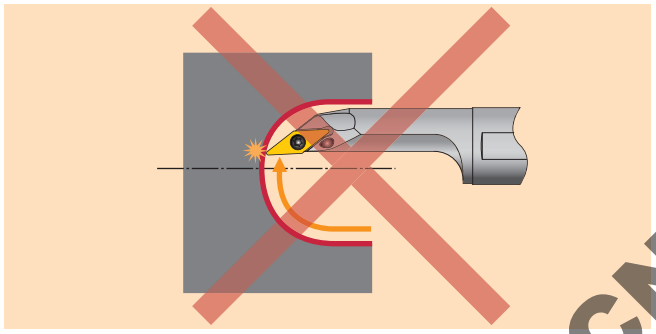
General machining information

The minimum machinable radius (R) of the internal sphere is 1/2 of the minimum bore diameter ($øD_m$).
The maximum machinable depth of the bore is within the L_2 size of the tool.

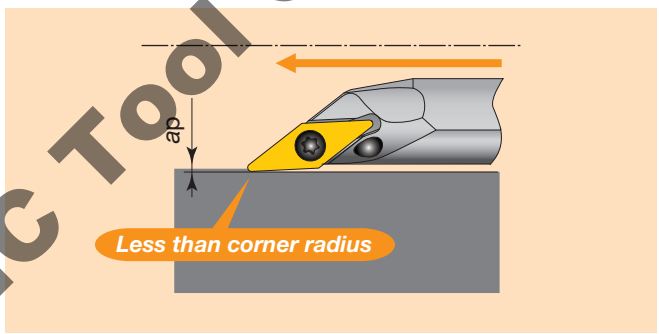


Cautionary points

To avoid insert breakage the tool point should not overrun the bore center.



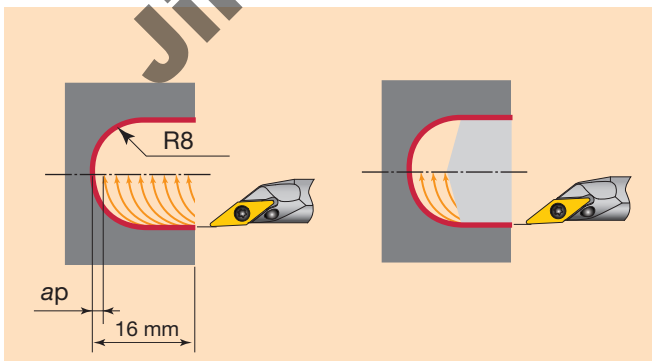
To avoid burr, the depth of cut should be within the corner radius.



Machining examples

Machining of internal sphere

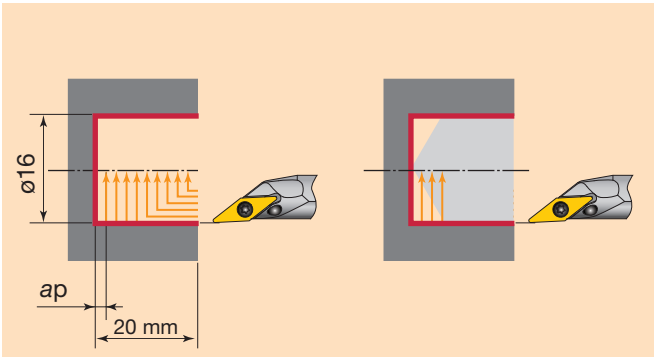
Work material : S45C
Toolholder : A12M-SVJCR08-D160
Insert : VCMT080204-PF (NS730)
Cutting speed : *Vc* = ~ 100 m/min
No of revs. : *n* = 3000 min^{-1} (constant)
Feed : *f* = 0.1 mm/rev
Depth of cut : *ap* = 0.5 mm



Machining from a solid workpiece | Machining from a pre-drilled bore

Machining of the bottom face of a bore

Work material : S45C
Toolholder : A12M-SVJCR08-D160
Insert : VCMT080204-PSF (T9115)
Cutting speed : *Vc* = ~ 100 m/min
No of revs. : *n* = 3000 min^{-1} (constant)
Feed : *f* = 0.1 mm/rev
: *f* = 0.05 mm/rev (only for plunging)
Depth of cut : *ap* = 0.5 mm



Machining from a solid workpiece | Machining from a pre-drilled bore

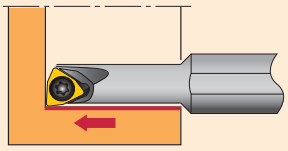
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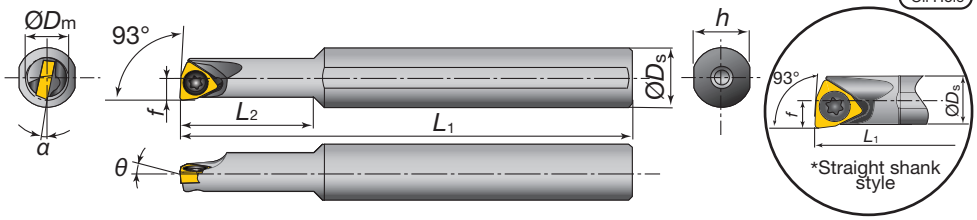
SWUBR/L

Min. bore dia. ø6 mm~ | Shank dia. ø5~8 mm | Steel Shank | Carbide Shank

Boring



Cutting edge style **U**



Right hand (R) shown.

Steel Shank

Toolholder Cat. No.	Stock R	Stock L	Min bore.dia. ØDm	Dimensions (mm) ØDs	f	L_1	L_2	h	f_2	θ	a	Std. corner radius r_ε	Applicable inserts	Parts: Clamping screw	Parts: Wrench	Torque (N·m)
MINI *A05F-SWUBR/L03-D060	●	●	6	5	3	80	9	4.8			-13°					
MINI *A06G-SWUBR/L03-D070	●	●	7	6	3.5	90	11	5.75	-	0°	-12°	0.4	WB□□0301	CSTB-2	T-6F	0.6
MINI *A07G-SWUBR/L03-D080	●	●	8	7	4	90	12	6.75			-11°					
A08H-SWUBR03-D060	●		6	8	3.1	100	18	7.5	-	0°	-12°	0.4	WB□□0301	CSTB-2	T-6F	0.6
A08H-SWUBR03-D070	●		7	8	3.6	100	20	7.5	-	0°	-12°	0.4				

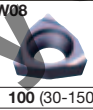
Carbide Shank

Toolholder Cat. No.	Stock R	Stock L	Min bore.dia. ØDm	Dimensions (mm) ØDs	f	L_1	L_2	h	f_2	θ	a	Std. corner radius r_ε	Applicable inserts	Parts: Clamping screw	Parts: Wrench	Torque (N·m)
MINI *E05G-SWUBR/L03-D060	●	●	6	5	3	90	10	4.8			-13°					
MINI *E06H-SWUBR/L03-D070	●	●	7	6	3.5	100	12	5.75	-	0°	-12°	0.4	WB□□0301	CSTB-2	T-6F	0.6
MINI *E07H-SWUBR/L03-D080	●	●	8	7	4	100	14	6.75			-11°					
E08K-SWUBR03-D060	●		6	8	3.1	125	30	7.5	-	0°	-12°	0.4	WB□□0301	CSTB-2	T-6F	0.6
E08K-SWUBR03-D070	●		7	8	3.6	125	40	7.5	-	0°	-12°	0.4				

When using a right or left hand insert, the right hand insert (R) is used for the left hand toolholders (SWUBL □□ type), and the left hand insert (L) is used for the right hand toolholders (SWUBR □□ type).

Basic Selection Chipbreakers WB□□0301□□-□□

	Operation	Finishing
P Steel	Grade	SH730
	Page	2-132
	Chipbreaker	W08 
	Vc (m/min)	**100** (50-150)
Continuous	ap (mm)	**0.5** (0.05-1.0)
	f (mm/rev)	**0.06** (0.02-0.1)
	r_ε (mm)	0.2

	Operation	Finishing
M Stainless	Grade	SH730
	Page	2-132
	Chipbreaker	W08 
	Vc (m/min)	**100** (30-150)
Continuous	ap (mm)	**0.5** (0.05-1.0)
	f (mm/rev)	**0.06** (0.02-0.1)
	r_ε (mm)	0.2

	Operation	Finishing
K Cast Iron	Grade	TH10
	Page	2-132
	Chipbreaker	W08 
	Vc (m/min)	**70** (30-100)
Continuous	ap (mm)	**0.5** (0.05-2.0)
	f (mm/rev)	**0.1** (0.03-0.2)
	r_ε (mm)	0.4

	Operation	Finishing
N Non-ferrous	Grade	GH110
	Page	2-132
	Chipbreaker	W08 
	Vc (m/min)	**600** (100-1000)
Continuous	ap (mm)	**1.0** (0.5-2.0)
	f (mm/rev)	**0.1** (0.03-0.2)
	r_ε (mm)	0.2

● : Stocked items.

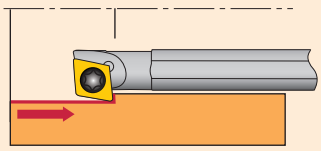
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STREAMJETBAR S-type SEZPR/L

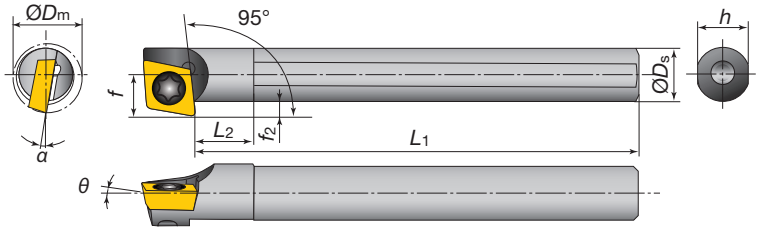
Positive rake / Screw-on system

Min. bore dia. ø5.5 mm~ | Shank dia. ø4~5 mm | Steel Shank | Carbide Shank

Internal retracting



Cutting edge style **Z**



Oil Hole

Right hand (R) shown.

Steel Shank

Toolholder Cat. No.	Stock R	Stock L	Min bore.dia. ØDm	Dimensions (mm) ØDs	f	L1	L2	h	f2	θ	a	Std. corner radius rε	Applicable inserts	Parts: Clamping screw	Parts: Wrench	Torque (N·m)
MINI A04F-SEZPR/L03-D055	●	●	5.5	4	3.2	80	4	3.8	1.2	0°	-8°	0.2	EP□□03X1	CSTA-1.6	T-6F	0.6
MINI A05F-SEZPR/L03-D065	●	●	6.5	5	3.7	80	5	4.8			-6°					

Carbide Shank

Toolholder Cat. No.	Stock R	Stock L	Min bore.dia. ØDm	Dimensions (mm) ØDs	f	L1	L2	h	f2	θ	a	Std. corner radius rε	Applicable inserts	Parts: Clamping screw	Parts: Wrench	Torque (N·m)
MINI E04G-SEZPR/L03-D055	●	●	5.5	4	3.2	90	5	3.8	1.2	0°	-8°	0.2	EP□□03X1	CSTA-1.6	T-6F	0.6
MINI E05G-SEZPR/L03-D065	●	●	6.5	5	3.7	90	6	4.8			-6°					

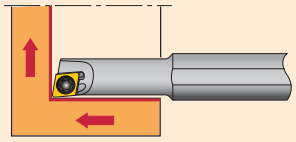
When using a right or left hand insert, the right hand insert (R) is used for the right hand toolholders (SEZPR □□ type), and the left hand insert (L) is used for the left hand toolholders (SEZPL □□ type).

STREAMJETBAR S-type SEXPR/L

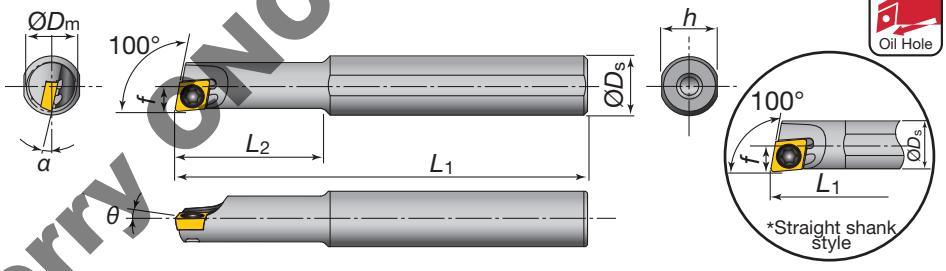
Positive rake / Screw-on system

Min. bore dia. ø4.5 mm~ | Shank dia. ø4~8 mm | Steel Shank | Carbide Shank

Boring & internal facing



Cutting edge style **X**



Oil Hole

Right hand (R) shown.

Steel Shank

Toolholder Cat. No.	Stock R	Stock L	Min bore.dia. ØDm	Dimensions (mm) ØDs	f	L1	L2	h	f2	θ	a	Std. corner radius rε	Applicable inserts	Parts: Clamping screw	Parts: Wrench	Torque (N·m)
MINI *A04F-SEXPR/L03-D045	●	●	4.5	4	2.3	80	8	3.8	-	0°	-15°	0.2	EP□□03X1	CSTA-1.6	T-6F	0.6
MINI *A04F-SEXPR/L03-D050	●	●	5	4	2.5	80	8	3.8	-	0°	-13°	0.2				
MINI *A05F-SEXPR/L04-D055	●	●	5.5	5	2.75	80	9	4.8	-	0°	-12°	0.4	EP□□0401	CSTB-2	T-6F	0.6
MINI *A06G-SEXPR/L04-D070	●	●	7	6	3.6	90	11	5.75	-	0°	-12°	0.4	EP□□0401	CSTB-2	T-6F	0.6
A08H-SEXPR/L04-D055	●	●	5.5	8	2.75	100	16	7.5	-	0°	-12°	0.4	EP□□0401	CSTB-2	T-6F	0.6
A08H-SEXPR/L04-D070	●	●	7	8	3.6	100	20	7.5	-	0°	-12°	0.4				0.6

Carbide Shank

Toolholder Cat. No.	Stock R	Stock L	Min bore.dia. ØDm	Dimensions (mm) ØDs	f	L1	L2	h	f2	θ	a	Std. corner radius rε	Applicable inserts	Parts: Clamping screw	Parts: Wrench	Torque (N·m)
MINI *E04G-SEXPR/L03-D045	●	●	4.5	4	2.3	90	9	3.8	-	0°	-15°	0.2	EP□□03X1	CSTA-1.6	T-6F	0.6
MINI *E04G-SEXPR/L03-D050	●	●	5	4	2.5	90	9	3.8	-	0°	-13°	0.2				
MINI *E05G-SEXPR/L04-D055	●	●	5.5	5	2.75	90	10	4.8	-	0°	-12°	0.4	EP□□0401	CSTB-2	T-6F	0.6
MINI *E06H-SEXPR/L04-D070	●	●	7	6	3.6	100	12	5.75	-	0°	-12°	0.4	EP□□0401	CSTB-2	T-6F	0.6
E08K-SEXPR/L04-D055	●	●	5.5	8	2.75	125	28	7.5	-	0°	-12°	0.4	EP□□0401	CSTB-2	T-6F	0.6
E08K-SEXPR/L04-D070	●	●	7	8	3.6	125	40	7.5	-	0°	-12°	0.4				0.6

When using a right or left hand insert, the right hand insert (R) is used for the left hand toolholders SEXPL □□ type), and the left hand insert (L) is used for the right hand toolholders (SEXPR □□ type).

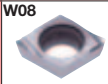
● : Stocked items.

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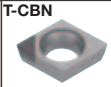
Basic Selection Chipbreakers EP□□0401□□-□□

	Operation	Finishing
P Steel	Grade	SH730
	Page	2-111
	Chipbreaker	W08 
Continuous	*Vc* (m/min)	**100** (50-150)
	ap (mm)	**0.5** (0.05-1.0)
	f (mm/rev)	**0.06** (0.02-0.1)
	*r*ε (mm)	0.2

	Operation	Finishing
M Stainless	Grade	SH730
	Page	2-111
	Chipbreaker	W08 
Continuous	*Vc* (m/min)	**100** (30-150)
	ap (mm)	**0.5** (0.05-1.0)
	f (mm/rev)	**0.06** (0.02-0.1)
	*r*ε (mm)	0.2

	Operation	Finishing
K Cast Iron	Grade	TH10
	Page	2-111
	Chipbreaker	W08 
Continuous	*Vc* (m/min)	**70** (30-100)
	ap (mm)	**0.5** (0.05-2.0)
	f (mm/rev)	**0.1** (0.03-0.2)
	*r*ε (mm)	0.4

	Operation	Precision finishing	Finishing
N Non-ferrous	Grade	DX140	GH110
	Page	3-23	2-111
	Chipbreaker	T-DIA 	W08 
Continuous	*Vc* (m/min)	**1500** (500-2500)	**600** (100-1000)
	ap (mm)	**0.1** (0.03-0.5)	**1.0** (0.5-2.0)
	f (mm/rev)	**0.1** (0.05-0.15)	**0.1** (0.03-0.2)
	*r*ε (mm)	0.2	0.4

	Operation	Precision finishing
H Hard Materials	Grade	BX310
	Page	3-15
	Chipbreaker	T-CBN 
Continuous	*Vc* (m/min)	**80** (30-150)
	ap (mm)	**0.1** (0.03-0.2)
	f (mm/rev)	**0.05** (0.03-0.1)
	*r*ε (mm)	0.2

Jinan Terry CNC Tool Co.,Ltd.

● : Stocked items.

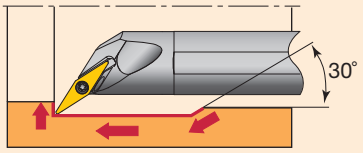
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STREAMJETBAR S-type SYQBR/L

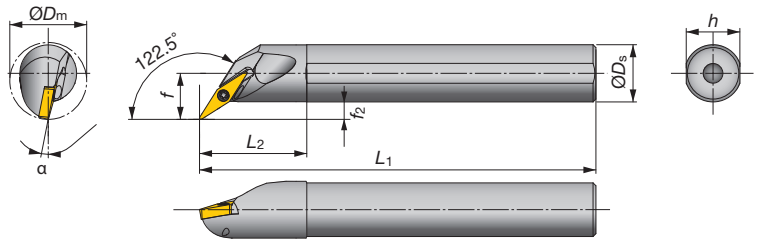
Positive rake / Screw-on system

Min. bore dia. ø17 mm~ | Shank dia. ø12~16 mm | Steel Shank | Carbide Shank

Internal undercut & profiling



Cutting edge style **Q**



Right hand (R) shown.

Steel Shank

Toolholder Cat. No.	Stock R	Stock L	Min bore.dia. ØDm	Dimensions (mm) ØDs	f	L1	L2	h	f2	θ	α	Std. corner radius rε	Applicable inserts	Parts Clamping screw	Parts Wrench	Torque (N·m)
A12M-SYQBR/L11-D170	●	●	17	12	10.5	150	24	11	4.5	-5°	-10°	0.4	YW□□11T2	CSTB-2L	T-6F	0.6
A16Q-SYQBR/L11-D215	●	●	21.5	16	13	180	30	15	5	-5°	-8°	0.4				

Carbide Shank

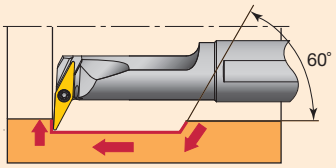
Toolholder Cat. No.	Stock R	Stock L	Min bore.dia. ØDm	Dimensions (mm) ØDs	f	L1	L2	h	f2	θ	α	Std. corner radius rε	Applicable inserts	Parts Clamping screw	Parts Wrench	Torque (N·m)
E12Q-SYQBR/L11-D170	●	●	17	12	10.5	180	27	11	4.5	-5°	-10°	0.4	YW□□11T2	CSTB-2L	T-6F	0.6
E16R-SYQBR/L11-D215	●	●	21.5	16	13	200	32	15	5	-5°	-8°	0.4				

STREAMJETBAR S-type SYUBR/L

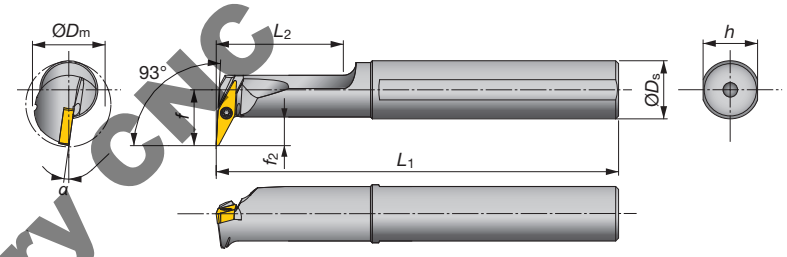
Positive rake / Screw-on system

Min. bore dia. ø20 mm~ | Shank dia. ø12~16 mm | Steel Shank | Carbide Shank

Boring & internal profiling



Cutting edge style **U**



Right hand (R) shown.

Steel Shank

Toolholder Cat. No.	Stock R	Stock L	Min bore.dia. ØDm	Dimensions (mm) ØDs	f	L1	L2	h	f2	θ	α	Std. corner radius rε	Applicable inserts	Parts Clamping screw	Parts Wrench	Torque (N·m)
A16Q-SYUBR/L11-D200	●	●	20	16	15.5	180	35	15	8	0°	-8°	0.4	YW□□11T2	CSTB-2L	T-6F	0.6

Carbide Shank

Toolholder Cat. No.	Stock R	Stock L	Min bore.dia. ØDm	Dimensions (mm) ØDs	f	L1	L2	h	f2	θ	α	Std. corner radius rε	Applicable inserts	Parts Clamping screw	Parts Wrench	Torque (N·m)
E12Q-SYUBR/L11-D200	●	●	20	12	13.5	180	27	11	7.5	0°	-8°	0.4	YW□□11T2	CSTB-2L	T-6F	0.6
E16R-SYUBR/L11-D245	●	●	24.5	16	16	200	32	15	8	0°	-8°	0.4				

Basic Selection Chipbreakers YW□□11T2□□-□□

	Operation	Finishing	Finishing to medium cutting
P Steel	Grade	GT730	T9125
	Page	2-139	2-139
	Chipbreaker	ZF 	ZM 
Continuous	Vc (m/min)	**200** (150-300)	**180** (120-250)
	ap (mm)	**0.5** (0.2-1.0)	**1.4** (0.75-2.0)
	f (mm/rev)	**0.15** (0.08-0.2)	**0.2** (0.1-0.25)
	rε (mm)	0.4	0.8

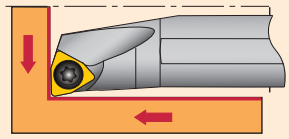
● : Stocked items.

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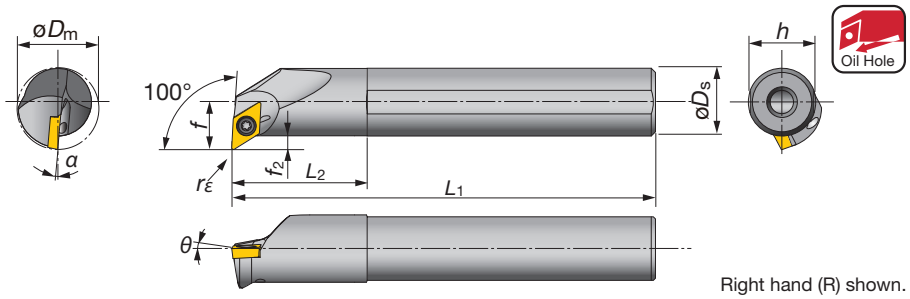
SWLXR/L

Min. bore dia. ø12 mm~ | Shank dia. ø10~20 mm | Steel Shank | Carbide Shank

Boring & internal facing



Cutting edge style **L**



Right hand (R) shown.

Steel shank

Cat. No	Stock R	Stock L	Min bore dia. øDm	Dimensions (mm) øDs	f	L1	L2	h	f2	θ	α	Std. corner radius rε	Insert	Parts Clamping screw	Parts Wrench	Torque (N·m)
A10K-SWLXR/L04-D120	●	●	12	10	6	125	20	9	-	-10°	-16°	0.4	WXGU0403** L/R	SR34-514	T-7F	0.9
A12M-SWLXR/L04-D140	●	●	14	12	7	150	24	11	-	-10°	-14°	0.4				
A16Q-SWLXR/L04-D180	●	●	18	16	9	180	32	15	-	-10°	-11°	0.4				
A20R-SWLXR/L04-D220	●	●	22	20	11	200	36	18	-	-10°	-10°	0.4				

Carbide shank

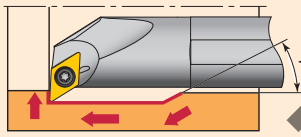
Cat. No	Stock R	Stock L	Min bore dia. øDm	Dimensions (mm) øDs	f	L1	L2	h	f2	θ	α	Std. corner radius rε	Insert	Parts Clamping screw	Parts Wrench	Torque (N·m)
E10M-SWLXR/L04-D120	●	●	12	10	6	150	25	9	-	-10°	-16°	0.4	WXGU0403** L/R	SR34-514	T-7F	0.9
E12Q-SWLXR/L04-D140	●	●	14	12	7	180	27	11	-	-10°	-14°	0.4				
E16R-SWLXR/L04-D180	●	●	18	16	9	200	32	15	-	-10°	-11°	0.4				
E20S-SWLXR/L04-D220	●	●	22	20	11	250	36	18	-	-10°	-10°	0.4				

When using a right or left hand insert, the right hand insert (R) is used for the left hand toolholders (SWLXL04-D**) , and the left hand insert (L) is used for the right hand toolholders (SWLXR04-D**) .

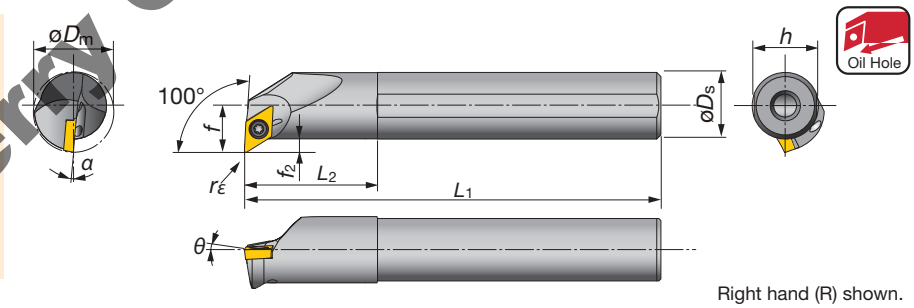
SDXXR/L

Min. bore dia. ø13 mm~ | Shank dia. ø10~20 mm | Steel Shank | Carbide Shank

Boring & internal profiling



Cutting edge style **X**



Right hand (R) shown.

Steel shank

Cat. No	Stock R	Stock L	Min bore dia. øDm	Dimensions (mm) øDs	f	L1	L2	h	f2	θ	α	Std. corner radius rε	Insert	Parts Clamping screw	Parts Wrench	Torque (N·m)
A10K-SDXXR/L07-D130	●	●	13	10	7.6	125	20	9	2.6	-14°	-16°	0.4	DXGU0703** L/R	SR34-514	T-7F	0.9
A12M-SDXXR/L07-D160	●	●	16	12	8.6	150	24	11	2.6	-14°	-14°	0.4				
A16Q-SDXXR/L07-D200	●	●	20	16	10.6	180	32	15	2.6	-13°	-13°	0.4				
A20R-SDXXR/L07-D240	●	●	24	20	12.6	200	36	18	2.6	-13°	-12°	0.4				

Carbide shank

Cat. No	Stock R	Stock L	Min bore dia. øDm	Dimensions (mm) øDs	f	L1	L2	h	f2	θ	α	Std. corner radius rε	Insert	Parts Clamping screw	Parts Wrench	Torque (N·m)
E10M-SDXXR/L07-D130	●	●	13	10	7.6	150	25	9	2.6	-14°	-16°	0.4	DXGU0703** L/R	SR34-514	T-7F	0.9
E12Q-SDXXR/L07-D160	●	●	16	12	8.6	180	27	11	2.6	-14°	-14°	0.4				
E16R-SDXXR/L07-D200	●	●	20	16	10.6	200	32	15	2.6	-13°	-13°	0.4				
E20S-SDXXR/L07-D240	●	●	24	20	12.6	250	36	18	2.6	-13°	-12°	0.4				

When using a right or left hand insert, the right hand insert (R) is used for the left hand toolholders (SDXXL07-D**) , and the left hand insert (L) is used for the right hand toolholders (SDXXR07-D**) .

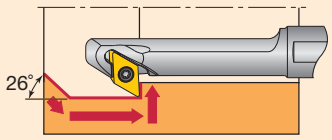
● : Stocked items.

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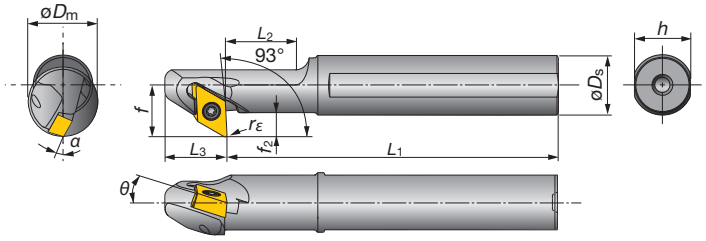
SDZXR/L

Min. bore dia. ø14 mm~ | Shank dia. ø12~20 mm | Steel Shank | Carbide Shank

New **Internal retracting**



Cutting edge style **Z**



Oil Hole

Right hand (R) shown.

Steel shank

Cat. No	Stock R	Stock L	Min bore dia. øDm	Dimensions (mm) øDs	f	L1	L2	L3	h	f2	θ	α	Std. corner radius rε	Insert	Parts Clamping screw	Parts Wrench	Torque (N·m)
A12M-SDZXR/L07-D140	★	★	14	12	11	150	30	13	11	4.5	-10°	-14°	0.4	DXGU0703** R/L	SR34-514	T-7F	0.9
A16Q-SDZXR/L07-D160	★	★	16	16	13	180	35	13	15	4.5	-10°	-12.5°	0.4				
A20R-SDZXR/L07-D200	★	★	20	20	15	200	40	13	18	4.5	-10°	-10.5°	0.4				

Carbide shank

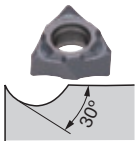
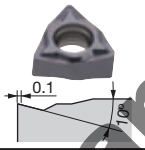
Cat. No	Stock R	Stock L	Min bore dia. øDm	Dimensions (mm) øDs	f	L1	L2	L3	h	f2	θ	α	Std. corner radius rε	Insert	Parts		Torque (N·m)
E12Q-SDZXR/L07-D180	★	★	18	12	11	180	-	13	11	4.5	-11°	-11°	0.4	DXGU0703** R/L	SR34-514	T-7F	0.9
E16R-SDZXR/L07-D220	★	★	22	16	13	200	-	13	15	4.5	-11°	-9°	0.4				

When using a right or left hand insert, the right hand insert (R) is used with the right hand toolholders (SDZXR07-D**), and the left hand insert (L) is used with the left hand toolholders (SDZXL07-D**).

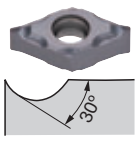
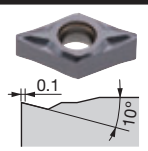
● : Stocked items.
★ : Available in 2013

Inserts

80° Trigon

Application	Chipbreaker Appearance (Cross section)	Cat. No.	Grades Coated AH725	Coated cermet GT530	Cermet NS530	Dimensions (mm) I.C. dia. ød	Thickness s	Hole dia. ød1	Corner radius rε
New Finishing (low cutting forces)	SS 	WXGU040302R-SS	●	●	●	6.35	3.18	2.7	0.2
		WXGU040302L-SS	●	●	●				
		WXGU040304R-SS	●	●	●				0.4
		*WXGU040304L-SS	●	●	●				
Finishing to medium cutting	TS 	WXGU040302R-TS	●	●	●	6.35	3.18	2.7	0.2
		WXGU040302L-TS	●	●	●				
		WXGU040304R-TS	●	●	●				0.4
		*WXGU040304L-TS	●	●	●				
		WXGU040308R-TS	●	●	●				0.8
		WXGU040308L-TS	●	●	●				

55° Rhombic

Application	Chipbreaker Appearance (Cross section)	Cat. No.	Grades Coated AH725	Coated cermet GT530	Cermet NS530	Dimensions (mm) I.C. dia. ød	Thickness s	Hole dia. ød1	Corner radius rε
New Finishing (low cutting forces)	SS 	DXGU070302R-SS	●	●	●	6.35	3.18	2.7	0.2
		DXGU070302L-SS	●	●	●				
		DXGU070304R-SS	●	●	●				0.4
		*DXGU070304L-SS	●	●	●				
Finishing to medium cutting	TS 	DXGU070302R-TS	●	●	●	6.35	3.18	2.7	0.2
		DXGU070302L-TS	●	●	●				
		DXGU070304R-TS	●	●	●				0.4
		*DXGU070304L-TS	●	●	●				
		DXGU070308R-TS	●	●	●				0.8
		DXGU070308L-TS	●	●	●				

Note: Chipbreaker cross-sections are of * marked inserts.

● : Stocked items.

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Standard cutting conditions

Work materials	Priority	Grades	Cutting Speed *Vc* (m/min)	Chip-breaker	Depth of cut *ap* (mm)	Feed *f* (mm/rev)
Low carbon steels SS400, SM490, S25C etc. (St42-1, St52-3, C25 etc.) Carbon steels S45C, S55C etc. (C45, C55 etc.) Low alloy steels SCM415 etc. Alloy steels SCM440, SCr420 etc. (42CrMo4, 20Cr4 etc.)	First choice	**AH725**	50 ~ 180	**SS**	0.15 - 1.5	0.05 - 0.2
				TS	0.3 - 2.0	0.08 - 0.3
	For improved surface finish	**NS530**	80 ~ 250	**SS**	0.15 - 1.5	0.05 - 0.2
				TS	0.3 - 2.0	0.08 - 0.3
	For wear resistance	**GT530**	80 ~ 300	**SS**	0.15 - 1.5	0.05 - 0.2
				TS	0.3 - 2.0	0.08 - 0.3
Stainless steels (Austenitic) SUS304, SUS316 etc. (X5CrNi18-9, X5CrNiMo17-12-2 etc.) Stainless steels (Martensitic and ferritic) SUS430, SUS416 etc. (X6Cr17, X20Cr13 etc.) Stainless steels (Precipitation hardening) SUS630 etc. (X5CrNiCuNb16-4 etc.)	First choice	**AH725**	50 ~ 150	**SS**	0.15 - 1.5	0.05 - 0.2
				TS	0.3 - 2.0	0.08 - 0.3
Grey cast irons FC250 etc. (GG25 etc.)	First choice	**AH725**	50 ~ 180	**SS**	0.15 - 1.5	0.05 - 0.2
				TS	0.3 - 2.0	0.08 - 0.3
	For improved surface finish	**NS530**	80 ~ 250	**SS**	0.15 - 1.5	0.05 - 0.2
				TS	0.3 - 2.0	0.08 - 0.3
	For wear resistance	**GT530**	80 ~ 300	**SS**	0.15 - 1.5	0.05 - 0.2
				TS	0.3 - 2.0	0.08 - 0.3
Ductile cast irons FCD700 etc. (GGG70 etc.)	First choice	**AH725**	50 ~ 120	**SS**	0.15 - 1.5	0.05 - 0.2
				TS	0.3 - 2.0	0.08 - 0.3
	For improved surface finish	**NS530**	80 ~ 150	**SS**	0.15 - 1.5	0.05 - 0.2
				TS	0.3 - 2.0	0.08 - 0.3
	For wear resistance	**GT530**	80 ~ 180	**SS**	0.15 - 1.5	0.05 - 0.2
				TS	0.3 - 2.0	0.08 - 0.3

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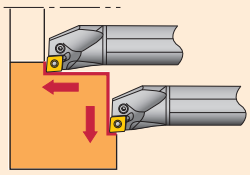
PCLNR/L

Min. bore dia. ø20 mm~

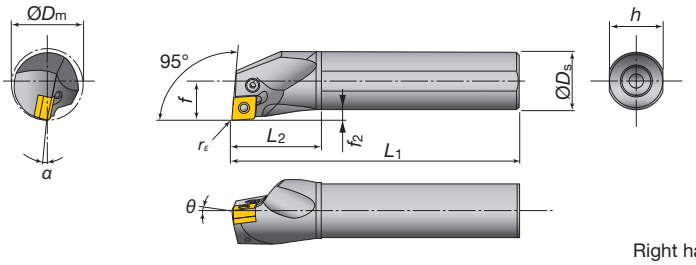
Shank dia. ø16~50 mm

Steel Shank

Boring & internal facing



Cutting edge style **L**



Oil Hole

Right hand (R) shown.

Steel Shank

Toolholder Cat. No.	Stock R	Stock L	Min bore. dia. ØDm	Dimensions (mm) ØDs	f	L1	L2	h	f2	θ	α	Std. corner radius rε	Applicable inserts	Parts: Shim	Lever	Clamping screw	Spring pin	Wrench	Oil supply attachment	Screw for oil hole	Torque (N·m)
A16M-PCLNR/L09-D200	●	●	20	16	11	150	32	15	3	-6°	-14°	0.8	CN□□0903	-	LCL32N	LCS22A	-	P-2F	-	SSHM3-4	1.7
A20Q-PCLNR/L09-D250	●	●	25	20	13	180	36	18	3	-6°	-12°	0.8							EA-20		
A25R-PCLNR/L09-D320	●	●	32	25	17	200	45	23	4.5	-6°	-11°	0.8							EA-25	SSHM5-6	
A25R-PCLNR/L12-D320	●	●	32	25	17	200	45	23	4.5	-6°	-13°	0.8	CN□□1204	-	LCL43N	LCS43	-	P-2,5	EA-25	SSHM5-6	2.7
A32S-PCLNR/L12-D400	●	●	40	32	22	250	50	30	6	-6°	-11°	0.8		LSC42BR/L	LCL4	LCS4	LSP4	P-3	EA-32		4.8
A40T-PCLNR/L12-D500	●	●	50	40	27	300	60	37	7	-6°	-10°	0.8							-	SSHM6-6	
A50U-PCLNR/L12-D630	●	●	63	50	35	350	65	47	10	-6°	-8°	0.8									

When using a right or left hand insert, the right hand insert (R) is used for the left hand toolholders (PCLNL □□ type), and the left hand insert (L) is used for the right hand toolholders (PCLNR □□ type).

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)
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	2-42	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)
rε (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)
rε (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 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 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)
rε (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)
rε (mm)	0.4	0.4

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

● : Stocked items.

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PDUNR/L

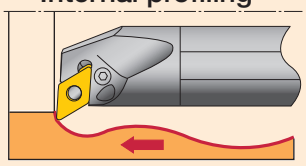
Min. bore dia. ø25 mm~

Shank dia. ø20~50 mm

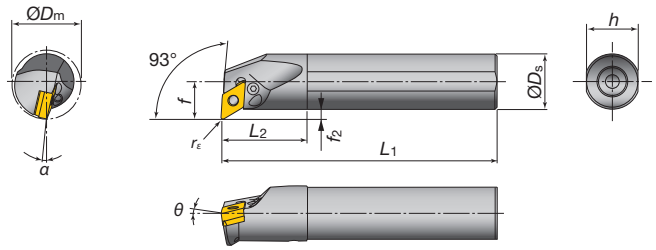
Steel Shank

Oil Hole

Internal profiling



Cutting edge style **U**



Right hand (R) shown.

Steel Shank

Toolholder Cat. No.	Stock R	Stock L	Min bore.dia. ØDm	Dimensions (mm) ØDs	f	L1	L2	h	f2	θ	α	Std. corner radius rε	Applicable inserts	Parts: Shim	Lever	Clamping screw	Spring pin	Wrench	Oil supply attach-ment	Screw for oil hole	Torque (N·m)
A20Q-PDUNR/L11-D250	●	●	25	20	13	180	36	18	3	-6°	-14°	0.8	DN□□1104	-	LCL33NL	LCS22A	-	P-2F	EA-20	SSHM2.5-3	1.7
A25R-PDUNR/L11-D320	●	●	32	25	17	200	45	23	4.5	-6°	-12°	0.8		ELSD317BR/L	LCL33L	LCS3	LSP3	P-2.5	EA-25	SSHM3-4	2.7
A32S-PDUNR/L15-D400	●	●	40	32	22	250	50	30	6	-6°	-13°	0.8	DN□□1504	LSD42BR/L	LCL4	LCS4	LSP4	P-3	EA-32	SSHM5-6	4.8
A40T-PDUNR/L15-D500	●	●	50	40	27	300	60	37	7	-6°	-10°	0.8							-	SSHM6-6	
A50U-PDUNR/L15-D630	●	●	63	50	35	350	65	47	10	-6°	-8°	0.8									
A32S-PDUNR/L1506-D400	●	●	40	32	22	250	50	30	6	-6°	-13°	0.8	DN□□1506	ELSD42	LCL44	ELCS4	LSP4S	P-3	EA-32	SSHM5-6	4.8
A40T-PDUNR/L1506-D500	●	●	50	40	27	300	60	37	7	-6°	-11°	0.8							-	SSHM6-6	
A50U-PDUNR/L1506-D630	●	●	63	50	35	350	65	47	10	-6°	-10°	0.8									

When using a right or left hand insert, the right hand insert (R) is used for the left hand toolholders (PDUNL □□ type), and the left hand insert (L) is used for the right hand toolholders (PDUNR □□ type).

PDZNR/L

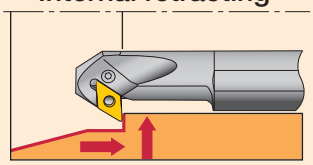
Min. bore dia. ø40 mm~

Shank dia. ø32~50 mm

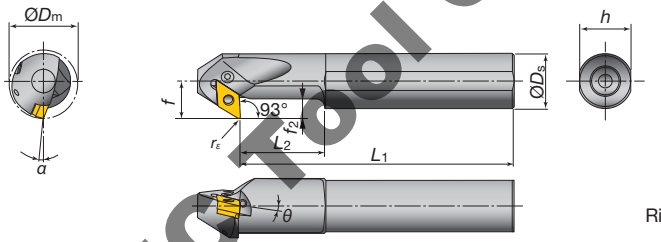
Steel Shank

Oil Hole

Internal retracting



Cutting edge style **Z**



Right hand (R) shown.

Steel Shank

Toolholder Cat. No.	Stock R	Stock L	Min bore.dia. ØDm	Dimensions (mm) ØDs	f	L1	L2	h	f2	θ	α	Std. corner radius rε	Applicable inserts	Parts: Shim	Lever	Clamping screw	Spring pin	Wrench	Oil supply attach-ment	Screw for oil hole	Torque (N·m)
A32S-PDZNR/L15-D400	●	●	40	32	22	250	50	30	11.5	-6°	-13°	0.8	DN□□1504	LSZ42BR/L	LCL4	LCS4	LSP4	P-3	EA-32	SSHM4-5	4.8
A40T-PDZNR/L15-D500	●	●	50	40	27	300	60	37	14.5	-6°	-10°	0.8							-	SSHM5-6	
A50U-PDZNR/L15-D630	●	●	63	50	35	350	65	47	14.5	-6°	-8°	0.8								SSHM6-6	

When using a right or left hand insert, the right hand insert (R) is used for the right hand toolholders (PDZNR □□ type), and the left hand insert (L) is used for the left hand toolholders (PDZNL □□ type).

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 ~

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PSKNR/L

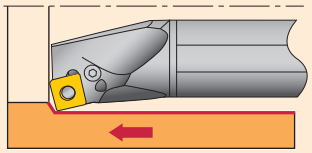
Min. bore dia. ø40 mm~

Shank dia. ø32~50 mm

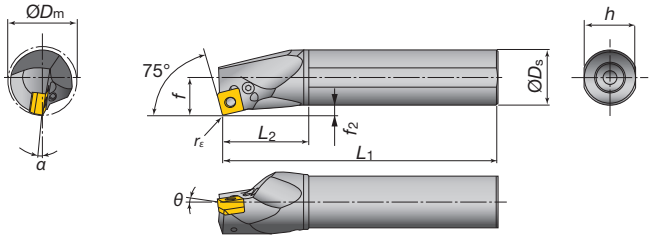
Steel Shank

Oil Hole

Through boring



Cutting edge style **K**



Right hand (R) shown.

Steel Shank

Toolholder Cat. No.	Stock R	Stock L	Min bore.dia. ØDm	Dimensions (mm) ØDs	f	L1	L2	h	f2	θ	α	Std. corner radius rε	Applicable inserts	Parts: Shim	Lever	Clamping screw	Spring pin	Wrench	Oil supply attach-ment	Screw for oil hole	Torque (N·m)
A32S-PSKNR/L12-D400	●	●	40	32	22	250	50	30	6	-6°	-10°	0.8	SN□□1204	LSS42BR/L	LCL4	LCS4	LSP4	P-3	EA-32	SSHM4-5	4.8
A40T-PSKNR/L12-D500	●	●	50	40	27	300	60	37	7	-6°	-10°	0.8							–	SSHM6-6	
A50U-PSKNR/L12-D630	●	●	63	50	35	350	65	47	10	-6°	-8°	0.8									

When using a right or left hand insert, the right hand insert (R) is used for the left hand toolholders (PSKNL □□ type), and the left hand insert (L) is used for the right hand toolholders (PSKNR □□ type).

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
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	2-62	2-64	2-67
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** (0.2-0.4)	**0.3** (0.2-0.3)
rε (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
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)
rε (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
Vc (m/min)	**1500** (500-2500)	**600** (100-1000)
ap (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)
rε (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
Vc (m/min)	**200** (70-300)	**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** (0.05-0.3)	**0.2** (0.1-0.3)	**0.3** (0.2-0.5)
rε (mm)	0.4	0.8	0.8

H Hard Materials — Continuous

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

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

● : Stocked items.

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STREAMJETBAR P-type PTFNR/L

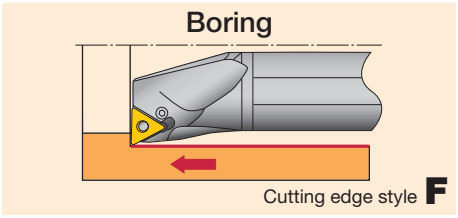
Negative rake / Lever-lock system

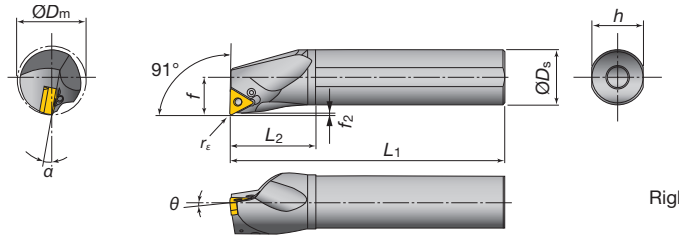
Min. bore dia. ø32 mm~

Shank dia. ø25~50 mm

Steel Shank

Oil Hole





Right hand (R) shown.

Steel Shank

Toolholder Cat. No.	Stock R	Stock L	Min bore.dia. ØDm	Dimensions (mm) ØDs	f	L1	L2	h	f2	θ	α	Std. corner radius rε	Applicable inserts	Parts: Shim	Lever	Clamping screw	Spring pin	Wrench	Oil supply attachment	Screw for oil hole	Torque (N·m)
A25R-PTFNR/L16-D320	●	●	32	25	17	200	45	23	1.2	-6°	-12°	0.8	TN□□1604	ELST317BR/L	LCL33	LCS3	LSP3	P-2.5	EA-25	SSHM4-5	2.7
A32S-PTFNR/L16-D400	●	●	40	32	22	250	50	30	1.1	-6°	-10°	0.8		LST317BR/L	LCL3				EA-32		
A40T-PTFNR/L16-D500	●	●	50	40	27	300	60	37	1.1	-6°	-10°	0.8							-	SSHM6-6	
A50U-PTFNR/L16-D630	●	●	63	50	35	350	65	47	1.1	-6°	-8°	0.8									

When using a right or left hand insert, the right hand insert (R) is used for the left hand toolholders (PTFNL □□ type), and the left hand insert (L) is used for the right hand toolholders (PTFNR □□ type).

STREAMJETBAR P-type PTUNR/L

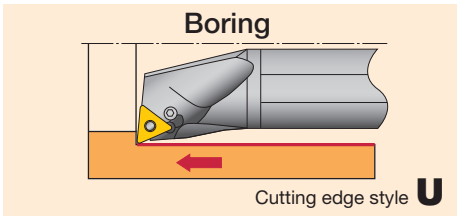
Negative rake / Lever-lock system

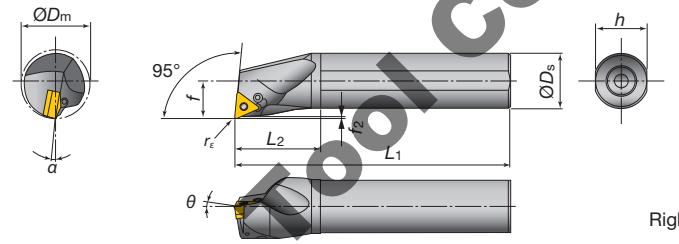
Min. bore dia. ø20 mm~

Shank dia. ø16~32 mm

Steel Shank

Oil Hole





Right hand (R) shown.

Steel Shank

Toolholder Cat. No.	Stock R	Stock L	Min bore.dia. ØDm	Dimensions (mm) ØDs	f	L1	L2	h	f2	θ	α	Std. corner radius rε	Applicable inserts	Parts: Shim	Lever	Clamping screw	Spring pin	Wrench	Oil supply attachment	Screw for oil hole	Torque (N·m)
A16M-PTUNR/L11-D200	●	●	20	16	11	150	32	15	1	-6°	-14°	0.4	TN□□1103	-	LCL22N	LCS22A	-	P-2F	-	SSHM3-4	1.7
A20Q-PTUNR/L11-D250	●	●	25	20	13	180	36	18	1	-6°	-12°	0.4							EA-20		
A25R-PTUNR/L16-D320	●	●	32	25	17	200	45	23	1.4	-6°	-12°	0.8	TN□□1604	ELST317BR/L	LCL33	LCS3	LSP3	P-2.5	EA-25	SSHM4-5	2.7
A32S-PTUNR/L16-D400	●	●	40	32	22	250	50	30	1.3	-6°	-10°	0.8		LST317BR/L	LCL3				EA-32		

* The insert hole conforms to the ISO standard.
* Tool holder length may be different to the ISO standard.

When using a right or left hand insert, the right hand insert (R) is used for the left hand toolholders (PTUNL □□ type), and the left hand insert (L) is used for the right hand toolholders (PTUNR □□ type).

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

	Operation	Precision finishing	Finishing	Finishing to medium cutting	Medium cutting
P Steel / Continuous	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)
	rε (mm)	0.4	0.4	0.8	1.2

	Operation	Finishing	Finishing to medium cutting
M Stainless / Continuous	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)
	rε (mm)	0.4	0.8

	Operation	Precision finishing	Finishing	Finishing to medium cutting	Medium cutting
K Cast Iron / Continuous	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)
	rε (mm)	0.4	0.4	0.8	1.2

	Operation	Precision finishing	Finishing	Finishing to medium cutting
N Non-ferrous / Continuous	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)
	rε (mm)	0.4	0.4	0.8

	Operation	Precision finishing	Finishing	Finishing to medium cutting	Medium cutting
S Superalloys / Continuous	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)
	rε (mm)	0.4	0.4	0.8	0.8

	Operation	Precision finishing	Finishing
H Hard Materials / Continuous	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)
	rε (mm)	0.4	0.4

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

● : Stocked items.

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PVUNR/L

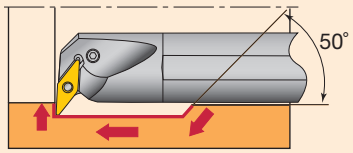
Min. bore dia. ø37 mm~

Shank dia. ø25~40 mm

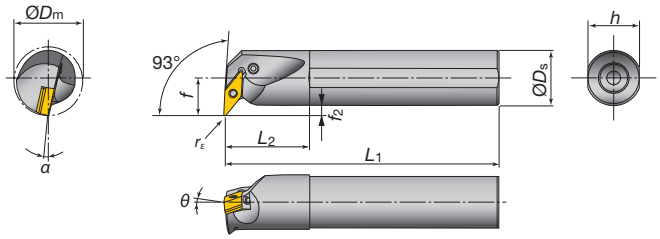
Steel Shank

Oil Hole

Boring & internal profiling



Cutting edge style **U**



Right hand (R) shown.

Steel Shank

Toolholder Cat. No.	Stock R	Stock L	Min bore.dia. ØDm	ØDs	f	L1	L2	h	f2	θ	a	Std. corner radius rε	Applicable inserts	Shim	Lever	Clamping screw	Spring pin	Wrench	Oil supply attachment	Screw for oil hole	Torque (N·m)
A25R-PVUNR/L16-D370	●	●	37	25	22	200	45	23	9.5	-5°	-14°	0.8	VN□□1604	LSV317BR/L	LCL3V	LCS3V	LSP3	P-2.5	EA-25	SSHM3-4	2.7
A32S-PVUNR/L16-D400	●	●	40	32	22	250	50	30	6	-5°	-12°	0.8							EA-32		
A40T-PVUNR/L16-D500	●	●	50	40	27	300	60	37	7	-5°	-10°	0.8							-	SSHM5-6	

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**
Vc (m/min)	**200** (150-250)	**200** (150-300)	**180** (150-300)
ap (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)
rε (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**
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)
rε (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**
Vc (m/min)	**700** (300-1200)	**270** (140-400)	**270** (150-400)
ap (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)
rε (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**
Vc (m/min)	**1500** (500-2500)	**600** (100-1000)
ap (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)
rε (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**
Vc (m/min)	**200** (100-280)	**200** (70-300)	**50** (20-100)
ap (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)
rε (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**
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 ~

● : Stocked items.

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PWLNR/L

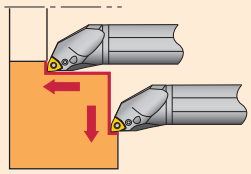
Min. bore dia. ø20 mm~

Shank dia. ø16~40 mm

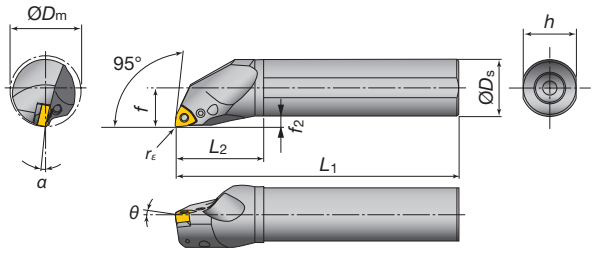
Steel Shank

Oil Hole

Boring & facing



Cutting edge style **L**



Right hand (R) shown.

Steel Shank

Toolholder Cat. No.	Stock R	Stock L	Min bore.dia. ØDm	Dimensions (mm) ØDs	f	L1	L2	h	f2	θ	a	Std. corner radius rε	Applicable inserts	Parts: Shim	Lever	Clamping screw	Spring pin	Wrench	Oil supply attachment	Screw for oil hole	Torque (N·m)
A16M-PWLNR/L06-D200	●	●	20	16	11	150	32	15	3	-8°	-17°	0.8	WN□□0604	-	LCL33N	LCS33	-	P-2F	-	SSHM3-4	1.7
A20Q-PWLNR/L06-D250	●	●	25	20	13	180	36	18	3	-6°	-14°	0.8		-			-		EA-20		
A25R-PWLNR/L06-D320	●	●	32	25	17	200	45	23	4.5	-6°	-12°	0.8		LSW312BR/L	LCL3	LCS3B	LSP3	P-2.5	EA-25	SSHM5-6	2.7
A32S-PWLNR/L06-D400	●	●	40	32	22	250	50	30	6	-6°	-11°	0.8				LCS3		P-2.5	EA-32		
A25R-PWLNR/L08-D320	●	●	32	25	17	200	45	23	4.5	-6°	-13°	0.8	WN□□0804	-	LCL43N	LCS43	-	P-2.5	EA-25	SSHM5-6	2.7
A32S-PWLNR/L08-D400	●	●	40	32	22	250	50	30	6	-6°	-11°	0.8		LSW42BR/L	LCL4	LCS4	LSP4	P-3	EA-32		4.8
A40T-PWLNR/L08-D500	●	●	50	40	27	300	60	37	7	-6°	-10°	0.8							-	SSHM6-6	

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**
Vc (m/min)	**200** (150-250)	**200** (150-300)	**220** (150-300)	**220** (150-250)
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	2-80	2-83	2-85
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)
rε (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**
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

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**
Vc (m/min)	**200** (70-300)	**50** (20-100)	**50** (20-80)
ap (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)
rε (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**
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 ~

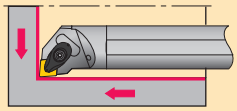
● : Stocked items.

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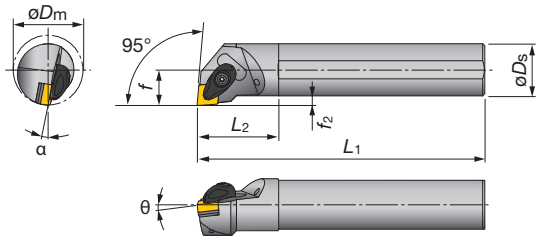
ACLNR/L

Min. bore dia. ø32 mm~ | Shank dia. ø25~50 mm | Steel Shank

Boring & Internal facing



Cutting edge style **L**



Oil Hole

Right hand (R) shown.

Cat. No.	Stock R	Stock L	Min bore.dia. ØDm	Dimensions (mm) øDs	f	L1	L2	h	f2	α	θ	Std. corner rε	Applicable inserts	Page
A25R-ACLNR/L12-D320	●	●	32	25	17	200	45	23	4.5	–13°	–6°	0.8	CN□□1204□□	2-42~
A32S-ACLNR/L12-D400	●	●	40	32	22	250	50	30	6	–10°				
A40T-ACLNR/L12-D500	●	●	50	40	27	300	55	37	7	–8°				
A50U-ACLNR/L12-D630	●		63	50	35	350	65	47	10	–7°				

T-CBN inserts 3-7~ | T-DIA inserts 3-21~

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 (0.2-0.5)
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	2-42	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)
rε (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)
rε (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 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 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)
rε (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)
rε (mm)	0.4	0.4

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

Parts for A-type

Cat. No.	Applicable inserts	Clamp	Clamping screw	Shim	Shim screw	Spring	Springpin	Wrench	Recommend clamping torque(N·m)
A□□□-ACLNR/L	CN□□1204□□	ACP4S	ACS-5W	ASC422	CSTB-3.5	BP-7	SP-2.5	T-15F	4.0

Note: Replacement parts of former A-type toolholders are not applicable to “Turning A” toolholders.

● : Stocked items.

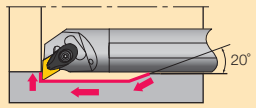
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ADUNR/L

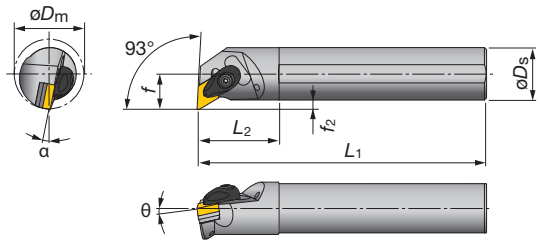
Negative rake / Double clamping system

Min. bore dia. ø32 mm~ | Shank dia. ø25~50 mm | Steel Shank

Boring & Internal facing



Cutting edge style **U**



Oil Hole

Right hand (R) shown.

Cat. No.	Stock R	Stock L	Min bore dia. øDm	Dimensions (mm) øDs	f	L1	L2	h	f2	α	θ	Std. corner rε	Applicable inserts	Page
A25R-ADUNR/L15-D320	●	●	32	25	17	200	45	23	4.5	–13°	–6°	0.8	DN□□1504□□	2-52~
A32S-ADUNR/L15-D400	●	●	40	32	22	250	50	30	6	–11°				
A40T-ADUNR/L15-D500	●		50	40	27	300	55	37	7	–8°				
A50U-ADUNR/L15-D630	●		63	50	35	350	65	47	10	–7°				
A25R-ADUNR/L1506-D320	●	●	32	25	17	200	45	23	4.5	–13°	–6°	0.8	DN□□1506□□	2-52~
A32S-ADUNR/L1506-D400	●	●	40	32	22	250	50	30	6	–11°				

T-CBN inserts 3-7~ T-DIA inserts 3-21~

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 ~

Parts for A-type

Cat. No.	Applicable inserts	Clamp	Clamping screw	Shim	Shim screw	Spring	Springpin	Wrench	Recommend clamping torque(N·m)
A□□□-ADUNR/L15	DN□□1504□□	ACP4S	ACS-5W	ASD432	CSTB-3.5	BP-7	SP-2.5	T-15F	4.0
A□□□-ADUNR/L1506	DN□□1506□□	ACP4S	ACS-5W	ASD423	CSTB-3.5	BP-7	SP-2.5	T-15F	4.0

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

● : Stocked items.

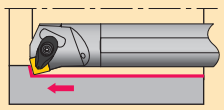
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ASKNR/L

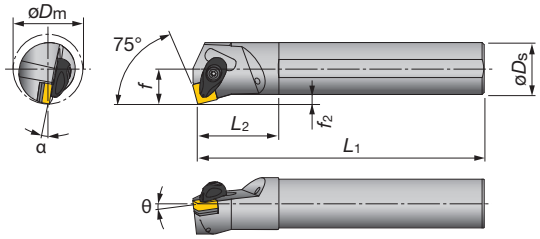
Negative rake / Double clamping system

Min. bore dia. ø32 mm~ | Shank dia. ø25~32 mm | Steel Shank

Through boring



Cutting edge style **K**



Oil Hole

Right hand (R) shown.

Cat. No.	Stock R	Stock L	Min bore.dia. øDm	Dimensions (mm) øDs	f	L1	L2	h	f2	α	θ	Std. corner rε	Applicable inserts	Page
A25R-ASKNR/L12-D320	●	●	32	25	17	200	45	23	4.5	–13°	–6°	0.8	SN□□1204□□	2-61~
A32S-ASKNR/L12-D400	●	●	40	32	22	250	50	30	6	–10°				

T-CBN inserts 3-8~ | T-DIA inserts 3-21~

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**
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	2-62	2-64	2-67
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** (0.2-0.4)	**0.3** (0.2-0.3)
rε (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**
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)
rε (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**
Vc (m/min)	**1500** (500-2500)	**600** (100-1000)
ap (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)
rε (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**
Vc (m/min)	**200** (70-300)	**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** (0.05-0.3)	**0.2** (0.1-0.3)	**0.3** (0.2-0.5)
rε (mm)	0.4	0.8	0.8

H Hard Materials — Continuous

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

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

Parts for A-type

Cat. No.	Applicable inserts	Clamp	Clamping screw	Shim	Shim screw	Spring	Springpin	Wrench	Recommend clamping torque(N·m)
A□□□-ASKNR/L	**SN□□1204□□**	ACP4S	ACS-5W	ASS422	CSTB-3.5	BP-7	SP-2.5	T-15F	4.0

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

● : Stocked items.

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Relating pages | Parts (14-1~)

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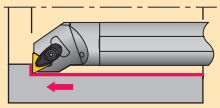
ATFNR/L

Negative rake / Double clamping system

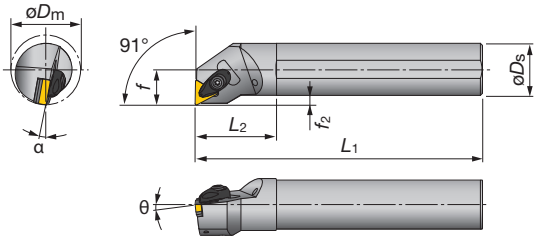
Min. bore dia. ø32 mm~ | Shank dia. ø25~32 mm | Steel Shank

Oil Hole

Blind hole boring



Cutting edge style **F**



Right hand (R) shown.

Cat. No.	Stock R	Stock L	Min bore.dia. ØDm	Dimensions (mm) øDs	f	L1	L2	h	f2	α	θ	Std. corner rε	Applicable inserts	Page
A25R-ATFNR/L16-D320	●	●	32	25	17	200	45	23	4.5	–13°	–6°	0.8	TN□□1604□□	2-70~
A32S-ATFNR/L16-D400	●	●	40	32	22	250	50	30	6	–10°				

T-CBN inserts 3-8~ | T-DIA inserts 3-21~

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)
rε (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)
rε (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)
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	2-70	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)
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	3-8	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)
rε (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)
rε (mm)	0.4	0.4

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

Parts for A-type

Cat. No.	Applicable inserts	Clamp	Clamping screw	Shim	Shim screw	Spring	Springpin	Wrench	Recommend clamping torque (N·m)
A□□□-ATFNR/L	**TN□□1604□□**	ACP3S	ACS-5W	AST322	CSTB-3.5	BP-7	SP-2.5	T-15F	3.0

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

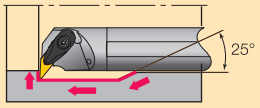
● : Stocked items.

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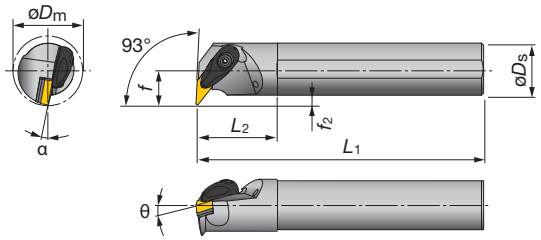
AVUNR/L

Min. bore dia. ø40 mm~ | Shank dia. ø32~40 mm | Steel Shank

Boring & internal profiling



Cutting edge style **U**



Oil Hole

Right hand (R) shown.

Cat. No.	Stock R	Stock L	Min bore.dia. ØDm	Dimensions (mm) øDs	f	L1	L2	h	f2	α	θ	Std. corner rε	Applicable inserts	Page
A32S-AVUNR/L16-D400	●	●	40	32	22	250	50	30	6	–10°	–6°	0.8	VN□□1604□□	2-88~
A40T-AVUNR/L16-D500	●	●	50	40	27	300	55	37	7	–8°			YN□□1604□□	2-87~

T-CBN inserts 3-9~ | T-DIA inserts 3-21~

5 TAC Internal Toolholders

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
Vc (m/min)	**200** (150-250)	**200** (150-300)	**180** (150-300)
ap (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)
rε (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
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)
rε (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
Vc (m/min)	**700** (300-1200)	**270** (140-400)	**270** (150-400)
ap (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)
rε (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
Vc (m/min)	**1500** (500-2500)	**600** (100-1000)
ap (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)
rε (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
Vc (m/min)	**200** (100-280)	**200** (70-300)	**50** (20-100)
ap (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)
rε (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
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 ~

Parts for A-type

Cat. No.	Applicable inserts	Clamp	Clamping screw	Shim	Shim screw	Spring	Springpin	Wrench	Recommend clamping torque(N·m)
A□□□-AVUNR/L	**VN□□1604□□** **YN□□1604□□**	ACP3L	ACS-5W	ASV322	CSTB-3.5	BP-7	SP-2.5	T-15F	3.0

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

● : Stocked items.

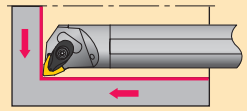
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AWLNR/L

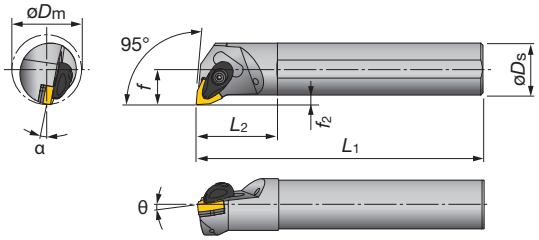
Negative rake / Double clamping system

Min. bore dia. ø32 mm~ | Shank dia. ø25~50 mm | Steel Shank

Boring & facing



Cutting edge style **L**



Oil Hole

Right hand (R) shown.

Cat. No.	Stock R	Stock L	Min bore.dia. øDm	Dimensions (mm) øDs	f	L1	L2	h	f2	α	θ	Std. corner rε	Applicable inserts	Page
A25R-AWLNR/L06-D320	●	●	32	25	17	200	45	23	4.5	–13°	–6°	0.8	WN□□0604□□	2-80~
A32S-AWLNR/L06-D400	●	●	40	32	22	250	50	30	6	–10°				
A25R-AWLNR/L08-D320	●	●	32	25	17	200	45	23	4.5	–13°	–6°	0.8	WN□□0804□□	2-80~
A32S-AWLNR/L08-D400	●	●	40	32	22	250	50	30	6	–10°				
A40T-AWLNR/L08-D500	●	●	50	40	27	300	55	37	7	–8°				
A50U-AWLNR/L08-D630	●	●	63	50	35	350	65	47	10	–7°				

T-CBN inserts 3-9~

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
Vc (m/min)	**200** (150-250)	**200** (150-300)	**220** (150-300)	**220** (150-250)
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	2-80	2-83	2-85
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)
rε (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
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

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
Vc (m/min)	**200** (70-300)	**50** (20-100)	**50** (20-80)
ap (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)
rε (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
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 ~

● : Stocked items.

Parts for A-type

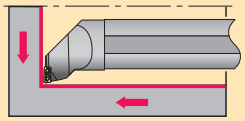
Cat. No.	Applicable inserts	Clamp	Clamping screw	Shim	Shim screw	Spring	Springpin	Wrench	Recommend clamping torque(N·m)
A□□□-AWLNR/L06	WN□□0604□□	ACP3S	ACS-5W	ASW322	CSTB-3.5	BP-7	SP-2.5	T-15F	3.0
A□□□-AWLNR/L08	WN□□0804□□	ACP4S	ACS-5W	ASW422	CSTB-3.5	BP-7	SP-2.5	T-15F	4.0

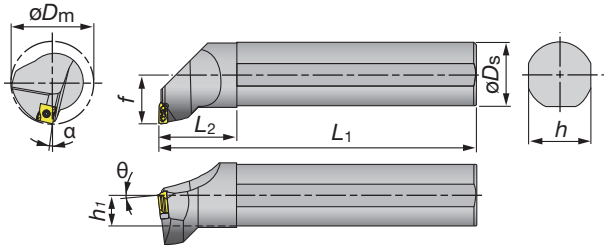
Note: Replacement parts of former A-type toolholders are not applicable to "Turning A" toolholders.

● : Stocked items.

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Boring & Internal facing



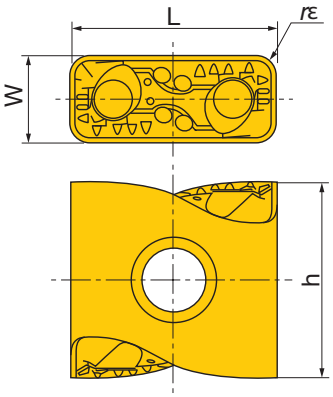


Right hand (R) shown.

Toolholders Cat. No.	Stock		Min bore.dia.	Dimensions (mm)						α	θ	Applicable inserts
	R	L	øDm	øDs	f	L1	L2	h	h1			
S25T-TLANR/L12-D530	●	●	53	25	17	300	40	23	11.5	-6°	-14°	LNMX1204□□L/R
S32U-TLANR/L12-D530	●	●	53	32	22	350	45	29	14.5	-6°	-14°	
S40V-TLANR/L12-D530	●	●	53	40	27	400	53	36	18	-6°	-14°	
S50U-TLANR/L16-D850	●	●	85	50	37	350	63	46	23	-6°	-10°	LNMX1606□□L/R

When using a right or left hand insert, the right hand insert (R) is used for the left hand toolholders (S-TLANL□□ type), and the left hand insert (L) is used for the right hand toolholders (S-TLANR□□ type).

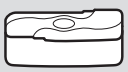
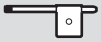
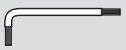
Inserts for TurnTec



Right hand (R) shown.

Cat. No.	Stocked grades						Dimensions (mm)			
	Coated									
	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
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

Parts for TurnTec

Toolholders Cat. No.	Applicable Inserts	Shim	Shim Screw	Spring pin	Wrench for shim screw	Clamping screw	Wrench
				–			
S25T-TLANR/L12-D530	LNMX1204□□L/R	TSL12L/RI	CSTF-2L055-S	–	T-6F-S	CSTB-3.5L115-S	KEYV-T10
S32U-TLANR/L12-D530							
S40V-TLANR/L12-D530							
S50U-TLANR/L16-D850	LNMX1606□□L/R	TSL16L/RI	–	PSP-16	–	CSTB-4L115-S	KEYV-T15

● : Stocked items
★ : Available from 2013

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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)		Feed: *f* (mm/rev)	
				r_ε: 0.8	r_ε: 1.2	r_ε: 0.8	r_ε: 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)			Feed: *f* (mm/rev)		
				r_ε: 0.8	r_ε: 1.2	r_ε: 1.6	r_ε: 0.8	r_ε: 1.2	r_ε: 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						

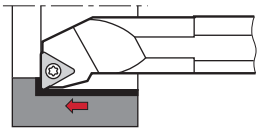
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STFPR/L

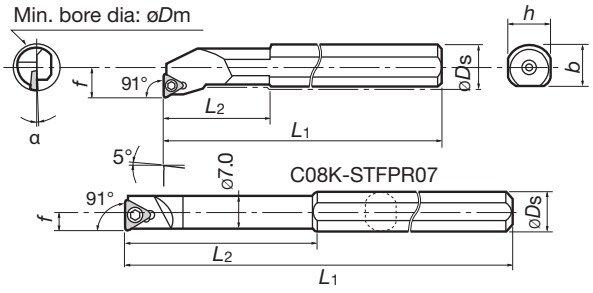
Min. bore dia. ø8mm~ | Shank dia. ø8~32mm | Steel Shank | Carbide Shank

Blind hole boring

STFPR/L



Cutting edge style **F**



Right hand (R) shown.

Steel Shank

Cat. No.	Stock R	Stock L	Min. bore dia. øDm	øDs	f	L1	L2	h	b	α	Std. corner rε	Applicable inserts		Clamping screw	Wrench
S08H-STFPR/L07			8	8	4	100	20	7	-	10°	0.4	TPGM	0701□□ 2-127	CSTB-2.2S	T-7F
S08H-STFPR/L09			10	8	5.5	100	16	7	-	8°	0.4	TPGM, TPGH, TPGA	0902□□ 2-123~	CSTB-2.2S	T-7F
S10K-STFPR/L11			12	10	6.5	125	20	9	-	6°	0.4	TPGM, TPGH, TPGA	1102□□ 2-123~	CSTB-2.5	T-8F
S12M-STFPR/L11			16	12	9	150	24	11	11.5	4°	0.4	TPGM, TPGH, TPGA	1102□□ 2-123~	CSTB-2.5	T-8F
S16Q-STFPR/L13			20	16	11	180	30	15	15.5	3°	0.4	TPGM, TPGH, TPGA	1303□□ 2-123~	CSTB-3	T-9F
S20R-STFPR/L13			24	20	13	200	40	18	19	2°	0.4	TPGM, TPGH, TPGA	1303□□ 2-123~	CSTB-3	T-9F
S25S-STFPR/L16			31	25	17	250	45	23	24	0°	0.8	TPGM, TPGH, TPGA	16T3□□ 2-123~	CSTB-4	T-15F
S32T-STFPR/L16			39	32	22	300	50	30	31	0°	0.8	TPGM, TPGH, TPGA	16T3□□ 2-123~	CSTB-4	T-15F

* Excepting TPGH, TPGM, TPGA

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

Carbide Shank

Cat. No.	Stock R	Stock L	Min. bore dia. øDm	øDs	f	L1	L2	h	b	α	Std. corner rε	Applicable inserts		Clamping screw	Wrench
C08K-STFPR/L07			8	8	4	125	45	7	-	10°	0.4	TPGM	0701□□ 2-127	CSTB-2.2S	T-7F
C08K-STFPR/L09			10	8	5.5	125	-	7	-	8°	0.4	TPGM, TPGH, TPGA	0902□□ 2-123~	CSTB-2.2S	T-7F
C10M-STFPR/L11			12	10	6.5	150	-	9	-	6°	0.4	TPGM, TPGH, TPGA	1102□□ 2-123~	CSTB-2.5	T-8F
C12Q-STFPR/L11			16	12	9	180	-	11	-	4°	0.4	TPGM, TPGH, TPGA	1102□□ 2-123~	CSTB-2.5	T-8F
C16R-STFPR/L13			20	16	11	200	-	15	-	3°	0.4	TPGM, TPGH, TPGA	1303□□ 2-123~	CSTB-3	T-9F
C20S-STFPR/L13			24	20	13	250	-	18	-	2°	0.4	TPGM, TPGH, TPGA	1303□□ 2-123~	CSTB-3	T-9F
C25T-STFPR/L16			31	25	17	300	-	23	-	0°	0.8	TPGM, TPGH, TPGA	16T3□□ 2-123~	CSTB-4	T-15F

* Excepting TPGH, TPGM, TPGA

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

Notes: • When using a right or left hand insert, the right hand insert is used for left hand toolholders and the left hand insert is used for right hand toolholders.

● : Stocked items.

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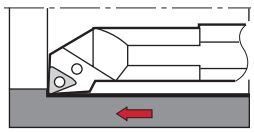
PTFNR/L

Negative rake / Lever-lock system

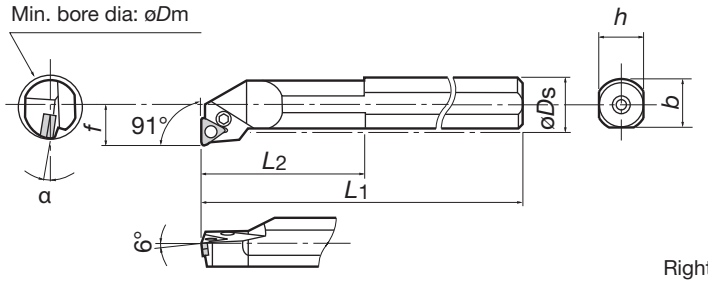
Min. bore dia. ø40mm~ | Shank dia. ø32~50mm | Steel Shank

Boring

PTFNR/L



Cutting edge style **F**



Right hand (R) shown.

Steel Shank

Cat. No.	Stock R	Stock L	Min. bore dia. øDm	Dimensions (mm) øDs	f	L1	L2	h	b	α	Std. corner rε	Applicable inserts		Shim	Lever	Clamping screw	Spring	Wrench
S32S-PTFNR/L16	●	●	40	32	22	250	50	30	29.5	10°	0.8	TN□□	1604□□ 2-70~	LST317B R / L	LCL3	LCS3	LSP3	P-2.5
S40T-PTFNR/L16	●	●	50	40	27	300	55	37	37.5									
S50U-PTFNR/L16	●		63	50	35	350	65	47	47.5	8°								

Notes: • When using a right or left hand insert, the right hand insert is used for left hand toolholders and the left hand insert is used for right hand toolholders.

T-CBN inserts 3-8 ~ T-DIA inserts 3-21

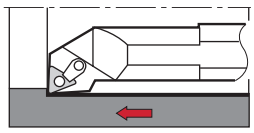
MTFNR/L

Negative rake / Multi clamping system

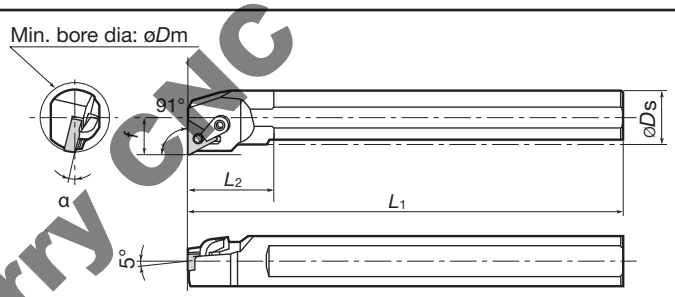
Min. bore dia. ø32mm | Shank dia. ø25mm | Steel Shank

Blind hole boring

MTFNR/L



Cutting edge style **F**



Right hand (R) shown.

Steel Shank

Cat. No.	Stock R	Stock L	Min. bore dia. øDm	Dimensions (mm) øDs	f	L1	L2	h	b	α	Std. corner rε	Applicable inserts		Lock pin	Clamp	Clamping screw	Shim	Wrench for lock pin	Wrench for clamp
S25R-MTFNR/L16	▲	▲	32	25	17	200	40	23	22.5	12°	0.8	TN□□	1604□□ 2-70~	MLP33L	MCL-5M* MCPM-6	MCS 520-2.5	-	P-2F	P-2.5

Notes: • When using a right or left hand insert, the right hand insert is used for left hand toolholders and the left hand insert is used for right hand toolholders.

T-CBN inserts 3-8 ~ T-DIA inserts 3-21

Note: * marked parts type No. is former type No.

● : Stocked items.
▲ : Will be replaced by new products.

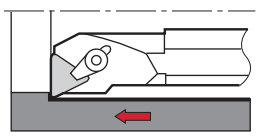
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CTFPR/L

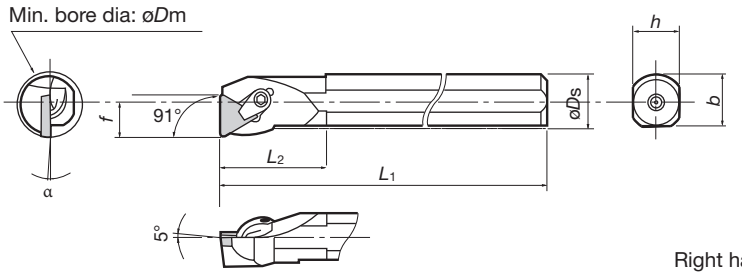
Min. bore dia. ø16mm~ | Shank dia. ø12~32mm | Steel Shank | Carbide Shank

Blind hole boring

CTFPR/L



Cutting edge style **F**



Right hand (R) shown.

Steel Shank

Cat. No.	Stock R	Stock L	Min. bore dia. øDm	Dimensions (mm) øDs	f	L1	L2	h	b	a	Std. corner rε	Applicable inserts		Clamp set	Wrench	Shim	Shim screw
S12M-CTFPR/L11	●	●	16	12	9	150	25	11	11.5	6°	0.4	TP□□ (Without hole)	1103□□ 2-130~	CSW-00	P-2.5	-	-
S16Q-CTFPR/L11	●	●	20	16	11	180	30	15	15	4°				CSG-5S			
S20R-CTFPR/L16	●	●	25	20	13	200	40	18	18.5	2°	0.8		1603□□ 2-130~	CSG-6S	P-3	-	-
S25S-CTFPR/L16	●	●	32	25	17	250	45	23	22.5	0°				CSG-6			
S32T-CTFPR/L16	●	●	40	32	22	300	50	30	29.5							PAT-32	M3×0.5×6

T-CBN inserts 3-14 ~ T-DIA inserts 3-23

Carbide Shank

Cat. No.	Stock R	Stock L	Min. bore dia. øDm	Dimensions (mm) øDs	f	L1	L2	h	b	a	Std. corner rε	Applicable inserts		Clamp set	Wrench	Shim	Shim screw
C12Q-CTFPR/L11	●	●	16	12	9	180	-	11	-	6°	0.4	TP□□ (Without hole)	1103□□ 2-130~	CSW-00	P-2.5	-	-
C16R-CTFPR/L11	●	●	20	16	11	200		15		4°				CSG-5S			

Notes: • The hole of inserts conforms to ISO standard.
• When using a right or left hand insert, the right hand insert is used for left hand toolholders and the left hand insert is used for right hand toolholders.

T-CBN inserts 3-14 ~ T-DIA inserts 3-23

Parts for positive-rake C-type toolholders when using chipbreaker piece

Toolholder Cat. No.	Shape	Clamp set	Chipbreaker piece
C12Q / S12M-CTFPR/L11		-	-
C16R / S16Q-CTFPR/L11		CSG-5	CBT-2M, (S)
S20R-CTFPR/L16 S25S-CTFPR/L16 S32T-CTFPR/L16		CSG-6	CBT-3M, (S, L)

Note: When using chipbreaker piece, order above optional parts separately. Chipbreaker piece grade: TX30

● : Stocked items.

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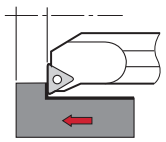
STUPR/L

Min. bore dia. ø8mm~ | Shank dia. ø8~32mm

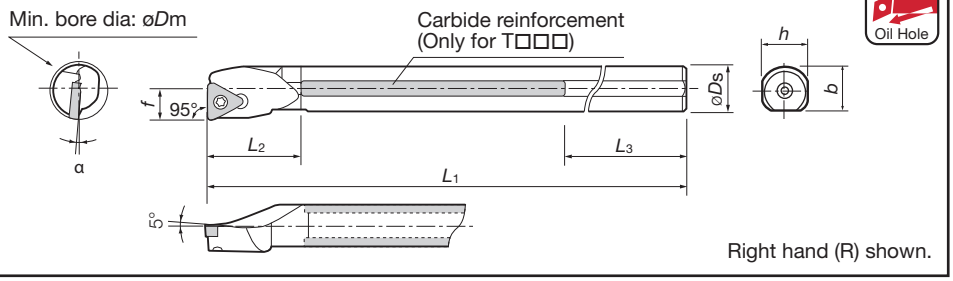
Tsuppari-Ichiban Shank | Steel Shank | Carbide Shank

Boring

STUPR/L



Cutting edge style **U**



Right hand (R) shown.

"Tsuppari-Ichiban" (Reinforced with carbide)

Cat. No.	Stock R	Stock L	Min. bore dia. øDm	Oil hole	øDs	f	L1	L2	L3	h	b	α	Std. corner rε	Applicable inserts		Clamping screw	Wrench
T12M-STUPR/L11-D14	●		14	-	12	7	150	24	59	11	-	4°	0.4	TP□□ *Excepting TPGH, TPGM, TPGA	1102□□ 2-123~	CSTB-2.5B	T-8F
T12M-STUPR/L11	●	●	16			9		25	58							CSTB-2.5	
T16Q-STUPR/L13-D18	●		18	-	16	9	180	30	59	15	-	3.5°	0.4		1303□□ 2-123~	CSTB-3S	T-9F
T16Q-STUPR/L13	●	●	20			11						3°				CSTB-3	
T20R-STUPR/L13C-D22	●		22	Rc1/4	20		200	35	49	18		2°				CSTB-3S	
T20R-STUPR/L13	●	●	24	-		13		40								CSTB-3	
T25S-STUPR/L16C-D27	●		27	Rc1/4	25	13.5	250	40	64	23	-	1°	0.8		16T3□□ 2-123~	CSTB-4S	T-15F
T25S-STUPR/L16	●	●	31	-		17		45				0°					

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

Steel Shank

Cat. No.	Stock R	Stock L	Min. bore dia. øDm	øDs	f	L1	L2	h	b	α	Std. corner rε	Applicable inserts		Clamping screw	Wrench	Coolant supply attachment
S08H-STUPR/L07			8	8	4	100	21	7	-	10°	0.4	TPGM	0701□□ 2-127	CSTB-2.2S	T-7F	-
S08H-STUPR/L09			10	8	5.5	100	16	7	-	8°	0.4	TP□□ *Excepting *TPGH, TPGM, TPGA	0902□□ 2-123~	CSTB-2.2S	T-7F	-
S10K-STUPR/L11			12	10	6.5	125	20	9	-	6°	0.4		1102□□ 2-123~	CSTB-2.5	T-8F	-
S12M-STUPR/L11			16	12	9	150	24	11	11.5	4°						
S16Q-STUPR/L13			20	16	11	180	30	15	15.5	3°	0.4		1303□□ 2-123~	CSTB-3	T-9F	-
S20R-STUPR/L13			24	20	13	200	40	18	19	2°						
S25S-STUPR/L16			31	25	17	250	45	23	24	0°	0.8		16T3□□ 2-123~	CSTB-4S	T-15F	-
S32T-STUPR/L16			39	32	22	300	50	30	31							
A20R-STUPR/L13			24	20	13	200	40	18	19		0.4	TP□□ *Excepting TPGH, TPGM, TPGA	1303□□ 2-123~	CSTB-3	T-9F	EA-20
A25S-STUPR/L16			31	25	17	250	45	23	24		0.8		16T3□□ 2-123~	CSTB-4S	T-15F	EA-25

Notes: • When using a right or left hand insert, the right hand insert is used for left hand toolholders and the left hand insert is used for right hand toolholders.

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

● : Stocked items.

Jinan Terry CNC Tool Co.,Ltd.

STUPR/L

Min. bore dia. ø8mm~ | Shank dia. ø8~32mm | Steel Shank | Carbide Shank

Carbide Shank

Cat. No.	Stock R	Stock L	Min. bore dia. øDm	Oil hole	Dimensions (mm) øDs	f	L1	L2	L3	h	b	α	Std. corner rε	Applicable inserts		Clamping screw	Wrench
C08K-STUPR/L07			8	-	8	4	125	45	-	7	-	10°	0.4	TPGM	0701□□ 2-127	CSTB-2.2S	T-7F
C08K-STUPR/L09			10	-	8	5.5	125	-	-	7	-	8°	0.4	TP□□ *Excepting TPGH, TPGM, TPGA	0902□□ 2-123~	CSTB-2.2S	T-7F
C10M-STUPR/L11			12	-	10	6.5	150	-	-	9	-	6°	0.4		1102□□ 2-123~	CSTB-2.5	T-8F
C12Q-STUPR/L11			16		12	9	180			11		4°					
C16R-STUPR/L13			20	-	16	11	200	-	-	15	-	3°	0.4		1303□□ 2-123~	CSTB-3	T-9F
C20S-STUPR/L13			24		20	13	250			18		2°					
C25T-STUPR/L16			31	-	25	17	300	-	-	23	-	0°	0.8		16T3□□ 2-123~	CSTB-4S	T-15F
E08J-STUPR/L07			8	-	8	4	110	40	-	7.5	-	-	0.4	TPGM	0701□□ 2-123~	CSTB-2.2S	T-7F
E08G-STUPR/L07							90										
E08J-STUPR/L09			10	-	8	5.5	110	-	-	7.5	-	-	0.4	TP□□ *Excepting TPGH, TPGM, TPGA	0902□□ 2-123~	CSTB-2.2S	T-7F
E08G-STUPR/L09							90										
E10K-STUPR/L11			12	-	10	6.5	120	-	-	9.5	-	-	0.4		1102□□ 2-123~	CSTB-2.5	T-8F
E10H-STUPR/L11							100										
E12L-STUPR/L11			16	-	12	9	130			11.5	-	-					
E12J-STUPR/L11							110										
E16M-STUPR/L13			20	-	16	11	150	-	-	15.5	-	-	0.4		1303□□ 2-123~	CSTB-3	T-9F
E16L-STUPR/L13							130										

Note: • When using a right or left hand insert, the right hand insert is used for left hand toolholders and the left hand insert is used for right hand toolholders.

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

● : Stocked items.

Jinan Terry CNC Tool Co.,Ltd.

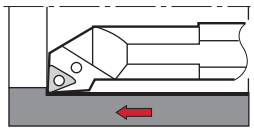
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PTUNR/L

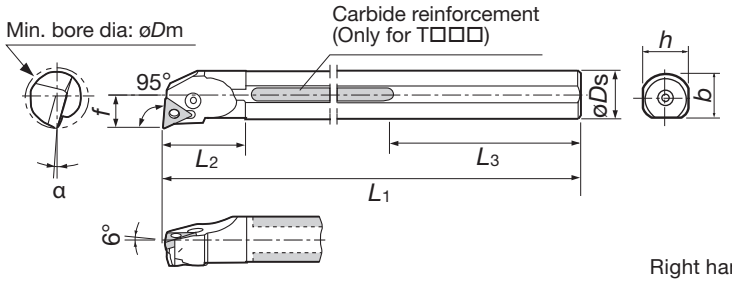
Min. bore dia. ø20mm~ | Shank dia. ø16~50mm | Tsuppari-Ichiban Shank | Carbide Shank

Boring

PTUNR/L



Cutting edge style **U**



Oil Hole

Right hand (R) shown.

"Tsuppari-Ichiban" (Reinforced with carbide)

Cat. No.	Stock R	Stock L	Min. bore dia. øDm	Oil hole	øDs	f	L1	L2	L3	h	b	α	Std. corner rε	Applicable inserts		Clamping screw	Wrench	Lever	Spring	Shim
T16Q-PTUNR/L11	●		20	-	16	11	180	27	59	15	-	14°	0.4	TN□□	1103□□ 2-70~	LCS22A	P-2F	LCL22N	-	-
T20R-PTUNR/L11C	●		25	Rc1/4	20	13	200	35	49	18		12°								
T25S-PTUNR/L16C	●		32		25	17	250	40	64	23	-	12°	0.8		1604□□ 2-70~	LCS3	P-2.5	LCL3	LSP3	ELST317B R/L
T32U-PTUNR/L16C	●		40	Rc1/2	32	22	350	50	103	30		10°								LST317B R/L
T40V-PTUNR/L16C	●		50		40	27	400	55	88	37								LCL3		
T50W-PTUNR/L16C	●		63		50	35	450	65	63	47		8°								

T-CBN inserts 3-8 ~ T-DIA inserts 3-21

Steel Shank

Cat. No.	Stock R	Stock L	Min. bore dia. øDm	øDs	f	L1	L2	h	b	α	Std. corner rε	Applicable inserts		Clamping screw	Wrench	Lever	Spring	Shim	Coolant supply attachmen
S16M-PTUNR/L11	●	●	20	16	11	150	30	15	15.5	14°	0.4	TN□□	1103□□ 2-70~	LCS22A	P-2F	LCL22N	-	-	-
S20Q-PTUNR/L11	●	●	25	20	13	180	35	18	19	12°									
S25R-PTUNR/L16	●	●	32	25	17	200	40	23	24	12°	0.8		1604□□ 2-70~	LCS3	P-2.5	LCL33	LSP3	ELST317B R/L	-
A32S-PTUNR/L16	●	●	40	32	22	250	50	30	29.5	12°	0.8	TN□□	1604□□ 2-70~	LCS3	P-2.5	LCL3	LSP3	LST317B R/L	EA-32

Notes : • The hole of inserts conforms to ISO standard.
• Toolholder lengths do not always conform to ISO.
• When using a right or left hand insert, the right hand insert is used for left hand toolholders and the left hand insert is used for right hand toolholders.

T-CBN inserts 3-8 ~ T-DIA inserts 3-21

● : Stocked items.

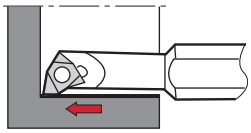
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SWUBR

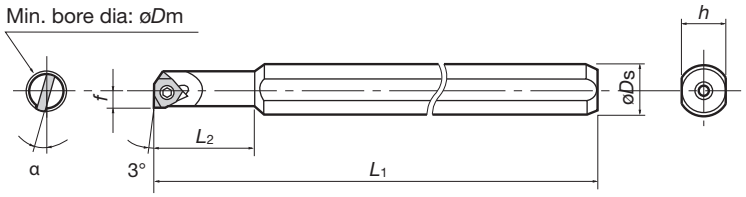
Min. bore dia. ø6mm~ | Shank dia. ø8mm | Steel Shank | Carbide Shank

Boring

SWUBR



Cutting edge style **U**



Right hand (R) shown.

Steel Shank

Cat. No.	Stock	Min. bore dia. øDm	Dimensions (mm)								Std. corner rε	Applicable inserts		Clamping screw	Wrench
	R		øDs	f	L1	L2	h	b	α	a					
S08H-SWUBR036		6	8	3.1	100	18	7	-	12°	-	0.4	WB□□	0301□□ 2-132	CSTB-2	T-6F
S08H-SWUBR037		7		3.6		20									

Carbide Shank

Cat. No.	Stock	Min. bore dia. øDm	Dimensions (mm)								Std. corner rε	Applicable inserts		Clamping screw	Wrench
	R		øDs	f	L1	L2	h	b	α	a					
C08K-SWUBR036		6	8	3.1	125	30	7	-	12°	-	0.4	WB□□	0301□□ 2-132	CSTB-2	T-6F
C08K-SWUBR037		7		3.6		40									

Notes : • The hole of inserts conforms to ISO standard.
• When using a left hand insert, it is used for right hand toolholders.

● : Stocked items.

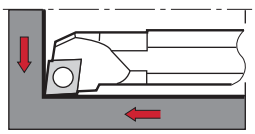
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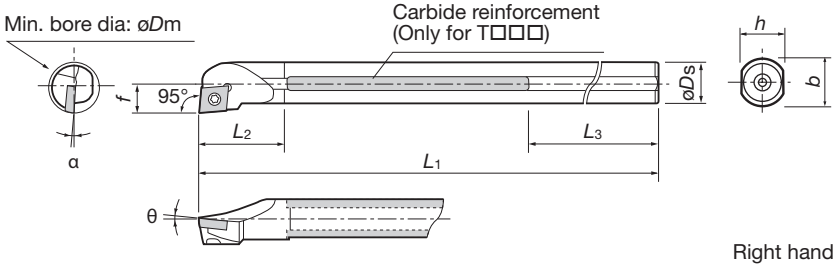
SCLCR/L

Boring & Internal facing

SCLCR/L



Cutting edge style **L**



Right hand (R) shown.

"Tsuppari-Ichiban" (Reinforced with carbide)

Cat. No.	Stock R	Stock L	Min. bore dia. øDm	Oil hole	Dimensions (mm) øDs	f	L1	L2	L3	h	b	α	θ	Std. corner rε	Applicable inserts		Clamping screw	Wrench
T12M-SCLCR/L06	●	●	16	-	12	9	150	22	59	11	-	10°	0°	0.4	CC□□	0602□□ 2-96~	CSTB-2.5	T-8F
T16Q-SCLCR/L09	●	●	20	-	16	11	180	27	59	15	-	10°	0°	0.8	CC□□	09T3□□ 2-96~	CSTB-4S	T-15F
T20R-SCLCR/L09C	●	●	25	Rc1/4	20	13	200	35	49	18	-	8°	0°	0.8	CC□□	09T3□□ 2-96~	CSTB-4S	T-15F
T25S-SCLCR/L09C	●	●	32	Rc1/4	25	17	250	40	64	23	-	6°	0°	0.8	CC□□	09T3□□ 2-96~	CSTB-4S	T-15F

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

Steel Shank

Cat. No.	Stock R	Stock L	Min. bore dia. øDm	Oil hole	Dimensions (mm) øDs	f	L1	L2	L3	h	b	α	θ	Std. corner rε	Applicable inserts		Clamping screw	Wrench
S08H-SCLCR/L06			10	-	8	5.5	100	16	-	7	-	13°	0°	0.4	CC□□	0602□□ 2-96~	CSTB-2.5S	T-8F
S10K-SCLCR/L06			13	-	10	7	125	25	-	9	-	12°	0°	0.4	CC□□	0602□□ 2-96~	CSTB-2.5	T-8F
S12M-SCLCR/L06			16	-	12	9	150	25	-	11	11.5	10°	0°	0.4	CC□□	0602□□ 2-96~	CSTB-2.5	T-8F
S16Q-SCLCR/L09			20	-	16	11	180	30	-	15	15.5	10°	0°	0.8	CC□□	09T3□□ 2-96~	CSTB-4S	T-15F
S20R-SCLCR/L09			25	-	20	13	200	35	-	18	19	6°	0°	0.8	CC□□	09T3□□ 2-96~	CSTB-4S	T-15F
S25S-SCLCR/L09			32	-	25	17	250	40	-	23	24	6°	0°	0.8	CC□□	09T3□□ 2-96~	CSTB-4S	T-15F

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

Carbide Shank

Cat. No.	Stock R	Stock L	Min. bore dia. øDm	Oil hole	Dimensions (mm) øDs	f	L1	L2	L3	h	b	α	θ	Std. corner rε	Applicable inserts		Clamping screw	Wrench
C08K-SCLCR/L06			10	-	8	5.5	125	21.5	-	7	-	13°	0°	0.4	CC□□	0602□□ 2-96~	CSTB-2.5S	T-8F
C10M-SCLCR/L06			13	-	10	7	150	-	-	9	-	12°	0°	0.4	CC□□	0602□□ 2-96~	CSTB-2.5	T-8F
C12Q-SCLCR/L06			16	-	12	9	180	-	-	11	-	10°	0°	0.4	CC□□	0602□□ 2-96~	CSTB-2.5	T-8F
C16R-SCLCR/L09			20	-	16	11	200	-	-	15	-	10°	0°	0.8	CC□□	09T3□□ 2-96~	CSTB-4S	T-15F
C20S-SCLCR/L09			25	-	20	13	250	-	-	18	-	8°	0°	0.8	CC□□	09T3□□ 2-96~	CSTB-4S	T-15F
C25T-SCLCR/L09			32	-	25	17	300	-	-	23	-	6°	0°	0.8	CC□□	09T3□□ 2-96~	CSTB-4S	T-15F

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

Notes: • The hole of inserts conforms to ISO standard.
• When using a right or left hand insert, the right hand insert is used for left hand toolholders and the left hand insert is used for right hand toolholders.

● : Stocked items.

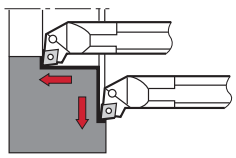
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PCLNR/L

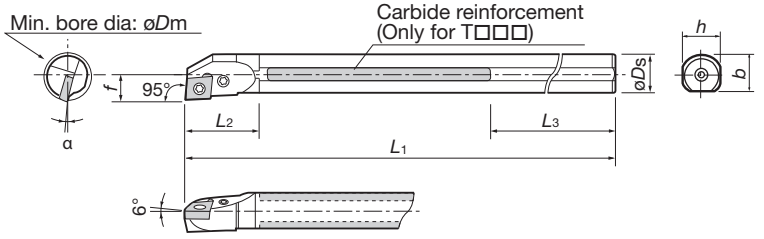
Min. bore dia. ø20mm~ | Shank dia. ø16~50mm | Tsuppari-Ichiban Shank | Steel Shank

Boring / Facing

PCLNR/L



Cutting edge style **L**



Right hand (R) shown.

"Tsuppari-Ichiban" (Reinforced with carbide)

Cat. No.	Stock R	Stock L	Min. bore dia. øDm	Oil hole	Dimensions (mm) øDs	f	L1	L2	L3	h	b	α	Std. corner rε	Applicable inserts		Clamping screw	Wrench	Lever	Shim	Spring
T16Q-PCLNR/L09	●		20	-	16	11	180	27	59	15		14°								
T20R-PCLNR/L09C	●		25	Rc1/4	20	13	200	35	49	18	-	12°	0.8	CN□□	0903□□ 2-42~	LCS22A	P-2F	LCL32N	-	-
T25S-PCLNR/L09C	●		32		25	17	250	40	64	23		11°								
T32U-PCLNR/L12C	●		40		32	22	350	50	103	30		11°								
T40V-PCLNR/L12C	●		50	Rc1/2	40	27	400	55	88	37	-	10°	0.8		1204□□ 2-42~	LCS4	P-3	LCL4	LSC42B R/L	LSP4
T50W-PCLNR/L12C	●		63		50	35	450	65	63	47		8°								

T-CBN inserts 3-7 ~ T-DIA inserts 3-21

Steel Shank

Cat. No.	Stock R	Stock L	Min. bore dia. øDm	Oil hole	Dimensions (mm) øDs	f	L1	L2	L3	h	b	α	Std. corner rε	Applicable inserts		Clamping screw	Wrench	Lever	Shim	Spring
S16M-PCLNR/L09	●	●	20	-	16	11	150	30		15	15.5	14°								
S20Q-PCLNR/L09	●	●	25	-	20	13	180	35	-	18	19	12°	0.8	CN□□	0903□□ 2-42~	LCS22A	P-2F	LCL32N	-	-
S25R-PCLNR/L09	●	●	32	-	25	17	200	40		23	24	11°								
S32S-PCLNR/L12	●	●	40	-	32	22	250	50		30	29.5	11°								
S40T-PCLNR/L12	●	●	50	-	40	27	300	55	-	37	37.5	10°	0.8		1204□□ 2-42~	LCS4	P-3	LCL4	LSC42B R/L	LSP4
S50U-PCLNR/L12	●	●	63	-	50	35	350	65		47	47.5	8°								

Notes: • When using a right or left hand insert, the right hand insert is used for left hand toolholders and the left hand insert is used for right hand toolholders.

T-CBN inserts 3-7~ T-DIA inserts 3-21

● : Stocked items.

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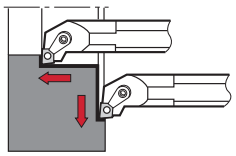
MCLNR/L

Negative rake / Multi clamping system

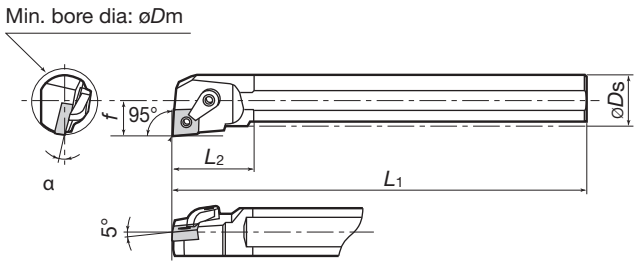
Min. bore dia. ø32mm | Shank dia. ø25mm | Steel Shank

Boring / facing

MCLNR/L



Cutting edge style **L**



Right hand (R) shown.

Steel Shank

Cat. No.	Stock R	Stock L	Min. bore dia. øDm	Dimensions (mm) øDs	f	L1	L2	h	b	α	Std. corner rε	Applicable inserts		Lock pin	Clamp	Clamping screw	Shim	Wrench for lock pin	Wrench for clamp
S25R-MCLNR/L12	●	●	32	25	17	200	40	23	22.5	12°	0.8	CN□□	1204□□ 2-42~	MLP44	MCRM-21	MCS620-3	-	P-2.5F	P-3

T-CBN inserts 3-7~ T-DIA inserts 3-21

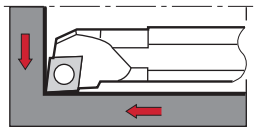
SCLPR/L

Positive rake / Screw-on system

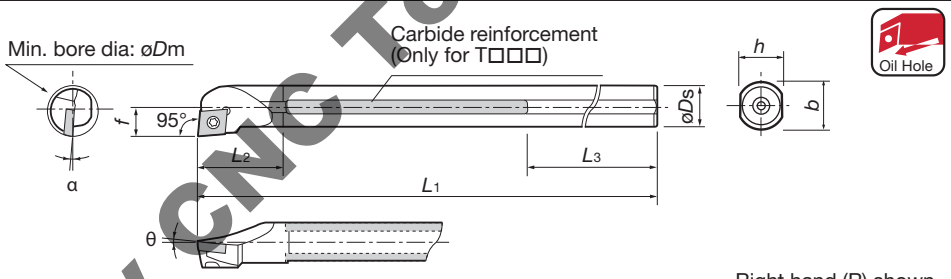
Min. bore dia. ø14mm~ | Shank dia. ø12~25mm | Tsuppari-Ichiban Shank

Boring / facing

SCLPR/L



Cutting edge style **L**



Right hand (R) shown.

"Tsuppari-Ichiban" (Reinforced with carbide)

Cat. No.	Stock R	Stock L	Min. bore dia. øDm	Oil hole	Dimensions (mm) øDs	f	L1	L2	L3	h	α	θ	Std. corner rε	Applicable inserts		Clamping screw	Wrench
T12M-SCLPR/L08-D14	●		14	-	12	7	150	22	59	11	4°	5°	0.4	CP□□	0802□□ 2-102~	CSTB-3L050	T-9F
T12M-SCLPR/L08	●	●	16			9		25			3°						
T16Q-SCLPR/L09-D18	●		18	-	16	9	180	27	59	15	3.5°	5°	0.8		0903□□ 2-102~	CSTB-4L060	T-15F
T16Q-SCLPR/L09	●	●	20			11		30			4°					CSTB-4S	
T20R-SCLPR/L09C-D22	●		22	Rc1/4	20		200	35	49	18	2°					CSTB-4L060	
T20R-SCLPR/L09	●	●	25	-		13										CSTB-4S	
T25S-SCLPR/L09C-D27	●		27	Rc1/4	25	13.5	250	40	64	23	1°					CSTB-4L060	
T25S-SCLPR/L09	●	●	32	-		17					0°					CSTB-4S	

Notes: • When using a right or left hand insert, the right hand insert is used for left hand toolholders and the left hand insert is used for right hand toolholders.

● : Stocked items.

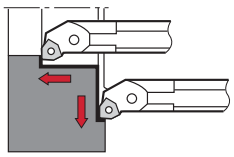
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PWLNR/L

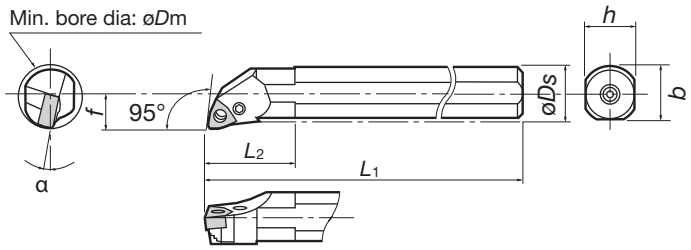
Min. bore dia. ø20mm~ | Shank dia. ø16~25mm | Steel Shank

Boring / facing

PWLNR/L



Cutting edge style **L**



Right hand (R) shown.

Steel Shank

Cat. No.	Stock R	Stock L	Min. bore dia. øDm	Dimensions (mm) øDs	f	L1	L2	h	b	α	Std. corner rε	Applicable inserts		Shim	Lever	Clamping screw	Spring	Wrench
S16M-PWLNR/L06	●	●	20	16	11	150	30	15	15.5	17°	0.8	WN□□	0604□□ 2-80~	-	LCL33N	LCS33	-	P-2F
S20Q-PWLNR/L06	●	●	25	20	13	180	35	18	19	14°				LSW312B R / L	LCL3	LCS3B	LSP3	P-2.5
S25R-PWLNR/L06	●	●	32	25	17	200	40	23	24	12°								

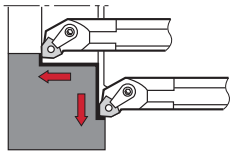
M-type / Internal Turning

MWLNR/L

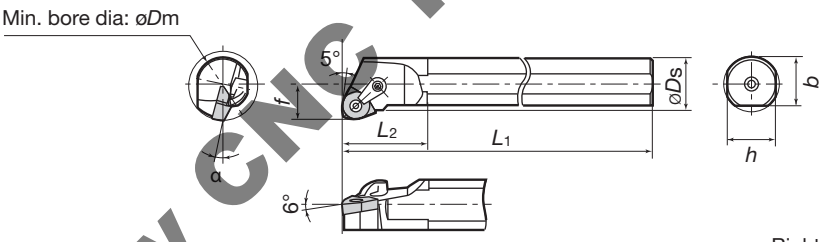
Min. bore dia. ø32mm~ | Shank dia. ø25~50mm | Steel Shank

Boring / facing

MWLNR/L



Cutting edge style **L**



Right hand (R) shown.

Steel Shank

Cat. No.	Stock R	Stock L	Min. bore dia. øDm	Dimensions (mm) øDs	f	L1	L2	h	b	α	Std. corner rε	Applicable inserts		Lock pin	Clamp	Clamping screw	Shim	Wrench for lock pin	Wrench for clamp
S25R-MWLNR/L08	▲	▲	32	25	17	200	40	23	22.5	12°	0.8	WN□□	0804□□ 2-80~	MLP44	MCPM-6	MCS 520-2.5	-	P-2.5F	P-2.5
S32S-MWLNR/L08	▲	▲	44	32	22	250	50	30	29.5	10°				MLP46			MSW -432BR/L		
S40T-MWLNR/L08	▲	▲	54	40	27	300	60	37	37.5										
S50U-MWLNR/L08	▲	▲	70	50	35	350	75	47	47.5										

T-CBN inserts 3-9

● : Stocked items.
▲ : Will be replaced by new products.

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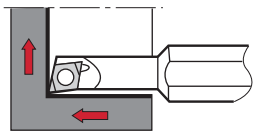
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SEXPR/L

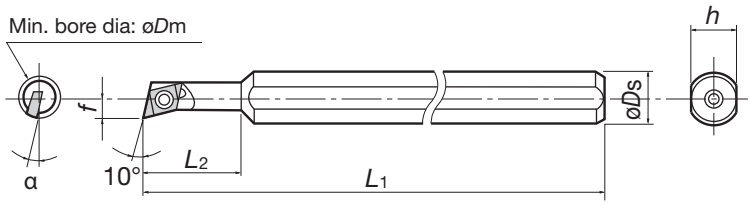
Min. bore dia. ø5.5mm~ | Shank dia. ø8mm | Steel Shank | Carbide Shank

Boring & facing

SEXPR/L



Cutting edge style **X**



Right hand (R) shown.

Steel Shank

Cat. No.	Stock R	Stock L	Min. bore dia. øDm	Dimensions (mm) øDs	f	L1	L2	h	b	α	Std. corner rε	Applicable inserts		Clamping screw	Wrench
S08H-SEXPR/L045			5.5	8	2.75	100	16	7	-	12°	0.4	EP□□	0401□□ 2-111	CSTB-2	T-6F
JS08H-SEXPR/L045	●				2.7										
S08H-SEXPR/L047			7		3.6		20								
JS08H-SEXPR/L047	●														

T-DIA inserts 3-23

Carbide Shank

Cat. No.	Stock R	Stock L	Min. bore dia. øDm	Dimensions (mm) øDs	f	L1	L2	h	b	α	Std. corner rε	Applicable inserts		Clamping screw	Wrench
C08K-SEXPR/L045			5.5	8	2.75	125	28	7	-	12°	0.4	EP□□	0401□□ 2-111	CSTB-2	T-6F
C08K-SEXPR/L047			7		3.6		40								

Notes: • When using a right or left hand insert, the right hand insert is used for left hand toolholders and the left hand insert is used for right hand toolholders.

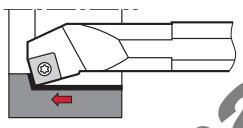
T-DIA inserts 3-23

SSKPR/L

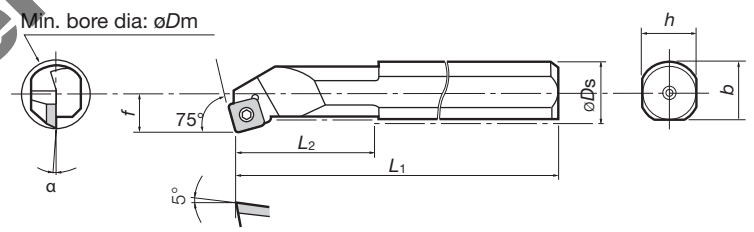
Min. bore dia. ø20mm~ | Shank dia. ø16~32mm | Steel Shank

Through boring

SSKPR/L



Cutting edge style **K**



Right hand (R) shown.

Steel Shank

Cat. No.	Stock R	Stock L	Min. bore dia. øDm	Dimensions (mm) øDs	f	L1	L2	h	b	α	Std. corner rε	Applicable inserts		Clamping screw	Wrench
S16Q-SSKPR/L09			20	16	11	180	30	15	15.5	6°	0.8	SP□□	0903□□ 2-114	CSTB-4S	T-15F
S20R-SSKPR/L09			24	20	13	200	40	18	19	2°					
S25S-SSKPR/L12			31	25	17	250	45	23	24	2°	0.8		1204□□ 2-114	CSTB-5	T-20F
S32T-SSKPR/L12			39	32	22	300	50	30	31	0°					

Notes : • The hole of inserts conforms to ISO standard.
• When using a right or left hand insert, the right hand insert is used for left hand toolholders and the left hand insert is used for right hand toolholders.

T-CBN inserts 3-15

● : Stocked items.

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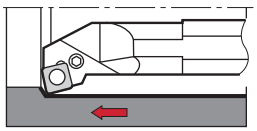
PSKNR/L

Min. bore dia. ø40mm~ | Shank dia. ø32~50mm | Steel Shank

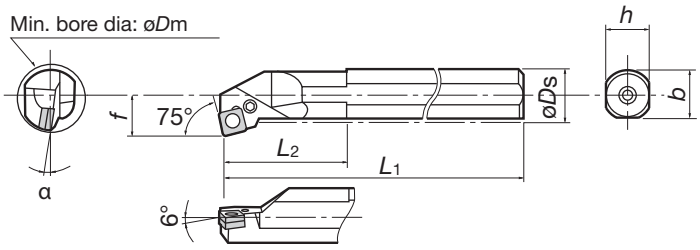
Negative rake / Lever-lock system

Through boring

PSKNR/L



Cutting edge style **K**



Right hand (R) shown.

Steel Shank

Cat. No.	Stock R	Stock L	Min. bore dia. øDm	Dimensions (mm) øDs	f	L1	L2	h	b	a	Std. corner rε	Applicable inserts		Shim	Lever	Clamping screw	Spring	Wrench
S32S-PSKNR/L12	●		40	32	22	250	50	30	29.5	10°	0.8	SN□□	1204□□ 2-61~	LS342B R / L	LCL4	LCS4	LSP4	P-3
S40T-PSKNR/L12	●		50	40	27	300	55	37	37.5									
S50U-PSKNR/L12	●		63	50	35	350	65	47	47.5	8°								

Notes: • When using a right or left hand insert, the right hand insert is used for left hand toolholders and the left hand insert is used for right hand toolholders.

T-CBN inserts 3-8 ~ T-DIA inserts 3-21

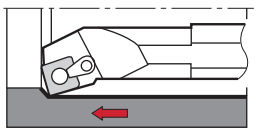
MSKNR/L

Min. bore dia. ø32mm | Shank dia. ø25mm | Steel Shank

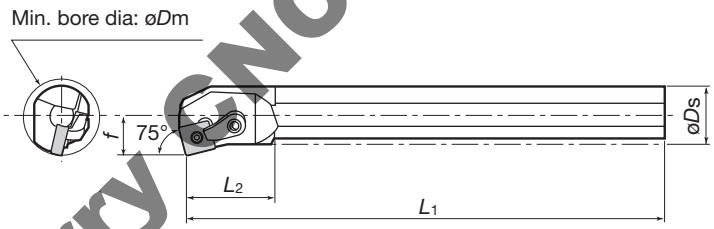
Negative rake / Multi clamping system

Boring & through boring

MSKNR/L



Cutting edge style **K**



Right hand (R) shown.

Steel Shank

Cat. No.	Stock R	Stock L	Min. bore dia. øDm	Dimensions (mm) øDs	f	L1	L2	h	b	a	Std. corner rε	Applicable inserts		Lock pin	Clamp	Clamping screw	Shim	Wrench for lock pin	Wrench for clamp
S25R-MSKNR/L12	▲	▲	32	25	17	200	40	23	22.5	12°	0.8	SN□□	1204□□ 2-61~	MLP44	MCL- 6* MCPM-21	MCS620-3	-	P-2.5F	P-3

Notes: • When using a right or left hand insert, the right hand insert is used for left hand toolholders and the left hand insert is used for right hand toolholders.

T-CBN inserts 3-8 ~ T-DIA inserts 3-21

Note: * marked parts type No. is former type No.

● : Stocked items.
▲ : Will be replaced by new products.

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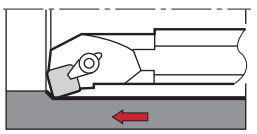
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CSKPR/L

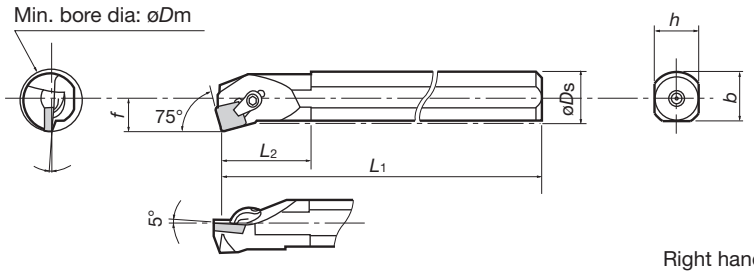
Min. bore dia. ø20mm~ | Shank dia. ø16~32mm | Steel Shank | Carbide Shank

Boring & Through boring

CSKPR/L



Cutting edge style **K**



Right hand (R) shown.

Steel Shank

Cat. No.	Stock R	Stock L	Min. bore dia. øDm	Dimensions (mm) øDs	f	L1	L2	h	b	α	Std. corner rε	Applicable inserts		Clamp set	Wrench	Shim	Shim screw
S16Q-CSKPR/L09	●		20	16	11	180	30	15	15	4°	0.8	SP□□ (Without hole)	0903□□ 2-116	CSG-5S	P-2.5	-	-
S20R-CSKPR/L09	●	●	25	20	13	200	40	18	18.5	2°				CSG-5			
S25S-CSKPR/L12	●		32	25	17	250	45	23	22.5	0°	0.8		1203□□ 2-116	CSG-6	P-3	-	-
S32T-CSKPR/L12			40	32	22	300	50	30	29.5							PAS-42	SM3 ×0.5×6

T-CBN inserts 3-14 ~ T-DIA inserts 3-22

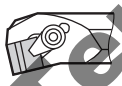
Carbide Shank

Cat. No.	Stock R	Stock L	Min. bore dia. øDm	Dimensions (mm) øDs	f	L1	L2	h	b	α	Std. corner rε	Applicable inserts		Clamp set	Wrench	Shim	Shim screw
C16R-CSKPR/L09	●		20	16	11	200	-	15	-	4°	0.8	SP□□ (Without hole)	0903□□ 2-116	CSG-5S	P-2.5	-	-

Notes: • When using a right or left hand insert, the right hand insert is used for left hand toolholders and the left hand insert is used for right hand toolholders.

T-CBN inserts 3-14 ~ T-DIA inserts 3-22

Parts for positive-rake C-type toolholders when using chipbreaker piece

Toolholder Cat. No.	Shape	Clamp set	Chipbreaker piece
C16R · S16Q-CSKPR / L09 S20R - CSKPR / L09 S25S - CSKPR / L12 S32T - CSKPR / L12		CSG-5	CBS-3M, (S, L)
		CSG-6	CBS - 4M, (S, L)

Note: When using chipbreaker piece, order above optional parts separately. Chipbreaker piece grade:TX30

● : Stocked items.

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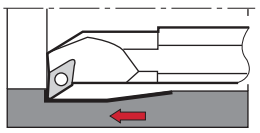
SDUCR/L

Positive rake / Screw-on system

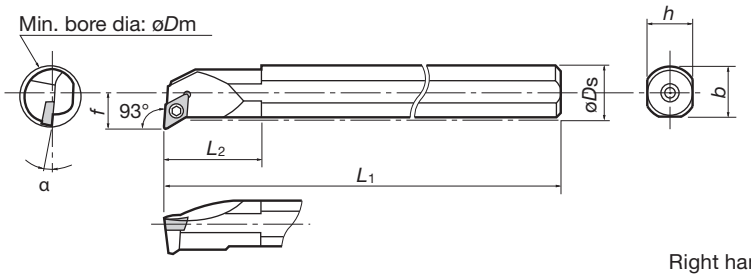
Min. bore dia. ø13mm~ | Shank dia. ø10~25mm | Steel Shank | Carbide Shank

Internal profiling

SDUCR/L



Cutting edge style **U**



Right hand (R) shown.

Steel Shank

Cat. No.	Stock R	Stock L	Min. bore dia. øDm	Dimensions (mm) øDs	f	L1	L2	h	b	α	Std. corner rε	Applicable inserts		Clamping screw	Wrench
S10K-SDUCR/L07			13	10	7	125	25	9	10	10°	0.4	DC□□	0702□□ 2-105~	CSTB-2.5	T-8F
S12M-SDUCR/L07			16	12	9	150	25	11	11.5	8°	0.4	DC□□	0702□□ 2-105~	CSTB-2.5	T-8F
S16Q-SDUCR/L07			20	16	11	180	30	15	15.5	6°	0.4	DC□□	0702□□ 2-105~	CSTB-2.5	T-8F
S20R-SDUCR/L11			25	20	13	200	35	18	18.5	8°	0.4	DC□□	11T3□□ 2-105~	CSTB-4S	T-15F
S25S-SDUCR/L11			32	25	17	250	40	23	24	4°	0.4	DC□□	11T3□□ 2-105~	CSTB-4	T-15F

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

Carbide Shank

Cat. No.	Stock R	Stock L	Min. bore dia. øDm	Dimensions (mm) øDs	f	L1	L2	h	b	α	Std. corner rε	Applicable inserts		Clamping screw	Wrench
C10M-SDUCR/L07			13	10	7	150	24	9	-	10°	0.4	DC□□	0702□□ 2-105~	CSTB-2.5	T-8F
C12Q-SDUCR/L07			16	12	9	180	-	11	12	8°	0.4	DC□□	0702□□ 2-105~	CSTB-2.5	T-8F
C16R-SDUCR/L07			20	16	11	200	-	15	16	6°	0.4	DC□□	0702□□ 2-105~	CSTB-2.5	T-8F
C20S-SDUCR/L11			25	20	13	250	-	18	-	8°	0.4	DC□□	11T3□□ 2-105~	CSTB-4S	T-15F

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

Notes: • The hole of inserts conforms to ISO standard.
• When using a right or left hand insert, the right hand insert is used for left hand toolholders and the left hand insert is used for right hand toolholders.

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PDUNR/L

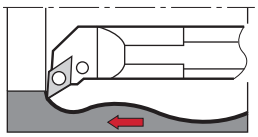
Min. bore dia. ø25mm~ | Shank dia. ø20~50mm

Negative rake / Lever-lock system

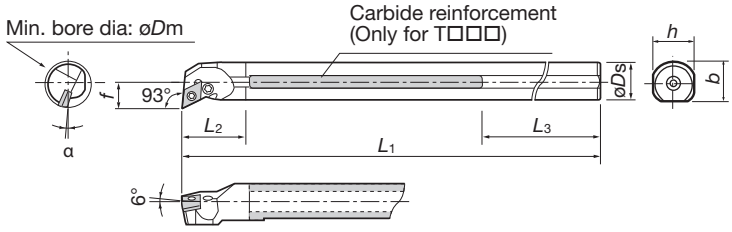
Tsuppari-Ichiban Shank | Steel Shank

Internal profiling

PDUNR/L



Cutting edge style **U**



Right hand (R) shown.

"Tsuppari-Ichiban" (Reinforced with carbide)

Cat. No.	Stock R	Stock L	Min. bore dia. øDm	Oil hole	Dimensions (mm) øDs	f	L1	L2	L3	h	b	α	Std. corner rε	Applicable inserts		Clamping screw	Wrench	Lever	Shim	Spring
T32U-PDUNR/L15C	●		40	Rc1/2	32	22	350	50	103	30	-	13°	0.8	DN□□	1504□□ 2-52~	LCS4	P-3	LCL4	LSD42B R / L	LSP4
T40V-PDUNR/L15C	●		50		40	27	400	55	88	37		10°								
T50W-PDUNR/L15C	●		63		50	35	450	65	63	47		8°								

T-CBN inserts 3-7 ~ T-DIA inserts 3-21

Steel Shank

Cat. No.	Stock R	Stock L	Min. bore dia. øDm	Oil hole	Dimensions (mm) øDs	f	L1	L2	L3	h	b	α	Std. corner rε	Applicable inserts		Clamping screw	Wrench	Lever	Shim	Spring
S20Q-PDUNR/L11	●	●	25	-	20	13	180	35	-	18	19	14°	0.8	DN□□	1104□□ 2-52~	LCS22A	P-2F	LCL33NL	-	-
S25R-PDUNR/L11	●	●	32		25	17	200	40		23	24	12°				LCS3	P-2.5	LCL33L	ELSD317B R / L	LSP3
S32S-PDUNR/L15	●	●	40	-	32	22	250	50	-	30	29.5	13°	0.8		1504□□ 2-52~	LCS4	P-3	LCL4	LSD42B R / L	LSP4
S40T-PDUNR/L15	●	●	50		40	27	300	55		37	37.5	10°								
S50U-PDUNR/L15	●	●	63		50	35	350	65		47	47.5	8°								

T-CBN inserts 3-7 ~ T-DIA inserts 3-21

Notes: • When using a right or left hand insert, the right hand insert is used for left hand toolholders and the left hand insert is used for right hand toolholders.

MDUNR/L

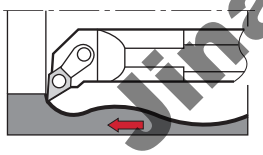
Min. bore dia. ø32mm~ | Shank dia. ø25mm

Negative rake / Multi clamping system

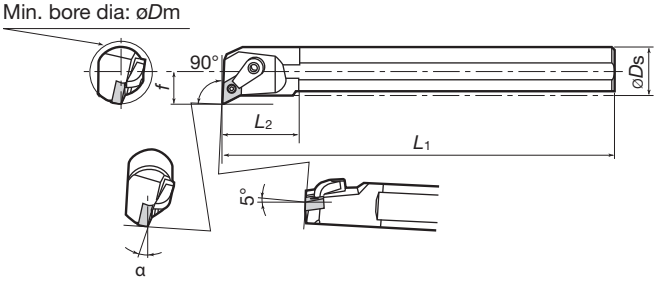
Steel Shank

Internal profiling

MDUNR/L



Cutting edge style **U**



Right hand (R) shown.

Steel Shank

Cat. No.	Stock R	Stock L	Min. bore dia. øDm	Dimensions (mm) øDs	f	L1	L2	h	b	α	Std. corner rε	Applicable inserts		Lock pin	Clamp	Clamping screw	Shim	Wrench for lock pin	Wrench for clamp
S25R-MDUNR/L11	▲	▲	32	25	17	200	40	23	22.5	12°	0.8	DN□□	1104□□ 2-52~	MLP33L	MCL- 6* MCPM-21	MCS620-3	-	P-2F	P-3

Notes: • When using a right or left hand insert, the right hand insert is used for left hand toolholders and the left hand insert is used for right hand toolholders.

Note: * marked parts type No. is former type No.

● : Stocked items.
▲ : Will be replaced by new products.

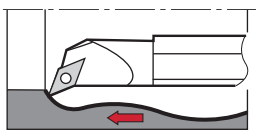
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SDQCR/L

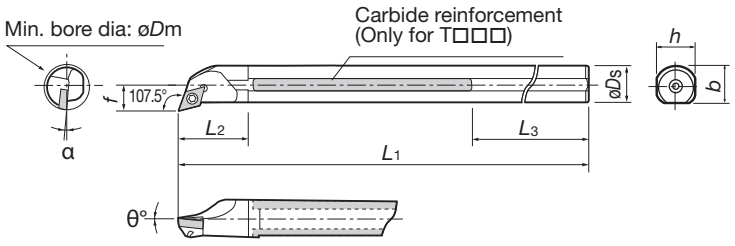
Min. bore dia. ø13mm~ | Shank dia. ø10~25mm | Tsuppari-Ichiban Shank | Steel Shank | Carbide Shank

Internal profiling

SDQCR/L



Cutting edge style **Q**



Right hand (R) shown.

"Tsuppari-Ichiban" (Reinforced with carbide)

Cat. No.	Stock R	Stock L	Min. bore dia. øDm	Oil hole	Dimensions (mm) øDs	f	L1	L2	L3	h	b	α	Std. corner rε	Applicable inserts		Clamping screw	Wrench
T16Q-SDQCR/L07	●	●	20	-	16	11	180	27	59	15	-	6°	0.4	DC□□	0702□□ 2-105	CSTB-2.5	T-8F
T20R-SDQCR/L11C	●	●	25	Rc1/4	20	13	200	35	49	18	-	6°	0.8	DC□□	11T3□□ 2-105	CSTB-4M	T-15F
T25S-SDQCR/L11C	●	●	32	Rc1/4	25	17	250	40	64	23	-	4°	0.8	DC□□	11T3□□ 2-105	CSTB-4	T-15F

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

Steel Shank

Cat. No.	Stock R	Stock L	Min. bore dia. øDm	Oil hole	Dimensions (mm) øDs	f	L1	L2	L3	h	b	α	Std. corner rε	Applicable inserts		Clamping screw	Wrench
S10K-SDQCR/L07			13	-	10	7	125	25	-	9	-	10°	0.4	DC□□	0702□□ 2-105	CSTB-2.5	T-8F
S12M-SDQCR/L07			16	-	12	9	150	25	-	11	11.5	7°	0.4	DC□□	0702□□ 2-105	CSTB-2.5	T-8F
S16Q-SDQCR/L07			20	-	16	11	180	30	-	15	15.5	6°	0.4	DC□□	0702□□ 2-105	CSTB-2.5	T-8F
S20R-SDQCR/L11			25	-	20	13	200	35	-	18	19	6°	0.8	DC□□	11T3□□ 2-105	CSTB-4M	T-15F
S25S-SDQCR/L11			32	-	25	17	250	40	-	23	24	4°	0.8	DC□□	11T3□□ 2-105	CSTB-4	T-15F

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

Carbide Shank

Cat. No.	Stock R	Stock L	Min. bore dia. øDm	Oil hole	Dimensions (mm) øDs	f	L1	L2	L3	h	b	α	Std. corner rε	Applicable inserts		Clamping screw	Wrench
C10M-SDQCR/L07			13	-	10	7	150	-	-	9	-	10°	0.4	DC□□	0702□□ 2-105	CSTB-2.5	T-8F
C12Q-SDQCR/L07			16	-	12	9	180	-	-	11	-	7°	0.4	DC□□	0702□□ 2-105	CSTB-2.5	T-8F
C16R-SDQCR/L07			20	-	16	11	200	-	-	15	-	6°	0.4	DC□□	0702□□ 2-105	CSTB-2.5	T-8F
C20S-SDQCR/L11			25	-	20	13	250	-	-	18	-	6°	0.8	DC□□	11T3□□ 2-105	CSTB-4M	T-15F

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

Notes: • The hole of inserts conforms to ISO standard.
• When using a right or left hand insert, the right hand insert is used for left hand toolholders and the left hand insert is used for right hand toolholders.

● : Stocked items.

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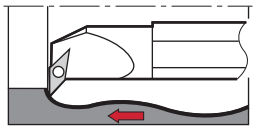
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SVUBR/L

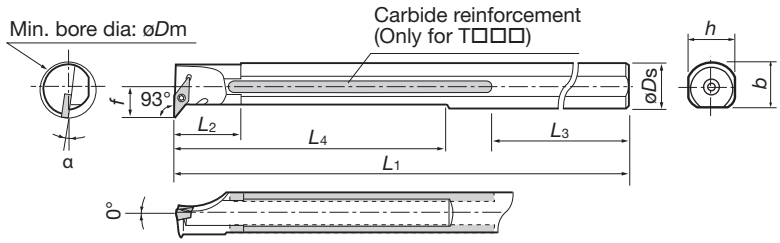
Min. bore dia. ø25mm | Shank dia. ø20mm | Tsuppari-Ichiban Shank

Internal profiling

SVUBR/L



Cutting edge style **U**



Right hand (R) shown.

"Tsuppari-Ichiban" (Reinforced with carbide)

Cat. No.	Stock R	Stock L	Min. bore dia. øDm	Oil hole	Dimensions (mm) øDs	f	L1	L2	L3	L4	h	b	α	Std. corner rε	Applicable inserts		Clamping screw	Wrench	Shim	Shim screw	Wrench
T20R-SVUBR/L11C	●		25	Rc1/4	20	14	200	30	59	121	18	-	8°	0.4	VB□□	1103□□ 2-133	CSTB-2.5	T-8F	-	-	-

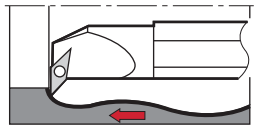
T-CBN inserts 3-13 ~

SVUCR/L

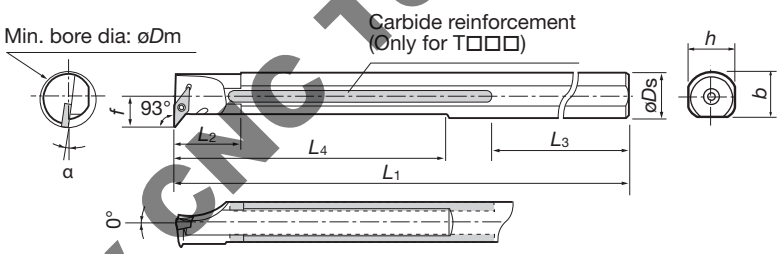
Min. bore dia. ø32mm~ | Shank dia. ø25~40mm | Tsuppari-Ichiban Shank | Steel Shank

Internal profiling

SVUCR/L



Cutting edge style **U**



Right hand (R) shown.

"Tsuppari-Ichiban" (Reinforced with carbide)

Cat. No.	Stock R	Stock L	Min. bore dia. øDm	Oil hole	Dimensions (mm) øDs	f	L1	L2	L3	L4	h	b	α	Std. corner rε	Applicable inserts		Clamping screw	Wrench	Shim	Shim screw	Wrench
T25S-SVUCR/L16C	●		32	Rc1/4	25	19	250	40	64	-	23	-	5°	0.8	VC□□	1604□□ 2-135	CSTB-3.5L	T-15F	-	-	-

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

Steel Shank

Cat. No.	Stock R	Stock L	Min. bore dia. øDm	Oil hole	Dimensions (mm) øDs	f	L1	L2	L3	L4	h	b	α	Std. corner rε	Applicable inserts		Clamping screw	Wrench	Shim	Shim screw	Wrench
S25S-SVUCR/L16			32	-	25	19	250	40	-	-	23	24	5°	0.8	VC□□	1604□□ 2-135	CSTB-3.5L	T-15F	-	-	-
S32T-SVUCR/L16			40		32	22	300	50			30	31	3°						SSV32 (Grade:D30)	DTS5-3.5	P-3.5
S40U-SVUCR/L16			50		40	27	350	60			37	38.5	1°								

Notes: • The hole of inserts conforms to ISO standard.
• When using a right or left hand insert, the right hand insert is used for left hand toolholders and the left hand insert is used for right hand toolholders.

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

● : Stocked items.

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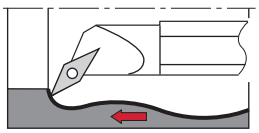
SVQBR/L

Positive rake / Screw-on system

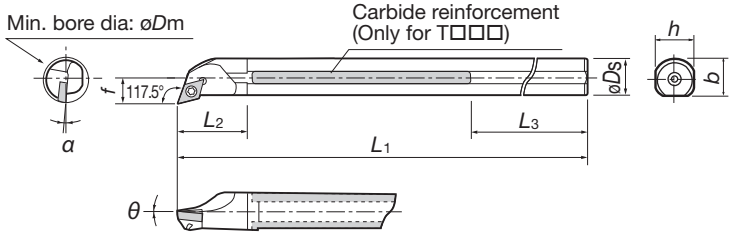
Min. bore dia. ø25mm | Shank dia. ø20mm | Tsuppari-Ichiban Shank

Internal profiling

SVQBR/L



Cutting edge style **Q**



Right hand (R) shown.

"Tsuppari-Ichiban" (Reinforced with carbide)

Cat. No.	Stock R	Stock L	Min. bore dia. øDm	Oil hole	øDs	f	L1	L2	L3	h	b	α	θ	Std. corner rε	Applicable inserts		Clamping screw	Wrench	Shim	Shim screw	Wrench
T20R-SVQBR/L11C	●		25	Rc1/4	20	14	200	30	59	18	-	7°	5°	0.4	VB□□	1103□□ 2-133	CSTB-2.5	T-8F	-	-	-

Notes: • The hole of inserts conforms to ISO standard.

T-CBN inserts 3-13 ~

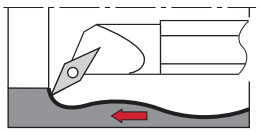
SVQCR/L

Positive rake / Screw-on system

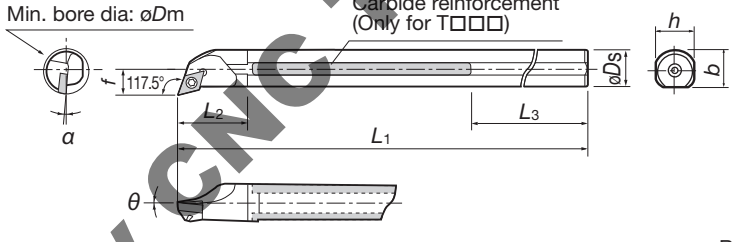
Min. bore dia. ø32mm~ | Shank dia. ø25~40mm | Tsuppari-Ichiban Shank | Steel Shank

Internal profiling

SVQCR/L



Cutting edge style **Q**



Right hand (R) shown.

"Tsuppari-Ichiban" (Reinforced with carbide)

Cat. No.	Stock R	Stock L	Min. bore dia. øDm	Oil hole	øDs	f	L1	L2	L3	h	b	α	θ	Std. corner rε	Applicable inserts		Clamping screw	Wrench	Shim	Shim screw	Wrench
T25S-SVQCR/L16C	●		32	Rc1/4	25	17	250	40	64	23	-	5°	0°	0.8	VC□□	1604□□ 2-135	CSTB-3.5L	T-15F	-	-	-

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

Steel Shank

Cat. No.	Stock R	Stock L	Min. bore dia. øDm	Oil hole	øDs	f	L1	L2	L3	h	b	α	θ	Std. corner rε	Applicable inserts		Clamping screw	Wrench	Shim	Shim screw	Wrench
S25S-SVQCR/L16			32	-	25	17	250	40	-	23	24	5°	0°	0.8	VC□□	1604□□ 2-135 ~	CSTB-3.5L	T-15F	-	-	-
S32T-SVQCR/L16			40		32	22	300	50		30	31	3°							SSV32 (Grade:D30)	DTS5-3.5	P-3.5
S40U-SVQCR/L16			50		40	27	350	60		37	38.5	1°									

Notes: • The hole of inserts conforms to ISO standard.
• When using a right or left hand insert, the right hand insert is used for left hand toolholders and the left hand insert is used for right hand toolholders.

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

● : Stocked items.

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SDZCR/L

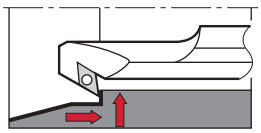
Min. bore dia. ø14mm~ | Shank dia. ø12~25mm

Positive rake / Screw-on system

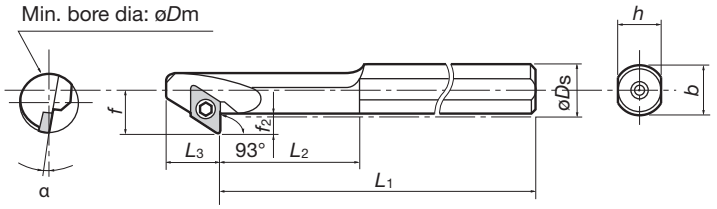
Steel Shank | Carbide Shank

Internal retracting

SDZCR/L



Cutting edge style **Z**



Right hand (R) shown.

Steel Shank

Cat. No.	Stock R	Stock L	Min. bore dia. øDm	Dimensions (mm) øDs	f	L1	L2	L3	h	b	α	f2	Std. corner rε	Applicable inserts		Clamping screw	Wrench
S12M-SDZCR/L07			14	12	10.5	150	32.5	12.5	11	11.5	9°	5	0.4	DC□□	0702□□ 2-105~	CSTB-2.5	T-8F
S16Q-SDZCR/L07			16	16	12.5	180	37.5		15	15.5	8°						
S20R-SDZCR/L11			20	20	15.5	200	40	14.4	18	19	8°	6.5	0.8		11T3□□ 2-105~	CSTB-4S	T-15F
S25S-SDZCR/L11			25	25	18	250	50		23	24	6°					CSTB-4M	

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

Carbide Shank

Cat. No.	Stock R	Stock L	Min. bore dia. øDm	Dimensions (mm) øDs	f	L1	L2	L3	h	b	α	f2	Std. corner rε	Applicable inserts		Clamping screw	Wrench
C12Q-SDZCR/L07			18	12	10.5	180	-	12.5	11	-	8°	4.5	0.4	DC□□	0702□□ 2-105~	CSTB-2.5	T-8F
C16R-SDZCR/L07			22	16	12.5	200			15		6°						

Notes: • The hole of inserts conforms to ISO standard.
• When using a right or left hand insert, the right hand insert is used for right hand toolholders and the left hand insert is used for left hand toolholders.

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

PDZNR/L

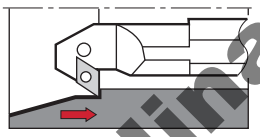
Min. bore dia. ø40mm~ | Shank dia. ø32~50mm

Negative rake / Lever-lock system

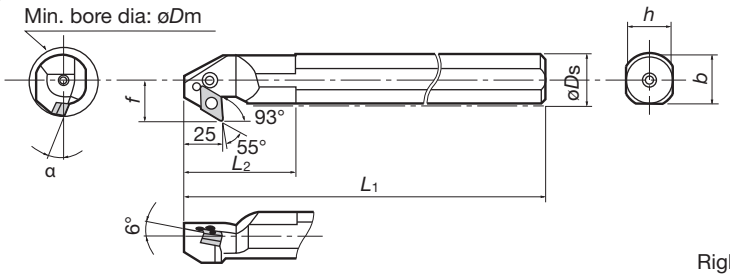
Steel Shank

Internal retracting

PDZNR/L



Cutting edge style **Z**



Right hand (R) shown.

Steel Shank

Cat. No.	Stock R	Stock L	Min. bore dia. øDm	Dimensions (mm) øDs	f	L1	L2	h	b	α	Std. corner rε	Applicable inserts		Shim	Lever	Clamping screw	Spring	Wrench
S32S-PDZNR/L15	●	●	40	32	22	275	55	30	29.5	13°	0.8	DN□□	1504□□ 2-52~	LSZ42B R / L	LCL4	LCS4	LSP4	P-3
S40T-PDZNR/L15	●		50	40	27	325	60	37	37.5	10°								
S50U-PDZNR/L15	●		60	50	35	375	65	47	47.5	8°								

Notes: • When using a right or left hand insert, the right hand insert is used for right hand toolholders and the left hand insert is used for left hand toolholders.

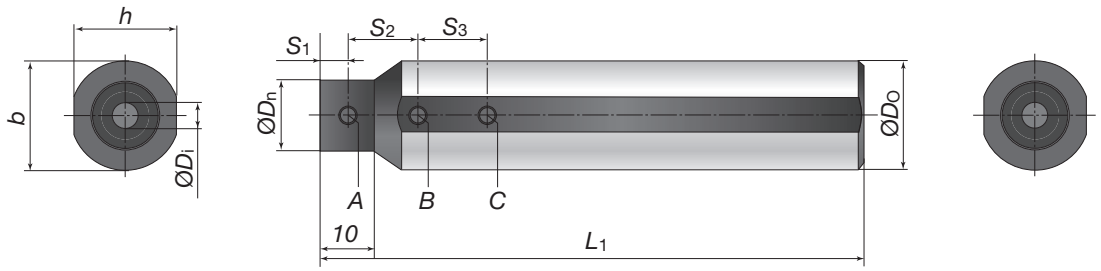
T-CBN inserts 3-7 T-DIA inserts 3-21

● : Stocked items.

Jinan Terry CNC Tool Co.,Ltd.

Sleeves

BLM type (Round shank for StreamJetBarMini)



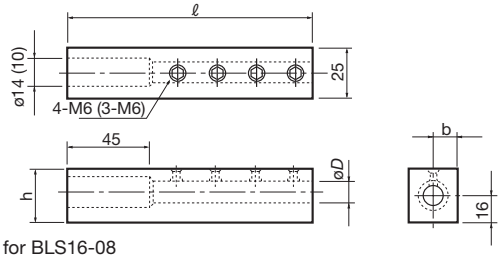
Cat. No.	Stock	Dimensions (mm)									Replacement parts				
											Clamping screws			Wrench	Seal cap* (Inner screw)
		øDo	øDi	øDn	L1	h	b	S1	S2	S3	A	B	C		
BLM159-04	●	15.875	4	15	100	15	15.875	5	15	15	SSHM4-4	SSHM4-4	SSHM4-4	P-2	CA-16 (M6)
BLM159-05	●		5												
BLM159-06	●		6						20	20					
BLM159-07	●		7												
BLM16-04	●	16	4	15	100	15	16	5	15	15	SSHM4-4	SSHM4-4	SSHM4-4	P-2	CA-16 (M6)
BLM16-05	●		5												
BLM16-06	●		6						20	20					
BLM16-07	●		7												
BLM19-04	●	19.05	4	18	100	18	19.05	5	15	15	SSHM4-4	SSHM4-6	SSHM4-6	P-2	CA-16 (M6)
BLM19-05	●		5									SSHM4-4	SSHM4-4		
BLM19-06	●		6						20	20					
BLM19-07	●		7												
BLM20-04	●	20	4	13	100	19	20	5	15	15	SSHM4-4	SSHM4-6	SSHM4-6	P-2	CA-16 (M6)
BLM20-05	●		5	14											
BLM20-06	●		6	15					20	20		SSHM4-4	SSHM4-4		
BLM20-07	●		7	16											
BLM22-04	●	22	4	13	125	21	22	5	15	15	SSHM4-4	SSHM4-6	SSHM4-6	P-2	CA-16 (M6)
BLM22-05	●		5	14											
BLM22-06	●		6	15					20	20					
BLM22-07	●		7	16											
BLM25-04	●	25	4	13	125	24	25	5	15	15	SSHM4-4	SSHM4-8	SSHM4-8	P-2	CA-16 (M6)
BLM25-05	●		5	14											
BLM25-06	●		6	15					20	20					
BLM25-07	●		7	16								SSHM4-6	SSHM4-6		
BLM254-04	●	25.4	4	13	125	24	25.4	5	15	15	SSHM4-4	SSHM4-8	SSHM4-8	P-2	CA-16 (M6)
BLM254-05	●		5	14											
BLM254-06	●		6	15					20	20					
BLM254-07	●		7	16								SSHM4-6	SSHM4-6		

*Seal cap (optional)

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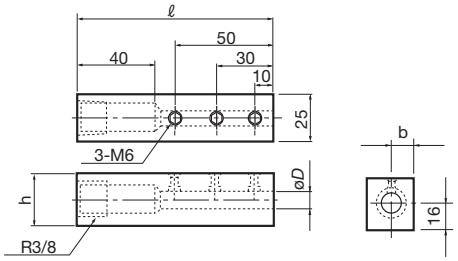
BLS type (Square shank)



( ) is for BLS16-08

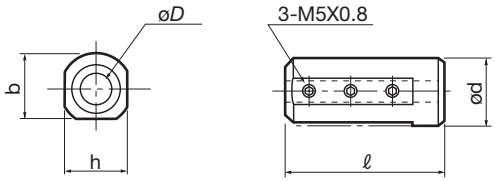
Cat. No.	Stock	Applicable shank dia. øD	Dimensions (mm)		
			ℓ	h	b
BLS16-08	●	8	125	28	12.5
BLS16-10	●	10			
BLS16-12	●	12			

BLS-C type (Square shank)



Cat. No.	Stock	Applicable shank dia. øD	Dimensions (mm)		
			ℓ	h	b
BLS16-08C	●	8	100	28	12.5
BLS16-10C	●	10			
BLS16-12C	●	12			

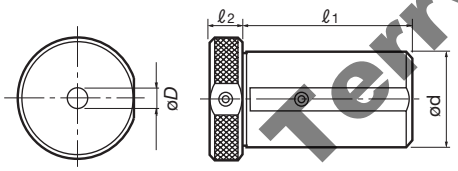
BLM type (Round shank)



Above drawing shows BLM25-□□C type.

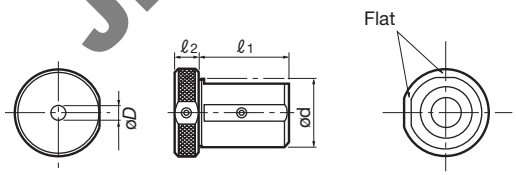
Cat. No.	Stock	Applicable shank dia. øD	Dimensions (mm)			
			ød	ℓ	h	b
BLM19-08	●	8	19.05	100	18	18
BLM20-08	●		20		19	
BLM22-08	●		22	125	21	21
BLM254-08	●		25.4		24	24
BLM25-08C	●		25	55	24	23
BLM25-10C	●	10				
BLM25-12C	●	12				

BLC type (Standard type)



Cat. No.	Stock	Applicable shank dia. øD	Dimensions (mm)		
			ℓ1	ℓ2	ød
BLC40-8	●	8	73	13	40
BLC40-10	●	10			
BLC40-12	●	12			
BLC40-16	●	16			

BLC type (Short type)



Cat. No.	Stock	Applicable shank dia. øD	Dimensions (mm)		
			ℓ1	ℓ2	ød
BLC32-8C	●	8	45	20	32
BLC32-10C	●	10			
BLC32-12C	●	12			
BLC40-8C	●	8	55	13	40
BLC40-10C	●	10			
BLC40-12C	●	12			
BLC40-16C	●	16			

● : Stocked items.

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