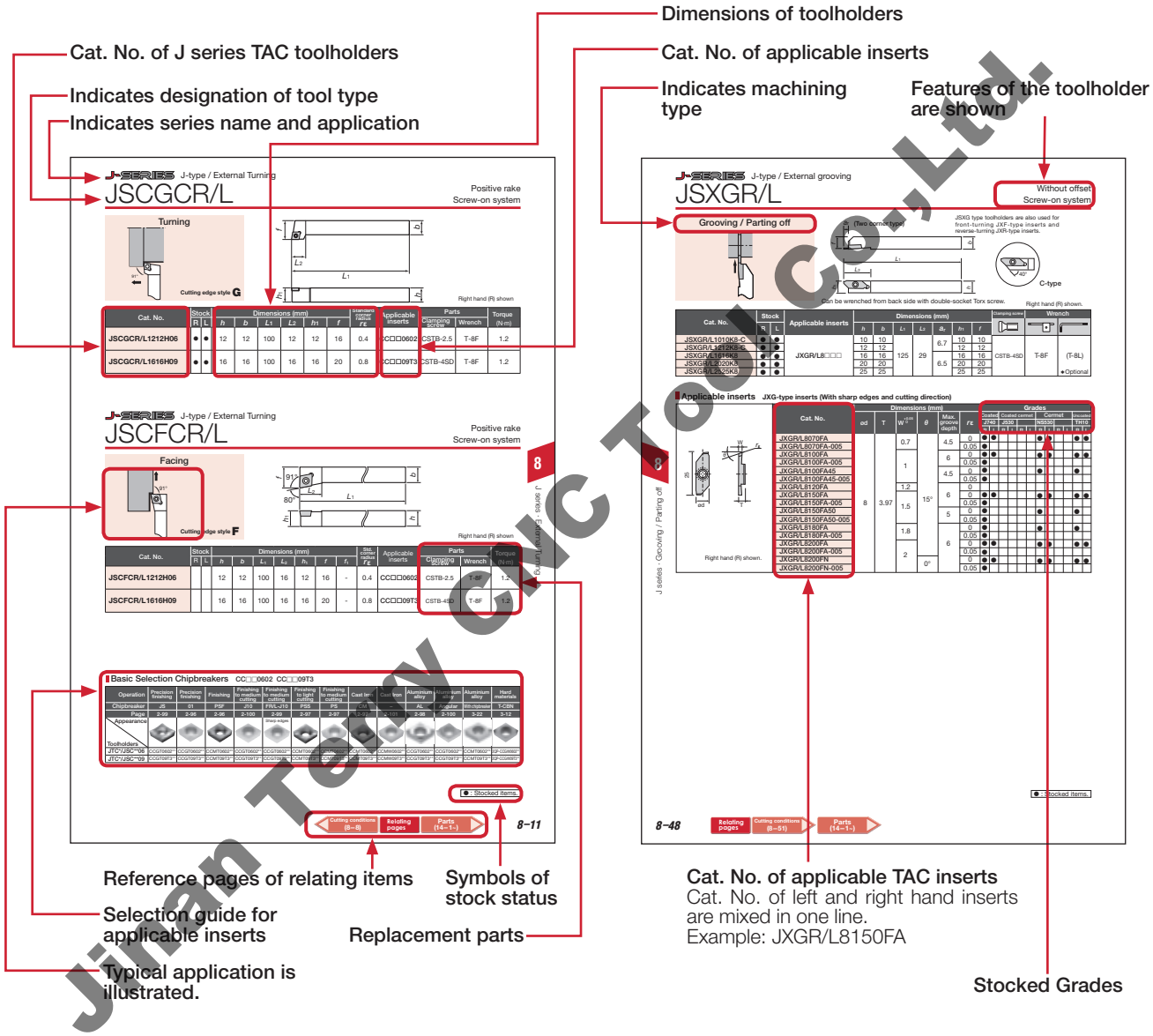
Chapter Composition of J series Tools for Small Lathes

◆In this chapter, specifications of tools are described by machining type in order of following: External turning, Facing → Front turning, Reverse turning, Back turning → Boring → Grooving → Parting → Threading



■ Ordering information

● When ordering a J series toolholder, please specify Cat. No. and quantity.

Example: **JSCLC R 1212 H09 1** piece

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

● When ordering a J series TAC inserts, please specify Cat. No., grade and quantity.

Example: **JXGR8150FA J740 10** pieces

- Standard packing quantity: 10 pieces

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Guidance

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■ The features of grades and standard cutting conditions ····· 8-8
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8 J series Turning Tools for Small Lathes

Products

■ **External turning tools**

● JTC□	Turning / Facing	Side clamping system	CC□□ inserts	8-9
● JSC□	Turning / Facing	Screw-on system	CC□□ inserts	8-9
● JTD□	Turning / Profiling	Side clamping system	DC□□ inserts	8-12
● JSD□	External profiling	Screw-on system	DC□□ inserts	8-12
● JS-SDUCL	Front turning (Round shank)	Screw-on system	DC□□ inserts	8-15
● JTT□	Turning	Side clamping system	TC□□ inserts	8-16
● JST□	Turning	Screw-on system	TC□□ inserts	8-16
● JSV□	Turning / Facing / Profiling	Screw-on system	VP□□ inserts	8-17
● JSV□	Turning / Facing / Profiling	Screw-on system	VB□□ inserts	8-19
● JT□□	Turning / Facing / Profiling	Side clamping system	CN□□ / DN□□ / TN□□ inserts (negative)	8-20
● JSXGR/L	Front and Reverse turning		JXFR/L, JXRR/L inserts	8-21
● JSXBR/L	Back turning		JXBR/L inserts	8-22
● JSTBR/L	Back turning		JTBR/L inserts	8-23
● JS-TBL3	Back turning (Round shank)		JTBR/L inserts	8-23
● JSEGR/L	Back turning	Screw-on system	J10ER/L inserts	8-24

■ **Internal turning tools**

● Solid boring bars "TinyTurn" JB type

JBT	Boring, profiling, chamfering	8-28
JBP	Boring, chamfering	8-29
JBU	Back boring, chamfering	8-29
JBC	Boring, 45° chamfering	8-30
JBB	Back boring	8-30
JBI	Threading (metric thread)	8-31
JBG	Grooving	8-32
JBF	Face grooving	8-33
JBS	Face grooving (for machining shaft)	8-33
JBR	Boring, profiling (full radius type)	8-34
JBBS sleeves		8-34

● Internal Turning "StreamJetBar"

● SCLCR/L	Boring / internal facing	Screw-on system	CC□□ inserts	8-36
● STUPR/L	Boring	Screw-on system	TP□□ inserts	8-37
● SWUBR/L	Boring	Screw-on system	WB□□ inserts	8-38
● SE□PR/L	Retracting / Facing	Screw-on system	EP□□ inserts	8-39
● BLM sleeves				8-41

■ **Grooving and parting tools**

● JCTER/L	Grooving / Parting off	D□□inserts	8-43
● JSXGR/L	Grooving / Parting off	JSXGR/L inserts	8-48
● JSVGR/L	Grooving	JVGR/L inserts	8-49
● JSTGR/L	Grooving	JTGR/L inserts	8-50
● JS-TGL3	Grooving (Round shanks)	JTGR/L inserts	8-50
● JCGSSR/L	Parting off	GE20 inserts	8-52
● JCCWSR/L	Parting off	JCCR/L inserts	8-53
● JCGWSR/L	Parting off	JCGN inserts	8-53

■ **Threading tools**

● JSTTR/L	External threading	JTTR/L inserts	8-54
● JS-TTL3	External threading (Round shank)	JTTR/L inserts	8-54
● JSXBR/L	External threading	JXT□R/L inserts	8-55
● SER/L	External threading	16ER/L inserts	8-56

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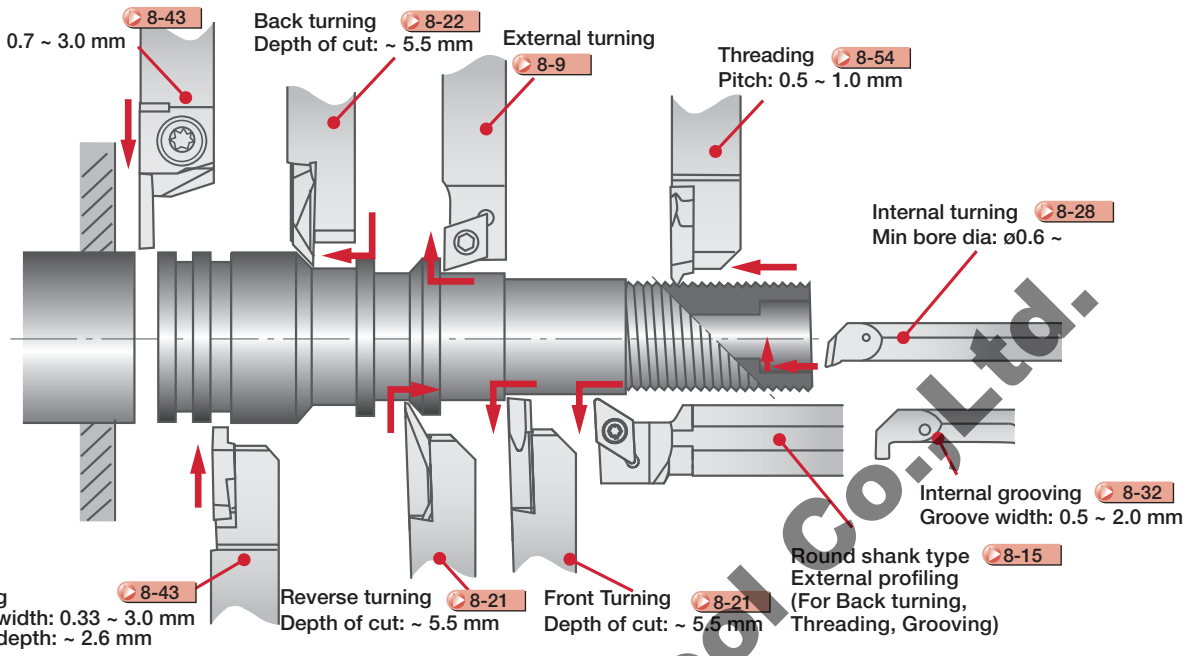
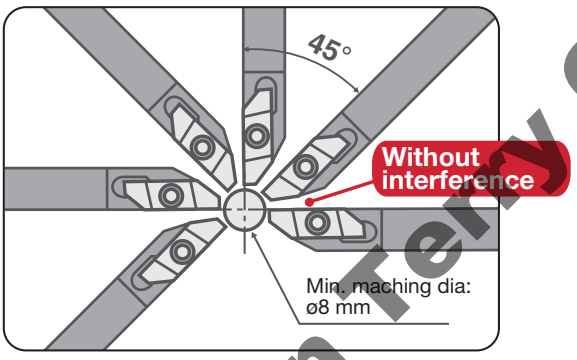
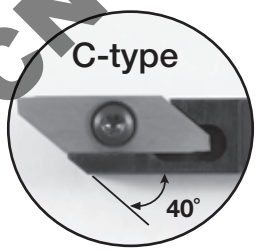
J-SERIES Tooling example



- **Applicable for various machining such as front turning, back turning, grooving, threading, parting off, internal turning and so on.**

Suitable for cam style small lathe (C-type toolholders)





JSXG

- C-type toolholders specially suited for cam style small lathe.
- Min. simultaneous machining dia: ø8 mm.
- Applicable for front turning, back turning, reverse turning, threading, parting off and grooving.

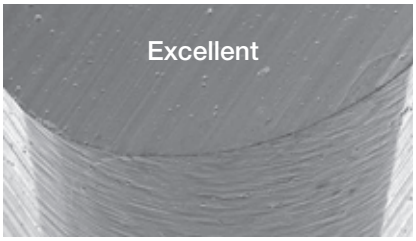
J-SERIES Insert grades for tools

- Excellent sharpness and long tool life by the combination of ultra fine grain cemented carbides and thin PVD-coat, "SH-coat".

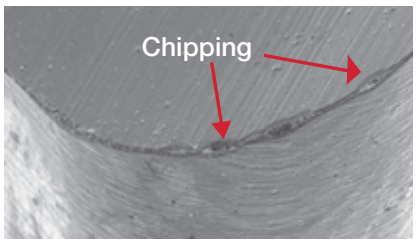
SH730

General cemented carbide

- Comparison of sharpness



J series



Competitor

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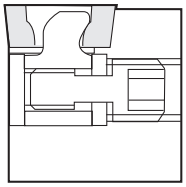
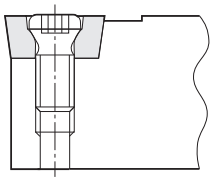
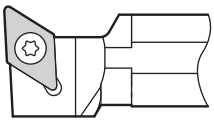
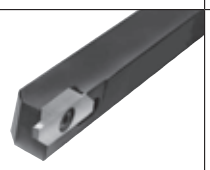
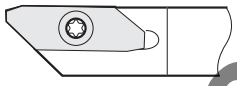
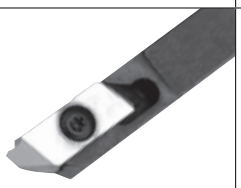
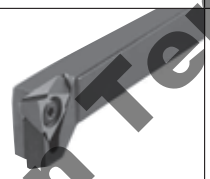
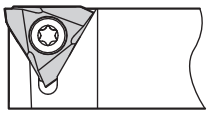
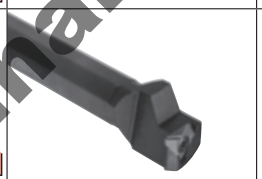
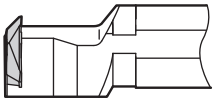
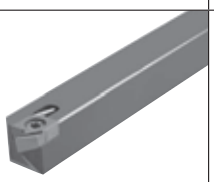
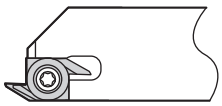
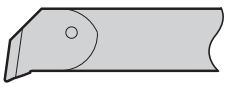
Overview of J series tools

Clamping Mechanism and Features

Appli.	Type	Appearance	Clamping mechanism	Features
External turning	**JT** 8-9			● Good operability for indexing the insert in limited space such as on gang tooling type lathes ● Good handling allows operation of clamping screw from back side of the toolholder ● Available shank height : 8, 10, 12 and 16 mm
External turning	**J** 8-9			● Available in small to medium shank sizes and abundant cutting edge styles ● The smaller shank size toolholders are best suitable for CNC automatics and other small lathes and larger sizes are usable for general purpose lathes. ● Secure insert fastening by highly durable torx screw
External turning	**JS-SDUCL** 8-15 (Round shank)			● Round shank type for small lathe ● For external copying ● Shank dia: ø19.05 ~ ø25.4 mm
Reverse turning	**JSXG** Front and reverse turning 8-21 Grooving and parting off 8-48			● The insert is clamped with a both end torx screw, resulting in easy and rapid changing or indexing of the insert. (Can be operated from the back side with a both end torx screw.) ● Applicable for front, reverse turning, grooving and parting off by changing insert ● Max. groove depth is 6.0 mm
Reverse turning	**JSXB** Back turning 8-22 Threading 8-55			● The insert is clamped with a both end torx screw, resulting in easy and rapid changing or indexing of the insert. (Can be operated from the back side with a both end torx screw.) ● Applicable for back turning and threading by changing insert ● The inserts for threading are two corner type. Applicable for 60° threads of 0.5 to 1.0 mm pitches.
Reverse turning	**JSTB** 8-23			● Applicable for back turning ● The insert is clamped with a both end torx screw, resulting in easy and rapid changing or indexing of the insert. (Can be operated from the back side with a both end torx screw.) ● Three corner type insert
Reverse turning	**JS-TBL3** 8-23 (Round shank)			● Round shank type for small lathe ● For back turning ● Shank dia: ø19.05 ~ ø25.4 mm
Reverse turning	**JSEG** 8-24			● Applicable for back turning ● Max. Parting off dia: ø3 mm ● Two corner type insert
Internal turning	**JB□** 8-28			● 146 solid bar items in a wide range of geometries ● Minimum boring diameter: ø*D*m = 0.6 mm

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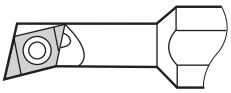
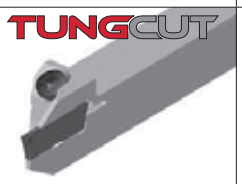
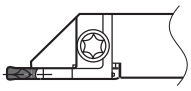
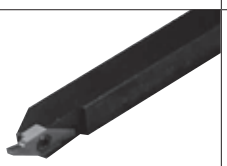
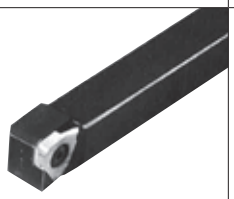
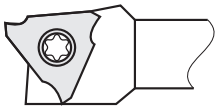
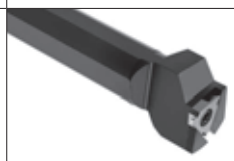
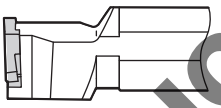
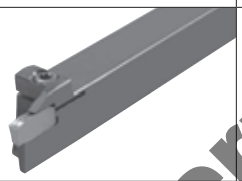
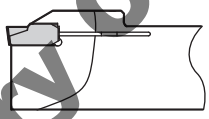
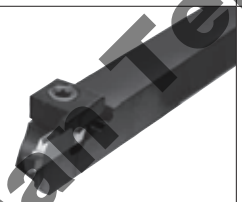
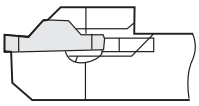
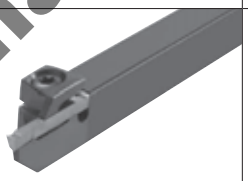
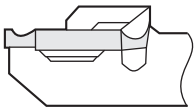
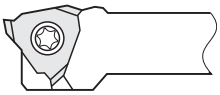
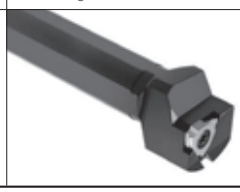
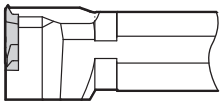
Overview of J series tools

Appli.	Type	Appearance	Clamping mechanism	Features
Internal turning	**Stream JetBar Mini** (Round shank) 8-36	STREAMJETBARMINI		● Minimum bore diameter from ø4.5 mm ● Steel and carbide shank available ● Straight shank type available ● Can be used with internal coolant supply ● Well designed chip pocket for excellent chip evacuation
Grooving	**JCTER/L** 8-43	TUNGCUT 		● M-class insert with good chip control ● Applicable in various grooving and parting off ● Right and left hand inserts are stocked
Grooving	**JSVG** 8-49			● Applicable for grooving ● Max. groove depth is 5.5 mm
Grooving	**JSTG** 8-50			● Applicable for grooving ● The insert is clamped with a both end torx screw, resulting in easy and rapid changing or indexing of the insert. (Can be operated from the the back side with a both end torx screw.) ● Applicable for grooving E-ring grooves of small parts (Cutting edge width: 0.33 ~ 2.5 mm) ● Three corner type insert
Grooving	**JS-TGL3** (Round shank) 8-50			● Round shank type for grooving ● Shank dia: ø19.05 ~ ø25.4 mm ● Three corner type insert
Parting off	**JCGSS** 8-52			● Applicable for parting off ● M-class insert with good chip control ● One corner type insert
Parting off	**JCCWS** 8-53			● Applicable for parting off ● Secure engaging of the clamp and the top face of the insert, allows secure clamping and superior accuracy of cutting edge positioning. ● Right and left hand inserts are stocked.
Parting off	**JCGWS** 8-53			● Applicable for parting off ● Right and left hand inserts are stocked.
Threading	**JSTT** 8-54			● Applicable for threading ● The insert is clamped with a both end torx screw, resulting in easy and rapid changing or indexing of the insert. (Can be operated from the back side with a both end torx screw.) ● Three corner type insert
Threading	**JS-TTL3** (Round shank) 8-54			● Round shank type for threading ● Shank dia: ø19.05 ~ ø25.4 mm ● Machinable pitch range: 0.5 ~ 1 mm

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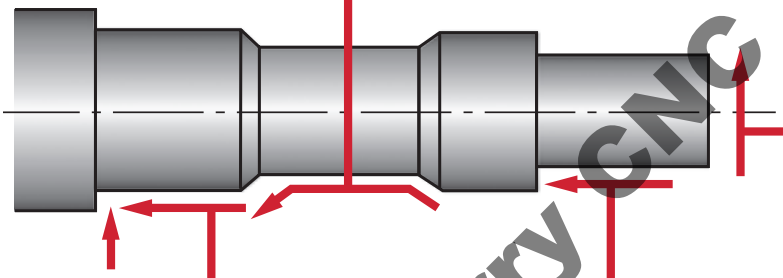
Types and application of TAC External Toolholders

For external profiling

Positive rake				
JTDJ2CR/L (P.8-12) Shank size 8 ~ 16 mm Back side clamping Without offset	JSDJ2CR/L (P.8-12) Shank size 10 ~ 12 mm Screw-on clamping Without offset	JSDJCR/L (P.8-13) Shank size 8 ~ 16 mm Screw-on clamping With offset	JSVJ2BR/L (P.8-17) Shank size 10 ~ 16 mm Screw-on clamping Without offset	JSVP2PR/L (P.8-19) Shank size 10 ~ 16 mm Screw-on clamping Without offset

Positive rake				Negative rake
JSVJBR/L (P.8-17) Shank size 10 ~ 16 mm Screw-on clamping With offset	JSDNCN (P.8-13) Shank size 8 ~ 16 mm Screw-on clamping With offset	JSDN3CR/L (P.8-14) Shank size 12 ~ 16 mm Screw-on clamping With offset	JS-SDUCL (P.8-15) Shank size ø19.05 ~ 25.4 mm Screw-on clamping With offset	JTDJ2NR/L (P.8-20) Shank size 12 ~ 16 mm Back side clamping Without offset



For facing

Positive rake	
JSCFCR/L (P.8-11) Shank size 12 ~ 16 mm Screw-on clamping With offset	JSDFCR/L (P.8-14) Shank size 12 ~ 16 mm Screw-on clamping With offset

For external turning

Positive rake					Negative rake
JTTACR/L (P.8-16) Shank size 8 ~ 16 mm Back side clamping Without offset	JSTACR/L (P.8-16) Shank size 8 ~ 16 mm Screw-on clamping Without offset	JSCGCR/L (P.8-11) Shank size 12 ~ 16 mm Screw-on clamping With offset	JSCACR/L (P.8-10) Shank size 8 ~ 12 mm Screw-on clamping Without offset	JSVABR/L (P.8-18) Shank size 10 ~ 16 mm Screw-on clamping Without offset	JTTANR/L (P.8-20) Shank size 12 ~ 16 mm Back side clamping Without offset

For external turning and facing

Positive rake				Negative rake
JTCL2CR/L (P.8-9) Shank size 8 ~ 16 mm Back side clamping Without offset	JSCL2CR/L (P.8-9) Shank size 10 ~ 12 mm Screw-on clamping Without offset	JSCLCR/L (P.8-10) Shank size 8 ~ 16 mm Screw-on clamping With offset	JSVL2PR/L (P.8-19) Shank size 10 ~ 16 mm Screw-on clamping Without offset	JTCL2NR/L (P.8-20) Shank size 12 ~ 16 mm Back side clamping Without offset

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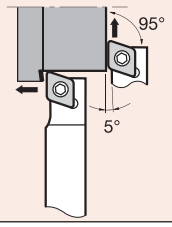
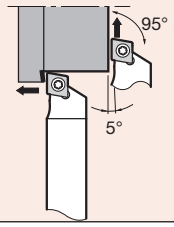
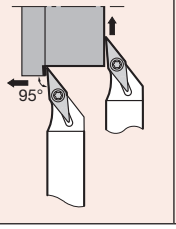
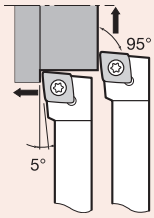
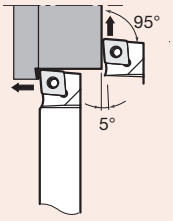
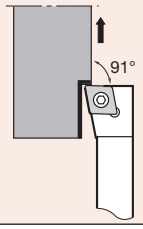
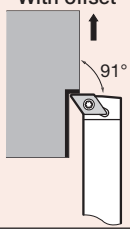
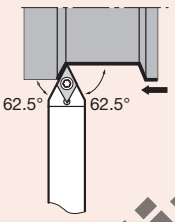
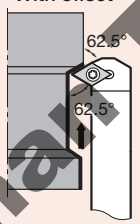
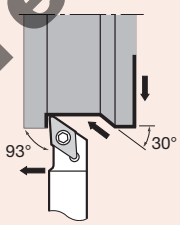
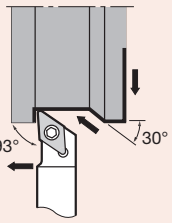
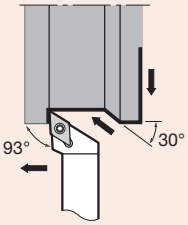
For external turning and facing

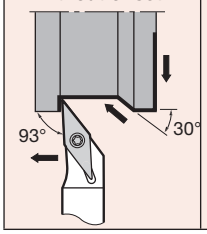
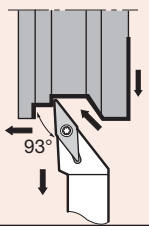
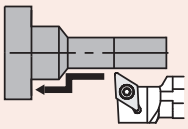
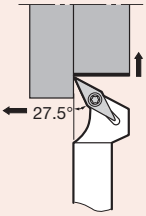
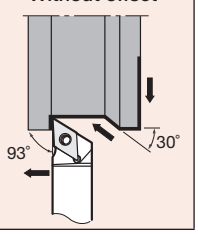
Positive rake				Negative rake
JTCL2C (P.8-9) Cutting edge angle: 95° **Back side clamping Without offset**	JSCL2C (P.8-9) Cutting edge angle: 95° **Screw-on clamping Without offset**	JSVL2P (P.8-19) Cutting edge angle: 95° **Screw-on clamping Without offset**	JSCLC (P.8-10) Cutting edge angle: 95° **Screw-on clamping With offset**	JTCL2N (P.8-20) Cutting edge angle: 95° **Back side clamping Without offset**
				

For facing

Positive rake	
JSCFC (P.8-11) Cutting edge angle: 91° **Screw-on clamping With offset**	JSDFC (P.8-14) Cutting edge angle: 91° **Screw-on clamping With offset**
	

For external turning and facing

Positive rake				
JSDNCN (P.8-13) Cutting edge angle: 62.5° **Screw-on clamping With offset**	JSDN3C (P.8-14) Cutting edge angle: 62.5° **Screw-on clamping With offset**	JTDJ2C (P.8-12) Cutting edge angle: 93° **Back side clamping Without offset**	JSDJ2C (P.8-12) Cutting edge angle: 93° **Screw-on clamping Without offset**	JSDJC (P.8-13) Cutting edge angle: 93° **Screw-on clamping With offset**
				

Positive rake				Negative rake
JSVJ2B (P.8-17) Cutting edge angle: 93° **Screw-on clamping Without offset**	JSVJB (P.8-17) Cutting edge angle: 93° **Screw-on clamping With offset**	JS-SDUCL (P.8-15) Cutting edge angle: 93° **Screw-on clamping With offset**	JSVP2P (P.8-19) Cutting edge angle: 117.5° **Screw-on clamping Without offset**	JTDJ2N (P.8-20) Cutting edge angle: 93° **Back side clamping Without offset**
				

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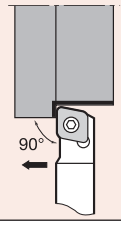
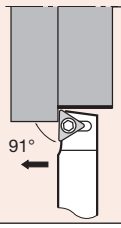
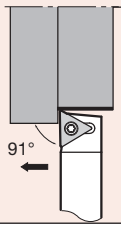
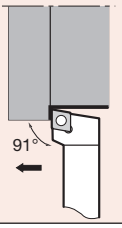
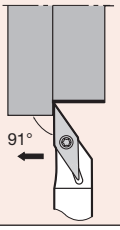
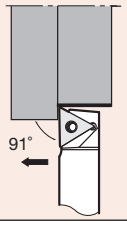
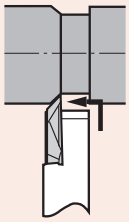
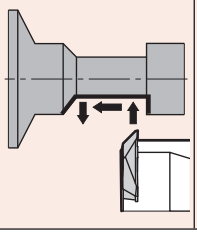
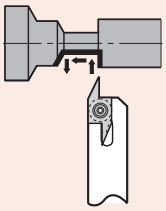
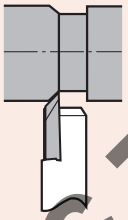
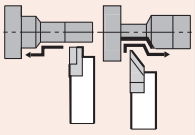
For external turning

Positive rake					Negative rake
JSCAC (P.8-10) Cutting edge angle: 90° Screw-on clamping Without offset	JTTAC (P.8-16) Cutting edge angle: 91° Back side clamping Without offset	JSTAC (P.8-16) Cutting edge angle: 91° Screw-on clamping Without offset	JSCGC (P.8-11) Cutting edge angle: 91° Back side clamping With offset	JSVAB (P.8-18) Cutting edge angle: 91° Screw-on clamping Without offset	JTTAN (P.8-20) Cutting edge angle: 91° Back side clamping Without offset
					

For back turning

Positive rake			
JSTB (P.8-23) Screw-on clamping Without offset	JS-TBL3 (P.8-23) Screw-on clamping With offset	JSEG (P.8-24) Screw-on clamping Without offset	JSXB (P.8-22) Screw-on clamping Without offset
			

For front and reverse turning

Positive rake
JSXG (P.8-21) Screw-on clamping Without offset


Jinan Terry CNC Tool Co.,Ltd.

The features of grades and standard cutting conditions

Feature of grades

Grades	Main composition	Features
AH725	Ultra fine grain cemented carbide + PVD coated	● The special (Ti,Al)N coated layer and a cemented carbide substrate bring the best use of its features such as wear resistance, long tool life, hardness and toughness. Highly recommended in steels and stainless steel operation.
SH730		● The unique (Ti,Al)N coating layer increases sharpness, chipping resistance and welding resistance. Enables enhanced tool life in superalloys machining.
J740		● "J-coat" developed for small parts machining. ● Excellent sharp cutting edge. ● Superior toughness and chipping resistance in general steel, stainless steel and free cutting steel machining.
NS530	Cermet	● General purpose grade offering great economy and fine surface finish.
J530	Coated cermet (Cermet + PVD coated)	● "J-coat" developed for small parts machining. ● Good sharp cutting edge and surface roughness. ● High wear and edge build up resistance.
TH10	Uncoated cemented carbide	● Long tool life for non-ferrous metals and difficult-to-cut materials.

Standard cutting conditions (External turning)

Working material	Operation	Chip-breaker	Grades	Depth of cut: *ap* (mm)	Feed: *f* (mm/rev) ($r\varepsilon$ = 0.1)	Cutting speed: *Vc* (m/min)
General steels	Precision finishing	**JS**	**AH725**	0.1 - 3.0	0.01 - 0.05	50 - 180
		JPR	**SH730**	0.1 - 0.5	0.01 - 0.05	50 - 150
		JPP	**SH730**	0.1 - 0.5	0.01 - 0.05	50 - 150
		JSP	**SH730**	0.1 - 0.5	0.01 - 0.05	50 - 150
		01	**J530**	0.05 - 0.5	0.03 - 0.15	70 - 250
			J740	0.05 - 0.5	0.03 - 0.15	10 - 100
	General	**J□□**	**NS530**	0.1 - 5.0	0.01 - 0.1	50 - 220
			J530	0.1 - 5.0	0.01 - 0.1	70 - 250
			J740	0.1 - 5.0	0.01 - 0.1	10 - 100
Free cutting steels (JIS : SUM)	Precision finishing	**JS**	**AH725**	0.1 - 3.0	0.01 - 0.05	50 - 180
		JPR	**SH730**	0.1 - 0.5	0.01 - 0.05	50 - 150
		JPP	**SH730**	0.1 - 0.5	0.01 - 0.05	50 - 150
		JSP	**SH730**	0.1 - 0.5	0.01 - 0.05	50 - 150
		01	**J740**	0.05 - 0.5	0.03 - 0.15	10 - 100
	General	**J□□**	**J740**	0.1 - 5.0	0.01 - 0.1	10 - 100
Stainless steels (JIS : SUS303)	Precision finishing	**JS**	**SH730**	0.1 - 3.0	0.01 - 0.05	30 - 150
			AH725	0.1 - 3.0	0.01 - 0.05	50 - 150
		JPR	**SH730**	0.1 - 0.5	0.01 - 0.05	30 - 150
		JPP	**SH730**	0.1 - 0.5	0.01 - 0.05	30 - 150
		JSP	**SH730**	0.1 - 0.5	0.01 - 0.05	30 - 150
		01	**J530**	0.05 - 0.5	0.03 - 0.15	50 - 220
			J740	0.05 - 0.5	0.03 - 0.15	10 - 100
	General	**J□□**	**J530**	0.1 - 5.0	0.01 - 0.1	50 - 220
			J740	0.1 - 5.0	0.01 - 0.1	10 - 100
Cast irons	General	**J□□**	**TH10**	0.1 - 5.0	0.01 - 0.1	20 - 100
Non-ferrous metals	General	**J□□**	**TH10**	0.1 - 5.0	0.01 - 0.1	100 - 1000
Difficult-to-cut materials	Precision finishing	**JS**	**SH730**	0.1 - 3.0	0.01 - 0.05	30 - 100
			AH725	0.1 - 3.0	0.01 - 0.05	30 - 100
		JPR	**SH730**	0.1 - 0.5	0.01 - 0.05	30 - 100
		JPP	**SH730**	0.1 - 0.5	0.01 - 0.05	30 - 100
		JSP	**SH730**	0.1 - 0.5	0.01 - 0.05	30 - 100
	General	**J□□**	**TH10**	0.1 - 5.0	0.01 - 0.1	10 - 150
Hard materials	General	**J□□**	**TH10**	0.1 - 5.0	0.01 - 0.1	10 - 60

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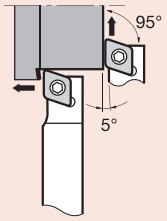
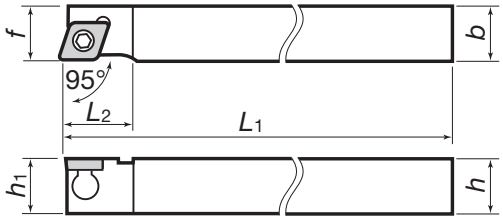
JTCL2CR/L

Without offset / Positive rake
Side clamping system

Turning / Facing



Cutting edge style **L2**



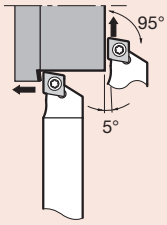
Right hand (R) shown

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

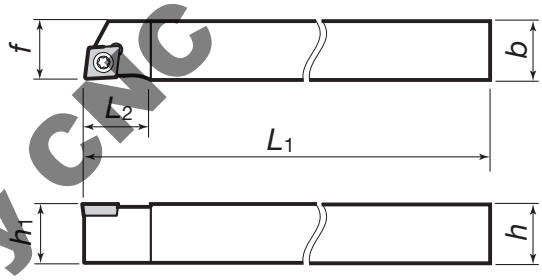
JSCL2CR/L

Without offset / Positive rake
Screw-on system

Turning / Facing



Cutting edge style **L2**



Right hand (R) shown

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

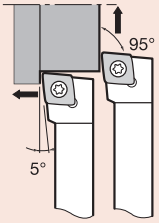
● : Stocked items.

Jinan Terry CNC Tool Co.,Ltd.

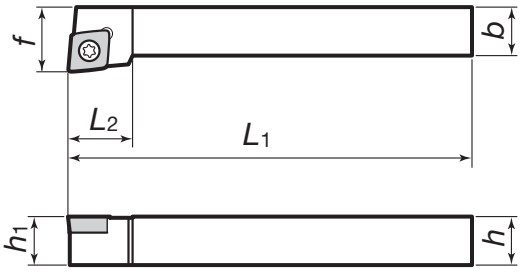
JSCLCR/L

Positive rake
Screw-on system

Turning / Facing



Cutting edge style **L**



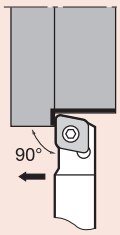
Right hand (R) shown

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

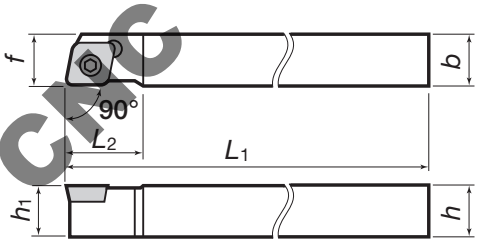
JSCACR/L

Without offset / Positive rake
Screw-on system

Turning



Cutting edge style **A**



Right hand (R) shown

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

● : Stocked items.

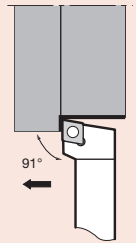
Jinan Terry CNC Tool Co.,Ltd.

sales@interui.com

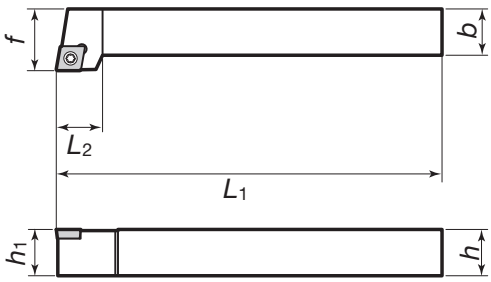
JSCGCR/L

Positive rake
Screw-on system

Turning



Cutting edge style **G**



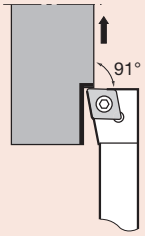
Right hand (R) shown

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

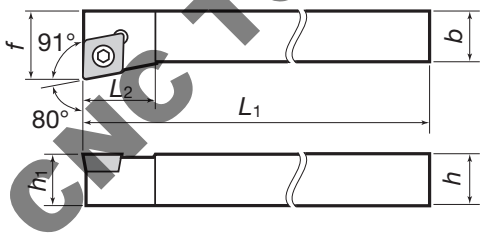
JSCFCR/L

Positive rake
Screw-on system

Facing



Cutting edge style **F**



Right hand (R) shown

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

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

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

● : Stocked items.

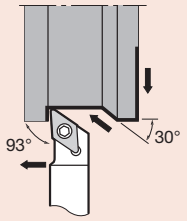
Jinan Terry CNC Tool Co.,Ltd.

sales@jnterui.com

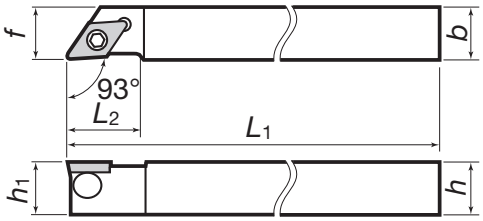
JTDJ2CR/L

Without offset / Positive rake
Back clamping system

Turning / profiling



Cutting edge style **J2**



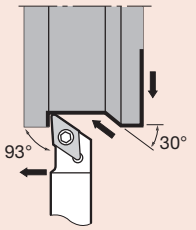
Right hand (R) shown

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

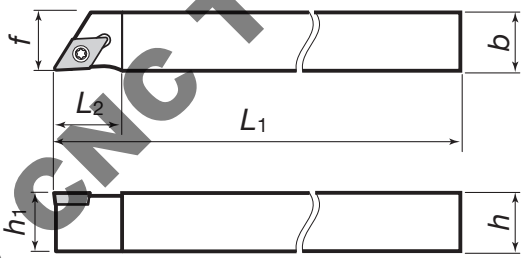
JSDJ2CR/L

Without offset / Positive rake
Screw-on system

Profiling



Cutting edge style **J2**



Right hand (R) shown

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

Basic Selection Chipbreaker DC□□

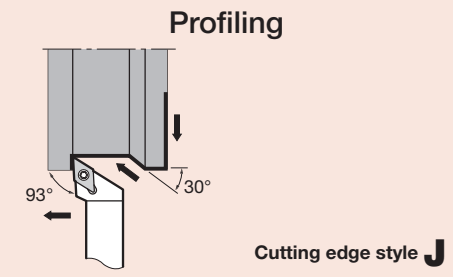
● : Stocked items.

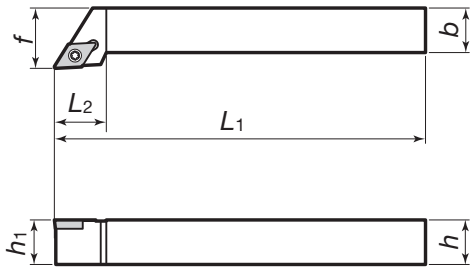
Jinan Terry CNC Tool Co.,Ltd.

sales@interui.com

JSDJCR/L

Positive rake
Screw-on system



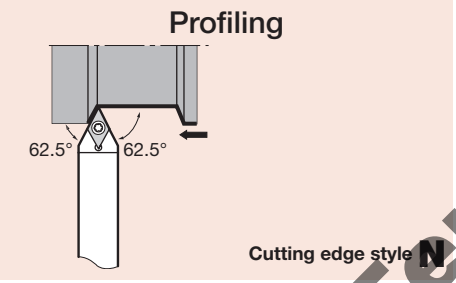


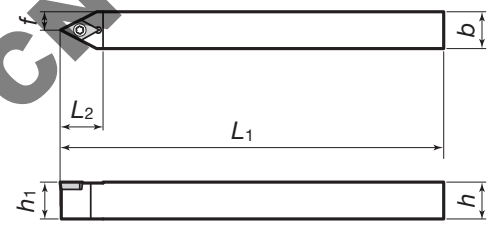
Right hand (R) shown

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

JSDNCN

Positive rake
Screw-on system





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

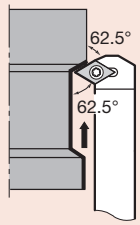
● : Stocked items.

Jinan Terry CNC Tool Co.,Ltd.

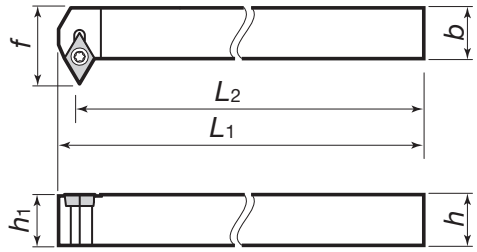
JSDN3CR/L

Positive rake
Screw-on system

Profiling



Cutting edge style **N3**



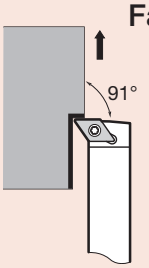
Right hand (R) shown

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

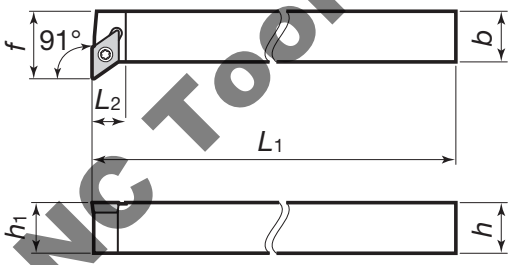
JSDFCR/L

Positive rake
Screw-on system

Facing



Cutting edge style **F**



Right hand (R) shown

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

● : Stocked items.

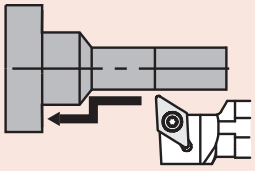
Jinan Terry CNC Tool Co.,Ltd.

sales@interui.com

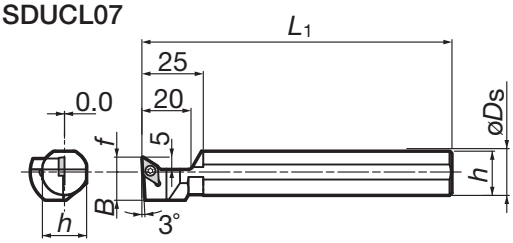
JS-SDUCL

Positive rake
Screw-on system

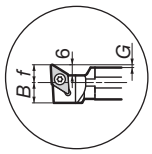
Profiling



SDUCL07



SDUCL11

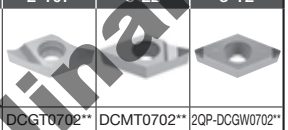


Left hand (L) shown.

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

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

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

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

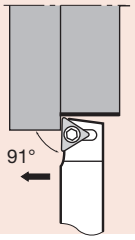
● : Stocked items.

Jinan Terry CNC Tool Co.,Ltd.

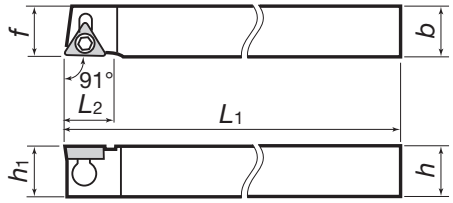
JTTACR/L

Without offset / Positive rake
Back clamping system

Turning



Cutting edge style **A**



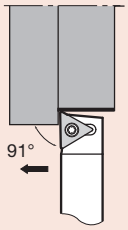
Right hand (R) shown

Cat. No.	Stock R	Stock L	Dimensions (mm) h	b	L_1	L_2	h_1	f	Standard corner radius r_ε	Applicable inserts	Parts Clamp	Clamping screw	Wrench
JTTACR/L0810K08	●	●	8	10	125	10	8	10	0.2	TC□□0802	JCP-1	JDS-3525	P-2F
JTTACR/L1010K08	●	●	10	10	125	10	10	10	0.2				
JTTACR/L1212M11	●	●	12	12	150	12	12	12	0.4	TC□□1102	JCP-2	JDS-3525	P-2F
JTTACR/L1616M11	●	●	16	16	150	12	16	16	0.4				

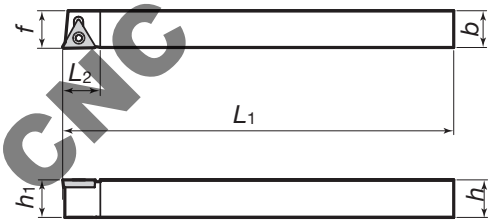
JSTACR/L

Without offset / Positive rake
Screw-on system

Turning



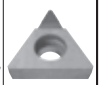
Cutting edge style **A**



Right hand (R) shown

Cat. No.	Stock R	Stock L	Dimensions (mm) h	b	L_1	L_2	h_1	f	Standard corner radius r_ε	Applicable inserts	Parts Clamping screw	Wrench	Torque (N·m)
JSTACR/L0808K08	●	●	8	8	125	10	8	8	0.2	TC□□0802	CSTB-2L	T-6F	0.6
JSTACR/L1010K08	●	●	10	10	125	10	10	10	0.2				
JSTACR/L1212K11	●	●	12	12	125	12	12	12	0.4	TC□□1102	CSTB-2.5	T-8F	1.2
JSTACR/L1616H11	●	●	16	16	100	12	16	16	0.4				

Basic Selection Chipbreakers TC□□0802 TC□□1102

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

● : Stocked items.

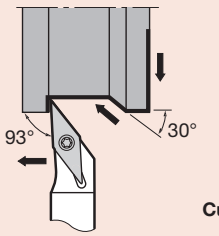
Jinan Terry CNC Tool Co.,Ltd.

sales@interui.com

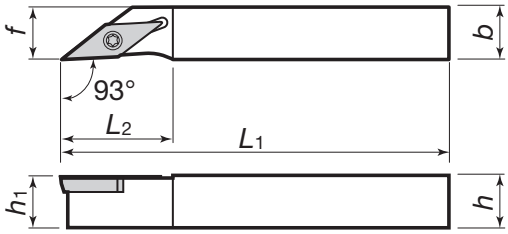
JSVJ2BR/L

Without offset / Positive rake
Screw-on system

Profiling



Cutting edge style **J2**



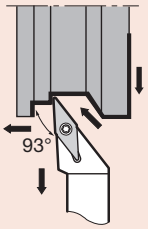
Right hand (R) shown

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

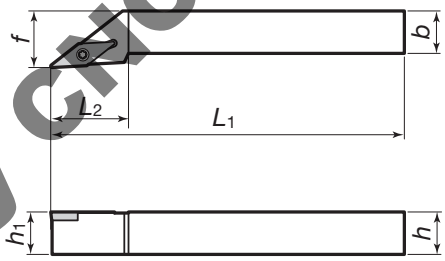
JSVJBR/L

Positive rake
Screw-on system

Profiling



Cutting edge style **J**



Right hand (R) shown

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

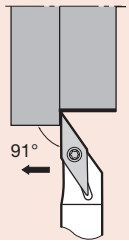
● : Stocked items.

Jinan Terry CNC Tool Co.,Ltd.

JSVABR/L

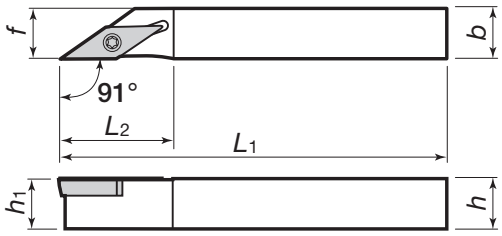
Without offset / Positive rake
Screw-on system

Turning



Cutting edge style **A**

Without offset



Right hand (R) shown

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

Basic Selection Chipbreakers VB□□1103

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

● : Stocked items.

Jinan Terry CNC Tool Co.,Ltd.

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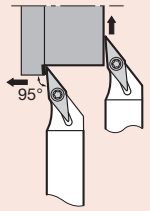
JSVL2PR/L

Without offset / Positive rake
Screw-on system

Turning / facing



Cutting edge style **L2**

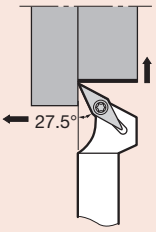
Right hand (R) shown

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

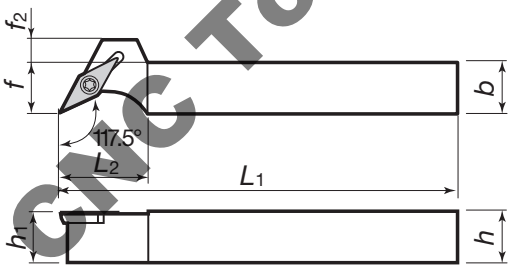
JSVP2PR/L

Positive rake
Screw-on system

Profiling



Cutting edge style **P2**



Right hand (R) shown

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

Basic Selection Chipbreakers VP□□

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

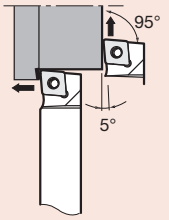
● : Stocked items.

Jinan Terry CNC Tool Co.,Ltd.

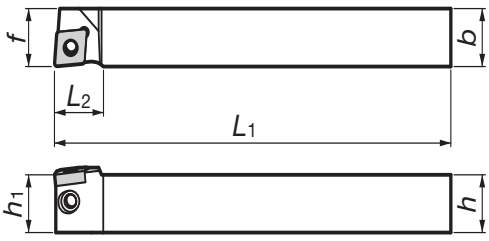
JTCL2NR/L

Without offset / Negative rake
Side clamping system

Turning / facing



Cutting edge style **L2**



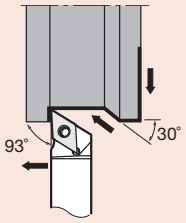
Right hand (R) shown

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

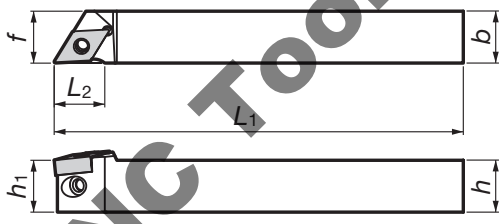
JTDJ2NR/L

Without offset / Negative rake
Side clamping system

Turning / profiling



Cutting edge style **J2**



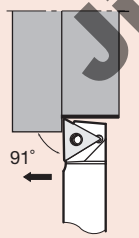
Right hand (R) shown

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

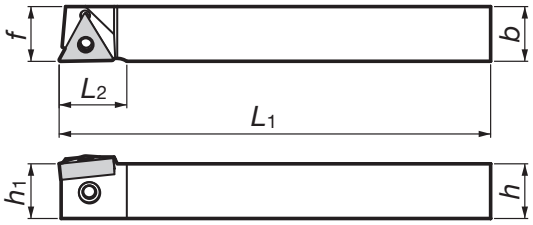
JTTANR/L

Without offset / Negative rake
Side clamping system

Turning



Cutting edge style **A**



Right hand (R) shown

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

● : Stocked items.

Jinan Terry CNC Tool Co.,Ltd.

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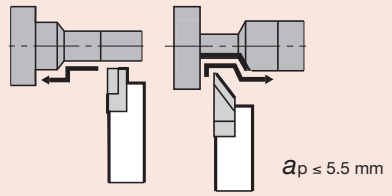
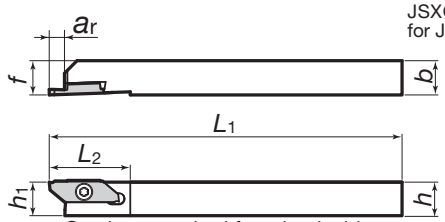
JSXGR/L

Without offset
Screw-on system

Front and reverse turning

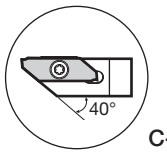


Front turning Reverse turning



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

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

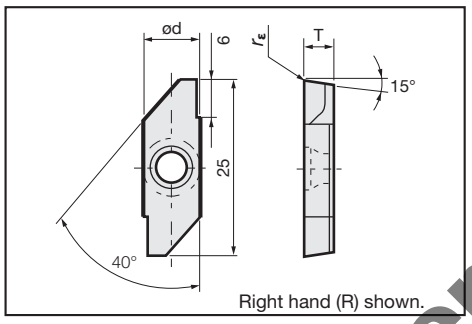


C-type

Right hand (R) shown.

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

Applicable inserts

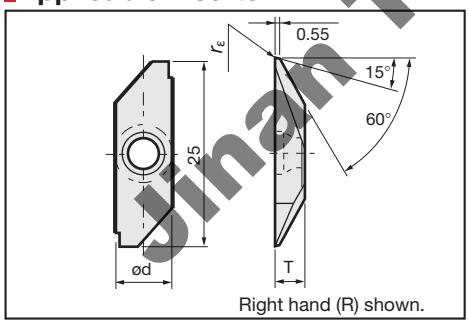


Right hand (R) shown.

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

Cat. No.	Dimensions (mm) ød	T	r_ε	Max. depth of cut	Stock Coated J740 R	Coated J740 L	Cermet NS530 R	Cermet NS530 L	Cermet R	Cermet L	Uncoated TH10 R	Uncoated TH10 L
JXFR/L8000F	8	3.97	0.03	5.5	●		●				●	
JXFR/L8010F			0.1		●		●				●	

Applicable inserts



Right hand (R) shown.

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

Cat. No.	Dimensions (mm) ød	T	r_ε	Max. depth of cut	Stock Coated J740 R	Coated J740 L	Cermet NS530 R	Cermet NS530 L	Cermet R	Cermet L	Uncoated TH10 R	Uncoated TH10 L
JXRR/L8000F	8	3.97	0.03	5.5	●		●				●	
JXRR/L8010F			0.1		●		●				●	

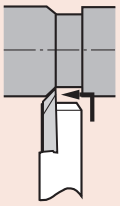
● : Stocked items.

Jinan Terry CNC Tool Co.,Ltd.

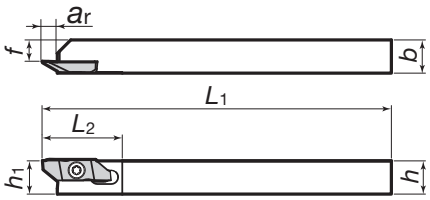
JSXBR/L

Without offset
Screw-on system

Back turning with large depth of cut

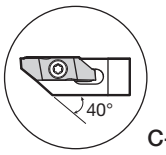


$a_p \leq 5.5$ mm



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

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

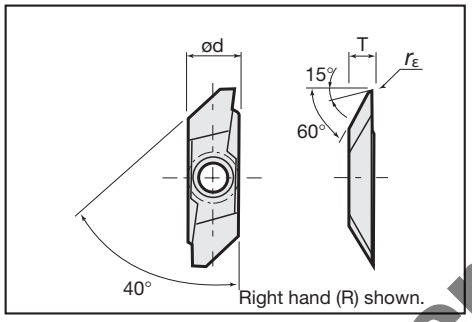


C-type

Right hand (R) shown.

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

Applicable inserts



JXB-type inserts (with sharp edges)

Cat. No.	Dimensions (mm) ød	T	r_ε	Max. depth of cut	Stock: Coated J740 R	Coated J740 L	Cermet NS530 R	Cermet NS530 L	Cermet R	Cermet L	Uncoated TH10 R	Uncoated TH10 L
JXBR/L8000F	8	3.97	0.03	5.5	●	●	●				●	●
JXBR/L8005F			0.05		●	●					●	●
JXBR/L8010F			0.1		●	●	●				●	●
JXBR/L8015F			0.15		●	●					●	●

JXB-type inserts (with honed edges)

Cat. No.	Dimensions (mm) ød	T	r_ε	Max. depth of cut	Stock: Coated J740 R	Coated J740 L	Cermet NS530 R	Cermet NS530 L	Cermet R	Cermet L	Uncoated TH10 R	Uncoated TH10 L
JXBR/L8005	8	3.97	0.05	5.5	●	●						
JXBR/L8010			0.1		●	●						
JXBR/L8015			0.15		●	●						

● : Stocked items.

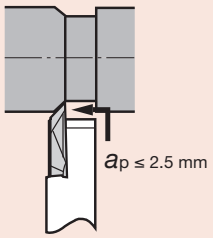
Jinan Terry CNC Tool Co.,Ltd.

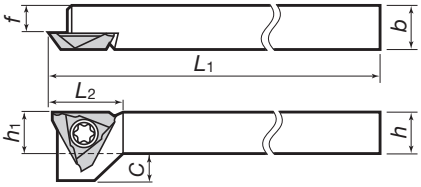
sales@interui.com

JSTBR/L

Without offset
Screw-on system

Back turning





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

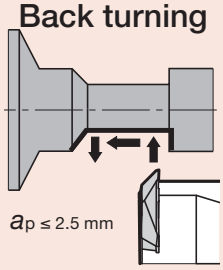
Right hand (R) shown.

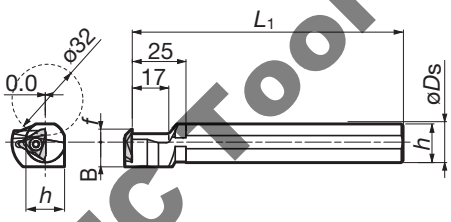
Cat. No.	Stock R	Stock L	h	b	L_1	L_2	h_1	f	C	Applicable inserts	Clamping screw	Wrench	
JSTBR/L1010K3	●	●	10	10	125	15	10	6	5	JTBR/L3□□□	CSTB-4SD	T-8F	(T-8L) ∗Optional
JSTBR/L1212K3	●	●	12	12			12	8	3				
JSTBR/L1616K3	●	●	16	16			16	12	-				

JS-TBL3

Positive rake
Screw-on system

Back turning

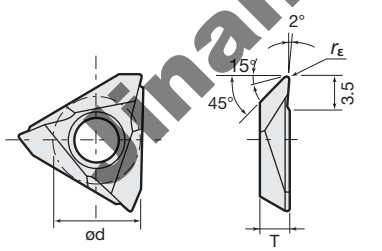




Cat. No.	Stock	$øD_s$	f	L_1	L_2	h	B	Applicable inserts	Clamping screw	Wrench
JS19K-TBL3	●	19.05	6	125	-	18	11.5	JTBR3□□□	CSTB-4S	T-15F
JS20K-TBL3	●	20				19				
JS22K-TBL3	●	22				21				
JS25K-TBL3	●	25.4	10			24	12.7			

Notes: Left hand holder use right hand insert.

Applicable inserts



Right hand (R) shown.

JTB-type inserts (with sharp edges)

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

JTB-type inserts (with honed edges)

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

● : Stocked items.

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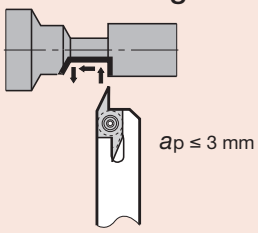
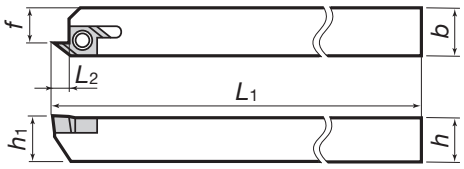
JSEGR/L

Without offset
Screw-on system

Back turning

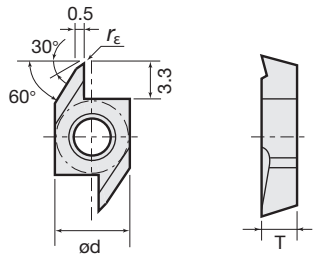




Right hand (R) shown.

Cat. No.	Stock R	Stock L	Dimensions (mm) h	b	L1	L2	h1	f	Applicable inserts	Clamping screw	Wrenches	
JSEGR/L1010K10	●	●	10	10	125	3.3	10	7.5	J10ER/L□□□□□	CSTB-2.5	T-8F	(T-8L)
JSEGR/L1212K10	●	●	12	12			12	9.5				
JSEGR/L1616K10	●	●	16	16			16	13.5				∗Optional

Applicable inserts



Right hand (R) shown.

J10E-type inserts (with sharp edges)

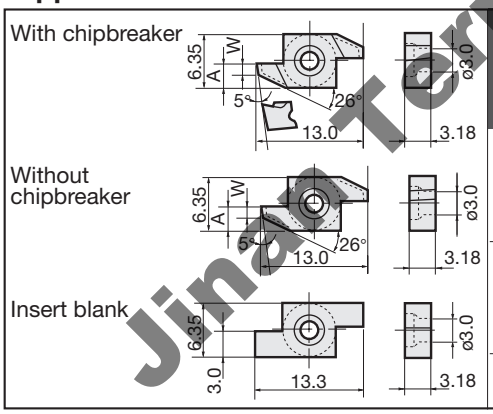
Cat. No.	Dimensions (mm) ød	T	rε	Max. depth of cut	Stock: Coated J740 R	Coated J740 L	Coated cermet J530 R	Coated cermet J530 L	Cermet R	Cermet L	Cermet NS530 R	Cermet NS530 L	Uncoated TH10 R	Uncoated TH10 L
J10ER/L005BF	6.35	3.18	0.05	3	●	●					●	●			●	●
J10ER/L010BF			0.1		●	●					●	●			●	●
J10ER/L015BF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

J10E-type inserts (with honed edges)

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

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

Applicable inserts

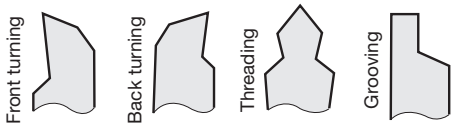


Type	Cat. No.	Dimensions (mm) W	A	Stock: Cermet NS530 R	Cermet NS530 L	Cermet R	Cermet L	Uncoated TH10 R	Uncoated TH10 L
With chipbreaker	10ER/L100BC	1	2.5	●					
	10ER/L150BC	1.5	3	●					
Without chipbreaker	10ER/L100B	1	2.5					●	●
	10ER/L150B	1.5	3					●	●
Insert blank	10ER/L300	–	–	●				●	●

Right hand (R) shown.

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

Formed examples of insert blanks



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

Standard cutting conditions

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

● : Stocked items.

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MEMO

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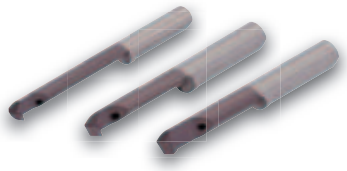
Overview of J series Internal Turning

TINYTURN



- 146 solid bar items in a wide range of geometries
- Minimum boring diameter: *øDm* = 0.6 mm

Boring, profiling, chamfering

Type	Application	Shank diameter *øDs* (mm)	Min. bore dia. *øDm* (mm) (0 – 2 – 4 – 6 – 8 – 10)
JBT (P. 8-28)	Boring, profiling, chamfering	ø4, ø7	ø0.6 – ø7.0
JBP (P. 8-29)	Boring, chamfering	ø4, ø7	ø2.8 – ø5.0
JBU (P. 8-29)	Back boring, chamfering	ø7	ø5.0
JBC (P. 8-30)	Boring, 45° chamfering	ø7	ø5.0 – ø6.8
JBB (P. 8-30)	Back boring	ø4, ø7	ø3.0 – ø7.0

Threading

Type	Application	Shank diameter *øDs* (mm)	Min. bore dia. *øDm* (mm) (0 – 2 – 4 – 6 – 8 – 10)
JBI (P. 8-31)	Threading (Metric thread)	ø4, ø7	ø4.0 – ø7.0

Grooving

Type	Application	Shank diameter *øDs* (mm)	Groove width W (mm)	Min. bore dia. *øDm* (mm) (0 – 2 – 4 – 6 – 8 – 10 – 12 – 14 – 15)
JBG (P. 8-32)	Grooving	ø4, ø7	0.5 - 2.0	ø2.0 – ø6.8
JBF (P. 8-33)	Face grooving	ø7	1.0 - 3.0	ø6.0 – ø15.0
JBS (P. 8-33)	Face grooving (for shaft)	ø7	2.0	ø6.0
JBR (P. 8-34)	Boring, profiling (full radius type)	ø7	1.0	ø5.0 – ø6.8

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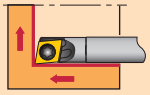
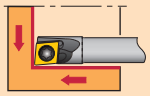
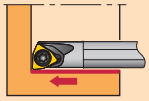
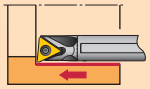
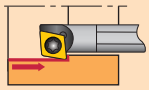
STREAMJETBARMINI

Positive type

	Style	Shank type	Shank diameter	Minimum bore diameter (mm) 0 10 20 30 40 50
	**SEXPR/L** ⇒8-39 Boring and facing Insert type: EP□□	Steel Carbide	ø4 ~ ø6 ø4 ~ ø6	ø4.5 ø7 ø4.5 ø7
	**SCLCR/L** ⇒8-36 Boring and facing Insert type: CC□□	Steel Carbide	ø4 ~ ø7 ø4 ~ ø7	ø5 ø8 ø5 ø8
	**SWUBR/L** ⇒8-38 Boring Insert type: WB□□	Steel Carbide	ø5 ~ ø7 ø5 ~ ø7	ø6 ø8 ø6 ø8
	**STUPR/L** ⇒8-37 Boring Insert type: TP□□	Steel Carbide	ø7 ø7	ø8 ø8
	**SEZPR/L** ⇒8-39 Internal retracting Insert type: EP□□	Steel Carbide	ø4 ~ ø5 ø4 ~ ø5	ø5.5 ø6.5 ø5.5 ø6.5

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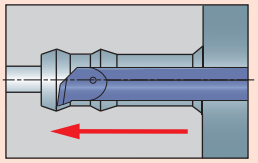
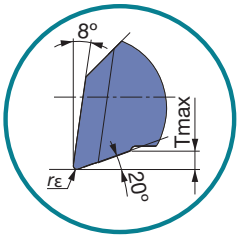
JBT

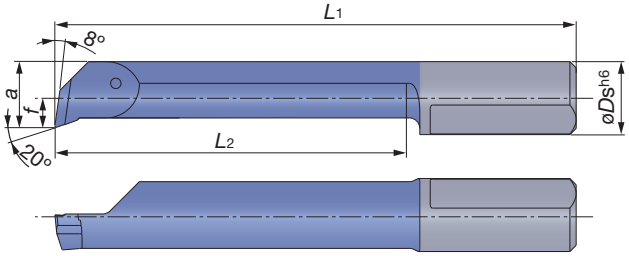
Solid boring bars

Boring, profiling, chamfering





Details of edge



Right hand (R) shown.

Cat. No.	Grade SH730 R	Grade SH730 L	Min. bore dia. øDm (mm)	Dimensions (mm) øDs	f	a	L_1	Overhang length L_2	Tmax	Corner radius r_ε $^{+0.05}_{0}$
JBTR/L04020004-D006	●		0.6	4	-	0.5	18.5	2	0.08	0.04
JBTR/L04030004-D006	●		0.6	4	-	0.5	19.5	3	0.08	0.04
JBTR/L04045005-D010	●		1	4	-	0.9	21	4.5	0.1	0.05
JBTR/L04065005-D010	●		1	4	-	0.9	23	6.5	0.1	0.05
JBTR/L04040005-D020	●		2	4	-	1.7	20.5	4	0.1	0.05
JBTR/L04090005-D020	●		2	4	-	1.7	25.5	9	0.1	0.05
JBTR/L04140005-D020	●		2	4	-	1.7	30.5	14	0.1	0.05
JBTR/L04090010-D028	●	●	2.8	4	0.6	2.6	25.5	9	0.2	0.10
JBTR/L04150010-D028	●	●	2.8	4	0.6	2.6	31.5	15	0.2	0.10
JBTR/L04190010-D028	●	●	2.8	4	0.6	2.6	35.5	19	0.2	0.10
JBTR/L04090010-D040	●	●	4	4	1.5	3.5	25.5	9	0.3	0.10
JBTR/L04150010-D040	●	●	4	4	1.5	3.5	31.5	15	0.3	0.10
JBTR/L04190010-D040	●	●	4	4	1.5	3.5	35.5	19	0.3	0.10
JBTR/L04230010-D040	●		4	4	1.5	3.5	39.5	23	0.3	0.10
JBTR/L04270010-D040	●		4	4	1.5	3.5	43.5	27	0.3	0.10
JBTR/L07090015-D050	●	●	5	7	0.9	4.4	25	9	0.5	0.15
JBTR/L07140015-D050	●	●	5	7	0.9	4.4	30	14	0.5	0.15
JBTR/L07190015-D050	●	●	5	7	0.9	4.4	35	19	0.5	0.15
JBTR/L07240015-D050	●	●	5	7	0.9	4.4	40	24	0.5	0.15
JBTR/L07290015-D050	●	●	5	7	0.9	4.4	45	29	0.5	0.15
JBTR/L07340015-D050	●		5	7	0.9	4.4	50	34	0.5	0.15
JBTR/L07140015-D060	●	●	6	7	1.8	5.3	30	14	0.5	0.15
JBTR/L07210015-D060	●	●	6	7	1.8	5.3	37	21	0.5	0.15
JBTR/L07240015-D060	●	●	6	7	1.8	5.3	40	24	0.5	0.15
JBTR/L07290015-D060	●	●	6	7	1.8	5.3	45	29	0.5	0.15
JBTR/L07340015-D060	●		6	7	1.8	5.3	50	34	0.5	0.15
JBTR/L07410015-D060	●		6	7	1.8	5.3	57	41	0.5	0.15
JBTR/L07190015-D068	●	●	6.8	7	2.8	6.3	35	19	0.6	0.15
JBTR/L07240015-D068	●		6.8	7	2.8	6.3	40	24	0.6	0.15
JBTR/L07290015-D068	●	●	6.8	7	2.8	6.3	45	29	0.6	0.15
JBTR/L07340015-D070	●	●	7	7	2.8	6.3	50	34	0.6	0.15
JBTR/L07390015-D070	●		7	7	2.8	6.3	55	39	0.6	0.15
JBTR/L07440015-D070	●		7	7	2.8	6.3	60	44	0.6	0.15
JBTR/L07490015-D070	●		7	7	2.8	6.3	65	49	0.6	0.15

● : Stocked items

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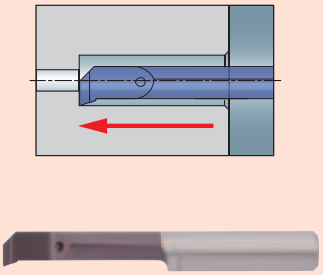
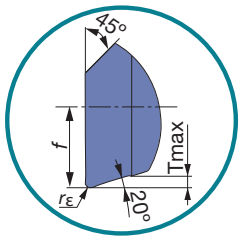
JBP

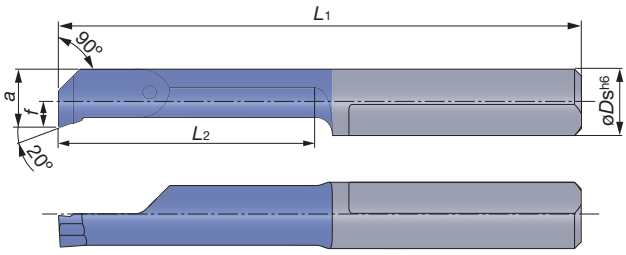
Solid boring bars

Boring, chamfering





Details of edge

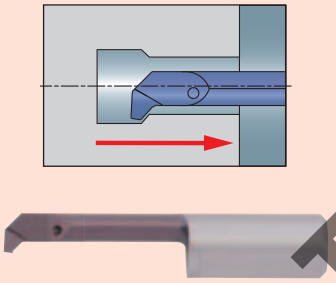


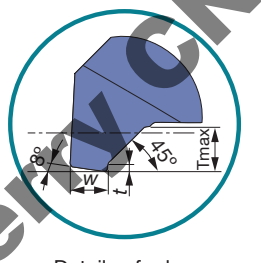
Cat. No.	Grade SH730	Min. bore dia. øDm (mm)	Dimensions (mm) øDs	f	a	L_1	Overhang length L_2	Tmax	Corner radius r_ε $^{+0.05}_{0}$
JBPR04090010-D028	●	2.8	4	0.6	2.6	25.5	9	0.2	0.10
JBPR04150010-D028	●	2.8	4	0.6	2.6	31.5	15	0.2	0.10
JBPR04090010-D040	●	4	4	1.5	3.5	25.5	9	0.3	0.10
JBPR04150010-D040	●	4	4	1.5	3.5	31.5	15	0.3	0.10
JBPR07140015-D050	●	5	7	0.9	4.4	30	14	0.5	0.15
JBPR07190015-D050	●	5	7	0.9	4.4	35	19	0.5	0.15

JBU

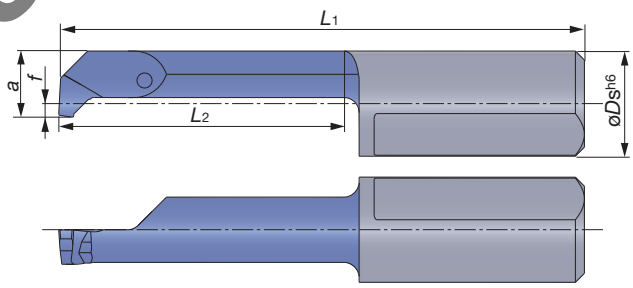
Solid boring bars

Back boring, chamfering





Details of edge



Right hand (R) shown.

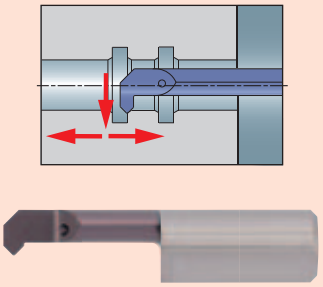
Cat. No.	Grade SH730 R	SH730 L	Min. bore dia. øDm (mm)	Dimensions (mm) øDs	f	a	L_1	Overhang length L_2	t	Tmax	Groove width (mm) W $^{+0.05}_{0}$
JBUR/L07140010-D050	●		5	7	0.9	4.4	30	14	0.2	1	1
JBUR/L07190010-D050	●		5	7	0.9	4.4	35	19	0.2	1	1

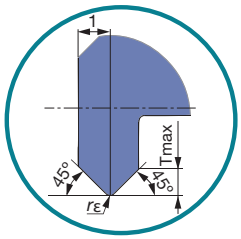
Jinan Terry CNC Tool Co.,Ltd.

JBC

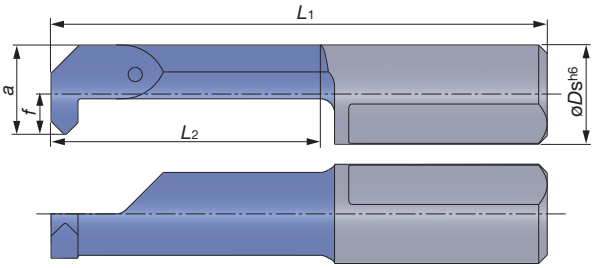
Solid boring bars

Boring, 45° chamfering





Details of edge

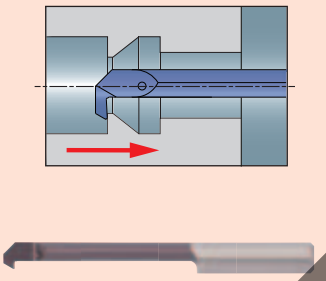


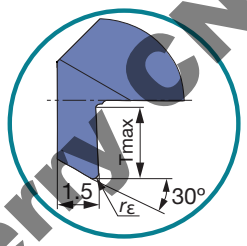
Cat. No.	Grade	Min. bore dia. øDm (mm)	Dimensions (mm)						
	SH730		øDs	f	a	L1	Overhang length L2	Tmax	Corner radius rε ± 0.05
JBCR07140020-D050	●	5	7	0.9	4.4	30	14	0.7	0.2
JBCR07190020-D050	●	5	7	0.9	4.4	35	19	0.7	0.2
JBCR07190020-D068	●	6.8	7	2.8	6.3	35	19	0.7	0.2

JBB

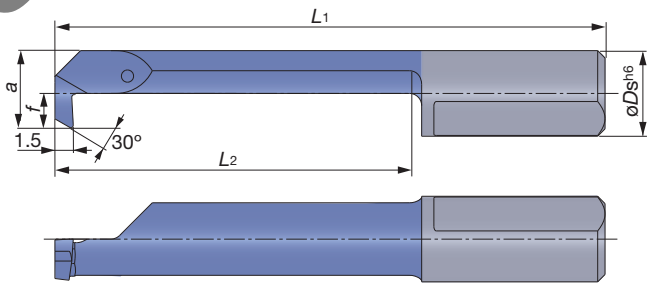
Solid boring bars

Back boring





Details of edge



Cat. No.	Grade	Min. bore dia. øDm (mm)	Dimensions (mm)						
	SH730		øDs	f	a	L1	Overhang length L2	Tmax	Corner radius rε ± 0.05
JBBR04140020-D030	●	3	4	0.6	2.6	30	14	0.5	0.2
JBBR04190020-D030	●	3	4	0.6	2.6	35	19	0.5	0.2
JBBR04140015-D040	●	4	4	1.5	3.5	30	14	0.8	0.15
JBBR04240015-D040	●	4	4	1.5	3.5	40	24	0.8	0.15
JBBR07190020-D050	●	5	7	0.9	4.4	35	19	1	0.2
JBBR07290020-D050	●	5	7	0.9	4.4	45	29	1	0.2
JBBR07190020-D060	●	6	7	1.8	5.3	35	19	1.8	0.2
JBBR07290020-D060	●	6	7	1.8	5.3	45	29	1.8	0.2
JBBR07190020-D070	●	7	7	2.8	6.3	35	19	2.5	0.2
JBBR07290020-D070	●	7	7	2.8	6.3	45	29	2.5	0.2

● : Stocked items

Jinan Terry CNC Tool Co.,Ltd.

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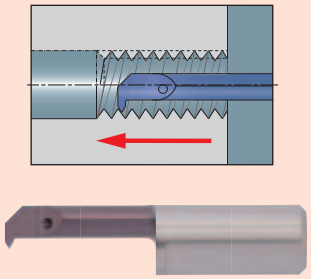
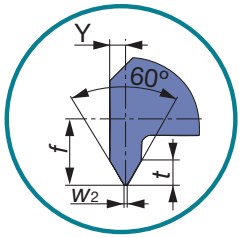
JBI

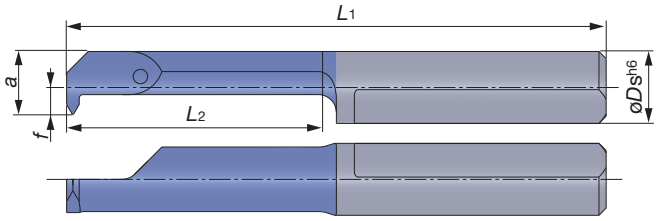
Solid boring bars

Threading (metric thread)





Details of edge



Cat. No.	Grade	Pitch	Min. bore dia.	Flat width	Dimensions (mm)						
	SH730	(mm)	øDm (mm)	$W_{2\ -0.02}^{\ 0}$	øDs	f	a	L_1	Overhang length L_2	t	Y
JBIR04140050-D040	●	0.5	4	0.06	4	1.5	3.5	30	14	0.3	0.35
JBIR07140050-D050	●	0.5	5	0.06	7	0.9	4.4	30	14	0.3	0.35
JBIR07140075-D050	●	0.75	5	0.09	7	0.9	4.4	30	14	0.4	0.45
JBIR07140100-D048	●	1	4.8	0.12	7	0.9	4.4	30	14	0.6	0.55
JBIR07140100-D060	●	1	6	0.12	7	1.8	5.3	30	14	0.6	0.55
JBIR07140125-D060	●	1.25	6	0.15	7	1.8	5.3	30	14	0.7	0.65
JBIR07140150-D060	●	1.5	6	0.18	7	1.8	5.3	30	14	0.8	0.75
JBIR07140150-D070	●	1.5	7	0.18	7	2.8	6.3	30	14	0.8	0.75

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● : Stocked items

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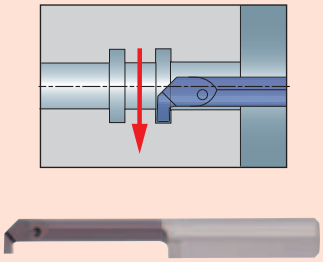
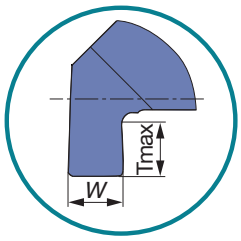
JBG

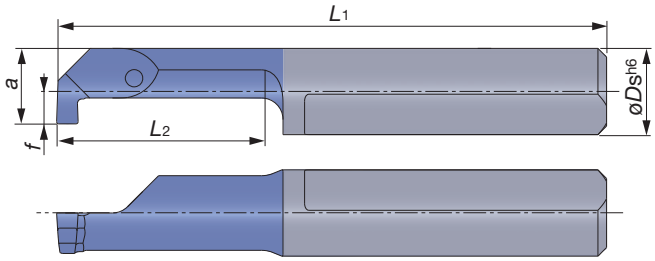
Solid boring bars

Grooving





Details of edge



Right hand (R) shown.

Cat. No.	Grade SH730 R	Grade SH730 L	Groove width $W^{+0.05}_{0}$ (mm)	Min. bore dia. øDm (mm)	Dimensions (mm) øDs	f	a	L1	Overhang length L2	Tmax
JBGR/L04050050-D020	●		0.5	2	4	0.2	1.8	21	5	0.4
JBGR/L04100050-D020	●		0.5	2	4	0.2	1.8	26	10	0.4
JBGR/L04050070-D030	●		0.7	3	4	0.7	2.7	21	5	0.6
JBGR/L04100070-D030	●		0.7	3	4	0.7	2.7	26	10	0.6
JBGR/L04090100-D040	●		1	4	4	1.5	3.5	25.5	9	0.8
JBGR/L04150100-D040	●		1	4	4	1.5	3.5	31.5	15	0.8
JBGR/L07090100-D050	●		1	5	7	0.9	4.4	25	9	1
JBGR/L07140100-D050	●		1	5	7	0.9	4.4	30	14	1
JBGR/L07090150-D050	●		1.5	5	7	0.9	4.4	25	9	1
JBGR/L07140150-D050	●		1.5	5	7	0.9	4.4	30	14	1
JBGR/L07090200-D050	●		2	5	7	0.9	4.4	25	9	1
JBGR/L07190200-D050	●		2	5	7	0.9	4.4	35	19	1
JBGR/L07090100-D060	●	●	1	6	7	1.8	5.3	25	9	1.8
JBGR/L07140100-D060	●		1	6	7	1.8	5.3	30	14	1.8
JBGR/L07210100-D060	●		1	6	7	1.8	5.3	37	21	1.8
JBGR/L07290100-D060	●		1	6	7	1.8	5.3	45	29	1.8
JBGR/L07090150-D060	●	●	1.5	6	7	1.8	5.3	25	9	1.8
JBGR/L07140150-D060	●		1.5	6	7	1.8	5.3	30	14	1.8
JBGR/L07210150-D060	●		1.5	6	7	1.8	5.3	37	21	1.8
JBGR/L07240150-D060	●		1.5	6	7	1.8	5.3	40	24	1.8
JBGR/L07290150-D060	●		1.5	6	7	1.8	5.3	45	29	1.8
JBGR/L07090200-D060	●		2	6	7	1.8	5.3	25	9	1.8
JBGR/L07140200-D060	●		2	6	7	1.8	5.3	30	14	1.8
JBGR/L07210200-D060	●		2	6	7	1.8	5.3	37	21	1.8
JBGR/L07240200-D060	●		2	6	7	1.8	5.3	40	24	1.8
JBGR/L07290200-D060	●		2	6	7	1.8	5.3	45	29	1.8
JBGR/L07090100-D068	●		1	6.8	7	2.7	6.2	25	9	2.5
JBGR/L07140100-D068	●		1	6.8	7	2.7	6.2	30	14	2.5
JBGR/L07210100-D068	●		1	6.8	7	2.7	6.2	37	21	2.5
JBGR/L07090150-D068	●		1.5	6.8	7	2.7	6.2	25	9	2.5
JBGR/L07140150-D068	●		1.5	6.8	7	2.7	6.2	30	14	2.5
JBGR/L07210150-D068	●		1.5	6.8	7	2.7	6.2	37	21	2.5
JBGR/L07290150-D068	●		1.5	6.8	7	2.7	6.2	45	29	2.5
JBGR/L07090200-D068	●		2	6.8	7	2.7	6.2	25	9	2.5
JBGR/L07140200-D068	●	●	2	6.8	7	2.7	6.2	30	14	2.5
JBGR/L07210200-D068	●		2	6.8	7	2.7	6.2	37	21	2.5
JBGR/L07250200-D068	●		2	6.8	7	2.7	6.2	40	25	2.5
JBGR/L07290200-D068	●		2	6.8	7	2.7	6.2	45	29	2.5

* The corner radius is less than 0.1 mm.

● : Stocked items

Jinan Terry CNC Tool Co.,Ltd.

Relating pages
Cutting conditions (8–35)
Tips (14–1~)

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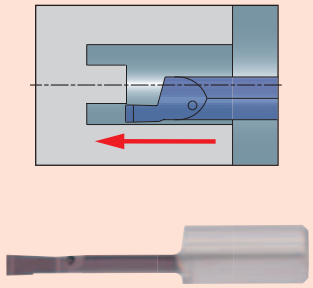
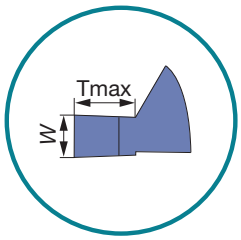
JBF

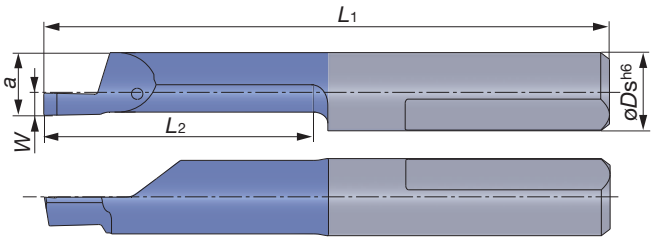
Solid boring bars

Face grooving





Details of edge



Right hand (R) shown.

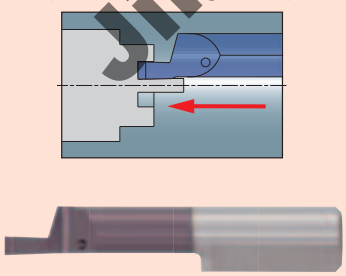
Cat. No.	Grade SH730 R	Grade SH730 L	Groove width $W^{+0.05}_{0}$ (mm)	Min. bore dia. øDm (mm)	Dimensions (mm) øDs	a	L1	Overhang length L2	Tmax
JBFR/L07110100-D060	●		1	6	7	5.2	26	10	1.5
JBFR/L07110150-D060	●		1.5	6	7	5.2	26	10	2
JBFR/L07110200-D060	●		2	6	7	5.2	26	10	3
JBFR/L07110250-D080	●		2.5	8	7	5.9	27	11	3.5
JBFR/L07110300-D080	●		3	8	7	5.9	27	11	3.5
JBFR/L07210150-D080	●	●	1.5	8	7	5.9	36	21	2.5
JBFR/L07210200-D080	●		2	8	7	5.9	36	21	3
JBFR/L07210250-D080	●		2.5	8	7	5.9	36	21	3.5
JBFR/L07210300-D080	●		3	8	7	5.9	36	21	3.5
JBFR/L07300200-D080	●	●	2	8	7	5.9	46	30	3
JBFR/L07300300-D080	●		3	8	7	5.9	46	30	3.5
JBFR/L07110100-D080	●		1	8	7	5.9	27	11	1.5
JBFR/L07110150-D080	●		1.5	8	7	5.9	27	11	2.5
JBFR/L07110200-D080	●		2	8	7	5.9	27	11	3
JBFR/L07200200-D080	●		2	8	7	5.9	36	20	3
JBFR/L07200250-D150	●		2.5	15	7	5.9	36	20	20
JBFR/L07200300-D150	●		3	15	7	5.9	36	20	20
JBFR/L07300300-D150	●		3	15	7	5.9	46	30	30

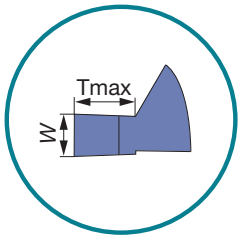
* The corner radius is less than 0.1 mm.

JBS

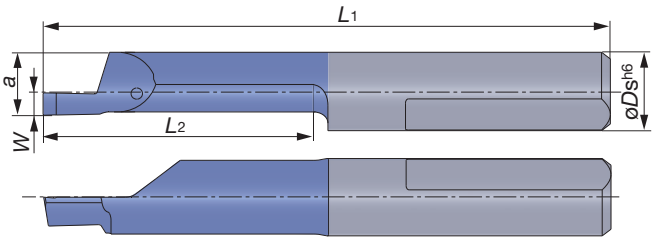
Solid boring bars

Face grooving (for machining shaft)





Details of edge



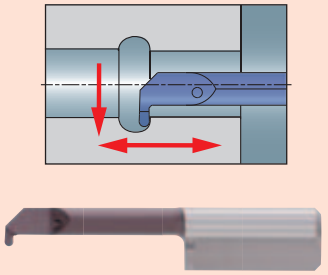
Cat. No.	Grade SH730	Groove width $W^{+0.05}_{0}$ (mm)	Min. bore dia. øDm (mm)	Dimensions (mm) øDs	a	L1	Overhang length L2	Tmax
JBSR07200200-D060	●	2	6	7	5.2	36	20	4

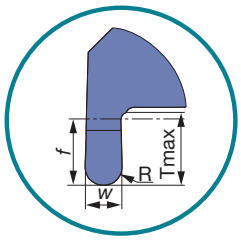
* The corner radius is less than 0.1 mm.

● : Stocked items

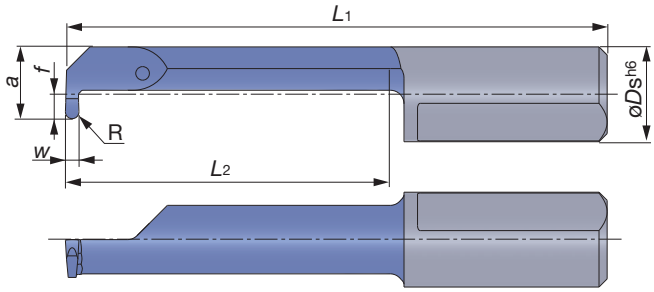
Jinan Terry CNC Tool Co.,Ltd.

Boring, profiling (full radius type)





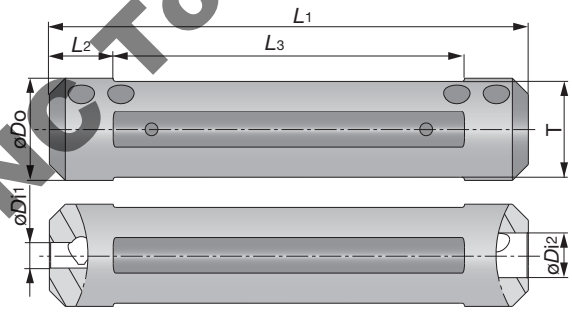
Details of edge



Cat. No.	Grade	Groove width $W^{+0.05}_{0}$ (mm)	Min. bore dia. øDm (mm)	Dimensions (mm)						
	SH730			øDs	f	a	L_1	Overhang length L_2	Tmax	R
JBRR07190050-D050	●	1	5	7	0.9	4.4	35	19	1	0.5
JBRR07240050-D060	●	1	6	7	1.8	5.3	40	24	1.8	0.5
JBRR07290050-D068	●	1	6.8	7	2.8	6.3	45	29	2.5	0.5

Sleeves

JBBS For TinyTurn



Cat. No.	Stock	Dimensions (mm)							Replacement parts	
		øDo	øDi1	øDi2	L_1	L_2	L_3	T	Clamping screw	Wrench
JBBS12-4-4	●	12	4	4	75	10	55	10.3	SSHM5-4PF-S	P-2.5
JBBS127-4-4	●	12.7	4	4	76.2	10	56.2	11.6	SSHM5-6PF-S	P-2.5
JBBS14-4-4	●	14	4	4	75	10	55	12	SSHM5-4PF-S	P-2.5
JBBS159-4-7	●	15.875	4	7	76.2	10	56.2	14	SSHM5-6PF-S	P-2.5
JBBS16-4-7	●	16	4	7	75	10	55	15	SSHM5-6PF-S	P-2.5
JBBS19-4-7	●	19.05	4	7	89	10	69	17.2	SSHM5-6PF-S	P-2.5
JBBS20-4-7	●	20	4	7	90	10	70	18	SSHM5-6PF-S	P-2.5
JBBS22-4-7	●	22	4	7	90	10	70	20	SSHM5-6PF-S	P-2.5
JBBS25-4-7	●	25	4	7	100	10	80	23	SSHM5-6PF-S	P-2.5
JBBS254-4-7	●	25.4	4	7	90	10	70	23.4	SSHM5-6PF-S	P-2.5

● : Stocked items

Jinan Terry CNC Tool Co.,Ltd.

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Standard cutting condition

Boring, profiling, chamfering, back boring

Work materials	Grade	Cutting speed *Vc* (m/min)	Feed *f* (mm/rev)
Steel S45C, SCM435 (C45, 34CrMo4) etc.	SH730	**90** (40 - 140)	**0.05** (0.01 - 0.08) * * JBTR/L04020004-D006, JBTR/L04030004-D006 Max. *f* = 0.01 mm/rev
Stainless steels SUS303, SUS304 (X10CrNiS18-9, X5CrNi18-9) etc.		**90** (40 - 140)	
Grey cast irons, ductile cast irons FC250, FCD400 (GG25, GGG40) etc.		**60** (30 - 100)	
Aluminium alloys, copper alloys Si < 12%		**150** (90 - 200)	
Titanium alloys Ti-6Al-4V etc.		**60** (30 - 100)	

Threading (metric thread)

Work materials	Grade	Cutting speed *Vc* (m/min)	Number of passes				
			Pitch (mm)				
			0.5	0.75	1	1.25	1.5
Steel S45C, SCM435 (C45, 34CrMo4) etc.	SH730	140	6 - 8	8 - 10	10 - 12	12 - 15	15 - 18
Stainless steels SUS303, SUS304 (X10CrNiS18-9, X5CrNi18-9) etc.		105	8	10	12	15	18
Grey cast irons, ductile cast irons FC250, FCD400 (GG25, GGG40) etc.		115	7	9	12	14	17
Aluminium alloys, copper alloys Si < 12%		350	6	8	10	12	15

Internal grooving

Work materials	Grade	Cutting speed *Vc* (m/min)	Feed *f* (mm/rev)
Steel S45C, SCM435 (C45, 34CrMo4) etc.	SH730	**90** (40 - 140)	**0.02** (0.01 - 0.03)
Stainless steels SUS303, SUS304 (X10CrNiS18-9, X5CrNi18-9) etc.		**90** (40 - 140)	
Grey cast irons, ductile cast irons FC250, FCD400 (GG25, GGG40) etc.		**60** (30 - 100)	
Aluminium alloys, copper alloys Si < 12%		**150** (90 - 200)	
Titanium alloys Ti-6Al-4V etc.		**60** (30 - 100)	

Face grooving

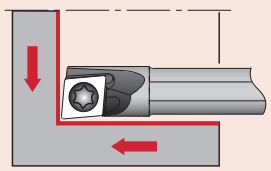
Work materials	Grade	Cutting speed *Vc* (m/min)	Feed *f* (mm/rev)
Steel S45C, SCM435 (C45, 34CrMo4) etc.	SH730	**90** (40 - 140)	**0.03** (0.01 - 0.05)
Stainless steels SUS303, SUS304 (X10CrNiS18-9, X5CrNi18-9) etc.		**90** (40 - 140)	
Grey cast irons, ductile cast irons FC250, FCD400 (GG25, GGG40) etc.		**60** (30 - 100)	
Aluminium alloys, copper alloys Si < 12%		**150** (90 - 200)	
Titanium alloys Ti-6Al-4V etc.		**60** (30 - 100)	

Jinan Terry CNC Tool Co.,Ltd.

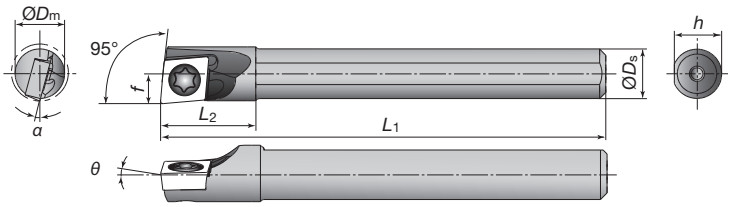
SCLCR/L STREAMJETBARMINI

Positive rake
screw-on system

Boring & internal facing



Cutting edge style **L**



Right hand (R) shown

Steel shank

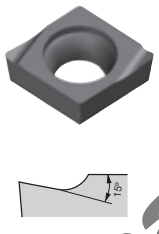
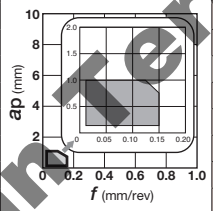
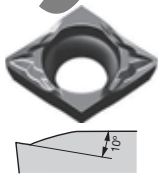
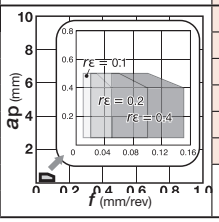
Cat. No.	Stock R	Stock L	Min bore.dia. øDm	Dimensions (mm) øDs	f	L1	L2	h	f2	θ	a	Std. corner radius rε	Applicable inserts	Parts: Clamping screw	Parts: Wrench	Torque (N·m)
A04F-SCLCR/L03-D050	●	●	5	4	2.5	80	8	3.8	-	0°	-15°	0.2	CC□□03X1	CSTA-1.6	T-6F	0.6
A05F-SCLCR/L03-D060	●	●	6	5	3	80	9	4.8	-	0°	-13°					
A06G-SCLCR/L04-D070	●	●	7	6	3.5	90	11	5.75	-	0°	-13°	0.2	CC□□04T1	CSTB-2	T-6F	0.6
A07G-SCLCR/L04-D080	●	●	8	7	4	90	12	6.75	-	0°	-11°					

Carbide shank

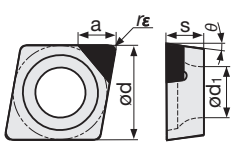
Cat. No.	Stock R	Stock L	Min bore.dia. øDm	Dimensions (mm) øDs	f	L1	L2	h	f2	θ	a	Std. corner radius rε	Applicable inserts	Parts: Clamping screw	Parts: Wrench	Torque (N·m)
E04G-SCLCR/L03-D050	●	●	5	4	2.5	90	9	3.8	-	0°	-15°	0.2	CC□□03X1	CSTA-1.6	T-6F	0.6
E05G-SCLCR/L03-D060	●	●	6	5	3	90	10	4.8	-	0°	-13°					
E06H-SCLCR/L04-D070	●	●	7	6	3.5	100	12	5.75	-	0°	-13°	0.2	CC□□04T1	CSTB-2	T-6F	0.6
E07H-SCLCR/L04-D080	●	●	8	7	4	100	14	6.75	-	0°	-11°					

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

Applicable inserts

Application	Chipbreaker: Appearance (Cross section)	f - ap	Insert Cat. No. (Metric)	Dimensions (mm): I.C. dia. ød	Thickness s	Hole dia. (Ø) ød1	Corner radius rε	Grades: Coated SH730	Carbide TH10
Finishing	W08 (G) 		CCGT03X100R-W08	3.57	1.39	1.9	0.03	●	●
			CCGT03X100L-W08					●	●
			CCGT03X101R-W08				0.10	●	●
			CCGT03X101L-W08					●	●
			CCGT03X102R-W08				0.20	●	●
			CCGT03X102L-W08					●	●
			CCGT03X104R-W08				0.40	●	●
			CCGT03X104L-W08					●	●
			CCGT04T100R-W08	4.37	1.79	2.3	0.03	●	●
			CCGT04T100L-W08					●	●
			CCGT04T101R-W08				0.10	●	●
			CCGT04T101L-W08					●	●
			CCGT04T102R-W08				0.20	●	●
			CCGT04T102L-W08					●	●
			CCGT04T104R-W08				0.40	●	●
			CCGT04T104L-W08					●	●
	JS (G) 		CCGT03X101-JS	3.57	1.39	1.9	0.10	●	
			CCGT03X102-JS				0.20	●	
			CCGT03X104-JS				0.40	●	
			CCGT04T101-JS	4.37	1.79	2.3	0.10	●	
			CCGT04T102-JS				0.20	●	
			CCGT04T104-JS				0.40	●	

Applicabale inserts (T-CBN)



Cat. No.	Dimensions (mm): Relief angle θ	I.C.dia ød	Thickness s	Hole dia ød1	Corner R rε	CBN length a	Grades: BX310
1QP-CCGW03X102	7°	3.57	1.39	1.9	0.2	1.4	●
1QP-CCGW03X104	7°	3.57	1.39	1.9	0.4	1.3	●
1QP-CCGW04T102	7°	4.37	1.79	2.3	0.2	1.9	●
1QP-CCGW04T104	7°	4.37	1.79	2.3	0.4	1.8	●

● : Stocked items.

Relating pages
Cutting conditions (8–41)
Insert (14–1~)

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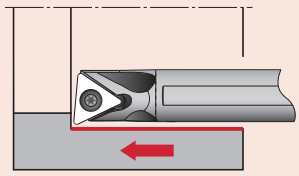
Jinan Terrific Tool Co.,Ltd.

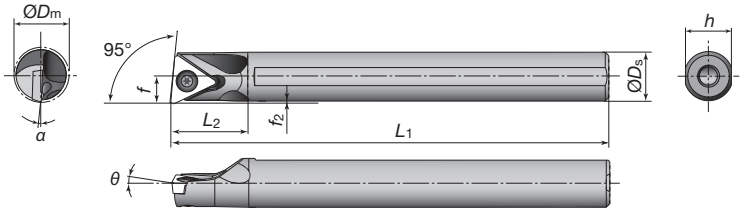
STUPR/L STREAMJETBARMINI

Positive rake
screw-on system

Boring



Cutting edge style **U**



Steel shank

Right hand (R) shown

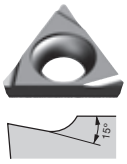
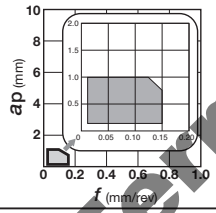
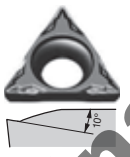
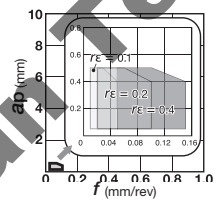
Cat. No.	Stock R	Stock L	Min bore.dia. øDm	Dimensions (mm) øDs	f	L1	L2	h	f2	θ	α	Std. corner radius rε	Applicable inserts	Parts: Clamping screw	Parts: Wrench	Torque (N·m)
A07G-STUPR/L07-D080	●	●	8	7	4	90	12	6.75	0.4	+5°	-10°	0.4	TP□□0701	CSTB-2.2L038	T-7F	0.9

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	Applicable inserts	Parts: Clamping screw	Parts: Wrench	Torque (N·m)
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

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).

Applicable inserts

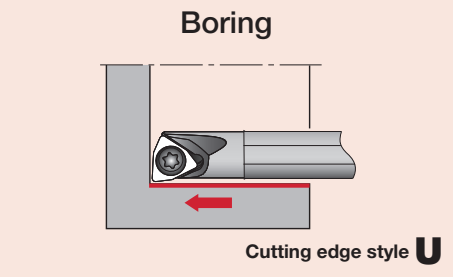
Application	Chipbreaker: Appearance (Cross section)	f - ap	Insert Cat. No. (Metric)	Dimensions (mm): I.C. dia. ød	Thickness s	Hole dia. (Ø) ød1	Corner radius rε	Grades: Coated SH730	Carbide TH10
Finishing	W08 (G) 		TPGT070100R-W08	4.37	1.59	2.58	0.03	●	●
			TPGT070100L-W08					●	●
			TPGT070101R-W08				0.10	●	●
			TPGT070101L-W08					●	●
			TPGT070102R-W08				0.20	●	●
			TPGT070102L-W08					●	●
			TPGT070104R-W08				0.40	●	●
			TPGT070104L-W08					●	●
	JS (G) 		TPGT070101-JS	4.37	1.59	2.58	0.10	●	
			TPGT070102-JS				0.20	●	
			TPGT070104-JS				0.40	●	

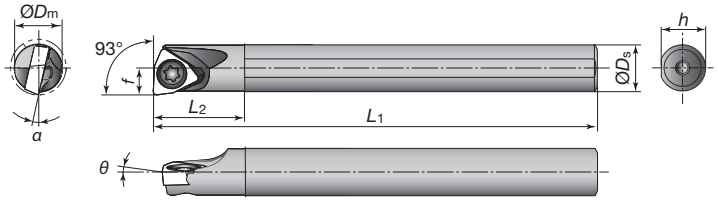
● : Stocked items.

Jinan Terrance CNC Tool Co.,Ltd.

SWUBR/L STREAMJETBARMINI

Positive rake
screw-on system





Right hand (R) shown

Steel shank

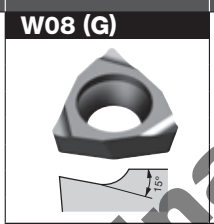
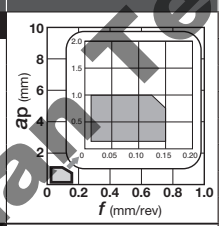
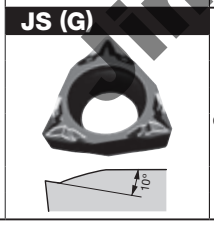
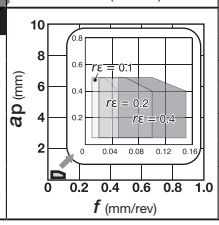
Cat. No.	Stock R	Stock L	Min bore.dia. øDm	Dimensions (mm) øDs	f	L1	L2	h	f2	θ	α	Std. corner radius rε	Applicable inserts	Parts Clamping screw	Parts Wrench	Torque (N·m)
A05F-SWUBR/L03-D060	●	●	6	5	3	80	9	4.8	-	0°	-13°	0.4	WB□□0301	CSTB-2	T-6F	0.6
A06G-SWUBR/L03-D070	●	●	7	6	3.5	90	11	5.75			-12°					
A07G-SWUBR/L03-D080	●	●	8	7	4	90	12	6.75			-11°					

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	Applicable inserts	Parts Clamping screw	Parts Wrench	Torque (N·m)
E05G-SWUBR/L03-D060	●	●	6	5	3	90	10	4.8	-	0°	-13°	0.4	WB□□0301	CSTB-2	T-6F	0.6
E06H-SWUBR/L03-D070	●	●	7	6	3.5	100	12	5.75			-12°					
E07H-SWUBR/L03-D080	●	●	8	7	4	100	14	6.75			-11°					

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).

Applicable inserts

Application	Chipbreaker / Appearance (Cross section)	f - ap	Insert Cat. No. (Metric)	Dimensions (mm) I.C. dia. ød	Thickness s	Hole dia. (Ø) ød1	Corner radius rε	Grades Coated SH730	Coated GH110	Cermet NS530	Carbide TH10	Carbide UX30
Finishing	W08 (G) 		WBGT030100R-W08	3.97	1.59	2.3	0.03	●				
			WBGT030100L-W08					●		●	●	●
			WBGT030101R-W08				0.10	●				
			WBGT030101L-W08					●			●	
			WBGT030102R-W08				0.20	●				
			WBGT030102L-W08					●	●	●	●	●
			WBGT030104R-W08				0.40	●				
			WBGT030104L-W08					●	●	●	●	●
	JS (G) 		WBGT030101R-JS	3.97	1.59	2.3	0.10	●				
			WBGT030101L-JS					●				
			WBGT030102R-JS				0.20	●				
			WBGT030102L-JS					●				
			WBGT030104R-JS				0.40	●				
			WBGT030104L-JS					●				

● : Stocked items.

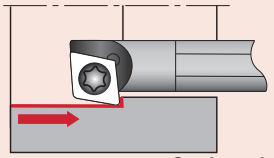
Dongguan Terry CNC Tool Co.,Ltd

sales@interui.com

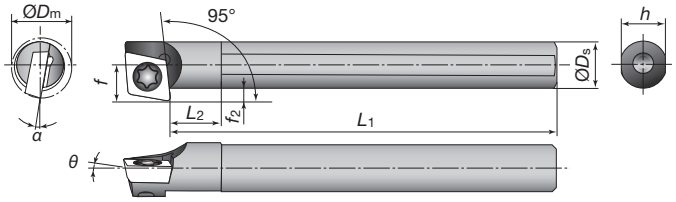
SEZPR/L STREAMJETBARMINI

Positive rake
screw-on system

Internal retracting



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	f2	θ	α	Std. corner radius rε	Applicable inserts	Parts: Clamping screw	Parts: Wrench	Torque (N·m)
A04F-SEZPR/L03-D055	●	●	5.5	4	3.2	80	4	3.8	1.2	0°	-8°	0.2	EP□□03X1 8-40	CSTA-1.6	T-6F	0.6
A05F-SEZPR/L03-D065	●	●	6.5	5	3.7	80	5	4.8			-6°					

Carbide shank

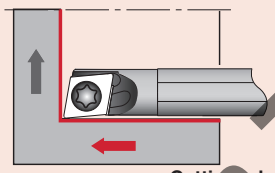
Cat. No.	Stock R	Stock L	Min bore.dia. øDm	Dimensions (mm) øDs	f	L1	L2	h	f2	θ	α	Std. corner radius rε	Applicable inserts	Parts: Clamping screw	Parts: Wrench	Torque (N·m)
E04G-SEZPR/L03-D055	●	●	5.5	4	3.2	90	5	3.8	1.2	0°	-8°	0.2	EP□□03X1 8-40	CSTA-1.6	T-6F	0.6
E05G-SEZPR/L03-D065	●	●	6.5	5	3.7	90	6	4.8			-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).

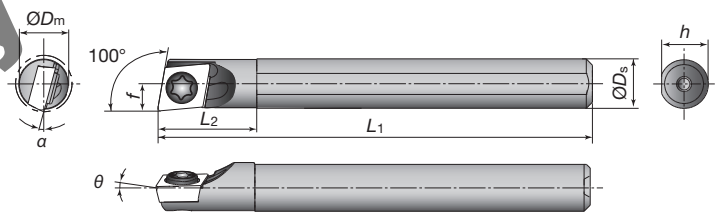
SEXPR/L STREAMJETBARMINI

Positive rake
screw-on system

Boring & internal facing



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	Applicable inserts	Parts: Clamping screw	Parts: Wrench	Torque (N·m)
A04F-SEXPR/L03-D045	●	●	4.5	4	2.3	80	8	3.8	-	0°	-15°	0.2	EP□□03X1 8-40	CSTA-1.6	T-6F	0.6
A04F-SEXPR/L03-D050	●	●	5	4	2.5	80	8	3.8	-	0°	-13°					
A05F-SEXPR/L04-D055	●	●	5.5	5	2.75	80	9	4.8	-	0°	-12°	0.4	EP□□0401 8-40	CSTB-2	T-6F	0.6
A06G-SEXPR/L04-D070	●	●	7	6	3.6	90	11	5.75	-	0°	-12°					

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	Applicable inserts	Parts: Clamping screw	Parts: Wrench	Torque (N·m)
E04G-SEXPR/L03-D045	●	●	4.5	4	2.3	90	9	3.8	-	0°	-15°	0.2	EP□□03X1 8-40	CSTA-1.6	T-6F	0.6
E04G-SEXPR/L03-D050	●	●	5	4	2.5	90	9	3.8	-	0°	-13°					
E05G-SEXPR/L04-D055	●	●	5.5	5	2.75	90	10	4.8	-	0°	-12°	0.4	EP□□0401 8-40	CSTB-2	T-6F	0.6
E06H-SEXPR/L04-D070	●	●	7	6	3.6	100	12	5.75	-	0°	-12°					

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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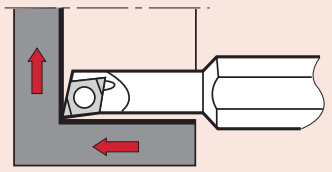
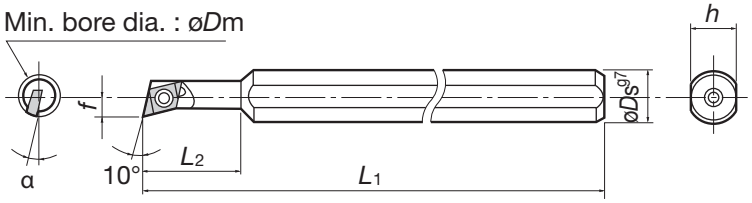
JS08H-SEXPR

Without offset / Positive rake
Screw-on system

Boring / Internal facing



Cutting edge style **X**



Right hand (R) shown.

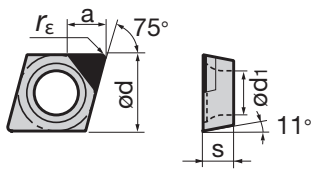
Cat. No.	Stock R	Stock L	Min. bore dia. øDm (mm)	Dimensions (mm) øDs	f	L1	L2	h	b	α	a	Std. Corner rε	Applicable insert	Clamping screw	Wrench
JS08H-SEXPR/L045	●		5.5	8	2.7	100	16	7	-	12°	-	0.4	EP□□0401□□	CSTB-2	T-6F
JS08H-SEXPR/L047	●		7		3.6		20								

● : Stocked items.

Applicable inserts

Application	Chipbreaker / Appearance (Cross section)	f - ap	Insert Cat. No. (Metric)	Dimensions (mm) I.C. dia. ød	Thickness s	Hole dia. (Ø) ød1	Corner radius rε	Grades Coated SH730	J740	GH110	Cermet NS530	GT530	Carbide TH10	UX30
Finishing	W08 (G)		EPGT03X100R-W08	3.57	1.39	1.9	0.03	●					●	
			EPGT03X100L-W08					●					●	
			EPGT03X101R-W08				0.10	●					●	
			EPGT03X101L-W08					●					●	
			EPGT03X102R-W08				0.20	●					●	
			EPGT03X102L-W08					●					●	
			EPGT03X104R-W08				0.40	●					●	
			EPGT03X104L-W08					●					●	
			EPGT040100R-W08	3.97	1.59	2.3	0.03	●					●	
			EPGT040100L-W08					●		●	●		●	
			EPGT040101R-W08				0.10	●					●	
			EPGT040101L-W08					●					●	
			EPGT040102R-W08				0.20	●		●	●		●	
			EPGT040102L-W08					●		●	●	●	●	●
			EPGT040104R-W08				0.40	●		●	●		●	
			EPGT040104L-W08					●		●	●	●	●	●
	J08 (G)		EPGT040100L-J08	3.97	1.59	2.3	0.03	●	●					
			EPGT040102L-J08				0.20	●	●					
			EPGT040104L-J08				0.40	●	●					
	JS (G)		EPGT03X101-JS	3.57	1.39	1.9	0.10	●						
			EPGT03X102-JS				0.20	●						
			EPGT03X104-JS				0.40	●						
			EPGT040101-JS	3.97	1.59	2.3	0.10	●						
			EPGT040102-JS				0.20	●						
			EPGT040104-JS				0.40	●						

Applicable T-CBN & T-DIA inserts



Cat. No.	Dimensions (mm) Inner circle ød	Thickness s	Hole ød1	Corner radius rε	Length of T-CBN, T-DIA edge a	Stock T-CBN & T-DIA BX310	DX140
1QP-EPGW03X102	3.57	1.39	1.9	0.2	1.4	●	
1QP-EPGW03X104				0.4	1.3	●	
1QP-EPGW040102	3.970	1.59	2.3	0.2	1.7	●	
1QP-EPGW040104				0.4	1.6	●	
EPGW040102-DIA	3.970	1.59	2.3	0.2	2.0		●
EPGW040104-DIA				0.4	1.9		●

"DX140" : Packing quantity = 1 pcs.

● : Stocked items.

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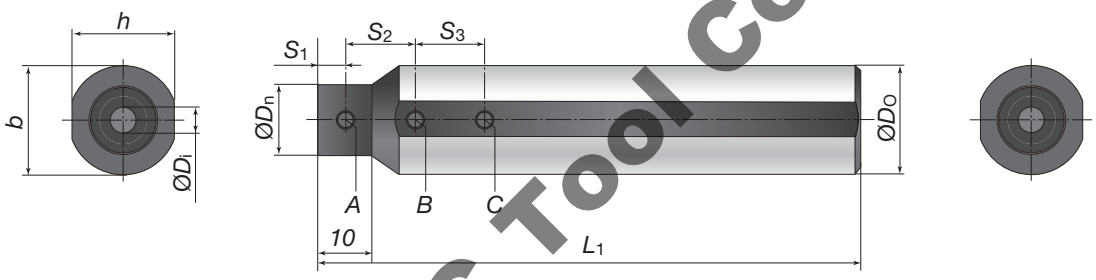
Standard cutting conditions (Internal turning)

Work material	Chip-breaker	Grades	Cutting Speed Vc (m/min)	Depth of cut ap (mm)	Feed: f (mm/rev) rε = 0.03	rε = 0.1	rε = 0.2	rε = 0.4
Steels S45C, SCM435 etc.	W08 J08	SH730	50 - **100** - 150	0.05 - **0.5** - 1.0	0.005 ~ **0.01** ~ 0.02	0.01 ~ **0.03** ~ 0.05	0.02 ~ **0.06** ~ 0.10	0.05 ~ **0.10** ~ 0.15
Stainless steels SUS303, SUS304 etc.	W08	SH730	30 - **100** - 150					
Grey cast irons Ductile cast irons FC250, FCD450 etc.	W08	TH10	30 - **70** - 100					
Aluminium alloys Copper alloys Si < 13%	W08	TH10	100 - **300** - 500					
Titanium Titanium alloys Ti-6Al-4V etc.	W08	SH730	30 - **60** - 100					

Sleeves

BLM type

(Round shank for Stream Jet Bar MINI)



Cat. No.	Stock	øDo	øDi	øDn	L1	h	b	S1	S2	S3	Replacement parts: Clamping screws A	B	C	Wrench	Seal cap* (Inner screw)
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) ● : Stocked items.

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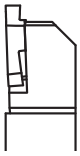
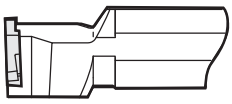
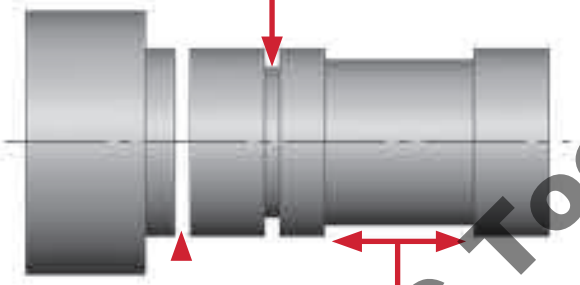
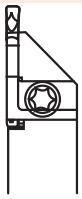
Types and application of TAC Grooving and Parting Tools

For grooving

JSVGR/L (P. 8-49) Shank size 10 ~ 16 mm **Groove with: 0.33 ~ 2.0 mm** **Max. groove depth: 0.7 ~ 5.5 mm**	JSTGR/L (P. 8-50) Shank size 10 ~ 16 mm **Groove with: 0.33 ~ 3.0 mm** **Max. groove depth: 0.7 ~ 2.6 mm**	JS-TGL3 (P. 8-50) Shank dia. ø19.05 ~ ø25.4 mm **Groove with: 0.33 ~ 3.0 mm** **Max. groove depth: 0.7 ~ 2.6 mm**
		



For grooving, parting off and traversing

JCTER/L (P. 8-43) Shank size 10 ~ 20 mm **Groove width: 1.0 ~ 3.0 mm** **Max.parting dia. : ø32 mm**


New

TUNGCUT

For grooving and parting off

JSXGR/L (P. 8-48) Shank size 10 ~ 25 mm **Groove with: 0.7 ~ 2.0 mm** **Max. parting dia: ø9 ~ ø12 mm**	JCGSSR/L (P. 8-52) Shank size 10 ~ 16 mm **Groove width: 2.0 mm** **Max. parting dia: ø20 ~ ø32 mm**	JCCWSR/L (P. 8-53) Shank size 10 ~ 25 mm **Groove width: 2.0 mm** **Max. parting dia: ø20 mm**	JCGWSR/L (P. 8-53) Shank size 10 ~ 16 mm **Groove width: 2.0 mm** **Max. parting dia: ø20 mm**

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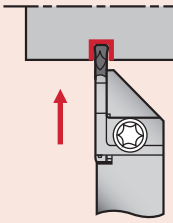
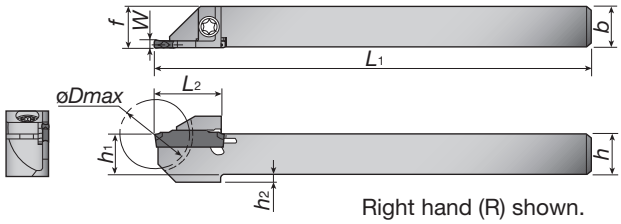
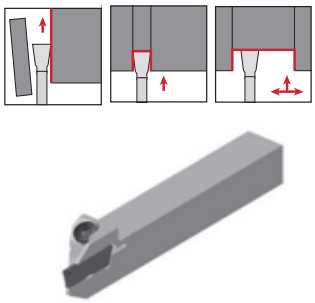
JCTER/L TUNGCUT

Grooving / Parting off





Right hand (R) shown.



Insert seat size	Cat. No.	Stock R	Stock L	Max. dia. øDmax (mm)	Dimensions (mm) h_1	b	h	L_1	*f	W	h_2	L_2	Inserts	Parts Clamping screw	Parts Wrench
1	JCTER/L1010-1.4T10	●	●	20	10	10	10	125	10.2	1.4	-	18	DGS1.4-016 8-45	CSHB-4-A	T-15F
	JCTER/L1212-1.4T12	●	●	24	12	12	12	125	12.2	1.4	-	19.5			
	JCTER/L1414-1.4T12	●	●	24	14	14	14	125	14.2	1.4	-	19.5			
	JCTER/L1616-1.4T16	●	●	32	16	16	16	125	16.2	1.4	-	24			
2	JCTER/L1010-2T10	●	●	20	10	10	10	125	10.1	2	2	19	DGM/SGM DGS/SGS DGE DTE 8-43~45	CSHB-4-A	T-15F
	JCTER/L1212-2T12	●	●	24	12	12	12	125	12.1	2	2	19			
	JCTER/L1414-2T12	●	●	24	14	14	14	125	14.1	2	-	19			
	JCTER/L1616-2T16	●	●	32	16	16	16	125	16.1	2	-	24			
3	JCTER/L1212-3T12	●	●	24	12	12	12	125	12.3	3	-	19		CSHB-4-A	T-15F
	JCTER/L1616-3T16	●	●	32	16	16	16	125	16.3	3	-	24			
	JCTER/L2020-3T16	●	●	32	20	20	20	125	20.3	3	-	24			

* "*f*" value in the above table is calculated with groove width "*W*" shown in the table.

Insert application

Insert	Application: Grooving External	Parting off	Traversing External
DGM / SGM	●	●	
DGS / SGS	●	●	
DTE	●		●
DGE	●		

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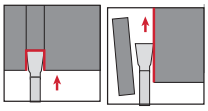
JCTER/L TUNGCUT

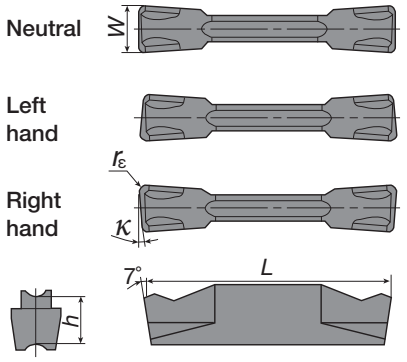
Applicable inserts

● Notation of "insert seat size"

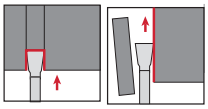
Seat size and grooving width are different. Seat size measure is for the specification of the setting insert. Please note this point.



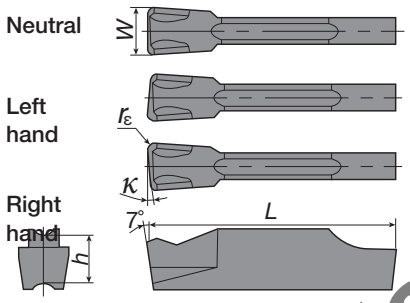
DGM External grooving and parting off, 2 corners



Insert seat size	Cat. No.	Grades Coated AH725 R	AH725 L	GH130 R	GH130 L	Dimensions (mm) W±0.05	rε	L	h	κ
2	DGM 2-020	●		●		2	0.2	20	5	-
	DGM 2-020-6R/L	●	●	●	●	2	0.2	20	5	6°
	DGM 2-020-8R/L	●	●	●	●	2	0.2	20	5	8°
	DGM 2-020-15R/L	●	●	●	●	2	0.2	20	5	15°
	DGM 2-002-15R/L	●	●	●	●	2	0.02	19.6	5	15°
3	DGM 3-020	●		●		3	0.2	20	5	-
	DGM 3-020-6R/L	●	●	●	●	3	0.2	20	5	6°
	DGM 3-002-6R/L	●	●	●	●	3	0.02	19.6	5	6°
	DGM 3-020-15R/L	●	●	●	●	3	0.2	20	5	15°



SGM External deep grooving and parting off, 1 corner



Insert seat size	Cat. No.	Grades Coated AH725 R	AH725 L	GH130 R	GH130 L	Dimensions (mm) W±0.05	rε	L	h	κ
2	SGM 2-020	●		●		2	0.2	20	5	-
	SGM 2-020-6R/L	●	●	●	●	2	0.2	20	5	6°
3	SGM 3-020	●		●		3	0.2	20	5	-
	SGM 3-020-6R/L	●	●	●	●	3	0.2	20	5	6°
	SGM 3-020-15R/L	●	●	●	●	3	0.2	20	5	15°

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● : Stocked items.

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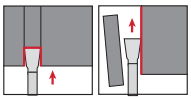
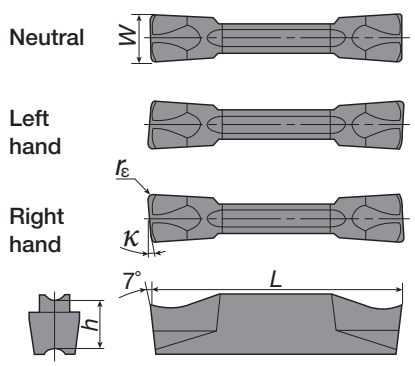
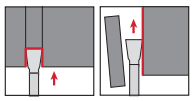
DGS External grooving and parting off, 2 corners

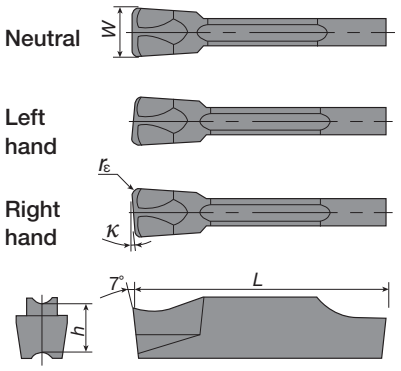




Insert seat size	Cat. No.	Grades Coated AH725 R	AH725 L	GH130 R	GH130 L	Dimensions (mm) W±0.05	rε	L	h	κ
1	DGS1.4-016	●		●		1.4	0.16	16	4.3	-
2	DGS2-020	●		●		2	0.2	20	5	-
	DGS2-020-6R/L	●	●	●	●	2	0.2	20	5	6°
	DGS2-002-6R/L	●	●	●	●	2	0.02	19.6	5	6°
	DGS2-020-15R/L	●	●	●	●	2	0.2	20	5	15°
	DGS2-002-15R/L	●	●	●	●	2	0.02	19.6	5	15°
3	DGS3-020	●		●		3	0.2	20	5	-
	DGS3-020-6R/L	●	●	●	●	3	0.2	20	5	6°
	DGS3-002-6R/L	●	●	●	●	3	0.02	19.6	5	6°
	DGS3-020-15R/L	●	●	●	●	3	0.2	20	5	15°
	DGS3-002-15R/L	●	●	●	●	3	0.02	19.6	5	15°

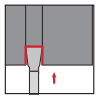
SGS External deep grooving and parting off, 1 corner

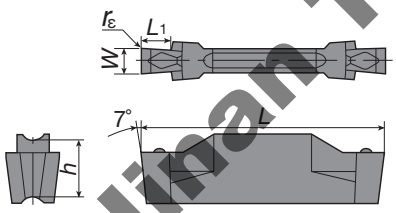




Insert seat size	Cat. No.	Grades Coated AH725 R	AH725 L	GH130 R	GH130 L	Dimensions (mm) W±0.05	rε	L	h	κ
2	SGS 2-020	●		●		2	0.2	20	5	-
	SGS 2-020-6R/L	●	●	●	●	2	0.2	20	5	6°
	SGS 2-020-15R/L	●	●	●	●	2	0.2	20	5	15°
3	SGS 3-020	●		●		3	0.2	20	5	-
	SGS 3-020-6R/L	●	●	●	●	3	0.2	20	5	6°
	SGS 3-002-6R/L	●	●	●	●	3	0.02	19.8	5	6°
	SGS 3-020-15R/L	●	●	●	●	3	0.2	20	5	15°
	SGS 3-002-15R/L	●	●	●	●	3	0.02	19.8	5	15°

DGE External grooving (Ground)





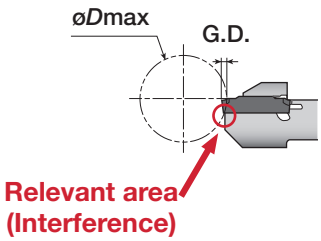
Insert seat size	Cat. No.	Grades Coated AH725	AH130	Dimensions (mm) W±0.02	rε±0.05	L1	L	h
2	DGE100-000	●	●	1	0	2.5	20	5
	DGE130-000	●	●	1.3	0	2.5	20	5
	DGE160-010	●	●	1.6	0.1	2.5	20	5
	DGE185-010	●	●	1.85	0.1	3.5	20	5
	DGE215-015	●	●	2.15	0.15	3.5	20	5

Caution

øDmax is limited as shown in picture in right according to groove depth, G.D. Please refer to the following table.

G.D. = Groove depth

Cat. No.	Max. groove depth	øDmax G.D. = 1	G.D. = 1.5	G.D. = 2	G.D. = 2.5	G.D. = 3
DGE100-000	2	∞	18.6	11.5	-	-
DGE130-000						
DGE160-010						
DGE185-010	3				8.8	7
DGE215-015						



● : Stocked items.

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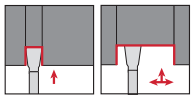
JCTER/L TUNGCUT

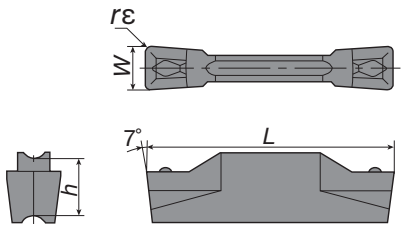
Applicable inserts

● Notation of "insert seat size"

Seat size and grooving width are different. Seat size measure is for the specification of the setting insert. Please note this point.

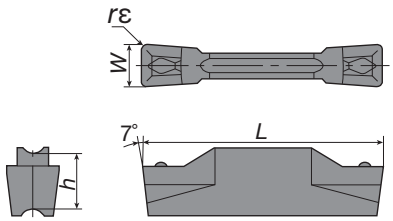


DTE External face grooving and traversing (Ground)



Insert seat size	Cat. No.	Grades Coated			Dimensions (mm)			
		AH725	GH130	NS530	W±0.02	rε±0.05	L	h
3	DTE265-015	●	●	★	2.65	0.15	20	5
	DTE300-020	●	●	★	3	0.2	20	5
	DTE300-040	●	●	★	3	0.4	20	5
	DTE315-015	●	●	★	3.15	0.15	20	5

External face grooving and traversing (Molded)



Insert seat size	Cat. No.	Grades Coated			Dimensions (mm)			
		AH725	GH130	NS530	W±0.05	rε	L	h
3	DTE3-040	●	●	★	3	0.4	20	5

● : Stocked items
★: Available from 2013

Jinan Terry CNC Tool Co.,Ltd

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Standard cutting conditions

Insert type	Application	insert seat size	Groove width *W* (mm)	Feed rate: *f* (mm/rev) Depth of cut: *ap* (mm)	Features
DGM (2 corners) SGM (1 corner)	External grooving & parting off	2	2	*f* = 0.05 ~ 0.2	· Smooth chip evacuation · Well designed edge with high strength · Handed insert available
		3	3	*f* = 0.07 ~ 0.25	
DGS (2 corners) SGS (1 corner)	External grooving & parting off	1	1.4	*f* = 0.02 ~ 0.1	· Sharper edge, and low cutting force · Unique designed edge and chipbreaker · Handed insert available
		2	2	*f* = 0.03 ~ 0.13	
		3	3	*f* = 0.03 ~ 0.17	
DGE (2 corners)	Grooving	2	1	*f* = 0.05 ~ 0.15	· For narrow grooving · Excellent chip control · Ground insert with high accuracy
			1.3	*f* = 0.05 ~ 0.17	
			1.6	*f* = 0.05 ~ 0.18	
			1.85	*f* = 0.05 ~ 0.19	
			2.15	*f* = 0.05 ~ 0.2	
DTE (2 corners)	External traversing & External grooving	3	3 (Grooving)	*f* = 0.05 ~ 0.25	· Unique chipbreaker makes chips shorter · Molded and ground insert available
			3 (Turning)	*f* = 0.1 ~ 0.25 *ap* = 0.5 ~ 2.2	

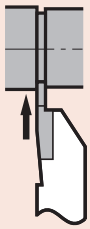
Work materials	Hardness	Cutting speed: *Vc* (m/min)	
		AH725	GH130
Steels S45C, SCM435 etc. C45, 34CrMo4 etc.	< 300 HB	50 ~ 180	40 ~ 150
Stainless steels SUS303, SUS304 etc. X10CrNiS18-9 etc.	< 200 HB	50 ~ 120	50 ~ 120
Grey cast irons, Ductile cast irons FC250, FCD450 etc. GG25, GGG45 etc.	-	-	50 ~ 180
Titanium, Titanium alloys Ti-6Al-4V etc.	< 40 HRC	-	20 ~ 80

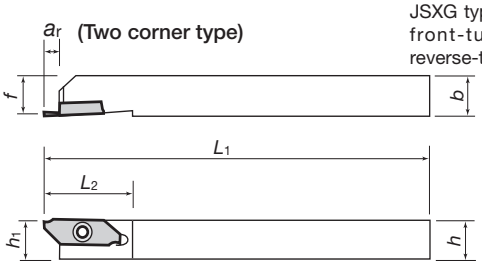
Jinan Terry CNC Tool Co.,Ltd.

JSXGR/L

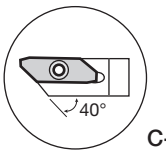
Without offset
Screw-on system

Grooving / Parting off





JSXG type toolholders are also used for front-turning JXF-type inserts and reverse-turning JXR-type inserts.



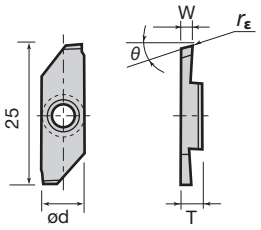
C-type

Can be wrenched from back side with double-socket Torx screw.

Right hand (R) shown.

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

Applicable inserts JXG-type inserts (With sharp edges and cutting direction)



Right hand (R) shown.

Cat. No.	Dimensions (mm) ød	T	$W^{+0.05}_{0}$	θ	Max. groove depth	r_ε	Grades: Coated J740 R	Coated J740 L	Coated cermet J530 R	Coated cermet J530 L	Cermet R	Cermet L	Cermet NS530 R	Cermet NS530 L	Cermet R	Cermet L	Uncoated TH10 R	Uncoated TH10 L
JXGR/L8070FA	8	3.97	0.7	15°	4.5	0	●	●					●	●			●	●
JXGR/L8070FA-005						0.05	●											
JXGR/L8100FA			1		6	0	●	●					●	●			●	●
JXGR/L8100FA-005						0.05	●											
JXGR/L8100FA45					4.5	0	●						●				●	
JXGR/L8100FA45-005						0.05	●											
JXGR/L8120FA			1.2		6	0												
JXGR/L8150FA			1.5			0	●	●					●	●			●	●
JXGR/L8150FA-005						0.05	●											
JXGR/L8150FA50					5	0	●						●				●	
JXGR/L8150FA50-005						0.05	●											
JXGR/L8180FA			1.8		6	0	●						●				●	
JXGR/L8180FA-005						0.05	●											
JXGR/L8200FA			2			0	●	●					●	●			●	●
JXGR/L8200FA-005						0.05	●											
JXGR/L8200FN				0°		0	●	●					●	●			●	●
JXGR/L8200FN-005						0.05	●											

● : Stocked items.

Jinan Terry CNC Tool Co.,Ltd.

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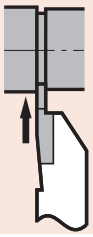
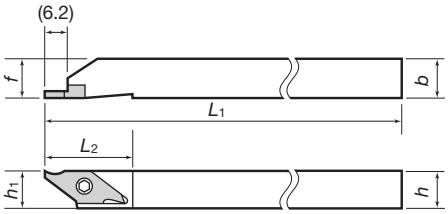
JSVGR/L

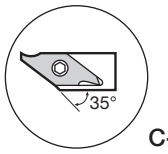
Without offset
Screw-on system

Grooving



(Two corner type)



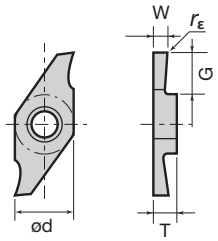


C-type

Right hand (R) shown.

Cat. No.	Stock R	Stock L	Applicable inserts	Dimensions (mm) h	b	L_1	L_2	h_1	f	Clamping screw	Wrench	
JSVGR/L1010K-C	●	●	JVGR/L□□□(F)	10	10	125	23	10	10	CSTB-3S	T-9F	(T-9L) ∗Optional
JSVGR/L1212K-C	●	●		12	12			12	12			
JSVGR/L1616K	●	●		16	16			16	16			

Applicable inserts JVG-type inserts (sharp edges)



Right hand (R) shown.

Cat. No.	Dimensions (mm) ød	T	W +0.05 0	G	Max. groove depth	rε	Grades Coated J740 R	L	Cermet NS530 R	L	R	L	Uncoated TH10 R	L
JVGR/L033F	7.94	3.18	0.33	0.8	0.7	0	●		●				●	
JVGR/L050F			0.5	1.2	1.1		●		●				●	
JVGR/L075F			0.75	2	1.9		●		●				●	
JVGR/L095F			0.95				●		●				●	
JVGR/L100F			1	6	5.5		●		●	●			●	●
JVGR/L125F			1.25	5.5	5		●		●				●	
JVGR/L150F			1.5	6	5.5		●		●	●			●	●
JVGR/L200F			2				●		●				●	

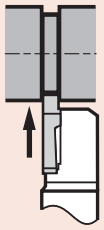
● : Stocked items.

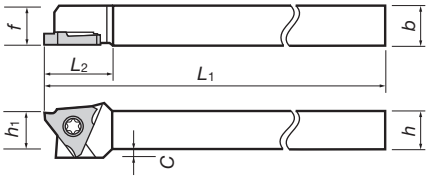
Jinan Terry CNC Tool Co.,Ltd.

JSTGR/L

Without offset
Screw-on system

Grooving





Can be wrenched from back side with double-socket Torx screw.

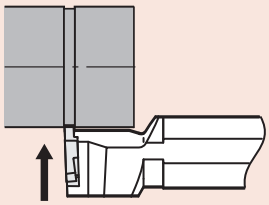
Right hand (R) shown.

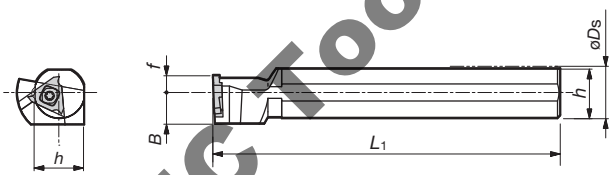
Cat. No.	Stock R	Stock L	Applicable inserts	Dimensions (mm) h	b	L_1	L_2	h_1	f	C	Clamping screw	Wrench	
JSTGR/L1010K3	●	●	JTGR/L3□□□(F) 8-51	10	10	125	18.5	10	10	2	CSTB-4SD	T-8F	(T-8L) ∗Optional
JSTGR/L1212K3	●	●		12	12			12	12	-			
JSTGR/L1616K3	●	●		16	16			16	16				

JS-TGL3

Screw-on system

Grooving





Leht hand (L) shown.

Cat. No.	Stock R	Stock L	Applicable inserts	Dimensions (mm) øDs	f	L_1	L_2	h	B	Clamping screw	Wrench
JS19K-TGL3		●	JTGR3□□□ (F) 8-51	19.05	6	125	-	18	11.5	CSTB-4S	T-15F
JS20K-TGL3		●		20				19			
JS22K-TGL3		●		22				21			
JS25K-TGL3		●		25.4	10			24	12.7		

● : Stocked items.

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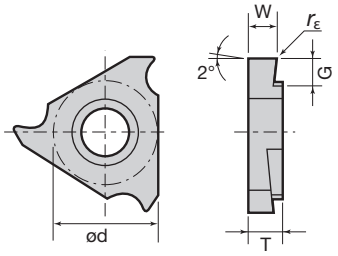
JSTGR/L, JS-TGL3

Without offset
Screw-on system

Applicable inserts

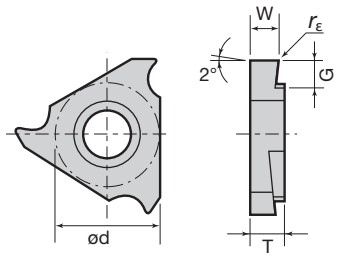
JTG-type inserts (With sharp edges)



Right hand (R) shown.

Cat. No.	Dimensions (mm) ød	T	W$^{+0.05}_{0}$	G	Max. groove depth	r_ε	Grades: Coated J740 R	Coated J740 L	Cermet NS530 R	Cermet NS530 L	Cermet NS530 R	Cermet NS530 L	Uncoated TH10 R	Uncoated TH10 L
JTGR/L3033F	9.525	3.18	0.33	0.8	0.7	0.03	●	●	●	●			●	●
JTGR/L3043F			0.43	1.2	1.1		●							
JTGR/L3050F			0.5				●	●	●	●			●	●
JTGR/L3065F			0.65	2	1.9		●							
JTGR/L3075F			0.75				●	●	●	●			●	●
JTGR/L3080F			0.8				●							
JTGR/L3085F			0.85				●							
JTGR/L3095F			0.95				●	●	●	●			●	●
JTGR/L3100F			1	2.2	2.1	0.05	●	●	●	●			●	●
JTGR/L3110F			1.1				●							
JTGR/L3120F			1.2				●							
JTGR/L3125F			1.25				●	●	●	●			●	●
JTGR/L3130F			1.3				●							
JTGR/L3140F			1.4				●							
JTGR/L3145F			1.45				●	●	●	●			●	●
JTGR/L3150F			1.5				●	●	●	●			●	●
JTGR/L3175F			1.75				●	●	●	●			●	●
JTGR/L3180F			1.8				●							
JTGR/L3200F			2	2.7	2.6		●	●	●	●			●	●
JTGR/L3225F			2.25				●							
JTGR/L3250F			2.5				●	●	●	●			●	●
JTGR/L3275F			2.75				●							
JTGR/L3300F			3				●							

JTG-type inserts (With honed edges)



Right hand (R) shown.

Cat. No.	Dimensions (mm) ød	T	W$^{+0.05}_{0}$	G	Max. groove depth	r_ε	Grades: Coated J740 R	Coated J740 L	Coated cermet J530 R	Coated cermet J530 L	Cermet NS530 R	Cermet NS530 L	Cermet NS530 R	Cermet NS530 L	Uncoated TH10 R	Uncoated TH10 L
JTGR/L3033	9.525	3.18	0.33	0.8	0.7	0.03										
JTGR/L3050			0.5	1.2	1.1											
JTGR/L3075			0.75	2.0	1.9											
JTGR/L3095			0.95													
JTGR/L3100			1	2.2	2.1	0.05			●	●						
JTGR/L3125			1.25						●	●						
JTGR/L3145			1.45						●	●						
JTGR/L3150			1.5						●	●						
JTGR/L3175			1.75						●	●						
JTGR/L3200			2	2.7	2.6				●	●						
JTGR/L3250			2.5						●	●						

Standard cutting conditions

Grade	Work materials	Cutting speed: v_C (m/min)	Feed: f (mm/rev)
J740	General steels Stainless steels Free-cutting steels	10-50-100	0.01-0.05-0.1
NS530 J530	General steels Stainless steels	50-80-150	0.01-0.05-0.1
TH10	Aluminium alloys, Brass, etc.	10-80-200	0.01-0.05-0.1
	Difficult-to-cut materials, Titanium alloys, etc.	10-20-30	0.01-0.05-0.1

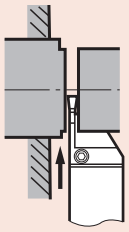
● : Stocked items.

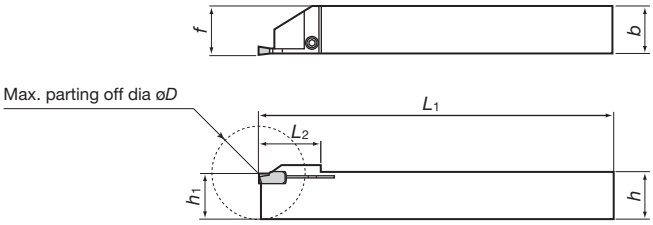
Jinan Terry CNC Tool Co.,Ltd.

JCGSSR/L

Without offset
Screw-on system

Parting off

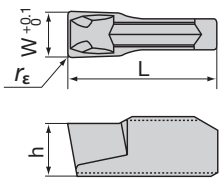




Right hand (R) shown.

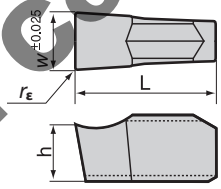
Groove width (mm)	Cat. No.	Stock R	Stock L	Applicable inserts	Max. parting off dia øD (mm)	Dimensions (mm) b	h	h1	L1	f	L2	Clamping screw	Wrench
2	JCGSSR/L1010-20	●	●	GE20 GE20-AL	20	10	10	10	125	10.2	15	CSTB-3	T-9F
	JCGSSR/L1212-20	●	●		25	12	12	12		12.2	19		
	JCGSSR/L1616-20	●	●		32	16	16	16		16.2	22.5		

Applicable inserts



Cat. No.	Grades Coated T9125	Coated GH730	Cermet NS730	Cermet NS530	Dimensions (mm) W	L	h	rε
GE20	●	●	●	●	2	10	3.5	0.2

For aluminium and non-ferrous metals



Cat. No.	Grade Uncoated KS05F	Dimensions (mm) W	L	h	rε
GE20-AL	●	2	10	3.5	0.2

● : Stocked items.

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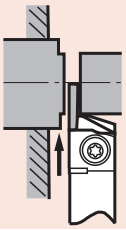
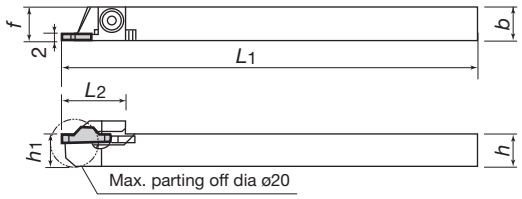
JCCWSR/L

Without offset
Clamp-on system

Parting off



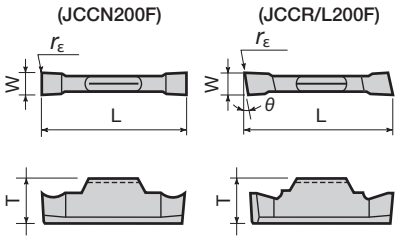
(Two corner type)



Right hand (R) shown.

Cat. No.	Stock R	Stock L	Applicable inserts	Dimensions (mm) h	b	L_1	L_2	h_1	f	Max. parting off dia	Clamping screw	Wrench	
JCCWSR/L1010K2	●	●	JCC□200F	10	10	125	19	10	10	ø20	CSTB-4S	T-15F	(T-15L)
JCCWSR/L1212K2	●	●		12	12			12	12				
JCCWSR/L1616K2	●	●		16	16			16	16				
JCCWSR/L2020K2	●	●		20	20			20	20				
JCCWSR/L2525K2	●	●		25	25			25	25				∗ Optional

Applicable inserts JCC-type inserts (With sharp edges)



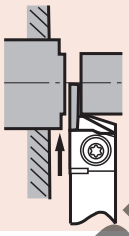
Right hand (R) shown.

Cat. No.	Dimensions (mm) T	W	L	rε	θ	Grades Coated J740 R	L	Coated J530 R	L	Coated Cermet R	L	Cermet NS530 R	L	Cermet R	L	Uncoated TH10 R	L
JCCN200F	4.8	2	15	0	-	●		●								●	
JCCN200F-005				0.05		●											
JCCR/L200F				0	15°	●	●	●	●							●	●
JCCR/L200F-005				0.05		●	●										

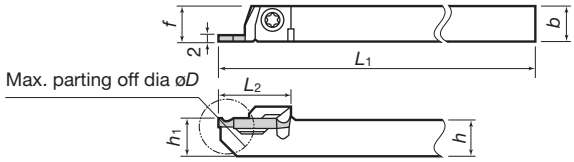
JCGWSR/L

Without offset
Clamp-on system

Parting off



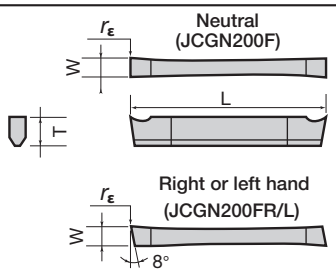
(Two corner type)



Right hand (R) shown.

Cat. No.	Stock R	Stock L	Applicable inserts	Dimensions (mm) h	b	L_1	L_2	h_1	f	Max. parting off dia øD	Clamping screw	Wrench	
JCGWSR/L1010K2	●	●	JCGN200□	10	10	125	20	10	10	ø20	CSTB-4S	T-15F	(T-15L)
JCGWSR/L1212K2	●	●		12	12			12	12				
JCGWSR/L1616K2	●	●		16	16			16	16				∗Optional

Applicable inserts JCG-type inserts (With sharp edges)



Right hand (R) shown.

Cat. No.	Dimensions (mm) T	W	L	rε	Grades Coated J740 R	L	Coated J530 R	L	Coated Cermet R	L	Cermet NS530 R	L	Cermet R	L	Uncoated TH10 R	L
JCGN200F	3	2	20	0.05	●		●								●	
JCGN200FR/L					●	●	●	●							●	●

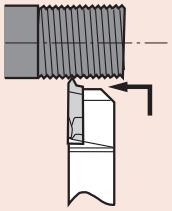
● : Stocked items.

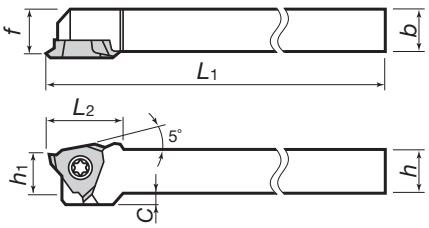
Jinan Terry CNC Tool Co.,Ltd.

JSTTR/L

Without offset
Screw-on system

External threading





Can be wrenched from back side with both-end Torx screw.

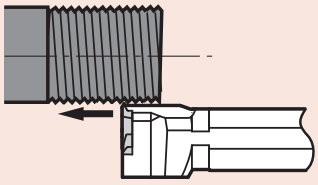
Right hand (R) shown.

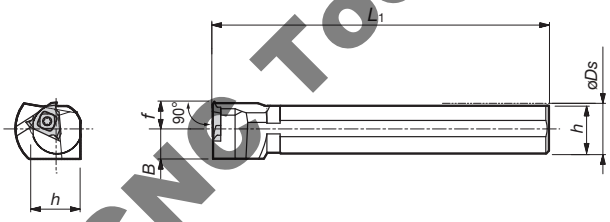
Cat. No.	Stock R	Stock L	Dimensions (mm) h	b	L_1	L_2	h_1	f	C	Applicable inserts	Clamping screw	Wrench	
JSTTR/L1010K3	●		10	10	125	16.5	10	9.5	2	JTTR/L3□□□□	CSTB-4SD	T-8F	(T-8L) ∗Optional
JSTTR/L1212K3	●		12	12			12	11.5	-				
JSTTR/L1616K3	●		16	16			16	15.5					

JS-TTL3

Screw-on system

External threading

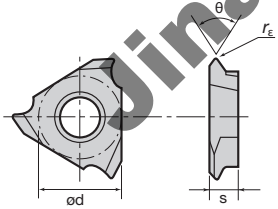




Left hand (L) shown.

Cat. No.	Stock R	Stock L	Dimensions (mm) øDs	f	L_1	L_2	h	B	Applicable inserts	Clamping screw	Wrench
JS19K-TTL3		●	19.05	10	125	-	18	11.5	JTTR30□□F	CSTB-4S	T-15F
JS20K-TTL3		●	20				19				
JS22K-TTL3		●	22				21				
JS25K-TTL3		●	25.4				24	12.7			

JTT-type inserts (sharp edge)



Right hand (R) shown.

Cat. No.	Dimensions (mm) θ	ød	T	rε	Grades: Coated J740 R	L	Coated Cermet J530 R	L	R	L	Cermet NS530 R	L	R	L	Uncoated TH10 R	L
JTTR/L3005F-55	55°	9.525	3.18	0.05	●											
JTTR/L3005F	60°				●						●				●	
JTTR/L3010F				0.1	●						●				●	

Notes: Left hand holder use right hand insert.
Machinable pitch range: 0.5 to 1 mm.

● : Stocked items.

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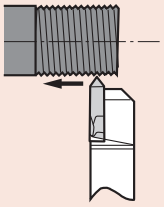
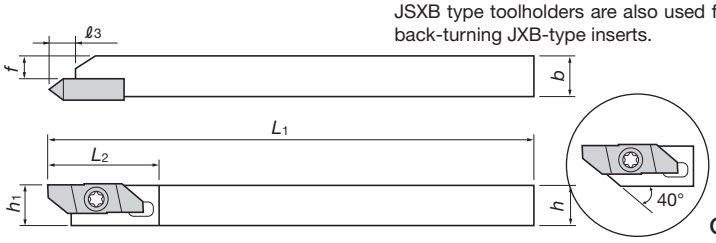
JSXBR/L

Screw-on system

External threading



JSXB type toolholders are also used for back-turning JXB-type inserts.



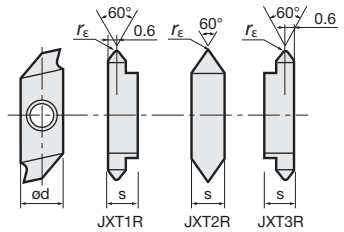
C-type

- Can be wrenched from back side with both-end Torx screw.
- This toolholder is also compatible with JSXB-type insert for back turning.

Right hand (R) shown

Cat. No.	Stock R	Stock L	h	b	L_1	L_2	ℓ_3	h_1	f	Applicable inserts	Clamping screw	Wrench	
JSXBR/L1010K8-C	●	●	10	10	125	29	6.4	10	5.7	JXT□R/L□□□□□	CSTB-4SD	T-8F	(T-8L) ∗Optional
JSXBR/L1212K8-C	●	●	12	12				12	7.7				
JSXBR/L1616K8	●	●	16	16				16	11.7				
JSXBR/L2020K8	●	●	20	20				20	15.7				
JSXBR/L2525K8	●	●	25	25				25	20.7				

JXT-type inserts (sharp edge)



Right hand (R) shown.

Cat. No.	Dimensions (mm) θ	ød	s	rε	Grades: Coated J740 R	Coated J740 L	Cermet NS530 R	Cermet NS530 L	Cermet R	Cermet L	Uncoated TH10 R	Uncoated TH10 L
JXT1R/L6000F	60°	8	3.97	0.03	●		●				●	
JXT2R/L6000F					●		●				●	
JXT3R/L6000F												

Notes: Right hand holder use right hand insert and left hand holder use left hand insert.
Machinable pitch range: 0.5 to 1 mm.

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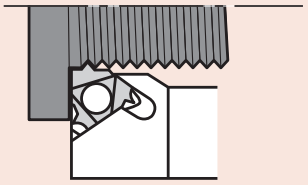
● : Stocked items.

TAC Toolholders for External threading

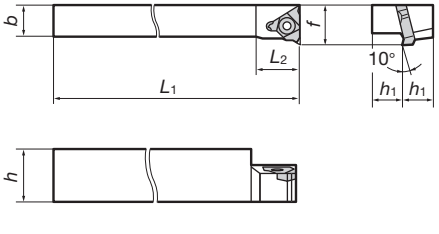
B-SER/L, B-CER/L TUNGTHREAD

Screw-on system, clamp-on system

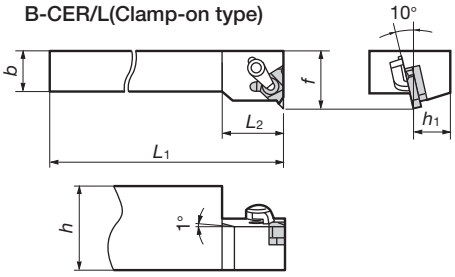
External threading



B-SER/L(Screw-on type)



B-CER/L(Clamp-on type)



Right hand (R) shown

B-type Toolholders (For gang tooling)

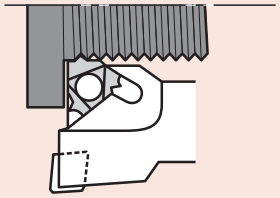
Cat. No.	Stock R	Stock L	Dimensions (mm) h	b	L_1	L_2	h_1	f	f_1	Applicable inserts	Clamp set	Shim set R	Shim set L	Clamping screw	Wrench
B-SER/L10H16	●		20	10	100	15	10	16	-	16ER/L□□□□ 7-7~	-	-	-	CSTB-3.5	T-15F
B-SER/L12K16	●		24	12	125	18	12	18	-						
B-CER/L16M16	●	●	32	16	150	24	16	22	-		CSP16	A16-1		-	

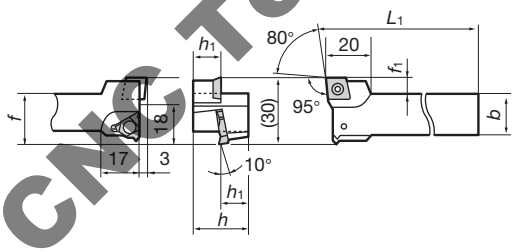
TAC Toolholders for External threading

BC-SER/L TUNGTHREAD

Screw-on system

External threading



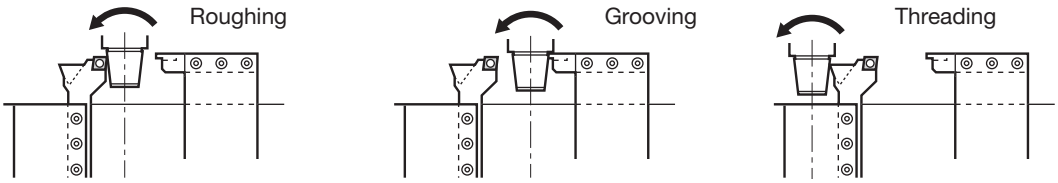


Right hand (R) shown

BC-type Toolholders (Screw-on type, for gang tooling)

Cat. No.	Stock R	Stock L	Dimensions (mm) h	b	L_1	L_2	h_1	f	f_1	Applicable inserts	Clamp set	Shim set R	Shim set L	Clamping screw	Wrench
BC-SER/L12K16	●		24	16	125	-	12	23	7	16ER/L□□□□ 7-7~ CC□T09T3□□ 2-96~ (Used for before threading)	-	-	-	CSTB-3.5	T-15F
BC-SER/L16M16			32	20	150	-	16	25	5						

● Tooling examples using BC-type toolholders



● : Stocked items.

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MEMO

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