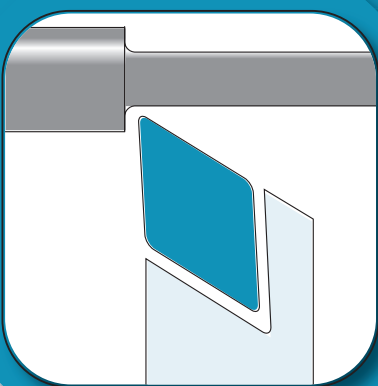
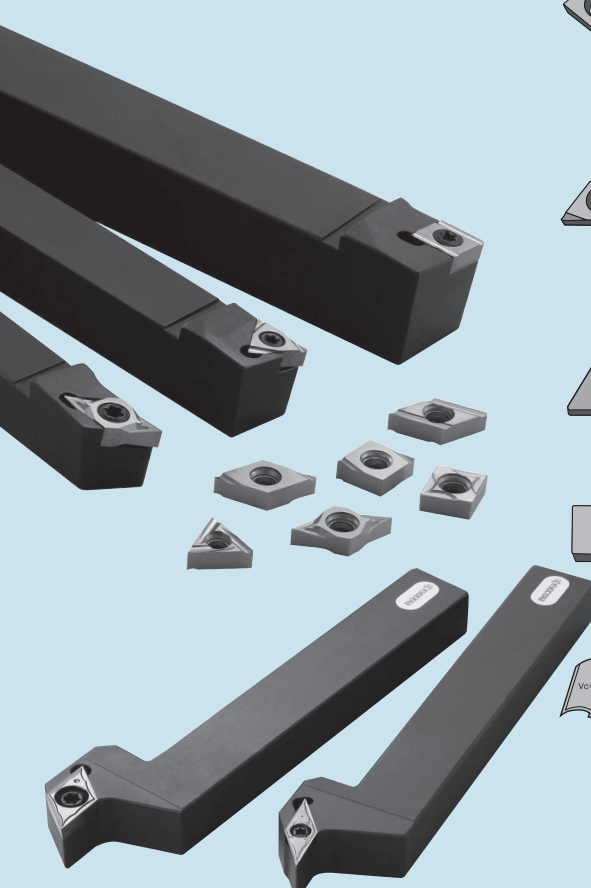


# Small Parts Machining (External)

**E1~E50**



# E



## Summary of External Turning E2~E10

## Small Parts Machining Identification System E11



## Toolholders for Back Turning E12~E19

<b>TKFB Insert</b>	(Back Turning, Goose-neck Holder)	<b>E12</b>
<b>TKF-AS Insert</b>	(Back Turning, Goose-neck Holder)	<b>E16</b>
<b>ABS Insert</b>	(Back Turning)	<b>E17</b>
<b>ABW Insert</b>	(Back Turning)	<b>E18</b>



## Goose-neck Holder E20~E21

<b>DC□□ Insert</b>	(Goose-neck Holder)	<b>E20</b>
<b>VP□□ Insert</b>	(Goose-neck Holder)	<b>E21</b>



## Toolholders for External Turning (Back Clamp / Screw Clamp) E22~E36

<b>CC□□ Insert</b>	(Without Offset, For High Pressure Coolant / With Offset)	<b>E22</b>
<b>DC□□ Insert</b>	(Without Offset, For High Pressure Coolant / With Offset)	<b>E24</b>
<b>DP□□ Insert</b>	(Without Offset)	<b>E28</b>
<b>TC / TP□□ Insert</b>		<b>E29</b>
<b>VB□□ Insert</b>	(Without Offset, For High Pressure Coolant / With Offset)	<b>E30</b>
<b>VC□□ Insert</b>	(Without Offset)	<b>E33</b>
<b>VP□□ Insert</b>	(Without Offset, For High Pressure Coolant / With Offset)	<b>E35</b>



## External Sleeve Holder E37~E39

<b>CC□□ Insert</b>		<b>E37</b>
<b>DC□□ Insert</b>		<b>E38</b>
<b>VB / VC□□ Insert</b>		<b>E39</b>



## Toolholders for Small Double Sided Tooling (Screw Clamp) E40~E41

<b>CN□U Insert</b>	(Without Offset)	<b>E40</b>
<b>DN□U Insert</b>	(Without Offset)	<b>E40</b>
<b>TN□U Insert</b>	(Without Offset)	<b>E41</b>



## Toolholder for Double Sided Tooling for Automatic Lathe (Lever Lock) E42~E43

<b>CN□□ Insert</b>	(Without Offset)	<b>E42</b>
<b>TN□□ Insert</b>	(Without Offset)	<b>E43</b>



## External Toolholder (Top Clamp) E44~E45

<b>SP□R / SP□N Insert</b>		<b>E44</b>
<b>TP□R / TP□N Insert</b>		<b>E45</b>



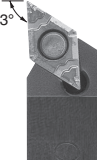






## Technical Information E46~E47

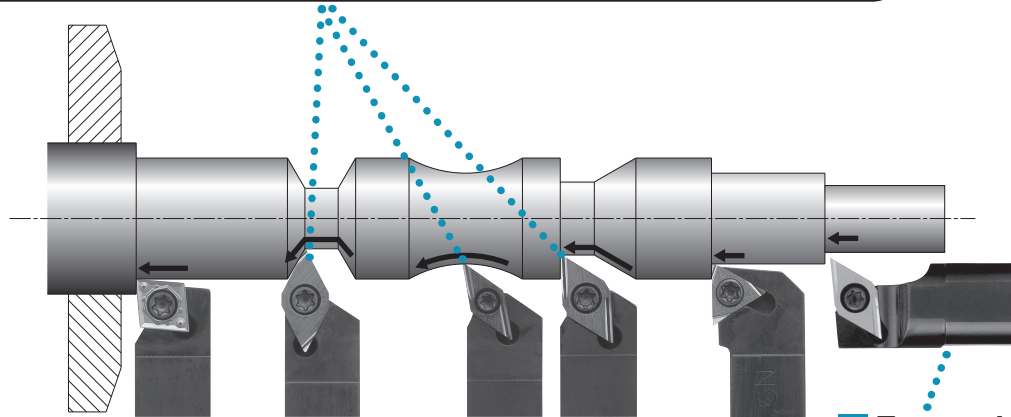
## Recommended Cutting Conditions E46

## Alternative Toolholder Reference Table for Small Parts Machining E48~E50





# Summary of External Turning

## External / Copying

						
ADJC-FF	SDJC-FF(JCT)	SDJC	SDLC-FF SDLP-FF	SDLN-FF	SDNC-F	SDNC
Back Clamp Without Offset	Screw Clamp Without Offset	Screw Clamp	Screw Clamp Without Offset	Screw Clamp Without Offset	Screw Clamp	Screw Clamp
➡ E24	➡ E24, E25	➡ E25	➡ E26, E28	➡ E40	➡ E27	➡ E27



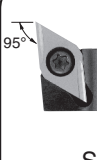
## External / Facing

			
ACL-FF	SCLC-FF(JCT)	SCLC	SCLN-FF
Back Clamp Without Offset	Screw Clamp Without Offset	Screw Clamp	Screw Clamp Without Offset
➡ E22	➡ E22, E23	➡ E23	➡ E40

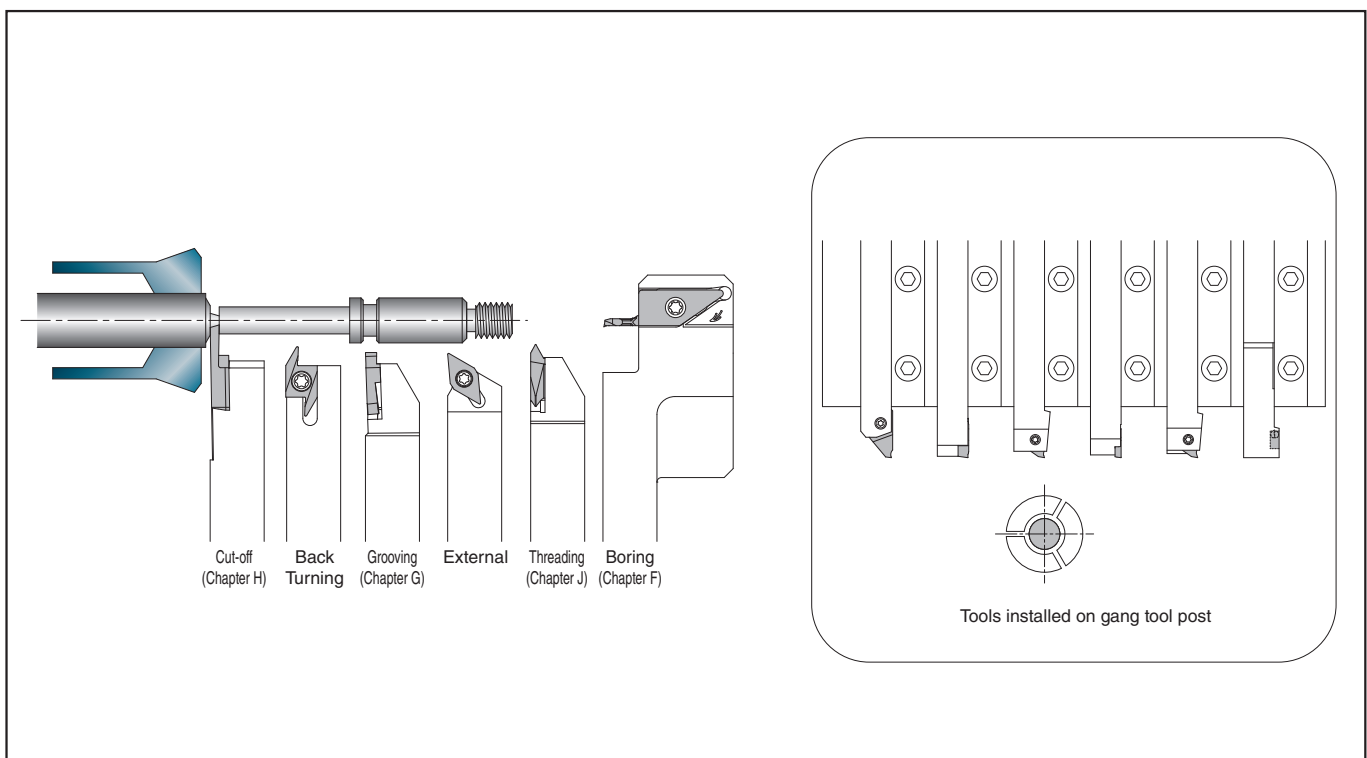
## External

	
STGC(P)	STLN-FF
Screw Clamp	Screw Clamp Without Offset
➡ E29	➡ E41

## External Sleeve Holder

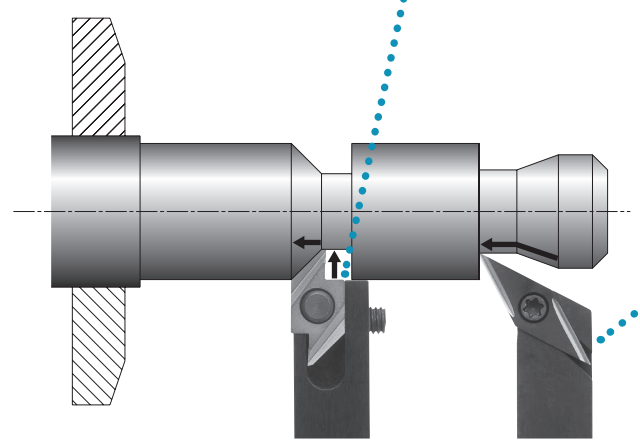

S-SDLC
Screw Clamp Shank Dia. ø12-ø25.4
➡ E38

## Tooling example (1) CNC Automatic lathe (Gang Type)



## Back Turning

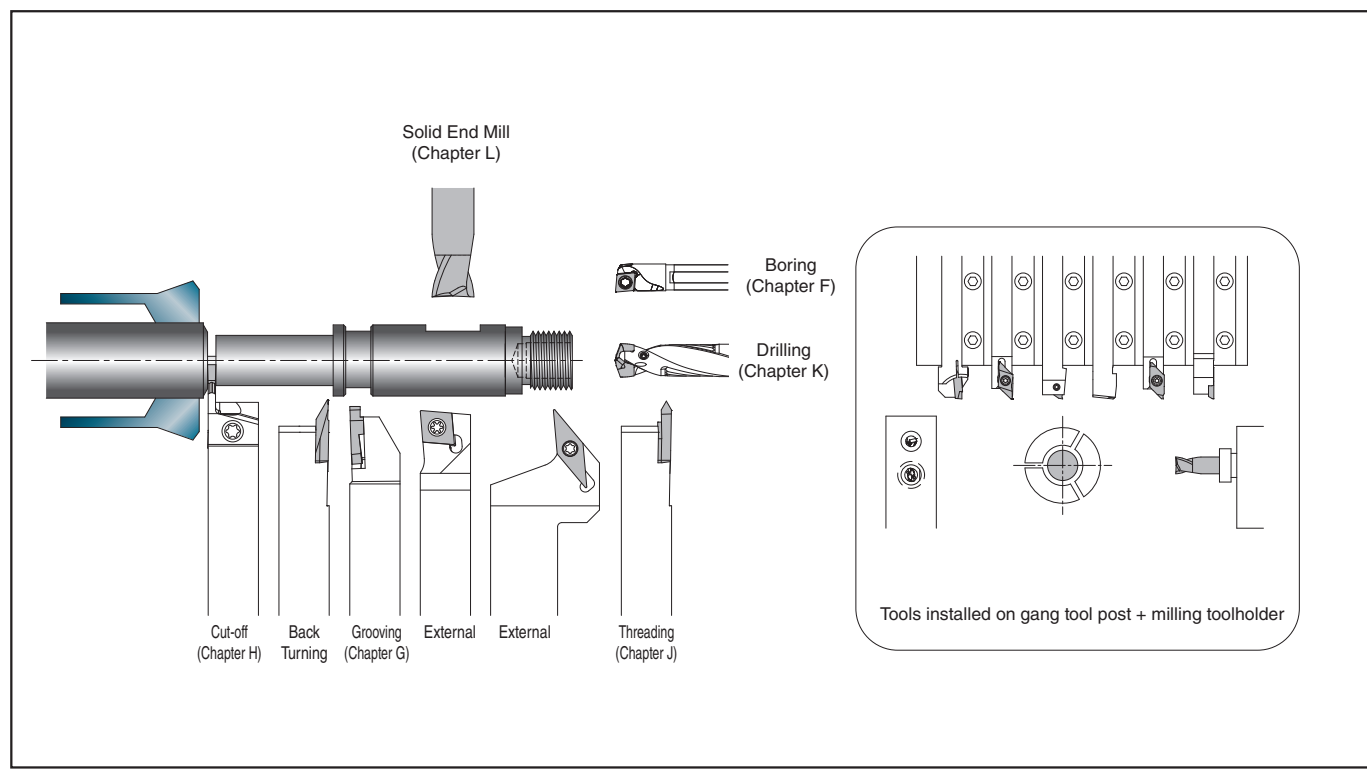
<b>AABS-40F</b>	<b>SABS-40F</b>	<b>AABW-40F</b>	<b>SABW-40F</b>	<b>AABW-50F</b>	<b>SABW-50F</b>	<b>KTKF</b>
Back Clamp Edge Width : 2.8 ap : ~4.0	Screw Clamp Edge Width : 2.8 ap : ~4.0	Back Clamp Edge Width : 4.7 ap : ~4.0	Screw Clamp Edge Width : 4.7 ap : ~4.0	Back Clamp Edge Width : 4.7 ap : ~5.0	Screw Clamp Edge Width : 4.7 ap : ~5.0	Screw Clamp Edge Width : 1.5~3.8 Max. ap : 1.8~5.5



## External / Facing / Copying / Undercutting

<b>SVPB</b> Screw Clamp	<b>SVPP-FF</b> Screw Clamp Without Offset

## Tooling example (2) CNC Automatic lathe (Gang Type)



# Summary of External Turning

For Swiss tool automatic lathe (Gang type tool post)

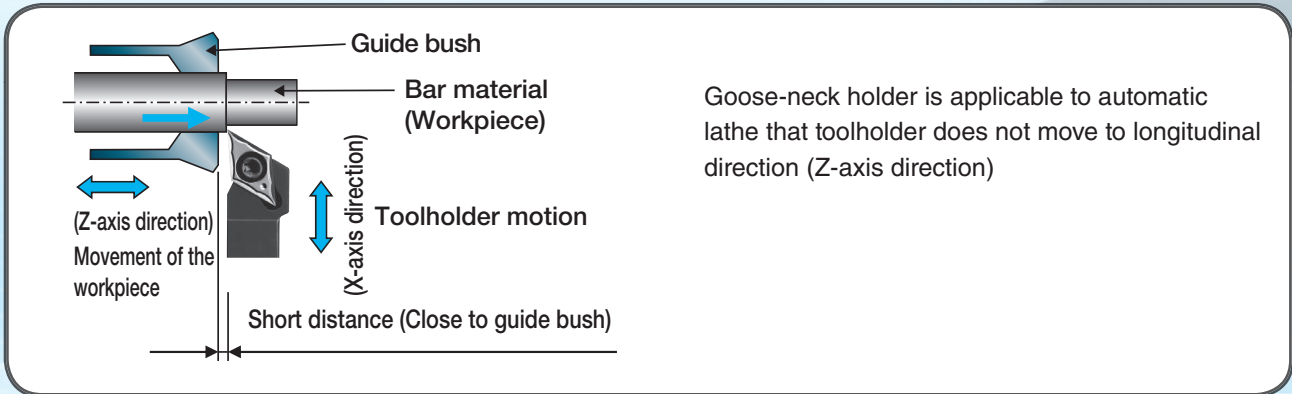
## How to use Goose-neck Holder



### Swiss tool automatic lathe (Guide bush system)

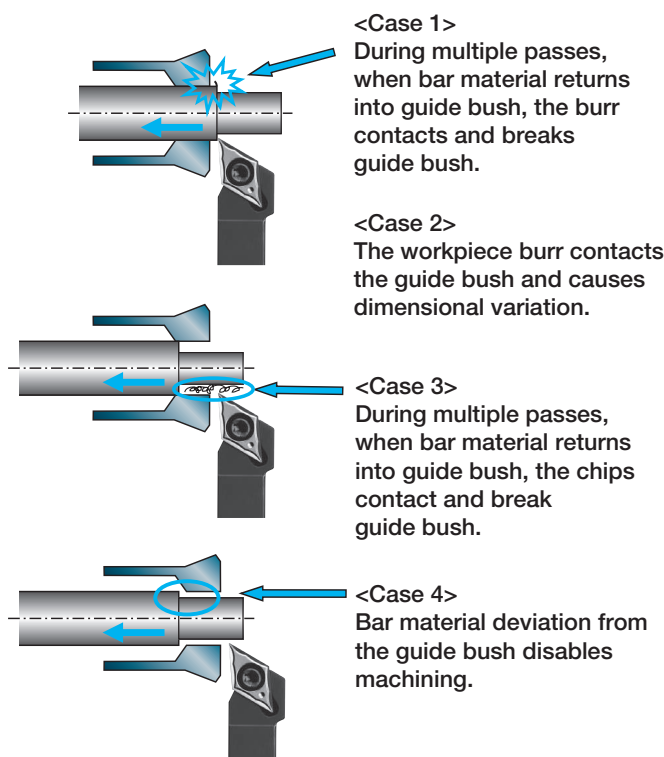
Goose-neck holder is applicable to automatic lathes whose toolholder does not move to longitudinal direction (Z-axis direction)

#### In case of machining with the conventional toolholder



#### Problems of machining with the conventional toolholder

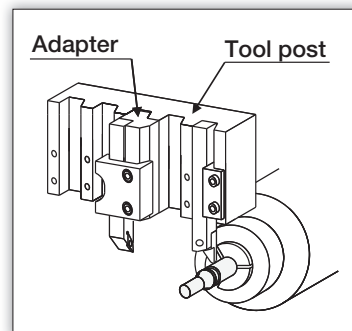
##### Problems of machining with the conventional toolholder



##### Problems of Toolholder Installation

When using a conventional toolholder,

- 1) Additional space is required for an adapter.
- 2) Toolholder's handling is difficult due to limited space.
- 3) Necessary to buy an adapter.
- 4) An adapter may interfere with the next tool post.



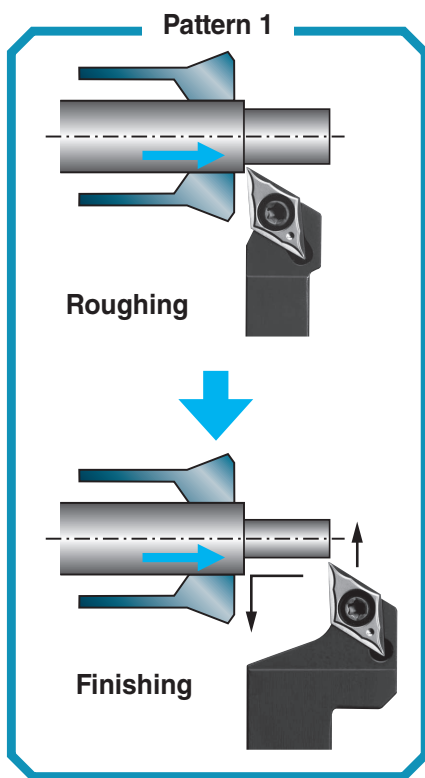
## Advantages of Goose-neck Holder

### Advantages of Using Goose-neck Holder

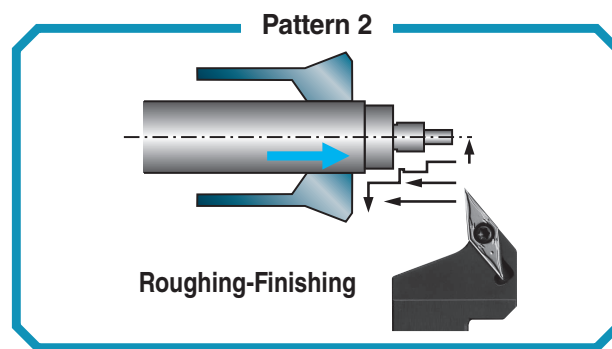
#### When using Goose-neck Holder

- 1) Machining precision improves by additional finishing process
- 2) Chips do not come into the guide bush
- 3) Better chip control due to large chip evacuation space

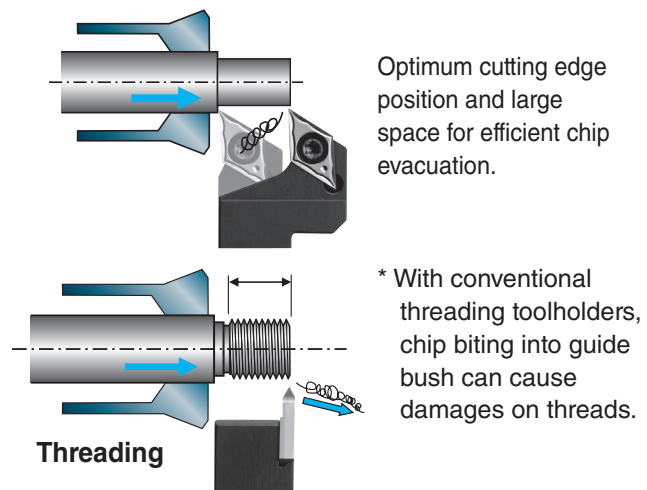
Available for machining after roughing without returning bar material into guide bush, preventing damages and improving precision.



Available for roughing and finishing with one Goose-neck Holder.



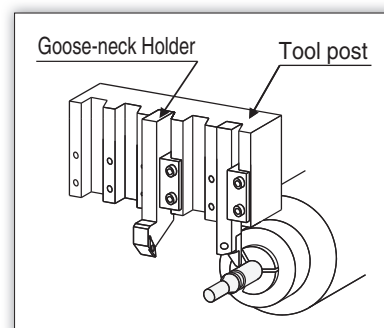
#### For better chip control



### Advantages of Toolholder Installation

When using a Goose-neck Holder

- 1) Maximum number of toolholders can be attached
- 2) No interference with next tool post



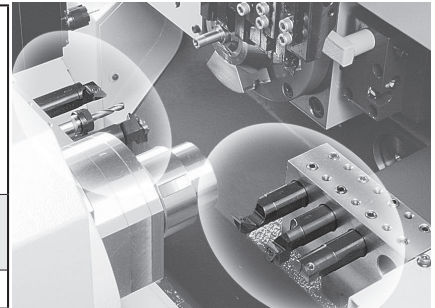
# Summary of External Turning

## External Sleeve Holder

More tools attachable to CNC Automatic Lathe !

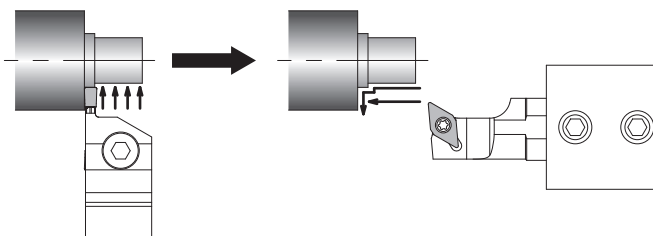
Limit to attachable tools at intricate part machining ▶▶▶ Use External Sleeve Holders

S-SCLC	S-SDUC	S-SDLC	S-SVUB(C)
Screw Clamp Shank Dia. $\phi 12\sim\phi 25.4$	Screw Clamp Shank Dia. $\phi 14\sim\phi 25.4$	Screw Clamp Shank Dia. $\phi 12\sim\phi 25.4$	Screw Clamp Shank Dia. $\phi 12\sim\phi 25.4$



For Tooling Layout and Automatic Lathe List by Manufacturer, See Page

### ● Finishing by Sleeve Holder



- 1) Roughing by grooving toolholder
- 2) Finishing by Sleeve Holder improves chip control and reduces cutting time

### Tooling Example (3) CNC Automatic lathe (Opposed Gang Type)

**External / Facing**

**External / Copying**

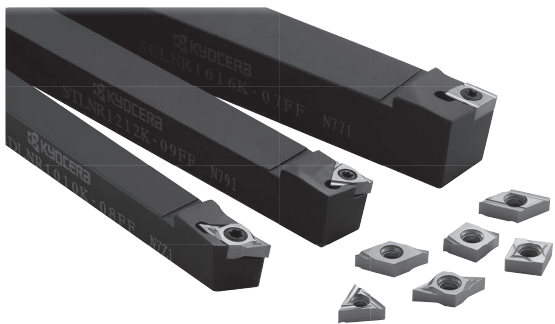
**Grooving**

**Threading**

**Boring**

For Tooling Layout and Automatic Lathe List by Manufacturer, See Page

## Toolholders for Small Double Sided Tooling (Screw Clamp)



Applications	External / Facing	External / Up Facing	External / Copying
Cutting Edge Angle	95°	95°	95°
Screw Clamp (Without Offset)			
See Page	<a href="#">E40</a>	<a href="#">E41</a>	<a href="#">E40</a>

Newly designed negative inserts (double-sided) enable high productivity and stability by economical doubled insert edge numbers  
 Sharp cutting equivalent to positive inserts (single-sided)

## Toolholder for Double Sided Tooling for Automatic Lathe (Lever Lock, Without Offset)



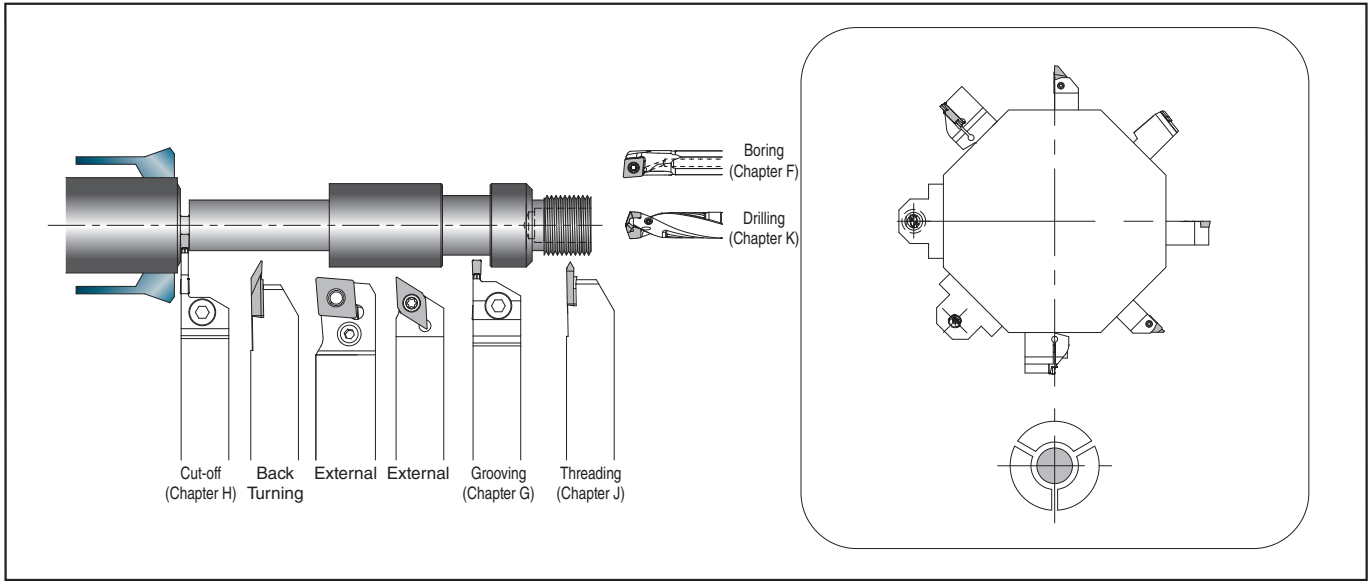
Applications	External / Facing	External / Up Facing
Cutting Edge Angle	95°	95°
Lever Lock (Without Offset)		
See Page	<a href="#">E42</a>	<a href="#">E43</a>

The lever lock type is available for small parts machining for external machining

## Top Clamp (for Insert without Hole)

Applications	External / Chamfering		External / Facing / Chamfering	External		Facing	
Cutting Edge Angle	45°	60°	45°	75°	91°	15°	-1°
Top Clamp							
See Page	<a href="#">E44</a>	<a href="#">E45</a>	<a href="#">E44</a>	<a href="#">E44</a>	<a href="#">E45</a>	<a href="#">E44</a>	<a href="#">E45</a>

## Tooling Example (4)

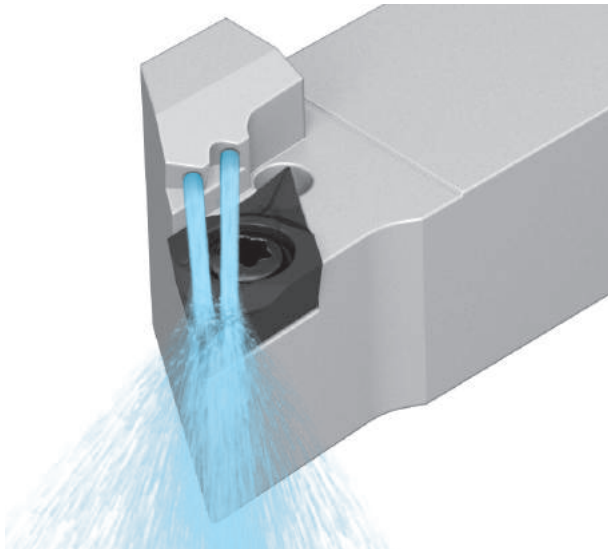


# Screw Clamp JCT

Double-coolant hole design delivers an ample supply of coolant to the tool edge  
Excellent Chip Control and Long Tool Life

## 1 Excellent Chip Control

Double coolant hole design provides coolant to the insert cutting edge surface

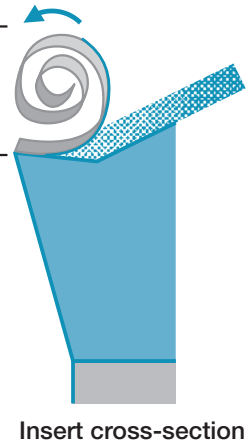


## 2 Sufficient cooling of the cutting edge leads to longer tool life

### Double Coolant Holes

Stable chip curls  
Excellent chip control

The cutting edge stays cool  
Long tool life



### Coolant System Comparison (Internal evaluation)

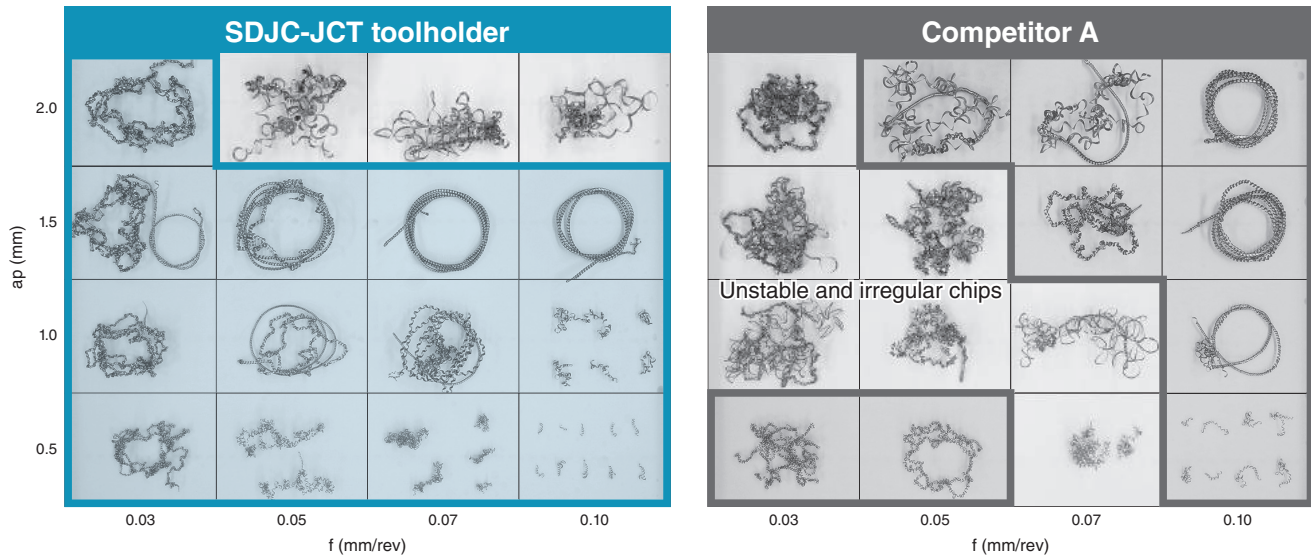
(Example Images)

	Screw Clamp JCT	Competitor A
Coolant System	<p>Coolant discharges towards the chips</p> <p>Chip evacuation direction</p>	<p>Discharges coolant down onto the chip forcing the chip into the part</p> <p>Chip evacuation direction</p>
Chip Control Performance	<p>✓ Stable chip curls</p>	<p>△ Chip becomes unstable</p>
Coolant Effects	<p>✓ The cutting edge stays cool</p>	<p>△ Chip can cause interference with the workpiece</p>



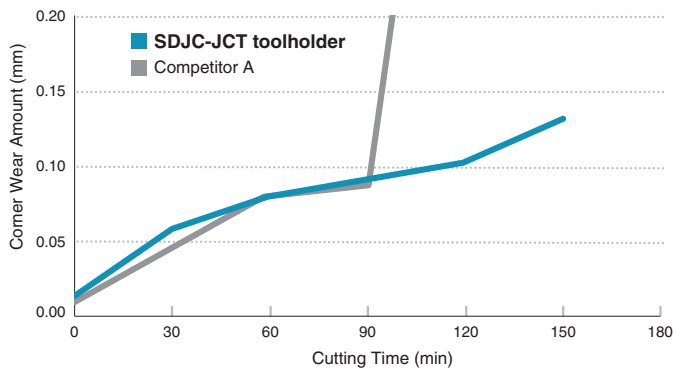
Toolholder with Coolant Holes Chip Control Comparison (Internal evaluation)

SDJC-JCT toolholder allows excellent chip control in a wide variety of cutting conditions



Cutting Conditions : Vc = 80 m/min, DCGT11T302MP-CK PR1535 (Same inserts were used) Workpiece Material : TAB6400 (Ti-6Al-4V) External coolant + Internal coolant (1.5MPa) External

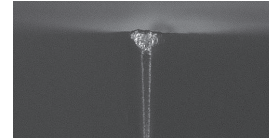
Toolholder with Coolant Holes Wear Resistance Comparison (Internal evaluation)



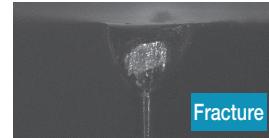
Cutting Conditions : Vc = 200 m/min, External : ap = 2.0 mm, f = 0.05 mm/rev, Facing : ap = 0.2 mm, f = 0.03 mm/rev DCGT11T302MFP-GQ PR1535 (Same inserts were used) Workpiece Material : SUS304 External coolant + Internal coolant (1.5MPa) External / Facing

Cutting edge condition

SDJC-JCT toolholder (after machining 150min)



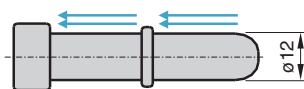
Competitor A (after machining 105min)



Case Studies

Pipe SUS304

Vc = 160 m/min  
ap = 0.9 / 1.2 mm  
f = 0.18 mm/rev  
Wet (Internal Coolant : 14MPa)  
DCMT11T304 type



Chip Control

**SDJC-JCT toolholder**  
(Internal coolant)



Competitor B  
(Internal coolant)

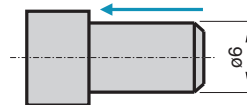


Changes to SDJC-JCT improved chip control and tool life.

(User Evaluation)

Pin SKS93

Vc = 180 m/min  
ap = 1.4 mm  
f = 0.13 mm/rev  
Wet  
DCMT11T304 type



Chip Control

**SDJC-JCT toolholder**  
(Internal Coolant : 2.5MPa)



Conventional toolholder  
(External coolant)



SDJC-JCT toolholder with internal coolant improved chip control.  
Reduced chip entanglement.

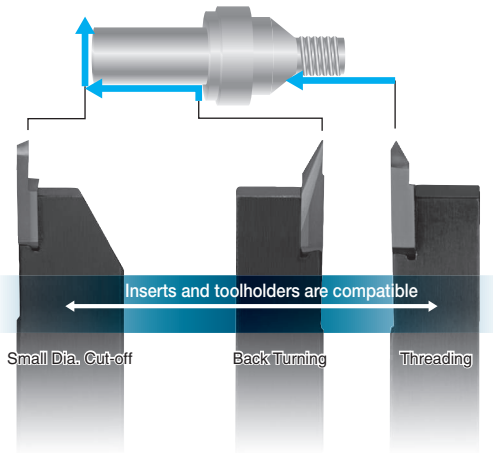
(User Evaluation)

# Summary of External Turning

Cutting tool for small workpiece

## KTKF

See Page E12



Inserts for back turning

## TKFB

See Page E12

- Molded Chipbreaker (GQ Chipbreaker)  
Added to anti-adhesion polished edge  
Improved chip control

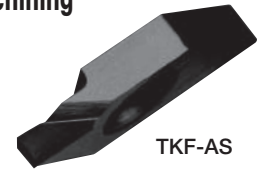


GQ Chipbreaker

- Insert Grades for Steel Machining  
**PR1425**

- Insert Grades for Stainless Steel Machining  
**PR1535**

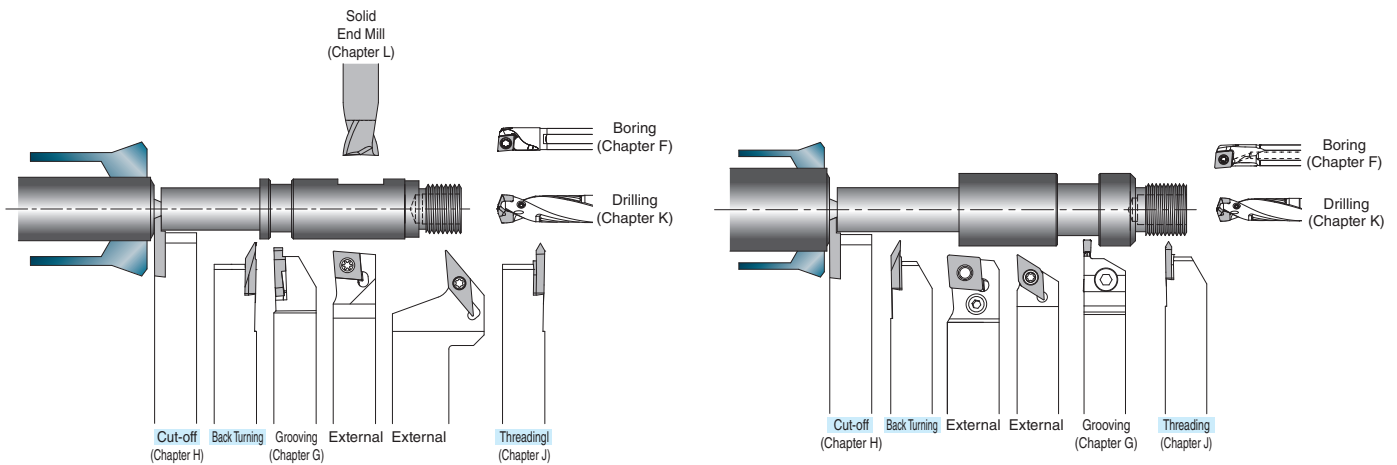
- "TKF..L-ASR" is added in  
"TKF-AS" PCD inserts



TKF-AS

**KTKF is applicable to back turning, threading and cut-off with one toolholder**

● Tooling example of KTKF toolholder

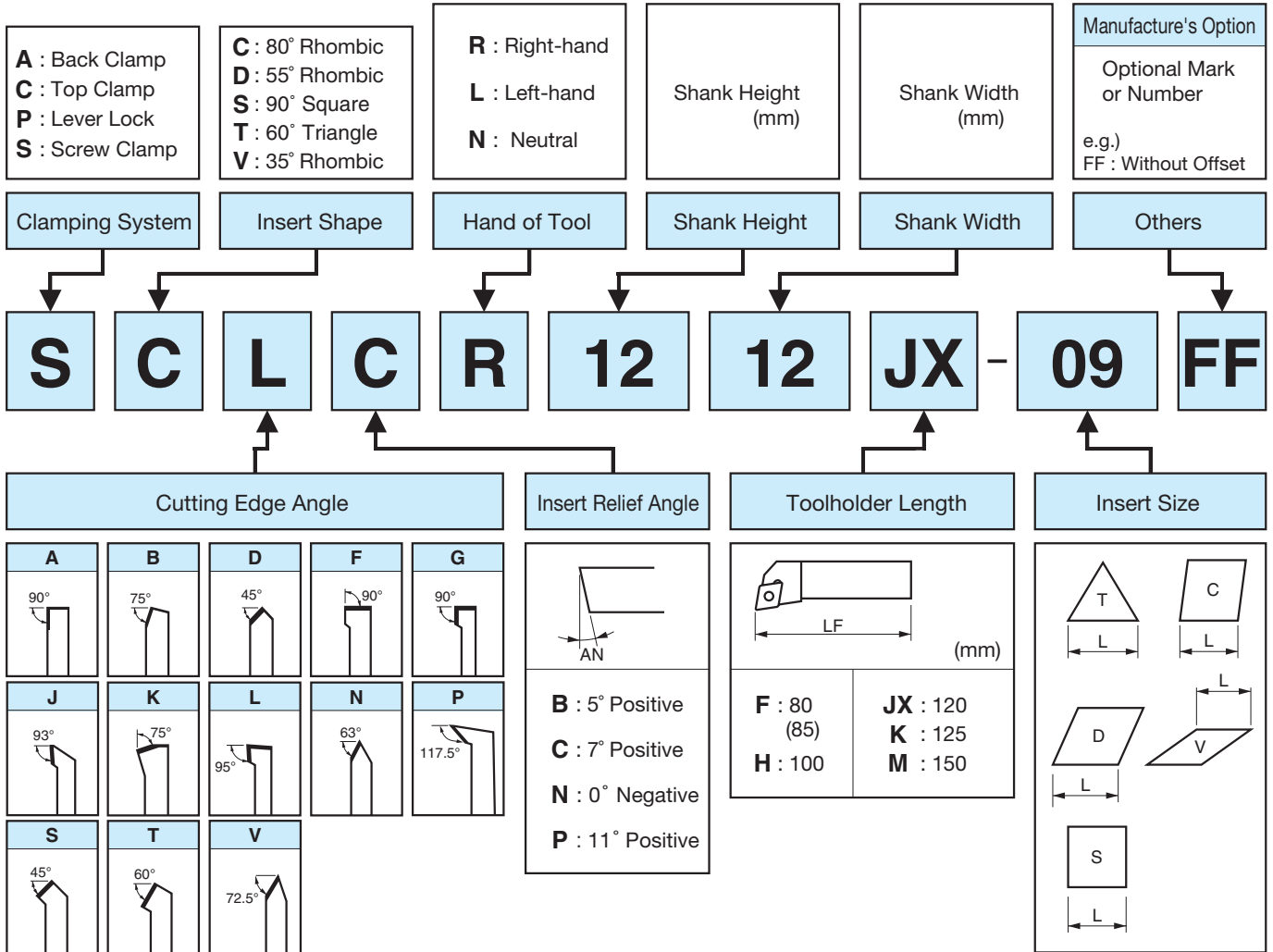


● Details of cutting edge

Small machining		General purpose		Large machining	
Description	Cutting Edge Length L	Description	Cutting Edge Length L	Description	Cutting Edge Length L
TKFB12R15..	2.1	TKFB12R28..	4.2	TKFB16R38..	5.8
-	-	TKFB12L28..	4.4	TKFB16L38..	6.2
For small diameter and short length workpiece Stable machining with minimum overhang		For general purpose Good chip control		Large ap at one pass	

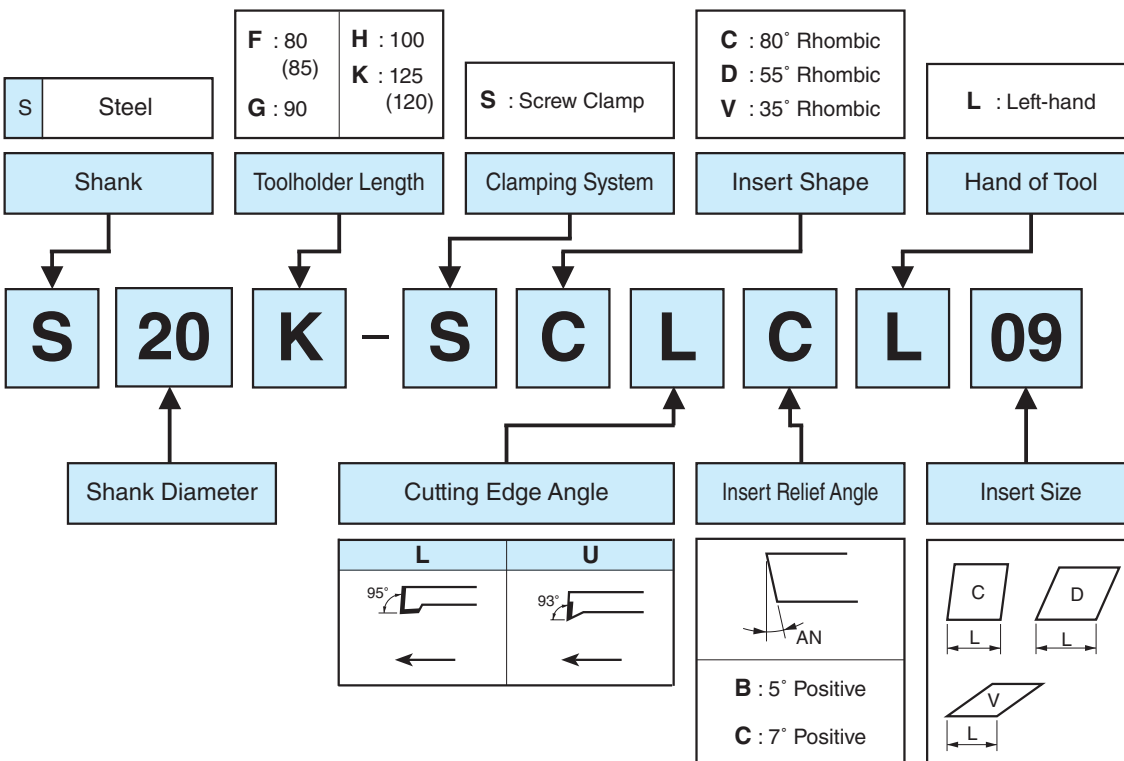
# Small Parts Machining Identification System

## Square Shank Identification System



• Some back turning toolholders are Kyocera's original products, therefore their descriptions are not accordant with international standards.

## External Sleeve Holder Identification System



• Specification may change without any prior notice.

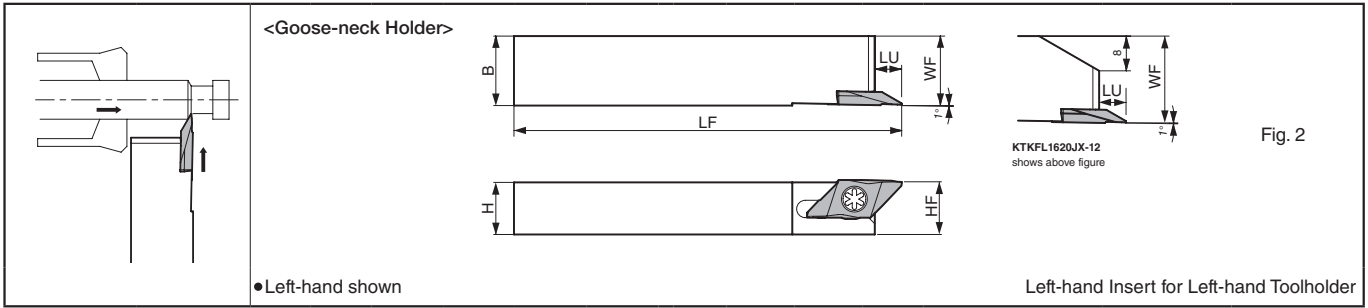
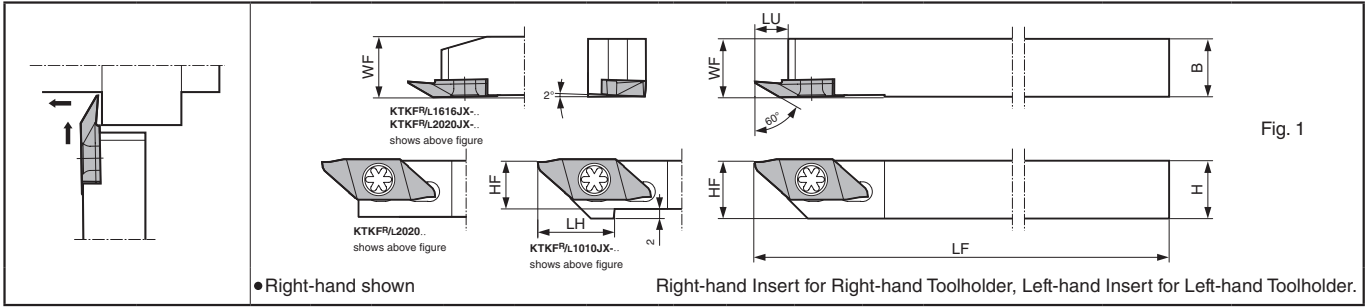
• Due to the installation size constrains on the machine, the toolholder length of some products may not match with the symbol.

Insert Grades  
 Turning  
 Indestructible Inserts  
 CBN & PCD Tools  
 External  
 Machining  
 Small Parts  
 Boring  
 Grooving  
 Cut-off  
 Threading  
 Drilling  
 Solid Tools  
 Milling  
 Tools for  
 Turning Mill  
 Spare Parts  
 Technical  
 Information  
 Index

**A**  
**B**  
**C**  
**D**  
**E**  
**F**  
**G**  
**H**  
**J**  
**K**  
**L**  
**M**  
**N**  
**P**  
**R**  
**T**

# Toolholders for Back Turning [TKFB Insert]

## KTKF / KTKF Goose-neck Holder



### Toolholder Dimensions

Description	Stock		Dimension (mm)							Drawing	Spare Parts		Applicable Inserts			
	R	L	H	HF	B	LF	LH	WF	LU		Clamp Screw	Wrench				
KTKF <sup>R/L</sup>	1010JX-12	●	●	10	10	10	120	15	10	6	Fig. 1	SB-4590TRWN	LTW-10S	TKFB12 <sup>R/L</sup> ...		
	1212JX-12	●	●	12	12	12		-	12							
	1616JX-12	●	●	16	16	16		-	16							
	2020JX-12	●	●	20	20	20		-	20							
KTKF <sup>R/L</sup>	1010JX-16	●	●	10	10	10	120	20	10	8		SB-4590TRWN	LTW-10S		TKFB16 <sup>R/L</sup> ...	
	1212JX-16	●	●	12	12	12		-	12							
	1616JX-16	●	●	16	16	16		-	16							
	2020JX-16	●	●	20	20	20		-	20							
KTKF <sup>R/L</sup>	1212F-12	●	●	12	12	12	85	-	12	6		SB-4590TRWN	LTW-10S		TKFB12 <sup>R/L</sup> ...	
	1212F-16	●	●	12	12	12		-	12						8	TKFB16 <sup>R/L</sup> ...
KTKFL	1216JX-12		●	12	12	16	120	-	16	6		Fig. 2	SB-4590TRWN		LTW-10S	TKFB12L ...
	1620JX-12		●	16	16	20		-	20							6

• LU shows the distance from the Toolholder to the cutting edge.  
 • See Page H13 for internal coolant type (coolant-through holders)

### Applicable Inserts (See Page B100)

Insert	Description	Corner-R (RE) (mm)
	TKFB 12R15005M	<0.05
	12R28005M	<0.05
	12R28010M	<0.1
	TKFB 16R38005M	<0.05
	16R38010M	<0.1
	TKFB 12L28005MR	<0.05
	12L28010MR	<0.1
	TKFB 16L38005MR	<0.05
	16L38010MR	<0.1

Recommended Cutting Conditions E47

### Applicable Inserts (Molded Chipbreaker, P: Polished edge, See Page B101)

Insert	Description	Corner-R (RE) (mm)
	TKFB 12R28005(P)-GQ	0.05
	12R28015(P)-GQ	0.15
	TKFB 16R38005(P)-GQ	0.05
	16R38015(P)-GQ	0.15

Recommended Cutting Conditions E47

### Combination of Toolholders and Inserts

Toolholder	Right-hand	Toolholder	Left-hand
Insert	Right-hand	Insert	Left-hand

● : Std. Item

# TKFB type **GQ** Chipbreaker for back Turning

Solution for problems in the conventional back-turning tools  
 Unique molded chipbreaker provides excellent surface finish with smooth chip control

Insert Grades	A
Turning	B
Indexable Inserts	C
CBN & PCD Tools	D
External	D
Small Parts Machining	<b>E</b>
Boring	F
Grooving	G
Cut-off	H
Threading	J
Drilling	K
Solid Tools	L
Milling	M
Tools for Turning Mill	N
Spare Parts	P
Technical Information	R
Index	T

## Point 1 Unique double-function chipbreaker for improved chip control

**Function 1 : External**  
Preventing chip entanglement

Stable chip control

**GQ Chipbreaker**

Competitor A (Ground Chipbreaker)

**Function 2 : Grooving**  
Preventing chip biting

Good surface roughness

**GQ Chipbreaker**

Competitor A (Ground Chipbreaker)

## Point 2 Excellent surface finish by preventing chip biting and clogging

**Surface finish comparison**

Cutting Conditions : Vc=100m/min ap=3.0mm f=0.02mm/rev (Grooving) 0.05mm/rev (External)  
 Workpiece Material : S45C Wet

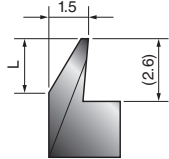
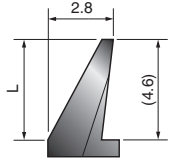
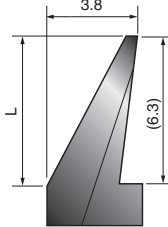
	TKFB GQ Chipbreaker		Competitor B (Ground Chipbreaker)	
	Facing	External	Facing	External
Workpiece surface	 Excellent surface 2.9µmRz	 3.8µmRz	 Chip biting 31.2µmRz	 7.6µmRz

**GQ Chipbreaker realizes excellent surface finish with single pass. Suitable for cycle time reduction.**

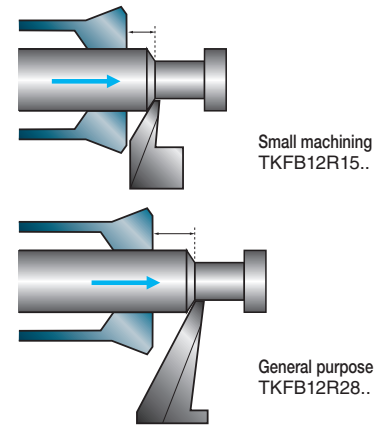
# Toolholders for Back Turning [TKFB Insert]

## Details of cutting edge and how to select

### Details of cutting edge

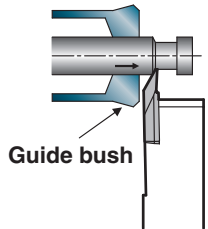
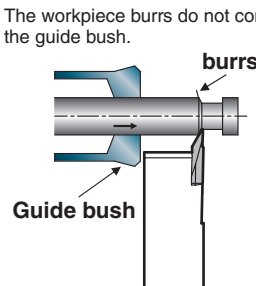
Small machining		General purpose		Large machining	
					
Description	Cutting Edge Length L	Description	Cutting Edge Length L	Description	Cutting Edge Length L
TKFB12R15..	2.1	TKFB12R28..	4.2	TKFB16R38..	5.8
-	-	TKFB12L28..	4.4	TKFB16L38..	6.2
For small diameter and short length workpiece Stable machining with minimum overhang		For general purpose Good chip control		Large ap at one pass	

### Selection



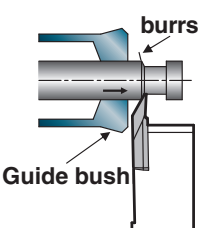
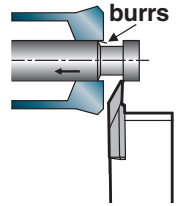
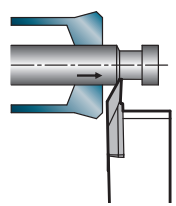
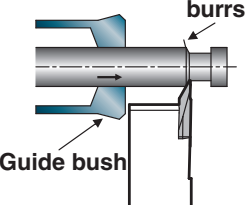
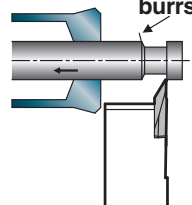
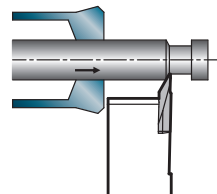
In case ap is same, if the insert with narrower edge width is used, overhang length from the guide bush is shorter, which enables better stability due to less workpiece deflection. ⇒ High precision machining

## How to select back turning toolholder hand

Right-hand		Machining near the guide bush is possible Narrow cutting edge width of TKFB12R15005M (1.5mm) allows it. → Optimum for small parts and high precision machining
Left-hand		Machining with a distance from guide bush Good chip control due to large space between the guide bush and the tool → Excellent chip control in roughing and finishing (plural passes) Stable accuracy of external diameter dimension : When burrs occur, if a Left-hand toolholder is used, it is not necessary to return workpiece into guide bush in finishing. Also, Left-hand toolholders prevent guide bush wear caused by chip biting.

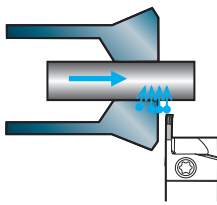
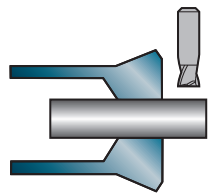
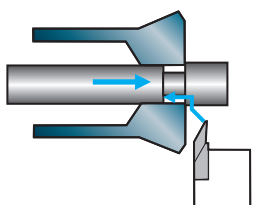
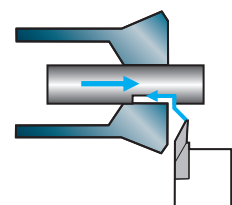
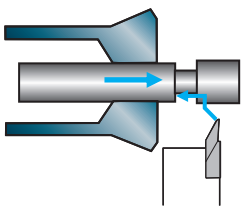
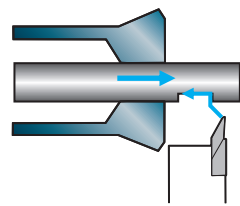
## Workpiece movement and tool hand selection

### In roughing and finishing

	Roughing	Workpiece position after roughing	Finishing
Right-hand			
Left-hand			

\* Good dimension accuracy : If a Left-hand toolholder is used, burrs on workpiece generated in roughing do not damage the guide bush in finishing.

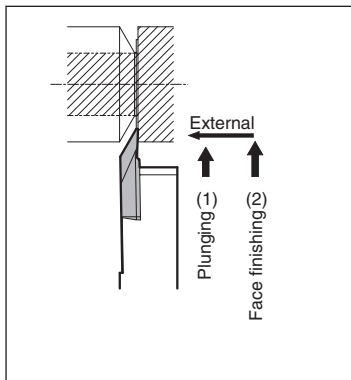
## Chip control improvement in back turning

	Chip control improvement by tool pass changes I	Chip control improvement by tool pass changes II
Roughing  	<p>● Roughing with grooving tools (1) GMM2420-020MW (Grooving)</p> 	<p>● Pre-Stage machining is processed with solid end mill (1) 2FESW040-040-04 (Solid End Mill)</p> 
Finishing (Countermeasures 1) Use Right-hand toolholder	<p>(1) When using TKFB12R28010M (for back turning / right hand)</p>  <p>Advantages : Good surface roughness Disadvantages : If a machining pass is long, the guide bush cannot support the workpiece</p>	<p>(1) When using TKFB12R28010M (for back turning / right hand)</p>  <p>Advantages : 1. Minimal deflection in long machining passes 2. Chips are broken into small pieces, though the workpiece material is sticky Disadvantages : The pre-stage machining may cause fractures, because of interrupted machining</p>
Finishing (Countermeasures 2) Use Left-hand toolholder	<p>(2) When using TKFB12L28010M (for back turning / left hand)</p>  <p>Advantages : 1. Good surface roughness 2. High precision machining if the machined portion does not contact the guide bush Disadvantages : If a machining pass is long, the guide bush cannot support the workpiece</p>	<p>(2) When using TKFB12L28010M (for back turning / left hand)</p>  <p>Advantages : 1. Minimal deflection in long machining passes 2. Chips are broken into small pieces, though the workpiece material is sticky 3. High precision machining if the machined portion does not contact the guide bush Disadvantages : The pre-stage machining may cause fractures, because of interrupted machining</p>

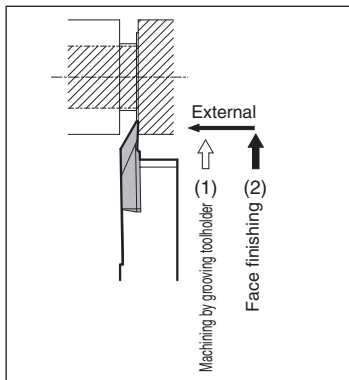
## Countermeasure against peeled surface in face back turning

When peeled surface occurs on the workpiece face, please apply the countermeasures below.

### ● Countermeasures 1 Face finishing



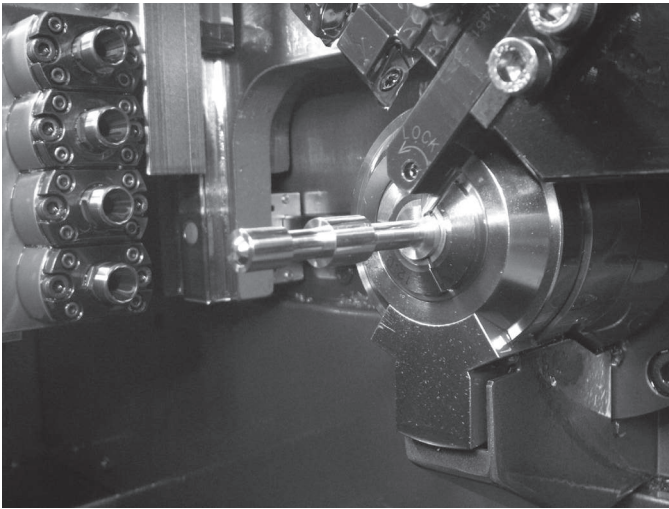
### ● Countermeasures 2 Face finishing after grooving



# External Inserts [For KTKF Toolholder]

## When using TKF-AS type Inserts

The KTKF toolholder can be used as a multi-functional tooling for non-ferrous metals and non-metals when combined with a TKF-AS insert. (Fig. 1)



Example of spool machining

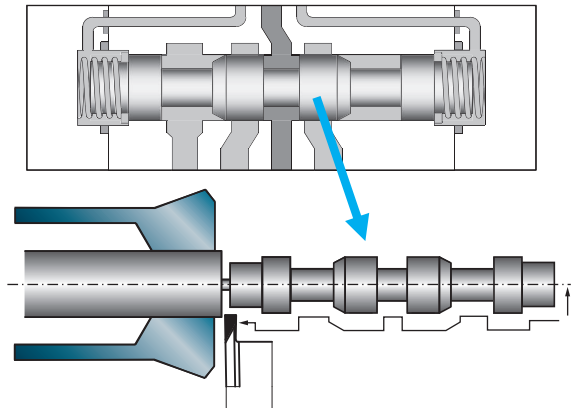


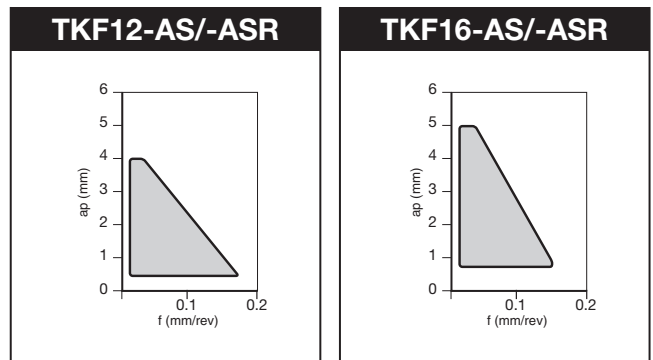


Fig. 1 Example of the pass of KTKF toolholder + TKF-AS insert

### Applicable Inserts (See Page C32)

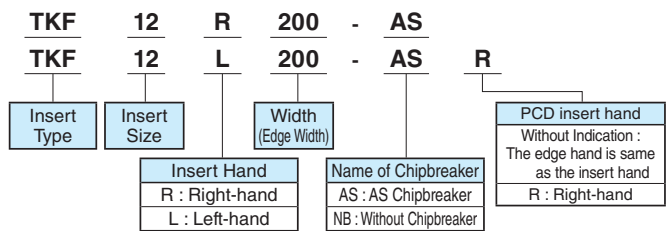
Insert Photo shows Right-hand	Description
 • Right-hand shown • Insert hand: Left-hand / PCD edge hand: Right-hand shown	TKF12 <sup>R/L</sup> 200-AS
	TKF12R 250-AS
	TKF16 <sup>R/L</sup> 250-AS
	TKF12L 200-ASR
	TKF16L 250-ASR
	TKF16L 250-ASR
 Grooving (Turning is possible) • Right-hand shown	TKF12 <sup>R/L</sup> 150-NB
	200-NB
	250-NB
	250-NB4.5

### Applicable Range



\* PCD Inserts for turning and grooving  
 \* Not recommended for cut-off

### Inserts Identification System



Applicable Toolholders **E12**  
 Recommended Cutting Conditions **E47**

Note 1) The cutting edge of the TKF-AS / -ASR will be 1 mm lower than the center line when attached to the KTKF toolholder (Ref. to Fig. 2). Adjust the height by making NC lathe parameter settings or inserting a plate.  
 2) If the 1 mm adjustment is not possible, use the TKF..-NB. (Ref. to Fig. 3)

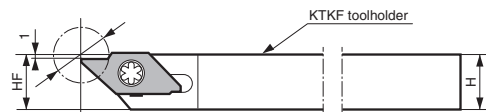


Fig. 2 When a TKF-AS / -ASR insert is attached (The cutting edge is 1mm lower than the center line)

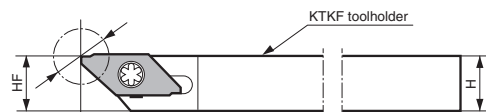
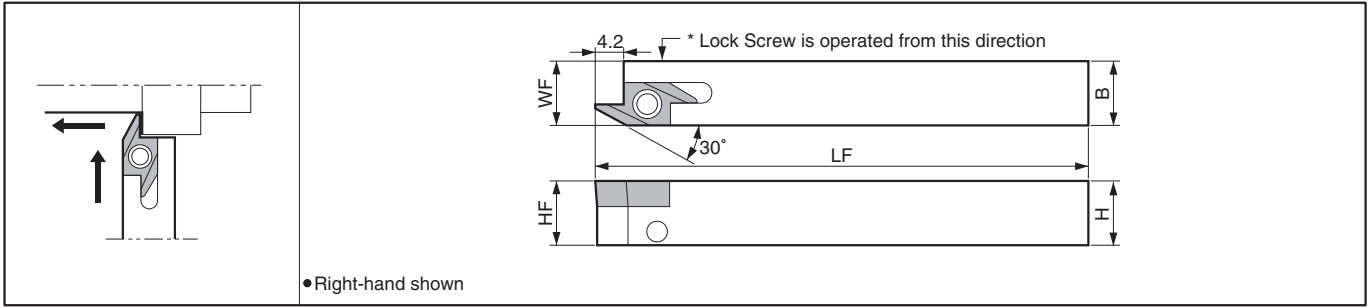


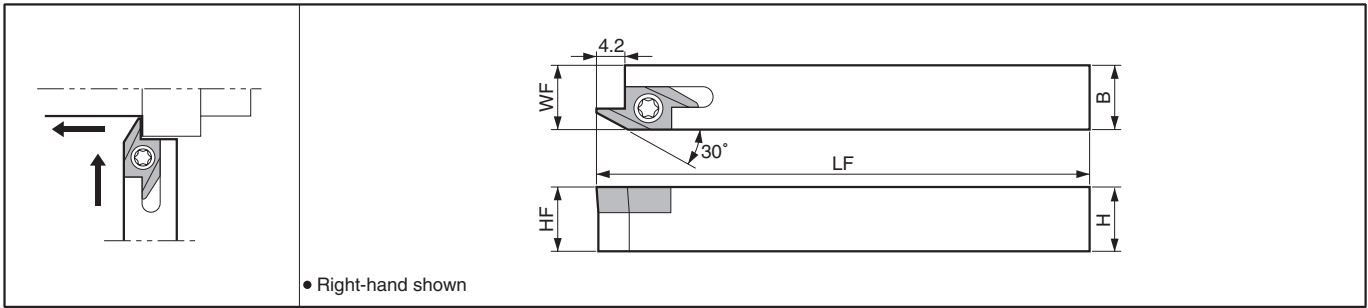
Fig. 3 When a TKF-NB insert is attached



### AABS-40F (Edge Width : 2.8mm, MAX. Depth : 4mm)



### SABS-40F (Edge Width : 2.8mm, MAX. Depth : 4mm)

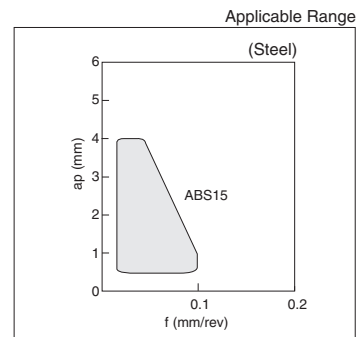


#### Toolholder Dimensions

Description	Stock	Dimension (mm)					Std. Corner-R(RE)	Spare Parts			
		H	HF	B	LF	WF		Anchor Pin	Lock Screw	Clamp Screw	Wrench
AABSR	1010JX-40F	●	10	10	10	120	10.2	LPA-11 LPA-13 LPA-17	HSB4X8R	-	FH-2
	1212JX-40F	●	12	12	12		12.2				
	1616JX-40F	●	16	16	16		16.2				
SABSR	1010JX-40F	●	10	10	10	120	10.2	-	-	SB-3080TR	FT-10
	1212JX-40F	●	12	12	12		12.2				
	1616JX-40F	●	16	16	16		16.2				
SABSR	1212F -40F	●	12	12	12	85	12.2	-	-	SB-3080TR	FT-10
	2020K -40F	●	20	20	20	125	20.2				

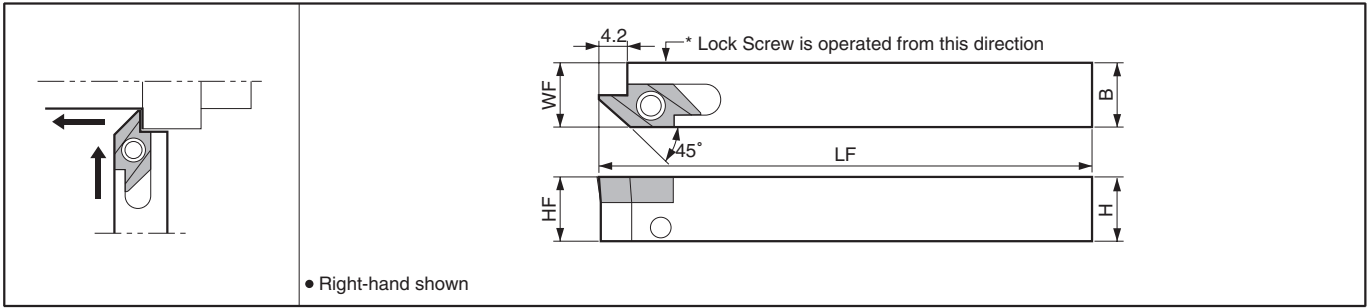
#### Applicable Inserts

Insert	Description	Corner-R(RE) (mm)	See Page
	ABS15R4005	0.05	B102
	15R4015	0.15	
	ABS15R4005M	<0.05	
	15R4015M	<0.15	

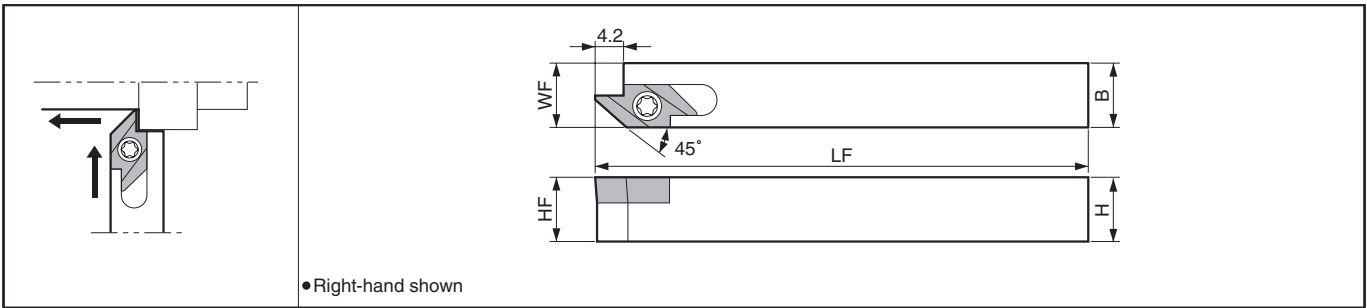


Recommended Cutting Conditions [E47](#)

### AABW-40F (Edge Width : 4.7mm, MAX. Depth : 4mm)



### SABW-40F (Edge Width : 4.7mm, MAX. Depth : 4mm)

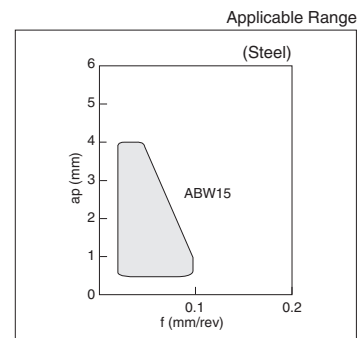


#### Toolholder Dimensions

Description	Stock	Dimension (mm)					Std. Corner-R(RE)	Spare Parts				
		H	HF	B	LF	WF		Anchor Pin	Lock Screw	Clamp Screw	Wrench	
AABWR	1010JX-40F	●	10	10	10	120	10.2	0.15	LPA-11	HSB4X8R	-	FH-2
	1212JX-40F	●	12	12	12		12.2					
	1616JX-40F	●	16	16	16		16.2					
SABWR	1010JX-40F	●	10	10	10	120	10.2	0.15	-	-	SB-3080TR	FT-10
	1212JX-40F	●	12	12	12		12.2					
	1616JX-40F	●	16	16	16		16.2					
SABWR	2020K-40F	●	20	20	20	125	20.2	0.15	-	-	SB-3080TR	FT-10

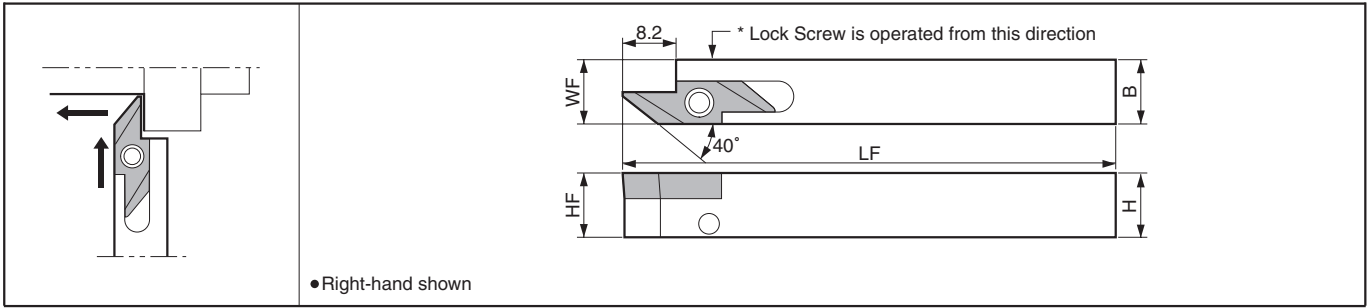
#### Applicable Inserts

Insert	Description	Corner-R(RE) (mm)	See Page
	ABW15R4005 15R4015	0.05 0.15	B102
	ABW15R4005M 15R4015M	<0.05 <0.15	

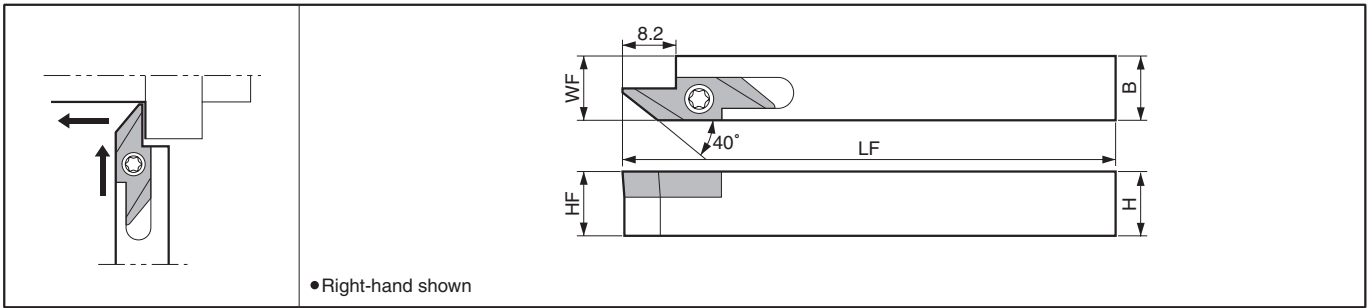


Recommended Cutting Conditions E47

### AABW-50F (Edge Width : 4.7mm, MAX. Depth : 5mm)



### SABW-50F (Edge Width : 4.7mm, MAX. Depth : 5mm)



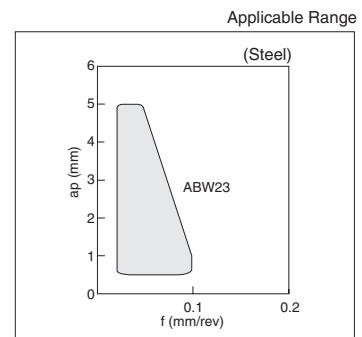
#### Toolholder Dimensions

Description	Stock	Dimension (mm)					Std. Corner-R(RE)	Spare Parts				
		H	HF	B	LF	WF		Anchor Pin	Lock Screw	Clamp Screw	Wrench	
AABWR	1010JX-50F	●	10	10	10	120	10.2	LPA-11	HSB4X8R	-	FH-2	
	1212JX-50F	●	12	12	12		12.2	LPA-13				
	1616JX-50F	●	16	16	16		16.2	LPA-17				
SABWR	1010JX-50F	●	10	10	10	120	10.2	-	-	SB-3080TR	FT-10	
	1212JX-50F	●	12	12	12		12.2	-				
	1616JX-50F	●	16	16	16		16.2	-				
SABWR	2020K -50F	●	20	20	20	125	20.2	0.15	-	-	SB-3080TR	FT-10

#### Applicable Inserts

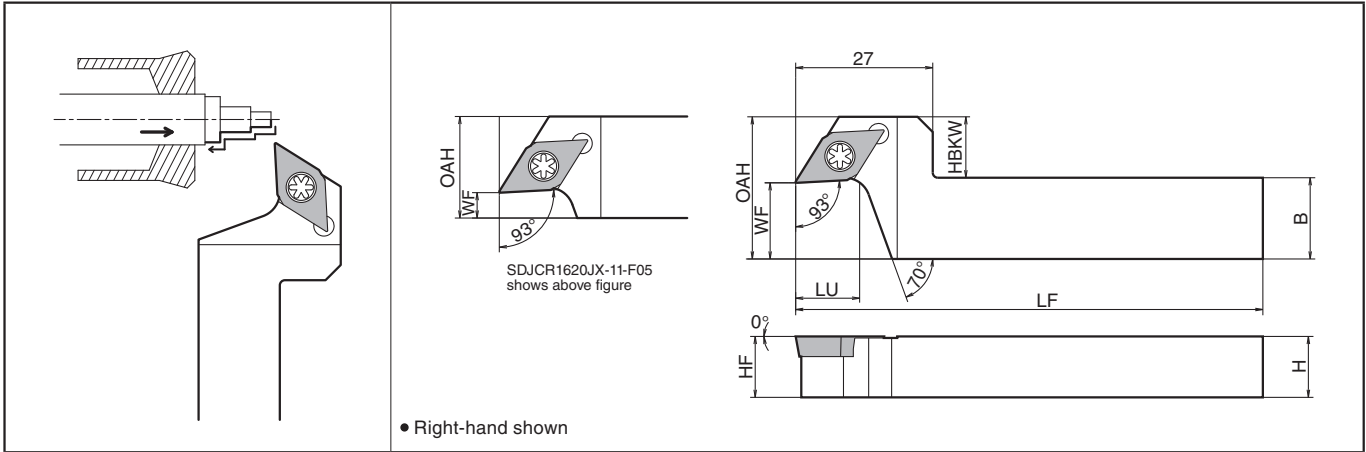
Insert	Description	Corner-R(RE) (mm)	See Page
	ABW23R5005 23R5015	0.05 0.15	B102
	ABW23R5005M 23R5015M	<0.05 <0.15	

Recommended Cutting Conditions [E47](#)



# Goose-neck Holder [DC□□ Insert]

## SDJC (External / Copying)



### Toolholder Dimensions

Description	Stock	Dimension (mm)								Std. Corner-R(RE)	Spare Parts	
		H	HF	B	LF	LU	OAH	HBKW	WF		Clamp Screw	Wrench
SDJCR 1216JX-11-F05	●	12	12	16	120	12.6	18	2	5	0.2	SB-4085TR	FT-15
1216JX-11-F15	●						28	12	15			
1620JX-11-F05	●	16	16	20			20	-	5			
1620JX-11-F15	●						28	8	15			

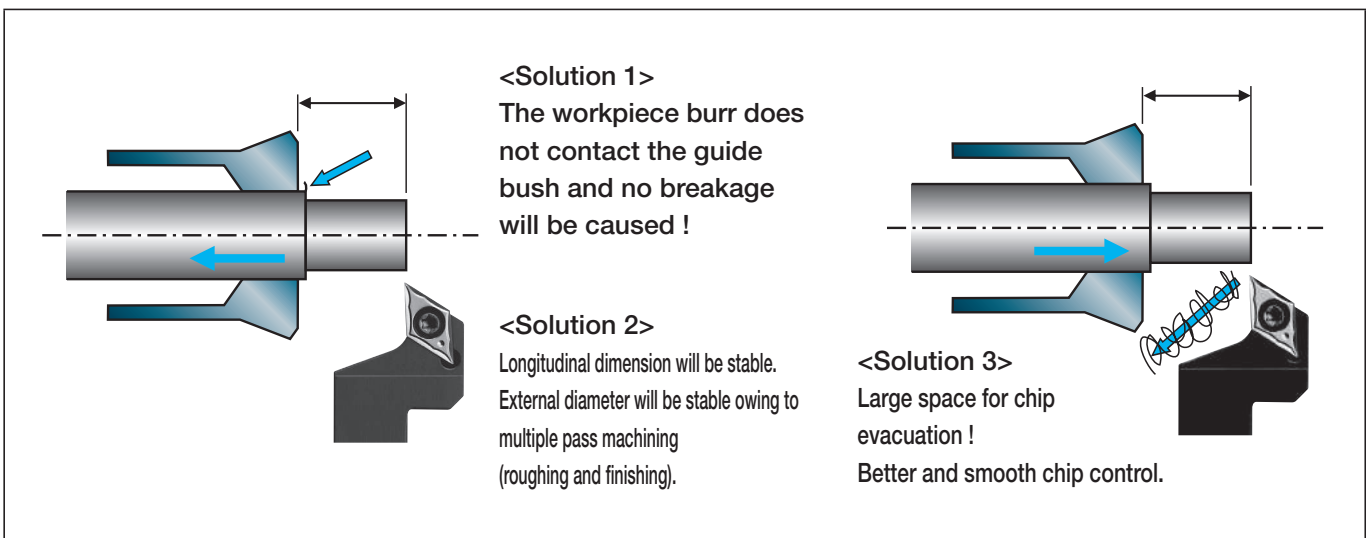
### Applicable Inserts

Applications	Minute ap	Finishing	* Finishing	Finishing	Finishing - Medium	Finishing - Medium	Finishing	Finishing / Precision	Low Feed	Low Feed / Precision
See Page	B62	B62	B63	B63	B64	B63	B67	B66	B68,B69	B68
Insert	CF	GF	WP(Wiper)	PP	GK	GQ	R-F	R-FSF	(E/F) R-U	FR-USF
Toolholder Description	DCGT11T3..	DCGT11T3..	DCMX11T3..	DCMT11T3..	DCMT11T3..	DCGT11T3..	DCGT11T3..	DCET11T3..	DCGT11T3..	DCET11T3..
Applications	Low Feed	Low Feed / Precision	Soft Steel / Finishing	Soft Steel / Finishing - Medium	Stainless Steel	Cast Iron	Non-ferrous Metals	Non-ferrous Metals	Non-ferrous Metals	Hard Materials
See Page	B70,B71	B70	B65	B65	B65	B71	B71	B71	C25	C15
Insert	(E/F)R-J	FR-JSF	XP	XQ	MQ	Without Chipbreaker	AH	R-A3	PCD	CBN
Toolholder Description	DCGT11T3..	DCET11T3..	DCMT11T3..	DCMT11T3..	DCMT11T3..	DCGW11T3..	DCGT11T3..	DCGT11T3..	DCMT11T3..	DCMW11T3..

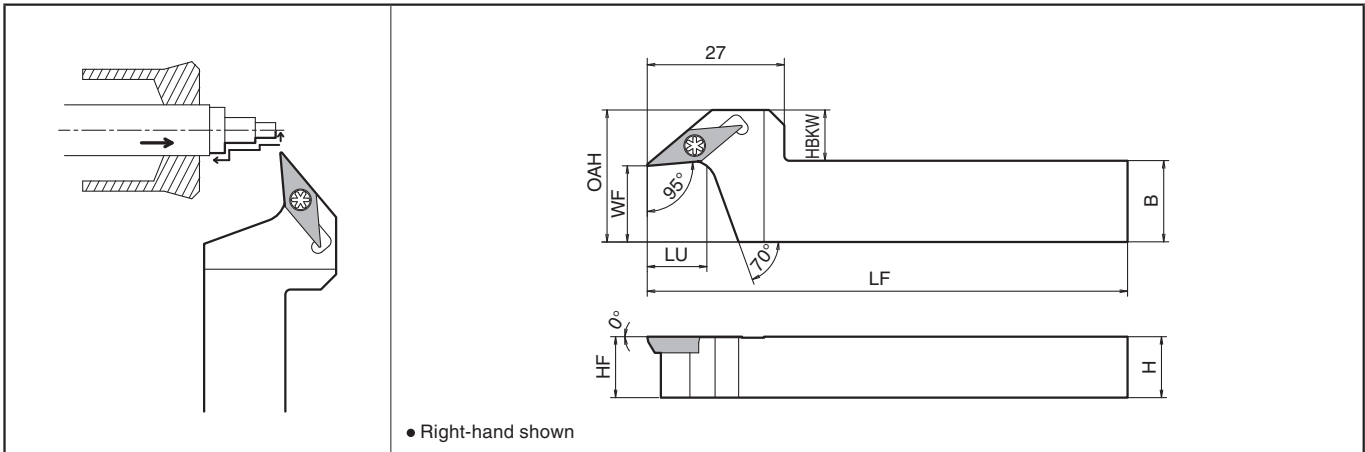
\* For WP chipbreaker, cutting edge offsets or program corrections are required. ● R35

Recommended Cutting Conditions ● E46

### Goose-neck holder is available for multiple passes at roughing and finishing !



### SVLP (External / Copying)



#### Toolholder Dimensions

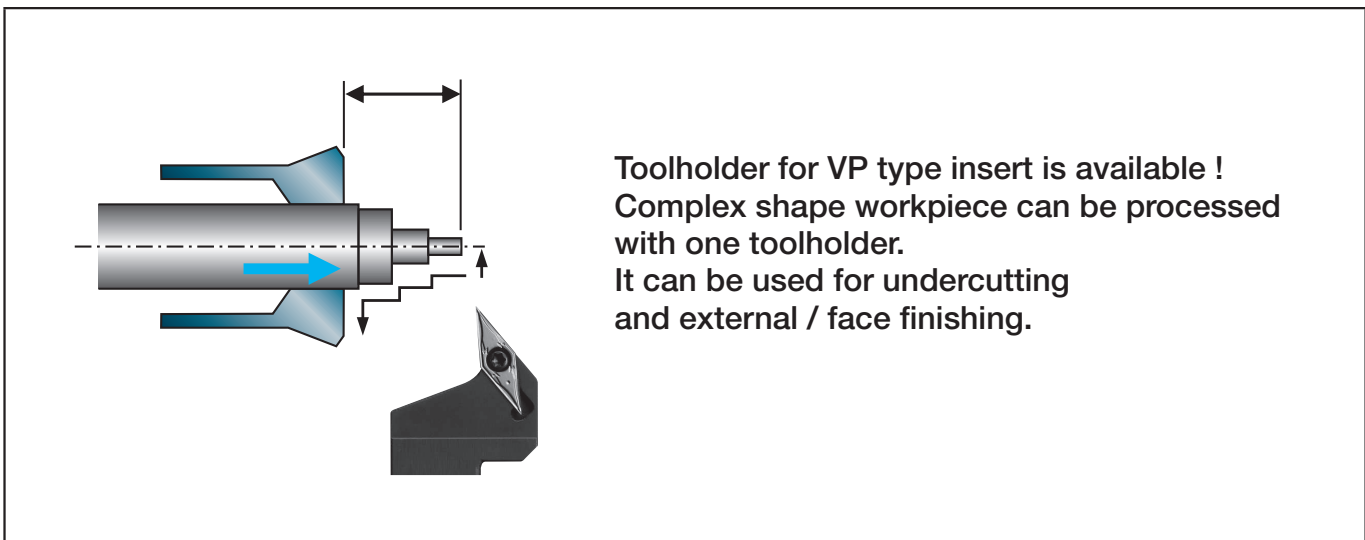
Description	Stock	Dimension (mm)								Std. Corner-R(RE)	Spare Parts	
		H	HF	B	LF	LU	OAH	HBKW	WF		Clamp Screw	Wrench
SVLPR 1216JX-11-F15	●	12	12	16	120	12	26	10	15	0.2	SB-2570TR	FT-8
1620JX-11-F15	●	16	16	20				6				

#### Applicable Inserts

Applications	Minute ap	Finishing	Finishing	Finishing / Precision	Low Feed	Low Feed / Precision				
See Page	B94	B94	B94	B95	B96	B96				
Toolholder Description	Insert	CF	CK	GF	R-FSF	FR-U	FR-USF			
SVLPR...-11-F..	VPGT1103..	VPGT1103..	VPGT1103..	VPET1103..	VPET1103..	VPET1103..				

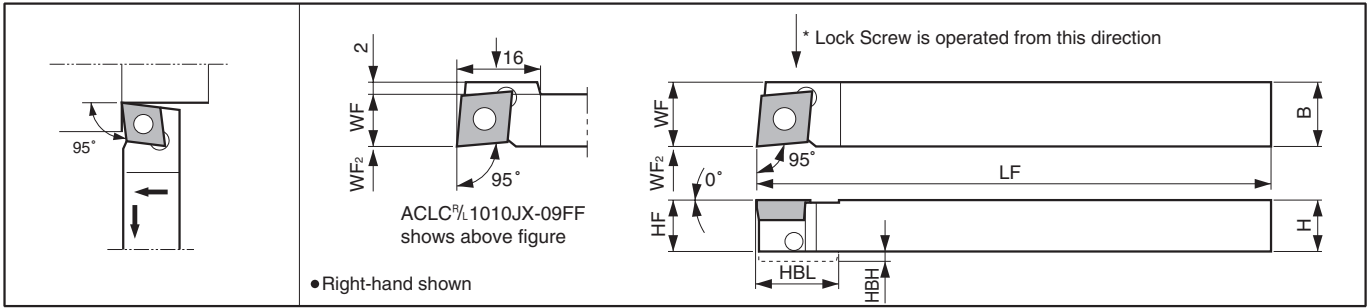
Recommended Cutting Conditions [E46](#)

#### One toolholder for complex shape workpiece



# External Toolholders [CC□□ Insert]

## ACLC-FF (Without Offset) (External / Facing)



### Toolholder Dimensions

Description	Stock		Dimension (mm)								Std. Corner-R(RE)	Spare Parts			
	R	L	H	HF	HBH	B	LF	HBL	WF	WF <sub>2</sub>		Anchor Pin	Lock Screw	Wrench	
ACLC <sup>R/L</sup>	1010JX-06FF	●	●	10	10	-	10	120	-	10	0	0.2	LPF-11	HSB4X8 <sup>R/L</sup>	FH-2
	1010JX-09FF	●	●	10	10	2	10	120	16	10			LPF-13		
	1212JX-09FF	●	●	12	12	-	12		-	12			LPF-17		
	1616JX-09FF	●	●	16	16	-	16	-	16						

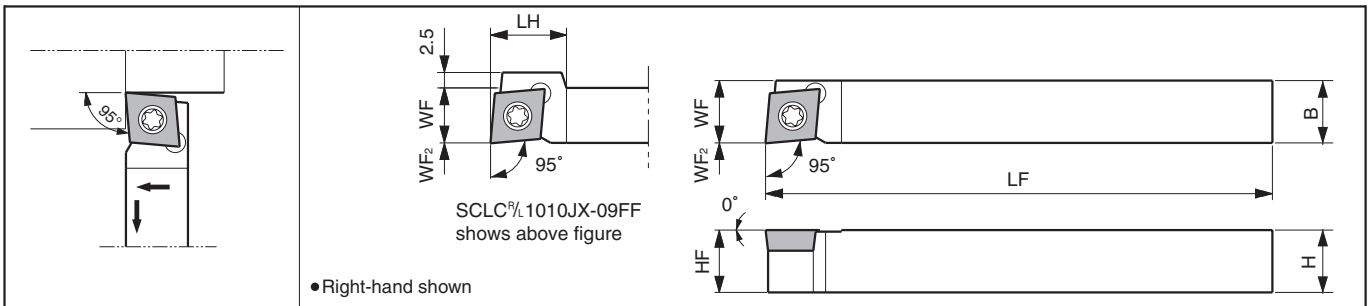
• Lock Screw : HSB4X8R for Right-hand Toolholder, HSB4X8L for Left-hand Toolholder.

### Applicable Inserts

Applications	Finishing	Finishing - Medium	Finishing - Medium	Low Feed	Stainless Steel	Cast Iron	Non-ferrous Metals	Non-ferrous Metals	Non-ferrous Metals	Hard Materials
See Page	B53	B54	B53,B54	B58,B59	B55	B60	B60	B60	C24	C14
Insert	GF	GK	GQ	(E/F) <sup>R/L</sup> -U	MQ	Without Chipbreaker	AH	<sup>R/L</sup> -A3	PCD	CBN
Toolholder Description										
ACLC <sup>R/L</sup> ...-06FF	CCGT0602..	CCMT0602..	CCGT0602..	CCGT0602..	-	CCGW0602..	-	-	CCMT0602.. CCGW0602..	CCMW0602..
ACLC <sup>R/L</sup> ...-09FF	CCGT09T3..	CCMT09T3..	CCGT09T3..	CCGT09T3..	CCMT09T3..	CCGW09T3..	CCGT09T3..	CCGT09T3..	CCMT09T3.. CCGW09T3..	CCMW09T3..

Recommended Cutting Conditions **E46**

## SCLC-FF (Without Offset) (External / Facing)



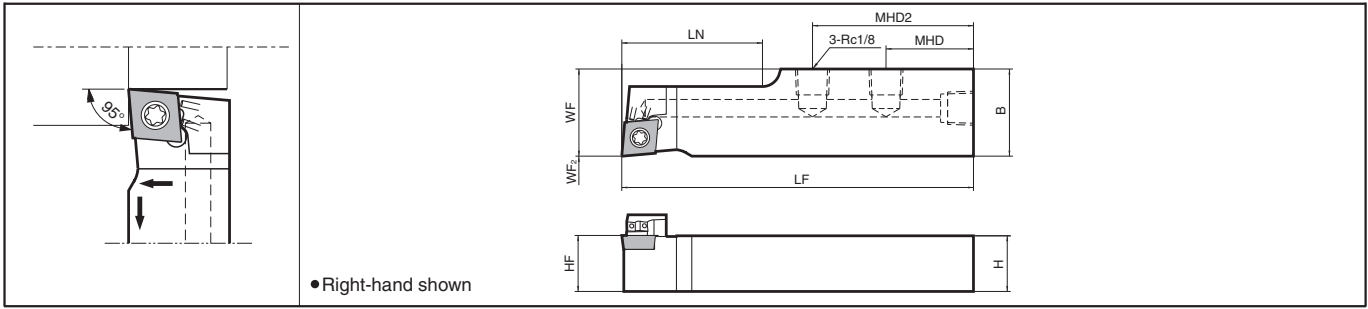
### Toolholder Dimensions

Description	Stock		Dimension (mm)							Std. Corner-R(RE)	Spare Parts		
	R	L	H	HF	B	LF	LH	WF	WF <sub>2</sub>		Clamp Screw	Wrench	
SCLC <sup>R/L</sup>	0808F-06FF	●	●	8	8	8	85	-	8	0	0.2	SB-2570TR	FT-8
	1212F-09FF	●	●	12	12	12		12	10			SB-4085TR	FT-15
SCLC <sup>R/L</sup>	1010JX-06FF	●	●	10	10	10	120	-	10	0	0.2	SB-2570TR	FT-8
	1010JX-09FF	●	●	10	10	10		15	10				
	1212JX-09FF	●	●	12	12	12		-	12				
	1616JX-09FF	●	●	16	16	16		-	16				
	2020JX-09FF	●	●	20	20	20		-	20				

● : Std. Item

# External Toolholders [CC□□ Insert]

## SCLC-FFJCT (Without Offset) (External / Facing / Coolant-through holders)

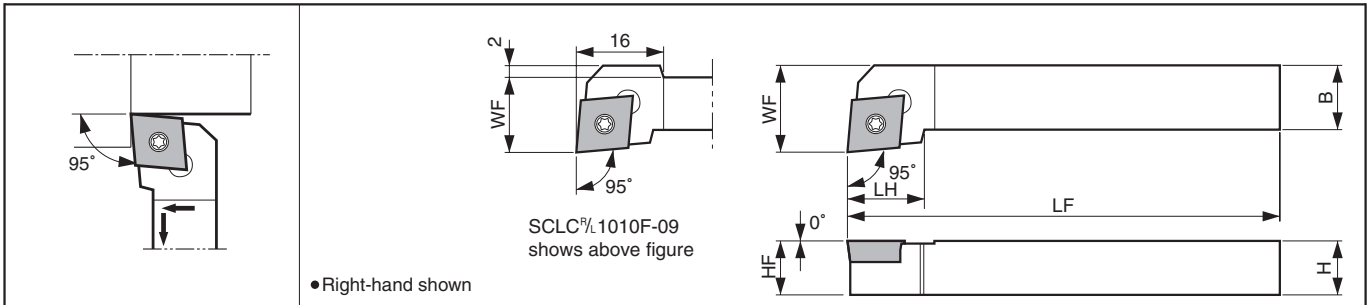


### Toolholder Dimensions

Description	Stock		Dimension (mm)									Std. Corner-R(RE)	Spare Parts					
	R	L	H	HF	B	LF	LN	WF	WF <sub>2</sub>	MHD	MHD2		Clamp Screw	Wrench	Plug			
<b>SCLCR 1220H-09FFJCT</b>	●		12	12	20	100	28	20				0	35	-	0.2	SB-4085TR	FT-15	GP-1
<b>1625H-09FFJCT</b>	●		16	16	25	100	40	25				25	46					
<b>2025H-09FFJCT</b>	●		20	20	25	100	40	25				25	46					

Please see page H14 and H15 for piping parts of coolant-through holders.

## SCLC (External / Facing)



### Toolholder Dimensions

Description	Stock		Dimension (mm)						Std. Corner-R(RE)	Spare Parts		
	R	L	H	HF	B	LF	LH	WF		Clamp Screw	Wrench	Wrench
<b>SCLC<sup>3/4</sup> 1010F -06</b>	●	●	10	10	10	80	9	12	0.2	SB-2570TR	FT-8	-
	●	●	10	10	10	80	14	14				
<b>1212H -09</b>	●	●	12	12	12	100	15	20	0.2	SB-4085TR	FT-15	-
<b>1616H -09</b>	●	●	16	16	16	100	20	20				
<b>2020K -09</b>	●	●	20	20	20	125	20	25	0.4	SB-5090TR	-	LTW-20
<b>2525M -09</b>	●	●	25	25	25	150	22	32				
<b>1616H -12</b>	●	●	16	16	16	100	20	20				
<b>2020K -12</b>	●	●	20	20	20	125	22	25				
<b>2525M -12</b>	●	●	25	25	25	150	22	32				

### Applicable Inserts (SCLC-FF / SCLC-FFJCT / SCLC)

Applications	Finishing	Finishing - Medium	Finishing - Medium	Low Feed	Stainless Steel	Cast Iron	Non-ferrous Metals	Non-ferrous Metals	Non-ferrous Metals	Hard Materials
See Page	B53	B54	B53,B54	B58,B59	B55	B60	B60	B60	C24	C14
Insert										
Toolholder Description										
<b>SCLC<sup>3/4</sup>L...-06FF/-06</b>	CCGT0602..	CCMT0602..	CCGT0602..	CCGT0602..	-	CCGW0602..	-	-	CCMT0602.. CCGW0602..	CCMW0602..
<b>SCLC<sup>3/4</sup>L...-09FF(JCT)/-09</b>	CCGT09T3..	CCMT09T3..	CCGT09T3..	CCGT09T3..	CCMT09T3..	CCGW09T3..	CCGT09T3..	CCGT09T3..	CCMT09T3.. CCGW09T3..	CCMW09T3..
<b>SCLC<sup>3/4</sup>L...-12</b>	-	CCMT1204..	-	-	-	-	-	CCGT1204..	-	-

Recommended Cutting Conditions E46

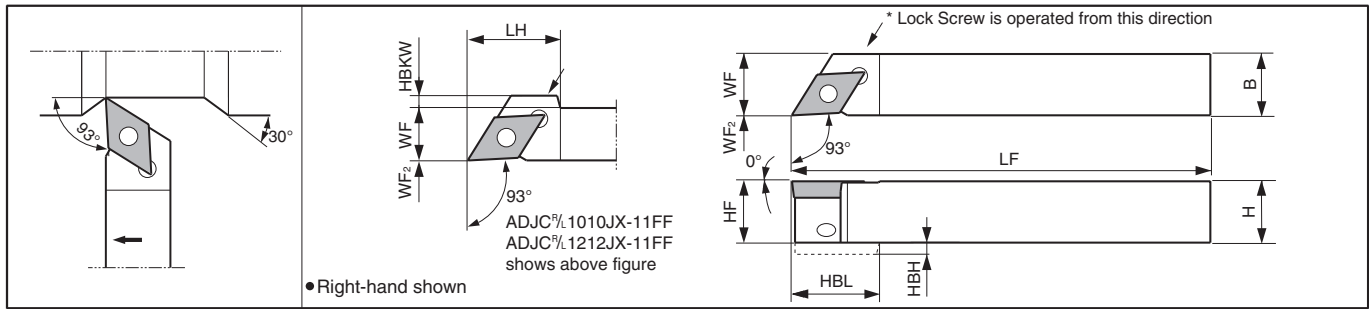
● : Std. Item

Insert Grades  
Turning  
Indexable Inserts  
CBN & PCD Tools  
External  
Small Parts  
Machining  
Boring  
Grooving  
Cut-off  
Threading  
Drilling  
Solid Tools  
Milling  
Tools for  
Turning Mill  
Spare Parts  
Technical  
Information

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# External Toolholders [DC□□ Insert]

## ADJC-FF (Without Offset) (External / Copying)

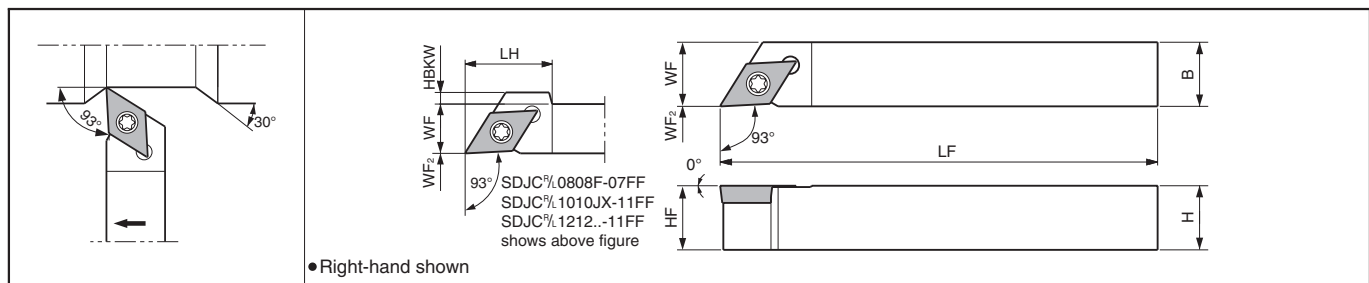


### Toolholder Dimensions

Description	Stock		Dimension (mm)									Std. Corner-R(RE)	Spare Parts		
	R	L	H	HF	HBH	B	LF	LH HBL	WF	HBKW	WF <sub>2</sub>		Anchor Pin	Lock Screw	Wrench
ADJC%L 1010JX-07FF 1010JX-11FF 1212JX-11FF 1616JX-11FF	●	●	10	10	-	10	120	-	10	-	0	0.2	LPF-11	HSB4X8%L	FH-2
	●	●	10	10	2	10		20	10	3		0.2	LPF-13		
	●	●	12	12	-	12		12	1	0.2		LPF-17			
	●	●	16	16	-	16		-	16	-		0.2	LPF-17		

• Lock Screw : HSB4X8R for Right-hand Toolholder, HSB4X8L for Left-hand Toolholder.

## SDJC-FF (Without Offset) (External / Copying)



### Toolholder Dimensions

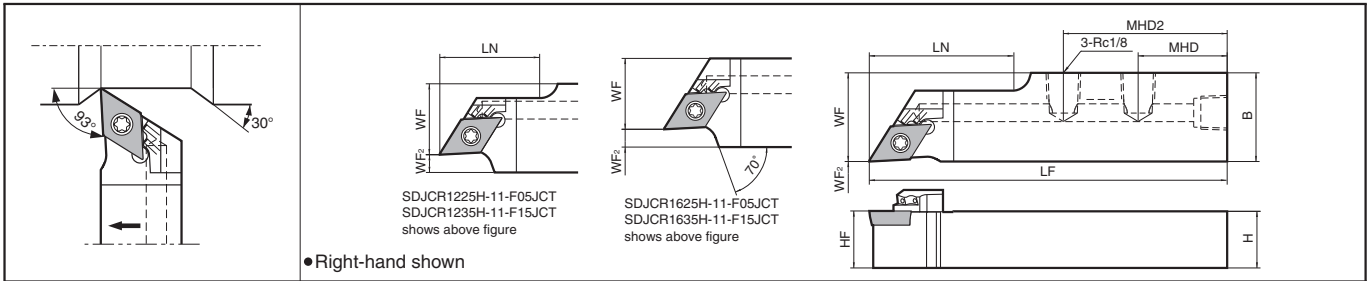
Description	Stock		Dimension (mm)									Std. Corner-R(RE)	Spare Parts	
	R	L	H	HF	B	LF	LH	WF	HBKW	WF <sub>2</sub>	Clamp Screw		Wrench	
SDJC%L 0808F -07FF 1212F -11FF	●	●	8	8	8	85	14	8	0.5	0	0.2	SB-2570TR	FT-8	
	●	●	12	12	12		20	12	1		0.2	SB-4085TR	FT-15	
SDJC%L 1010JX-07FF 1010JX-11FF 1212JX-11FF 1616JX-11FF 2020JX-11FF	●	●	10	10	10	120	-	10	-	0	0.2	SB-2570TR	FT-8	
	●	●	10	10	10		20	10	3		0.2	SB-4085TR	FT-15	
	●	●	12	12	12		12	12	1		0.2	SB-4085TR	FT-15	
	●	●	16	16	16		-	16	-		0.2	SB-4085TR	FT-15	
	●	●	20	20	20		-	20	-		0.2	SB-4085TR	FT-15	

● : Std. Item



# External Toolholders [DC□□ Insert]

## SDJC-JCT (External / Copying, Coolant-through Holders)

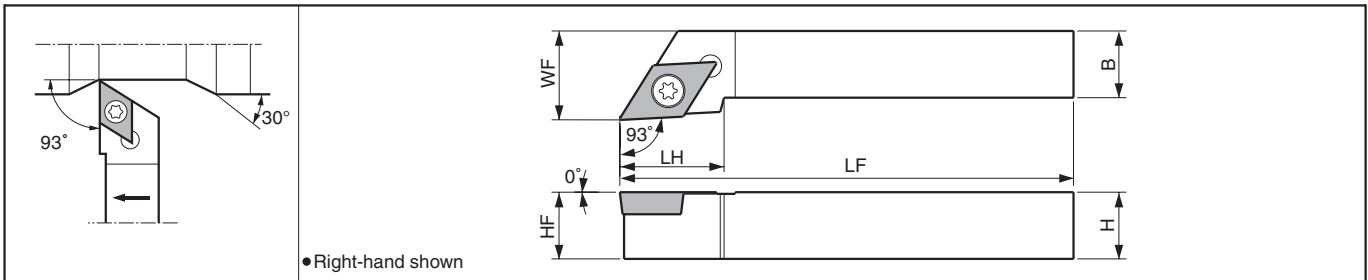


### Toolholder Dimensions

Description	Stock		Dimension (mm)									Std. Corner-R(RE)	Spare Parts					
	R	L	H	HF	B	LF	LN	WF	WF <sub>2</sub>	MHD	MHD2		Clamp Screw	Wrench	Plug			
SDJCR 1220H-11FFJCT	●		12	12	20	100	28	20		35	-	0.2	SB-4085TR	FT-15	GP-1			
1625H-11FFJCT	●		16	16	25		40	25	0	25	46							
2025H-11FFJCT	●		20	20	25		40	25		25	46							
SDJCR 1225H-11-F05JCT	●		12	12	25	100	28	20	5	35	-	0.2				SB-4085TR	FT-15	GP-1
1235H-11-F15JCT	●		12	12	35		28	20	15	35	-							
SDJCR 1625H-11-F05JCT	●		16	16	25	100	-	20	5	25	46							
1635H-11-F15JCT	●		16	16	35		-	20	15	25	46							

Please see page H14 and H15 for piping parts of coolant-through holders.

## SDJC (External / Copying)



### Toolholder Dimensions

Description	Stock		Dimension (mm)							Std. Corner-R(RE)	Spare Parts		
	R	L	H	HF	B	LF	LH	WF	Clamp Screw		Wrench		
SDJC <sup>R/L</sup> 1010F -07	●	●	10	10	10	80	12	12	0.2	SB-2570TR	FT-8		
SDJC <sup>R/L</sup> 1010F -11	●	●	10	10	10	80	18	12	0.2	SB-4085TR	FT-15		
1212H -11	●	●	12	12	12	100		16					
1616H -11	●	●	16	16	16	100		20					
2020K -11	●	●	20	20	20	125		25					
2525M -11	●	●	25	25	25	150	23	32					

### Applicable Inserts

Applications See Page	Minute ap	Finishing	Finishing	* Finishing	Finishing	Finishing - Medium	Finishing - Medium	Finishing	Finishing / Precision	Low Feed
	B62	B62	B62,B63	B63	B63	B64	B63	B67	B66	B68,B69
Insert	CF	GF	CK	WP (Wiper)	PP	GK	GQ	<sup>R/L</sup> -F	<sup>R/L</sup> -FSF	(E/F) <sup>R/L</sup> -U
Toolholder Description										
<b>DCJ<sup>R/L</sup>....-07FF/-07</b>	DCGT0702..	DCGT0702..	DCGT0702..	DCMX0702..	DCMT0702..	DCMT0702..	DCGT0702..	DCGT0702..	DCET0702..	DCGT0702..
<b>DCJ<sup>R/L</sup>....-11FF/-11...JCT/-11</b>	DCGT11T3..	DCGT11T3..	DCGT11T3..	DCMX11T3..	DCMT11T3..	DCMT11T3..	DCGT11T3..	DCGT11T3..	DCET11T3..	DCGT11T3..
Applications See Page	Low Feed / Precision	Low Feed	Soft Steel / Finishing	Soft Steel / Finishing - Medium	Stainless Steel	Cast Iron	Non-ferrous Metals	Non-ferrous Metals	Non-ferrous Metals	Hard Materials
	B68	B70,B71	B65	B65	B65	B71	B71	B71	C25	C15
Insert	F <sup>R/L</sup> -USF	(E/F) <sup>R/L</sup> -J	XP	XQ	MQ	Without Chipbreaker	AH	<sup>R/L</sup> -A3	PCD	CBN
Toolholder Description										
<b>DCJ<sup>R/L</sup>....-07FF/-07</b>	DCET0702..	DCET0702..	DCMT0702..	-	DCMT0702..	DCGW0702..	-	-	DCMT0702..	DCMW0702..
<b>DCJ<sup>R/L</sup>....-11FF/-11...JCT/-11</b>	DCET11T3..	DC_T11T3..	DCMT11T3..	DCMT11T3..	DCMT11T3..	DCGW11T3..	DCGT11T3..	DCGT11T3..	DCMT11T3..	DCMW11T3..

\* For WP chipbreaker, cutting edge offsets or program corrections are required. **R35**

Recommended Cutting Conditions **E46**

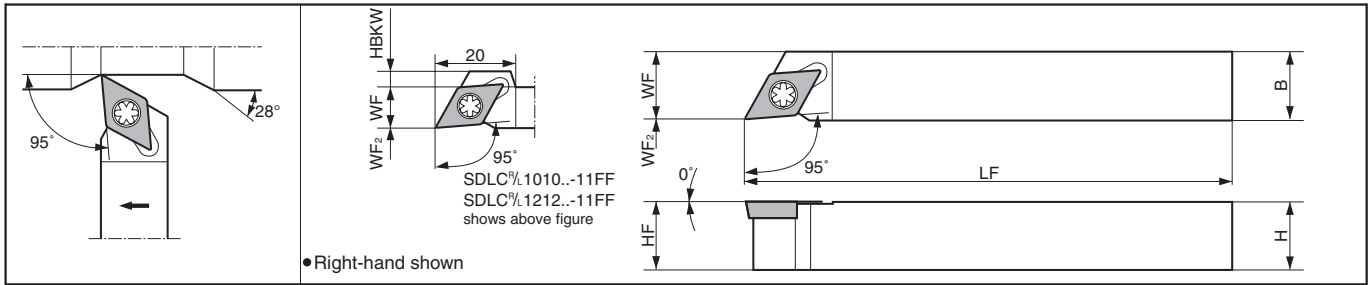
● : Std. Item

Insert Grades  
Turning  
Indexable Inserts  
CBN & PCD Tools  
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Small Parts  
Machining  
Boring  
Grooving  
Cut-off  
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Drilling  
Solid Tools  
Milling  
Tools for Turning Mill  
Spare Parts  
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# External Toolholders [DC□□ Insert]

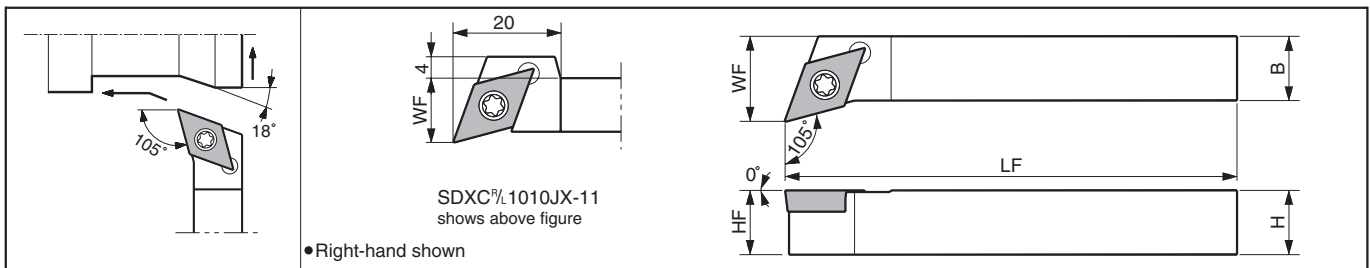
## SDLC-FF (Without Offset) (External / Copying)



### Toolholder Dimensions

Description	Stock		Dimension (mm)							Std. Corner-R(RE)	Spare Parts							
	R	L	H	HF	B	LF	WF	HBKW	WF <sub>2</sub>		Clamp Screw	Wrench						
<b>SDLC<sup>R/L</sup></b> 1010JX-07FF 1212JX-07FF 1616JX-07FF	●	●	10	10	10	120	10	-	0	0.2	SB-2570TR		FT-8					
<b>SDLC<sup>R/L</sup></b> 1010JX-11FF 1212JX-11FF 1616JX-11FF	●	●	10	10	10		10	4	0	0.2				SB-4085TR		FT-15		
<b>SDLC<sup>R/L</sup></b> 1212F -07FF <b>SDLC<sup>R/L</sup></b> 1010F -11FF 1212F -11FF 1616H -11FF	●	●	12	12	12		85	12	-	0							0.2	SB-2570TR
	●	●	10	10	10	80	10	4	0	0.2	SB-4085TR		FT-15					
	●		12	12	12	85	12	2	0	0.2								
	●		16	16	16	100	16	-										

## SDXC (External / Facing / Copying)



### Toolholder Dimensions

Description	Stock		Dimension (mm)							Std. Corner-R(RE)	Spare Parts										
	R	L	H	HF	B	LF	WF	HBKW	WF <sub>2</sub>		Clamp Screw	Wrench									
<b>SDXC<sup>R/L</sup></b> 1010JX-07 1010JX-11 1212JX-11 1616JX-11	●	●	10	10	10	120	12			0.2	SB-2570TR		FT-8								
	●	●	10	10	10		12			0.2				SB-4085TR		FT-15					
	●	●	12	12	12		16														
	●	●	16	16	16		20														

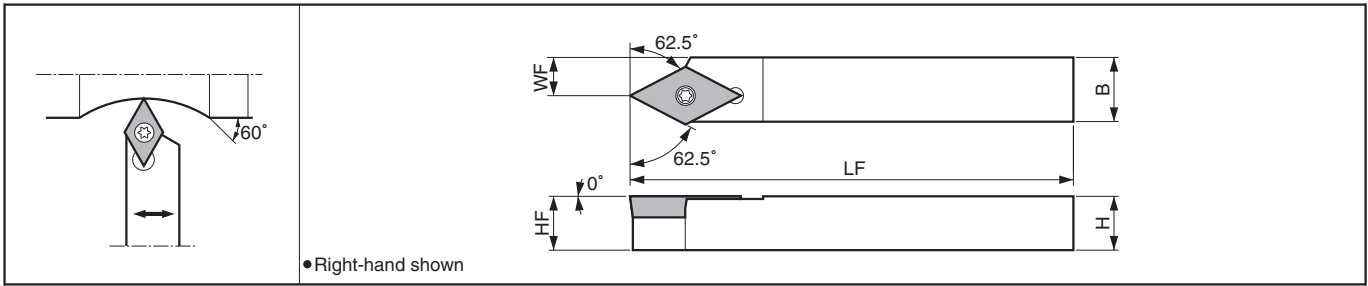
### Applicable Inserts

Applications See Page	Minute ap B62	Finishing B62	Finishing B62,B63	Finishing -	Finishing B63	Finishing - Medium B64	Finishing - Medium B63	Finishing B67	Finishing / Precision B66	Low Feed B68,B69
Insert	CF	GF	CK	WP (Wiper)	PP	GK	GQ	%-F	%-FSF	(E/F) %-U
Toolholder Description										
<b>SDLC<sup>R/L</sup>...-07FF</b> <b>SDXC<sup>R/L</sup>...-07</b>	DCGT0702..	DCGT0702..	DCGT0702..	-	DCMT0702..	DCMT0702..	DCGT0702..	DCGT0702..	DCET0702..	DCGT0702..
<b>SDLC<sup>R/L</sup>...-11FF</b> <b>SDXC<sup>R/L</sup>...-11</b>	DCGT11T3..	DCGT11T3..	DCGT11T3..	-	DCMT11T3..	DCMT11T3..	DCGT11T3..	DCGT11T3..	DCET11T3..	DCGT11T3..
Applications See Page	Low Feed / Precision B68	Low Feed B70,B71	Soft Steel / Finishing B65	Soft Steel / Finishing - Medium B65	Stainless Steel B65	Cast Iron B71	Non-ferrous Metals B71	Non-ferrous Metals B71	Non-ferrous Metals C25	Hard Materials C15
Insert	F%-USF	(E/F)%-J	XP	XQ	MQ	Without Chipbreaker	AH	%-A3	PCD	CBN
Toolholder Description										
<b>SDLC<sup>R/L</sup>...-07FF</b> <b>SDXC<sup>R/L</sup>...-07</b>	DCET0702..	DCET0702..	DCMT0702..	-	DCMT0702..	DCGW0702..	-	-	DCMT0702..	DCMW0702..
<b>SDLC<sup>R/L</sup>...-11FF</b> <b>SDXC<sup>R/L</sup>...-11</b>	DCET11T3..	DC_T11T3..	DCMT11T3..	DCMT11T3..	DCMT11T3..	DCGW11T3..	DCGT11T3..	DCGT11T3..	DCMT11T3..	DCMW11T3..

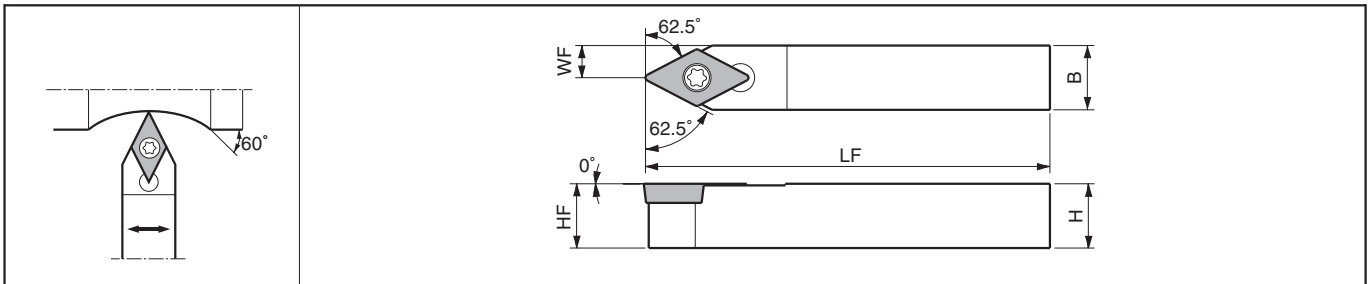
# External Toolholders [DC□□ Insert]

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## SDNC-F (External / Copying)



## SDNC (External / Copying)



### Toolholder Dimensions

Description	Stock			Dimension (mm)					Std. Corner-R(RE)	Spare Parts				
	R	N	L	H	HF	B	LF	WF		Clamp Screw	Wrench			
<b>SDNC<sup>F/L</sup> 1010JX-07F</b>	●		●	10	10	10	120	7	0.2					
<b>SDNCN 1010JX-07</b>		●		10	10	10	120	5	0.2					
<b>1212JX-07</b>		●		12	12	12		6						
<b>1010JX-11</b>		●		10	10	10		5	0.2					
<b>1212JX-11</b>		●		12	12	12		6						
<b>1616JX-11</b>		●		16	16	16		8						
<b>SDNCN 0808F -07</b>		●		8	8	8	85	4	0.2					
<b>SDNCN 1010F -11</b>		●		10	10	10	80	5	0.2					
<b>1212F -11</b>		●		12	12	12	85	6						
<b>1616H -11</b>		●		16	16	16	100	8						

### Applicable Inserts

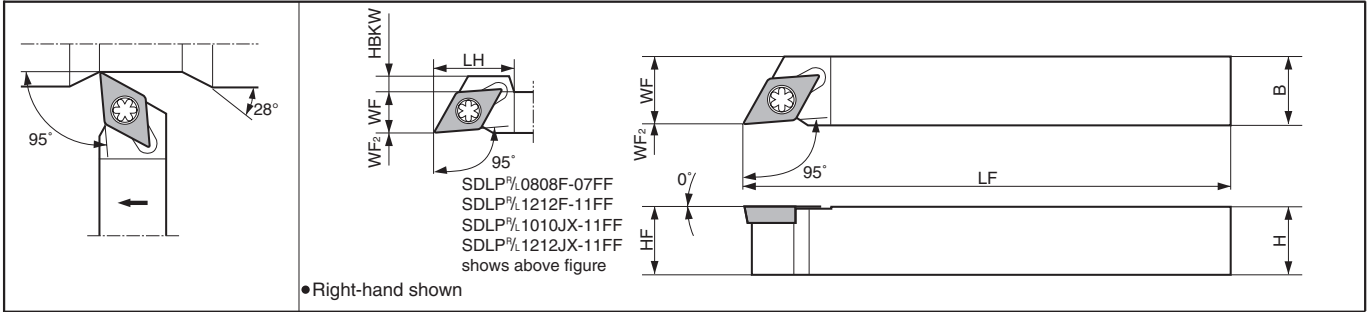
Applications	Minute ap	Finishing	Finishing	Finishing	Finishing	Finishing - Medium	Finishing - Medium	Finishing	Finishing / Precision	Low Feed
See Page	B62	B62	B62,B63	-	B63	B64	B63	B67	B66	B68,B69
Insert										
Toolholder Description	<b>SDNC<sup>F/L</sup>...-07F</b>	<b>SDNCN...-07</b>	<b>SDNCN...-11</b>							
	DCGT0702..	DCGT0702..	DCGT0702..	-	DCMT0702..	DCMT0702..	DCGT0702..	DCGT0702..	DCET0702..	DCGT0702..
	DCGT11T3..	DCGT11T3..	DCGT11T3..	-	DCMT11T3..	DCMT11T3..	DCGT11T3..	DCGT11T3..	DCET11T3..	DCGT11T3..
Applications	Low Feed / Precision	Low Feed	Soft Steel / Finishing	Soft Steel / Finishing - Medium	Stainless Steel	Cast Iron	Non-ferrous Metals	Non-ferrous Metals	Non-ferrous Metals	Hard Materials
See Page	B68	B70,B71	B65	B65	B65	B71	B71	B71	C25	C15
Insert										
Toolholder Description	<b>SDNC<sup>F/L</sup>...-07F</b>	<b>SDNCN...-07</b>	<b>SDNCN...-11</b>							
	DCET0702..	DCET0702..	DCMT0702..	-	DCMT0702..	DCGW0702..	-	-	DCMT0702..	DCMW0702..
	DCET11T3..	DC_T11T3..	DCMT11T3..	DCMT11T3..	DCMT11T3..	DCGW11T3..	DCGT11T3..	DCGT11T3..	DCMT11T3..	DCMW11T3..

Recommended Cutting Conditions E46

● : Std. Item

# External Toolholders [DP□□ Insert]

## SDLP-FF (Without Offset) (External / Copying)



### Toolholder Dimensions

Description	Stock		Dimension (mm)									Std. Corner-R(RE)	Spare Parts		
	R	L	H	HF	B	LF	LH	WF	HBKW	WF <sub>2</sub>	Clamp Screw		Wrench		
SDLP <sup>®</sup> /L 0808F -07FF	●	●	8	8	8	85	14	8	0.5	0	0.2	SB-2570TR	FT-8		
SDLP <sup>®</sup> /L 1010JX-07FF	●	●	10	10	10	120	-	10	-	0	0.2	SB-2570TR	FT-8		
SDLP <sup>®</sup> /L 1010JX-11FF	●	●	10	10	10		20	10	4		0.2	SB-4085TR	FT-15		
SDLP <sup>®</sup> /L 1212JX-11FF	●	●	12	12	12		-	12	2						
SDLP <sup>®</sup> /L 1616JX-11FF	●	●	16	16	16		-	16	-						

### Applicable Inserts

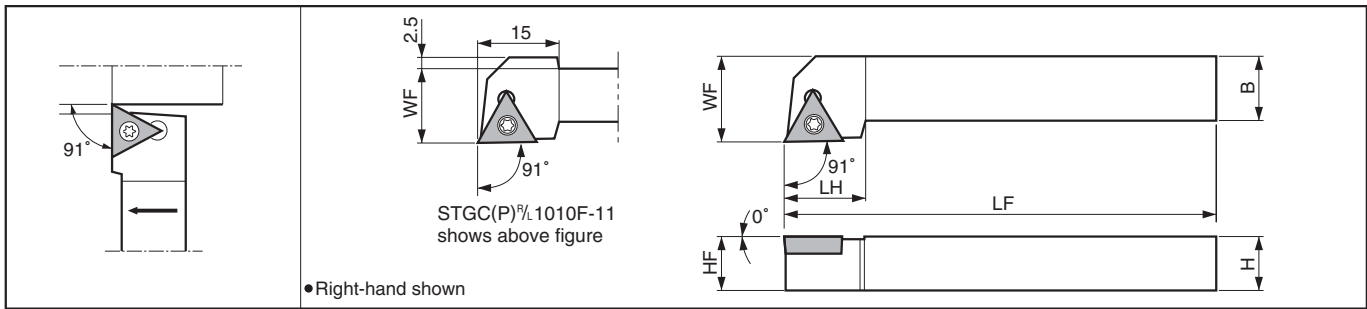
Applications See Page	Finishing / Precision B72	Low Feed / Precision B72											
Insert													
Toolholder Description													
SDLP <sup>®</sup> /L...-07FF	DPET0702..	DPET0702..											
SDLP <sup>®</sup> /L...-11FF	DPET11T3..	DPET11T3..											

Recommended Cutting Conditions E46

● : Std. Item

# External Toolholders [TC□□ / TP□□ Insert]

## STGC(P) (External)



### Toolholder Dimensions

Description	Stock		Dimension (mm)						Std. Corner-R (RE)	Spare Parts			
	R	L	H	HF	B	LF	LH	WF		Clamp Screw	Wrench		
STGC <sup>FL</sup> 0808E -08	●		8	8	8	70	12	10	0.2	SB-2050TR	FT-6		
	●	●	10	10	10	80		12					
STGC <sup>FL</sup> 1010F -11	●	●	10	10	10	80	15	14	0.4	SB-2570TR	FT-8		
	●	●	12	12	12	100		16					
	●	●	16	16	16			20					
	●	●	20	20	20			125				25	
	●	●	25	25	25			150				20	32
STGP <sup>FL</sup> 0808E -08	●		8	8	8	70	12	10	0.2	SB-2050TR	FT-6		
STGP <sup>FL</sup> 1010F -11	●	●	10	10	10	80	15	14	0.2	SB-3080TR	FT-10		
	●	●	12	12	12	100		16					
	●	●	16	16	16			20					

### Applicable Inserts (STGC)

Applications	Low Feed	Low Feed / Precision	Cast Iron	Non-ferrous Metals	Non-ferrous Metals				
See Page	<b>B78</b>	<b>B77</b>	<b>B79</b>	<b>B79</b>	<b>C26</b>				
Insert	(E/F) <sup>FL</sup> -U	F <sup>FL</sup> -USF	Without Chipbreaker	<sup>FL</sup> -A3	PCD				
Toolholder Description									
STGC <sup>FL</sup> ...-08	TCGT0802..	TCET0802..	TCGW0802..	-	TCMT0802..				
STGC <sup>FL</sup> ...-11	TCGT1103..	TCET1103..	TCGW1103..	TCGT1103..	TCMT1103.. TCGW1103..				

### Applicable Inserts (STGP)

Applications	Minute ap	Finishing	Finishing - Medium	Finishing	Finishing / Precision	Low Feed / Precision	Medium	Soft Steel / Finishing	Soft Steel / Finishing - Medium	Cast Iron
See Page	<b>B80</b>	<b>B80</b>	<b>B81</b>	<b>B82, B83</b>	<b>B85</b>	<b>B86</b>	<b>B84</b>	<b>B81</b>	<b>B81</b>	<b>B86</b>
Insert	CF	PP	HQ	<sup>FL</sup>	<sup>FL</sup> -FSF	F <sup>FL</sup> -USF	<sup>FL</sup> -H	XP	XQ	Without Chipbreaker
Toolholder Description										
STGP <sup>FL</sup> ...-08	TPGT0802..	-	-	TPGH0802..	TPET0802..	TPET0802..	-	-	-	TPGB0802..
STGP <sup>FL</sup> ...-11	-	TPMT1103..	TPMT1103..	TPGH1103..	TPET1103..	TPET1103..	TPGH1103..	TPMT1103..	TPMT1103..	TPGB1103..
Applications	Non-ferrous Metals	Hard Materials								
See Page	<b>C26-C28</b>	<b>C16</b>								
Insert	PCD	CBN								
Toolholder Description										
STGP <sup>FL</sup> ...-08	TPMH0802.. TPGB0802..	TPGB0802..								
STGP <sup>FL</sup> ...-11	TPMH1103.. TPGB1103..	TPGB1103..								

Recommended Cutting Conditions E46

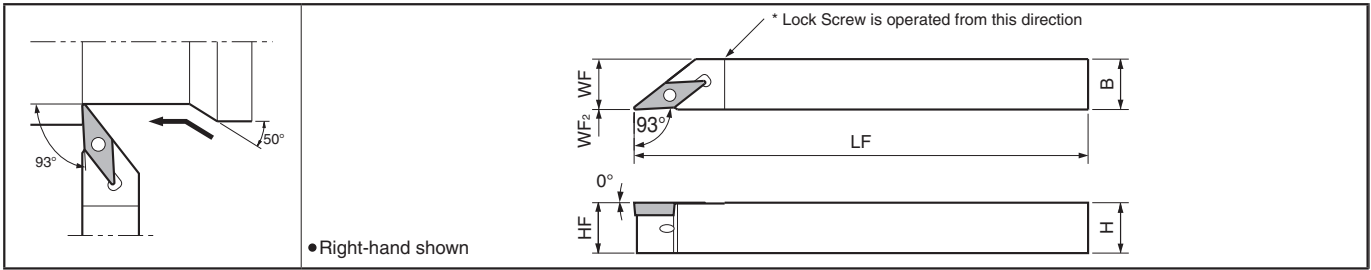
● : Std. Item

Insert Grades  
 Turnings  
 Indexable Inserts  
 CBN & PCD Tools  
 External  
 Small Parts  
 Machining  
 Boring  
 Grooving  
 Cut-off  
 Threading  
 Drilling  
 Solid Tools  
 Milling  
 Tools for  
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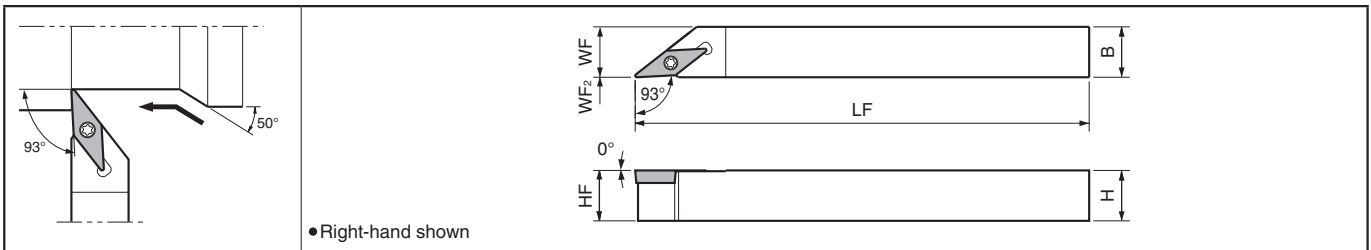
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# External Toolholders [VB□□ / VC□□ Insert]

## AVJB-FF (Without Offset) (External / Copying)



## SVJB-FF (Without Offset) (External / Copying)

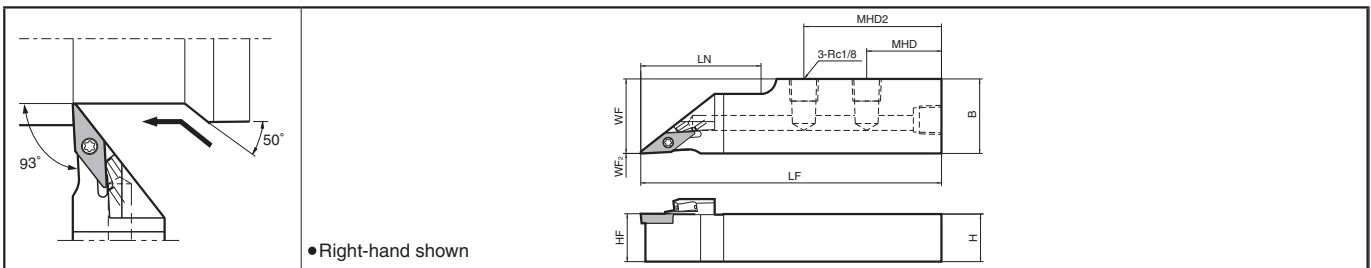


### Toolholder Dimensions

Description	Stock		Dimension (mm)						Std. Corner-R(RE)	Spare Parts				
	R	L	H	HF	B	LF	WF	WF <sub>2</sub>		Anchor Pin	Lock Screw	Clamp Screw	Wrench	
AVJB <sup>R/L</sup>	1010JX-11FF	●	●	10	10	10	120	10	0	0.4	LPF-11	HSB4X8 <sup>R/L</sup>	-	FH-2
	1212JX-11FF	●	●	12	12	12		12			LPF-1113			
	1616JX-11FF	●	●	16	16	16		16			LPF-1117			
SVJB <sup>R/L</sup>	1010JX-11FF	●	●	10	10	10	120	10	0	0.4	-	-	SB-2570TR	FT-8
	1212JX-11FF	●	●	12	12	12		12						
	1616JX-11FF	●	●	16	16	16		16						
	2020JX-11FF	●	●	20	20	20		20						

Lock Screw : HSB4X8R for Right-hand Toolholder, HSB4X8L for Left-hand Toolholder.

## SVJB-FFJCT



### Toolholder Dimensions

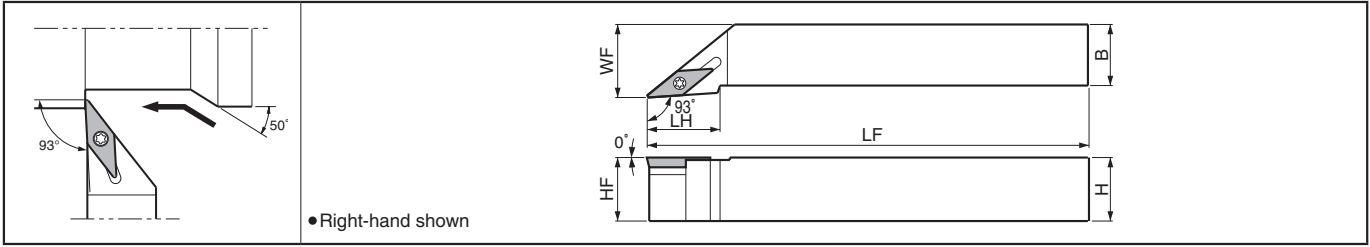
Description	Stock		Dimension (mm)									Std. Corner-R(RE)	Spare Parts		
	R	L	H	HF	B	LF	LN	WF	WF <sub>2</sub>	MHD	MHD2		Clamp Screw	Wrench	Plug
SVJBR	1220H-11FFJCT	●		12	12	20	100	28	20	0	35	-	SB-2570TR	FT-8	GP-1
	1625H-11FFJCT	●		16	16	25		40	25		25	46			
	2025H-11FFJCT	●		20	20	25		40	25		25	46			

Please see page H14 and H15 for piping parts of coolant-through holders.

● : Std. Item

# External Toolholders [VB□□ / VC□□ Insert]

## SVJB (External / Copying)

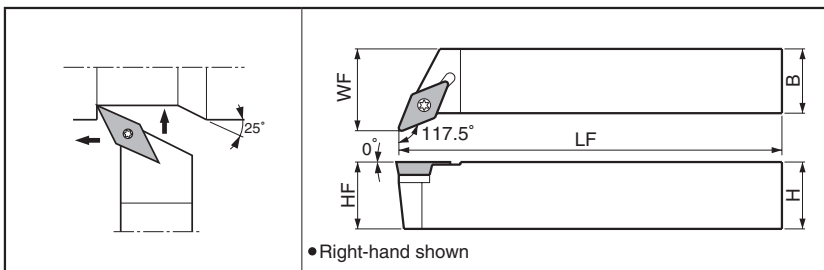


### Toolholder Dimensions

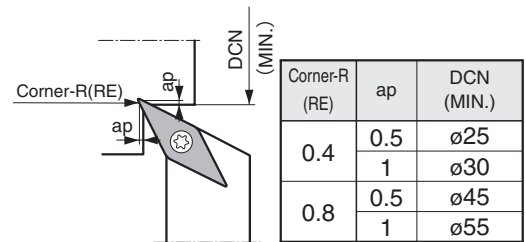
Description	Stock		Dimension (mm)							Std. Corner-R(RE)	Spare Parts				
	R	L	H	HF	B	LF	LH	WF	Clamp Screw		Wrench	Shim	Shim Screw	Wrench	
SVJB <sup>9/L</sup> 2020K-11	●	●	20	20	20	125	30	25	0.4	SB-2570TR	FT-8	-	-	-	
	●	●	25	25	25	150	35	32							
SVJB <sup>9/L</sup> 2020K-16N	●	●	20	20	20	125	30	25	0.8	SB-40125TRN	FT-15	SVN-32N *(SVN-32S)	SS-4N	LW-4	
	●	●	25	25	25	150		32							

For insert with corner-R(RE) 0.2 or 0.4, shim of marked \* is recommended (sold separately).

## SVPB (External / Facing / Copying / Undercutting)



### Undercutting diameter of SVPB



### Toolholder Dimensions

Description	Stock		Dimension (mm)							Std. Corner-R(RE)	Spare Parts				
	R	L	H	HF	B	LF	WF	Clamp Screw	Wrench		Shim	Shim Screw	Wrench		
SVPB <sup>9/L</sup> 1010JX-11	●	●	10	10	10	120	14.5	0.4	SB-2570TR	FT-8	-	-	-		
	●	●	12	12	12		16.5								
	●	●	16	16	16		20.5								
SVPB <sup>9/L</sup> 2020K-11	●	●	20	20	20	125	25	0.4	SB-2570TR	FT-8	-	-	-		
	●	●	25	25	25	150	32								
SVPB <sup>9/L</sup> 2020K-16N	●	●	20	20	20	125	25	0.8	SB-40125TRN	FT-15	SVN-32N *(SVN-32S)	SS-4N	LW-4		
	●	●	25	25	25	150	32								

For insert with corner-R(RE) 0.2 or 0.4, shim of marked \* is recommended (sold separately).

### Applicable Inserts

Applications	Finishing	Finishing	Finishing - Medium	Finishing	Finishing / Precision	Finishing - Medium	Non-ferrous Metals	Non-ferrous Metals	Non-ferrous Metals	Hard Materials
See Page	B89	B89	B89	B90	B89	B91	B93	B93	C28	C17
Insert	GP	VF	HQ	9/L-F	9/L-FSF	9/L-Y	AH	9/L-A3	PCD	CBN
Toolholder Description										
□ VJB <sup>9/L</sup> ...-11FF(JCT)/-11	VBMT1103..	VBMT1103..	VBMT1103..	VBGT1103..	VBET1103..	VBGT1103..	-	-	VBMT1103..	VBGW1103..
SVPB <sup>9/L</sup> ...-11	VBMT1103..	VBMT1103..	VBMT1103..	VBGT1103..	VBET1103..	VBGT1103..	-	-	VBMT1103..	VBGW1103..
SVJB <sup>9/L</sup> ...-16 N	VBMT1604..	VBMT1604..	VBMT1604..	-	-	VBGT1604..	VCGT1604..	VCGT1604..	VBMT1604..	VBGW1604..
SVPB <sup>9/L</sup> ...-16 N	VBMT1604..	VBMT1604..	VBMT1604..	-	-	VBGT1604..	VCGT1604..	VCGT1604..	VBMT1604..	VBGW1604..

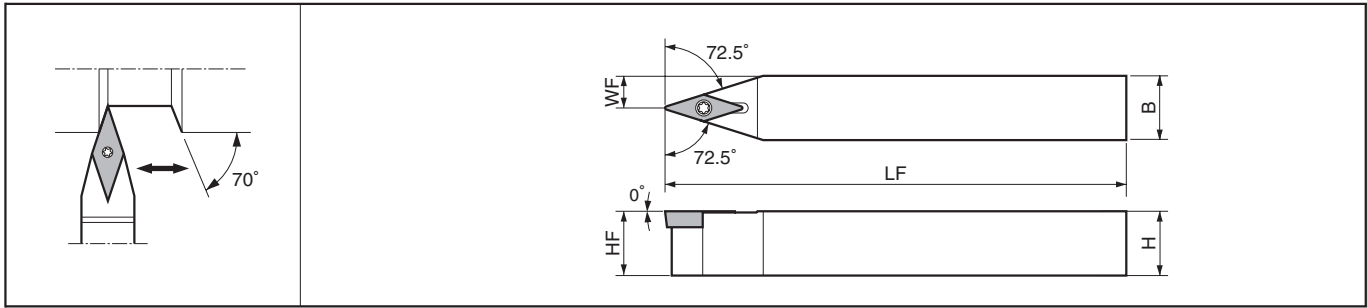
Recommended Cutting Conditions E46

● : Std. Item

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# External Toolholders [VB□□ / VC□□ Insert]

## SVVB (External / Copying)



### Toolholder Dimensions

Description	Stock	Dimension (mm)					Std. Corner-R(RE)	Spare Parts				
		H	HF	B	LF	WF		Clamp Screw	Wrench	Shim	Shim Screw	Wrench
SVVBN 1212F-11	●	12	12	12	85	6	0.4	SB-2570TR	FT-8	-	-	-
SVVBN 1010JX-11	●	10	10	10	120	5						
SVVBN 1212JX-11	●	12	12	12		6						
SVVBN 1616JX-11	●	16	16	16		8						
SVVBN 1010F-11	●	10	10	10	80	5	0.4	SB-2570TR	FT-8	-	-	-
SVVBN 1616H-11	●	16	16	16	100	8						
SVVBN 2020K-11	●	20	20	20	125	10						
SVVBN 2525M-11	●	25	25	25	150	12.5						
SVVBN 2020K-16N	●	20	20	20	125	10	0.8	SB-40125TRN	FT-15	SVN-32N *(SVN-32S)	SS-4N	LW-4
SVVBN 2525M-16N	●	25	25	25	150	12.5						

\* For insert with corner-R(RE) 0.2 or 0.4, shim of marked \* is recommended (sold separately).

### Applicable Inserts

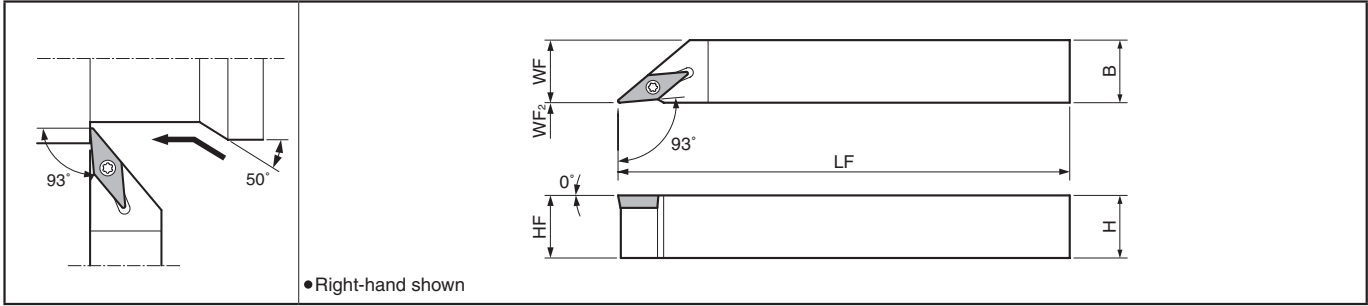
Applications	Finishing	Finishing	Finishing - Medium	Finishing	Finishing / Precision	Finishing - Medium	Non-ferrous Metals	Non-ferrous Metals	Non-ferrous Metals	Hard Materials
See Page	B89	B89	B89	B90	B89	B91	B93	B93	C28	C17
Insert	GP	VF	HQ	½-F	¾-FSF	¾-Y	AH	¾-A3	PCD	CBN
Toolholder Description										
SVVBN...-11	VBMT1103..	VBMT1103..	VBMT1103..	VBGT1103..	VBET1103..	VBGT1103..	-	-	VBMT1103..	VBGW1103..
SVVBN...-16N	VBMT1604..	VBMT1604..	VBMT1604..	-	-	VBGT1604..	VCGT1604..	VCGT1604..	VBMT1604..	VBGW1604..

Recommended Cutting Conditions E46

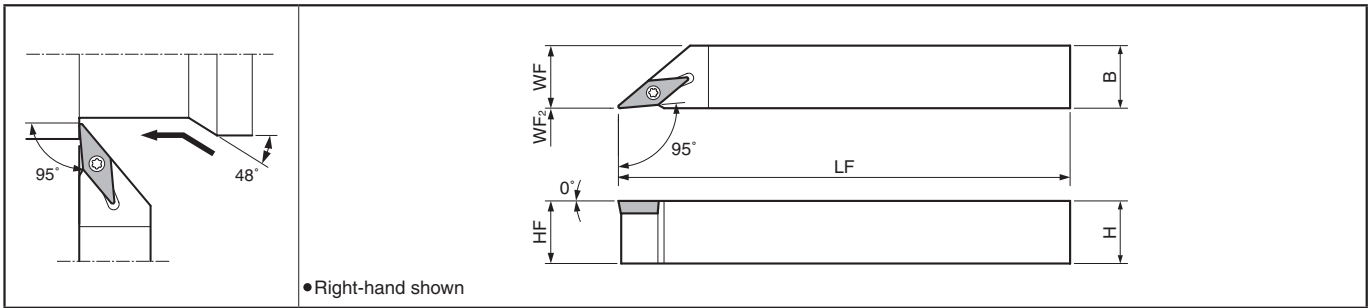


# External Toolholders [VC□□ Insert]

## SVJC-FF (Without Offset) (External / Copying)



## SVLC-FF (Without Offset) (External / Copying)



### Toolholder Dimensions

Description	Stock		Dimension (mm)						Std. Corner-R(RE)	Spare Parts				
	R	L	H	HF	B	LF	WF	WF <sub>2</sub>		Clamp Screw	Wrench			
SVJC <sup>R/L</sup>	1010JX-11FF	●	●	10	10	10	120	10	0	0.2	SB-2570TR	FT-8		
	1212F-11FF	●	●	12	12	12	85	12						
	1212JX-11FF	●	●	12	12	12		12						
	1616JX-11FF	●	●	16	16	16	120	16						
	2020JX-11FF	●	●	20	20	20		20						
SVLC <sup>R/L</sup>	1212F-11FF	●	●	12	12	12	85	12	0	0.2	SB-2570TR	FT-8		
	1212JX-11FF	●	●	12	12	12	120	12						
	1616JX-11FF	●	●	16	16	16	120	16						

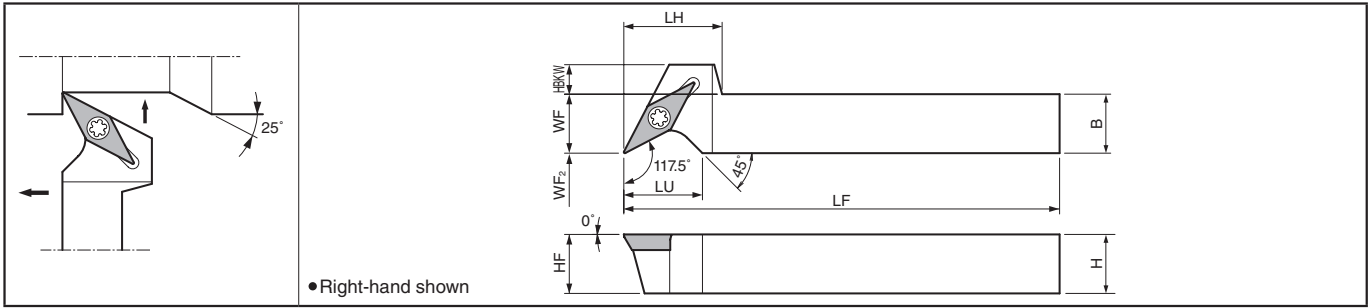
### Applicable Inserts

Applications	Minute ap	Finishing	Finishing	Finishing - Medium
See Page	B92	B92	B93	B93
Insert	CF	GF	%/L-F	%/L-Y
Toolholder Description				
SVJC <sup>R/L</sup> ...11FF	VCGT1103..	VCGT1103..	VCET1103..	VCET1103..
SVLC <sup>R/L</sup> ...11FF				

Recommended Cutting Conditions E46

# External Toolholders [VC□□ Insert]

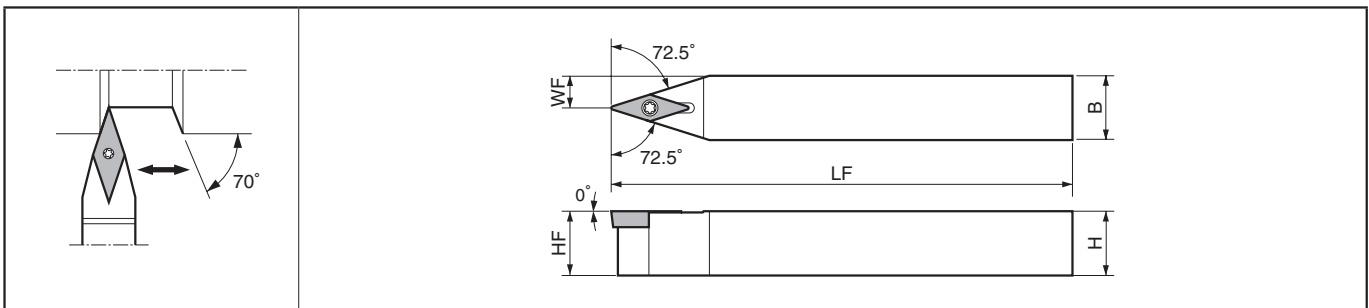
## SVPC-FF (Without Offset) (External / Facing / Copying / Undercutting)



### Toolholder Dimensions

Description	Stock	Dimension (mm)									Std. Corner(R/E)	Spare Parts		
		H	HF	B	LF	LU	LH	WF	HBKW	WF <sub>2</sub>		Clamp Screw	Wrench	
SVPCR	1010JX-11FF	●	10	10	10	120	16	20	10	8	0.2	SB-2570TR	FT-8	
	1212F-11FF	●	12	12	12	85			12	6				
	1212JX-11FF	●	12	12	12	120	20	16	2					
	1616JX-11FF	●	16	16	16	120	20	16	2					

## SVVC (External / Copying)



### Toolholder Dimensions

Description	Stock	Dimension (mm)						Std. Corner(R/E)	Spare Parts			
		H	HF	B	LF	WF	Clamp Screw		Wrench			
SVVCN	1010JX-11	●	10	10	10	120	5	0.2	SB-2570TR	FT-8		
	1212JX-11	●	12	12	12		6					
	1616JX-11	●	16	16	16		8					

### Applicable Inserts

Applications	Minute ap	Finishing	Finishing	Finishing - Medium
See Page	B92	B92	B93	B93
Insert	CF	GF	%/L-F	%/L-Y
Toolholder Description				
SVPCR...11FF	VCGT1103..	VCGT1103..	VCET1103..R-F	VCET1103..R-Y
SVVCN...11	VCGT1103..	VCGT1103..	VCET1103..%/L-F	VCET1103..%/L-Y

Recommended Cutting Conditions ● E46

# External Toolholders [VP□□ Insert]

Insert Grades  
 Turning  
 Indexable Inserts  
 CBN & PC-D Tools  
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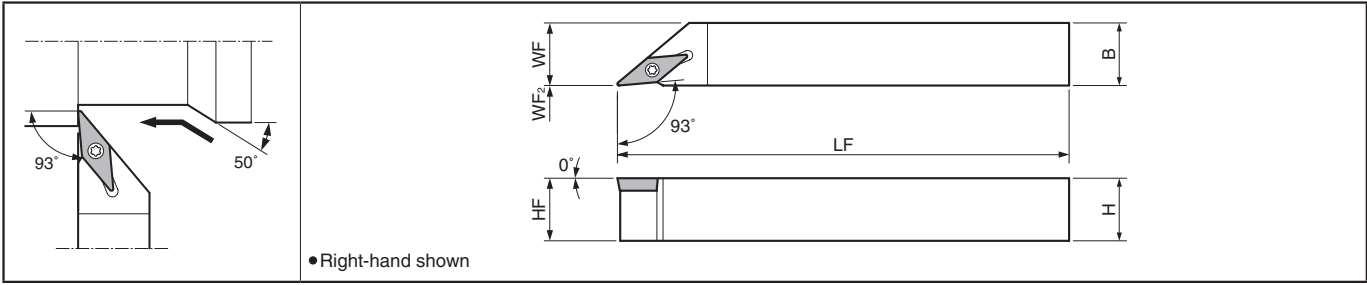
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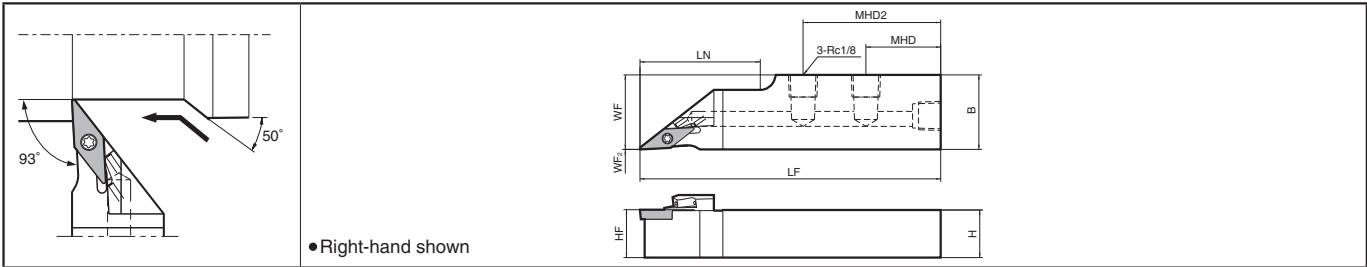
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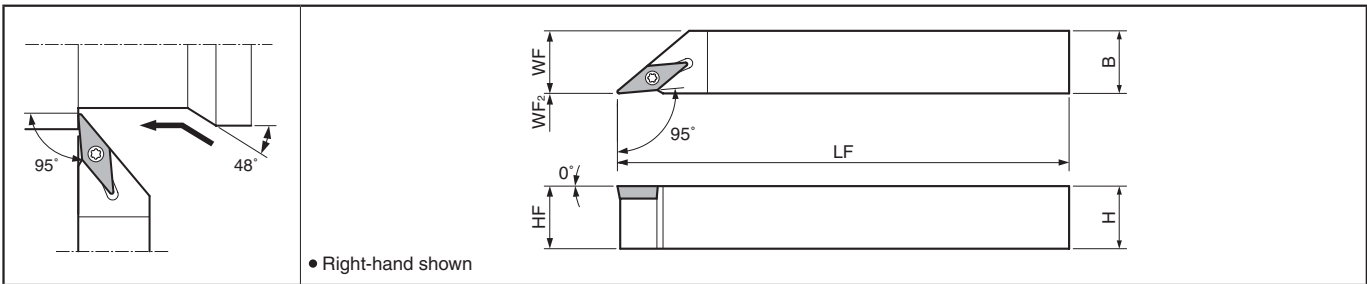
## SVJP-FF (Without Offset) (External / Copying)



## SVJP-FFJCT (Without Offset) (External / Copying, Coolant-through Holders)



## SVLP-FF (Without Offset) (External / Copying)



### Toolholder Dimensions

Description	Stock		Dimension (mm)									Std. Corner-R(RE)	Spare Parts			
	R	L	H	HF	B	LF	LN	WF	WF <sub>2</sub>	MHD	MHD2		Clamp Screw	Wrench	Plug	
SVJP <sup>R/L</sup> 1212F -11FF 1212JX -11FF 1616JX -11FF 2020JX -11FF	●	●	12	12	12	85		12					0.2	SB-2570TR	FT-8	-
	●	●	12	12	12		-	12	0	-	-					
	●	●	16	16	16	120		16								
	●	●	20	20	20			20								
SVJPR 1220H-11FFJCT 1625H-11FFJCT 2025H-11FFJCT	●		12	12	20		28	20		35	-	0.2	SB-2570TR	FT-8	GP-1	
	●		16	16	25	100	40	25	0	25	46					
	●		20	20	25		40	25		25	46					
SVLP <sup>R/L</sup> 1010JX -08FF 1212JX -08FF 1616JX -08FF	●	●	10	10	10			10				0.1	SB-2050TR	FT-6	-	
	●	●	12	12	12	120	-	12	0	-	-					
	●	●	16	16	16			16								
SVLP <sup>R/L</sup> 1212JX -11FF 1616JX -11FF	●	●	12	12	12	120	-	12	0	-	-	0.2	SB-2570TR	FT-8	-	
	●	●	16	16	16			16								
SVLP <sup>R/L</sup> 1212F -08FF 1212F -11FF	●	●	12	12	12	85		12	0			0.1	SB-2050TR	FT-6	-	
	●	●	12	12	12	85		12	0							0.2

Please see page H14 and H15 for piping parts of coolant-through holders.

### Applicable Inserts

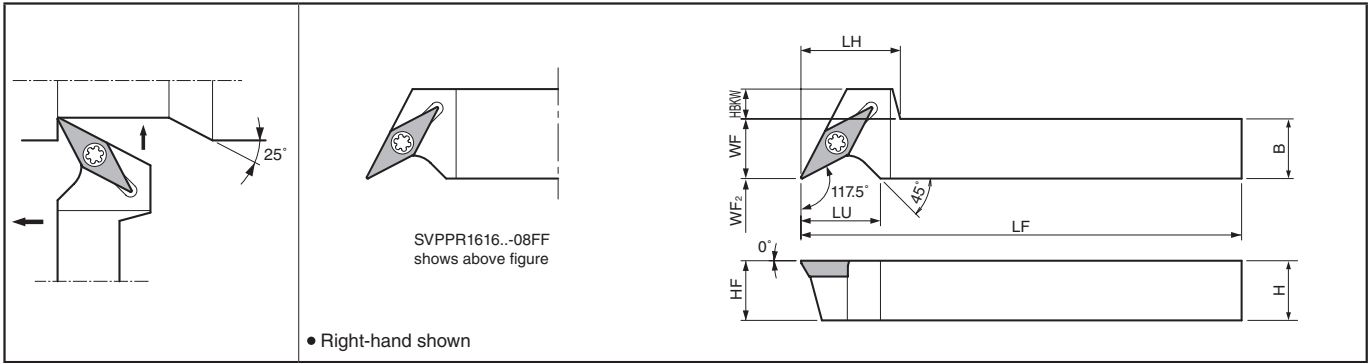
Applications	Minute ap	Finishing	Finishing	Finishing / Precision	Low Feed	Low Feed / Precision			
See Page	B94	B94	B94	B95	B96	B96			
Insert	CF	CK	GF	F/L-FSF	F/L-U	F/L-USF			
Toolholder Description									
SVLP <sup>R/L</sup> ...-08FF	-	VPGT0802..	-	VPET0802..	-	VPET0802..			
SV <sup>□</sup> P <sup>R/L</sup> ...-11FF	VPGT1103..	VPGT1103..	VPGT1103..	VPET1103..	VPET1103..	VPET1103..			

Recommended Cutting Conditions E46

● : Std. Item

# External Toolholders [VP□□ Insert]

## SVPP-FF (Without Offset) (External / Facing / Copying / Undercutting)



### Toolholder Dimensions

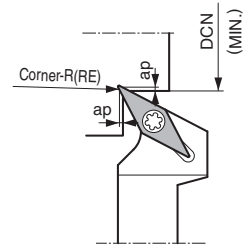
Description	Stock	Dimension (mm)										Std. Corner-R(RE)	Spare Parts	
		H	HF	B	LF	LU	LH	WF	HBKW	WF <sub>2</sub>	Clamp Screw		Wrench	
SVPPR 1010JX-08FF 1212JX-08FF 1616JX-08FF	●	10	10	10	120	12	16	10	4	0	0.1	SB-2050TR	FT-6	
	●	12	12	12				12	2					
	●	16	16	16				-	-					
SVPPR 1010JX-11FF 1212JX-11FF 1616JX-11FF	●	10	10	10	120	16	20	10	8	0	0.2	SB-2570TR	FT-8	
	●	12	12	12				12	6					
	●	16	16	16				16	2					
SVPPR 1212F -08FF 1212F -11FF	●	12	12	12	85	12	16	12	2	0	0.1	SB-2050TR	FT-6	
	●	12	12	12	85	16	20	12	6	0	0.2	SB-2570TR	FT-8	

### Applicable Inserts

Applications See Page	Minute ap	Finishing	Finishing	Finishing / Precision	Low Feed	Low Feed / Precision
	B94	B94	B94	B95	B96	B96
Insert	CF	CK	GF	¾/-FSF	F¾/-U	F¾/-USF
Toolholder Description						
SVPPR...-08FF	-	VPGT0802..	-	VPET0802..	-	VPET0802..
SVPPR...-11FF	VPGT1103..	VPGT1103..	VPGT1103..	VPET1103..	VPET1103..	VPET1103..

Recommended Cutting Conditions ➔ E46

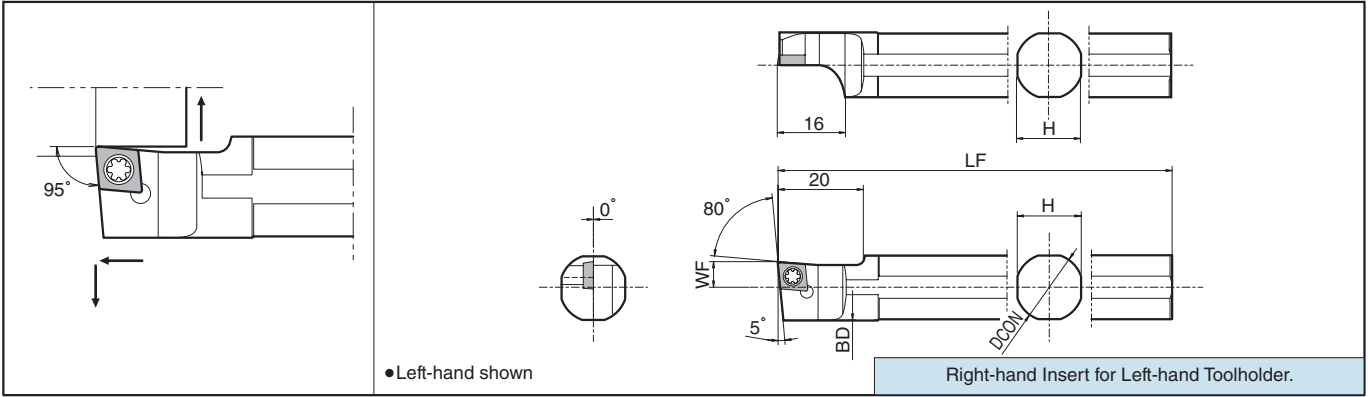
### Undercutting diameter of SVPP-FF



Corner-R (RE)	ap	DCN (MIN.)
0.2	0.5	ø20
	1	ø25

# External Sleeve Holders [CC□□ Insert]

## S-SCLC (External / Facing)



### Toolholder Dimensions

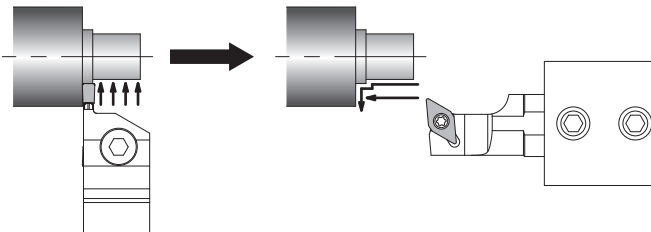
Description	Stock	Dimension (mm)					Std. Corner-R(RE)	Spare Parts	
		DCON	LF	WF	BD	H		Clamp Screw	Wrench
S12F -SCLCL06	●	12	80	6	13.4	11	0.4	SB-2560TR	FT-8
S14H -SCLCL06	●	14	100		13				
S15F -SCLCL06	●	15.875	85		15.4	15			
S16F -SCLCL06	●	16	90		18.4	17			
S19G -SCLCL06	●	19.05	120		19.4	18			
S19K -SCLCL06	●	20	90		19.4	18			
S20G -SCLCL06	●	20	120	10	18.4	17	0.4	SB-4065TR	FT-15
S20K -SCLCL06	●	19.05	90		19.4	18			
S19G -SCLCL09	●	19.05	120		24.4	23			
S19K -SCLCL09	●	20	90		24.8				
S20G -SCLCL09	●	20	120						
S20K -SCLCL09	●	25	100						
S25.0H-SCLCL09	●	25.4	120						
S25K -SCLCL09	●	25.4	120						

### Applicable Inserts

Applications	Finishing	Finishing - Medium	Finishing - Medium	Low Feed	Stainless Steel	Cast Iron	Non-ferrous Metals	Non-ferrous Metals	Non-ferrous Metals	Hard Materials
See Page	B53	B54	B53,B54	B58,B59	B55	B60	B60	B60	C24	C14
Insert	GF	GK	GQ	(E/F)R-U	MQ	Without Chipbreaker	AH	R-A3	PCD	CBN
S-SCLCL06	CCGT0602..	CCMT0602..	CCGT0602..	CCGT0602..	-	CCGW0602..	-	-	CCMT0602.. CCGW0602..	CCMW0602..
S-SCLCL09	CCGT09T3..	CCMT09T3..	CCGT09T3..	CCGT09T3..	CCMT09T3..	CCGW09T3..	CCGT09T3..	CCGT09T3..	CCMT09T3.. CCGW09T3..	CCMW09T3..

Recommended Cutting Conditions **E46**

### Finishing by Sleeve Holder



- 1) Roughing by grooving toolholder
- 2) Finishing by Sleeve Holder improves chip control and reduces cutting time

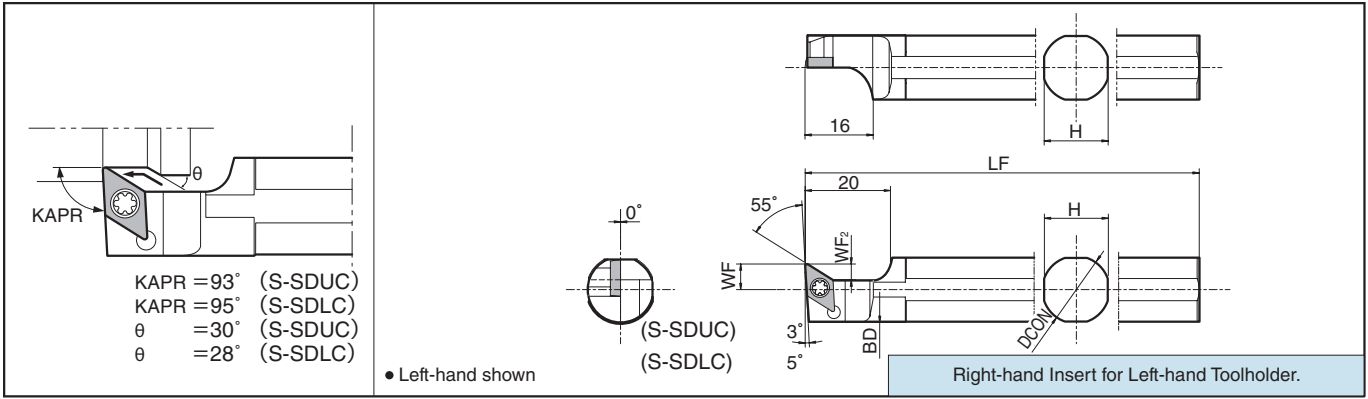
● : Std. Item

Insert Grades  
Turning  
Indexable Inserts  
CBN & PCD Tools  
External  
Machining  
Small Parts  
Boring  
Grooving  
Cut-off  
Threading  
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# External Sleeve Holder [DC□□ Insert]

## S-SDUC (External / Copying) / S-SDLCL (External / Copying)



### Toolholder Dimensions

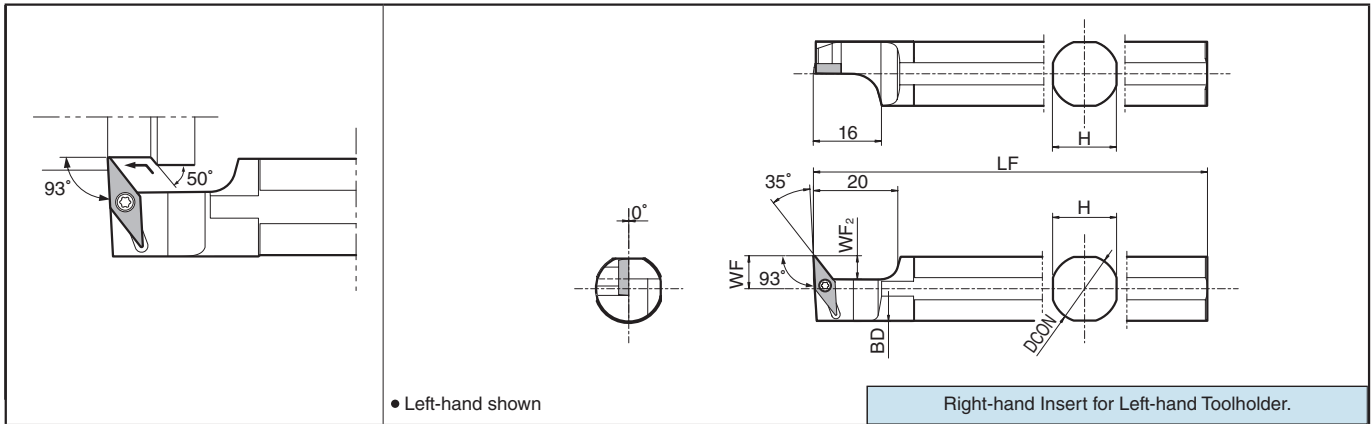
Description	Stock	Dimension (mm)						Std. Corner-R(RE)	Spare Parts		
		DCON	LF	WF	BD	H	WF <sub>2</sub>		Clamp Screw	Wrench	
S14H -SDUCL07	●	14	100	6	13.4	13	3.8	0.4	SB-2560TR	FT-8	
S15F -SDUCL07	●	15.875	85		15.4	15					
S19G -SDUCL07	●	19.05	90		18.4	17					
S19K -SDUCL07	●		120		19.4	18					
S20G -SDUCL07	●	20	90		18.4	17					
S20K -SDUCL07	●		120		19.4	18					
S19G -SDUCL11	●	19.05	90	18.4	17	5.8	0.4	SB-4085TR	FT-15		
S19K -SDUCL11	●		120	19.4	18						
S20G -SDUCL11	●	20	90	21.4	20						
S20K -SDUCL11	●		120	24.4	23						
S22K -SDUCL11	●	22	120	24.8	23						
S25.0H-SDUCL11	●	25	100								
S25K -SDUCL11	●	25.4	120								
S12F -SDLCL07	●	12	80	6	13.4	11	3.8	0.4	SB-2560TR	FT-8	
S14H -SDLCL07	●	14	100		15.4	15					
S15F -SDLCL07	●	15.875	85		18.4	17					
S16F -SDLCL07	●	16	90		19.4	18					
S19G -SDLCL07	●	19.05	90		18.4	17					
S19K -SDLCL07	●		120		19.4	18					
S20G -SDLCL07	●	20	90	18.4	17	5.8	0.4	SB-4085TR	FT-15		
S20K -SDLCL07	●		120	19.4	18						
S19G -SDLCL11	●	19.05	90	21.4	20						
S19K -SDLCL11	●		120	24.4	23						
S20G -SDLCL11	●	20	90	24.8	23						
S20K -SDLCL11	●		120								
S22K -SDLCL11	●	22	120								
S25.0H-SDLCL11	●	25	100								
S25K -SDLCL11	●	25.4	120								

### Applicable Inserts

Applications	Minute ap	Finishing	Finishing	* Finishing	Finishing	Finishing - Medium	Finishing - Medium	Finishing	Finishing / Precision	Low Feed
See Page	B62	B62	B62,B63	B63	B63	B64	B63	B67	B66	B68,B69
Insert	CF	GF	CK	WP (Wiper)	PP	GK	GQ	R-F	R-FSF	(E/F) R-U
Toolholder Description										
S-SD□CL07	DCGT0702..	DCGT0702..	DCGT0702..	DCMX0702..	DCMT0702..	DCMT0702..	DCGT0702..	DCGT0702..	DCET0702..	DCGT0702..
S-SD□CL11	DCGT11T3..	DCGT11T3..	DCGT11T3..	DCMX11T3..	DCMT11T3..	DCMT11T3..	DCGT11T3..	DCGT11T3..	DCET11T3..	DCGT11T3..
Applications	Low Feed / Precision	Low Feed	Soft Steel / Finishing	Soft Steel / Finishing - Medium	Stainless Steel	Cast Iron	Non-ferrous Metals	Non-ferrous Metals	Non-ferrous Metals	Hard Materials
See Page	B68	B70,B71	B65	B65	B65	B71	B71	B71	C25	C15
Insert	FR-USF	(E/F)R-J	XP	XQ	MQ	Without Chipbreaker	AH	R-A3	PCD	CBN
Toolholder Description										
S-SD□CL07	DCET0702..	DCET0702..	DCMT0702..	-	DCMT0702..	DCGW0702..	-	-	DCMT0702..	DCMW0702..
S-SD□CL11	DCET11T3..	DC_T11T3..	DCMT11T3..	DCMT11T3..	DCMT11T3..	DCGW11T3..	DCGT11T3..	DCGT11T3..	DCMT11T3..	DCMW11T3..

# External Sleeve Holder [VB□□ / VC□□ Insert]

## S-SVUB(C) (External / Copying)



### Toolholder Dimensions

Description	Stock	Dimension (mm)						Std. Corner-R(RE)	Spare Parts			
		DCON	LF	WF	BD	H	WF <sub>2</sub>		Clamp Screw	Wrench		
S12F -SVUCL08	●	12	80	7.5	13.4	11	5.5	0.4	SB-2050TR	FT-6		
S14H -SVUCL08	●	14	100								13	
S15F -SVUCL08	●	15.875	85	8	15.4	15	8	0.4	SB-2570TR	FT-8		
S16F -SVUCL08	●	16										
S19G -SVUBL11	●	19.05	90	10.5	18.4	17	8	0.4	SB-2570TR	FT-8		
S19K -SVUBL11	●		120									
S20G -SVUBL11	●	20	90	10.5	19.4	18	8	0.4	SB-2570TR	FT-8		
S20K -SVUBL11	●		120									
S25.0H-SVUBL11	●	25	100	10.5	24.4	23	8	0.2	SB-2570TR	FT-8		
S25K -SVUBL11	●	25.4	120								24.8	
S19G -SVUCL11	●	19.05	90	10.5	18.4	17	8	0.2	SB-2570TR	FT-8		
S19K -SVUCL11	●		120									
S20G -SVUCL11	●	20	90	10.5	19.4	18	8	0.2	SB-2570TR	FT-8		
S20K -SVUCL11	●		120									
S25.0H-SVUCL11	●	25	100	10.5	24.4	23	8	0.2	SB-2570TR	FT-8		
S25K -SVUCL11	●	25.4	120								24.8	

### Applicable Inserts

Applications	Minute ap	Finishing	Finishing	Finishing	Finishing - Medium	Finishing	Finishing / Precision	Finishing - Medium	Non-ferrous Metals	Hard Materials
See Page	B92	B92	B89	B89,B92	B89,B92	B90,B93	B89	B91,B93	C28	C17
Insert	CF	GF	GP	VF	HQ	R-F	R-FSF	R-Y	PCD	CBN
Toolholder Description										
S-SVUCL08	-	-	-	VCMT0802..	VCMT0802..	-	-	-	VCMT0802..	VCGW0802..
S-SVUBL11	-	-	VBMT1103..	VBMT1103..	VBMT1103..	VBGT1103..	VBET1103..	VBGT1103..	VBMT1103..	VBGW1103..
S-SVUCL11	VCGT1103..	VCGT1103..	-	-	-	VCET1103..	-	VCET1103..	-	-

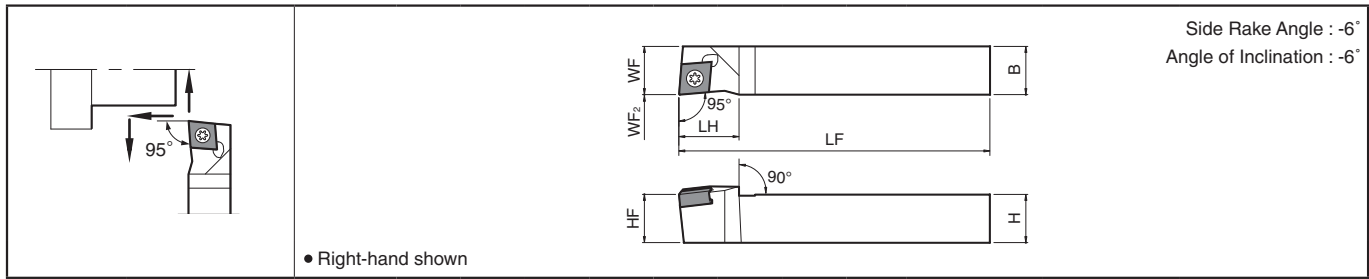
Recommended Cutting Conditions E46

● : Std. Item

Insert Grades  
 Turning  
 Indexable Inserts  
 CBN & PCD Tools  
 External  
 Small Parts  
 Machining  
 Boring  
 Grooving  
 Cut-off  
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# Toolholders for Small Double Sided Tooling

## SCLN (Without Offset) (External / Facing)



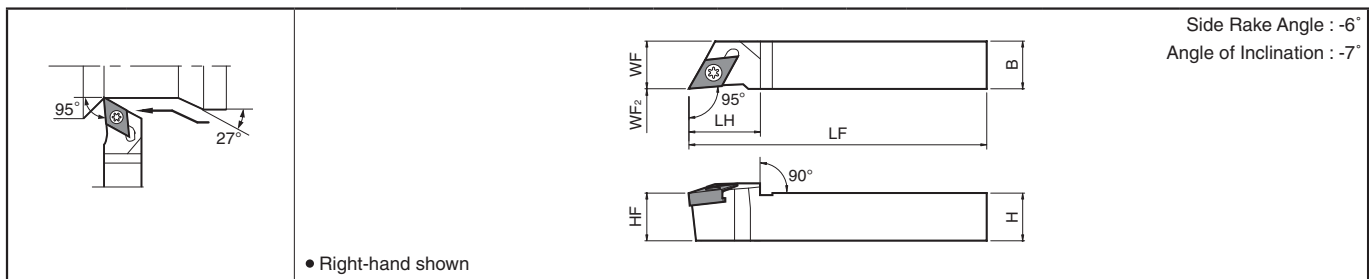
### Toolholder Dimensions

Description	Stock	Dimension (mm)							Std. Corner-R(RE)	Spare Parts		Applicable Inserts
		H	HF	B	LF	LH	WF	WF <sub>2</sub>		Clamp Screw	Wrench	
<b>SCLNR 1010K-07FF</b>	●	10	10	10	120	15	10	0	0.2	SB-3080TR	LTW-10SS	CNGU0703.. CNMU0703..
<b>1212F-07FF</b>	●	12	12	12	85		12					
<b>1212K-07FF</b>	●				120							
<b>1616K-07FF</b>	●	16	16	16	120	16						

### Applicable Inserts

Applications	Finishing - Medium	Medium - Roughing	Finishing	Low Feed
See Page	<b>B50</b>	<b>B50</b>	<b>B50</b>	<b>B50</b>
Insert	<b>SK</b> 	<b>GK</b> 	<b>FR-F</b> 	<b>(F/E)R-U</b> 
Toolholder Description	<b>SCLNR...-07FF</b>			
	CNGU0703..	CNMU0703..	CNGU0703..	CNGU0703..

## SDLN (Without Offset) (External / Copying)



### Toolholder Dimensions

Description	Stock	Dimension (mm)							Std. Corner-R(RE)	Spare Parts		Applicable Inserts
		H	HF	B	LF	LH	WF	WF <sub>2</sub>		Clamp Screw	Wrench	
<b>SDLNR 1010K-08FF</b>	●	10	10	10	120	18	10	0	0.2	SB-3080TR	LTW-10SS	DNGU0803.. DNMU0803..
<b>1212F-08FF</b>	●	12	12	12	85		12					
<b>1212K-08FF</b>	●				120							
<b>1616K-08FF</b>	●	16	16	16	120	16						

### Applicable Inserts

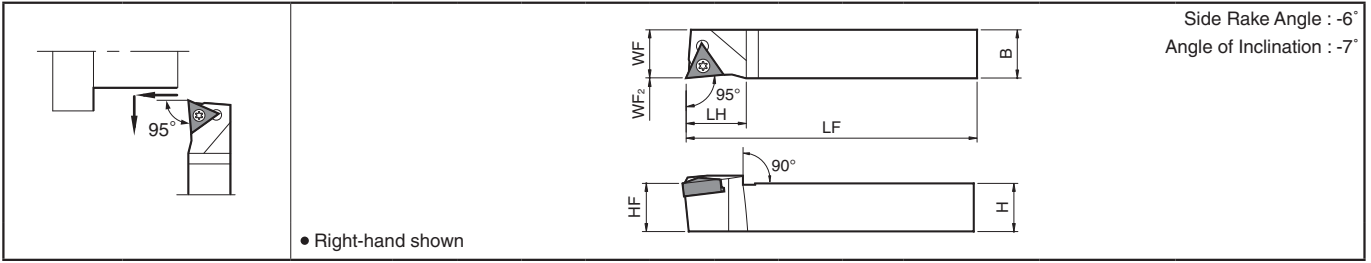
Applications	Finishing - Medium	Medium - Roughing	Finishing	Low Feed
See Page	<b>B51</b>	<b>B51</b>	<b>B51</b>	<b>B51</b>
Insert	<b>SK</b> 	<b>GK</b> 	<b>FR-F</b> 	<b>(F/E)R-U</b> 
Toolholder Description	<b>SDLNR...-08FF</b>			
	DNGU0803..	DNMU0803..	DNGU0803..	DNGU0803..

● : Std. Item

Small Parts Machining



**STLN** (Without Offset) (External / Up Facing)



**Toolholder Dimensions**

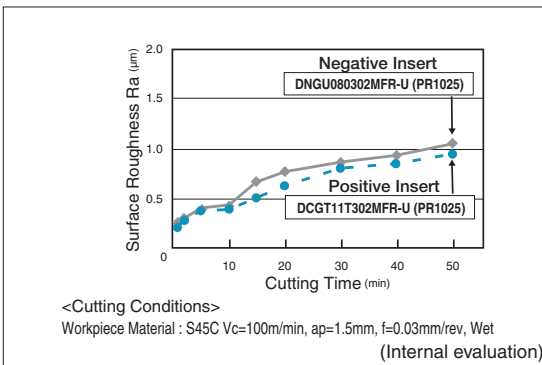
Description	Stock	Dimension (mm)							Std. Corner-R(RE)	Spare Parts		Applicable Inserts
		H	HF	B	LF	LH	WF	WF <sub>2</sub>		Clamp Screw	Wrench	
<b>STLNR 1010K-09FF</b>	●	10	10	10	120	15	10	0	0.2	SB-2570TR	LTW-8SS	TNGU0903..
<b>1212F-09FF</b>	●	12	12	12	85							
<b>1212K-09FF</b>	●	16	16	16	120		16					
<b>1616K-09FF</b>	●											

**Applicable Inserts**

Applications	Finishing	Low Feed
See Page	<b>B52</b>	<b>B52</b>
Insert	FR-F	(E/F)R-U
Toolholder Description		
<b>STLNR...-09FF</b>	TNGU0903..	TNGU0903..

Double-sided design allows all edges to be used. Compared to the positive type, this offers less cost per insert and more stability.

**Comparison of surface roughness (Sharp edge)**



**Case Studies**

**SUS303**

- Spool <Dia. 6mm portion>
- Vc=66m/min
- ap=1.25mm
- f=0.025mm/rev
- Wet
- <Dia. 8mm portion>
- Vc=130m/min
- ap=0.25mm
- f=0.025mm/rev
- Wet

Required Surface Roughness 0.8µmRa

<b>DNGU080302MF-SK (PR1025)</b>	60,000pcs/insert (4 edges)
Competitor C (DCGT type)	20,000 pcs/insert (2 edges)

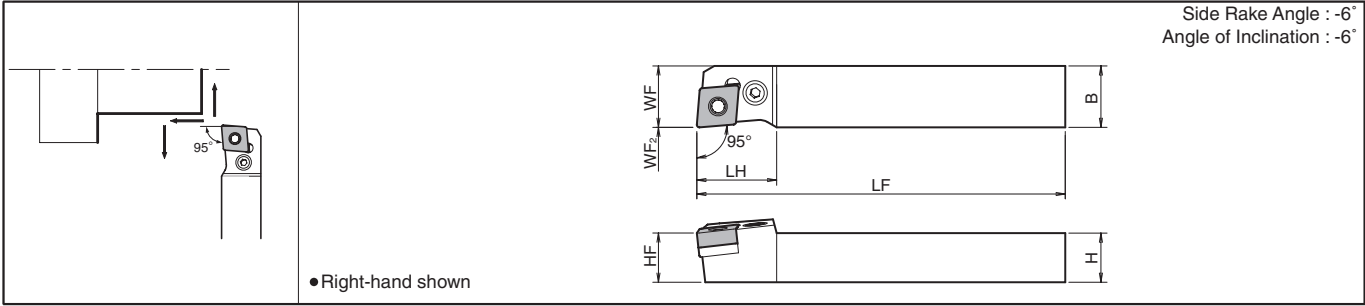
Competitor C (DCGT type) machined 10,000 pcs/edge. PR1025 machined 15,000 pcs/edge resulting in 3 times longer tool life per insert.  
(User Evaluation)

**Recommended Cutting Conditions**

Workpiece Material	Insert Grades			
	PR1005	PR1025	PR1225	PR1425
Free-cutting steel	● Vc=100m/min (60~150)	-	-	-
Carbon steel / Alloy steel	☺ Vc=100m/min (60~150)	☺ Vc=100m/min (60~150)	☺ Vc=100m/min (60~150)	● Vc=120m/min (60~200)
Stainless Steel	-	☺ Vc=100m/min (60~150)	● Vc=80m/min (50~150)	☺ Vc=100m/min (80~150)

● : Continuous to Light interruption / 1st Choice  
☺ : Continuous to Light interruption / 2nd Choice

### PCLN-FF (Without Offset) (External / Facing)



#### Toolholder Dimensions

Description	Stock	Dimension (mm)							Std. Corner-R(RE)	Spare Parts					
		H	HF	B	LF	LH	WF	WF <sub>2</sub>		Lever	Lock Screw	Shim	Shim Pin	Punch	Wrench
<b>PCLNR</b> 1620JX-12FF	●	16	16	20	120	26	20	0	0.8						
	●	20	20												
2020JX-12FF	●	20	20	20	120	26	20	0	0.8	LL-2N	LS-2N	LC-42N	LSP-2	PC-2	LW-3

#### Applicable Inserts (1st Choice)

Applications	Finishing - Medium	Medium - Roughing
See Page	<b>B19</b>	<b>B19</b>
Insert		
Toolholder Description		
<b>PCLNR...-12FF</b>	CNGG1204..FP-SK	CNGG1204..FP-TK

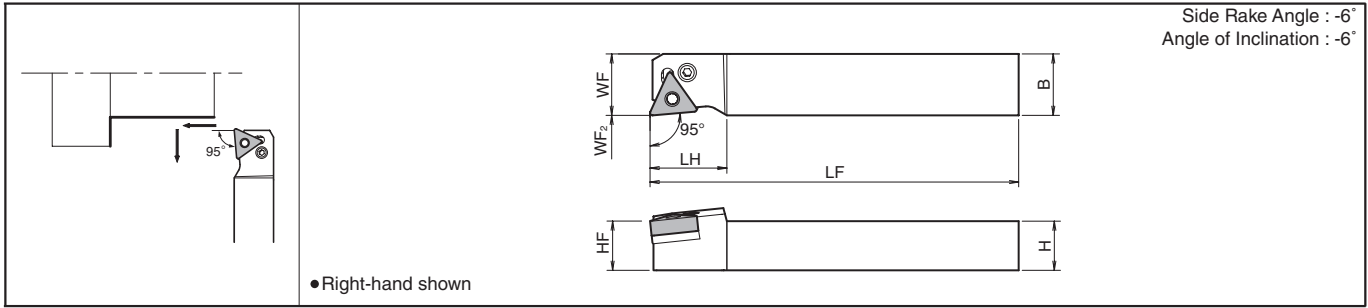
Recommended Cutting Conditions **E41**

#### Applicable Inserts (Optional)

Applications	Finishing	Finishing - Medium	Finishing	Finishing - Medium	Finishing - Medium	Finishing - Medium	Medium - Roughing	Medium - Roughing	Medium - Roughing
Insert									
Size	12	12	12	12	12	12	12	12	12
Page	<b>B16</b>	<b>B16</b>	<b>B16</b>	<b>B16</b>	<b>B17</b>	<b>B17</b>	<b>B17</b>	<b>B17</b>	<b>B17</b>
Applications	Medium - Roughing / High Feed Rate	Roughing	Roughing	Single Sided / Roughing / High Feed Rate	Finishing	Medium	Soft Steel / Small ap	Soft Steel / Finishing	Soft Steel / Medium
Insert									
Size	12	12	12	12	-	12	12	12	12
Page	<b>B18</b>	<b>B18</b>	<b>B18</b>	<b>B19</b>	-	<b>B22</b>	<b>B19</b>	<b>B19</b>	<b>B19</b>
Applications	Soft Steel / Roughing	Stainless Steel / Finishing	Stainless Steel / Medium-Roughing	Stainless Steel / Medium-Roughing	Cast Iron	Cast Iron	Cast Iron	Cast Iron	Cast Iron
Insert									
Size	12	12	12	12	12	12	12	12	12
Page	<b>B19</b>	<b>B20</b>	<b>B20</b>	<b>B20</b>	<b>B21</b>	<b>B21</b>	<b>B21</b>	<b>B21</b>	<b>B21</b>
Applications	Cast Iron	Cast Iron	Cast Iron	Non-ferrous Metals	Non-ferrous Metals	Non-ferrous Metals	Heat-resistant Alloys	Heat-resistant Alloys	Hard Materials
Insert									
Size	12	12	12	12	12	12	12	12	12
Page	<b>B21</b>	<b>B21</b>	<b>B106</b>	<b>B22</b>	<b>B22</b>	<b>C23</b>	<b>B20</b>	<b>B21</b>	<b>C6, C7</b>

● : Std. Item

### PTLN-FF (Without Offset) (External / Up Facing)



### Toolholder Dimensions

Description	Stock	Dimension (mm)							Std. Corner-R(RE)	Spare Parts						
		H	HF	B	LF	LH	WF	WF <sub>2</sub>		Lever	Lock Screw	Shim	Shim Pin	Punch	Wrench	
<b>PTLNR</b>	<b>1620JX-16FF</b>	●	16	16	20	120	24	20	0	0.8	LL-1N	LS-1N	LT-32N * LT-32N-20	LSP-1	PC-1	FH-2.5
	<b>2020JX-16FF</b>	●	20	20												

\* When using inserts whose corner-R(RE) is greater than 1.6mm, please purchase a shim with \* mark and use it in order to prevent workpiece and shim from interfering each other.

### Applicable Inserts (1st Choice)

Applications See Page	Finishing - Medium <b>B38</b>	Medium - Roughing <b>B39</b>	Large ap <b>B38</b>
Insert	FP-SK	FP-TK	R-LD
<b>PTLNR...-16FF</b>	TNGG1604..FP-SK	TNGG1604..FP-TK	TNMG1604..R-LD

Recommended Cutting Conditions **E41**

### Applicable Inserts (Optional)

Applications	Finishing	Finishing - Medium	Finishing - Medium	Medium - Roughing	Medium - Roughing	Medium - Roughing	Medium - Roughing / High Feed Rate	Medium - Roughing / High Feed Rate	Roughing
Insert	PP	PQ	CQ	GS	PG	PS	PT	GT	PH
Size	16	16	16	16	16	16	16	16	16
Page	<b>B36</b>	<b>B36</b>	<b>B36</b>	<b>B36</b>	<b>B36</b>	<b>B37</b>	<b>B37</b>	<b>B37</b>	<b>B37</b>
Applications	Single Sided / Roughing / High Feed Rate	Roughing	Finishing	Finishing - Roughing	Medium-Roughing / Low Cutting Force	Soft Steel / Small ap	Soft Steel / Finishing	Soft Steel / Medium	Soft Steel / Roughing
Insert	PX	Standard	R-S	R-□	R-25R	XF	XP	XQ	XS
Size	16	16	16	16	16	16	16	16	16
Page	<b>B38</b>	<b>B37</b>	<b>B42</b>	<b>B42, B43</b>	<b>B43</b>	<b>B38</b>	<b>B38</b>	<b>B38</b>	<b>B38</b>
Applications	Stainless Steel / Finishing	Stainless Steel / Medium-Roughing	Stainless Steel / Medium-Roughing	Cast Iron	Cast Iron	Cast Iron	Cast Iron	Cast Iron	Cast Iron
Insert	MQ	MS	MU	KQ	KG	KH	C	ZS	GC
Size	16	16	16	16	16	16	16	16	16
Page	<b>B39</b>	<b>B39</b>	<b>B39</b>	<b>B40</b>	<b>B40</b>	<b>B40</b>	<b>B40</b>	<b>B40</b>	<b>B40</b>
Applications	Cast Iron	Cast Iron	Non-ferrous Metals	Non-ferrous Metals	Non-ferrous Metals	Hard Materials			
Insert	Without Chipbreaker	Ceramic	AH	R-A3	PCD	CBN			
Size	16	16	16	16	16	16			
Page	<b>B40</b>	<b>B111</b>	<b>B41</b>	<b>B41</b>	<b>C23</b>	<b>C10, C11</b>			

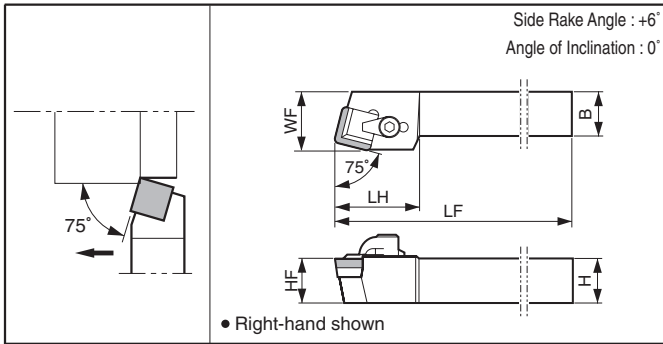
● : Std. Item

Insert Grades  
 Turning  
 Boring  
 Grooving  
 Cut-off  
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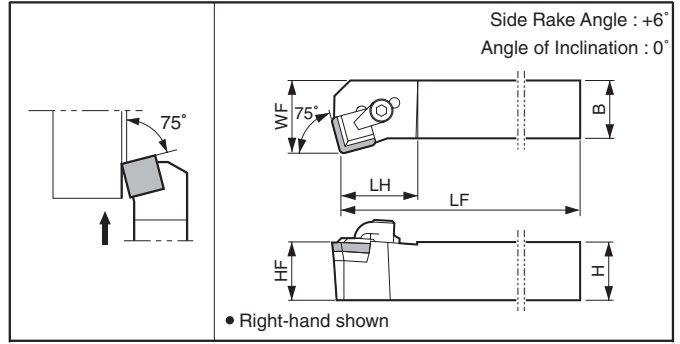
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# External Toolholders [SP□R / SP□N Insert]

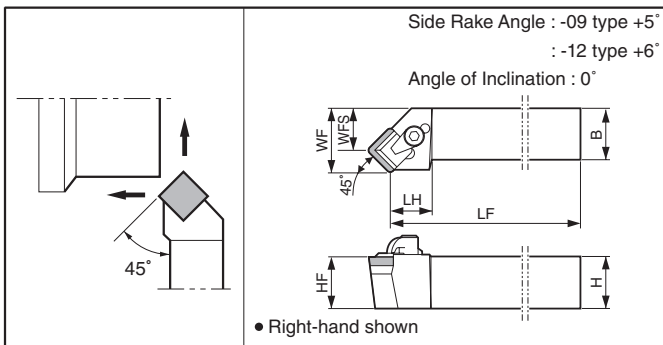
## CSBP (External)



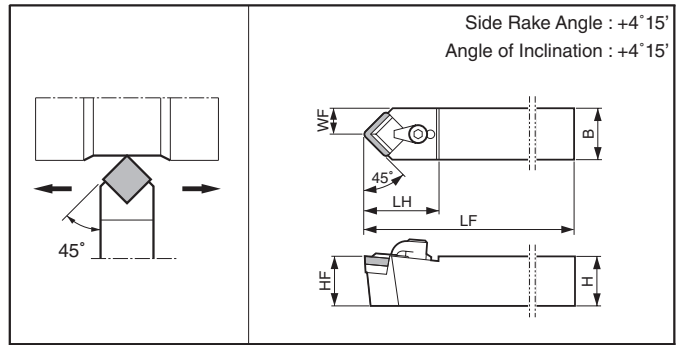
## CSKP (Facing)



## CSSP (External / Facing / Chamfering)



## CSDP (External / Chamfering)



### Toolholder Dimensions

Description	Stock		Dimension (mm)								Std. Corner-R(RE)	Spare Parts				
	R	N	L	H	HF	B	LF	LH	WF	WFS		Clamp Set	Wrench	Shim	Shim Screw	*Chipbreaker
CSBPR 1212F -09N	<input type="checkbox"/>			12	12	12	80	23	15.7	-	0.4	CPS-2P	LW-2.5	-	-	CB-S3220
CSKPR 1616H -09N	<input type="checkbox"/>			16	16	16	100	21	20	-	0.4	CPS-2P	LW-2.5	-	-	CB-S3220
CSKPR 2020K -12N	<input type="checkbox"/>			20	20	20	125	28	25	-	0.8	CPS-3	LW-3	KPS-42	SP3X8	CB-S4220
	<input type="checkbox"/>			25	25	25	150		32							
CSSP <sup>3/4</sup> 1212F -09N	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	12	12	12	80	15	16	9	0.4	CPS-2P	LW-2.5	-	-	CB-S3220
	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	16	16	16	100	16	20	13						
CSSP <sup>3/4</sup> 2020K -12N	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	20	20	20	125	19	25	16	0.8	CPS-3	LW-3	KPS-42	SP3X8	CB-S4220
	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	25	25	25	150		32	23						
CSDPN 2020K -12N	<input type="checkbox"/>	<input type="checkbox"/>		20	20	20	125	32	10	-	0.8	CPS-3	LW-3	KPS-42	SP3X8	CB-S4220
	<input type="checkbox"/>	<input type="checkbox"/>		25	25	25	150		12.5							

\* Chipbreaker is not included. Purchase separately.

### Applicable Inserts

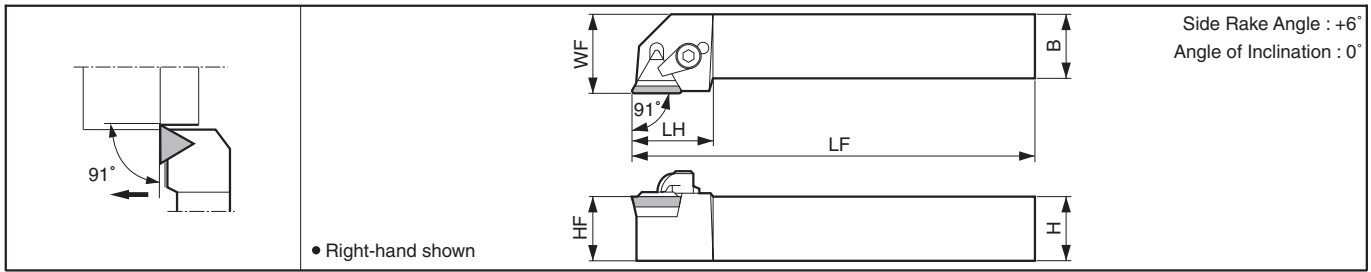
Applications See Page	Medium	Medium	Finishing - Medium	Cast Iron	Cast Iron	Non-ferrous Metals			
	B75	B75	B75	B75	B113	C29			
Insert	G	Standard	3/4	Without Chipbreaker	Ceramic	PCD			
Toolholder Description									
CSBPR...-09N	SPMR0903..	SPMR0903..	SPGR0903..	SPMN0903.. SPGN0903..	SPGN0903..	-			
CSKPR...-09N	SPMR0903..	SPMR0903..	SPGR0903..	SPMN0903.. SPGN0903..	SPGN0903..	-			
CSKPR...-12N	SPMR1203..	SPMR1203..	SPGR1203..	SPMN1203.. SPGN1203..	SPGN1203..	SPGN1203..			
CSSP <sup>3/4</sup> ...-09N	SPMR0903..	SPMR0903..	SPGR0903..	SPMN0903.. SPGN0903..	SPGN0903..	-			
CSSP <sup>3/4</sup> ...-12N	SPMR1203..	SPMR1203..	SPGR1203..	SPMN1203.. SPGN1203..	SPGN1203..	SPGN1203..			
CSDPN...-12N	SPMR1203..	SPMR1203..	SPGR1203..	SPMN1203.. SPGN1203..	SPGN1203..	SPGN1203..			

CSKPR : When using handed inserts, Left-hand Insert for Right-hand Toolholder.  
 CSSP<sup>3/4</sup> : When using handed inserts,  
 For External Turning, Right-hand Insert for Right-hand Toolholder, Left-hand Insert for Left-hand Toolholder.  
 For Facing, Left-hand Insert for Right-hand Toolholder, Right-hand Insert for Left-hand Toolholder.

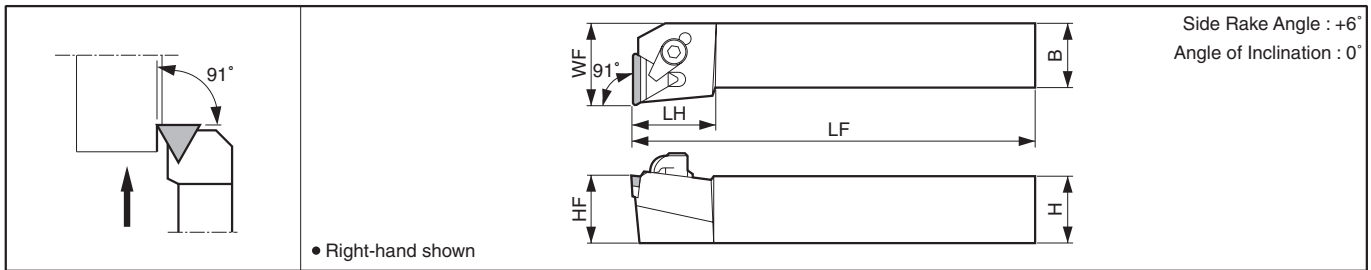
Recommended Cutting Conditions **E46**

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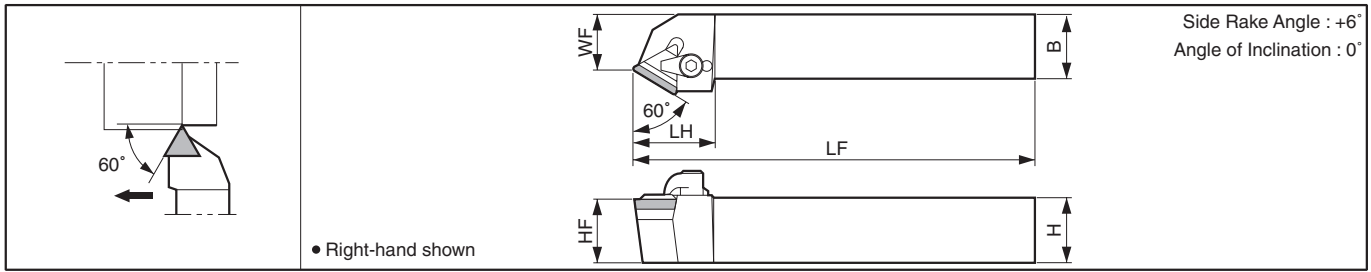
### CTGP (External)



### CTFP (Facing)



### CTTP (External / Chamfering)



### Toolholder Dimensions

Description	Stock		Dimension (mm)						Std. Corner-R(RE)	Spare Parts				
	R	L	H	HF	B	LF	LH	WF		Clamp Set	Wrench	Shim	Shim Screw	*Chipbreaker
CTGP <sup>R/L</sup> 1212F -11N	<input type="checkbox"/>	<input type="checkbox"/>	12	12	12	80	18	16	0.4	CPS-2P	LW-2.5	-	-	CB-T2212
	<input type="checkbox"/>	<input type="checkbox"/>	16	16	16	100		20						
CTGP <sup>R/L</sup> 2020K -16N	<input type="checkbox"/>	<input type="checkbox"/>	20	20	20	125	26	25	0.8	CPS-3	LW-3	KPT-32	SP3X8	CB-T3220
	<input type="checkbox"/>	<input type="checkbox"/>	25	25	25	150		32						
CTFP <sup>R/L</sup> 1212F -11N	<input type="checkbox"/>	<input type="checkbox"/>	12	12	12	80	18	16	0.4	CPS-2P	LW-2.5	-	-	CB-T2212
	<input type="checkbox"/>	<input type="checkbox"/>	16	16	16	100		20						
CTFP <sup>R/L</sup> 2020K -16N	<input type="checkbox"/>	<input type="checkbox"/>	20	20	20	125	22	25	0.8	CPS-3	LW-3	KPT-32	SP3X8	CB-T3220
	<input type="checkbox"/>	<input type="checkbox"/>	25	25	25	150		32						
CTTP <sup>R/L</sup> 1212F -11N	<input type="checkbox"/>	<input type="checkbox"/>	12	12	12	80	22.5	9	0.4	CPS-2P	LW-2.5	-	-	CB-T2212
	<input type="checkbox"/>	<input type="checkbox"/>	16	16	16	100		13						
CTTP <sup>R/L</sup> 2020K -16N	<input type="checkbox"/>	<input type="checkbox"/>	20	20	20	125	28	17	0.8	CPS-3	LW-3	KPT-32	SP3X8	CB-T3220
	<input type="checkbox"/>	<input type="checkbox"/>	25	25	25	150		22						

\* Chipbreaker is not included. Purchase separately.

### Applicable Inserts

Applications See Page	Finishing B87	Finishing B87	Finishing - Medium B87	Medium B87	Medium B87	Finishing - Medium B88	Cast Iron B88	Cast Iron B113	Non-ferrous Metals C29	Hard Materials C18
Insert	GP	DP	HQ	G	Standard	<sup>R/L</sup> -□	Without Chipbreaker	Ceramic	PCD	CBN
CTGP <sup>R/L</sup> ...-11N	TPMR1103..	TPMR1103..	TPMR1103..	TPMR1103..	TPMR1103..	TPGR1103..	TPMN1103.. TPGN1103..	TPGN1103..	TPGN1103..	TPGN1103..
CTGP <sup>R/L</sup> ...-16N	TPMR1603..	TPMR1603..	TPMR1603..	TPMR1603..	TPMR1603..	TPGR1603..	TPMN1603.. TPGN1603..	TPGN1603..	TPGN1603..	TPGN1603..
CTFP <sup>R/L</sup> ...-11N	TPMR1103..	TPMR1103..	TPMR1103..	TPMR1103..	TPMR1103..	TPGR1103..	TPMN1103.. TPGN1103..	TPGN1103..	TPGN1103..	TPGN1103..
CTFP <sup>R/L</sup> ...-16N	TPMR1603..	TPMR1603..	TPMR1603..	TPMR1603..	TPMR1603..	TPGR1603..	TPMN1603.. TPGN1603..	TPGN1603..	TPGN1603..	TPGN1603..
CTTP <sup>R/L</sup> ...-11N	TPMR1103..	TPMR1103..	TPMR1103..	TPMR1103..	TPMR1103..	TPGR1103..	TPMN1103.. TPGN1103..	TPGN1103..	TPGN1103..	TPGN1103..
CTTP <sup>R/L</sup> ...-16N	TPMR1603..	TPMR1603..	TPMR1603..	TPMR1603..	TPMR1603..	TPGR1603..	TPMN1603.. TPGN1603..	TPGN1603..	TPGN1603..	TPGN1603..

CTGP<sup>R/L</sup> : Left-hand Insert for Right-hand Toolholder, Right-hand Insert for Left-hand Toolholder.

Recommended Cutting Conditions **E46**

□ : Deleted from the next catalog

Insert Grades  
Turning  
Indexable Inserts  
CBN & PCD Tools  
External  
Small Parts  
Machining  
Boring  
Grooving  
Cut-off  
Threading  
Drilling  
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# Recommended Cutting Conditions

Cutting Dia.  $\phi$ 16mm or less

## Recommended Cutting Conditions - External Turning (Positive Insert) [ap indicates radius]

ISO Classification	Workpiece Material	Hardness	Cutting Range	Applications	Recommended Chipbreaker	Recommended Insert Grade	Corner-R (RE)	Lower Limit - Recommendation - Upper Limit		
								Vc (m/min)	ap (mm)	f (mm/rev)
*P	Low Carbon Steel Low Carbon Alloy	HB $\leq$ 300	Precision Finishing	Continuous Interruption	F	PR1425 PR1425	0.05 0.2	100 - 150 - 200 80 - 120 - 160	0.05 - 0.07 - 0.15 0.05 - 0.1 - 0.2	0.03 - 0.05 - 0.1 0.03 - 0.1 - 0.15
			Precision Finishing (Molded Chipbreaker)	Continuous	CF	PR1425	0.2	100 - 150 - 200	0.02 - 0.05 - 0.1	0.02 - 0.05 - 0.12
			Finishing	Continuous Interruption	GF	PR1425 PR1425	0.2 0.4	100 - 140 - 180 80 - 120 - 160	0.2 - 0.5 - 1.0 0.2 - 0.5 - 1.0	0.05 - 0.1 - 0.2 0.05 - 0.1 - 0.2
			Finishing - Medium	Continuous Interruption	GQ	PR1425 PR1425	0.2 0.4	80 - 120 - 160 60 - 100 - 140	0.8 - 3.0 - 5.0 0.8 - 2.0 - 3.0	0.03 - 0.05 - 0.1 0.03 - 0.05 - 0.1
			Low Feed & Large ap	Continuous	J, U	PR1425	0.2	80 - 100 - 140	0.5 - 2.0 - 3.5	0.02 - 0.05 - 0.1
	Medium Carbon Steel Medium Carbon Alloy	HB $\leq$ 330	Precision Finishing	Continuous Interruption	F	PR1425 PR1425	0.05 0.2	100 - 150 - 200 80 - 120 - 160	0.05 - 0.07 - 0.15 0.05 - 0.1 - 0.2	0.03 - 0.05 - 0.1 0.03 - 0.1 - 0.15
			Precision Finishing (Molded Chipbreaker)	Continuous	CF	PR1425	0.2	100 - 150 - 200	0.02 - 0.05 - 0.1	0.02 - 0.05 - 0.12
			Finishing	Continuous Interruption	GF	PR1425 PR1425	0.2 0.4	100 - 140 - 180 80 - 120 - 160	0.2 - 0.5 - 1.0 0.2 - 0.5 - 1.0	0.05 - 0.1 - 0.2 0.05 - 0.1 - 0.2
			Finishing - Medium	Continuous Interruption	GQ	PR1425 PR1425	0.2 0.4	80 - 120 - 160 60 - 100 - 140	0.8 - 3.0 - 5.0 0.8 - 2.0 - 3.0	0.03 - 0.05 - 0.1 0.03 - 0.05 - 0.1
			Low Feed & Large ap	Continuous	J, U	PR1425	0.2	80 - 100 - 140	0.5 - 2.0 - 3.5	0.02 - 0.05 - 0.1
	High Carbon Alloy	HB $\leq$ 280	Precision Finishing	Continuous Interruption	F	PR1425 PR1425	0.05 0.2	100 - 150 - 200 80 - 120 - 160	0.05 - 0.07 - 0.15 0.05 - 0.1 - 0.2	0.03 - 0.05 - 0.1 0.03 - 0.1 - 0.15
			Precision Finishing (Molded Chipbreaker)	Continuous	CF	PR1425	0.2	100 - 150 - 200	0.02 - 0.05 - 0.1	0.02 - 0.05 - 0.12
			Finishing	Continuous Interruption	GF	PR1425 PR1425	0.2 0.4	100 - 140 - 180 80 - 120 - 160	0.2 - 0.5 - 1.0 0.2 - 0.5 - 1.0	0.05 - 0.1 - 0.2 0.05 - 0.1 - 0.2
			Finishing - Medium	Continuous Interruption	GQ	PR1425 PR1425	0.2 0.4	80 - 120 - 160 60 - 100 - 140	0.8 - 3.0 - 5.0 0.8 - 2.0 - 3.0	0.03 - 0.05 - 0.1 0.03 - 0.05 - 0.1
			Low Feed & Large ap	Continuous	J, U	PR1425	0.2	80 - 100 - 140	0.5 - 2.0 - 3.5	0.02 - 0.05 - 0.1
M	Stainless Steel (Austenitic related)	HB $\leq$ 220	Finishing	Continuous Interruption	GF	PR1225 PR1535	0.2 0.4	80 - 100 - 120 60 - 80 - 100	0.1 - 0.3 - 0.5 0.3 - 0.5 - 1.0	0.03 - 0.05 - 0.1 0.05 - 0.1 - 0.15
			Medium	Continuous Interruption	GQ	PR1225 PR1535	0.2 0.4	80 - 100 - 120 60 - 80 - 100	0.5 - 1.5 - 3.0 0.5 - 1.0 - 2.0	0.03 - 0.08 - 0.12 0.05 - 0.1 - 0.15
	Stainless Steel (Precipitation Hardening)	HB $\leq$ 300	Finishing	Continuous Interruption	GF	PR1225 PR1535	0.2 0.4	40 - 60 - 80 30 - 50 - 70	0.1 - 0.3 - 0.5 0.3 - 0.5 - 1.0	0.03 - 0.05 - 0.1 0.05 - 0.1 - 0.15
			Medium	Continuous Interruption	GQ	PR1225 PR1535	0.2 0.4	40 - 60 - 80 30 - 50 - 70	0.5 - 1.0 - 1.5 0.5 - 1.0 - 1.5	0.03 - 0.08 - 0.12 0.05 - 0.1 - 0.15
K	Gray Cast Iron	HB $\leq$ 250	Finishing	Continuous Interruption	Standard	CA310 CA315	0.4 0.4	100 - 120 - 150 80 - 100 - 120	0.2 - 0.5 - 1.0 0.2 - 0.5 - 1.0	0.1 - 0.15 - 0.2 0.05 - 0.1 - 0.15
			Medium	Continuous Interruption	Standard	CA310 CA315	0.4 0.8	100 - 120 - 150 80 - 100 - 120	0.5 - 1.0 - 2.0 0.5 - 1.0 - 2.0	0.1 - 0.15 - 0.2 0.05 - 0.1 - 0.15
	Nodular Cast Iron	HB $\leq$ 270	Finishing	Continuous Interruption	Standard	CA310 CA315	0.4 0.4	80 - 100 - 120 60 - 80 - 100	0.2 - 0.5 - 1.0 0.2 - 0.5 - 1.0	0.1 - 0.15 - 0.2 0.05 - 0.1 - 0.15
			Medium	Continuous Interruption	Standard	CA315 CA320	0.4 0.8	80 - 100 - 120 60 - 80 - 100	0.5 - 1.0 - 2.0 0.5 - 1.0 - 2.0	0.1 - 0.15 - 0.2 0.05 - 0.1 - 0.15
N	Non-ferrous Metals Copper Alloy Aluminum Aluminum Alloys (Si10% or less) etc.	HB $\leq$ 100	High Speed Machining (Rainbow Surface Gloss)	Continuous	Without Chipbreaker	KPD001	0.2	150 - 250 - 350	0.05 - 0.1 - 0.3	0.05 - 0.1 - 0.15
			Finishing (Long Tool Life)	Continuous Interruption	F, FSF	PDL025 PDL025	0.2 0.4	100 - 150 - 200 100 - 150 - 200	0.05 - 0.3 - 0.5 0.05 - 0.3 - 0.5	0.02 - 0.07 - 0.1 0.02 - 0.07 - 0.1
			Finishing	Continuous Interruption	F, FSF	KW10 KW10	0.2 0.4	100 - 150 - 200 100 - 150 - 200	0.05 - 0.3 - 0.5 0.05 - 0.3 - 0.5	0.02 - 0.07 - 0.1 0.02 - 0.07 - 0.1
			Medium	Continuous Interruption	U, USF	KW10 KW10	0.2 0.4	100 - 150 - 200 100 - 150 - 200	0.2 - 0.5 - 1.5 0.2 - 0.5 - 1.5	0.03 - 0.1 - 0.2 0.03 - 0.1 - 0.2
S	Titanium Alloys	HB $\leq$ 400	Precision Finishing (Rainbow Surface Gloss)	Continuous Interruption	Without Chipbreaker	KPD001 KPD001	0.2 0.4	100 - 120 - 150 70 - 100 - 120	0.05 - 0.1 - 0.3 0.05 - 0.1 - 0.3	0.03 - 0.07 - 0.1 0.03 - 0.07 - 0.1
			Medium	Continuous Interruption	FSF,USF	KW10 KW10	0.4 0.4	30 - 50 - 70 30 - 50 - 70	0.1 - 0.5 - 1.0 0.1 - 0.5 - 1.0	0.03 - 0.1 - 0.2 0.03 - 0.1 - 0.2
	Heat-resistant Alloys	HB $\leq$ 350	Finishing	Continuous Interruption	F, U Without Chipbreaker	KW10 KW10	0.4 0.8	10 - 30 - 50 10 - 30 - 50	0.1 - 0.3 - 0.5 0.2 - 0.5 - 0.7	0.03 - 0.05 - 0.1 0.03 - 0.05 - 0.1
			Finishing	Continuous Interruption	MQ	PR1535 PR1535	0.4 0.8	40 - 60 - 80 40 - 60 - 80	0.1 - 0.3 - 0.5 0.1 - 0.3 - 0.5	0.03 - 0.05 - 0.1 0.03 - 0.05 - 0.1
H	Hardened Steel Hard Materials	40~50 HRC	Finishing	Continuous Interruption	GK	PR1425 PR1425	0.2 0.4	40 - 60 - 80 40 - 60 - 80	0.1 - 0.3 - 0.5 0.1 - 0.3 - 0.5	0.02 - 0.07 - 0.1 0.02 - 0.07 - 0.1
		50~68 HRC	Finishing	Continuous Interruption	ME MET	KBN05M KBN05M	0.2 0.4	80 - 120 - 150 60 - 100 - 120	0.1 - 0.3 - 0.5 0.1 - 0.3 - 0.5	0.02 - 0.07 - 0.1 0.02 - 0.07 - 0.1

\* For machining free-cutting steels, such as SUM, etc., use PR1005 at Vc=200m/min or less. For ap and f, refer to specs for low carbon steels.

## Recommended Cutting Conditions - Back Turning

● KTKF  $\rightarrow$  E12

Workpiece Material		MEGACOAT NANO				MEGACOAT		Remarks
		PR1535		PR1425		PR1225		
		Grooving	Turning	Grooving	Turning	Grooving	Turning	
Carbon steel / Alloy steel	Vc (m/min)	☆ 60 ~ 150		★ 80 ~ 200		☆ 60 ~ 150		Coolant
	f (mm/rev)	0.01 ~ 0.03	0.02 ~ 0.15	0.01 ~ 0.03	0.02 ~ 0.15	0.01 ~ 0.03	0.02 ~ 0.15	
Stainless Steel	Vc (m/min)	★ 60 ~ 130		☆ 60 ~ 150		☆ 60 ~ 130		
	f (mm/rev)	0.01 ~ 0.02	0.02 ~ 0.1	0.01 ~ 0.02	0.02 ~ 0.1	0.01 ~ 0.02	0.02 ~ 0.1	

Workpiece Material		PVD Coated Carbide		Carbide		PCD		Remarks
		PR1025		KW10		KPD001		
		Grooving	Turning	Grooving	Turning	Grooving	Turning	
Carbon steel / Alloy steel	Vc (m/min)	☆ 60 ~ 150		-		-		Coolant
	f (mm/rev)	0.01 ~ 0.03	0.02 ~ 0.15	-		-		
Stainless Steel	Vc (m/min)	☆ 50 ~ 120		-		-		
	f (mm/rev)	0.01 ~ 0.02	0.02 ~ 0.1	-		-		
Cast Iron	Vc (m/min)	-		50 ~ 100		-		
	f (mm/rev)	-		0.01 ~ 0.02	0.02 ~ 0.15	-		
Aluminum Alloys	Vc (m/min)	-		200 ~ 450		200 ~ 500		
	f (mm/rev)	-		0.01 ~ 0.03	0.02 ~ 0.15	0.01 ~ 0.03	0.02 ~ 0.12	
Brass	Vc (m/min)	-		100 ~ 200		100 ~ 350		
	f (mm/rev)	-		0.01 ~ 0.05	0.02 ~ 0.2	0.01 ~ 0.05	0.02 ~ 0.15	

★ : 1st Recommendation  
☆ : 2nd Recommendation

● KTKF (GQ Chipbreaker)  $\rightarrow$  E12

Workpiece Material		MEGACOAT NANO				MEGACOAT		Remarks
		PR1535		PR1425		PR1225		
		Grooving	Turning	Grooving	Turning	Grooving	Turning	
Carbon steel / Alloy steel	Vc (m/min)	☆ 60 ~ 150		★ 80 ~ 200		☆ 60 ~ 150		Coolant
	f (mm/rev)	0.01 ~ 0.04	0.02 ~ 0.15	0.01 ~ 0.04	0.02 ~ 0.15	0.01 ~ 0.04	0.02 ~ 0.15	
Stainless Steel	Vc (m/min)	★ 60 ~ 130		☆ 60 ~ 150		☆ 60 ~ 130		
	f (mm/rev)	0.01 ~ 0.03	0.02 ~ 0.1	0.01 ~ 0.03	0.02 ~ 0.1	0.01 ~ 0.03	0.02 ~ 0.1	

★ : 1st Recommendation  
☆ : 2nd Recommendation

● ABS15, ABW15, ABW23  $\rightarrow$  E17~E19

Workpiece Material		MEGACOAT NANO		MEGACOAT		PVD Coated Carbide		Remarks
		PR1425		PR1225		PR1025 (PR930)		
		Grooving	Turning	Grooving	Turning	Grooving	Turning	
Carbon steel / Alloy steel	Vc (m/min)	★ 80 ~ 180		☆ 60 ~ 150		☆ 80 ~ 100		Coolant
	f (mm/rev)	0.02	0.02 ~ 0.07	0.02	0.02 ~ 0.07	0.02	0.02 ~ 0.07	
Stainless Steel	Vc (m/min)	☆ 40 ~ 130		★ 40 ~ 120		☆ 30 ~ 50		
	f (mm/rev)	0.02	0.02 ~ 0.05	0.02	0.02 ~ 0.05	0.02	0.02 ~ 0.05	




★ : 1st Recommendation  
☆ : 2nd Recommendation

Workpiece Material		Carbide		Remarks
		KW10		
		Grooving	Turning	
Aluminum Alloys	Vc (m/min)	150 ~ 200		Coolant
	f (mm/rev)	0.02	0.02 ~ 0.10	
Brass	Vc (m/min)	100 ~ 160		
	f (mm/rev)	0.03	0.02 ~ 0.15	

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# Alternative Toolholder Reference Table for Small Parts Machining

## Alternative Toolholder Reference Table for Small Parts Machining (Back Clamp)

Insert Description	Conventional Toolholder					Alternative Toolholder					
	Description	Overall length (mm)	Spare Parts			Description	Overall length (mm)	Remarks	See Page		
			Anchor Pin	Lock Screw	Wrench						
											
ABS.. 40	AABSR0810K-40F	125	LPA-11	HSB4X8R	FH-2	-	-	No Alternative	-		
	AABSR1010K-40F	125				AABSR1010JX-40F	120		E17		
	AABSR1212M-40F	150				AABSR1212JX-40F	120				
	AABSR1616M-40F	150				AABSR1616JX-40F	120				
ABW.. 40	AABWR0810K-40F	125	LPA-11	HSB4X8R	FH-2	-	-	No Alternative	-		
	AABWR1010K-40F	125				AABWR1010JX-40F	120		E18		
	AABWR1212M-40F	150				AABWR1212JX-40F	120				
	AABWR1616M-40F	150				AABWR1616JX-40F	120				
ABW.. 50	AABWR0810K-50F	125	LPA-11	HSB4X8R	FH-2	-	-	No Alternative	-		
	AABWR1010K-50F	125				AABWR1010JX-50F	120		E19		
	AABWR1212M-50F	150				AABWR1212JX-50F	120				
	AABWR1616M-50F	150				AABWR1616JX-50F	120				
CC..	ACLCL <sup>®</sup> L0810K-06F	125	LPF-11	HSB4X8R (Right-hand toolholder)	FH-2	SCLCL <sup>®</sup> L0808F-06FF	120	Clamping system is different.	E22		
	ACLCL <sup>®</sup> L1010K-06F	125				ACLCL <sup>®</sup> L1010JX-06FF	120				
	ACLCL <sup>®</sup> L1010K-09F	125	LPF-13	HSB4X8L (Left-hand toolholder)		ACLCL <sup>®</sup> L1010JX-09FF	120				
	ACLCL <sup>®</sup> L1212M-09F	150				ACLCL <sup>®</sup> L1212JX-09FF	120				
	ACLCL <sup>®</sup> L1616M-09F	150				ACLCL <sup>®</sup> L1616JX-09FF	120				
DC..	ADJCL <sup>®</sup> L0810K-07F	125	LPF-11	HSB4X8R (Right-hand toolholder)	FH-2	SDJCL <sup>®</sup> L0808F-07FF	120	Clamping system is different.	E24		
	ADJCL <sup>®</sup> L1010K-07F	125				ADJCL <sup>®</sup> L1010JX-07FF	120				
	ADJCL <sup>®</sup> L1010K-11F	125	LPF-13	HSB4X8L (Left-hand toolholder)		ADJCL <sup>®</sup> L1010JX-11FF	120				
	ADJCL <sup>®</sup> L1212M-11F	150				ADJCL <sup>®</sup> L1212JX-11FF	120				
	ADJCL <sup>®</sup> L1616M-11F	150				ADJCL <sup>®</sup> L1616JX-11FF	120				
	ADNCR0810K-07F	125	LPF-11	HSB4X8R		FH-2	-	-		No Alternative	-
	ADNCR1010K-07F	125					SDNCN1010JX-07	120			
	ADNCR1010K-11F	125	LPF-13				SDNCN1010JX-11	120		Clamping system is different.	E27
	ADNCR1212M-11F	150					SDNCN1212JX-11	120		Neutral	
ADNCR1616M-11F	150	LPF-17			SDNCN1616JX-11		120				
VB..	AVJBL <sup>®</sup> L1010K-11F	125	LPF-11		HSB4X8R (Right-hand toolholder)		FH-2	AVJBL <sup>®</sup> L1010JX-11FF	120		
	AVJBL <sup>®</sup> L1212M-11F	150						LPF-1113	AVJBL <sup>®</sup> L1212JX-11FF	120	
	AVJBL <sup>®</sup> L1616M-11F	150	LPF-1117		AVJBL <sup>®</sup> L1616JX-11FF			120			
	AVVBL <sup>®</sup> L1010K-11F	125	LPF-1113		HSB4X8R (Right-hand toolholder)			SVVBN1010JX-11	120	Clamping system is different.	E32
	AVVBL <sup>®</sup> L1212M-11F	150		SVVBN1212JX-11		120		Neutral			
	AVVBL <sup>®</sup> L1616M-11F	150		LPF-1117		SVVBN1616JX-11		120			

Note) The corresponding alternative toolholder may be different from the conventional toolholder in insert clamping system or insert size. Make sure of their specifications by referring to the catalog or other documents.



Alternative Toolholder Reference Table for Small Parts Machining

Alternative Toolholder Reference Table for Small Parts Machining (Screw Clamp)

Insert Description	Conventional Toolholder				Alternative Toolholder				
	Description	Overall length (mm)	Spare Parts		Description	Overall length (mm)	Remarks	See Page	
			Clamp Screw	Wrench					
ABS.. 40	SABSR0810K-40F	125	SB-3080TR	FT-10	-	-	No Alternative	-	
	SABSR1010K-40F	125			SABSR1010JX-40F	120		E17	
	SABSR1212M-40F	150			SABSR1212JX-40F	120			
	SABSR1616M-40F	150			SABSR1616JX-40F	120			
ABW.. 40	SABWR0810K-40F	125	SB-3080TR	FT-10	-	-	No Alternative	-	
	SABWR1010K-40F	125			SABWR1010JX-40F	120		E18	
	SABWR1212M-40F	150			SABWR1212JX-40F	120			
	SABWR1616M-40F	150			SABWR1616JX-40F	120			
ABW.. 50	SABWR0810K-50F	125	SB-3080TR	FT-10	-	-	No Alternative	-	
	SABWR1010K-50F	125			SABWR1010JX-50F	120		E19	
	SABWR1212M-50F	150			SABWR1212JX-50F	120			
	SABWR1616M-50F	150			SABWR1616JX-50F	120			
CC..	SCAC <sup>®</sup> /L0808K-06	125	SB-2570TR	FT-8	SCLC <sup>®</sup> /L0808F-06FF	85	Cutting edge angle is different.	E22	
	SCAC <sup>®</sup> /L1010K-06	125			SCLC <sup>®</sup> /L1010JX-06FF	120			
	SCAC <sup>®</sup> /L1010K-09	125	SB-4085TR	FT-15	SCLC <sup>®</sup> /L1010JX-09FF	120			
	SCAC <sup>®</sup> /L1212M-09	150			SCLC <sup>®</sup> /L1212JX-09FF	120			
	SCAC <sup>®</sup> /L1616M-09	150			SCLC <sup>®</sup> /L1616JX-09FF	120			
	SCACR1212F-09FF	85	SB-4085TR	FT-15	SCLCR1212JX-09FF	120			
SCLC <sup>®</sup> /L0808E-06	70	SB-2570TR	FT-8	SCLC <sup>®</sup> /L0808F-06FF	85				
DC..	SDJC <sup>®</sup> /L0808F-07F	80	SB-2570TR	FT-8	SDJC <sup>®</sup> /L0808F-07FF	85	E24		
	SDJC <sup>®</sup> /L1010F-07F	80			SDJC <sup>®</sup> /L1010JX-07FF	120			
	SDJC <sup>®</sup> /L1010F-11F	80	SB-4085TR	FT-15	SDJC <sup>®</sup> /L1010JX-11FF	120			
	SDJC <sup>®</sup> /L1212H-11F	100			SDJC <sup>®</sup> /L1212JX-11FF	120			
	SDJC <sup>®</sup> /L1616H-11F	100			SDJC <sup>®</sup> /L1616JX-11FF	120			
	SDLC <sup>®</sup> /L1010F-07FF	80			SDLC <sup>®</sup> /L1010JX-07FF	120			
	SDLC <sup>®</sup> /L1212H-07FF	100	SB-2570TR	FT-8	SDLC <sup>®</sup> /L1212F-07FF	85		Short length type	E26
	SDLC <sup>®</sup> /L1212JX-07FF	120							
	SDLC <sup>®</sup> /L1616H-07FF	100	SB-4085TR	FT-15	SDLC <sup>®</sup> /L1616JX-07FF	120			
	SDLC <sup>®</sup> /L1212F-11FF	85			SDLC <sup>®</sup> /L1212JX-11FF	120			
	SDLC <sup>®</sup> /L1212H-11FF	100			SDLCL1616JX-11FF	120			
	SDLCL1616H-11FF	100							
SDNC <sup>®</sup> /L1010F-07F	80	SB-2570TR	FT-8	SDNC <sup>®</sup> /L1010JX-07F	120	Insert size is different.	E27		
SDNC <sup>®</sup> /L1010F-11F	80	SB-4085TR	FT-15	SDNC <sup>®</sup> /L1010JX-07F	120	Neutral			
SDNC <sup>®</sup> /L1212H-11F	100	SB-4085TR	FT-15	SDNCN1212F-11	85	Neutral Short length type			
SDNC <sup>®</sup> /L1616H-11F	100	SB-4085TR	FT-15	SDNCN1212JX-11	120	Neutral			
SDNCN0808E-07	70	SB-2570TR	FT-8	SDNCN0808F-07	85				
SDNCN1010F-07	80			SDNCN1010JX-07	120				
SDNCN1212H-07	100	SB-4085TR	FT-15	SDNCN1212JX-07	120				
SDNCN1212H-11	100			SDNCN1212F-11	85	Short length type			
SDXC <sup>®</sup> /L1010F-07	80	SB-2570TR	FT-8	SDXC <sup>®</sup> /L1010JX-07	120		E26		
SDXC <sup>®</sup> /L1010F-11	80	SB-4085TR	FT-15	SDXC <sup>®</sup> /L1010JX-11	120				
SDXC <sup>®</sup> /L1212H-11	100			SDXC <sup>®</sup> /L1212JX-11	120				
SDXC <sup>®</sup> /L1616H-11	100			SDXC <sup>®</sup> /L1616JX-11	120				
				SDXC <sup>®</sup> /L1616JX-11	120				
DP..	SDLP <sup>®</sup> /L0808F-07F	80	SB-2570TR	FT-8	SDLP <sup>®</sup> /L0808F-07FF	85	E28		
	SDLP <sup>®</sup> /L1010F-07F	80			SDLP <sup>®</sup> /L1010JX-07FF	120			
	SDLP <sup>®</sup> /L1010F-11F	80	SB-4085TR	FT-15	SDLP <sup>®</sup> /L1010JX-11FF	120			
	SDLP <sup>®</sup> /L1212F-11FF	85			SDLP <sup>®</sup> /L1212JX-11FF	120			
	SDLP <sup>®</sup> /L1212H-11F	100			SDLP <sup>®</sup> /L1212JX-11FF	120			
SDLP <sup>®</sup> /L1616H-11F	100			SDLP <sup>®</sup> /L1616JX-11FF	120				
TC..	STGC <sup>®</sup> /L0808E-08	70	SB-2050TR	FT-6	-	-	No Alternative	-	
TP..	STGP <sup>®</sup> /L1010F-08	80	SB-2050TR	FT-6	-	-	No Alternative	-	



Note) The corresponding alternative toolholder may be different from the conventional toolholder in insert clamping system or insert size. Make sure of their specifications by referring to the catalog or other documents.

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
## Alternative Toolholder Reference Table for Small Parts Machining

## Alternative Toolholder Reference Table for Small Parts Machining (Screw Clamp)

Insert Description	Conventional Toolholder				Alternative Toolholder				
	Description	Overall length (mm)	Spare Parts		Description	Overall length (mm)	Remarks	See Page	
			Clamp Screw	Wrench					
									
VB..	SVJB <sup>®</sup> /1010F-11F	80	SB-2570TR	FT-8	SVJB <sup>®</sup> /1010JX-11FF	120		E30	
	SVJB <sup>®</sup> /1212H-11F	100			SVJB <sup>®</sup> /1212JX-11FF	120			
	SVJB <sup>®</sup> /1616H-11F	100			SVJB <sup>®</sup> /1616JX-11FF	120			
	SVPB <sup>®</sup> /1010F-11	80	SB-2570TR	FT-8	SVPB <sup>®</sup> /1010JX-11	120		E31	
	SVPB <sup>®</sup> /1212H-11	100			SVPB <sup>®</sup> /1212JX-11	120			
	SVPB <sup>®</sup> /1616H-11	100			SVPB <sup>®</sup> /1616JX-11	120			
	SVVBN1212H-11	100	SB-2570TR	FT-8	SVVBN1212JX-11	120		E32	
VP..	SVLP <sup>®</sup> /1010F-08FF	80	SB-2050TR	FT-6	SVLP <sup>®</sup> /1010JX-08FF	120		E35	
	SVLP <sup>®</sup> /1212H-08FF	100			SVLP <sup>®</sup> /1212F-08FF	85	Short length type		
	SVLP <sup>®</sup> /1616H-08FF	100			SVLP <sup>®</sup> /1212JX-08FF	120			
	SVLP <sup>®</sup> /1010F-11F	80	SB-2570TR	FT-8	SVLP <sup>®</sup> /1616JX-08FF	120		E35	
	SVLP <sup>®</sup> /1212H-11F	100			SVLP <sup>®</sup> /1010JX-08FF	120	Insert size is different.		
	SVLP <sup>®</sup> /1616H-11F	100			SVLP <sup>®</sup> /1212F-11FF	85	Short length type		
		100			SVLP <sup>®</sup> /1212JX-11FF	120			
	SVPBR1010F-11	80	SB-2570TR	FT-8	SVPBR1010JX-11	120	Insert relief angle is different.	E31	
		SVPBR1212H-11			100	SVPBR1010JX-11FF	120	Without Offset	E36
					100	SVPBR1212JX-11	120	Insert relief angle is different.	E31
		SVPBR1616H-11	100	SVPBR1212JX-11FF	120	Without Offset	E36		
100			SVPBR1616JX-11	120	Insert relief angle is different.	E31			
SVPPL1616H-11		100	SVPBR1616JX-11FF	120	Without Offset	E36			
		100	SB-2570TR	FT-8	SVPBL1616JX-11	120	Insert relief angle is different.	E31	

Note) The corresponding alternative toolholder may be different from the conventional toolholder in insert clamping system or insert size. Make sure of their specifications by referring to the catalog or other documents.

Alternative Toolholder Reference Table for Small Parts Machining (Screw Clamp)  
Toolholders for Back Turning

Insert Description	Conventional Toolholder				Alternative Toolholder			
	Description	Overall length (mm)	Spare Parts		Description	Overall length (mm)	Remarks	See Page
			Clamp Screw	Wrench				
								
TKKF..	KTKF <sup>®</sup> /1010K-12	125	SB-4590TRWN	LTW-10S	KTKF <sup>®</sup> /1010JX-12	120		E12
	KTKF <sup>®</sup> /1212M-12	150			KTKF <sup>®</sup> /1212JX-12	120		
	KTKF <sup>®</sup> /1616M-12	150			KTKF <sup>®</sup> /1616JX-12	120		
	KTKF <sup>®</sup> /1010K-16	125			KTKF <sup>®</sup> /1010JX-16	120		
	KTKF <sup>®</sup> /1212M-16	150			KTKF <sup>®</sup> /1212JX-16	120		
	KTKF <sup>®</sup> /1616M-16	150			KTKF <sup>®</sup> /1616JX-16	120		
		150						

Note) The corresponding alternative toolholder may be different from the conventional toolholder in insert clamping system or insert size. Make sure of their specifications by referring to the catalog or other documents.