

Chapter Composition of TAC External Toolholders

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

Cat. No. of TAC toolholder

Series name

Designation of toolholder type

Machining type

Clamping type

Overview of applicable TAC inserts
These charts indicate basic selection of grades and chipbreaker types by the work material and the application.

Dimensions

Reference pages of relating items

Symbol of stock status

Typical tooling is illustrated.

Applicable TAC insert and page

TAC External Toolholders

ADPNN A-type
Applicable inserts: DN□□1504
Negative rake
Double clamping system

External Profiling
Cutting edge style P

Toolholders Cat. No.	Stock	Dimensions (mm)								Std. Corner r_1	Applicable inserts	Page
		ϕ	ϕ	ϕ	L_1	L_2	ϕ	ϕ	ϕ			
ADPNN20K15-A	•	20	20	125	36	20	7.5	—	—	0.8	DN□□1504□□	2-52 ~ 3-27 ~ 3-28 ~
ADPNN25M16-A	•	25	25	150	36	25	12.5	—	—	—	—	—

Recommend clamping torque: 4.0 N·m

PDPNN P-type
Applicable inserts: DN□□1504□□
Negative rake
Lever-lock system

External Profiling
Cutting edge style P

Toolholders Cat. No.	Stock	Dimensions (mm)								Std. Corner r_1	Applicable inserts	Page
		ϕ	ϕ	ϕ	L_1	L_2	ϕ	ϕ	ϕ			
PDPNN20Z5	•	20	20	150	36	20	12.5	—	—	0.8	DN□□1504□□	3-27 ~ 3-28 ~
PDPNN25Z5	•	25	25	170	36	25	12.5	—	—	—	—	—
PDPNN25M15E	•	25	25	150	36	25	12.5	—	—	1.2	DN□□1506□□	2-52 ~
PDPNN32SP15E	•	32	25	170	36	32	12.5	—	—	—	—	—

PDNNR/L P-type
Applicable inserts: DN□□1504□□
Negative rake
Lever-lock system

External Profiling
Cutting edge style N

Toolholders Cat. No.	Stock	Dimensions (mm)								Std. Corner r_1	Applicable inserts	Page
		ϕ	ϕ	ϕ	L_1	L_2	ϕ	ϕ	ϕ			
PDNNR/L4025	•	40	25	150	36	40	12	—	—	0.8	DN□□1504□□	3-27 ~ 3-28 ~
PDNNR/L5032	•	50	32	150	36	50	16	—	—	0.8	DN□□1506□□	2-52 ~
PDNNR/L5032H	•	50	32	150	36	50	16	—	—	0.8	DN□□1506□□	2-52 ~
PDNNR/L4025M15E	•	40	25	150	36	40	12	—	—	0.8	DN□□1506□□	2-52 ~
PDNNR/L5032M15E	•	50	32	150	36	50	16	—	—	0.8	DN□□1506□□	2-52 ~

Right hand (R) shown.

Basic Selection Chipbreakers DN□□1504□□□□

4-20 Features (4-6) Relating pages (14-17) Parts (14-17)

4-21 Relating pages (14-17) Parts (14-17)

Ordering information

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

Guidance

■ Designation system for general purpose TAC external toolholders	4-2
■ Outline of new TAC toolholder “Turning A”	4-4
■ Outline of new “Y Pro series” for Profiling.....	4-6
■ Structures and features of external TAC toolholders	4-8
■ Types and applications of TAC toolholders.....	4-10

4 TAC External Toolholders

Products

■ TAC toolholders for external turning

● Turning A [Double clamping system]	
D-type [One-action double clamping system]	
P-type [Lever-lock system]	
for CN □□ inserts.....	4-14
for WN □□ inserts.....	4-17
for DN □□ inserts.....	4-18
for TN □□ inserts.....	4-22
for SN □□ inserts.....	4-25
for VN □□ / YN □□ inserts.....	4-30
for RN □□ inserts.....	4-32
● Replacement parts for Turning A.....	4-33
for D-type.....	4-34
for P-type.....	4-35
● DimpleFX [Double clamping system] for dimple ceramic inserts	4-36
● TurnTec [Screw-on system].....	4-39
● TurnFeed [Double clamping system] for super high feeds.....	4-42
● Y-Pro series [Screw-on system].....	4-42
● A-type [Clamp-on system].....	4-44
● M-type [Multi-clamping system].....	4-46
● C-type [Clamp-on system].....	4-54
● H-type [Pull-down-pin system] for heavy cutting.....	4-56

■ TAC external toolholders for positive inserts

● S-type [Screw-on system].....	4-57
● T-type [Taper-lock system].....	4-65
● P-type [Lever lock system].....	4-66
● C-type [Clamp-on system].....	4-67

■ J-series TAC external toolholders for small lathes.....

■ J-series special purpose TAC toolholders for small lathes

● JSXG type for front and reverse turning.....	4-81
● JSXB type for back turning.....	4-82
● JSTB type for back turning.....	4-83
● JS-TBL3 type for back turning.....	4-83
● JSEG type for back turning.....	4-84

■ H-type [Pull-down, cartridge system] for wheel turning.....

■ MS-type [Lever lock / screw-on system].....

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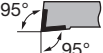
Designation System for TAC Toolholders

4

TAC External Toolholders

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

1 Clamping system

Symbol	Shape	Offset	H		With	P *		Without
A		Without	I		Without	Q *	45° 	With
			J		With	S		With
B		Without	J2 *		Without	V		Without
C	90° 	Without	K	75° 	With	U	93° 	With
D		Without	L	95° 	With	X	100° 	With
E	60° 	Without	L2 *	95° 	Without	Y	80° 	With
F	91° 	With	N		Without	Z		Without
G	 	With	N3 *		With	No mark: ISO symbol *mark: Tungaloy's symbol		
			P *		Without			

3 Cutting edge style

(Example)

1
A

W

3
L

N

R

(Example)

P

2
T

G

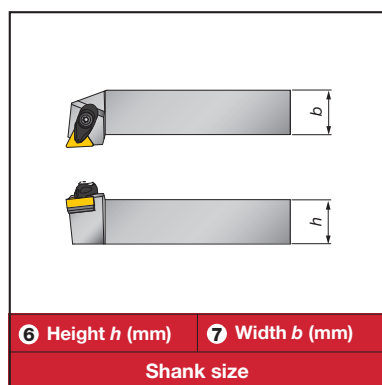
4
N

5
R

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

4 Relief angle of insert	
C	
B	
N	
P	

5 Hand of tool	
L	
N	
R	



6

25

20

7

25

20

F	80
H	100
K	125
M	150
P	170
Q	180
R	200
S	250
T	300
U	350

8 Holder length L_1 (mm)

8

M

K

08

3

9

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

11 Added symbol

11

A

3

10

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

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

10 Insert thickness (s)	
Symbol	Thickness (mm)
2	3.18
3	4.76

TAC Toolholders for External and Internal Turning

Turning Ace

TURNINGA

4-14 ~

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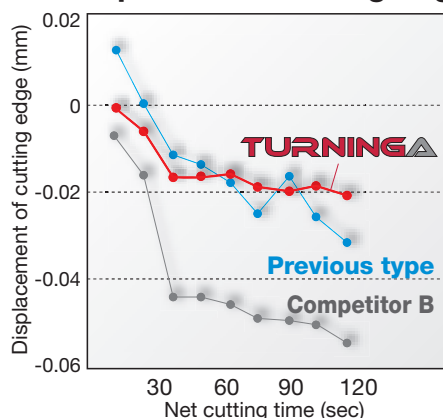
Highly rigid “Double-Clamp” system provides remarkable stability and high accuracy!

● Simple and strong double-clamp system

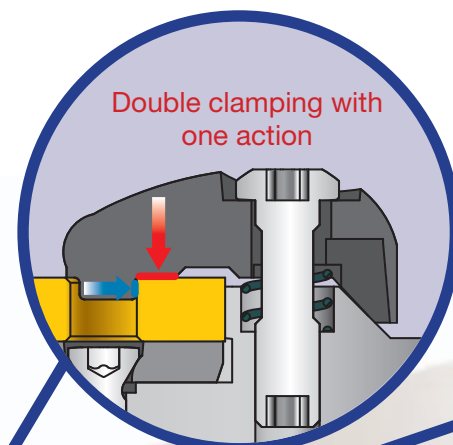
Provides strong clamping force with one screw

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

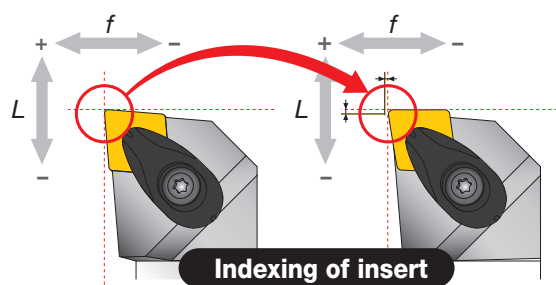
■ Comparison of cutting edge stability



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



Higher indexing accuracy



■ Indexing accuracy

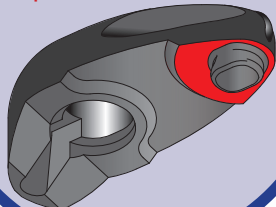
Type	f direction (μm)	L direction (μm)
TURNINGA	0.8	1.4
Previous type	1.1	2.2
Competitor A	2.8	7.7
Competitor B	3.8	1.5
Competitor C	1.0	2.2



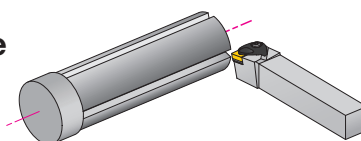
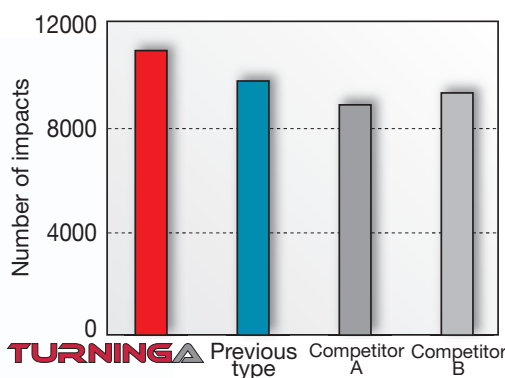
Unique clamp improves rigidity

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

Insert holding area is about 50% larger than previous models



Comparison of impact resistance



Toolholder : ACLNR2525M12-A
 Insert : CNMG120408-TM
 Grade : T9115
 Work material : Carbon steel (JIS S45C)
 Machining mode : Interrupted
 Cutting speed : $V_c = 200 \text{ m/min}$
 Depth of cut : $a_p = 1.0 \sim 2.0 \text{ mm}$
 Feed : $f = 0.3 \text{ mm/rev}$

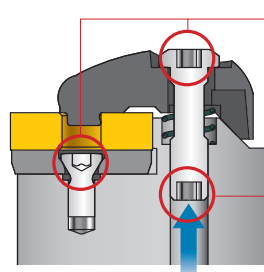
Easy handling and maintenance

Only one wrench required

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

Marking

Parts Cat. No. are marked on the holder.

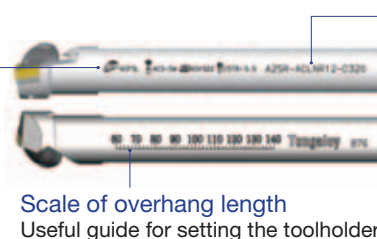
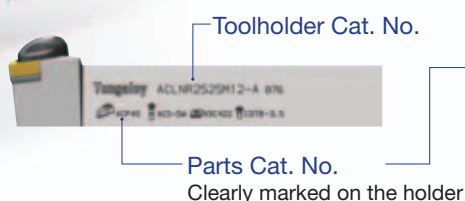


One wrench for both clamping and changing shim

Permits operation from underside

External-use toolholder

Internal-use toolholders



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

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

Profiling inserts

Y-PRO SERIES

PATENT PENDING

A new concept in profiling!

Inserts with a 25° corner angle to expand machining possibilities!!

Negative type

Positive type

VNMG / VBMT

Y Pro series

35° ⇒ 25°

This angle reduction contributes to reducing customer costs

Suitable for a wide range of machining applications

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

Negative
Positive

Spherical profiling
Enlarged clearance expands the interference avoidance area.

Negative
Positive

"V" grooving
Suitable for various "V" grooving applications

Positive

Face profiling
Allows drastic productivity and capability improvements
 $\theta \leq 30^\circ$

Positive

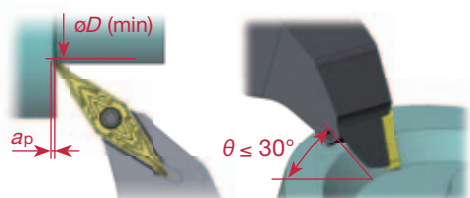
External undercutting
Allows a range of undercut forms to be machined

Positive

Internal undercutting and profiling
Allows undercutting of small diameters.

Comparison of undercutting capability

Reduced tool interference



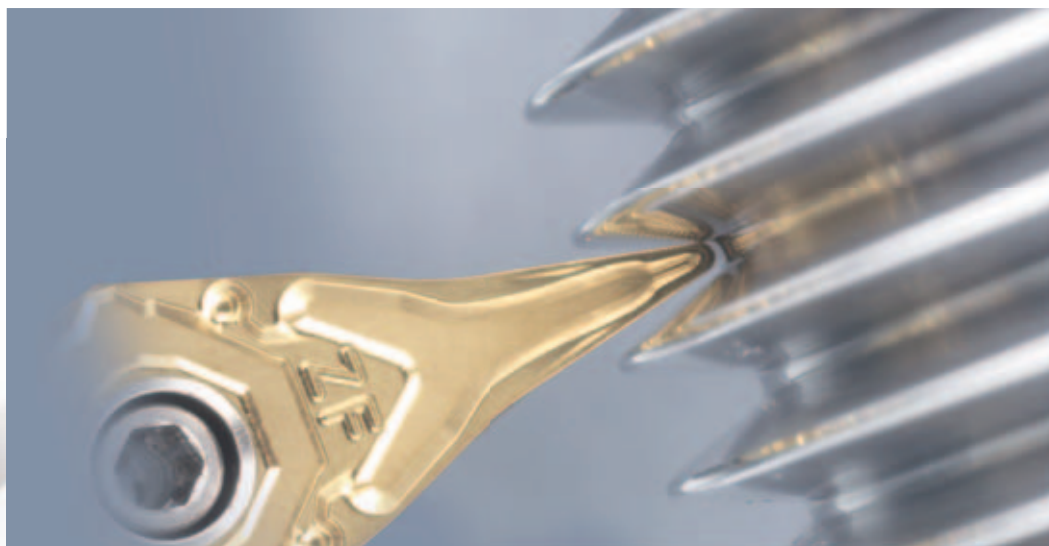
Y Pro series / YWMT type

Corner r_ϵ	a_p (mm)	ϕD (mm)
0.2	0.5	$\phi 10$
	1.0	$\phi 16$
0.4	0.5	$\phi 15$
	1.0	$\phi 18$
0.8	0.5	$\phi 21$
	1.0	$\phi 26$

Corner angle 35° / VBMT type

Corner r_ϵ	a_p (mm)	ϕD (mm)
0.4	0.5	$\phi 25$
	1.0	$\phi 30$
0.8	0.5	$\phi 45$
	1.0	$\phi 55$

Improves the capability of small diameter machining!

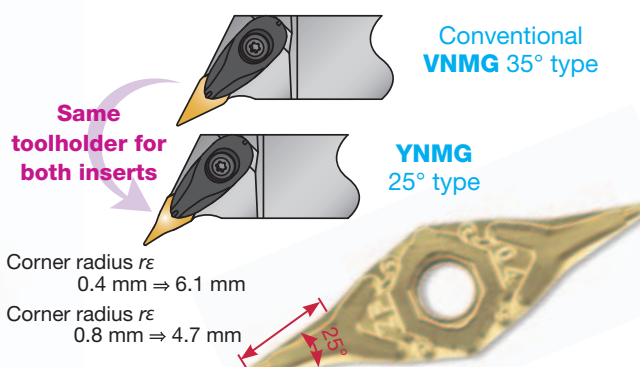


● YNMG type – Extremely capable and flexible insert

Negative

YNMG inserts are applicable for existing external and internal toolholders.

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



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

● YWMT type - for a variety of machining processes

Positive

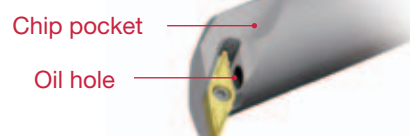
■ External toolholders

Vastly reduced tool interference in facing and undercutting.



■ Internal toolholders

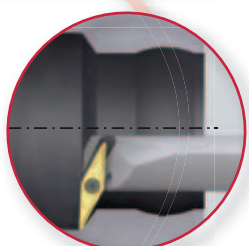
By using the specialized "Stream Jet Bar" series of boring toolholders, excellent chip evacuation is guaranteed with its internal coolant supply.



Positive

Internal profiling

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

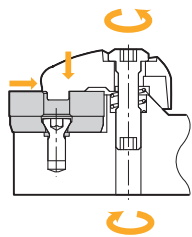
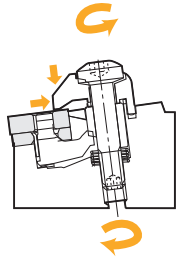
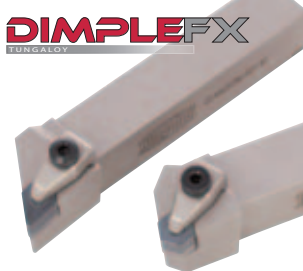
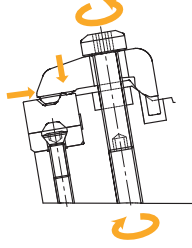
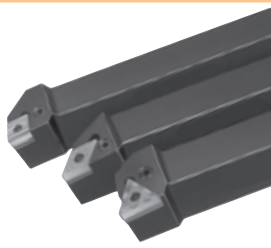
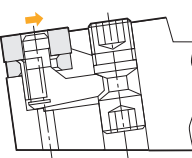
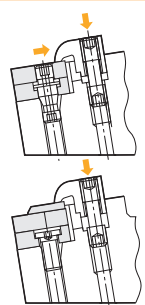
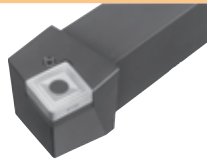
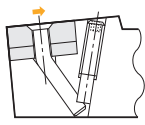


Structures and Features of External TAC Toolholders

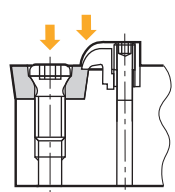
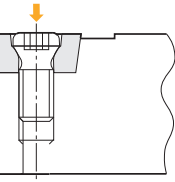
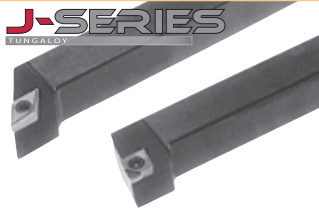
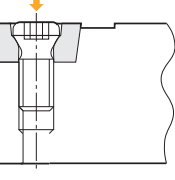
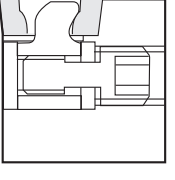
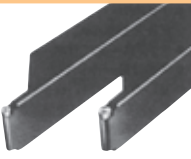
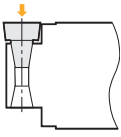
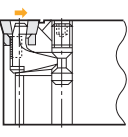
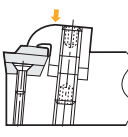
Negative

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TAC External Toolholders

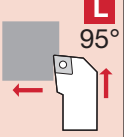
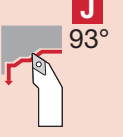
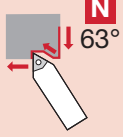
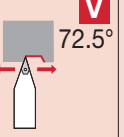
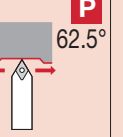
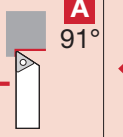
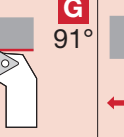
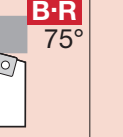
Turning A A Double clamping 1st Choice ▶ 4-14 ~			- Improved rigidity allows excellent cutting edge positioning accuracy and extended tool life. - Enlarged engaging area with the insert contributes to excellent cutting edge positioning, even when using a VNMG type insert (35° corner angle) whose cutting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

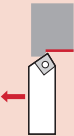
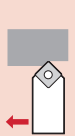
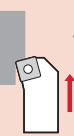
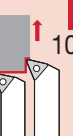
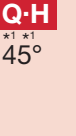
Positive

TurnFeed X Double Clamping (Screw-on / clamp) High feed ➤ 4-42 ~			- Allows super high feed machining. Amazingly 8 times the productivity. - The double clamping mechanism of the clamping screw and the clamp can securely clamp the insert.
S Screw-on ➤ 4-42 ~			- Simple clamping mechanism. - Smart shape without overhang area. - Good cutting action by using positive inserts.
J Screw-on Small lathes ➤ 4-69 ~			- Available in small to medium shank sizes and abundant cutting edge styles. - Secure insert fastening by highly durable Torx screw. - The shank of J type toolholders is ground on all four faces.
JT Back clamping Small lathes ➤ 4-69 ~			- Good operability for indexing the insert in limited space such as on gang tooling type lathes. - Good handling allows wrenching the clamping screw from back side of the toolholder. - Available shank height: 8, 10, 12 and 16 mm
T Taper-lock General ➤ 4-65			- Simplest mechanism composed only of an insert and toolholder. - Can be used by simply pushing the insert into the tapered hole of the toolholder. - The cavity formed on the top of the insert allows freer cutting action and chatterless machining. - Inserts are available in ø5, ø6, and ø8 mm diameters.
P Lever lock General ➤ 4-66			- Positive rake round insert is clamped through lever lock type clamping mechanism with high indexing, accuracy. - Used for external, face, profile cutting and high feed is possible with excellent surface finish. - Insert diameters: ø10,12,16, 20, 25 mm
C Clamp-on General ➤ 4-67 ~			- General purpose, clamp-on system, positive rake toolholders. - Strong insert clamping and excellent indexing accuracy. - The positive rake design allows freer cutting action.

Types and Applications of TAC Toolholders

Negative

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

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

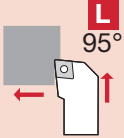
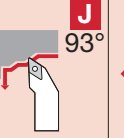
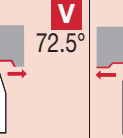
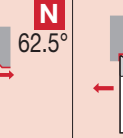
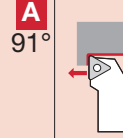
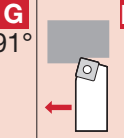
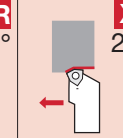
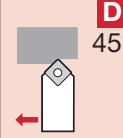
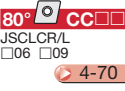
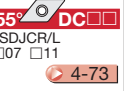
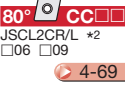
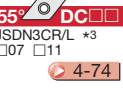
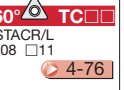
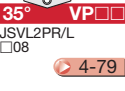
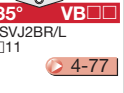
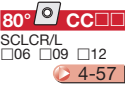
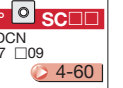
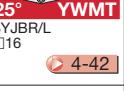
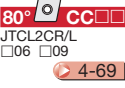
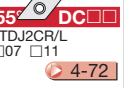
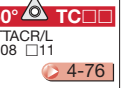
Note: *1 marked Q and H style are Tungaloy Standard.

Types and Applications of TAC Toolholders

Positive

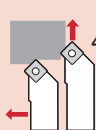
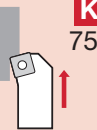
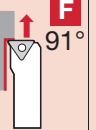
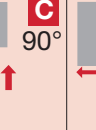
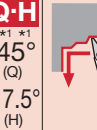
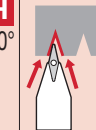
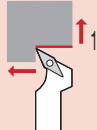
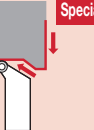
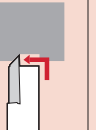
4

TAC External Toolholders

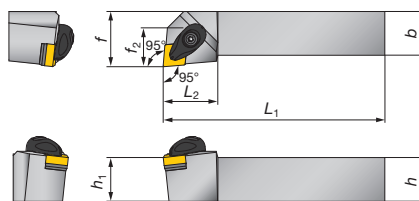
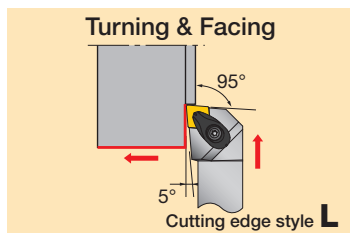
Application	Turning Facing	External profiling				Turning			Turning Facing	Turning Chamfering	
Cutting edge style											
Type											
X Double clamping (Screw-on/clamp)								 80° WPMT XWXPRL □09 ➤ 4-42			
P Lever lock											
C Clamp-on						 60° TP CTGPR/L □16 ➤ 4-67	 90° SP CSBPR/L □09 □12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

*2: L2 and J2: 0 offsetting *3



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

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



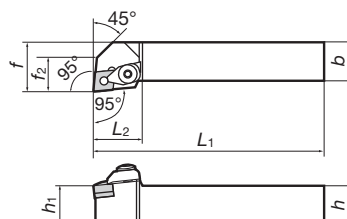
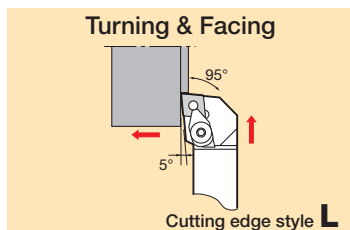
Right hand (R) shown.

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

*Recommend clamping torque: 4.0 N·m

D-type

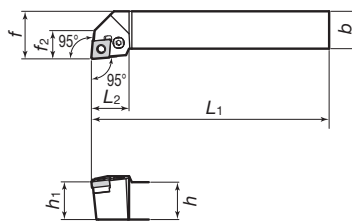
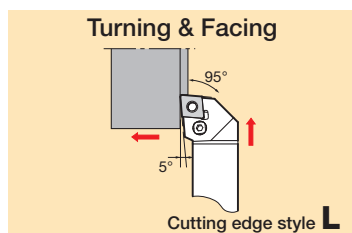
DCLNR/L



Right hand (R) shown.

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

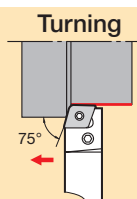
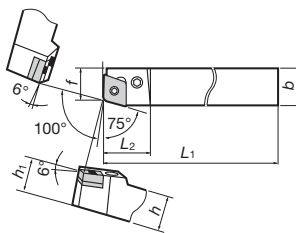
● : Stocked items.



Right hand (R) shown.

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

● : Stocked items.

Cutting edge style **B**

Right hand (R) shown.

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

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

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

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

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

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

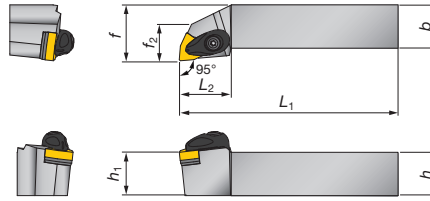
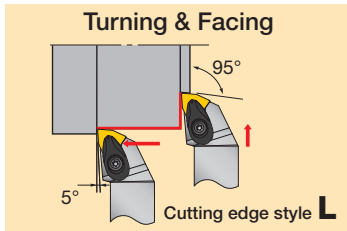
Operation	Precision finishing	Finishing	Finishing to medium cutting
	Grade	Grade	Grade
Non-ferrous	DX120	TH10	GH110
Page	3-21	2-42	2-48
Chipbreaker	T-DIA	O1	P
V_c (m/min)	1500 (500-2500)	600 (100-1000)	600 (100-1000)
a_p (mm)	0.5 (0.05-1.0)	0.5 (0.05-1.0)	2.0 (0.5-4.0)
f (mm/rev)	0.1 (0.05-0.2)	0.1 (0.03-0.15)	0.3 (0.2-0.5)
r_ϵ (mm)	0.4	0.4	0.8

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

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

For other machining types, see "Selection System"

➤ 2-4 ~



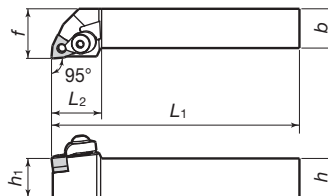
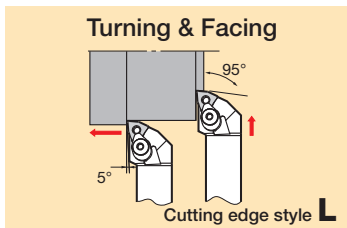
Right hand (R) shown.

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

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

D-type

DWLNR/L



Right hand (R) shown.

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

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

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

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

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

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

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

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

● : Stocked items.

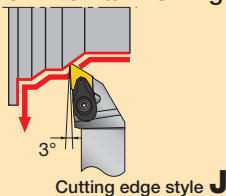
TURNING A-type

ADJNR/L

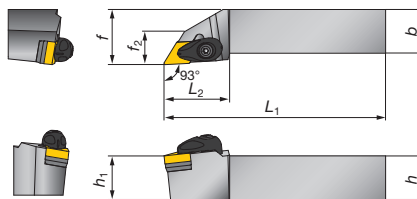
Applicable inserts
DN□□

Negative rake
Double clamping system

Turning & External Profiling



Cutting edge style J



Right hand (R) shown.

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

*Recommend clamping torque: 4.0 N·m

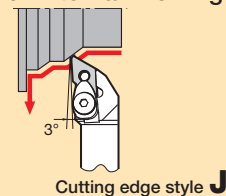
D-type

DDJNR/L

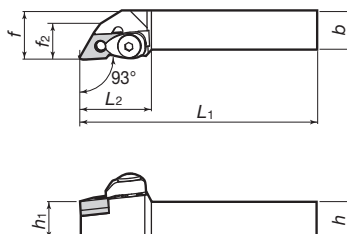
Applicable inserts
DN□□

Negative rake
“One-Double” system

Turning & External Profiling



Cutting edge style J



Right hand (R) shown.

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

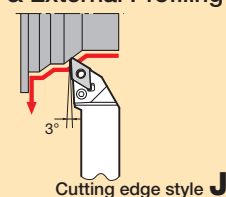
P-type

PDJNR/L

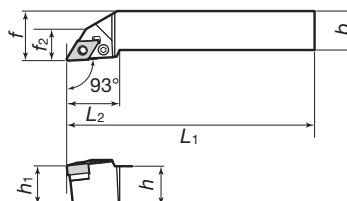
Applicable inserts
DN□□

Negative rake
Lever-lock system

Turning & External Profiling



Cutting edge style J



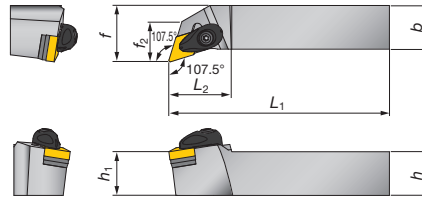
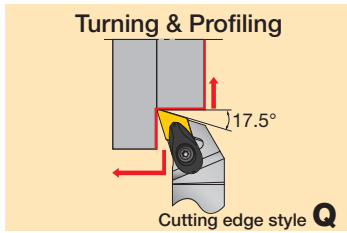
Right hand (R) shown.

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

● : Stocked items.

Applicable inserts
DN□□

Negative rake
Double clamping system



Right hand (R) shown.

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

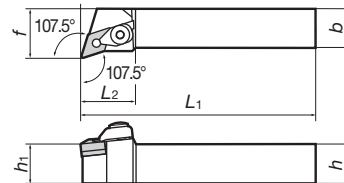
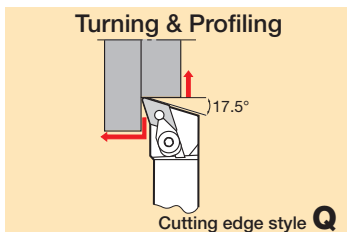
*Recommend clamping torque: 4.0 N·m

D-type

DDQNR/L

Applicable inserts
DN□□

Negative rake
“One-Double” system



Right hand (R) shown.

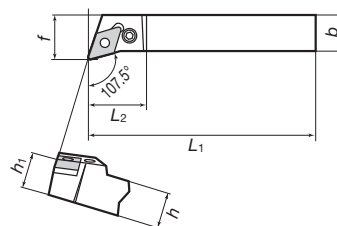
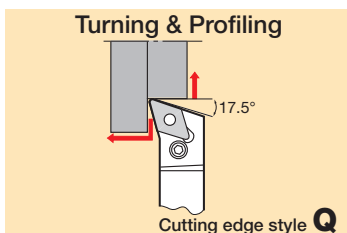
Toolholders Cat. No.	Stock		Dimensions (mm)							Std. Corner r_{ϵ}	Applicable inserts	Page
	R	L	h	b	L_1	L_2	h_1	f	f_2			
DDQNR/L2020K15	●	●	20	20	125	35	20	25	—	0.8	DN□□1504□□ (Except for 57-type chipbreaker inserts)	2-52 ~ 3-7 ~ T-CBN 3-21 ~ T-DIA
DDQNR/L2525M15	●	●	25	25	150	35	25	32	—			
DDQNR/L3225P15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

P-type

PDQNR/L

Applicable inserts
DN□□

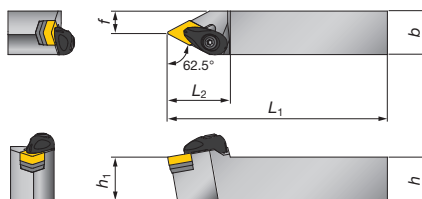
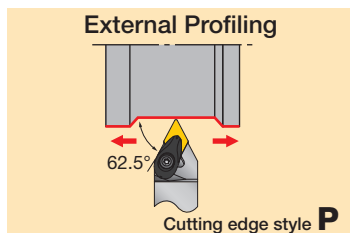
Negative rake
Lever-lock system



Right hand (R) shown.

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

● : Stocked items.



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

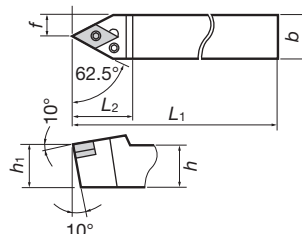
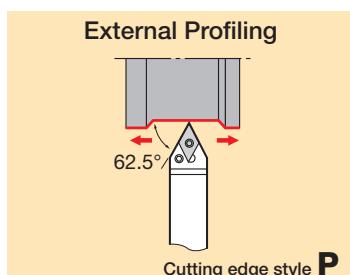
*Recommend clamping torque: 4.0 N·m

P-type

PDPNN

Applicable inserts
DN□□

Negative rake
Lever-lock system



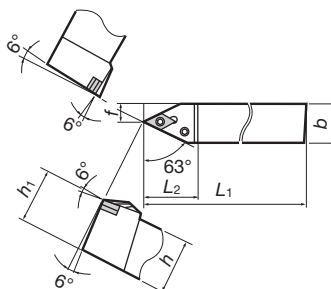
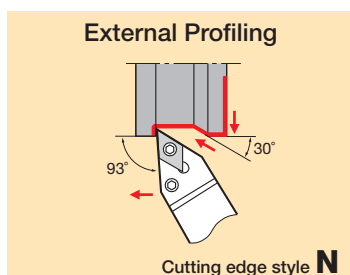
Toolholders Cat. No.	Stock	Dimensions (mm)							Std. Corner r_{ϵ}	Applicable inserts	Page
		h	b	L_1	L_2	h_1	f	f_2			
PDPNN2525	●	25	25	150	36	25	12.5	—	0.8	DN□□1504□□	2-52 ~ 3-7 ~ T-CBN 3-21 ~ T-DIA
PDPNN3225		32	25	170	36	32	12.5	—			
PDPNN2525M15E	●	25	25	150	36	25	12.5	—	1.2	DN□□1506□□	2-52 ~
PDPNN3225P15E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

P-type

PDNNR/L

Applicable inserts
DN□□

Negative rake
Lever-lock system



Right hand (R) shown.

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

● : Stocked items.

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

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

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

 Superalloys	Operation	Precision finishing	Finishing	Finishing to medium cutting	Medium cutting
	Grade	BX470	KS20	AH905	AH120
	Page	3-7	2-53	2-56	2-55
	Chipbreaker	T-CBN	SS	HMM	All-round
					

 Continuous	Vc (m/min)	200 (100-280)	50 (30-70)	50 (20-100)	50 (20-80)
	ap (mm)	0.3 (0.1-0.5)	1.0 (0.5-3.0)	1.5 (0.5-3.0)	3.0 (1.0-6.0)
	f (mm/rev)	0.1 (0.05-0.2)	0.15 (0.08-0.2)	0.2 (0.1-0.3)	0.3 (0.2-0.5)
	fe (mm)	0.4	0.8	0.8	0.8

For other machining types, see “Selection System”

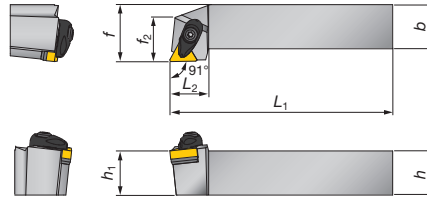
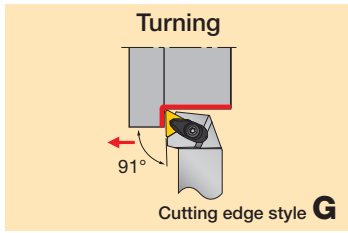
	Operation	Finishing	Finishing to medium cutting	Medium cutting	
 Stainless	Grade	T6120	T6130	T6130	
	Page	2-53	2-55	2-58	
	Chipbreaker	SF		SM	SH
		V_c (m/min)	150 (100-200)	120 (70-150)	120 (70-150)
		a_p (mm)	1.0 (0.5-3.0)	2.0 (0.5-4.0)	3.0 (3.0-6.0)
f (mm/rev)		0.1 (0.03-0.15)	0.3 (0.2-0.5)	0.3 (0.2-0.4)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

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

H Hard Materials  Continuous	Operation	Precision finishing	Finishing
	Grade	BXM10	BXM20
	Page	3-7	3-7
		T-CBN	T-CBN
	Chipbreaker		
	V_c (m/min)	200 (150-350)	150 (70-220)
	a_p (mm)	0.1 (0.05-0.30)	0.2 (0.05-0.30)
	f (mm/rev)	0.1 (0.03-0.18)	0.1 (0.05-0.25)
	r_e (mm)	0.4	0.4

Applicable inserts
TN□□

Negative rake
Double clamping system



Right hand (R) shown.

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

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

4

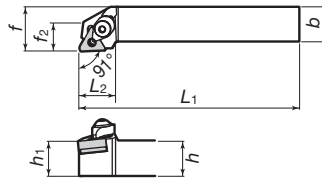
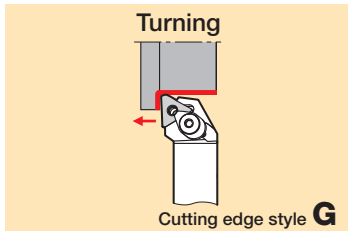
TAC External Toolholders

D-type

DTGNR/L

Applicable inserts
TN□□

Negative rake
“One-Double” system



Right hand (R) shown.

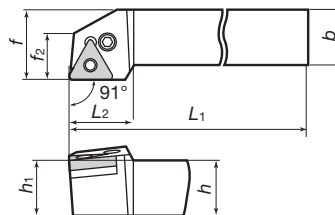
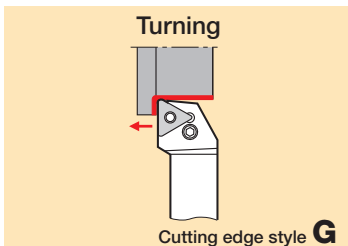
Toolholders Cat. No.	Stock		Dimensions (mm)							Std. Corner r_ϵ	Applicable inserts	Page
	R	L	h	b	L_1	L_2	h_1	f	f_2			
DTGNR/L2020K16	●	●	20	20	125	21	20	25	16	0.8	TN□□1604□□ (Except for 57-type chipbreaker inserts)	2-70 ~ 3-8 ~ T-CBN 3-21 ~ T-DIA
DTGNR/L2525M16	●	●	25	25	150	21	25	32	21			
DTGNR/L2525M22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

P-type

PTGNR/L

Applicable inserts
TN□□

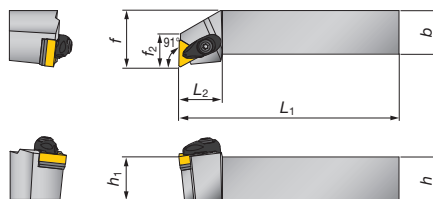
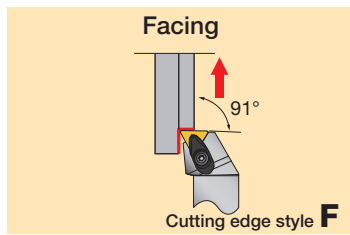
Negative rake
Lever-lock system



Right hand (R) shown.

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

● : Stocked items.

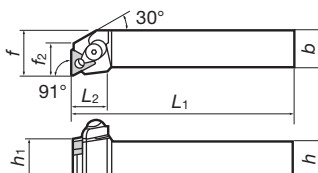
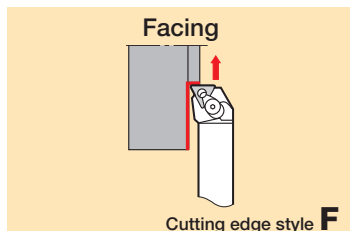


Right hand (R) shown.

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

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

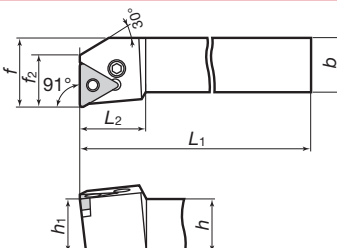
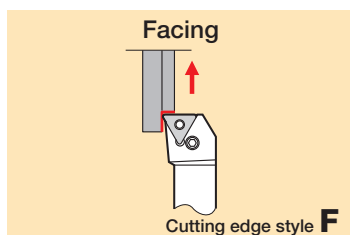
D-type DTFNR/L



Right hand (R) shown.

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

P-type PTFNR/L



Right hand (R) shown.

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

● : Stocked items.

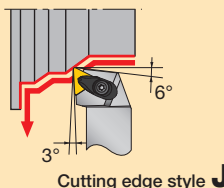
TURNING A-type

ATJNR/L

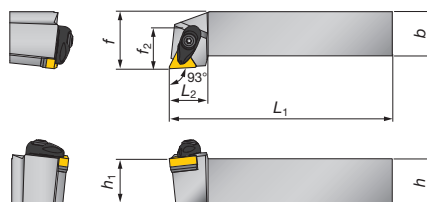
 Applicable inserts
 TN□□1604

 Negative rake
 Double clamping system

Turning • External Profiling



Cutting edge style J



Right hand (R) shown.

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

*Recommend clamping torque: 3.0 N·m

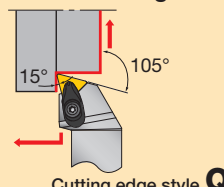
A-type

ATQNR/L

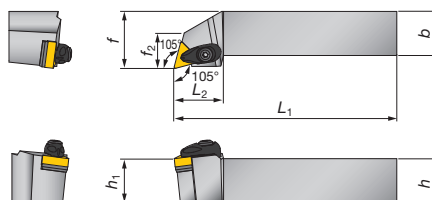
 Applicable inserts
 TN□□1604

 Negative rake
 Double clamping system

External Profiling



Cutting edge style Q



Right hand (R) shown.

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

*Recommend clamping torque: 3.0 N·m

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

P Steel	Operation	Precision finishing	Finishing	Finishing to medium cutting	Medium cutting
	Grade	NS730	GT730	T9115	T9115
	Page	2-70	2-71	2-74	2-77
Continuous	Chipbreaker				
	V_c (m/min)	200 (150-250)	200 (150-300)	200 (150-300)	220 (150-300)
	a_p (mm)	0.3 (0.05-0.5)	1.0 (0.3-1.5)	3.0 (1.0-5.0)	4.0 (3.0-6.0)
	f (mm/rev)	0.1 (0.03-0.15)	0.15 (0.08-0.3)	0.3 (0.2-0.5)	0.3 (0.2-0.5)
	r_{ϵ} (mm)	0.4	0.4	0.8	1.2

M Stainless	Operation	Finishing	Finishing to medium cutting
	Grade	T6120	T6130
	Page	2-71	2-74
Continuous	Chipbreaker		
	V_c (m/min)	150 (100-200)	120 (70-150)
	a_p (mm)	1.0 (0.5-3.0)	2.0 (0.5-4.0)
	f (mm/rev)	0.1 (0.03-0.15)	0.3 (0.2-0.4)
	r_{ϵ} (mm)	0.4	0.8

K Cast Iron	Operation	Precision finishing	Finishing	Finishing to medium cutting	Medium cutting
	Grade	BX930	T5115	T5115	T5115
	Page	3-8	2-72	2-75	2-77
Continuous	Chipbreaker				
	V_c (m/min)	700 (300-1200)	270 (140-400)	270 (150-400)	270 (140-400)
	a_p (mm)	0.3 (0.05-0.5)	1.0 (0.5-2.0)	2.0 (1.0-5.0)	4.0 (2.0-6.0)
	f (mm/rev)	0.1 (0.05-0.2)	0.15 (0.05-0.2)	0.3 (0.15-0.4)	0.4 (0.2-0.6)
	r_{ϵ} (mm)	0.4	0.4	0.8	1.2

N Non-ferrous	Operation	Precision finishing	Finishing	Finishing to medium cutting
	Grade	DX120	GH110	GH110
	Page	3-21	2-70	2-76h
Continuous	Chipbreaker			
	V_c (m/min)	1500 (500-2500)	600 (100-1000)	600 (100-1000)
	a_p (mm)	0.5 (0.05-1.0)	0.5 (0.05-1.0)	2.0 (0.5-4.0)
	f (mm/rev)	0.1 (0.05-0.2)	0.1 (0.03-0.15)	3.0 (0.2-0.5)
	r_{ϵ} (mm)	0.4	0.4	0.8

S Superalloys	Operation	Precision finishing	Finishing	Finishing to medium cutting	Medium cutting
	Grade	BX470	KS20	AH905	AH120
	Page	3-8	2-71	2-75	2-76
Continuous	Chipbreaker				
	V_c (m/min)	200 (100-280)	50 (30-70)	50 (20-100)	50 (20-80)
	a_p (mm)	0.3 (0.1-0.5)	1.0 (0.5-3.0)	1.5 (0.5-3.0)	2.0 (1.0-4.0)
	f (mm/rev)	0.1 (0.05-0.2)	0.1 (0.03-0.15)	0.2 (0.1-0.3)	0.3 (0.2-0.5)
	r_{ϵ} (mm)	0.4	0.4	0.8	0.8

H Hard Materials	Operation	Precision finishing	Finishing
	Grade	BXM10	BXM20
	Page	3-8	3-8
Continuous	Chipbreaker		
	V_c (m/min)	200 (150-350)	150 (70-220)
	a_p (mm)	0.1 (0.05-0.30)	0.2 (0.05-0.30)
	f (mm/rev)	0.1 (0.03-0.18)	0.1 (0.05-0.25)
	r_{ϵ} (mm)	0.4	0.4

For other machining types, see "Selection System"

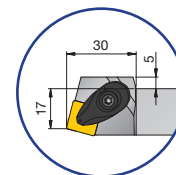
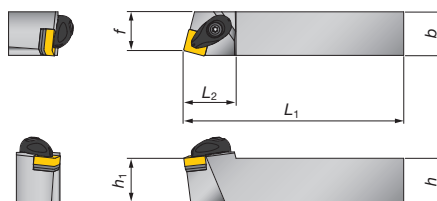
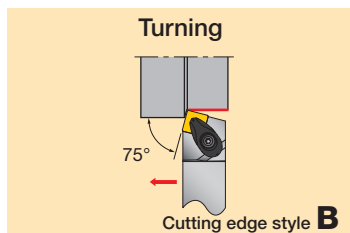
▶ 2-4 ~

● : Stocked items.

TURNING A-type ASBNR/L

Applicable inserts
SN□□

Negative rake
Double clamping system



Enlarged view of 2020 type
Right hand (R) shown.

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

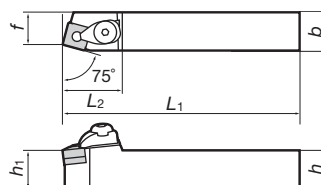
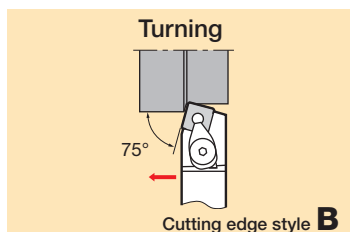
*Recommend clamping torque: 4.0 N·m

D-type

DSBNR/L

Applicable inserts
SN□□

Negative rake
“One-Double” system



Right hand (R) shown.

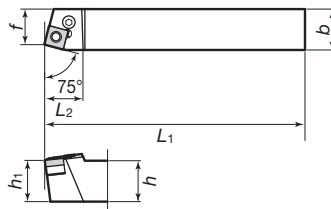
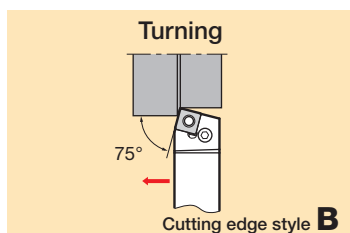
Toolholders Cat. No.	Stock		Dimensions (mm)							Std. Corner r_ϵ	Applicable inserts	Page
	R	L	h	b	L_1	L_2	h_1	f	f_2			
DSBNR/L2020K12	●	●	20	20	125	35	20	17	—	0.8	SN□□1204□□ (Except for 57-type chipbreaker inserts)	2-61 ~ 3-8 ~ T-CBN 3-21 ~ T-DIA
DSBNR/L2525M12	●	●	25	25	150	35	25	22	—			
DSBNR/L3225P15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

P-type

PSBNR/L

Applicable inserts
SN□□

Negative rake
Lever-lock system



Right hand (R) shown.

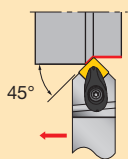
Toolholders Cat. No.	Stock		Dimensions (mm)							Std. Corner r_ϵ	Applicable inserts	Page
	R	L	h	b	L_1	L_2	h_1	f	f_2			
PSBNR/L1616H09E			16	16	100	22	16	13	—	0.8	SN□□0903□□	2-61 ~
PSBNR/L2020K12E	●	●	20	20	125	28	20	17	—	0.8	SN□□1204□□	2-61 ~ 3-8 ~ T-CBN 3-21 ~ T-DIA
PSBNR/L2525M12E	●	●	25	25	150	24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

● : Stocked items.

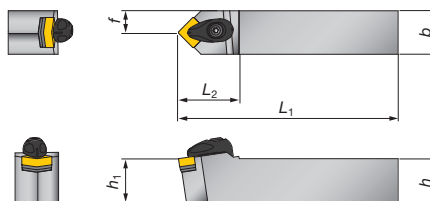
Applicable inserts
SN□□1204□□

Negative rake
Double clamping system

Turning & Chamfering



Cutting edge style **D**



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

*Recommend clamping torque: 4.0 N·m

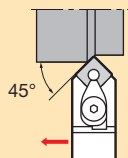
D-type

DSDNN

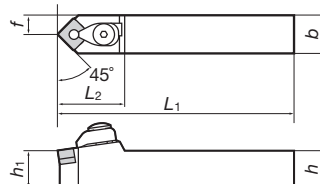
Applicable inserts
SN□□1204

Negative rake
“One-Double” system

Turning & Chamfering



Cutting edge style **D**



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

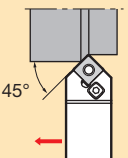
P-type

PSDNN

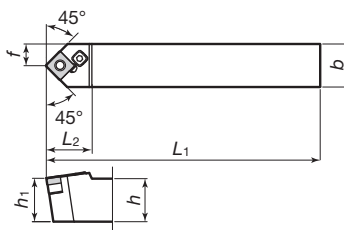
Applicable inserts
SN□□

Negative rake
Lever-lock system

Turning & Chamfering



Cutting edge style **D**

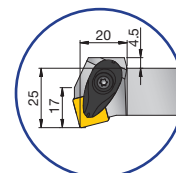
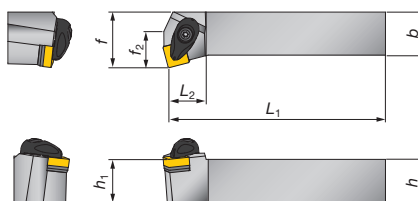
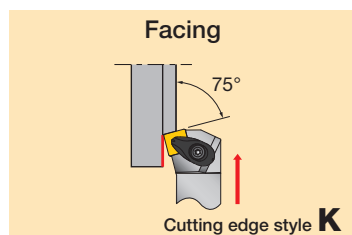


Toolholders Cat. No.	Stock	Dimensions (mm)							Std. Corner r_ϵ	Applicable inserts	Page
		h	b	L_1	L_2	h_1	f	f_2			
PSDNN1616H09E		16	16	100	22	16	8.0	—	0.8	SN□□0903□□	2-61 ~
PSDNN2020K12E	●	20	20	125	30	20	10.3	—	0.8	SN□□1204□□	2-61 ~ 3-8 ~ T-CBN 3-21 ~ T-DIA
PSDNN2525M12E	●	25	25	150	30	25	12.8	—	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

● : Stocked items.

Applicable inserts
SN□□1204□□

Negative rake
Double clamping system



Enlarged view of 2020 type
Right hand (R) shown.

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

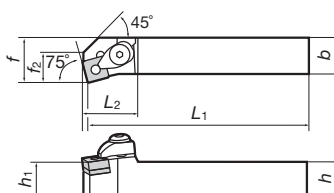
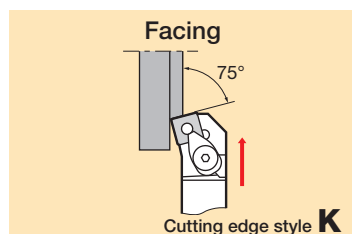
*Recommend clamping torque: 4.0 N·m

D-type

DSKNR/L

Applicable inserts
SN□□1204

Negative rake
“One-Double” system



Right hand (R) shown.

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

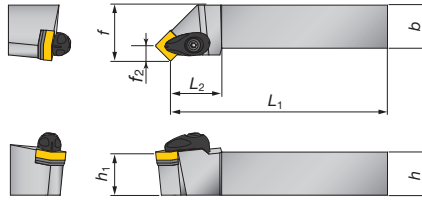
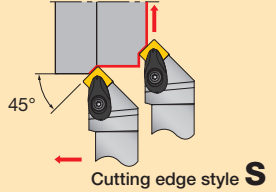
● : Stocked items.

TURNING A-type ASSNR/L

Applicable inserts
SN□□

Negative rake
Double clamping system

Turning & Facing & Chamfering



Right hand (R) shown.

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

*Recommend clamping torque: 4.0 N·m

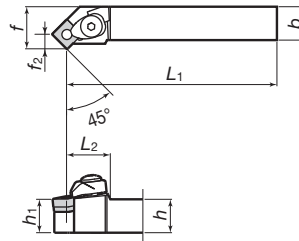
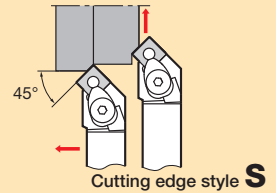
D-type

DSSNR/L

Applicable inserts
SN□□1204

Negative rake
“One-Double” system

Turning & Facing & Chamfering



Right hand (R) shown.

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

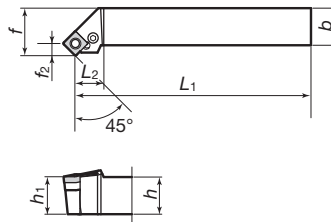
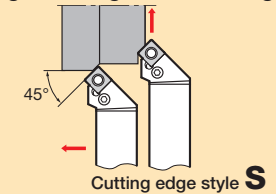
P-type

PSSNR/L

Applicable inserts
SN□□

Negative rake
Lever-lock system

Turning & Facing & Chamfering



Right hand (R) shown.

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

● : Stocked items.

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

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

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

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

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

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

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

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

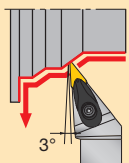
TURNING A-type

AVJNR/L

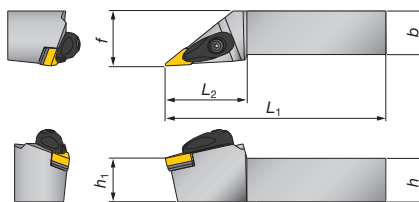
Applicable inserts
VN / YN□□1604

Negative rake
Double clamping system

Turning & External Profiling



Cutting edge style **J**



Right hand (R) shown.

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

*Recommend clamping torque: 3.0 N·m

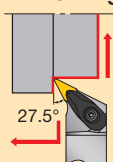
TURNING A-type

AVQNR/L

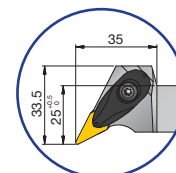
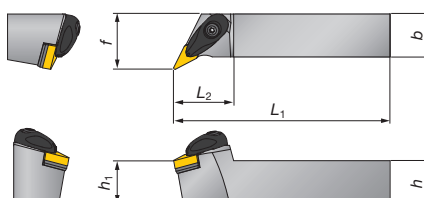
Applicable inserts
VN / YN□□1604

Negative rake
Double clamping system

Profiling



Cutting edge style **Q**



Enlarged view of 2020 type

Right hand (R) shown.

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

*Recommend clamping torque: 3.0 N·m

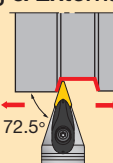
TURNING A-type

AVVNN

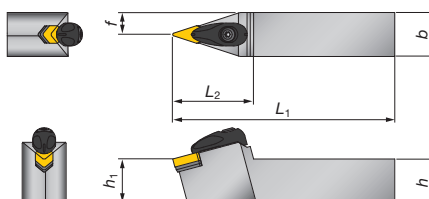
Applicable inserts
VN / YN□□1604

Negative rake
Double clamping system

Turning & External Profiling



Cutting edge style **V**



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

*Recommend clamping torque: 3.0 N·m

● : Stocked items.

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

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

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

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

For other machining types, see "Selection System"



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

		Operation	Precision finishing	Finishing
N Non-ferrous		Grade	DX120	GH110
		Page	3-21	2-87
	Continuous	Chipbreaker	T-DIA With chipbreaker O1	
				
		Vc (m/min)	1500 (500-2500)	600 (100-1000)
ap (mm)		0.5 (0.05-1.0)	0.5 (0.05-1.0)	
	f (mm/rev)	0.1 (0.05-0.2)	0.1 (0.03-0.15)	
	fc (mm)	0.4	0.2	

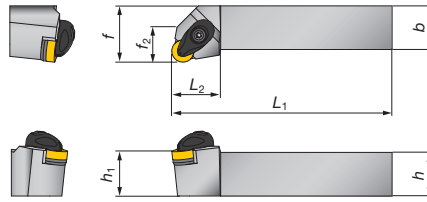
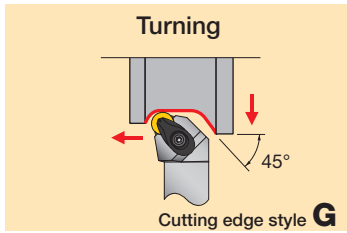
H Hard Materials  Continuous	Operation	Precision finishing	Finishing
	Grade	BXM10	BXM20
	Page	3-9	3-9
	Chipbreaker	T-CBN 	T-CBN 
	Vc (m/min)	200 (150-350)	150 (70-220)
ap (mm)		0.1 (0.05-0.30)	0.2 (0.05-0.30)
f (mm/rev)		0.1 (0.03-0.18)	0.1 (0.05-0.25)
fe (mm)		0.4	0.4

TURNING A-type

ARGNR/L

Applicable inserts
RN□□120400

Negative rake
Double clamping system



Right hand (R) shown.

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

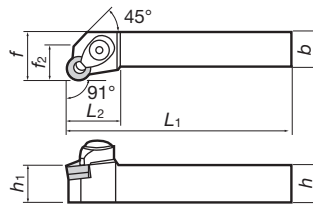
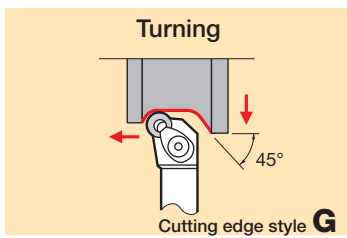
*Recommend clamping torque: 4.0 N·m

D-type

DRGNR/L

Applicable inserts
RN□□120400

Negative rake
"One-Double" system



Right hand (R) shown.

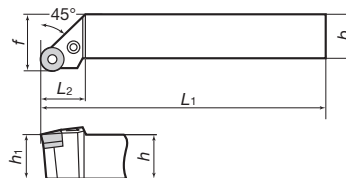
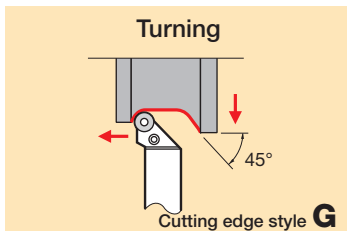
Toolholders Cat. No.	Stock		Dimensions (mm)							Std. Corner r_ϵ	Applicable inserts	Page
	R	L	h	b	L_1	L_2	h_1	f	f_2			
DRGNR/L2525M12	●	●	25	25	150	28	25	32	18	6	RN□□120400	2-92 ~

P-type

PRGNR/L

Applicable inserts
RN□□

Negative rake
Lever-lock system



Right hand (R) shown.

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

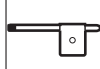
Basic Selection Chipbreakers RN□□1204□□-□□

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

● : Stocked items.

Parts

Parts for Turning A

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

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

Parts

Parts for D-type

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



 Parts for P-type

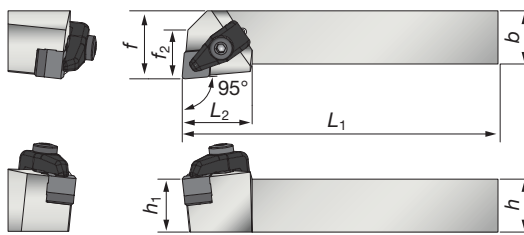
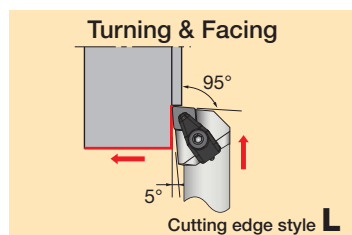
Toolholders Cat. No.		Applicable inserts		Shim	Spring pin	Lever	Clamping screw	Wrench
		Cat. No.	Shape					
PCLNR/L PCBNR/L	1616H09 2020K09 2525M09	CN□□0903□□		ELSC32	LSP3L	LCL33	LCS3	P-2.5
	1616H12E 2020K12E 2525M12E 3225P12E	CN□□1204□□		ELSC42	LSP4	LCL4	LCS4CA	P-3
	2525M16E 3225P16E 3232P16E	CN□□1606□□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

DIMPLEFX C-type for dimple inserts

CCLNR/L

Applicable inserts

CNGD1207□□

Negative rake
Double clamping system

Right hand (R) shown.

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

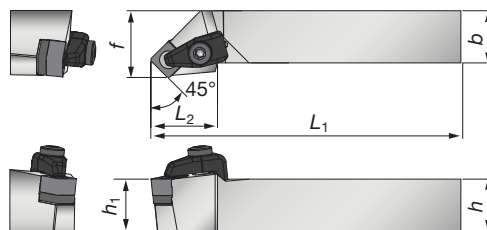
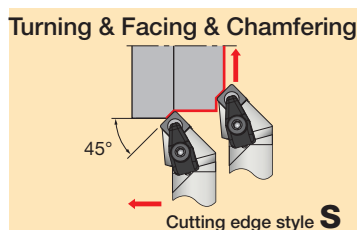
*Recommend clamping torque: 4.0 N·m

DIMPLEFX C-type for dimple inserts

CSSNR/L

Applicable inserts

SNGD1207□□

Negative rake
Double clamping system

Right hand (R) shown.

Toolholders Cat. No.	Stock	Dimensions (mm)							Std. Corner r_{ϵ}	Applicable inserts	Page
		h	b	L_1	L_2	h_1	f	f_2			
CSSNR2525M1207-RD	●	25	25	150	32	25	32	—	1.2	SNGD1207□□	4-38
CSSNL2525M1207-RD	●	25	25	150	32	25	32	—	1.2		4-38

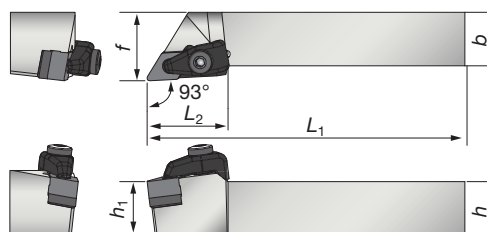
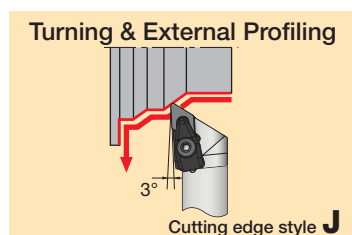
*Recommend clamping torque: 4.0 N·m

DIMPLEFX C-type for dimple inserts

CDJNR/L

Applicable inserts

DNGD1507□□

Negative rake
Double clamping system

Right hand (R) shown.

Toolholders Cat. No.	Stock	Dimensions (mm)							Std. Corner r_{ϵ}	Applicable inserts	Page
		h	b	L_1	L_2	h_1	f	f_2			
CDJNR2525M1507-RD	●	25	25	150	38	25	32	—	1.2	DNGD1507□□	4-38
CDJNL2525M1507-RD	●	25	25	150	38	25	32	—	1.2		4-38
CDJNR3225P1507-RD	●	32	25	170	38	32	32	—	1.2		4-38

*Recommend clamping torque: 4.0 N·m

● : Stocked items.

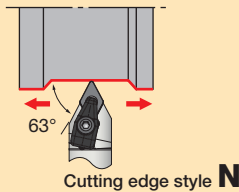
CDNNN

Applicable inserts

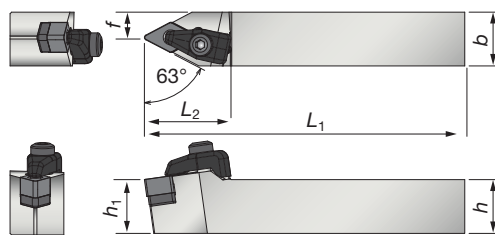
DNGD1507□□

Negative rake
Double clamping system

Turning & External Profiling



Cutting edge style **N**



Toolholders Cat. No.	Stock	Dimensions (mm)							Std. Corner rε	Applicable inserts	Page
		h	b	L ₁	L ₂	h ₁	f	f ₂			
CDNNN2525M1507-RD	●	25	25	150	40	25	12.5	—	1.2	DNGD1507□□	4-38

*Recommend clamping torque: 4.0 N·m

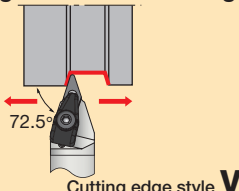
CVVNN

Applicable inserts

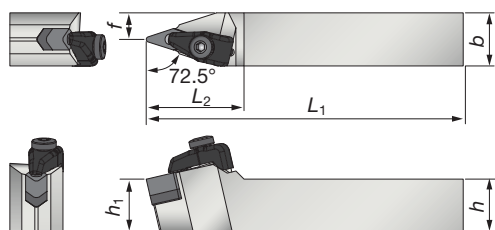
VNGD160712

Negative rake
Double clamping system

Turning & External Profiling



Cutting edge style **V**



Toolholders Cat. No.	Stock	Dimensions (mm)							Std. Corner rε	Applicable inserts	Page
		h	b	L ₁	L ₂	h ₁	f	f ₂			
CVVNN2525M1607-RD	●	25	25	150	46	25	12.5	—	1.2	VNGD160712	4-38

*Recommend clamping torque: 4.0 N·m

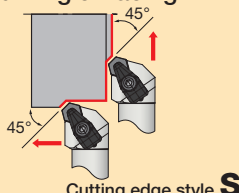
CHSNR

Applicable inserts

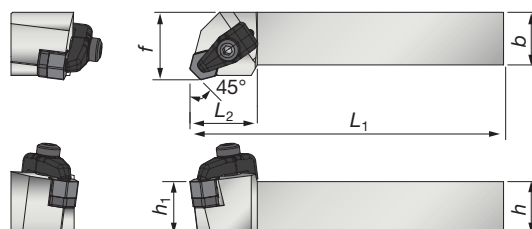
HNGD0507□□

Negative rake
Double clamping system

Turning & Facing



Cutting edge style **S**



Toolholders Cat. No.	Stock	Dimensions (mm)							Std. Corner rε	Applicable inserts	Page
		h	b	L ₁	L ₂	h ₁	f	f ₂			
CHSNR2525M0507-RD	●	25	25	150	32	25	32	—	1.2	HNGD0507□□	4-38

*Recommend clamping torque: 4.0 N·m

● : Stocked items.

Inserts for C-type

Application	Shape	Cat. No.	Stocked Grade	Dimensions (mm)			
			FX105	Inner circle ød	Thickness s	Hole dia. ød ₁	Corner radius rε
Finishing to medium cutting		CNGD120712	●	12.7	7.94	—	1.2
		CNGD120716	●	12.7	7.94	—	1.6
		SNGD120712	●	12.7	7.94	—	1.2
		SNGD120716	●	12.7	7.94	—	1.6
		DNGD150708	●	12.7	7.94	—	0.8
		DNGD150712	●	12.7	7.94	—	1.2
		DNGD150716	●	12.7	7.94	—	1.6
		VNGD160712	●	9.525	7.94	—	1.2
		HNGD050712	●	12.7	7.94	—	1.2
		HNGD050716	●	12.7	7.94	—	1.6

Note: Applicable only C-type toolholder for dimple.

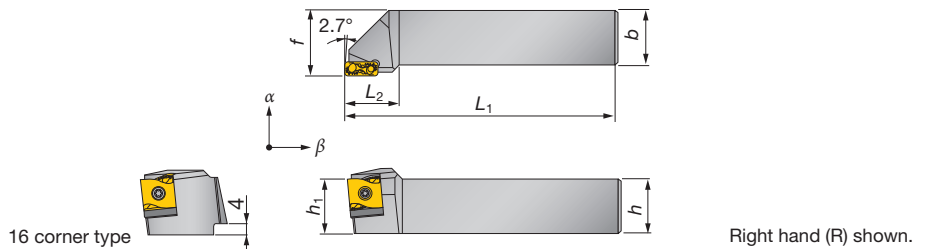
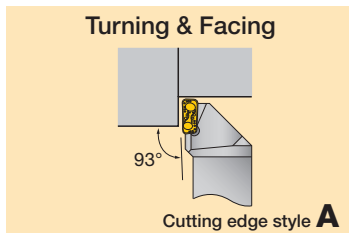
Standard cutting conditions

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

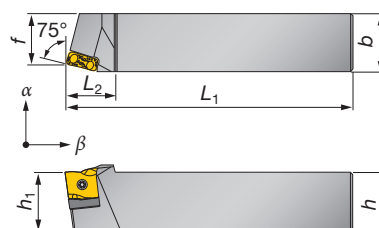
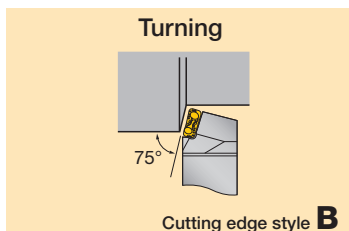
Parts for C-type

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

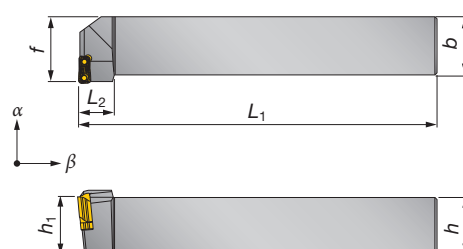
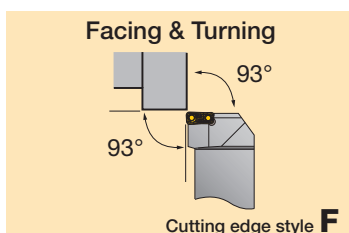
● : Stocked items.



Toolholders Cat. No.	Stock		Dimensions (mm)								Applicable inserts	Page
	R	L	h	b	L ₁	L ₂	h ₁	f	α	β		
TLANR/L1616H12	●	●	16	16	100	20	16	20	-6°	-6°	LNMX1204□□□R/L	4-40
TLANR/L1616M12S	●	●	16	16	150	20	16	20	-6°	-6°		
TLANR/L2020K12	●	●	20	20	125	20	20	25	-6°	-6°		
TLANR/L2525M12	●	●	25	25	150	20	25	30	-6°	-6°		
TLANR/L2020K16	●	●	20	20	125	25	20	25	-6°	-6°	LNMX1606□□□R/L	4-40
TLANR/L2525M16	●	●	25	25	150	25	25	30	-6°	-6°		
TLANR/L3232P16	●	●	32	32	170	35	32	37	-6°	-6°		
TLANR/L4040R16	●	●	40	40	200	35	40	47	-6°	-6°		
TLANR/L3232P24	●	●	32	32	170	35	32	38	-6°	-6°	LNMX2410□□□R/L	4-40
TLANR/L4040R24	●	●	40	40	200	40	40	47	-6°	-6°		
TLANR/L5050S24	●	●	50	50	250	40	50	57	-6°	-6°		



Toolholders Cat. No.	Stock		Dimensions (mm)								Applicable inserts	Page
	R	L	h	b	L ₁	L ₂	h ₁	f	α	β		
TLBNR/L4040R24	●	●	40	40	200	35	40	35	-7.4°	-4.3°	LNMX2410□□□R/L	4-40



Toolholders Cat. No.	Stock		Dimensions (mm)								Applicable inserts	Page
	R	L	h	b	L ₁	L ₂	h ₁	f	α	β		
TLFNR/L2525M16	●	●	25	25	150	20	25	30	-6°	-6°	LNMX1606□□□L/R	4-40
TLFNR/L3232P16	●	●	32	32	170	20	32	37	-6°	-6°		

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

● : Stocked items

■ Inserts for TurnTec

Right hand (R) shown.

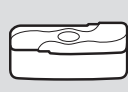
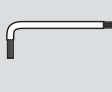
Cat. No.	Stocked grades						Dimensions (mm)							
	Coated						W	L	h	r _ε				
	T9115		T9125		AH725									
	R	L	R	L	R	L								
LNMX120408R/L-TDR	●	●	●	●			4.8	12.0	11.6	0.8				
LNMX120412R/L-TDR	●	●	●	●			4.8	12.0	11.6	1.2				
LNMX160608R/L-TDR	●	●	●	●			6.4	16.2	13.5	0.8				
LNMX160612R/L-TDR	●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

Right hand (R) shown.

● : Stocked items

★ : Available from 2013

■ Parts for TurnTec

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

 Standard cutting conditions

* Values in red shows the condition for facing

LNMX1204□□□-□□□

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

LNMX1606□□□-□□□

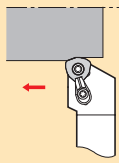
Work materials	Chip-breakers	Grades	Cutting speed Vc (m/min)	Depth of cut: ap (mm)			Feed: f (mm/rev)		
				r _ε : 0.8	r _ε : 1.2	r _ε : 1.6	r _ε : 0.8	r _ε : 1.2	r _ε : 1.6
Steels S45C, SCM415 etc. (C45, 18CrMo4 etc.)	TDR	T9115	120 - 250	0.5 - 5	0.8 - 6	1 - 8	0.15 - 0.6	0.25 - 0.8	0.3 - 1
		T9125	80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

LNMX2410□□□-□□□

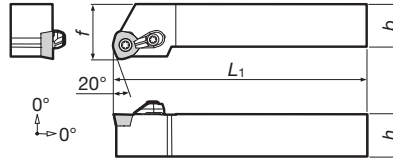
Work materials	Chip-breakers	Grades	Cutting speed Vc (m/min)	Depth of cut: ap (mm)		Feed: f (mm/rev)	
				r _ε : 1.6	r _ε : 2.4	r _ε : 1.6	r _ε : 2.4
Steels S45C, SCM415 etc. (C45, 18CrMo4 etc.)	TDR	T9115	120 - 250	4 - 15	5 - 15	0.3 - 1.0	0.3 - 1.1
		T9125	80 - 150	1 - 4.5	1 - 4.5		
Stainless steels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



Turning & Facing



Cutting edge style **X**



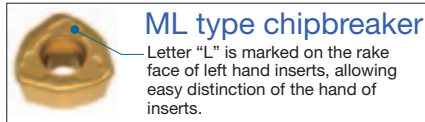
Right hand (R) shown.

Cat. No.	Stock		Dimensions (mm)				Applicable inserts	Clamp set	Clamping screw	Wrench
	R	L	h	b	L ₁	f				
XWXPR/L2525M09	●	●	25	25	150	32	WPMT090725ZPR/L-ML	CSY-20	CSTB-5	IP-20T
XWXPR/L3232P09	●	●	32	32	170	40				
XWXPR/L4040S09	●	●	40	40	250	50				

Inserts

	Cat. No.	Accuracy	Honing	Grades			Dimensions (mm)			
				T9115	T9125	AH120	A	B	T	r _ε
	WPMT090725ZPR-ML	M	With	●	●	●	9	15	7	2.5
	WPMT090725ZPL-ML			●	●	●				

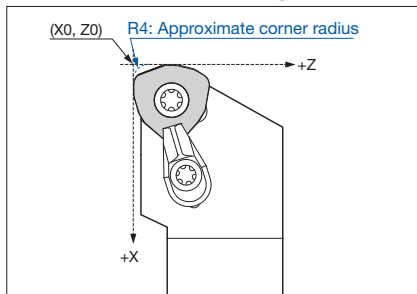
Note: Care should be taken not to confuse the hand of inserts to be used.



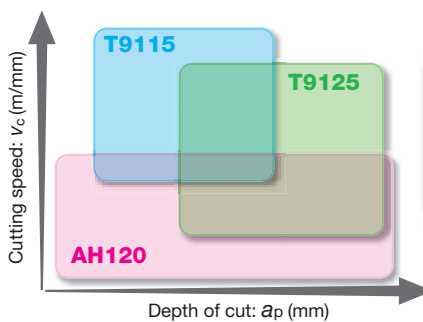
ML type chipbreaker

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

Zero point setting method



Application on areas



First choice

● T9125

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

● T9115

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

● AH120 (Complementary grade for stainless and mild steels)

- In machining stainless and mild steels, if chipping or breakage occurs, use AH120.

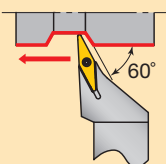
Standard cutting conditions

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

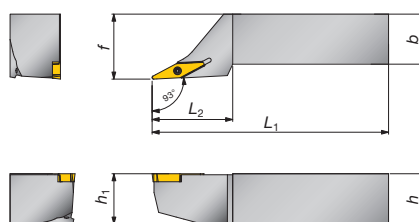
Note: When the side cutting edge is used for facing, the maximum feed is limited to within 1.0 mm/rev.

Y-PRO SERIES S-type SYJBR/L

Spherical surface cutting / Taper cutting



Cutting edge symbol **J**



Right hand (R) shown.

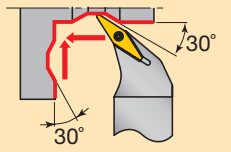
Toolholders Cat. No.	Stock		Dimensions (mm)						Std. Corner radius r _ε	Applicable insert	Replacement parts	
	R	L	h	b	L ₁	L ₂	h ₁	f			Clamping screw	Wrench
SYJBR/L2020K16	●	●	20	20	125	35	20	25	0.8	YWMT16T3□□	CSTB-2.5L080	T-8F
SYJBR/L2525M16	●	●	25	25	150	40	25	32				

● : Stocked items.
▲ : Shortly unavailable

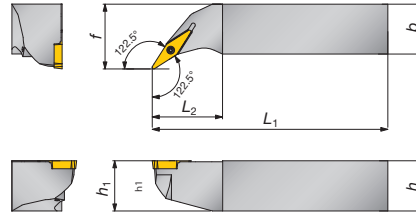
Y-PRO SERIES S-type SYQBR/L

Positive rake
Screw-on system

External & Undercutting



Cutting edge symbol **Q**



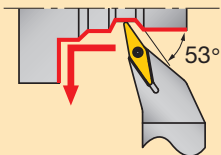
Right hand (R) shown.

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

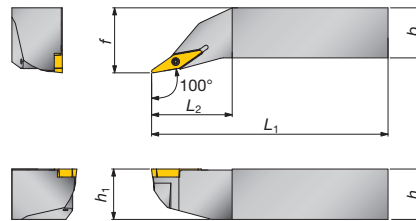
Y-PRO SERIES S-type SYHBR/L

Positive rake
Screw-on system

External & Retracting



Cutting edge symbol **H**



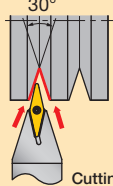
Right hand (R) shown.

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

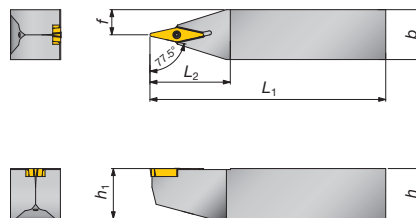
Y-PRO SERIES S-type SYIBN

Positive rake
Screw-on system

External & "V" grooving



Cutting edge symbol **I**



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

Inserts

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

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

● : Stocked items.
▲ : Shortly unavailable

Features
(4-6)

Relating
pages

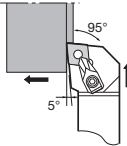
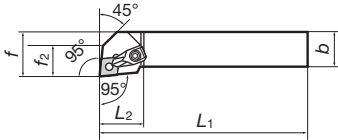
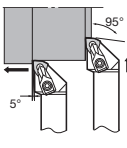
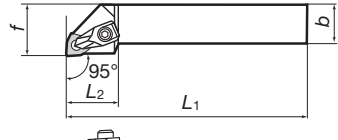
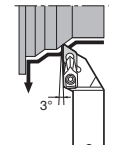
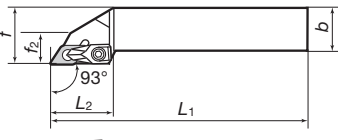
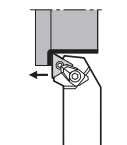
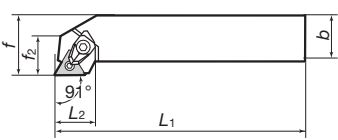
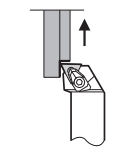
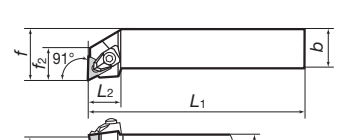
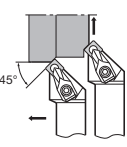
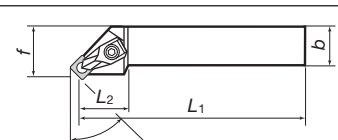
Parts
(14-1~)

Toolholders for External Turning

Negative rake
Clamp-on system

4

TAC External Toolholders

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

* Will be replaced by Turning A.

Toolholders for External Turning

 Parts for A-type

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

1) For 4.76 mm thick inserts

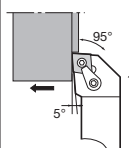
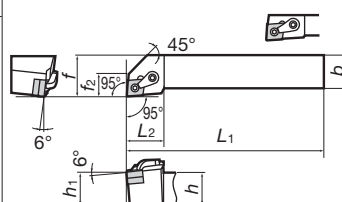
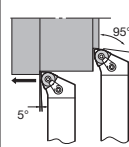
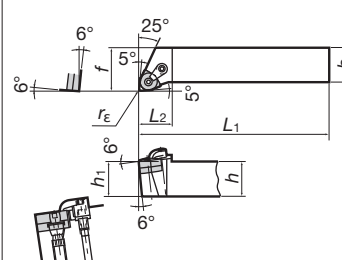
2) For 6.35 mm thick inserts

Toolholders for External Turning

Negative rake
Multi clamping system

4

TAC External Toolholders

Tooling styles	Cat. No.	Stock		Dimensions (mm)								Std. Corner r _E	Applicable inserts	Shape
		R	L	h	b	L ₁	L ₂	h ₁	f	f ₂				
Turning • Facing MCLNR/L  Cutting edge style L	MCLNR/L1616H12			16	16	100		16	20	—		0.8	CN□□1204□□ 80°  80°  ➤ 2-42 ~ T-CBN ➤ 3-7 ~ T-DIA ➤ 3-21 ~	
	MCLNR/L2020K12			20	20	125		20	25					
	MCLNR/L2525M12	●	●	25		150		25		18				
	MCLNR/L3225P12			32		170		32						
	MCLNR/L2020K12C			20	20	125		20	25			0.8	CN□□1207□□ 80°  ➤ 2-51 CN□□1206□□ 80° 	
	MCLNR/L2525M12C			25		150	32	25		18				
	MCLNR/L3225P12C			32		170		32						
	MCLNR/L2525M16			25		150		25				1.2	CN□□1606□□ 80°  ➤ 2-45 ~ (CN□□1604□□)	
	MCLNR/L3225P16						35		32	22				
	MCLNR/L3232P16			32		170		32		40				
MCLNR/L3232P19			32	32	170		32	40		30	1.2	CN□□1906□□ 80°  ➤ 2-45 ~		
MCLNR/L4040R19			40	40	200		40	50						
Turning • Facing MWLNR/L  Cutting edge style L	MWLNR/L2020K08	●		20	20	125		20	25			0.8	WN□□0804□□ 80°  ➤ 2-80 ~ T-CBN ➤ 3-9 ~	
	MWLNR/L2525M08	●	●	25		150	25	25		32				
	MWLNR/L3225P08			32		170		32						
	MWLNR/L2525M10			25		150		25				1.2	WN□□1006□□ 80°  ➤ 2-85	
	MWLNR/L3225P10						30		32					
	MWLNR/L3232P10			32		170			40					
	MWLNR/L4040R10			40	40	200		40	50					
	MWLNR/L3232P13			32	32	170		32	40			1.2	WN□□1306□□ 80° 	
	MWLNR/L4040R13			40	40	200		40	50					

Right hand (R) shown.

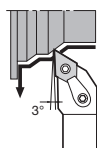
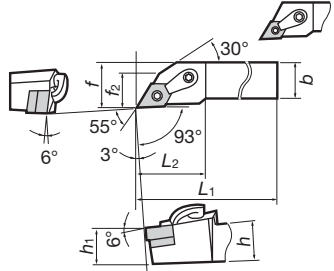
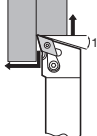
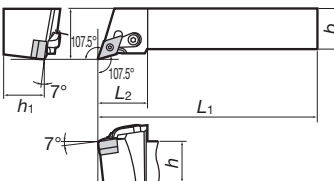
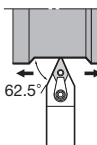
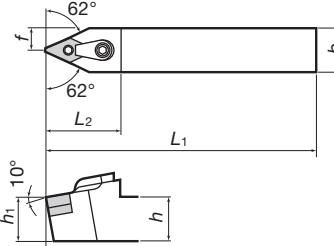
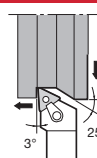
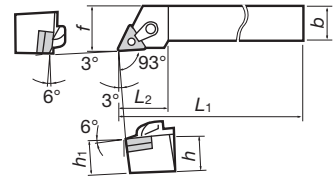
Right hand (R) shown.

Right hand (R) shown.

Right hand (R) shown.

● : Stocked items.

Toolholders for External Turning

Tooling styles	Cat. No.	Stock		Dimensions (mm)								Std. Corner r _E	Applicable inserts	Shape
		R	L	h	b	L ₁	L ₂	h ₁	f	f ₂				
External profiling MDJNR/L  Cutting edge style J	MDJNR/L1616H11			16	16	100	30	16	20	—	0.8	DN□□1104□□ 55°/6° ➤ 2-52 ~	 Right hand (R) shown.	
	MDJNR/L2020K15			20	20	125		20	25			DN□□1504□□ 55°/6° 55°/6°		
	MDJNR/L2525M15	●		25		150		25			0.8	DN□□1506□□ 55°/6° ➤ 2-52 ~		
	MDJNR/L3225P15				25		38		32	19		T-CBN ➤ 3-7 ~		
	MDJNR/L3232P15			32		170		32		40		T-DIA ➤ 3-21 ~		
	MDJNR/L2020K15C			20	20	125		20	25			DN□□1507□□ 55°/6° ➤ 2-60 ~		
	MDJNR/L2525M15C			25		150		25		32	19	0.8		DN□□1506□□ 55°/6° ➤ 2-52 ~
	MDJNR/L3225P15C					32		32		40				
	MDJNR/L3232P15C				32	170		32		40				
Profiling MDQNR/L  Cutting edge style Q	MDQNR/L1616H11			16	16	100	30	16	20	—	0.8	DN□□1104□□ 55°/6° ➤ 2-52 ~	 Right hand (R) shown.	
	MDQNR/L2020K15			20	20	125		20	25			DN□□1504□□ 55°/6° 55°/6°		
	MDQNR/L2525M15			25		150		25		32	—	0.8		DN□□1506□□ 55°/6° ➤ 2-52 ~
	MDQNR/L3225P15					32		32		40		T-CBN ➤ 3-7 ~		
	MDQNR/L3232P15				32	170		32		40		T-DIA ➤ 3-21 ~		
External profiling MDPNN  Cutting edge style P	MDPNN1616H11			16	16	100	36	16	8		0.8	DN□□1104□□ 55°/6° ➤ 2-52 ~	 Right hand (R) shown.	
	MDPNN2020K15			20	20	125		20	10			DN□□1504□□ 55°/6° 55°/6°		
	MDPNN2525M15	●		25		150		25		12.5	—	0.8		DN□□1506□□ 55°/6° ➤ 2-52 ~
	MDPNN3225P15					32		32		16		T-CBN ➤ 3-7 ~		
	MDPNN3232P15				32	170		32		16		T-DIA ➤ 3-21 ~		
External profiling MTJNR/L  Cutting edge style J	MTJNR/L2020K16			20	20	125		20	25			TN□□1603□□ TN□□1604□□ 60°/6° 60°/6° ➤ 2-70 ~	 Right hand (R) shown.	
	MTJNR/L2525M16	●		25		150	28	25		32	—	0.8		T-CBN ➤ 3-8 ~
	MTJNR/L3225P16				25							T-DIA ➤ 3-21 ~		
	MTJNR/L2525M22			25		150		25		32				TN□□2204□□ 60°/6° 60°/6° ➤ 2-70 ~
	MTJNR/L3225P22					32		32		40				
	MTJNR/L3232P22				32	170		32		40				

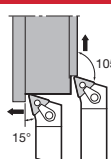
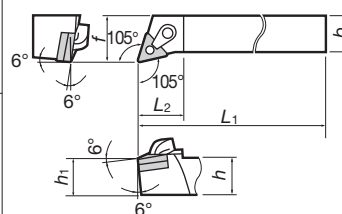
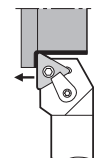
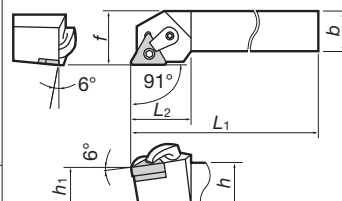
● : Stocked items.

Toolholders for External Turning

Negative rake
Multi clamping system

4

TAC External Toolholders

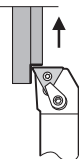
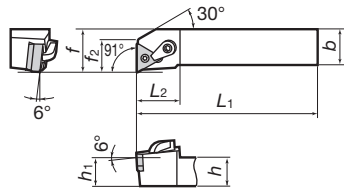
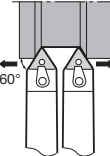
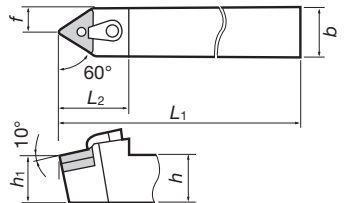
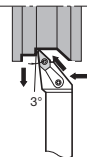
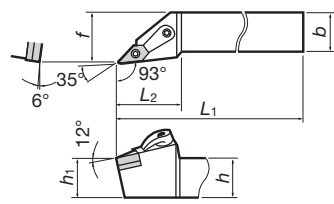
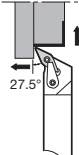
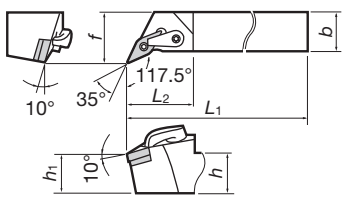
Tooling styles	Cat. No.	Stock		Dimensions (mm)								Std. Corner r _E	Applicable inserts	Shape		
		R	L	h	b	L ₁	L ₂	h ₁	f	f ₂						
Profiling MTQNR/L 	MTQNR/L2020K16	●		20	20	125		20	25			0.8	TN□□1603□□ TN□□1604□□ 60°△ 60°△ ➤ 2-70 ~ T-CBN ➤ 3-8 ~ T-DIA ➤ 3-21 ~			
	MTQNR/L2525M16	●		25	25	150	26	25		32						
	MTQNR/L3225P16			32	25	170		32								
	Cutting edge style Q	MTQNR/L2525M22			25		150		25				0.8		TN□□2204□□ 60°△ 60°△ ➤ 2-70 ~	
	MTQNR/L3225P22				25		32		32							
	MTQNR/L3232P22			32		170		32		40						
Right hand (R) shown.																
Turning MTGNR/L 	MTGNR/L1616H16			16	16	100		16	20			0.8	TN□□1603□□ TN□□1604□□ 60°△ 60°△ ➤ 2-70 ~ T-CBN ➤ 3-8 ~ T-DIA ➤ 3-21 ~			
	MTGNR/L2020K16			20	20	125	28	20	25							
	MTGNR/L2525M16			25	25	150		25	32							
	Cutting edge style G	MTGNR/L2020K16C			20	20	125	28	20	25			0.8		TN□□1607□□ 60°△ ➤ 2-79 ~	
	MTGNR/L2525M16C			25	25	150		25	32							
	MTGNR/L2525M22			25		150		25								
	MTGNR/L3225P22				25		32		32				0.8		TN□□2204□□ 60°△ 60°△ ➤ 2-70 ~	
	MTGNR/L3232P22				32	170			32		40					
					32											
	MTGNR/L2525M27			25	25	150		25	32				1.2		TN□□2706□□ 60°△	
	MTGNR/L3232P27			32	32	170	38	32	40							
	MTGNR/L4040R27			40	40	200		40	50							
	MTGNR/L3232P33			32	32	170	40	32	40				1.2		TN□□3307□□ 60°△	
	MTGNR/L4040R33			40	40	200		40	50							
Right hand (R) shown.																

Right hand (R) shown.

Right hand (R) shown.

● : Stocked items.

Toolholders for External Turning

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

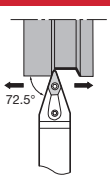
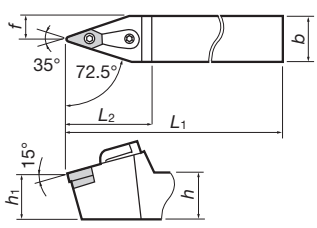
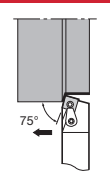
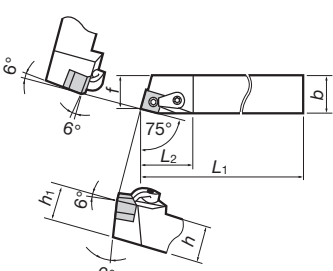
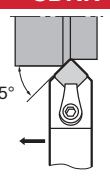
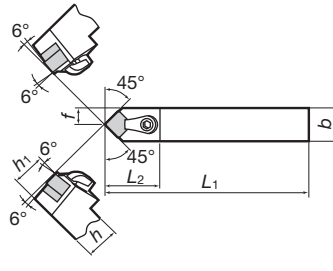
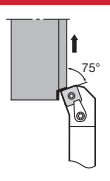
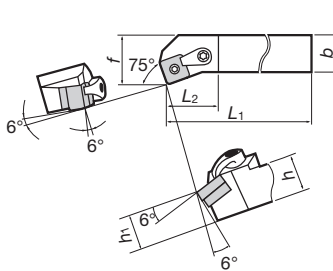
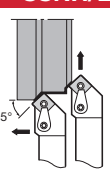
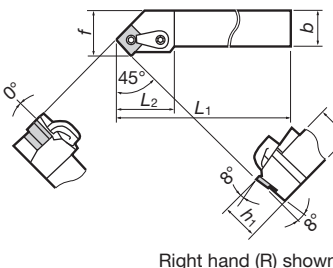
● : Stocked items.

Toolholders for External Turning

Negative rake
Multi clamping system

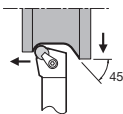
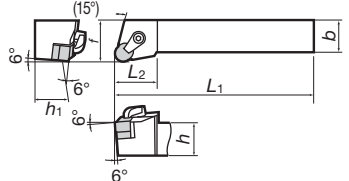
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TAC External Toolholders

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

● : Stocked items.

Toolholders for External Turning

Tooling styles	Cat. No.	Stock		Dimensions (mm)								Std. Corner r _ε	Applicable inserts	Shape
		R	L	h	b	L ₁	L ₂	h ₁	f	f ₂				
Turning MRGNR/L  Cutting edge style G	MRGNR/L2020K12			20	20	125	28	20	25	(12)	—	RN□□120400 		
	MRGNR/L2525M12			25	25	150		25	32					
	MRGNR/L2020K12C			20	20	125	28	20	25	(12)	—	RNGN120700 		
	MRGNR/L2525M12C			25	25	150		25	32					

Right hand (R) shown.

● : Stocked items.

Replacement Parts for M-type

Replacement Parts for M-type TAC Toolholders

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

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

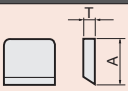
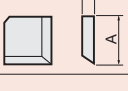
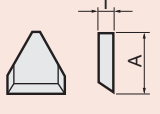
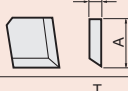
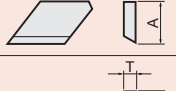
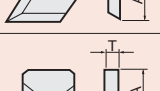
Replacement Parts for M-type

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

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

List of Chipbreaker Pieces

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

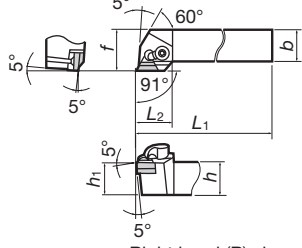
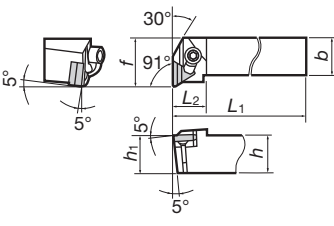
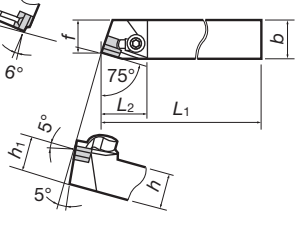
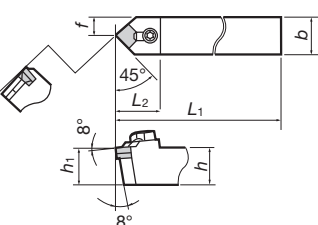
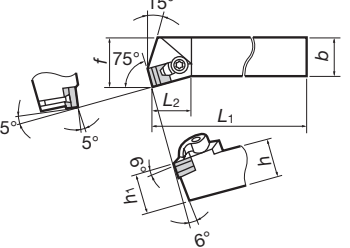
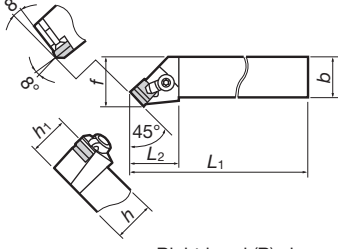
Shape	Cat. No.	Applicable inserts	Dimensions(mm)		Chipbreaker width when assembled (mm)
			A	T	
	CBS-4S	 SN□□1204□□	11.6	2.5	1.5
	CBS-4M	 SN□□1207□□	10.6		2.5
	CBS-4L		9.1		4.0
	CBS-4SN	 SN□□1204□□	11.5	2.5	1.5
	CBS-4MN	 SN□□1207□□	10.5		2.5
	CBS-4LN		9.0		4.0
	CBT-3S	 TN□□1604□□	12.1	2.5	1.5
	CBT-3M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

Toolholders for External Turning

Negative rake
Clamp-on system

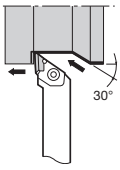
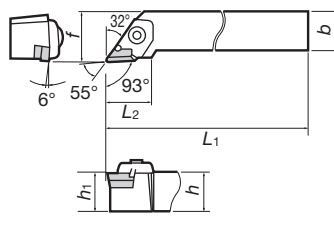
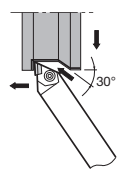
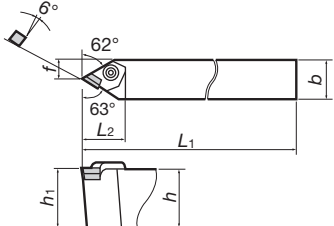
4

TAC External Toolholders

Tooling styles	Cat. No.	Stock		Dimensions (mm)								Std. Corner r_{ϵ}	Applicable inserts	Shape
		R	L	h	b	L ₁	L ₂	h ₁	f	f ₂				
Turning CTGNR/L  Cutting edge style G	CTGNR/L2020	●	●	20	20	125		20	25			0.8	TN□□1604□□ 60°  	 Right hand (R) shown.
	CTGNR/L2525	●	●	25	25	150		25	32					
Facing CTFNR/L  Cutting edge style F	CTFNR/L2020	●	●	20	20	125		20	25			0.8	TN□□1604□□ 60°  	 Right hand (R) shown.
	CTFNR/L2525	●	●	25	25	150		25	32					
Turning CSBNR/L  Cutting edge style B	CSBNR/L2020	●		20	20	125		20	17			0.8	SN□□1204□□ 90°  	 Right hand (R) shown.
	CSBNR/L2525	●	●	25	25	150		25	22					
Turning Chamfering CSDNN  Cutting edge style D	CSDNN2020	●		20	20	125		20	10.0			0.8	SN□□1204□□ 90°  	 Right hand (R) shown.
	CSDNN2525	●		25	25	150		25	12.5					
Facing CSKNR/L  Cutting edge style K	CSKNR/L2020			20	20	125		20	25			0.8	SN□□1204□□ 90°  	 Right hand (R) shown.
	CSKNR/L2525	●	●	25	25	150		25	32					
Turning-Facing Chamfering CSSNR/L  Cutting edge style S	CSSNR/L2020	●	●	20	20	125		20	25			0.8	SN□□1204□□ 90°  	 Right hand (R) shown.
	CSSNR/L2525	●	●	25	25	150		25	32					

● : Stocked items.

Toolholders for External Turning

Tooling styles	Cat. No.	Stock		Dimensions (mm)								Std. Corner r_{ϵ}	Applicable inserts	Shape
		R	L	h	b	L ₁	L ₂	h ₁	f	f ₂				
External profiling CKJNR/L  Cutting edge style J	CKJNR/L2525	●	●	25	25	150		25	32			0.8	KNMX1604□□ 55°  2-94	
	CKJNR/L3232			32	32	170		32	40					
External profiling CKNNR/L  Cutting edge style N	CKNNR/L4025			40	25			40	15			0.8	KNMX1604□□ 55°  2-94	
	CKNNR/L5032			50	32			50	16					

● : Stocked items.

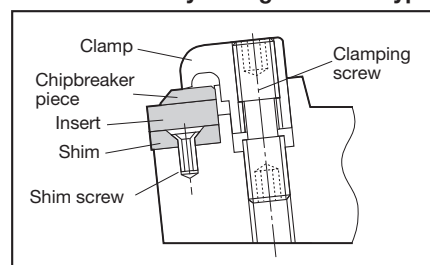
Parts of C-type

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

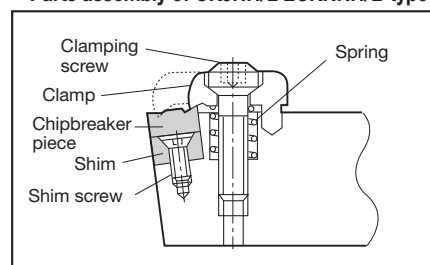
Toolholders Cat. No.		Applicable inserts		Shim	Clamping screw	Clamp	Spring	Pin	Shim screw	Wrench
		Cat. No.	Shape							
CKJNR/L 3232	2525	KNMX1604□□		CSK54R/L	CTS-M6	CPK5R/L	SP913	BP-490	SM3×0.5×10	P-4
CKNNR/L 4025 5032										

Parts Assembly and Chipbreaker Pieces for C-type TAC Toolholders

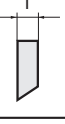
Parts assembly of negative rake type



Parts assembly of CKJNR/L-ECKNNR/L-type



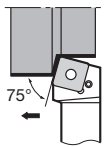
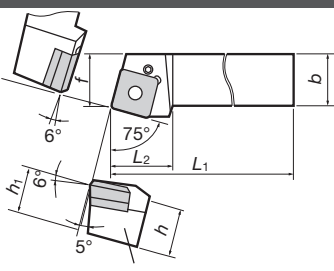
List of chipbreaker piece for positive rake, C-type toolholders

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

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

Toolholders for External Turning

Negative rake
Retract-pin system

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

Right hand (R) shown.

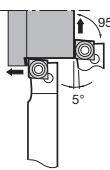
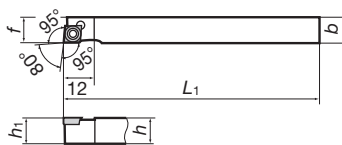
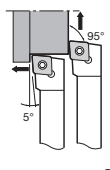
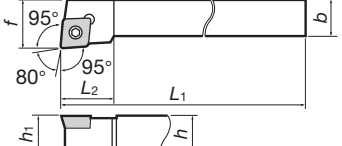
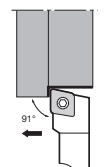
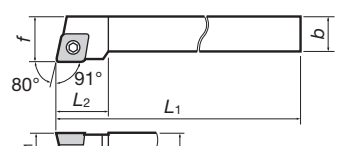
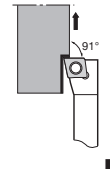
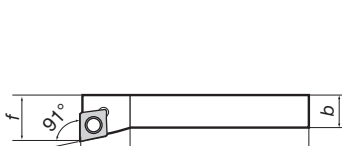
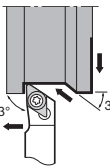
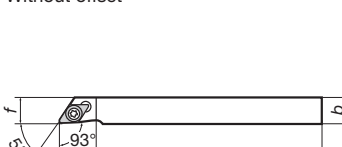
● : Stocked items.

4

TAC External Toolholders

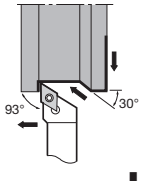
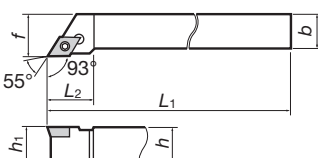
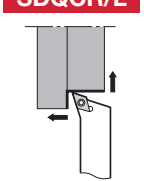
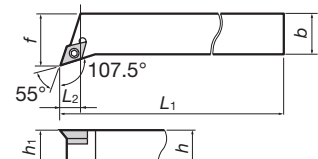
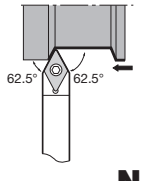
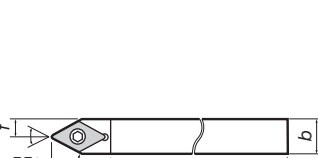
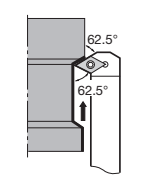
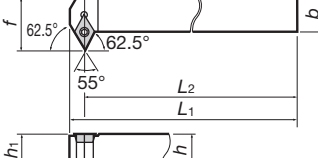
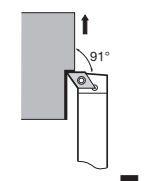
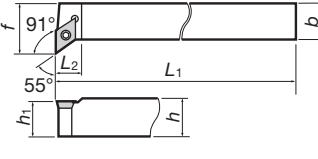
Parts of H-type

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

Tooling styles	Cat. No.	Stock		Dimensions (mm)								Std. Corner r _E	Applicable inserts	Shape
		R	L	h	b	L ₁	L ₂	h ₁	f	f ₂				
Turning • Facing SCL2CR/L 	SCL2CR/L1010H			10	10	100	12	10	10	-	0.4	CC□□0602□□ 80°  		
	SCL2CR/L1010K06				125									
	SCL2CR/L1212H			12	12	100		12	12					
	SCL2CR/L1212K06				125									
Cutting edge style L2														Right hand (R) shown.
Turning • Facing SCLCR/L 	SCLCR/L1212H			12	12	100	12	12	16	-	0.4	CC□□0602□□ 80°  		
	SCLCR/L1616H			16	16	100	16	16	20	-	0.8	CC□□09T3□□ 80°  		
	SCLCR/L1616H09	●	●											
	SCLCR/L2020K12	●	●	20	20	125	20	20	25	-	0.8	CC□□1204□□ 80°  		
Cutting edge style L														Right hand (R) shown.
Turning SCGCR/L 	SCGCR/L1212H			12	12	100	12	12	16	-	0.4	CC□□0602□□ 80°  		
	SCGCR/L1616H			16	16	100	16	16	20	-	0.8	CC□□09T3□□ 80°  		
Cutting edge style G														Right hand (R) shown.
Facing SCFCR/L 	SCFCR/L1212H			12	12	100	16	12	16	-	0.4	CC□□0602□□ 80°  		
	SCFCR/L1616H			16	16	100	16	16	20	-	0.8	CC□□09T3□□ 80°  		
Cutting edge style F														Right hand (R) shown.
Turning-Profiling SDJ2CR/L 	SDJ2CR/L1010H			10	10	100	14	10	10	-	0.4	DC□□0702□□ 55°  		
	SDJ2CR/L1010K07				125									
	SDJ2CR/L1212H			12	12	100		12	12					
	SDJ2CR/L1212K07				125									
Cutting edge style J2														Right hand (R) shown.

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

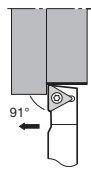
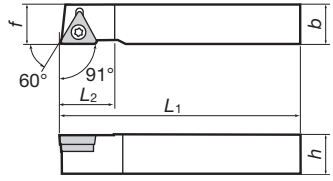
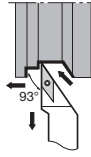
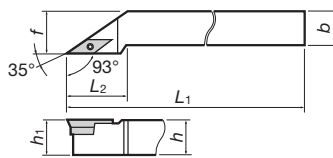
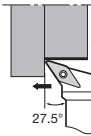
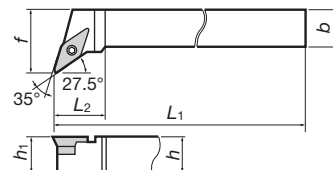
● : Stocked items.

Tooling styles	Cat. No.	Stock		Dimensions (mm)								Std. Corner r_{ϵ}	Applicable inserts	Shape
		R	L	h	b	L ₁	L ₂	h ₁	f	f ₂				
External profiling SDJCR/L  Cutting edge style J	SDJCR/L1212H			12	12	100	14	12	16	—	0.4	DC□□0702□□ 55°/0°	▶ 2-105 ~	 Right hand (R) shown.
	SDJCR/L1616H			16	16	100	18	16	20	—	0.8	DC□□11T3□□ 55°/0°	▶ 2-105 ~	
	SDJCR/L1616H11	●				20				—	0.8	DC□□11T3□□ 55°/0°	▶ 2-105 ~	
	SDJCR/L2020K11	●	●	20	20	125	20.5	20	25	—	0.8	DC□□11T3□□ 55°/0°	▶ 2-105 ~	
	SDJCR/L2525M11	●	●	25	25	150	21.5	25	32	—	0.8	DC□□11T3□□ 55°/0°	▶ 2-105 ~	
Profiling SDQCR/L  Cutting edge style Q	SDQCR/L2020K11	●	●	20	20	125	20.5	20	25	—	0.8	DC□□11T3□□ 55°/0°	▶ 2-105 ~	 Right hand (R) shown.
	SDQCR/L2525M11	●		25	25	150	21.5	25	32	—	0.8	DC□□11T3□□ 55°/0°	▶ 2-105 ~	
Turning-Profiling SDNCN  Cutting edge style N	SDNCN1010H			10	10	100		10	5	—	0.4	DC□□0702□□ 55°/0°	▶ 2-105 ~	 Right hand (R) shown.
	SDNCN1010K07					125		14		—	0.4	DC□□0702□□ 55°/0°	▶ 2-105 ~	
	SDNCN1212H			12	12	100		12	6	—	0.4	DC□□0702□□ 55°/0°	▶ 2-105 ~	
	SDNCN1212K07					125				—	0.4	DC□□0702□□ 55°/0°	▶ 2-105 ~	
	SDNCN1616H			16	16	100		16	8	—	0.8	DC□□11T3□□ 55°/0°	▶ 2-105 ~	
	SDNCN1616H11	●				21				—	0.8	DC□□11T3□□ 55°/0°	▶ 2-105 ~	
	SDNCN2020K11	●		20	20	125		20	10	—	0.8	DC□□11T3□□ 55°/0°	▶ 2-105 ~	
External profiling SDN3CR/L  Cutting edge style N3	SDN3CR/L1212H			12	12	105	100	12	18	—	0.4	DC□□0702□□ 55°/0°	▶ 2-105 ~	 Right hand (R) shown.
	SDN3CR/L1616H			16	16	107	100	16	25	—	0.8	DC□□11T3□□ 55°/0°	▶ 2-105 ~	
Facing SDFCR/L  Cutting edge style F	SDFCR/L1212H			12	12	100	8	12	16	—	0.4	DC□□0702□□ 55°/0°	▶ 2-105 ~	 Right hand (R) shown.
	SDFCR/L1616H			16	16	100	10.5	16	22	—	0.8	DC□□11T3□□ 55°/0°	▶ 2-105 ~	

T-CBN ▶ 3-12 ~ T-DIA ▶ 3-22

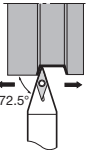
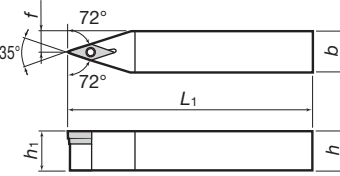
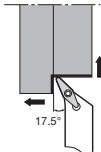
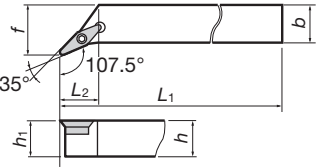
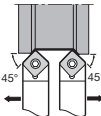
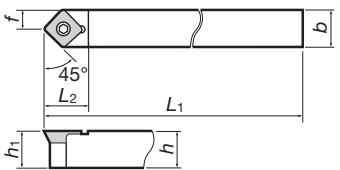
● : Stocked items.

Toolholders for External Turning

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

T-CBN  T-DIA 

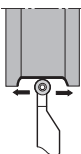
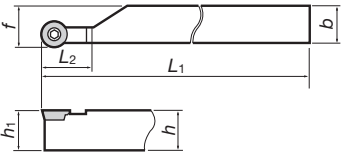
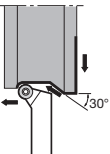
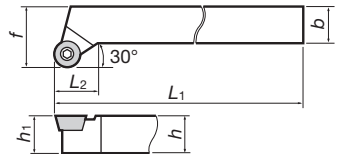
● : Stocked items.

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

T-CBN  3-13 ~

● : Stocked items.

Toolholders for External Turning

Tooling styles	Cat. No.	Stock		Dimensions (mm)							Std. Corner r _E	Applicable inserts	Shape
		R	L	h	b	L ₁	L ₂	h ₁	f	f ₂			
Turning SRACR/L  Cutting edge style A	SRACR/L1010H05	●		10	10			10	10.3			RCMT0502M0 ⊙ ▶ 2-140	
	SRACR/L1212H05	●	▲	12	12	100		12	12.3				
	SRACR/L1616H05	●	▲	16	16		10	16	16.3	-	-		
	SRACR/L2020K05	●	●	20	20	125		20	20.3				
	SRACR/L2525M05	●	●	25	25	150		25	25.3				
	SRACR/L1212H06	●	●	12	12		100	12	12.4			RC□T0602M0 ⊙ ▶ 2-140 ~	
	SRACR/L1616H06	●	●	16	16		12	16	16.4				
	SRACR/L2020K06	●	●	20	20	125		20	20.4				
	SRACR/L2525M06	●	●	25	25	150		25	25.4				
	SRACR/L1616H08	●	●	16	16	100		16	16.5			RC□T0803M0 ⊙ ▶ 2-140 ~	
SRACR/L2020K08	●	●	20	20	125	16	20	20.5	-	-			
SRACR/L2525M08	●	●	25	25	150		25	25.5					
Turning SRGCR/L  Cutting edge style G	SRGCR/L1212H05	●	▲	12	12		100	9.5	12	16		RCMT0502M0 ⊙ ▶ 2-140	
	SRGCR/L1616H05	●	●	16	16				16	20			
	SRGCR/L2020K05	●	●	20	20	125	11.2	20	25				
	SRGCR/L2525M05	●	●	25	25	150	14.7	25	32				
	SRGCR/L1212H06	●	●	12	12		100	10	12	16		RC□T0602M0 ⊙ ▶ 2-140 ~	
	SRGCR/L1616H06	●	●	16	16				16	20			
	SRGCR/L2020K06	●	●	20	20	125	12	20	25				
	SRGCR/L2525M06	●	●	25	25	150	15	25	32				
	SRGCR/L1616H08	●	●	16	16	100	11	16	20			RC□T0803M0 ⊙ ▶ 2-140 ~	
	SRGCR/L2020K08	●	●	20	20	125	12.7	20	25	-	-		
	SRGCR/L2525M08	●	●	25	25	150	16.2	25	32				
	SRGCR/L2020K10	●	●	20	20	125	14	25	25			RC□T1003M0 ⊙ ▶ 2-140 ~	
	SRGCR/L2525M10	●	●	25	25	150	17.5	25	32	-	-		

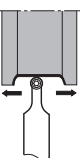
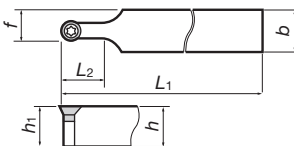
Right hand (R) shown.

Right hand (R) shown.

Right hand (R) shown.

Right hand (R) shown.

 ● : Stocked items.
 ▲ : Shortly unavailable

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

● : Stocked items.



Replacement Parts for S-type

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

Replacement Parts for S-type

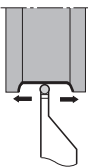
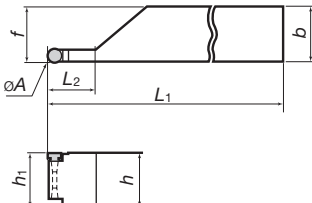
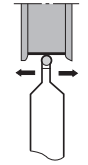
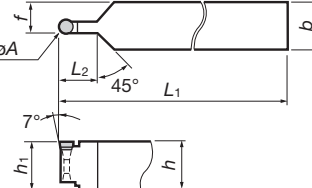
4

TAC External Toolholders

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

Toolholders for External Turning

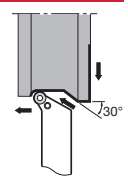
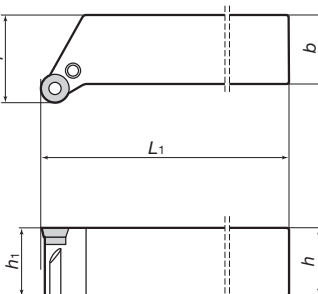
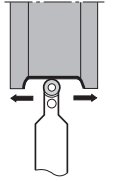
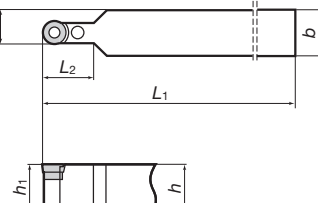
Positive rake
Taper lock system

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

● : Stocked items.

Toolholders for External Turning

Positive rake
Lever lock system

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

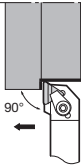
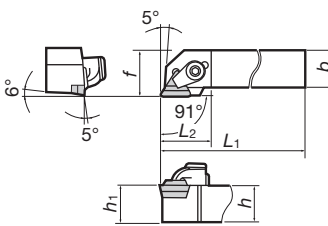
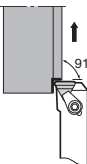
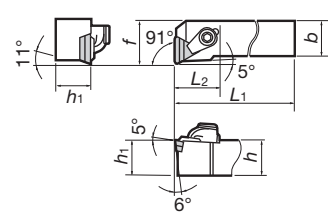
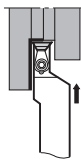
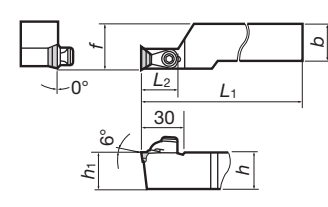
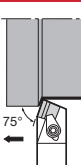
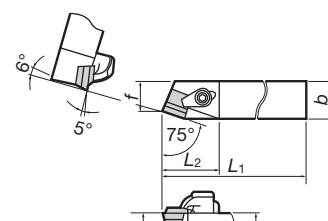
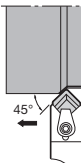
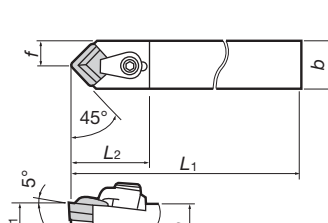
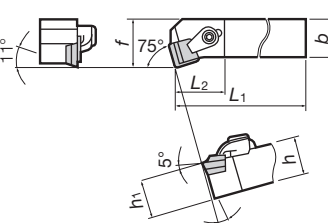
● : Stocked items.

Parts of P-type

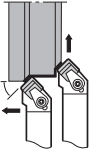
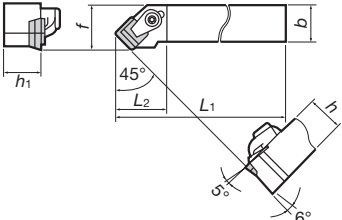
Toolholders Cat. No.		Applicable inserts		Shim	Clamping-screw	Spring pin	Lever	Wrench
		Cat. No.	Shape					
PRGCR/L PRDCN	2020K10	RCM□1003M0	⊙	LSR32C	LCS2	LSP3	LCL3C	P-2
	2525M10							
	2525M12	RCM□1204M0	⊙	LSR42C	LCS3	LSP3	LCL4C	P-2.5
	3225P12							
	3225P16	RCM□1606M0	⊙	LSR53C	LCS5	LSP4	LCL5C	P-3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

Toolholders for External Turning

Positive rake
Clamp-on system

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

● : Stocked items.

Tooling styles	Cat. No.	Stock		Dimensions (mm)							Std. Corner r_{ϵ}	Applicable inserts	Shape
		R	L	h	b	L_1	L_2	h_1	f	f_2			
Turning-Facing Chamfering CSSPR/L  Cutting edge style S	CSSPR/L1616H3	●		16	16	105.5	23	16	20	–	0.8	SP□□0903□□ 90°  	
	CSSPR/L2020K4	●		20	20	133	28	20	25	–	0.8	SP□□1203□□ 90°  	
	CSSPR/L2525M4	●		25	25	158		25	32				

Right hand (R) shown.

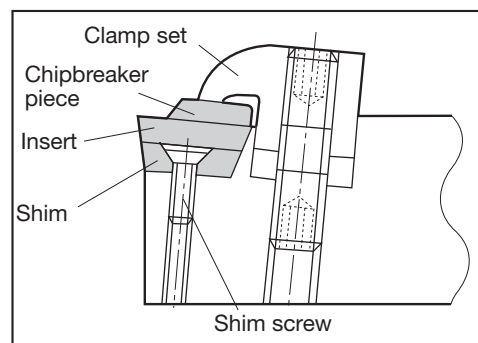
● : Stocked items.

Parts of C-type

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

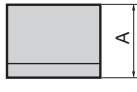
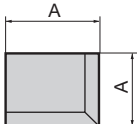
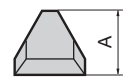
Parts Assembly and Chipbreaker Pieces for C-type TAC Toolholders

Parts assembly of positive rake type



Note: Shim is made of D30 grade.

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

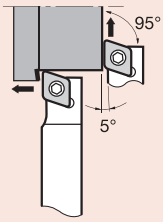
Shape	Cat. No.	Applicable insert	Dimensions(mm)		Chipbreaker width when assembled (mm)
			A	T	
	CBS-3S	SP□□0903□□	8.33	2	1.5
	CBS-3M*		7.33	2	2.5
	CBS-4S	SP□□1203□□	11.6	2.5	1.5
	CBS-4M*		10.6	2.5	2.5
	CBS-4L		9.1	2.5	4
	CBS-3SN	SP□□0903□□	8.33	2	1.5
	CBS-3MN*		7.33	2	2.5
	CBS-4SN	SP□□1203□□	11.6	2.5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

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

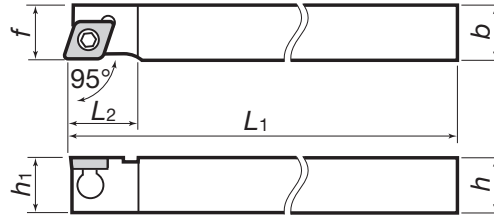
JTCL2CR/L

Without offset / Positive rake
Side clamping system

Turning / Facing



Cutting edge style **L2**



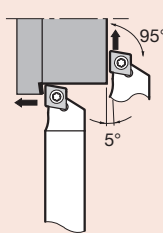
Right hand (R) shown

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

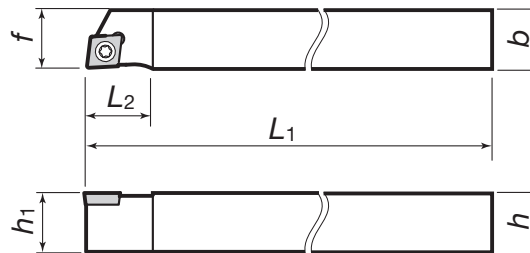
JSCL2CR/L

Without offset / Positive rake
Screw-on system

Turning / Facing



Cutting edge style **L2**



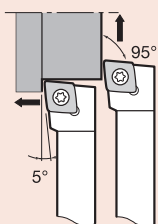
Right hand (R) shown

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

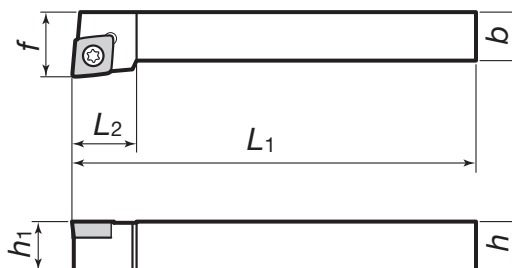
JSCLCR/L

Positive rake
Screw-on system

Turning / Facing



Cutting edge style **L**



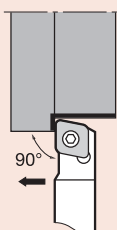
Right hand (R) shown

Cat. No.	Stock		Dimensions (mm)						Standard corner radius r_E	Applicable inserts	Parts		Torque (N·m)
	R	L	h	b	L ₁	L ₂	h ₁	f			Clamping screw	Wrench	
JSCLCR/L0808H06	●	●	8	8	100	12	8	10	0.4	CC□□0602	CSTB-2.5	T-8F	1.2
JSCLCR/L1010H06	●	●	10	10	100	12	10	12	0.4				
JSCLCR/L1212H09	●	●	12	12	100	16	12	16	0.8	CC□□09T3	CSTB-4SD	T-8F	1.2
JSCLCR/L1616H09	●	●	16	16	100	16	16	20	0.8				

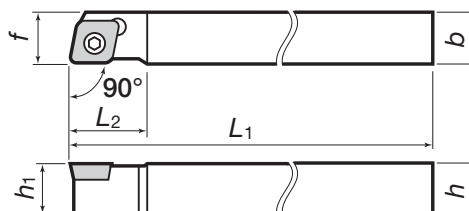
JSCACR/L

Without offset / Positive rake
Screw-on system

Turning



Cutting edge style **A**

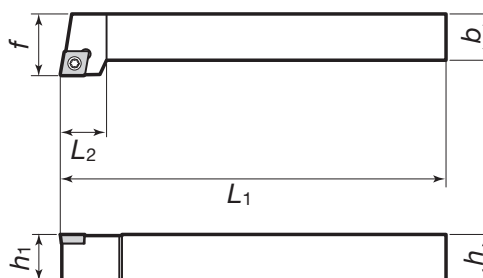
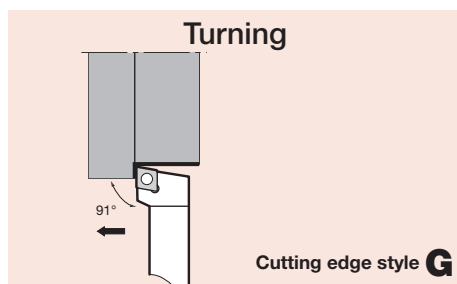


Right hand (R) shown

Cat. No.	Stock		Dimensions (mm)						Standard corner radius r_E	Applicable inserts	Parts		Torque (N·m)
	R	L	h	b	L ₁	L ₂	h ₁	f			Clamping screw	Wrench	
JSCACR/L0808H06	●	●	8	8	100	12	8	8	0.4	CC□□0602	CSTB-2.5	T-8F	1.2
JSCACR/L1010H06	●	●	10	10	100	12	10	10	0.4				
JSCACR/L1212H09	●	●	12	12	100	16	12	12	0.8	CC□□09T3	CSTB-4SD	T-8F	1.2

JSCGCR/L

Positive rake
Screw-on system



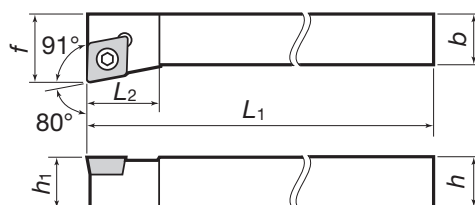
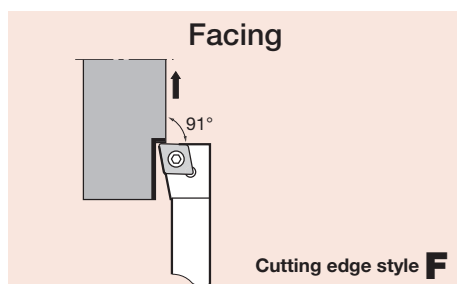
Cat. No.	Stock		Dimensions (mm)						Standard corner radius r_E	Applicable inserts	Parts		Torque (N·m)
	R	L	h	b	L ₁	L ₂	h ₁	f			Clamping screw	Wrench	
JSCGCR/L1212H06	●	●	12	12	100	12	12	16	0.4	CC□□0602	CSTB-2.5	T-8F	1.2
JSCGCR/L1616H09	●	●	16	16	100	16	16	20	0.8	CC□□09T3	CSTB-4SD	T-8F	1.2

4

TAC External Toolholders

JSCFCR/L

Positive rake
Screw-on system



Cat. No.	Stock		Dimensions (mm)						Std. corner radius r_E	Applicable inserts	Parts		Torque (N·m)
	R	L	h	b	L ₁	L ₂	h ₁	f			Clamping screw	Wrench	
JSCFCR/L1212H06			12	12	100	16	12	16	0.4	CC□□0602	CSTB-2.5	T-8F	1.2
JSCFCR/L1616H09			16	16	100	16	16	20	0.8	CC□□09T3	CSTB-4SD	T-8F	1.2

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

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

● : Stocked items.

Relating pages

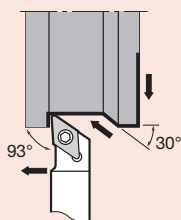
Cutting conditions (8-3)

Parts (14-1~)

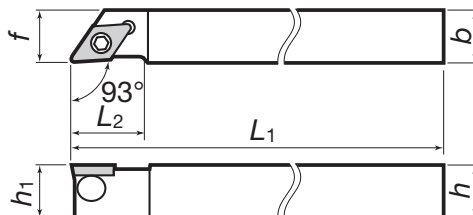
JTDJ2CR/L

Without offset / Positive rake
Back clamping system

Turning / profiling



Cutting edge style **J2**



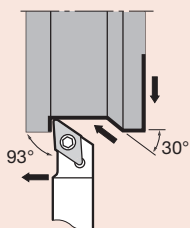
Right hand (R) shown

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

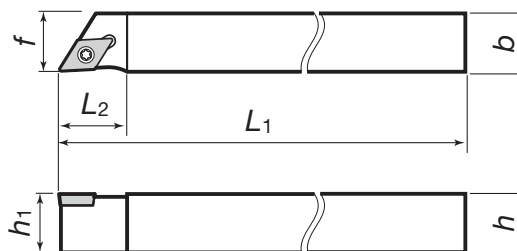
JSDJ2CR/L

Without offset / Positive rake
Screw-on system

Profiling



Cutting edge style **J2**



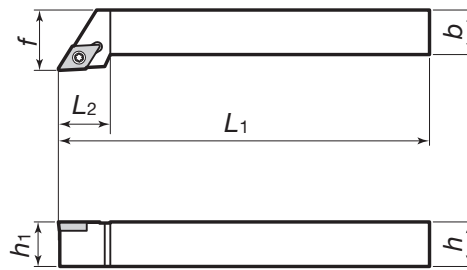
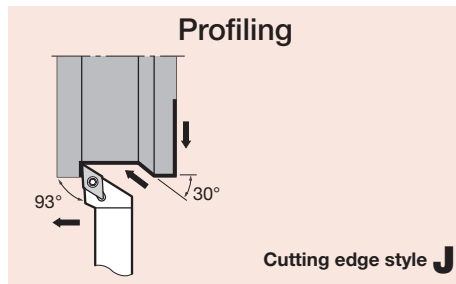
Right hand (R) shown

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

Basic Selection Chipbreaker DC□□

JSDJCR/L

Positive rake
Screw-on system



Right hand (R) shown

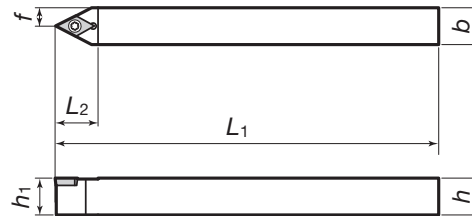
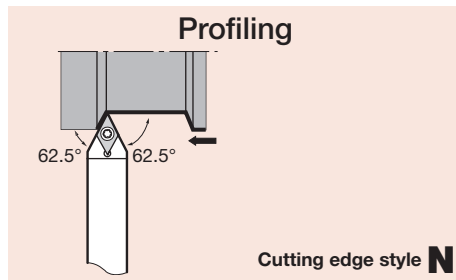
Cat. No.	Stock		Dimensions (mm)						Standard corner radius r_{ϵ}	Applicable inserts	Parts		Torque (N·m)
	R	L	h	b	L ₁	L ₂	h ₁	f			Clamping screw	Wrench	
JSDJCR/L0808H07	●	●	8	8	100	14	8	10	0.4	DC□□0702	CSTB-2.5	T-8F	1.2
JSDJCR/L1212H07	●	●	12	12	100	14	12	16	0.4				
JSDJCR/L1010H11	●	●	10	10	100	18	10	12	0.8	DC□□11T3	CSTB-2.5	T-8F	1.2
JSDJCR/L1212H11	●	●	12	12	100	18	12	16	0.8				
JSDJCR/L1616H11	●	●	16	16	100	18	16	20	0.8		CSTB-4SD		

4

TAC External Toolholders

JSDNCN

Positive rake
Screw-on system

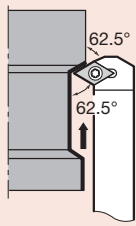
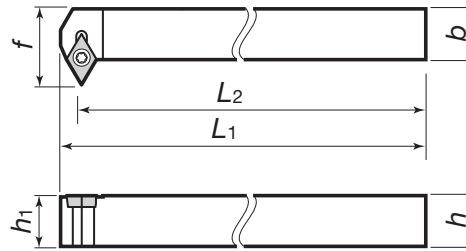


Cat. No.	Stock	Dimensions (mm)						Standard corner radius r_{ϵ}	Applicable inserts	Parts		Torque (N·m)
		h	b	L ₁	L ₂	h ₁	f			Clamping screw	Wrench	
JSDNCN0808H07	●	8	8	100	14	8	4	0.4	DC□□0702	CSTB-2.5	T-8F	1.2
JSDNCN1010K07	●	10	10	125	14	10	5	0.4				
JSDNCN1212K07	●	12	12	125	14	12	6	0.4				
JSDNCN1212H11	●	12	12	100	21	12	6	0.8	DC□□11T3	CSTB-4SD	T-8F	1.2
JSDNCN1616H11	●	16	16	100	21	16	8	0.8				

JSDN3CR/L

Positive rake
Screw-on system

Profiling

Cutting edge style **N3**

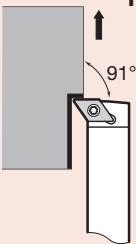
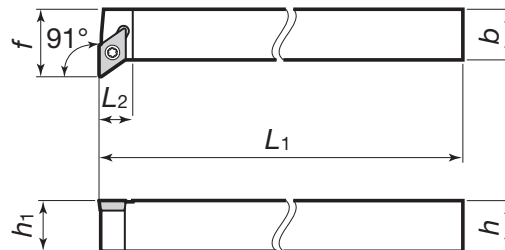
Right hand (R) shown

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

JSDFCR/L

Positive rake
Screw-on system

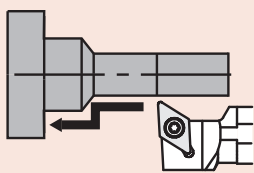
Facing

Cutting edge style **F**

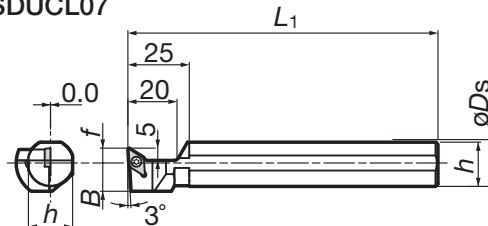
Right hand (R) shown

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

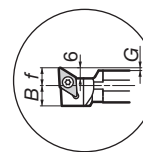
Profiling



SDUCL07



SDUCL11



Left hand (L) shown.

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

4

TAC External Toolholders

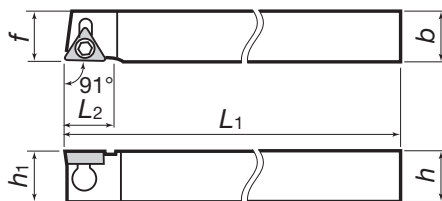
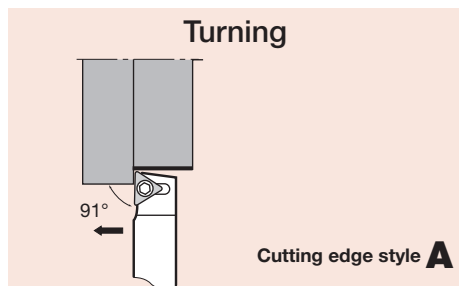
Basic Selection Chipbreakers DC□□0702 DC□□11T3

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

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

JTTACR/L

Without offset / Positive rake
Back clamping system

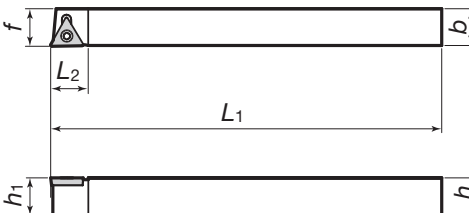
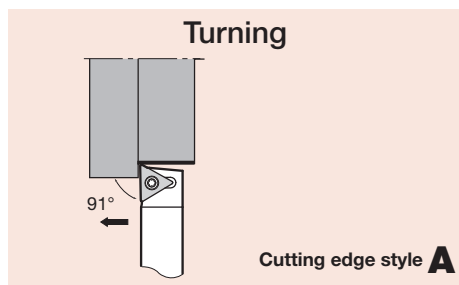


Right hand (R) shown

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

JSTACR/L

Without offset / Positive rake
Screw-on system



Right hand (R) shown

Cat. No.	Stock		Dimensions (mm)						Standard corner radius r_{ϵ}	Applicable inserts	Parts		Torque (N·m)
	R	L	h	b	L ₁	L ₂	h ₁	f			Clamping screw	Wrench	
JSTACR/L0808K08	●	●	8	8	125	10	8	8	0.2	TC□□0802	CSTB-2L	T-6F	0.6
JSTACR/L1010K08	●	●	10	10	125	10	10	10	0.2				
JSTACR/L1212K11	●	●	12	12	125	12	12	12	0.4	TC□□1102	CSTB-2.5	T-8F	1.2
JSTACR/L1616H11	●	●	16	16	100	12	16	16	0.4				

Basic Selection Chipbreakers TC□□0802 TC□□1102

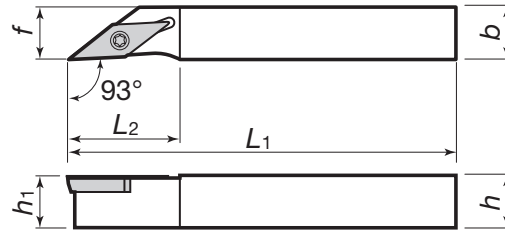
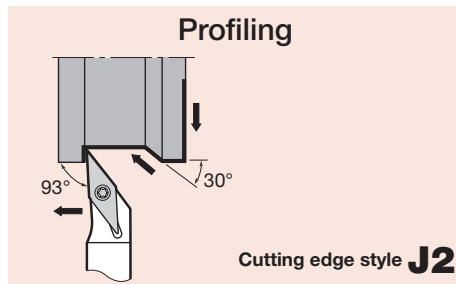
Operation	Precision finishing	Precision finishing	Finishing	Finishing to medium cutting	Finishing to medium cutting	Finishing to light cutting	Finishing to medium cutting	Cast Iron	Aluminium alloy	Aluminium alloy
Chipbreaker	JS	01	PSF	J08/J10	FR/L-J10	PSS	PS	CM	AL	With chipbreaker
Page	2-120	2-118	2-118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

● : Stocked items.

JSVJ2BR/L

Without offset / Positive rake

Screw-on system



Cat. No.	Stock		Dimensions (mm)						Standard corner radius r_{ϵ}	Applicable inserts	Parts		Torque (N·m)
	R	L	h	b	L ₁	L ₂	h ₁	f			Clamping screw	Wrench	
JSVJ2BR/L1010K11	●	●	10	10	125	21	10	10	0.2	VB□□1103	CSTB-2.5	T-8F	1.2
JSVJ2BR/L1212K11	●	●	12	12	125	21	12	12	0.2				
JSVJ2BR/L1616K11	●	●	16	16	125	21	16	16	0.2				

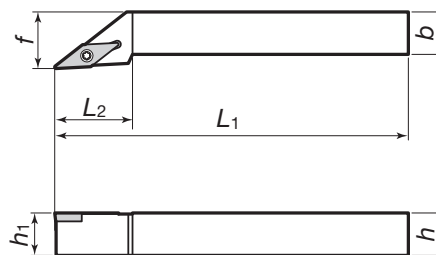
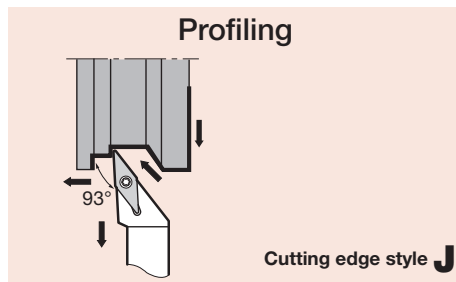
4

TAC External Toolholders

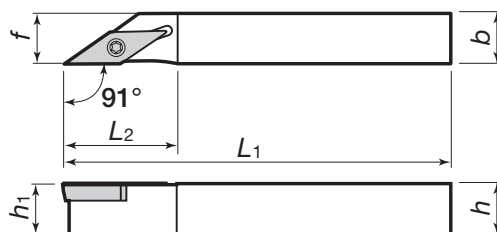
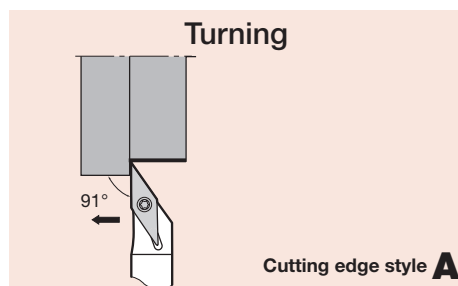
JSVJBR/L

Positive rake

Screw-on system



Cat. No.	Stock		Dimensions (mm)						Standard corner radius r_{ϵ}	Applicable inserts	Parts		Torque (N·m)
	R	L	h	b	L ₁	L ₂	h ₁	f			Clamping screw	Wrench	
JSVJBR/L1010H11	●	●	10	10	100	20	10	12	0.4	VB□□1103	CSTB-2.5	T-8F	1.2
JSVJBR/L1212H11	●	●	12	12	100	22	12	16	0.4				
JSVJBR/L1616H11	●	●	16	16	100	22	16	20	0.4				



Without offset

Right hand (R) shown

Cat. No.	Stock		Dimensions (mm)						Standard corner radius r_{Σ}	Applicable inserts	Parts		Torque (N·m)
	R	L	h	b	L ₁	L ₂	h ₁	f			Clamping screw	Wrench	
JSVABR/L1010K11	●	●	10	10	125	21	10	10	0.2	VB□□1103	CSTB-2.5	T-8F	1.2
JSVABR/L1212K11	●	●	12	12	125	21	12	12	0.2				
JSVABR/L1616K11	●	●	16	16	125	21	16	16	0.2				

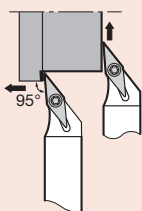
Basic Selection Chipbreakers VB□□1103

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

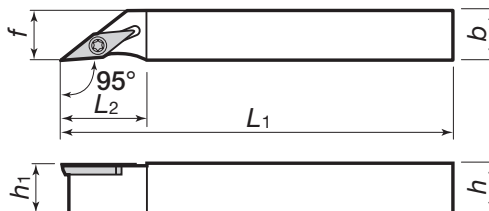
JSVL2PR/L

Without offset / Positive rake
Screw-on system

Turning / facing



Cutting edge style **L2**



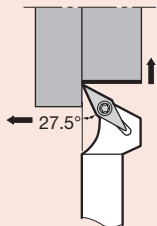
Right hand (R) shown

Cat. No.	Stock		Dimensions (mm)						Standard corner radius r_{ϵ}	Applicable inserts	Parts		Torque (N·m)
	R	L	h	b	L ₁	L ₂	h ₁	f			Clamping screw	Wrench	
JSVL2PR/L1010K08	●	●	10	10	125	16	10	10	0.2	VP□□0802	CSTB-2L	T-6F	0.6
JSVL2PR/L1212K08	●	●	12	12	125	16	12	12	0.2				
JSVL2PR/L1616K08	●	●	16	16	125	16	16	16	0.2				

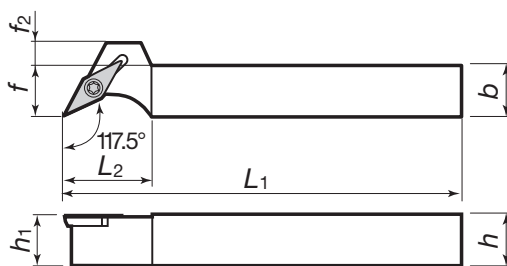
JSVP2PR/L

Positive rake
Screw-on system

Profiling



Cutting edge style **P2**



Right hand (R) shown

Cat. No.	Stock		Dimensions (mm)						Standard corner radius r_{ϵ}	Applicable inserts	Parts		Torque (N·m)
	R	L	h	b	L ₁	L ₂	h ₁	f			Clamping screw	Wrench	
JSVP2PR/L1010K08	●	●	10	10	125	16	10	10	4	VP□□0802	CSTB-2L	T-6F	0.6
JSVP2PR/L1212K08	●	●	12	12	125	16	12	12	2				
JSVP2PR/L1616K08	●	●	16	16	125	16	16	16	-				
JSVP2PR/L1010K11	●	●	10	10	125	20	10	10	8	VP□□1103	CSTB-2.5	T-8F	1.2
JSVP2PR/L1212K11	●	●	12	12	125	20	12	12	6				
JSVP2PR/L1616K11	●	●	16	16	125	20	16	16	4				

Basic Selection Chipbreakers VP□□

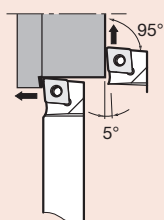
Operation	Precision finishing	Precision finishing	Precision finishing
Chipbreaker	JRP	JPP	JSP
Page	2-137	2-137	2-138
Appearance			
Toolholders			
JSVP**08	VPET0802**	VPET0802**	VPET0802**
JSVP**11	VPET1103**	VPET1103**	VPET1103**

● : Stocked items.

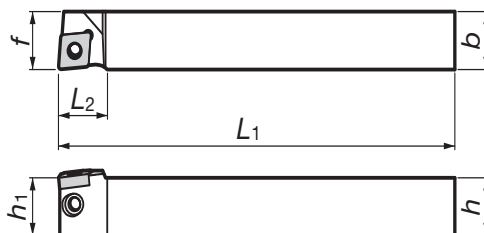
JTCL2NR/L

Without offset / Negative rake
Side clamping system

Turning / facing



Cutting edge style **L2**



Right hand (R) shown

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

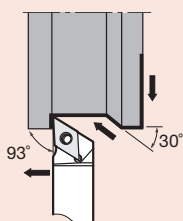
4

TAC External Toolholders

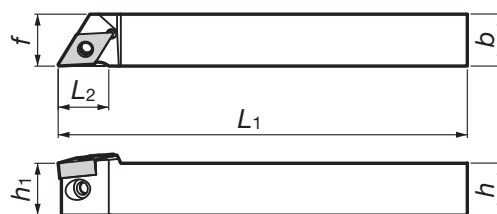
JTDJ2NR/L

Without offset / Negative rake
Side clamping system

Turning / profiling



Cutting edge style **J2**



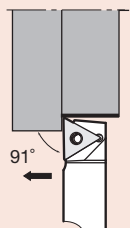
Right hand (R) shown

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

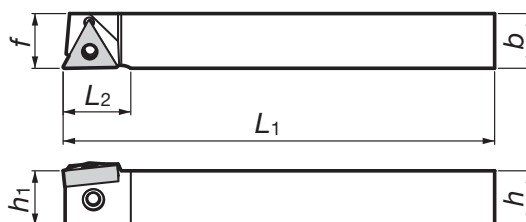
JTTANR/L

Without offset / Negative rake
Side clamping system

Turning



Cutting edge style **A**

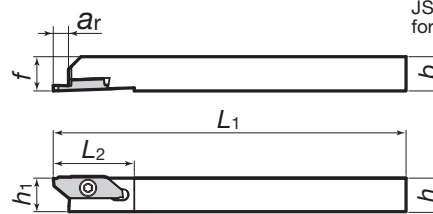
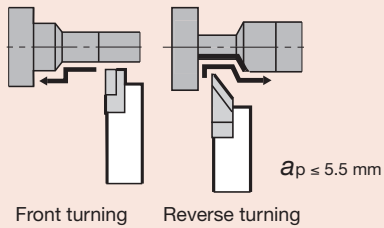


Right hand (R) shown

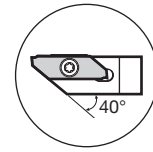
Cat. No.	Stock		Dimensions (mm)						Standard corner radius r_{Σ}	Applicable inserts	Parts		
	R	L	h	b	L_1	L_2	h_1	f			Clamp	Clamping screw	Wrench
JTTANR/L1216K16	●	●	12	16	125	19.8	12	16	0.4	TN□□1604 ▶ 2-70 ~	JCP-3N	JDS-5040	P-2.5F
JTTANR/L1616K16	●	●	16	16	125	19.8	16	16	0.4				

● : Stocked items.

Front and reverse turning



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



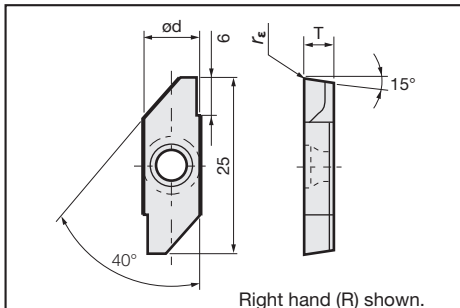
C-type

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

Right hand (R) shown.

Cat. No.	Stock		Dimensions (mm)							Applicable inserts	Clamping screw	Wrench	
	R	L	h	b	L ₁	L ₂	a _r	h ₁	f				
JSXGR/L1010K8-C	●	●	10	10	125	29	6.7	10	10	JXFR/L8□□□ JXRR/L8□□□	CSTB-4SD	T-8F	(T-8L)
JSXGR/L1212K8-C	●	●	12	12				12	12				
JSXGR/L1616K8	●	●	16	16			6.5	16	16				
JSXGR/L2020K8	●	●	20	20				20	20				
JSXGR/L2525K8	●	●	25	25				25	25				
													*Optional

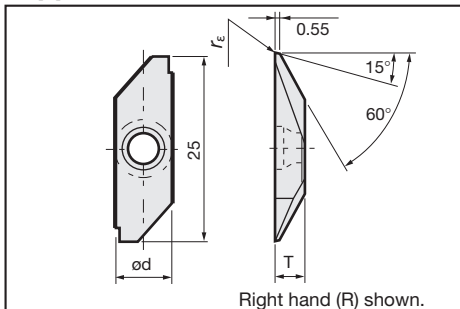
Applicable inserts



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

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

Applicable inserts

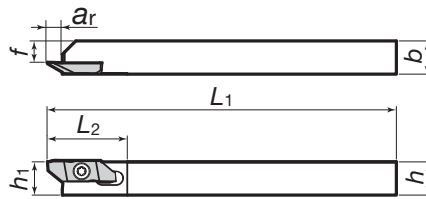
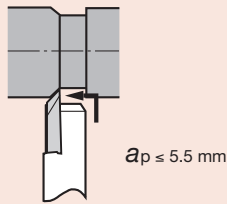


JXR-type inserts (with sharp edges) for reverse turning

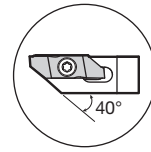
Cat. No.	Dimensions (mm)				Stock					
	ød	T	r _ε	Max. depth of cut	Coated		Cermet		Uncoated	
					J740	NS530	TH10			
JXRR/L8000F	8	3.97	0.03	5.5	●	●			●	
JXRR/L8010F			0.1		●	●			●	

● : Stocked items.

Back turning with large depth of cut



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



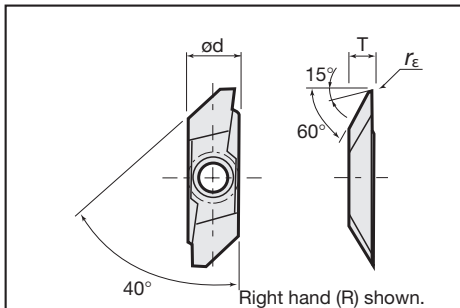
C-type

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

Right hand (R) shown.

Cat. No.	Stock		Dimensions (mm)							Applicable inserts	Clamping screw	Wrench	
	R	L	h	b	L ₁	L ₂	a _r	h ₁	f				
JSXBR/L1010K8-C	●	●	10	10	125	29	6.7	10	5.7	JXBR/L8□□□	CSTB-4SD	T-8F	(T-8L)
JSXBR/L1212K8-C	●	●	12	12				12	7.7				
JSXBR/L1616K8	●	●	16	16			6.4	16	11.7				
JSXBR/L2020K8	●	●	20	20				20	15.7				
JSXBR/L2525K8	●	●	25	25				25	20.7				
													*Optional

Applicable inserts



JXB-type inserts (with sharp edges)

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

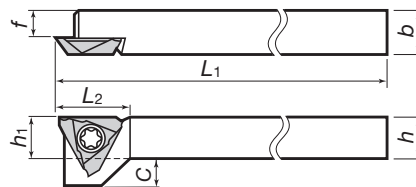
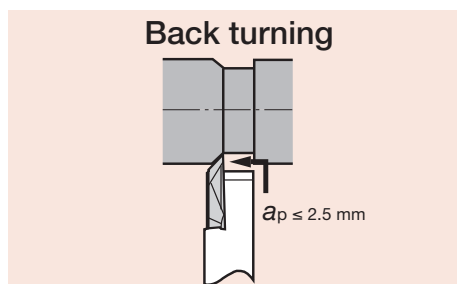
JXB-type inserts (with honed edges)

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

● : Stocked items.

JSTBR/L

Without offset
Screw-on system



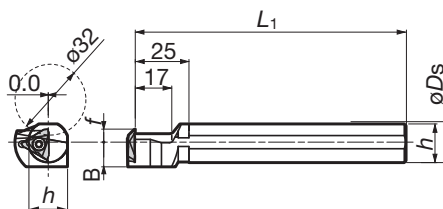
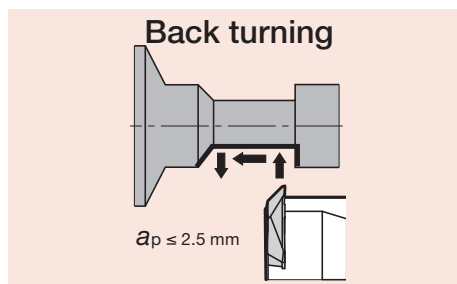
Can be wrenched from back side
with double socket torx screw.

Right hand (R) shown.

Cat. No.	Stock		Dimensions (mm)							Applicable inserts	Clamping screw	Wrench	
	R	L	h	b	L ₁	L ₂	h ₁	f	C				
JSTBR/L1010K3	●	●	10	10	125	15	10	6	5	JTBR/L3□□□	CSTB-4SD	T-8F	(T-8L) *Optional
JSTBR/L1212K3	●	●	12	12			12	8	3				
JSTBR/L1616K3	●	●	16	16			16	12	-				

JS-TBL3

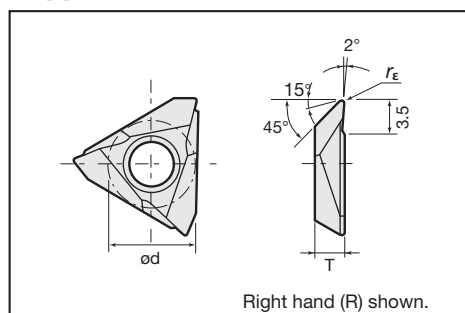
Positive rake
Screw-on system



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

Notes: Left hand holder use right hand insert.

Applicable inserts



Right hand (R) shown.

JTB-type inserts (with sharp edges)

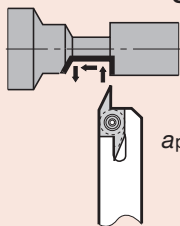
Cat. No.	Dimensions (mm)				Stock							
	ϕd	T	r_ϵ	Max. depth of cut	Coated J740	Coated cermet J530	Cermet NS530	Uncoated TH10				
					R	L	R	L	R	L	R	L
JTBR/L3000F	9.438	3.18	0.03	2.5	●	●			●	●		●
JTBR/L3005F			0.05		●	●			●	●		●
JTBR/L3010F			0.1		●	●			●	●		●
JTBR/L3015F			0.15		●							

JTB-type inserts (with honed edges)

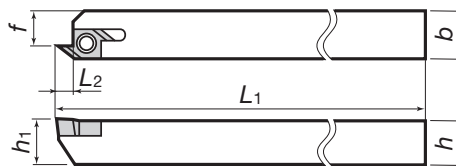
Cat. No.	Dimensions (mm)				Stock							
	ϕd	T	r_ϵ	Max. depth of cut	Coated J740	Coated cermet J530	Cermet NS530	Uncoated TH10				
					R	L	R	L	R	L	R	L
JTBR/L3005	9.438	3.18	0.05	2.5	●	●	●					
JTBR/L3010			0.1		●	●	●					
JTBR/L3015			0.15									

● : Stocked items.

Back turning



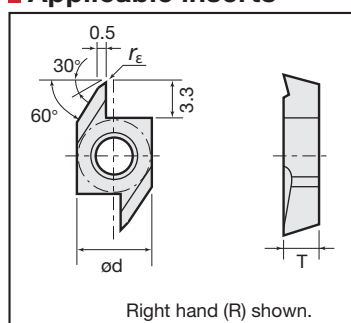
$$a_p \leq 3 \text{ mm}$$



Right hand (R) shown.

Cat. No.	Stock		Dimensions (mm)						Applicable inserts	Clamping screw	Wrenches		
	R	L	h	b	L ₁	L ₂	h ₁	f					
JSEGR/L1010K10	●	●	10	10	125	3.3	10	7.5	J10ER/L□□□□□	CSTB-2.5	T-8F	(T-8L)	*Optional
JSEGR/L1212K10	●	●	12	12			12	9.5					
JSEGR/L1616K10	●	●	16	16			16	13.5					

Applicable inserts



Right hand (R) shown.

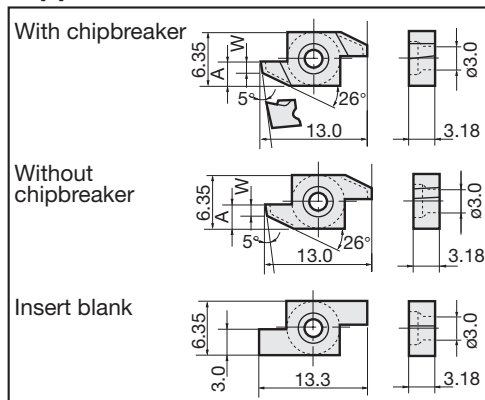
J10E-type inserts (with sharp edges)

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

J10E-type inserts (with honed edges)

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

Applicable inserts



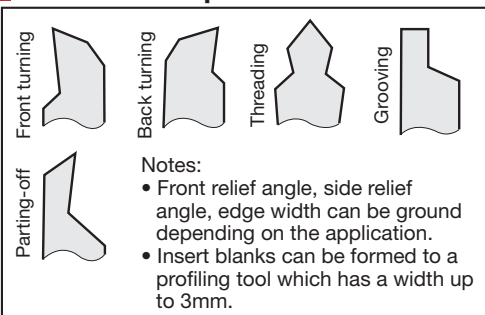
Right hand (R) shown.

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

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

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

Formed examples of insert blanks



Standard cutting conditions

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

● : Stocked items.

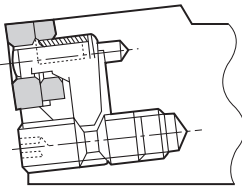
4

TAC External Toolholders

Right hand (R) shown.

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

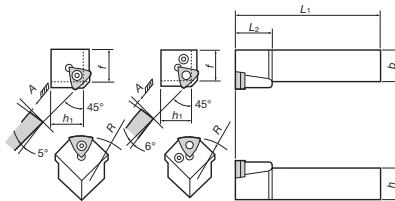
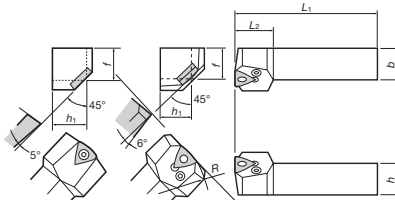
Note: Shim is made of D30 grade.

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

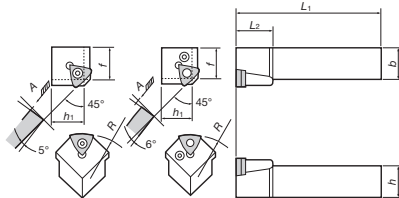
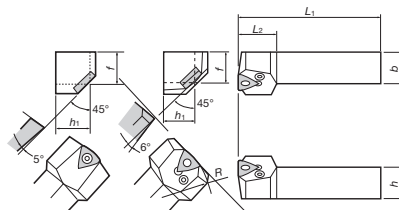
4

TAC External Toolholders

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

Tooling styles	Cat. No.	Stock	Dimensions (mm)							Applicable inserts	Shape
			<i>h</i>	<i>b</i>	<i>L</i> ₁	<i>L</i> ₂	<i>h</i> ₁	<i>f</i>	<i>R</i>		
O.D. and I.D. Turning and Facing PTVN   Vertical type	PTVN2525M50		25	25	150	32	25	25	50	TNGA2204-50	 Viewed from A
	PTVN3232P50		32	32	170	36	32	32			
	PTVN2525M100		25	25	150	32	25	25	100	TNGA2204-100	
	PTVN3232P100		32	32	170	36	32	32			
	PTVN2525M300		25	25	150	32	25	25	300	TNGA2204-300	
	PTVN3232P300		32	32	170	36	32	32			
O.D. and I.D. Turning and Facing PTHN   Horizontal type	PTHN2525M50		25	25	150	32	25	25	50	TNGA2204-50	
	PTHN3232P50		32	32	170	36	32	32			
	PTHN2525M100		25	25	150	32	25	25	100	TNGA2204-100	
	PTHN3232P100		32	32	170	36	32	32			
	PTHN2525M300		25	25	150	32	25	25	300	TNGA2204-300	
	PTHN3232P300		32	32	170	36	32	32			

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

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

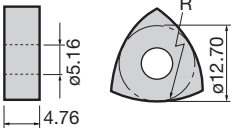
Parts of MS-type

Parts of MS-type

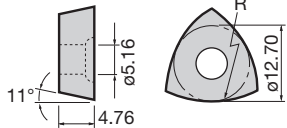
Toolholders Cat. No.		Applicable inserts		Shim	Lever	Clamping screw	Spring	Wrench
		Cat. No.	Shape					
PTVN PTHN	2525M50 3232P50	TNGA2204-50		LST42K	LCL4	LCS4K	LSP4	P-3
	2525M100 3232P100	TNGA2204-100						
	2525M300 3232P300	TNGA2204-300						
STVP STHP	2525M50 3232P50	TPGA2204-50		-	-	CSTA-5S	-	T-15F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

Applicable inserts

Negative inserts

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

Positive inserts

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

Standard cutting conditions

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

Note: Please use proper cutting conditions by shape of workpiece and others.

Note: Cutting speeds in parentheses are for cutting stainless steel.

● : Stocked items.

