

- Standard packing quantity: 10 pieces

Guidance

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8 J series Turning Tools for Small Lathes

Products

■ External turning tools

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

■ Internal turning tools

● Solid boring bars "TinyTurn" JB type				
● JBT	Boring, profiling, chamfering			8-28
● JBP	Boring, chamfering			8-29
● JBU	Back boring, chamfering			8-29
● JBC	Boring, 45° chamfering			8-30
● JBB	Back boring			8-30
● JBI	Threading (metric thread)			8-31
● JBG	Grooving			8-32
● JBF	Face grooving			8-33
● JBS	Face grooving (for machining shaft)			8-33
● JBR	Boring, profiling (full radius type)			8-34
● JBBS sleeves				8-34
● Internal Turning "StreamJetBar"				
● SCLCR/L	Boring / internal facing	Screw-on system	CC□□ inserts	8-36
● STUPR/L	Boring	Screw-on system	TP□□ inserts	8-37
● SWUBR/L	Boring	Screw-on system	WB□□ inserts	8-38
● SE□PR/L	Retracting / Facing	Screw-on system	EP□□ inserts	8-39
● BLM sleeves				8-41

■ Grooving and parting tools

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

■ Threading tools

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

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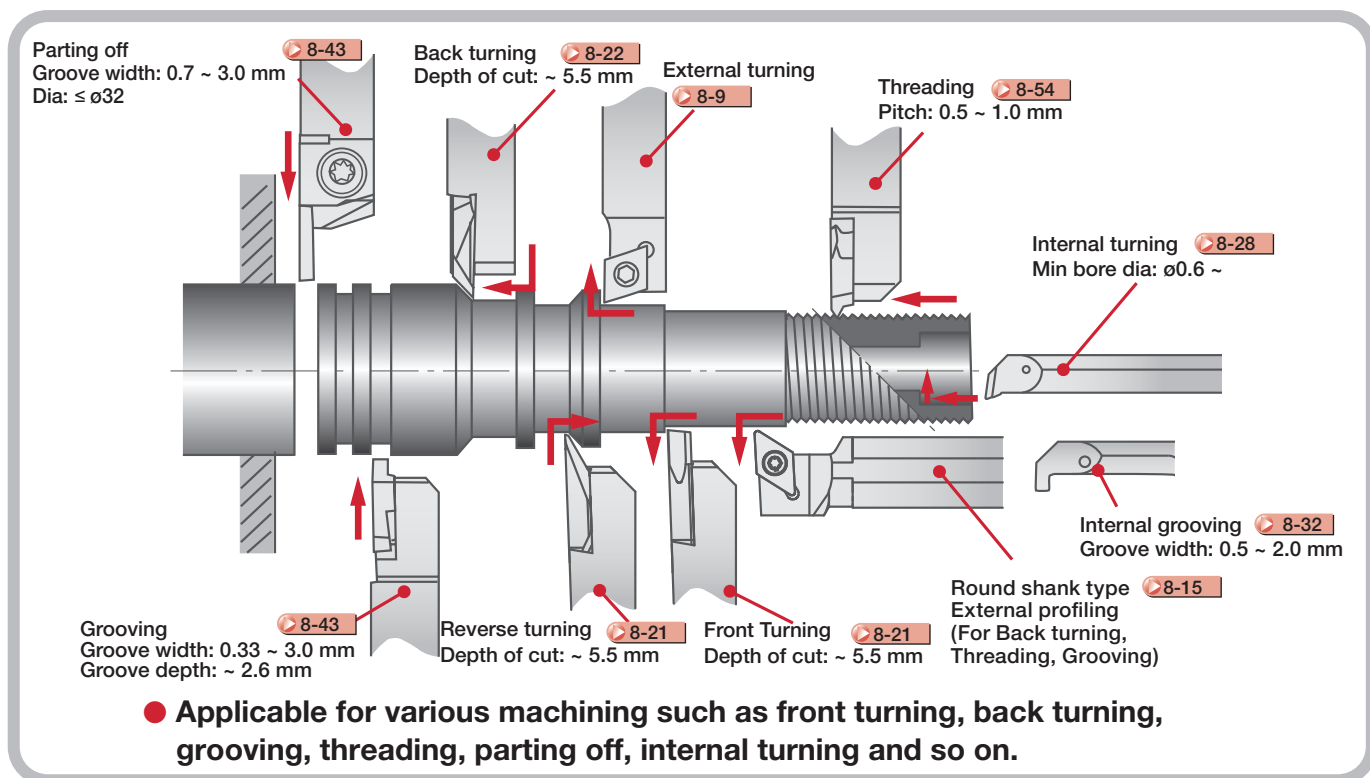
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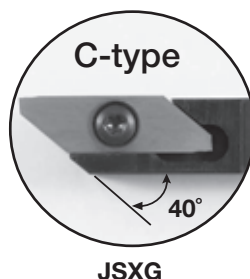
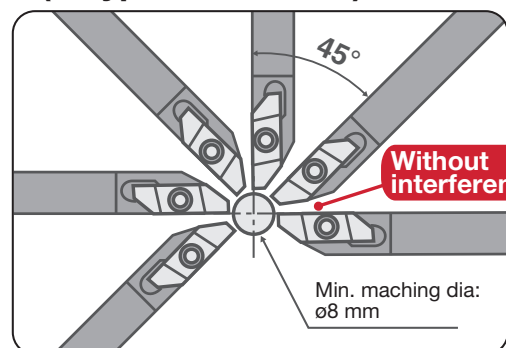
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J-SERIES Introduction of tools

J-SERIES Tooling example



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



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

J-SERIES Insert grades for tools

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

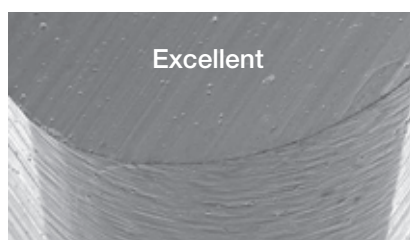


SH730

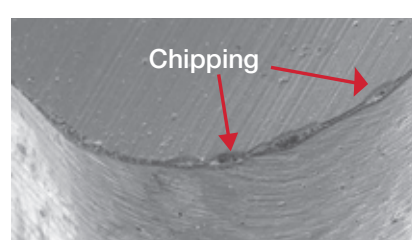


General cemented carbide

- Comparison of sharpness



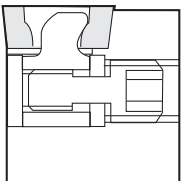
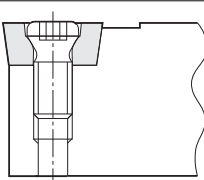
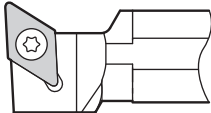
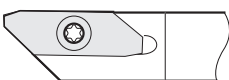
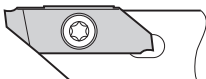
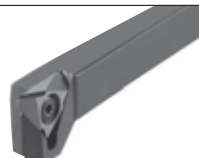
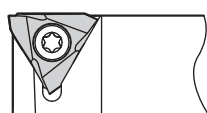
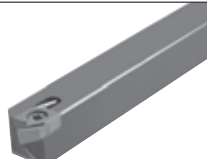
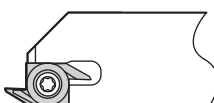
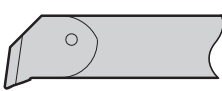
J series



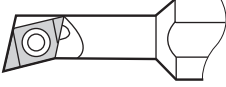
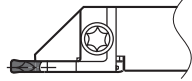
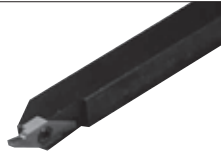
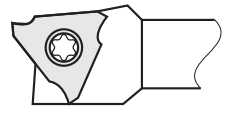
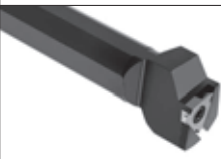
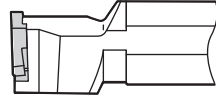
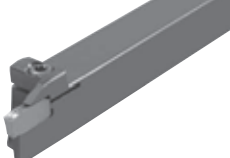
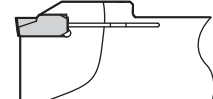
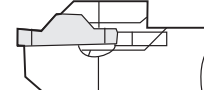
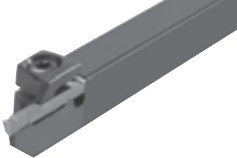
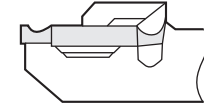
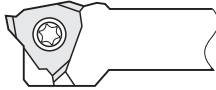
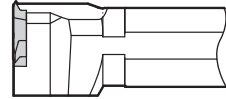
Competitor

Overview of J series tools

Clamping Mechanism and Features

Appli.	Type	Appearance	Clamping mechanism	Features
External turning	JT ▶ 8-9			● Good operability for indexing the insert in limited space such as on gang tooling type lathes ● Good handling allows operation of clamping screw from back side of the toolholder ● Available shank height : 8, 10, 12 and 16 mm
	J ▶ 8-9			● Available in small to medium shank sizes and abundant cutting edge styles ● The smaller shank size toolholders are best suitable for CNC automatics and other small lathes and larger sizes are usable for general purpose lathes. ● Secure insert fastening by highly durable torx screw
	JS-SDUCL ▶ 8-15 (Round shank)			● Round shank type for small lathe ● For external copying ● Shank dia: $\phi 19.05 \sim \phi 25.4$ mm
Reverse turning	JSXG Front and reverse turning ▶ 8-21 Grooving and parting off ▶ 8-48			● The insert is clamped with a both end torx screw, resulting in easy and rapid changing or indexing of the insert. (Can be operated from the back side with a both end torx screw.) ● Applicable for front, reverse turning, grooving and parting off by changing insert ● Max. groove depth is 6.0 mm
	JSXB Back turning ▶ 8-22 Threading ▶ 8-55			● The insert is clamped with a both end torx screw, resulting in easy and rapid changing or indexing of the insert. (Can be operated from the back side with a both end torx screw.) ● Applicable for back turning and threading by changing insert ● The inserts for threading are two corner type. Applicable for 60° threads of 0.5 to 1.0 mm pitches.
	JSTB ▶ 8-23			● Applicable for back turning ● The insert is clamped with a both end torx screw, resulting in easy and rapid changing or indexing of the insert. (Can be operated from the back side with a both end torx screw.) ● Three corner type insert
	JS-TBL3 ▶ 8-23 (Round shank)			● Round shank type for small lathe ● For back turning ● Shank dia: $\phi 19.05 \sim \phi 25.4$ mm
	JSEG ▶ 8-24			● Applicable for back turning ● Max. Parting off dia: $\phi 3$ mm ● Two corner type insert
	JB  ▶ 8-28			● 146 solid bar items in a wide range of geometries ● Minimum boring diameter: $\phi D_m = 0.6$ mm

Overview of J series tools

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

Types and application of TAC External Toolholders

● For external profiling

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

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

● For facing

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

● For external turning

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

● For external turning and facing

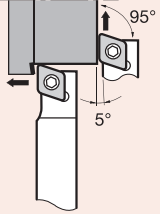
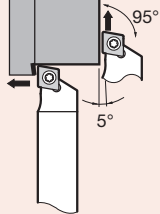
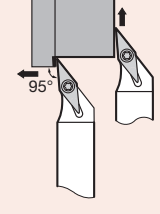
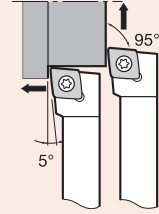
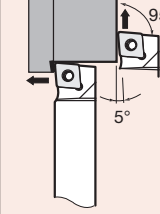
Positive rake				Negative rake
JTCL2CR/L (P.8-9) Shank size 8 ~ 16 mm Back side clamping Without offset	JSCL2CR/L (P.8-9) Shank size 10 ~ 12 mm Screw-on clamping Without offset	JSCLCR/L (P.8-10) Shank size 8 ~ 16 mm Screw-on clamping With offset	JSVL2PR/L (P.8-19) Shank size 10 ~ 16 mm Screw-on clamping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

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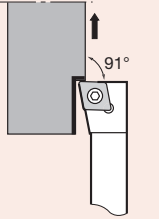
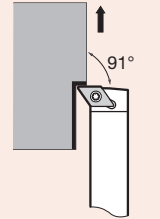
J series

Types and application of TAC External Toolholders

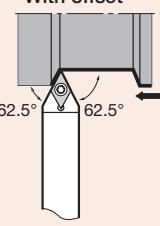
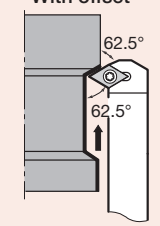
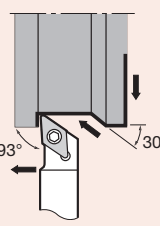
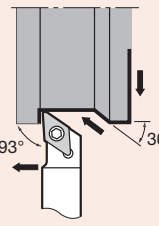
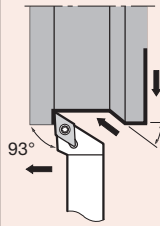
● For external turning and facing

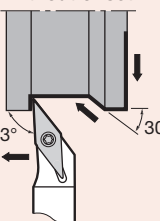
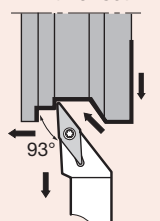
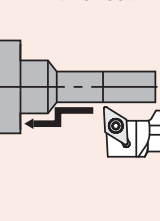
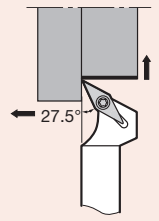
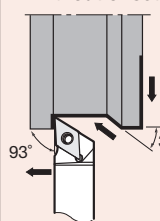
Positive rake				Negative rake
JTCL2C (P.8-9) Cutting edge angle: 95° Back side clamping Without offset 	JSCL2C (P.8-9) Cutting edge angle: 95° Screw-on clamping Without offset 	JSVL2P (P.8-19) Cutting edge angle: 95° Screw-on clamping Without offset 	JSCLC (P.8-10) Cutting edge angle: 95° Screw-on clamping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

● For facing

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

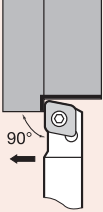
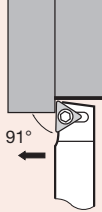
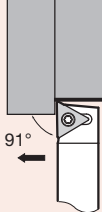
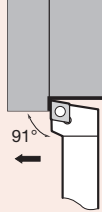
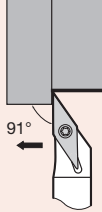
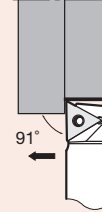
● For external turning and facing

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

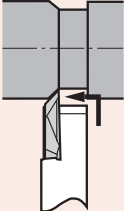
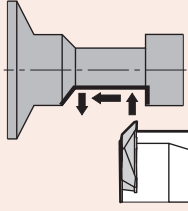
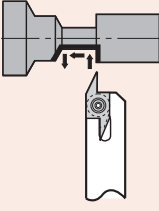
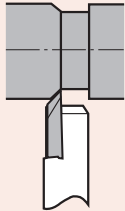
Positive rake				Negative rake
JSVJ2B (P.8-17) Cutting edge angle: 93° Screw-on clamping Without offset 	JSVJB (P.8-17) Cutting edge angle: 93° Screw-on clamping With offset 	JS-SDUCL (P.8-15) Cutting edge angle: 93° Screw-on clamping With offset 	JSVP2P (P.8-19) Cutting edge angle: 117.5° Screw-on clamping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

Types and application of TAC External Toolholders

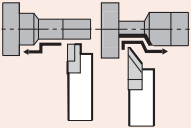
● For external turning

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

● For back turning

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

● For front and reverse turning

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

The features of grades and standard cutting conditions

Feature of grades

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

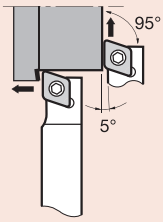
Standard cutting conditions (External turning)

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

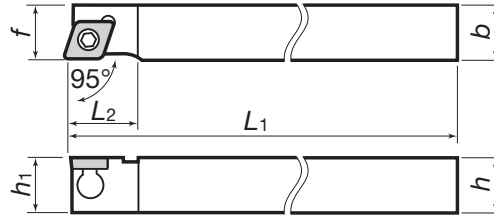
JTCL2CR/L

Without offset / Positive rake
Side clamping system

Turning / Facing



Cutting edge style **L2**



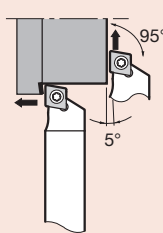
Right hand (R) shown

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				

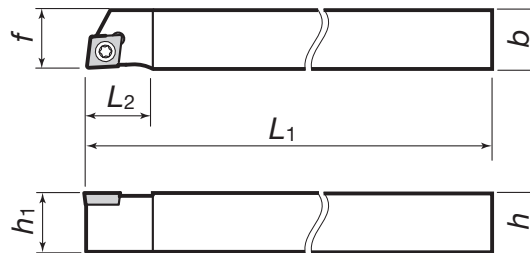
JSCL2CR/L

Without offset / Positive rake
Screw-on system

Turning / Facing



Cutting edge style **L2**



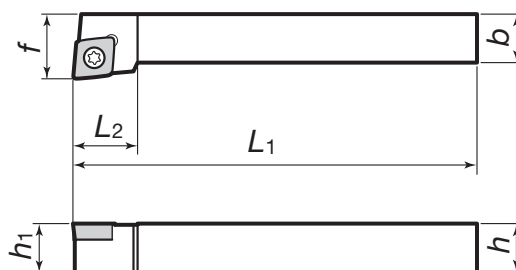
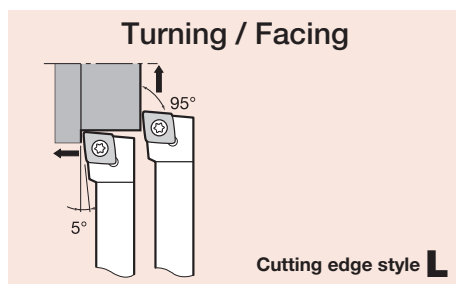
Right hand (R) shown

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				

● : Stocked items.

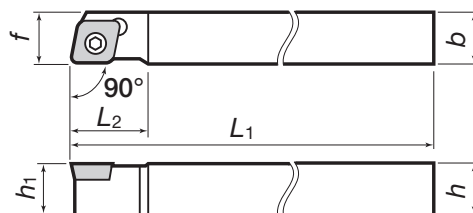
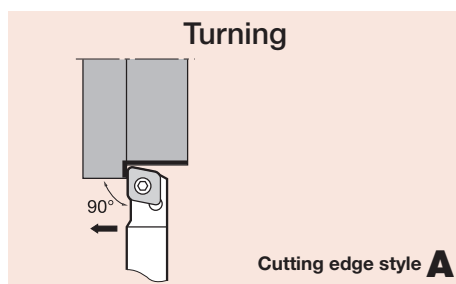
8

J series · External Turning



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				



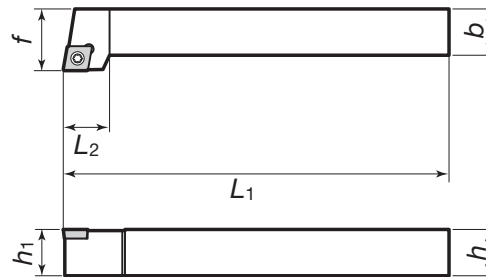
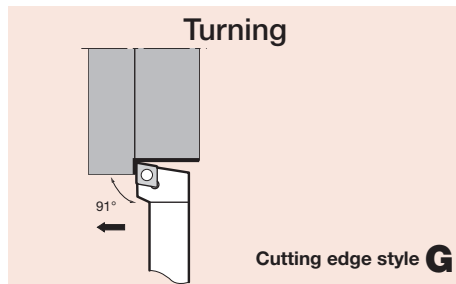
Right hand (R) shown

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

● : Stocked items.

JSCGCR/L

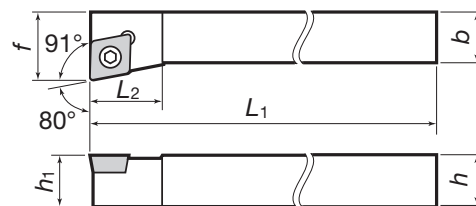
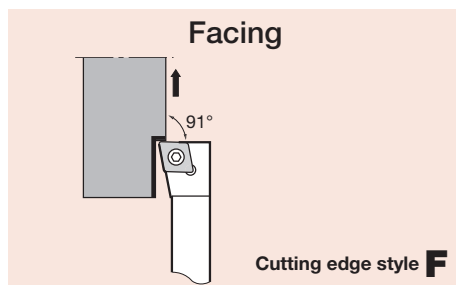
Positive rake
Screw-on system



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	
JSCGCR/L1212H06	●	●	12	12	100	12	12	16	0.4	CC□□0602	CSTB-2.5	T-8F	1.2
JSCGCR/L1616H09	●	●	16	16	100	16	16	20	0.8	CC□□09T3	CSTB-4SD	T-8F	1.2

JSCFCR/L

Positive rake
Screw-on system



Cat. No.	Stock		Dimensions (mm)						Std. corner radius r_{ϵ}	Applicable inserts	Parts		Torque (N·m)
	R	L	h	b	L ₁	L ₂	h ₁	f			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

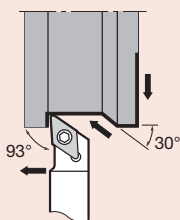
Operation	Precision finishing	Precision finishing	Finishing	Finishing to medium cutting	Finishing to medium cutting	Finishing to light cutting	Finishing to medium cutting	Cast Iron	Cast Iron	Aluminium alloy	Aluminium alloy	Aluminium alloy	Hard materials
Chipbreaker	JS	01	PSF	J10	FR/L-J10	PSS	PS	CM	-	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.

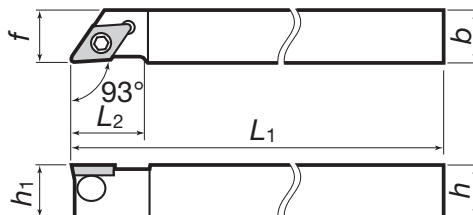
JTDJ2CR/L

Without offset / Positive rake
Back clamping system

Turning / profiling



Cutting edge style **J2**



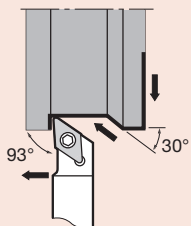
Right hand (R) shown

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

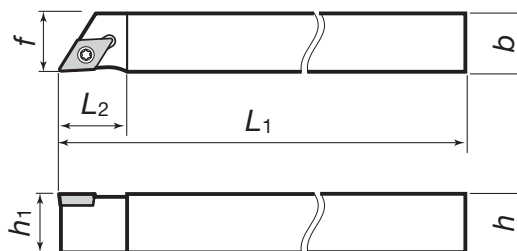
JSDJ2CR/L

Without offset / Positive rake
Screw-on system

Profiling



Cutting edge style **J2**



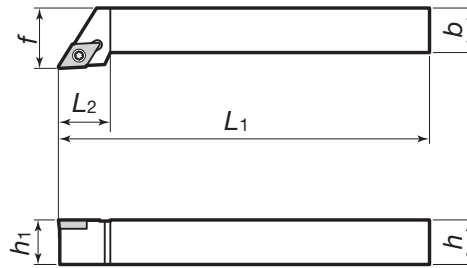
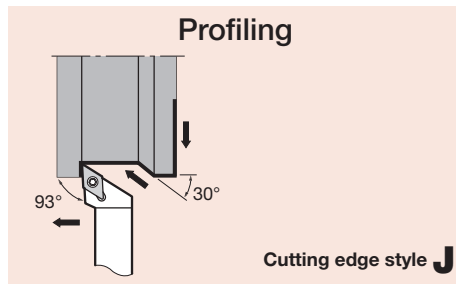
Right hand (R) shown

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

Basic Selection Chipbreaker DC□□

● : Stocked items.

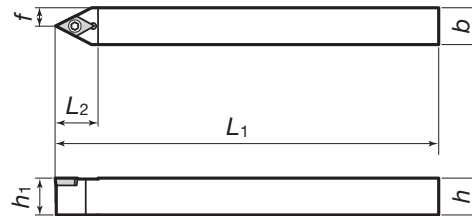
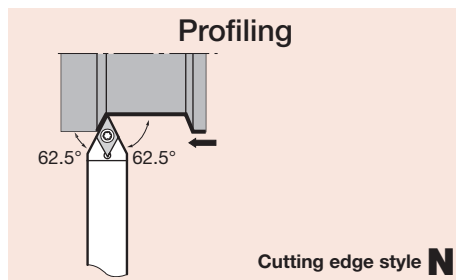
JSDJCR/L

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		

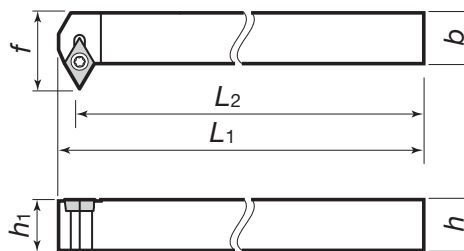
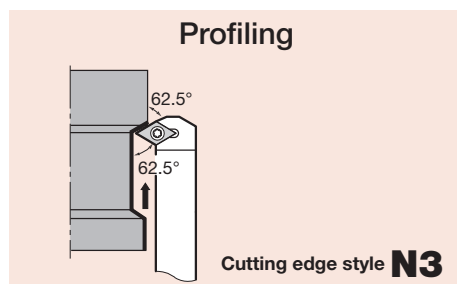
JSDNCN

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				

● : Stocked items.

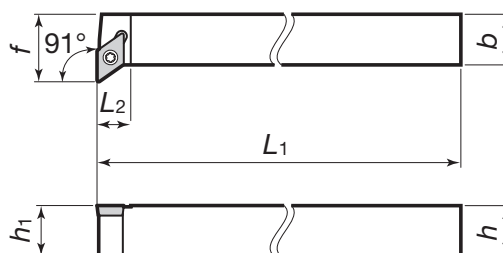
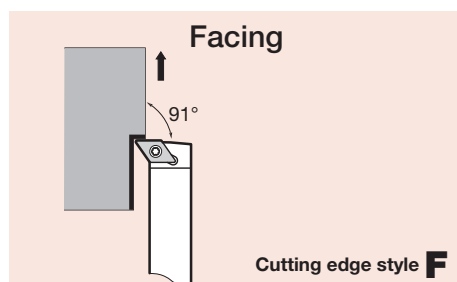
JSDN3CR/L

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	
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

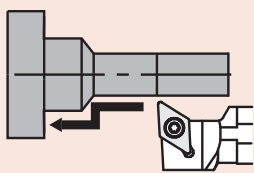
Positive rake
Screw-on system

Right hand (R) shown

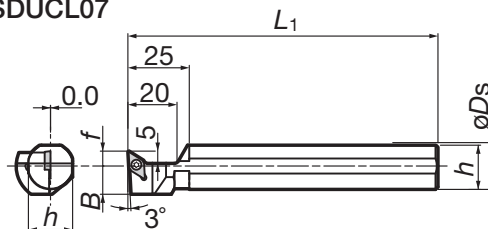
Cat. No.	Stock		Dimensions (mm)						Standard corner radius r_{ϵ}	Applicable inserts	Parts		Torque (N·m)
	R	L	h	b	L_1	L_2	h_1	f			Clamping screw	Wrench	
JSDFCR/L1212H07	●	●	12	12	100	8	12	16	0.4	DC□□0702	CSTB-2.5	T-8F	1.2
JSDFCR/L1616H11	●	●	16	16	100	10.5	16	22	0.8	DC□□11T3	CSTB-4SD	T-8F	1.2

● : Stocked items.

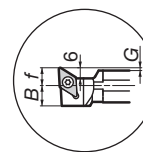
Profiling



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							

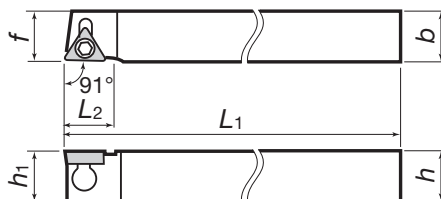
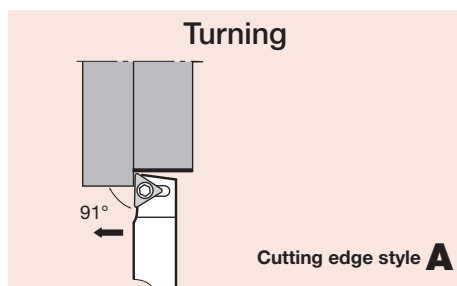
Basic Selection Chipbreakers DC□□0702 DC□□11T3

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**

● : Stocked items.

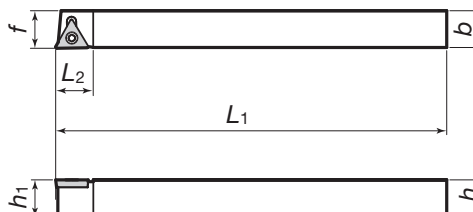
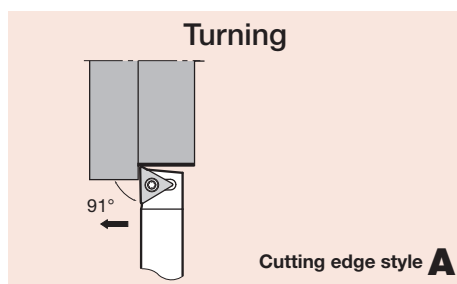
JTTACR/L

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				

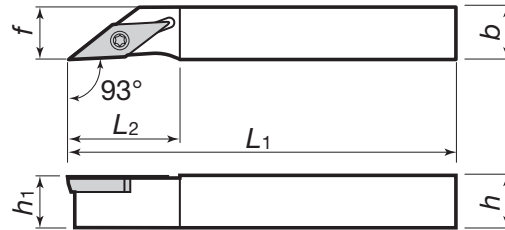
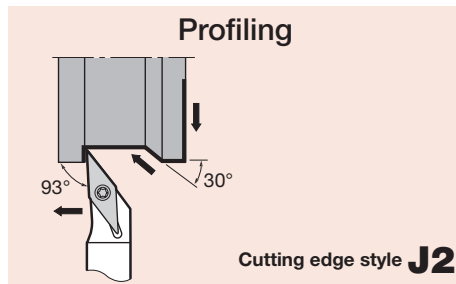
Basic Selection Chipbreakers TC□□0802 TC□□1102

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

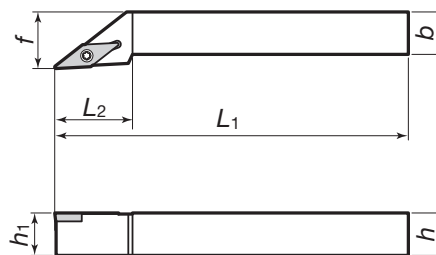
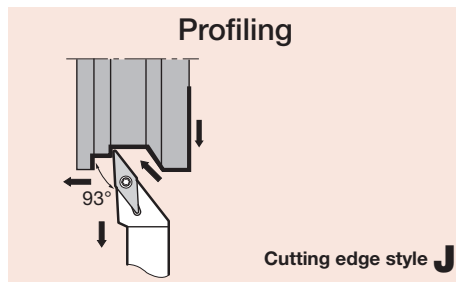


Right hand (R) shown

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	
JSVJ2BR/L1010K11	●	●	10	10	125	21	10	10	0.2	VB□□1103	CSTB-2.5	T-8F	1.2
JSVJ2BR/L1212K11	●	●	12	12	125	21	12	12	0.2				
JSVJ2BR/L1616K11	●	●	16	16	125	21	16	16	0.2				

JSVJBR/L

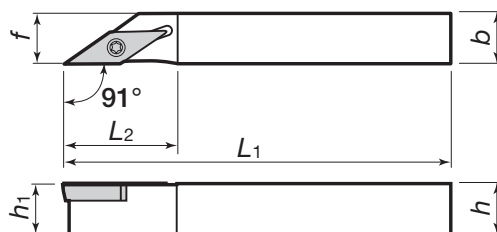
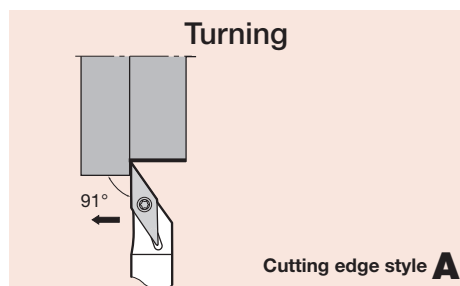
Positive rake
Screw-on system



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	
JSVJBR/L1010H11	●	●	10	10	100	20	10	12	0.4	VB□□1103	CSTB-2.5	T-8F	1.2
JSVJBR/L1212H11	●	●	12	12	100	22	12	16	0.4				
JSVJBR/L1616H11	●	●	16	16	100	22	16	20	0.4				

● : Stocked items.



Without offset

Right hand (R) shown

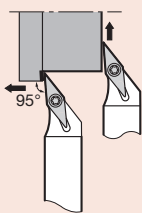
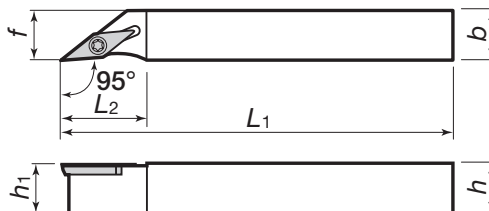
Cat. No.	Stock		Dimensions (mm)						Standard corner radius r_{Σ}	Applicable inserts	Parts		Torque (N·m)
	R	L	h	b	L_1	L_2	h_1	f			Clamping screw	Wrench	
JSVABR/L1010K11	●	●	10	10	125	21	10	10	0.2	VB□□1103	CSTB-2.5	T-8F	1.2
JSVABR/L1212K11	●	●	12	12	125	21	12	12	0.2				
JSVABR/L1616K11	●	●	16	16	125	21	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	JSV**11	VBGT1103**	VBMT1103**	VBGT1103**	VBMT1103**	VBMT1103**	VBGT1103**	VBGT1103**	2QP-VBGW1103**

● : Stocked items.

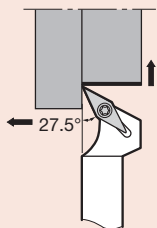
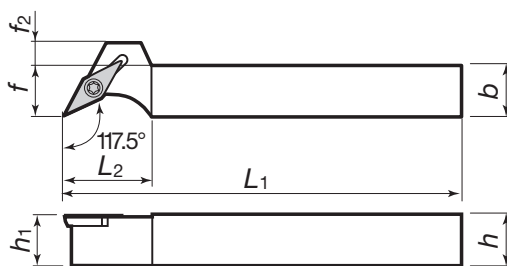
Turning / facing

Cutting edge style **L2**

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	
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				

Profiling

Cutting edge style **P2**

Right hand (R) shown

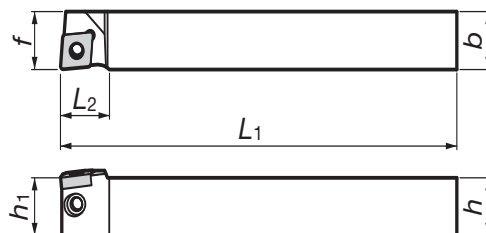
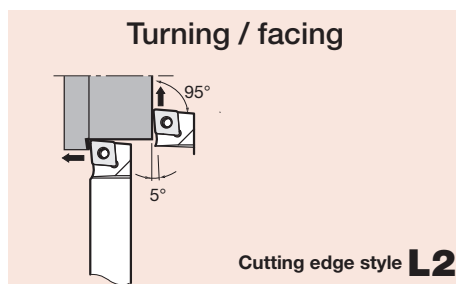
Cat. No.	Stock		Dimensions (mm)						Standard corner radius r_{Σ}	Applicable inserts	Parts		Torque (N·m)
	R	L	h	b	L ₁	L ₂	h ₁	f			Clamping screw	Wrench	
JSVP2PR/L1010K08	●	●	10	10	125	16	10	10	4	VP□□0802	CSTB-2L	T-6F	0.6
JSVP2PR/L1212K08	●	●	12	12	125	16	12	12	2				
JSVP2PR/L1616K08	●	●	16	16	125	16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

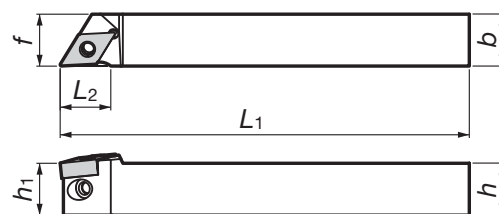
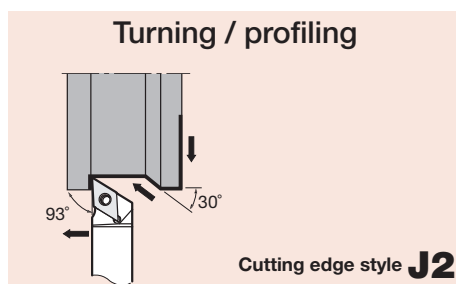
JTCL2NR/L

Without offset / Negative rake
Side clamping system

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				

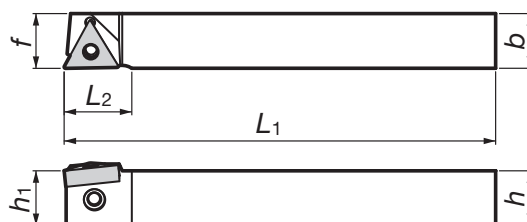
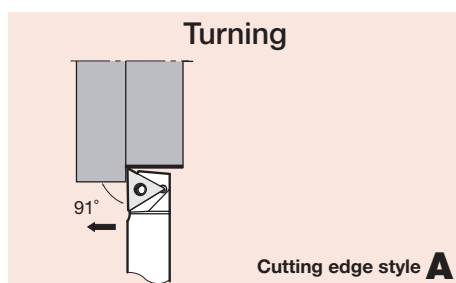
JTDJ2NR/L

Without offset / Negative rake
Side clamping system

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

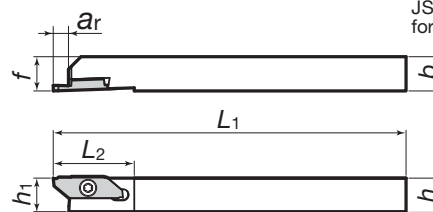
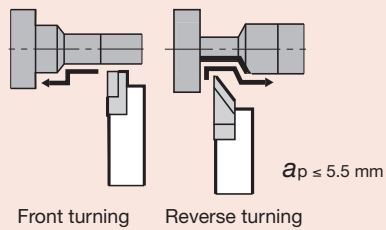
Without offset / Negative rake
Side clamping system

Right hand (R) shown

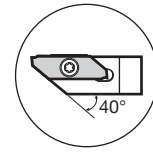
Cat. No.	Stock		Dimensions (mm)						Standard corner radius r_{Σ}	Applicable inserts	Parts		
	R	L	h	b	L_1	L_2	h_1	f			Clamp	Clamping screw	Wrench
JTTANR/L1216K16	●	●	12	16	125	19.8	12	16	0.4	TN□□1604 ▶ 2-70 ~	JCP-3N	JDS-5040	P-2.5F
JTTANR/L1616K16	●	●	16	16	125	19.8	16	16	0.4				

● : Stocked items.

Front and reverse turning



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



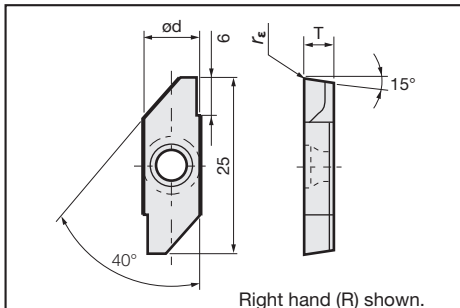
C-type

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

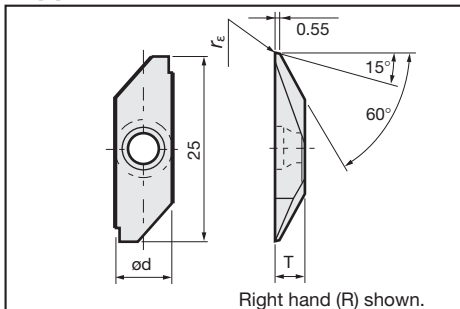
Applicable inserts



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

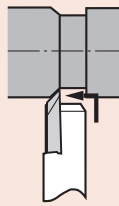


JXR-type inserts (with sharp edges) for reverse turning

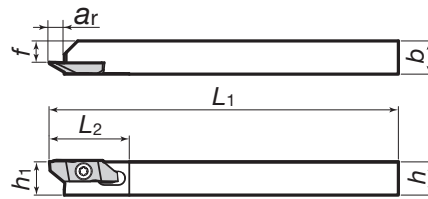
Cat. No.	Dimensions (mm)				Stock					
	ød	T	r _ε	Max. depth of cut	Coated		Cermet		Uncoated	
					J740	NS530	TH10			
JXRR/L8000F	8	3.97	0.03	5.5	●	●			●	
JXRR/L8010F			0.1		●	●			●	

● : Stocked items.

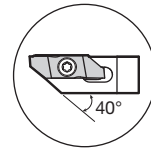
Back turning with large depth of cut



$a_p \leq 5.5 \text{ mm}$



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



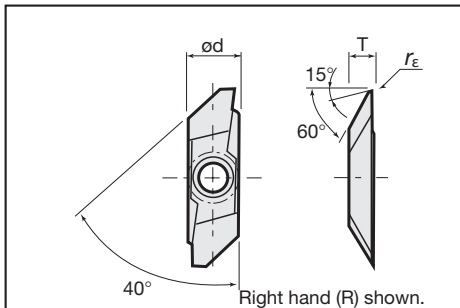
C-type

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



Right hand (R) shown.

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		●	●					●	●

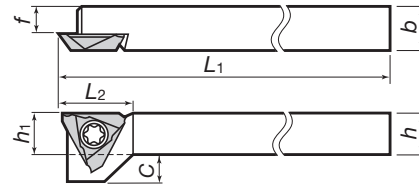
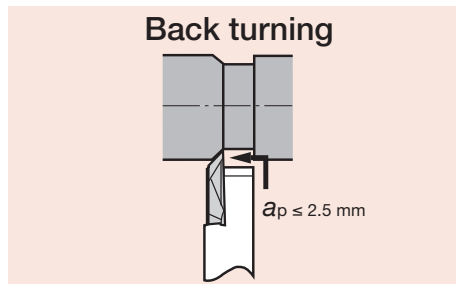
JXB-type inserts (with honed edges)

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



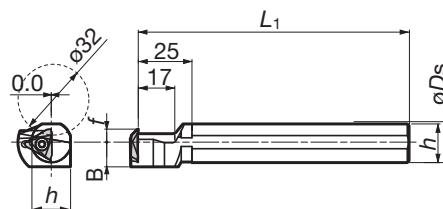
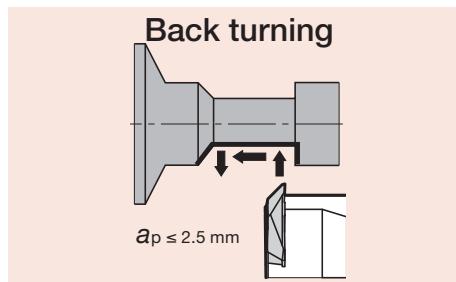
Can be wrenched from back side
with double socket torx screw.

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

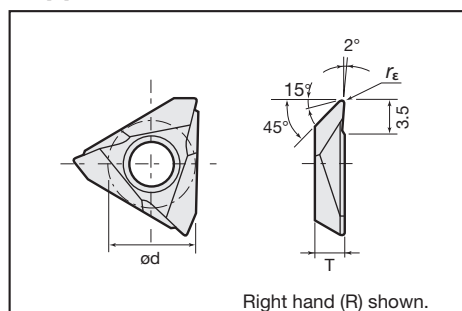
Positive rake
Screw-on system



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			24				

Notes: Left hand holder use right hand insert.

Applicable inserts



Right hand (R) shown.

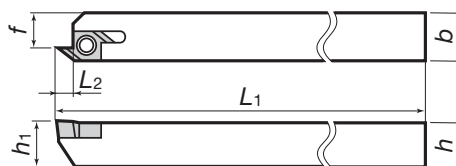
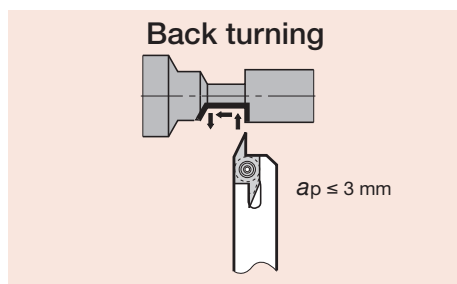
JTB-type inserts (with sharp edges)

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									

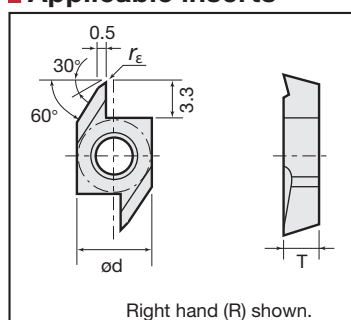
● : Stocked items.



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



J10E-type inserts (with sharp edges)

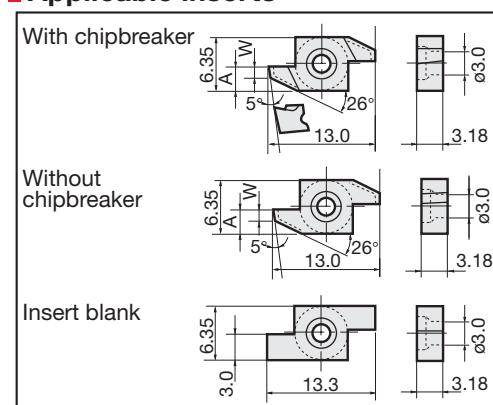
Cat. No.	Dimensions (mm)				Stock									
	ød	T	rε	Max. depth of cut	Coated		Coated cermet		Cermet				Uncoated	
					J740	J530	R	L	R	L	R	L	R	L
J10ER/L005BF	6.35	3.18	0.05	3	●	●					●	●		●
J10ER/L010BF			0.1		●	●					●	●		●
J10ER/L015BF			0.15											

J10E-type inserts (with honed edges)

Cat. No.	Dimensions (mm)				Stock									
	ød	T	rε	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											

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

Applicable inserts

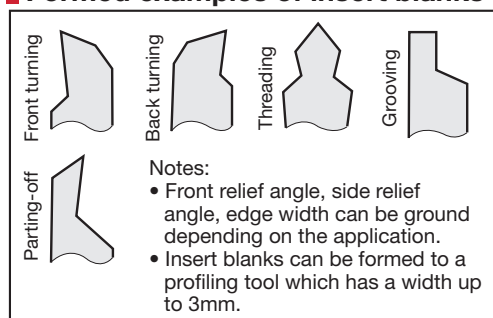


Right hand (R) shown.

Type	Cat. No.	Dimensions (mm)		Stock							
		W	A	Cermet				Uncoated			
				NS530		TH10		TH10		TH10	
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~).

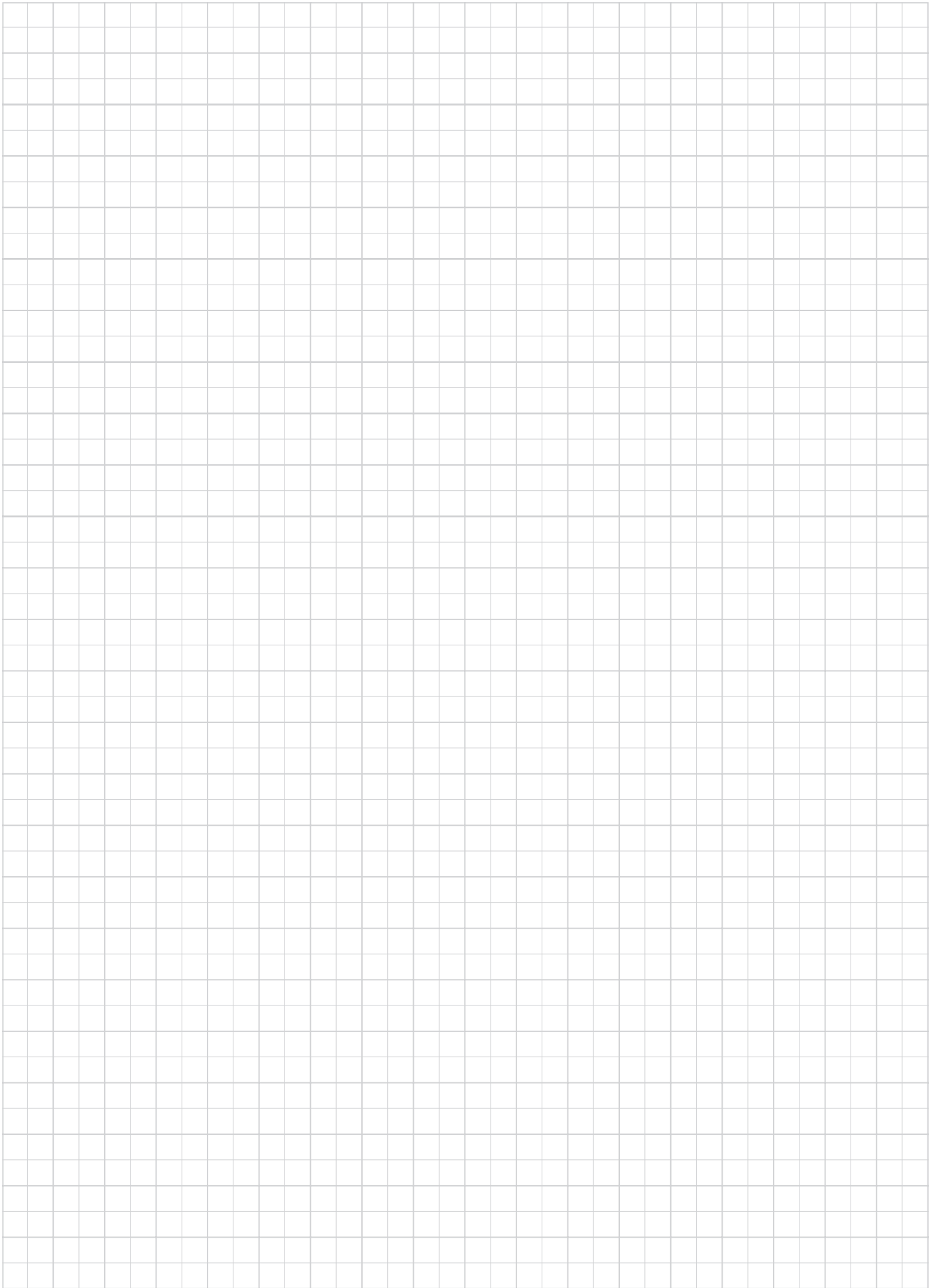
Formed examples of insert blanks



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.



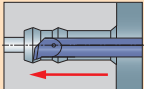
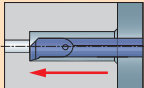
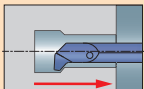
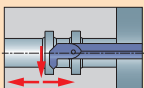
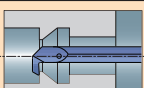
Overview of J series Internal Turning

TINYTURN

- 146 solid bar items in a wide range of geometries
- Minimum boring diameter: $\varnothing D_m = 0.6 \text{ mm}$



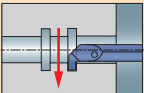
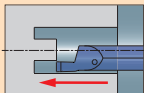
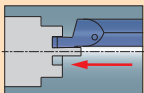
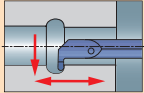
Boring, profiling, chamfering

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

Threading

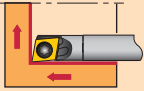
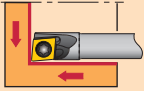
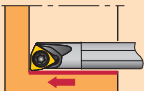
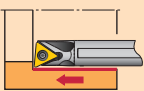
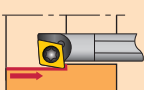
Type	Application		Shank diameter øDs (mm)	Min. bore dia. øDm (mm)					
				0	2	4	6	8	10
JB1 (P. 8-31)		Threading (Metric thread)	ø4, ø7			ø4.0			ø7.0

Grooving

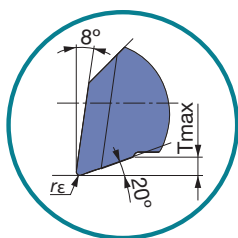
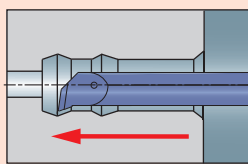
Type	Application		Shank diameter øDs (mm)	Groove width W (mm)	Min. bore dia. øDm (mm)									
					0	2	4	6	8	10	12	14	15	
JBG (P. 8-32)		Grooving	ø4, ø7	0.5 - 2.0		ø2.0			ø6.8					
JBf (P. 8-33)		Face grooving	ø7	1.0 - 3.0				ø6.0						ø15.0
JBS (P. 8-33)		Face grooving (for shaft)	ø7	2.0				ø6.0		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

STREAMJETBARMINI

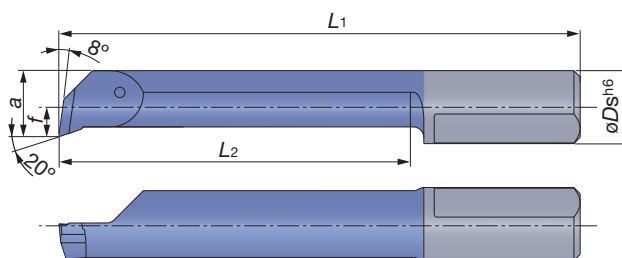
Positive type

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

Boring, profiling, chamfering



Details of edge

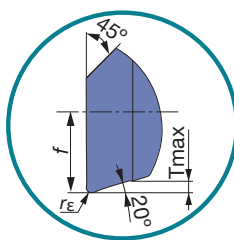
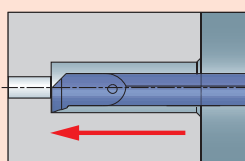


Right hand (R) shown.

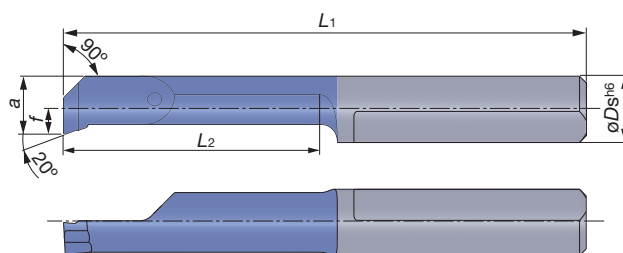
Cat. No.	Grade		Min. bore dia. øDm (mm)	Dimensions (mm)						
	SH730			øDs	f	a	L1	Overhang length L2	Tmax	Corner radius rε+0.05 0
	R	L								
JBTR/L04020004-D006	●		0.6	4	-	0.5	18.5	2	0.08	0.04
JBTR/L04030004-D006	●		0.6	4	-	0.5	19.5	3	0.08	0.04
JBTR/L04045005-D010	●		1	4	-	0.9	21	4.5	0.1	0.05
JBTR/L04065005-D010	●		1	4	-	0.9	23	6.5	0.1	0.05
JBTR/L04040005-D020	●		2	4	-	1.7	20.5	4	0.1	0.05
JBTR/L04090005-D020	●		2	4	-	1.7	25.5	9	0.1	0.05
JBTR/L04140005-D020	●		2	4	-	1.7	30.5	14	0.1	0.05
JBTR/L04090010-D028	●	●	2.8	4	0.6	2.6	25.5	9	0.2	0.10
JBTR/L04150010-D028	●	●	2.8	4	0.6	2.6	31.5	15	0.2	0.10
JBTR/L04190010-D028	●	●	2.8	4	0.6	2.6	35.5	19	0.2	0.10
JBTR/L04090010-D040	●	●	4	4	1.5	3.5	25.5	9	0.3	0.10
JBTR/L04150010-D040	●	●	4	4	1.5	3.5	31.5	15	0.3	0.10
JBTR/L04190010-D040	●	●	4	4	1.5	3.5	35.5	19	0.3	0.10
JBTR/L04230010-D040	●		4	4	1.5	3.5	39.5	23	0.3	0.10
JBTR/L04270010-D040	●		4	4	1.5	3.5	43.5	27	0.3	0.10
JBTR/L07090015-D050	●	●	5	7	0.9	4.4	25	9	0.5	0.15
JBTR/L07140015-D050	●	●	5	7	0.9	4.4	30	14	0.5	0.15
JBTR/L07190015-D050	●	●	5	7	0.9	4.4	35	19	0.5	0.15
JBTR/L07240015-D050	●	●	5	7	0.9	4.4	40	24	0.5	0.15
JBTR/L07290015-D050	●	●	5	7	0.9	4.4	45	29	0.5	0.15
JBTR/L07340015-D050	●		5	7	0.9	4.4	50	34	0.5	0.15
JBTR/L07140015-D060	●	●	6	7	1.8	5.3	30	14	0.5	0.15
JBTR/L07210015-D060	●	●	6	7	1.8	5.3	37	21	0.5	0.15
JBTR/L07240015-D060	●	●	6	7	1.8	5.3	40	24	0.5	0.15
JBTR/L07290015-D060	●	●	6	7	1.8	5.3	45	29	0.5	0.15
JBTR/L07340015-D060	●		6	7	1.8	5.3	50	34	0.5	0.15
JBTR/L07410015-D060	●		6	7	1.8	5.3	57	41	0.5	0.15
JBTR/L07190015-D068	●	●	6.8	7	2.8	6.3	35	19	0.6	0.15
JBTR/L07240015-D068	●		6.8	7	2.8	6.3	40	24	0.6	0.15
JBTR/L07290015-D068	●	●	6.8	7	2.8	6.3	45	29	0.6	0.15
JBTR/L07340015-D070	●	●	7	7	2.8	6.3	50	34	0.6	0.15
JBTR/L07390015-D070	●		7	7	2.8	6.3	55	39	0.6	0.15
JBTR/L07440015-D070	●		7	7	2.8	6.3	60	44	0.6	0.15
JBTR/L07490015-D070	●		7	7	2.8	6.3	65	49	0.6	0.15

● : Stocked items

Boring, chamfering

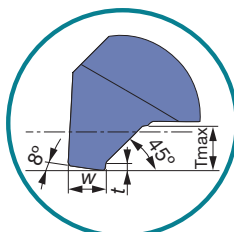
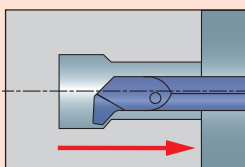


Details of edge

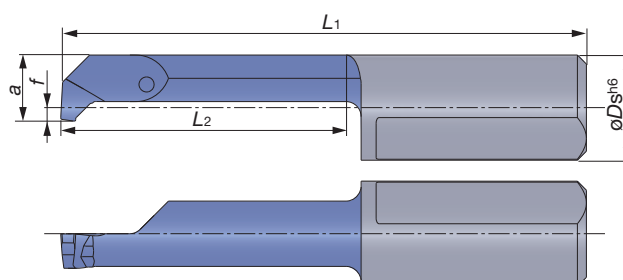


Cat. No.	Grade	Min. bore dia. øDm (mm)	Dimensions (mm)						
	SH730		øDs	f	a	L1	Overhang length L2	Tmax	Corner radius rε +0.05 0
JBPR04090010-D028	●	2.8	4	0.6	2.6	25.5	9	0.2	0.10
JBPR04150010-D028	●	2.8	4	0.6	2.6	31.5	15	0.2	0.10
JBPR04090010-D040	●	4	4	1.5	3.5	25.5	9	0.3	0.10
JBPR04150010-D040	●	4	4	1.5	3.5	31.5	15	0.3	0.10
JBPR07140015-D050	●	5	7	0.9	4.4	30	14	0.5	0.15
JBPR07190015-D050	●	5	7	0.9	4.4	35	19	0.5	0.15

Back boring, chamfering



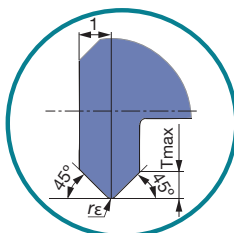
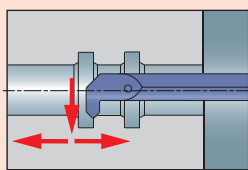
Details of edge



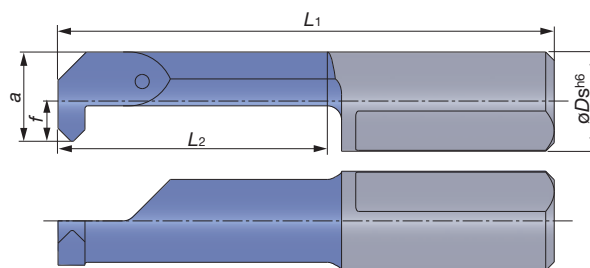
Right hand (R) shown.

Cat. No.	Grade		Min. bore dia. øDm (mm)	Dimensions (mm)							Groove width (mm)
	SH730	R L		øDs	f	a	L1	Overhang length L2	t	Tmax	W +0.05 0
JBUR/L07140010-D050	●		5	7	0.9	4.4	30	14	0.2	1	1
JBUR/L07190010-D050	●		5	7	0.9	4.4	35	19	0.2	1	1

Boring, 45° chamfering

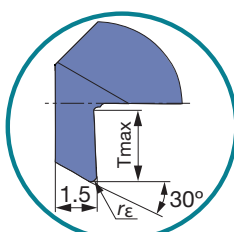
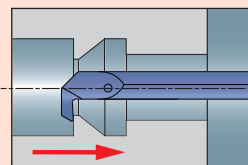


Details of edge

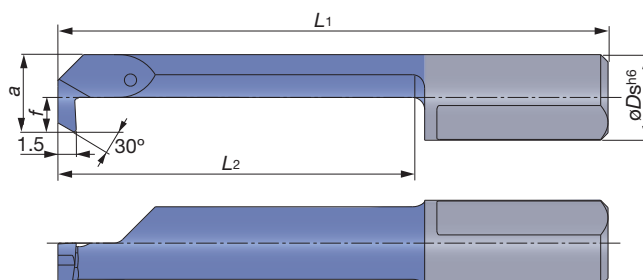


Cat. No.	Grade	Min. bore dia. øDm (mm)	Dimensions (mm)						
	SH730		øDs	f	a	L1	Overhang length L2	Tmax	Corner radius rε ± 0.05
JBCR07140020-D050	●	5	7	0.9	4.4	30	14	0.7	0.2
JBCR07190020-D050	●	5	7	0.9	4.4	35	19	0.7	0.2
JBCR07190020-D068	●	6.8	7	2.8	6.3	35	19	0.7	0.2

Back boring



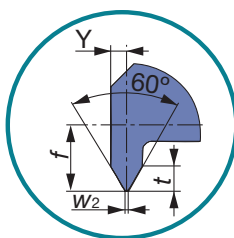
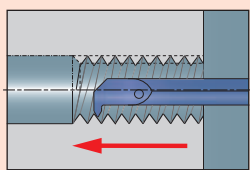
Details of edge



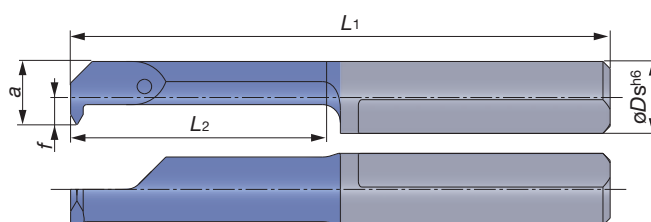
Cat. No.	Grade	Min. bore dia. øDm (mm)	Dimensions (mm)						
	SH730		øDs	f	a	L1	Overhang length L2	Tmax	Corner radius rε ± 0.05
JBBR04140020-D030	●	3	4	0.6	2.6	30	14	0.5	0.2
JBBR04190020-D030	●	3	4	0.6	2.6	35	19	0.5	0.2
JBBR04140015-D040	●	4	4	1.5	3.5	30	14	0.8	0.15
JBBR04240015-D040	●	4	4	1.5	3.5	40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

● : Stocked items

Threading (metric thread)

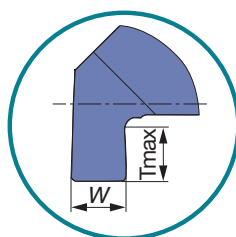
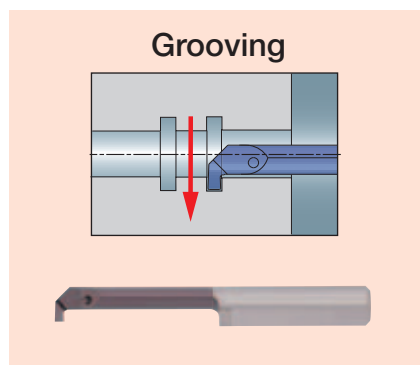


Details of edge

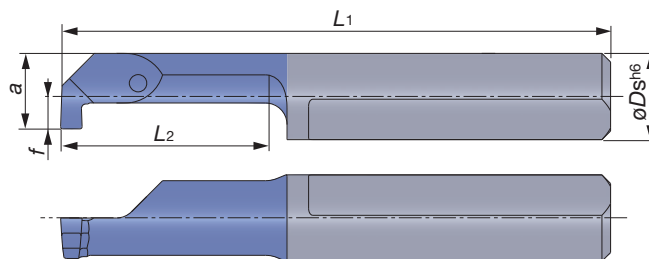


Cat. No.	Grade	Pitch (mm)	Min. bore dia. øDm (mm)	Flat width W ₂ -0.02	Dimensions (mm)						
	SH730				øDs	f	a	L ₁	Overhang length L ₂	t	Y
JBIR04140050-D040	●	0.5	4	0.06	4	1.5	3.5	30	14	0.3	0.35
JBIR07140050-D050	●	0.5	5	0.06	7	0.9	4.4	30	14	0.3	0.35
JBIR07140075-D050	●	0.75	5	0.09	7	0.9	4.4	30	14	0.4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

● : Stocked items



Details of edge

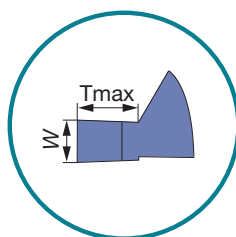
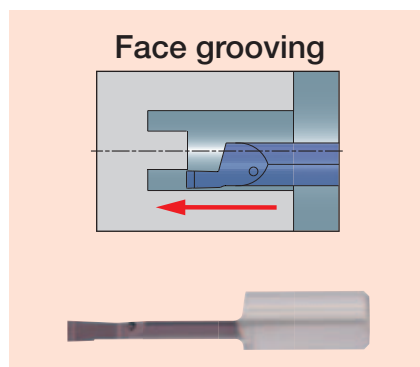


Right hand (R) shown.

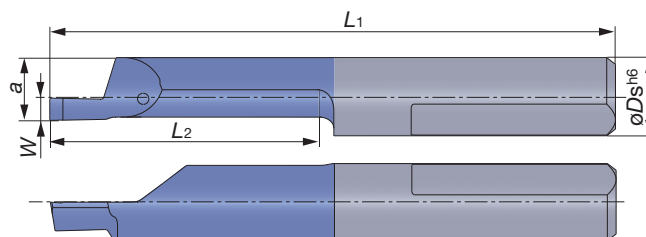
Cat. No.	Grade		Groove width $W_0^{+0.05}$ (mm)	Min. bore dia. ϕD_m (mm)	Dimensions (mm)					
	SH730				ϕD_s	f	a	L_1	Overhang length L_2	Tmax
	R	L								
JBGR/L04050050-D020	●		0.5	2	4	0.2	1.8	21	5	0.4
JBGR/L04100050-D020	●		0.5	2	4	0.2	1.8	26	10	0.4
JBGR/L04050070-D030	●		0.7	3	4	0.7	2.7	21	5	0.6
JBGR/L04100070-D030	●		0.7	3	4	0.7	2.7	26	10	0.6
JBGR/L04090100-D040	●		1	4	4	1.5	3.5	25.5	9	0.8
JBGR/L04150100-D040	●		1	4	4	1.5	3.5	31.5	15	0.8
JBGR/L07090100-D050	●		1	5	7	0.9	4.4	25	9	1
JBGR/L07140100-D050	●		1	5	7	0.9	4.4	30	14	1
JBGR/L07090150-D050	●		1.5	5	7	0.9	4.4	25	9	1
JBGR/L07140150-D050	●		1.5	5	7	0.9	4.4	30	14	1
JBGR/L07090200-D050	●		2	5	7	0.9	4.4	25	9	1
JBGR/L07190200-D050	●		2	5	7	0.9	4.4	35	19	1
JBGR/L07090100-D060	●	●	1	6	7	1.8	5.3	25	9	1.8
JBGR/L07140100-D060	●		1	6	7	1.8	5.3	30	14	1.8
JBGR/L07210100-D060	●		1	6	7	1.8	5.3	37	21	1.8
JBGR/L07290100-D060	●		1	6	7	1.8	5.3	45	29	1.8
JBGR/L07090150-D060	●	●	1.5	6	7	1.8	5.3	25	9	1.8
JBGR/L07140150-D060	●		1.5	6	7	1.8	5.3	30	14	1.8
JBGR/L07210150-D060	●		1.5	6	7	1.8	5.3	37	21	1.8
JBGR/L07240150-D060	●		1.5	6	7	1.8	5.3	40	24	1.8
JBGR/L07290150-D060	●		1.5	6	7	1.8	5.3	45	29	1.8
JBGR/L07090200-D060	●		2	6	7	1.8	5.3	25	9	1.8
JBGR/L07140200-D060	●		2	6	7	1.8	5.3	30	14	1.8
JBGR/L07210200-D060	●		2	6	7	1.8	5.3	37	21	1.8
JBGR/L07240200-D060	●		2	6	7	1.8	5.3	40	24	1.8
JBGR/L07290200-D060	●		2	6	7	1.8	5.3	45	29	1.8
JBGR/L07090100-D068	●		1	6.8	7	2.7	6.2	25	9	2.5
JBGR/L07140100-D068	●		1	6.8	7	2.7	6.2	30	14	2.5
JBGR/L07210100-D068	●		1	6.8	7	2.7	6.2	37	21	2.5
JBGR/L07090150-D068	●		1.5	6.8	7	2.7	6.2	25	9	2.5
JBGR/L07140150-D068	●		1.5	6.8	7	2.7	6.2	30	14	2.5
JBGR/L07210150-D068	●		1.5	6.8	7	2.7	6.2	37	21	2.5
JBGR/L07290150-D068	●		1.5	6.8	7	2.7	6.2	45	29	2.5
JBGR/L07090200-D068	●		2	6.8	7	2.7	6.2	25	9	2.5
JBGR/L07140200-D068	●	●	2	6.8	7	2.7	6.2	30	14	2.5
JBGR/L07210200-D068	●		2	6.8	7	2.7	6.2	37	21	2.5
JBGR/L07250200-D068	●		2	6.8	7	2.7	6.2	40	25	2.5
JBGR/L07290200-D068	●		2	6.8	7	2.7	6.2	45	29	2.5

* The corner radius is less than 0.1 mm.

● : Stocked items



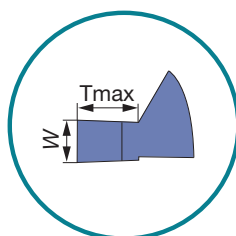
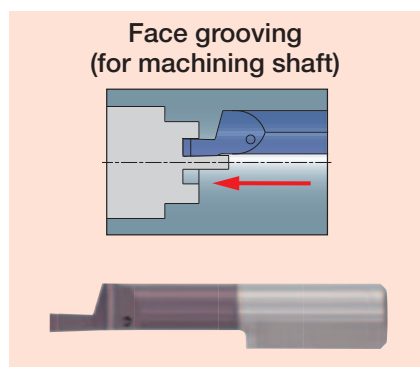
Details of edge



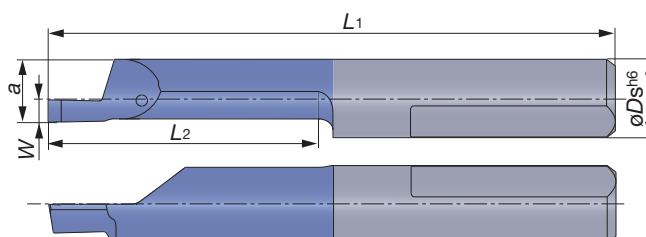
Right hand (R) shown.

Cat. No.	Grade		Groove width $W_{0}^{+0.05}$ (mm)	Min. bore dia. $\varnothing D_m$ (mm)	Dimensions (mm)				
	SH730				$\varnothing D_s$	a	L_1	Overhang length L_2	Tmax
	R	L							
JBFR/L07110100-D060	●		1	6	7	5.2	26	10	1.5
JBFR/L07110150-D060	●		1.5	6	7	5.2	26	10	2
JBFR/L07110200-D060	●		2	6	7	5.2	26	10	3
JBFR/L07110250-D080	●		2.5	8	7	5.9	27	11	3.5
JBFR/L07110300-D080	●		3	8	7	5.9	27	11	3.5
JBFR/L07210150-D080	●	●	1.5	8	7	5.9	36	21	2.5
JBFR/L07210200-D080	●		2	8	7	5.9	36	21	3
JBFR/L07210250-D080	●		2.5	8	7	5.9	36	21	3.5
JBFR/L07210300-D080	●		3	8	7	5.9	36	21	3.5
JBFR/L07300200-D080	●	●	2	8	7	5.9	46	30	3
JBFR/L07300300-D080	●		3	8	7	5.9	46	30	3.5
JBFR/L07110100-D080	●		1	8	7	5.9	27	11	1.5
JBFR/L07110150-D080	●		1.5	8	7	5.9	27	11	2.5
JBFR/L07110200-D080	●		2	8	7	5.9	27	11	3
JBFR/L07200200-D080	●		2	8	7	5.9	36	20	3
JBFR/L07200250-D150	●		2.5	15	7	5.9	36	20	20
JBFR/L07200300-D150	●		3	15	7	5.9	36	20	20
JBFR/L07300300-D150	●		3	15	7	5.9	46	30	30

* The corner radius is less than 0.1 mm.



Details of edge

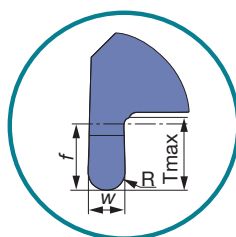
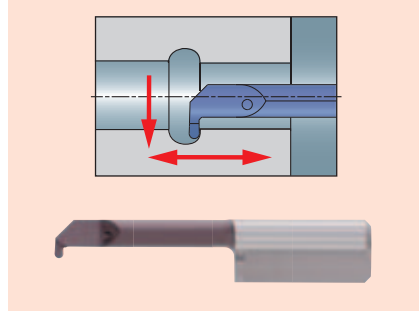


Cat. No.	Grade	Groove width $W_{+0.05}^0$ (mm)	Min. bore dia. ϕD_m (mm)	Dimensions (mm)				
	SH730			ϕD_s	a	L_1	Overhang length L_2	Tmax
JBSR07200200-D060	●	2	6	7	5.2	36	20	4

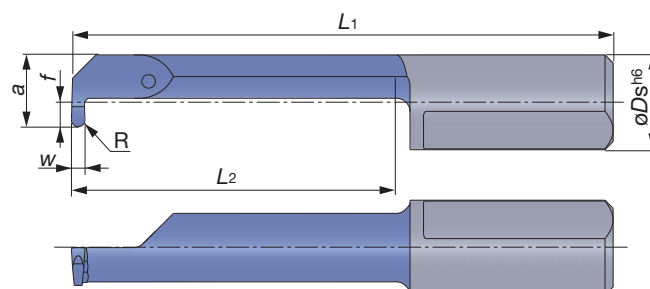
* The corner radius is less than 0.1 mm.

● : Stocked items

Boring, profiling (full radius type)



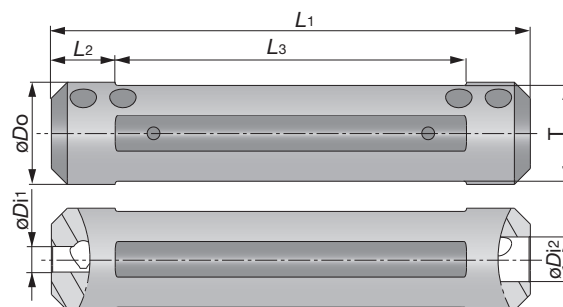
Details of edge



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

Sleeves

JBBS For TinyTurn



Cat. No.	Stock	Dimensions (mm)							Replacement parts	
		ϕD_o	ϕD_{i1}	ϕD_{i2}	L_1	L_2	L_3	T	Clamping screw	Wrench
JBBS12-4-4	●	12	4	4	75	10	55	10.3	SSHM5-4PF-S	P-2.5
JBBS127-4-4	●	12.7	4	4	76.2	10	56.2	11.6	SSHM5-6PF-S	P-2.5
JBBS14-4-4	●	14	4	4	75	10	55	12	SSHM5-4PF-S	P-2.5
JBBS159-4-7	●	15.875	4	7	76.2	10	56.2	14	SSHM5-6PF-S	P-2.5
JBBS16-4-7	●	16	4	7	75	10	55	15	SSHM5-6PF-S	P-2.5
JBBS19-4-7	●	19.05	4	7	89	10	69	17.2	SSHM5-6PF-S	P-2.5
JBBS20-4-7	●	20	4	7	90	10	70	18	SSHM5-6PF-S	P-2.5
JBBS22-4-7	●	22	4	7	90	10	70	20	SSHM5-6PF-S	P-2.5
JBBS25-4-7	●	25	4	7	100	10	80	23	SSHM5-6PF-S	P-2.5
JBBS254-4-7	●	25.4	4	7	90	10	70	23.4	SSHM5-6PF-S	P-2.5

● : Stocked items

Standard cutting condition

Boring, profiling, chamfering, back boring

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

* JBTR/L04020004-D006,
JBTR/L04030004-D006
Max. f = 0.01 mm/rev

Threading (metric thread)

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

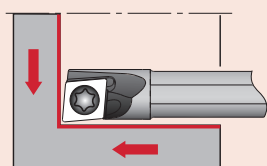
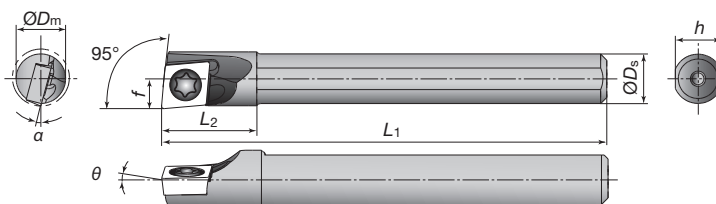
Internal grooving

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

Face grooving

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

Boring & internal facing

Cutting edge style **L**

Right hand (R) shown

Steel shank

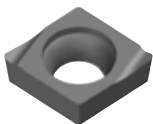
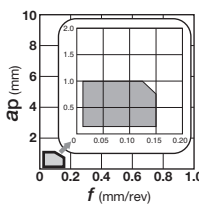
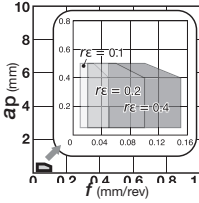
Cat. No.	Stock		Min bore dia. ϕD_m	Dimensions (mm)								Std. corner radius r_ϵ	Applicable inserts	Parts		Torque (N·m)
	R	L		ϕD_s	f	L_1	L_2	h	f_2	θ	α			Clamping screw	Wrench	
A04F-SCLCR/L03-D050	●	●	5	4	2.5	80	8	3.8	-	0°	-15°	0.2	CC□□03X1	CSTA-1.6	T-6F	0.6
A05F-SCLCR/L03-D060	●	●	6	5	3	80	9	4.8	-	0°	-13°	0.2	CC□□03X1	CSTA-1.6	T-6F	0.6
A06G-SCLCR/L04-D070	●	●	7	6	3.5	90	11	5.75	-	0°	-13°	0.2	CC□□04T1	CSTB-2	T-6F	0.6
A07G-SCLCR/L04-D080	●	●	8	7	4	90	12	6.75	-	0°	-11°	0.2	CC□□04T1	CSTB-2	T-6F	0.6

Carbide shank

Cat. No.	Stock		Min bore dia. ϕD_m	Dimensions (mm)								Std. corner radius r_ϵ	Applicable inserts	Parts		Torque (N·m)
	R	L		ϕD_s	f	L_1	L_2	h	f_2	θ	α			Clamping screw	Wrench	
E04G-SCLCR/L03-D050	●	●	5	4	2.5	90	9	3.8	-	0°	-15°	0.2	CC□□03X1	CSTA-1.6	T-6F	0.6
E05G-SCLCR/L03-D060	●	●	6	5	3	90	10	4.8	-	0°	-13°	0.2	CC□□03X1	CSTA-1.6	T-6F	0.6
E06H-SCLCR/L04-D070	●	●	7	6	3.5	100	12	5.75	-	0°	-13°	0.2	CC□□04T1	CSTB-2	T-6F	0.6
E07H-SCLCR/L04-D080	●	●	8	7	4	100	14	6.75	-	0°	-11°	0.2	CC□□04T1	CSTB-2	T-6F	0.6

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

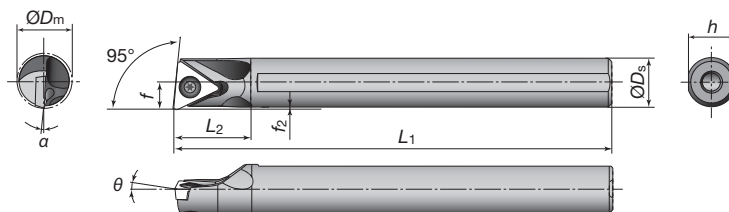
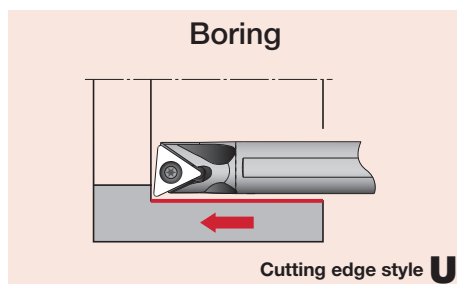
Applicable inserts

Application	Chipbreaker Appearance (Cross section)	$f - a_p$	Insert Cat. No. (Metric)	Dimensions (mm)				Grades	
				I.C. dia. ϕd	Thickness s	Hole dia. ϕd_1	Corner radius r_ϵ	Coated	Carbide
								SH730	TH10
Finishing	W08 (G) 		CCGT03X100R-W08	3.57	1.39	1.9	0.03	●	●
			CCGT03X100L-W08				0.03	●	●
			CCGT03X101R-W08				0.10	●	●
			CCGT03X101L-W08				0.10	●	●
			CCGT03X102R-W08				0.20	●	●
			CCGT03X102L-W08				0.20	●	●
			CCGT03X104R-W08				0.40	●	●
			CCGT03X104L-W08				0.40	●	●
			CCGT04T100R-W08	4.37	1.79	2.3	0.03	●	●
			CCGT04T100L-W08				0.03	●	●
			CCGT04T101R-W08				0.10	●	●
			CCGT04T101L-W08				0.10	●	●
			CCGT04T102R-W08				0.20	●	●
			CCGT04T102L-W08				0.20	●	●
			CCGT04T104R-W08				0.40	●	●
			CCGT04T104L-W08				0.40	●	●
	JS (G) 		CCGT03X101-JS	3.57	1.39	1.9	0.10	●	
			CCGT03X102-JS				0.20	●	
			CCGT03X104-JS				0.40	●	
			CCGT04T101-JS	4.37	1.79	2.3	0.10	●	
			CCGT04T102-JS				0.20	●	
			CCGT04T104-JS				0.40	●	

Applicable inserts (T-CBN)

Cat. No.	Dimensions (mm)						Grades
	Relief angle θ	I.C. dia ϕd	Thickness s	Hole dia ϕd_1	Corner R r_ϵ	CBN length a	
1QP-CCGW03X102	7°	3.57	1.39	1.9	0.2	1.4	●
1QP-CCGW03X104	7°	3.57	1.39	1.9	0.4	1.3	●
1QP-CCGW04T102	7°	4.37	1.79	2.3	0.2	1.9	●
1QP-CCGW04T104	7°	4.37	1.79	2.3	0.4	1.8	●

● : Stocked items.



Steel shank

Right hand (R) shown

Cat. No.	Stock		Min bore dia. ØDm	Dimensions (mm)								Std. corner radius r _ε	Applicable inserts	Parts		Torque (N·m)
	R	L		ØDs	f	L ₁	L ₂	h	f ₂	θ	α			Clamping screw	Wrench	
A07G-STUPR/L07-D080	●	●	8	7	4	90	12	6.75	0.4	+5°	-10°	0.4	TP□□0701	CSTB-2.2L038	T-7F	0.9

Carbide shank

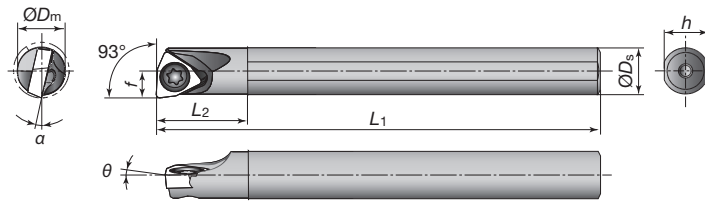
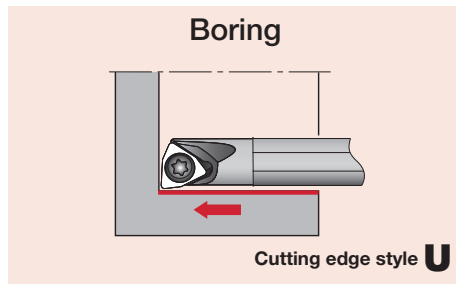
Cat. No.	Stock		Min bore dia. ØDm	Dimensions (mm)								Std. corner radius r _ε	Applicable inserts	Parts		Torque (N·m)
	R	L		ØDs	f	L ₁	L ₂	h	f ₂	θ	α			Clamping screw	Wrench	
E07H-STUPR/L07-D080	●	●	8	7	4	100	14	6.75	0.3	+5°	-10°	0.4	TP□□0701	CSTB-2.2L038	T-7F	0.9

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

Applicable inserts

Application	Chipbreaker	$f - a_p$	Insert Cat. No. (Metric)	Dimensions (mm)				Grades	
	Appearance (Cross section)			I.C. dia. ϕd	Thickness s	Hole dia. (ϕ) ϕd_1	Corner radius r_ϵ	Coated SH730	Carbide TH10
Finishing	W08 (G)		TPGT070100R-W08	4.37	1.59	2.58	0.03	●	●
	TPGT070100L-W08		0.10				●	●	
	TPGT070101R-W08		0.20				●	●	
	TPGT070101L-W08		0.40				●	●	
	TPGT070102R-W08						●	●	
	TPGT070102L-W08						●	●	
	TPGT070104R-W08						●	●	
	TPGT070104L-W08						●	●	
	JS (G)		TPGT070101-JS	4.37	1.59	2.58	0.10	●	
	TPGT070102-JS		0.20				●		
	TPGT070104-JS		0.40				●		

● : Stocked items.



Right hand (R) shown

Steel shank

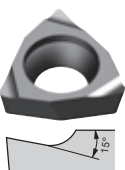
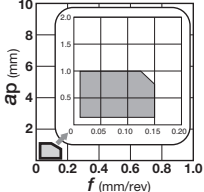
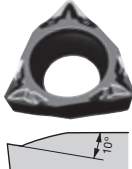
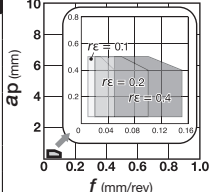
Cat. No.	Stock		Min bore dia. øDm	Dimensions (mm)							Std. corner radius rε	Applicable inserts	Parts		Torque (N·m)	
	R	L		øDs	f	L1	L2	h	f2	θ			α	Clamping screw		Wrench
A05F-SWUBR/L03-D060	●	●	6	5	3	80	9	4.8	-	0°	-13°	0.4	WB□□0301	CSTB-2	T-6F	0.6
A06G-SWUBR/L03-D070	●	●	7	6	3.5	90	11	5.75			-12°			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

Carbide shank

Cat. No.	Stock		Min bore dia. ϕD_m	Dimensions (mm)							Std. corner radius r_E	Applicable inserts	Parts		Torque (N·m)	
	R	L		ϕD_s	f	L_1	L_2	h	f_2	θ			α	Clamping screw		Wrench
E05G-SWUBR/L03-D060	●	●	6	5	3	90	10	4.8	-	0°	-13°	0.4	WB□□0301	CSTB-2	T-6F	0.6
E06H-SWUBR/L03-D070	●	●	7	6	3.5	100	12	5.75			-12°					
E07H-SWUBR/L03-D080	●	●	8	7	4	100	14	6.75			-11°					

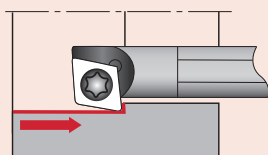
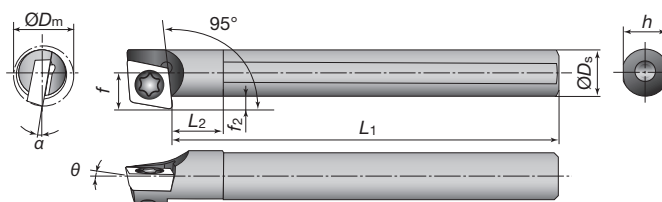
When using a right or left hand insert, the right hand insert (R) is used for the left hand toolholders (SWUBL □□ type), and the left hand insert (L) is used for the right hand toolholders (SWUBR □□ type).

Applicable inserts

Application	Chipbreaker	$f - a_p$	Insert Cat. No. (Metric)	Dimensions (mm)				Grades					
	Appearance (Cross section)			I.C. dia. ϕd	Thickness s	Hole dia. (ϕ) ϕd_1	Corner radius r_ϵ	Coated		Cermet	Carbide		
								SH730	GH110	NS530	TH10	UX30	
Finishing	W08 (G)			WBGT030100R-W08	3.97	1.59	2.3	0.03	●				
		WBGT030100L-W08	●						●	●			
		WBGT030101R-W08	0.10	●									
		WBGT030101L-W08		●					●				
		WBGT030102R-W08	0.20	●									
		WBGT030102L-W08		●				●	●	●			
		WBGT030104R-W08	0.40	●									
		WBGT030104L-W08		●				●	●	●			
	JS (G)			WBGT030101R-JS	3.97	1.59	2.3	0.10	●				
		WBGT030101L-JS	●										
		WBGT030102R-JS	0.20	●									
		WBGT030102L-JS		●									
		WBGT030104R-JS	0.40	●									
		WBGT030104L-JS		●									

● : Stocked items.

Internal retracting

Cutting edge style **Z**

Right hand (R) shown

Steel shank

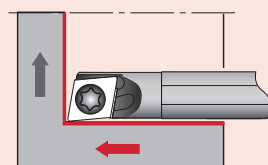
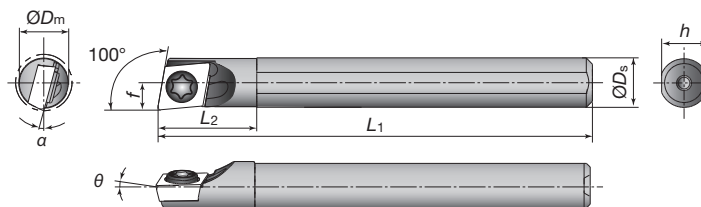
Cat. No.	Stock		Min bore dia. ØDm	Dimensions (mm)								Std. corner radius r _ε	Applicable inserts	Parts		Torque (N·m)
	R	L		ØDs	f	L ₁	L ₂	h	f ₂	θ	α			Clamping screw	Wrench	
A04F-SEZPR/L03-D055	●	●	5.5	4	3.2	80	4	3.8	1.2	0°	-8°	0.2	EP□□03X1 8-40	CSTA-1.6	T-6F	0.6
A05F-SEZPR/L03-D065	●	●	6.5	5	3.7	80	5	4.8			-6°					

Carbide shank

Cat. No.	Stock		Min bore dia. ØDm	Dimensions (mm)								Std. corner radius r _ε	Applicable inserts	Parts		Torque (N·m)
	R	L		ØDs	f	L ₁	L ₂	h	f ₂	θ	α			Clamping screw	Wrench	
E04G-SEZPR/L03-D055	●	●	5.5	4	3.2	90	5	3.8	1.2	0°	-8°	0.2	EP□□03X1 8-40	CSTA-1.6	T-6F	0.6
E05G-SEZPR/L03-D065	●	●	6.5	5	3.7	90	6	4.8			-6°					

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

Boring & internal facing

Cutting edge style **X**

Right hand (R) shown

Steel shank

Cat. No.	Stock		Min bore dia. ØDm	Dimensions (mm)								Std. corner radius r _ε	Applicable inserts	Parts		Torque (N·m)
	R	L		ØDs	f	L ₁	L ₂	h	f ₂	θ	α			Clamping screw	Wrench	
A04F-SEXPR/L03-D045	●	●	4.5	4	2.3	80	8	3.8	-	0°	-15°	0.2	EP□□03X1 8-40	CSTA-1.6	T-6F	0.6
A04F-SEXPR/L03-D050	●	●	5	4	2.5	80	8	3.8	-	0°	-13°					
A05F-SEXPR/L04-D055	●	●	5.5	5	2.75	80	9	4.8	-	0°	-12°	0.4	EP□□0401 8-40	CSTB-2	T-6F	0.6
A06G-SEXPR/L04-D070	●	●	7	6	3.6	90	11	5.75	-	0°	-12°					

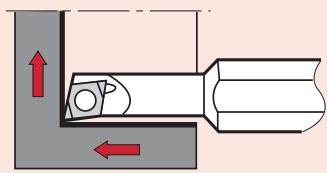
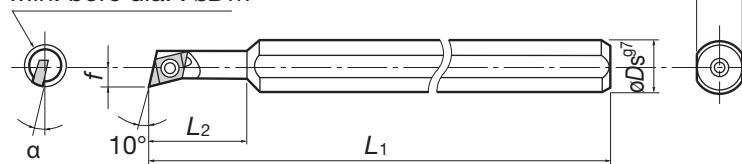
Carbide shank

Cat. No.	Stock		Min bore dia. ØDm	Dimensions (mm)								Std. corner radius r _ε	Applicable inserts	Parts		Torque (N·m)
	R	L		ØDs	f	L ₁	L ₂	h	f ₂	θ	α			Clamping screw	Wrench	
E04G-SEXPR/L03-D045	●	●	4.5	4	2.3	90	9	3.8	-	0°	-15°	0.2	EP□□03X1 8-40	CSTA-1.6	T-6F	0.6
E04G-SEXPR/L03-D050	●	●	5	4	2.5	90	9	3.8	-	0°	-13°					
E05G-SEXPR/L04-D055	●	●	5.5	5	2.75	90	10	4.8	-	0°	-12°	0.4	EP□□0401 8-40	CSTB-2	T-6F	0.6
E06H-SEXPR/L04-D070	●	●	7	6	3.6	100	12	5.75	-	0°	-12°					

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

● : Stocked items.

Boring / Internal facing

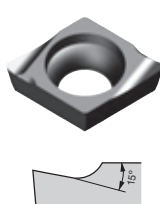
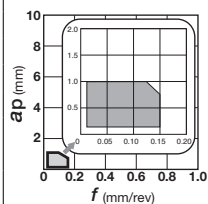
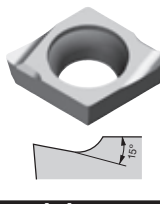
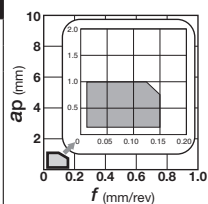
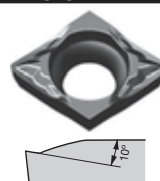
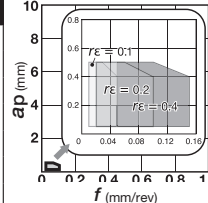
Cutting edge style **X**Min. bore dia. : ϕD_m 

Right hand (R) shown.

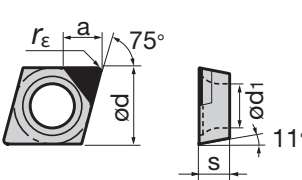
Cat. No.	Stock		Min. bore dia. øD _m (mm)	Dimensions (mm)								Std. Corner r _ε	Applicable insert	Clamping screw	Wrench
	R	L		øD _s	f	L ₁	L ₂	h	b	α	a				
JS08H-SEXPR/L045	●		5.5	8	2.7	100	16	7	-	12°	-	0.4	EP□□0401□□	CSTB-2	T-6F
JS08H-SEXPR/L047	●		7		3.6		20								

● : Stocked items.

Applicable inserts

Application	Chipbreaker	$f - a_p$	Insert Cat. No. (Metric)	Dimensions (mm)				Grades									
	Appearance (Cross section)			I.C. dia. ϕd	Thickness s	Hole dia. (ϕ) ϕd_1	Corner radius r_E	Coated		Cermet		Carbide					
								SH730	J740	GH110	NS530	GT530	TH10	UX30			
Finishing	W08 (G)	 		EPGT03X100R-W08	3.57	1.39	1.9	0.03	●						●		
	EPGT03X100L-W08		●									●					
	EPGT03X101R-W08													●			
	EPGT03X101L-W08													●			
	EPGT03X102R-W08													●			
	EPGT03X102L-W08													●			
	EPGT03X104R-W08													●			
	EPGT03X104L-W08													●			
	EPGT040100R-W08	3.97	1.59	2.3	0.03	●		●	●				●				
	EPGT040100L-W08					●						●					
	EPGT040101R-W08					●						●					
	EPGT040101L-W08					●						●					
	EPGT040102R-W08					●		●	●			●					
	EPGT040102L-W08					●		●	●	●		●	●				
	EPGT040104R-W08					●		●	●			●					
	EPGT040104L-W08					●		●	●	●		●	●				
	J08 (G)	 		EPGT040100L-J08	3.97	1.59	2.3	0.03	●	●							
	EPGT040102L-J08	0.20	●	●													
	EPGT040104L-J08	0.40	●	●													
	JS (G)	 		EPGT03X101-JS	3.57	1.39	1.9	0.10	●								
	EPGT03X102-JS	0.20	●														
	EPGT03X104-JS	0.40	●														
	EPGT040101-JS	3.97	1.59	2.3	0.10	●											
	EPGT040102-JS				0.20	●											
	EPGT040104-JS				0.40	●											

Applicable T-CBN & T-DIA inserts

	Cat. No.	Dimensions (mm)					Stock	
		Inner circle ϕd	Thickness s	Hole ϕd_1	Corner radius r_E	Length of T-CBN, T-DIA edge a	T-CBN & T-DIA	
							BX310	DX140
	1QP-EPGW03X102	3.57	1.39	1.9	0.2	1.4	●	
	1QP-EPGW03X104				0.4	1.3	●	
	1QP-EPGW040102	3.970	1.59	2.3	0.2	1.7	●	
	1QP-EPGW040104				0.4	1.6	●	
	EPGW040102-DIA	3.970	1.59	2.3	0.2	2.0		●
	EPGW040104-DIA				0.4	1.9		●

"DX140" : Packing quantity = 1 pcs.

● : Stocked items.

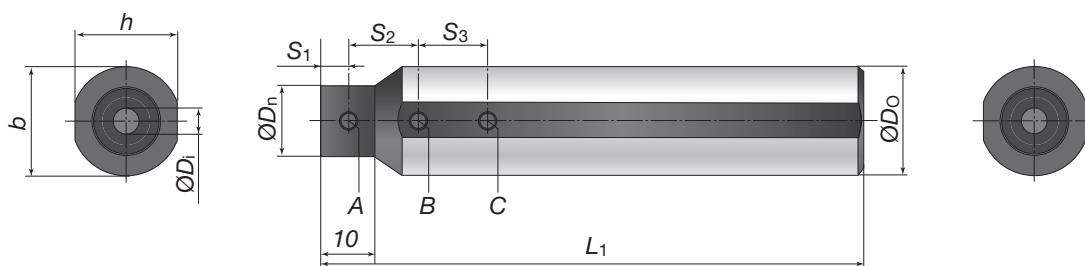
Standard cutting conditions (Internal turning)

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

Sleeves

BLM type

(Round shank for
Stream Jet Bar
MINI)

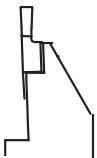
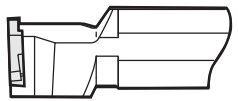


Cat. No.	Stock										Replacement parts					
		øDo	øDi	øDn	L1	h	b	S1	S2	S3	Clamping screws			Wrench	Seal cap* (Inner screw)	
											A	B	C			
BLM159-04	●	15.875	4	15	100	15	15.875	5	15	15	SSHM4-4	SSHM4-4	SSHM4-4	P-2	CA-16 (M6)	
BLM159-05	●		5													
BLM159-06	●		6													
BLM159-07	●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

*Seal cap (optional) ● : Stocked items.

Types and application of TAC Grooving and Parting Tools

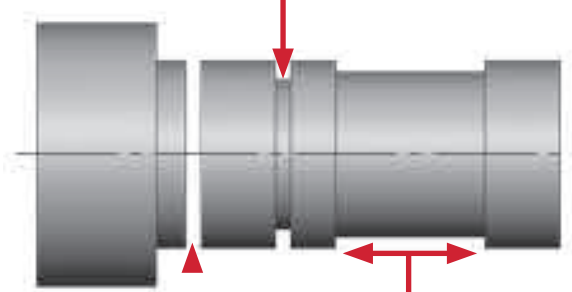
● For grooving

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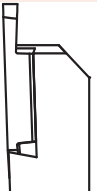
● For grooving, parting off and traversing

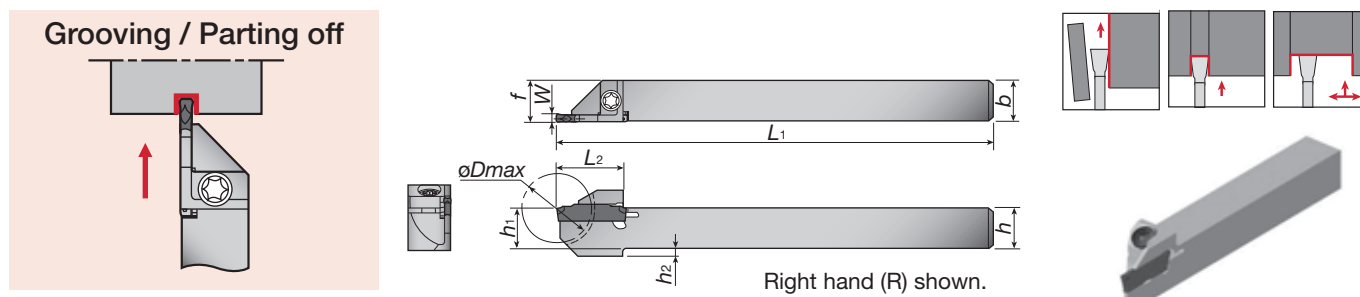
JCTER/L (P. 8-43) New Shank size 10 ~ 20 mm Groove width: 1.0 ~ 3.0 mm Max. parting dia. : ø32 mm 
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TUNGCUT



● For grooving and parting off

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



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

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

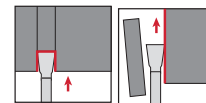
Insert application

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

Applicable inserts

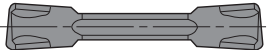
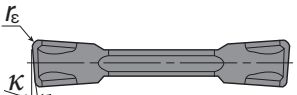
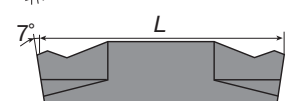
Notation of "insert seat size"

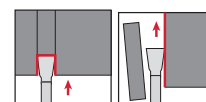
Seat size and grooving width are different. Seat size measure is for the specification of the setting insert. Please note this point.



DGM

External grooving and parting off, 2 corners

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

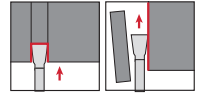


SGM

External deep grooving and parting off, 1 corner

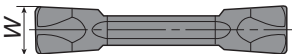
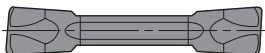
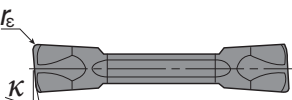
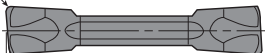
Neutral		Insert seat size	Cat. No.	Grades				Dimensions (mm)				
	Coated											
	AH725			GH130								
Left hand		2	SGM 2-020	●		●		2	0.2	20	5	-
			SGM 2-020-6R/L	●	●	●	●	2	0.2	20	5	6°
Right hand		3	SGM 3-020	●		●		3	0.2	20	5	-
			SGM 3-020-6R/L	●	●	●	●	3	0.2	20	5	6°
			SGM 3-020-15R/L	●	●	●	●	3	0.2	20	5	15°

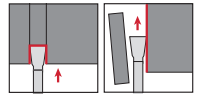
● : Stocked items.



DGS

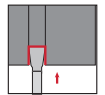
External grooving and parting off, 2 corners

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



SGS

External deep grooving and parting off, 1 corner

[illegible]

DGE

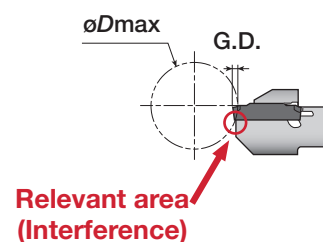
External grooving (Ground)

	Insert seat size	Cat. No.	Grades		Dimensions (mm)				
			Coated						
			AH725	AH130	$W \pm 0.02$	$r_E \pm 0.05$	L_1	L	h
2		DGE100-000	●	●	1	0	2.5	20	5
		DGE130-000	●	●	1.3	0	2.5	20	5
		DGE160-010	●	●	1.6	0.1	2.5	20	5
		DGE185-010	●	●	1.85	0.1	3.5	20	5
		DGE215-015	●	●	2.15	0.15	3.5	20	5

- **Caution**

ϕD_{max} is limited as shown in picture in right according to groove depth, G.D. Please refer to the following table. G.D. = Groove depth

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

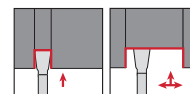


● : Stocked items.

Applicable inserts

● Notation of “insert seat size”

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



DTE External face grooving and traversing (Ground)

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

External face grooving and traversing (Molded)

	Insert seat size	Cat. No.	Grades			Dimensions (mm)			
			Coated			$W \pm 0.05$	r_{ϵ}	L	h
			AH725	GH130	NS530				
3		DTE3-040	●	●	★	3	0.4	20	5

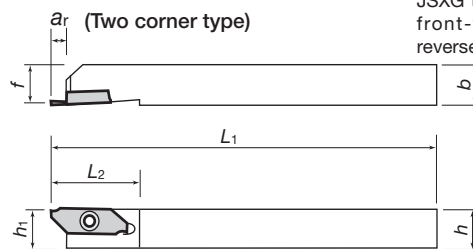
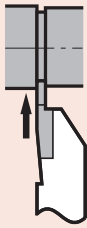
● : Stocked items
 ★ : Available from 2013

 Standard cutting conditions

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

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

Grooving / Parting off



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

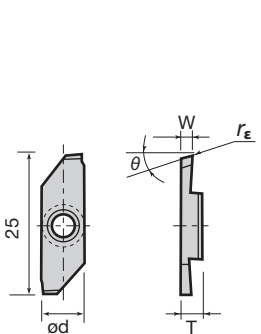
C-type

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

Right hand (R) shown.

Cat. No.	Stock		Applicable inserts	Dimensions (mm)							Clamping screw	Wrench	
	R	L		<i>h</i>	<i>b</i>	<i>L</i> ₁	<i>L</i> ₂	<i>a</i> _{<i>r</i>}	<i>h</i> ₁	<i>f</i>			
JSXGR/L1010K8-C	●	●	JXGR/L8□□□	10	10	125	29	6.7	10	10			
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

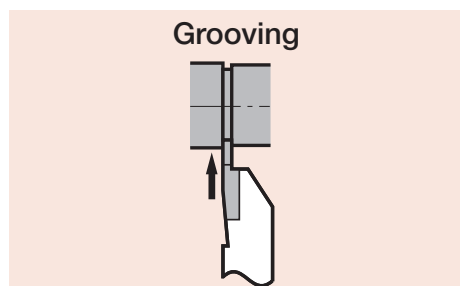
Applicable inserts JXG-type inserts (With sharp edges and cutting direction)

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

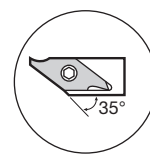
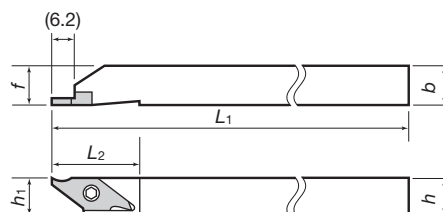
Right hand (R) shown.

Right hand (R) shown.

● : Stocked items.



(Two corner type)



C-type

Right hand (R) shown.

Cat. No.	Stock		Applicable inserts	Dimensions (mm)						Clamping screw	Wrench	
	R	L		h	b	L ₁	L ₂	h ₁	f			
JSVGR/L1010K-C	●	●	JVGR/L□□□(F)	10	10	125	23	10	10	CSTB-3S	T-9F	(T-9L) *Optional
JSVGR/L1212K-C	●	●		12	12			12	12			
JSVGR/L1616K	●	●		16	16			16	16			

■ Applicable inserts JVGR-type inserts (sharp edges)

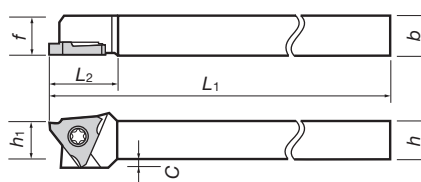
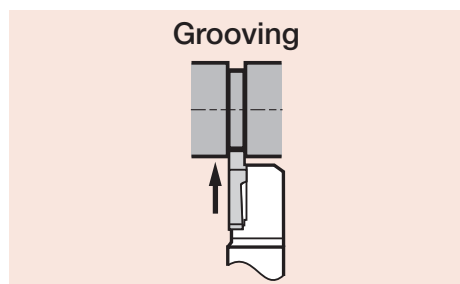
Cat. No.	Dimensions (mm)							Grades						
	ød	T	W ^{+0.05 0}	G	Max. groove depth	r _ε		Coated		Cermet				Uncoated
								J740	NS530	TH10				
								R	L	R	L	R	L	R
JVGR/L033F	7.94	3.18	0.33	0.8	0.7	0		●		●				●
JVGR/L050F			0.5	1.2	1.1			●		●				●
JVGR/L075F			0.75	2	1.9			●		●				●
JVGR/L095F			0.95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

Right hand (R) shown.

● : Stocked items.

JSTGR/L

Without offset
Screw-on system



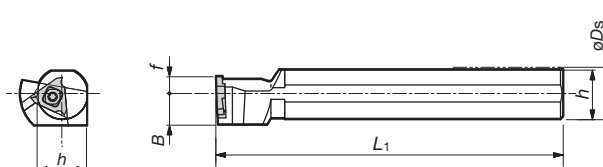
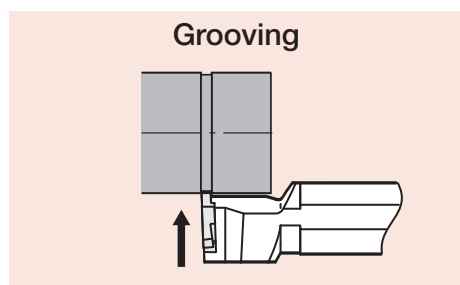
Can be wrenched from back side with double-socket Torx screw.

Right hand (R) shown.

Cat. No.	Stock		Applicable inserts	Dimensions (mm)							Clamping screw	Wrench	
	R	L		h	b	L ₁	L ₂	h ₁	f	C			
JSTGR/L1010K3	●	●	JTGR/L3□□□(F) ▶ 8-51	10	10	125	18.5	10	10	2	CSTB-4SD	T-8F	(T-8L) *Optional
JSTGR/L1212K3	●	●		12	12			12	12	-			
JSTGR/L1616K3	●	●		16	16			16	16	-			

JS-TGL3

Screw-on system



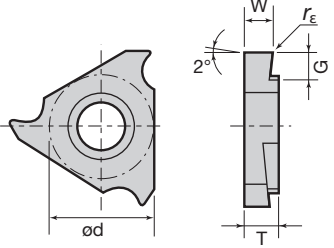
Left hand (L) shown.

Cat. No.	Stock		Applicable inserts	Dimensions (mm)						Clamping screw	Wrench
	R	L		øDs	f	L ₁	L ₂	h	B		
JS19K-TGL3		●	JTGR3□□□(F) ▶ 8-51	19.05	6	125	-	18	11.5	CSTB-4S	T-15F
JS20K-TGL3		●		20				19			
JS22K-TGL3		●		22				21			
JS25K-TGL3		●		25.4	10			24	12.7		

● : Stocked items.

Applicable inserts

JTG-type inserts (With sharp edges)

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

JTG-type inserts (With honed edges)

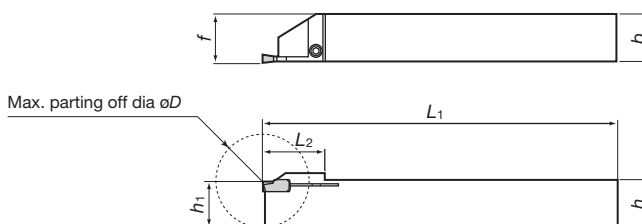
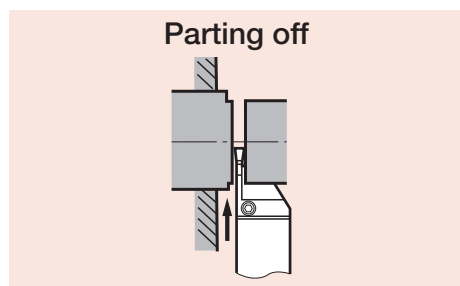
Right hand (R) shown.

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

Standard cutting conditions

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

● : Stocked items.



Right hand (R) shown.

Groove width (mm)	Cat. No.	Stock		Applicable inserts	Max. parting off dia ϕD (mm)	Dimensions (mm)						Clamping screw	Wrench
		R	L			b	h	h ₁	L ₁	f	L ₂		
2	JCGSSR/L1010-20	●	●	GE20 GE20-AL	20	10	10	10	125	10.2	15	CSTB-3	T-9F
	JCGSSR/L1212-20	●	●		25	12	12	12		12.2	19		
	JCGSSR/L1616-20	●	●		32	16	16	16		16.2	22.5		

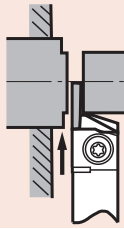
Applicable inserts

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

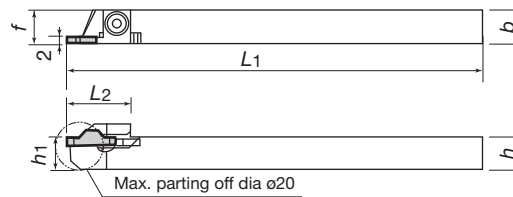
For aluminium and non-ferrous metals

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

Parting off



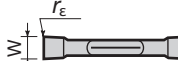
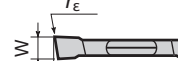
(Two corner type)



Right hand (R) shown.

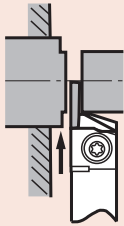
Cat. No.	Stock		Applicable inserts	Dimensions (mm)							Clamping screw	Wrench	
	R	L		h	b	L ₁	L ₂	h ₁	f	Max. parting off dia			
JCCWSR/L1010K2	●	●	JCC□200F	10	10	125	19	10	10	ø20	CSTB-4S	T-15F	(T-15L) * Optional
JCCWSR/L1212K2	●	●		12	12			12	12				
JCCWSR/L1616K2	●	●		16	16			16	16				
JCCWSR/L2020K2	●	●		20	20			20	20				
JCCWSR/L2525K2	●	●		25	25			25	25				

Applicable inserts JCC-type inserts (With sharp edges)

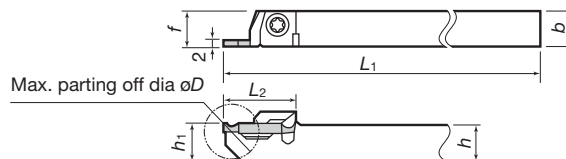
Neutral (JCCN200F)		Right or left hand (JCCR/L200F)	
			
			
Right hand (R) shown.			

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

Parting off



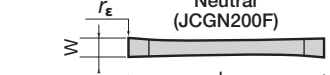
(Two corner type)



Right hand (R) shown.

Cat. No.	Stock		Applicable inserts	Dimensions (mm)							Clamping screw	Wrench	
	R	L		h	b	L ₁	L ₂	h ₁	f	Max. parting off dia			
JCGWSR/L1010K2	●	●	JCGN200□	10	10	125	20	10	10	ø20	CSTB-4S	T-15F	(T-15L) * Optional
JCGWSR/L1212K2	●	●		12	12			12	12				
JCGWSR/L1616K2	●	●		16	16			16	16				

Applicable inserts JCG-type inserts (With sharp edges)

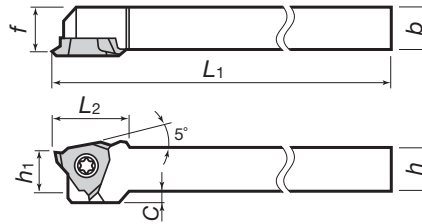
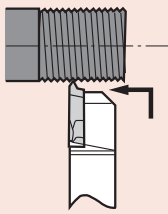
	Cat. No.	Dimensions (mm)				Grades											
		T	W	L	rε	Coated		Coated Cermet		Cermet				Uncoated			
						J740	J530	NS530		TH10		TH10					
	JCGN200F	3	2	20	0.05	●	●								●		
	JCGN200FR/L					●	●	●	●						●	●	
																	
Right or left hand (JCGN200FR/L)																	
Right hand (R) shown.																	

● : Stocked items.

JSTTR/L

Without offset
Screw-on system

External threading



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

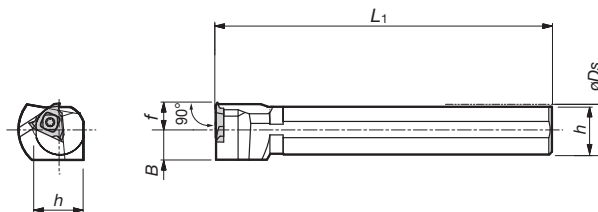
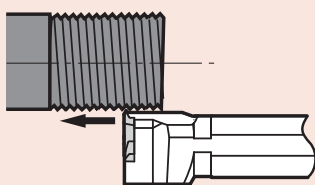
Right hand (R) shown.

Cat. No.	Stock		Dimensions (mm)							Applicable inserts	Clamping screw	Wrench	
	R	L	h	b	L ₁	L ₂	h ₁	f	C				
JSTTR/L1010K3	●		10	10	125	16.5	10	9.5	2	JTTR/L3□□□□	CSTB-4SD	T-8F	(T-8L) * Optional
JSTTR/L1212K3	●		12	12			12	11.5	-				
JSTTR/L1616K3	●		16	16			16	15.5	-				

JS-TTL3

Screw-on system

External threading



Left hand (L) shown.

Cat. No.	Stock		Dimensions (mm)						Applicable inserts	Clamping screw	Wrench
	R	L	øD _S	f	L ₁	L ₂	h	B			
JS19K-TTL3		●	19.05	10	125	-	18	11.5	JTTR30□□F	CSTB-4S	T-15F
JS20K-TTL3		●	20				19				
JS22K-TTL3		●	22				21				
JS25K-TTL3		●	25.4				24				

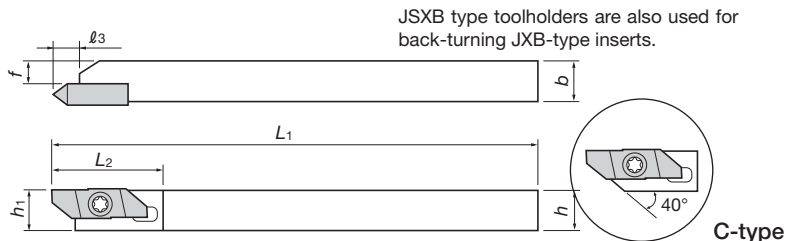
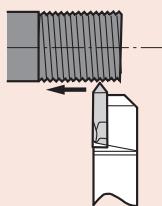
JTT-type inserts (sharp edge)

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

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

● : Stocked items.

External threading



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

C-type

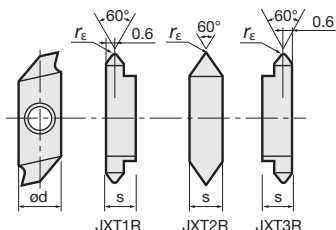
- Can be wrenched from back side with both-end Torx screw.
- This toolholder is also compatible with JSXB-type insert for back turning.

Right hand (R) shown

Cat. No.	Stock		Dimensions (mm)							Applicable inserts	Clamping screw	Wrench	
	R	L	h	b	L ₁	L ₂	ℓ ₃	h ₁	f				
JSXBR/L1010K8-C	●	●	10	10	125	29	6.4	10	5.7	JXT□R/L□□□□□	CSTB-4SD	T-8F	(T-8L)
JSXBR/L1212K8-C	●	●	12	12				12	7.7				
JSXBR/L1616K8	●	●	16	16				16	11.7				
JSXBR/L2020K8	●	●	20	20				20	15.7				
JSXBR/L2525K8	●	●	25	25				25	20.7				
										* Optional			

JXT-type inserts (sharp edge)

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



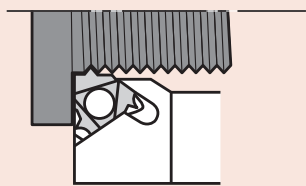
Right hand (R) shown.

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

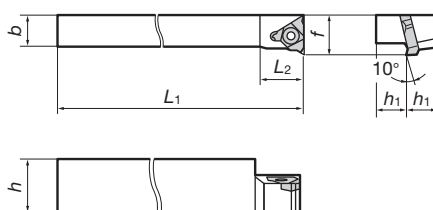
● : Stocked items.

B-SER/L, B-CER/L **TUNGTHREAD** Screw-on system, clamp-on system

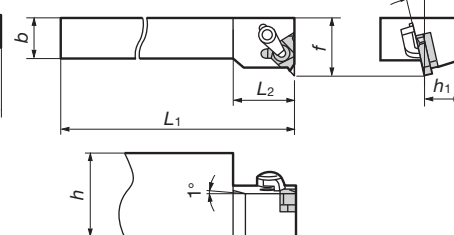
External threading



B-SER/L(Screw-on type)



B-CER/L(Clamp-on type)



Right hand (R) shown

B-type Toolholders (For gang tooling)

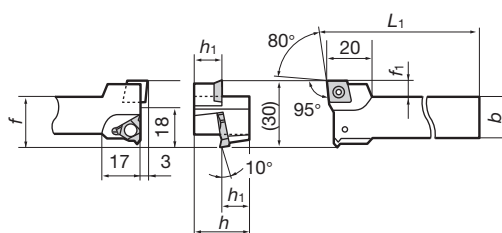
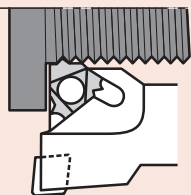
Cat. No.	Stock		Dimensions (mm)							Applicable inserts	Clamp set	Shim set		Clamping screw	Wrench
	R	L	h	b	L ₁	L ₂	h ₁	f	f ₁			R	L		
B-SER/L10H16	●		20	10	100	15	10	16	-	16ER/L□□□□ ➤ 7-7~	-	-	-	CSTB-3.5	T-15F
B-SER/L12K16	●		24	12	125	18	12	18	-		-	-	-		
B-CER/L16M16	●	●	32	16	150	24	16	22	-		CSP16	A16-1		-	

TAC Toolholders for External threading

BC-SER/L **TUNGTHREAD**

Screw-on system

External threading

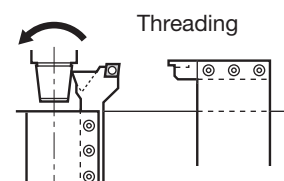
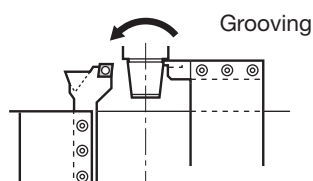
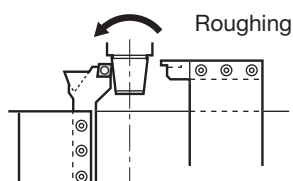


Right hand (R) shown

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

Cat. No.	Stock		Dimensions (mm)							Applicable inserts	Clamp set	Shim set		Clamping screw	Wrench
	R	L	h	b	L ₁	L ₂	h ₁	f	f ₁			R	L		
BC-SER/L12K16	●		24	16	125	-	12	23	7	16ER/L□□□□ ➤ 7-7~ CC□T09T3□□ ➤ 2-96~ (Used for before threading)	-	-	-	CSTB-3.5	T-15F
BC-SER/L16M16			32	20	150	-	16	25	5						

● Tooling examples using BC-type toolholders



● : Stocked items.

