External Toolholder

External Toolholder - Content structure

- Indexable toolholders are listed by cutting edge shape.
- In the same cutting edge shape, the inserts are sorted alphabetically.
  The order of the list: CN** insert → DN** insert → RN** insert → SN** insert → TN** insert → VN** insert → WN** insert
- Toolholders in the catalog are our standard stock items.

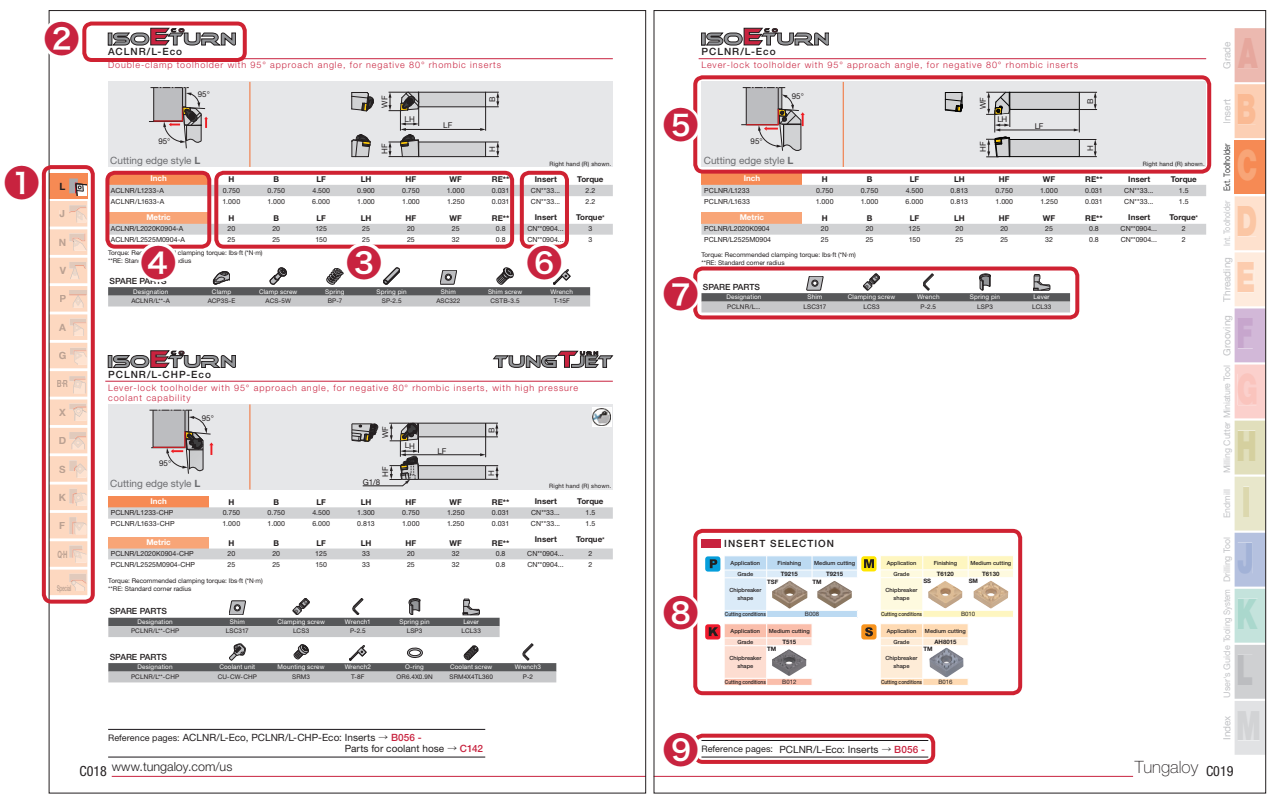
How to use the page

Method① Select the cutting edge shape described at the left end of each page, jump to the page on the left index, and choose a designation you need (❹) in the dimension table (❸). Applicable inserts are shown in (❻) and (❽).

Method② Select the cutting edge on **C003** and check the details on the product page.

Method③ Select the series name of a toolholder on **C003** and check the details on each page.

Method④ Select an item from Quick Guide on **C008-C015**.



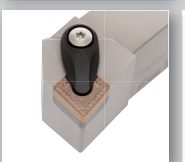
❶: Cutting edge shape
❷: Series name of indexable external toolholders
❸: Dimension table
❹: Toolholder designation
e.g. right-hand, 1 inch square shank

→ **ACLNR 16 33-A**

❺: Dimension drawing (conforming to ISO13399)
❻: Applicable insert
❼: Spare parts
❽: Basic selection
❾: Reference pages

When ordering
- Please specify the designation and quantity.
  e.g. **ACLNR164-A ...** 1 (one external toolholder per package)
  * Inserts are not included. Please order those separately.

Main products

		Inch	Metric
	**TURNTEEN FEED** Innovative tool realizing both high productivity and economy C016, C102	✓	✓
	**ISOECOTURN** Small-sized “Eco” insert series for maximized profits C017	✓	✓
	**MINIFORCE TURN** Economical double-sided inserts with excellent sharpness C033 - C036, C042 - C045, C059 - C061, C137 - C138	✓	✓
	**TURNINGA** Highly rigid clamping system with excellent repeatability C008	✓	✓
	**TUNGTURN JET** Toolholders for high pressure coolant supply C018, C021, C023, C031, C038, C040, C046, C048, C050, C058, C063 - C064, C067, C092, C133, C140 - C141	✓	✓
	**DIMPLEFX** Ceramic insert with dimple for highly efficient cast iron machining C010	✓	✓
	**TURNTEC** Inserts and toolholders for roughing large depths of cut with high productivity C082, C097, C120	✓	
	**Y-PRO SERIES** Inserts with 25° corner angle for profiling C069, C136, C139	✓	✓
	**TURNFEED** Tool series for super high-feed cutting C104	✓	
	**FIXRTURN** Highly productive round insert with 6 indexes C089, C107	✓	✓

Designation system for Toolholders

A,C	Clamp-on
D	Double clamp ("One Double")
E	Eccentric pin lock
M	Multi-clamp
P	Pin-lock
S	Screw-on
T	Taper-lock
W	Wedge-on

1 Clamping system

Symbol	Shape	Offset
A	90°	Without
B	75°	Without
C	90°	Without
D	45°	Without
E	60°	Without
F	91°	Without
G	91°	With
	91°	With
J	93°	With
K	75°	With
L	95° 95°	With
N	63°	Without
P	62.5°	Without
Q	45°	With
R	75°	Without
S	45°	With
V	72.5°	Without
X*	100°	With
Y	80°	With

*mark: Tungaloy's symbol

3 Cutting edge style

(Example)

1	2	3	4
A	C	L	N

2 Insert shape

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

4 Relief angle of insert

C	0°
B	5°
C	7°
D	15°
E	20°
P	11°

ANSI Designation

10	0.625	0.625	4.500
12	0.750	0.750	4.500
64	0.750	1.000	8.000
66	0.750	1.250	8.000
16	1.000	1.000	6.000
85	1.000	1.250	6.000
86	1.000	1.500	7.000
20	1.250	1.250	7.000
24	1.500	1.500	7.000
32	2.000	2.000	14.000
No.	**Width**	**Height**	**Length**

⑦ Toolholder shank size (in)

S = Single wall pocket construction. full pocket construction when letter position is Vacant

⑥ Pocket style

⑤	⑥	⑦		⑧
R	S	16	-	4

⑤ Hand of tool

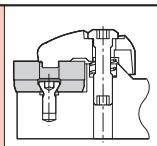
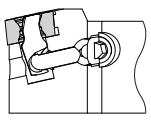
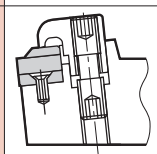
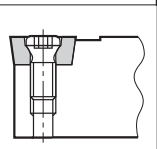
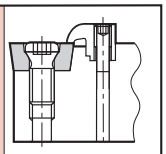
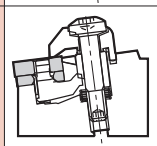
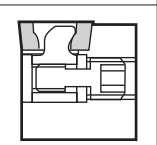
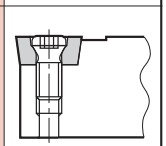
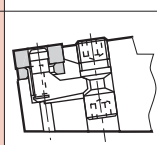
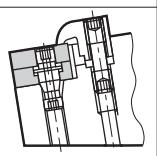
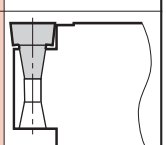
L	
N	
R	

⑨ Insert size I.C.

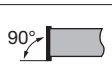
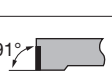
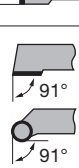
Symbol	Inscribed circle (in)
3	0.375
4	0.500
5	0.625
6	0.750

Designation system for Toolholders

① Clamping system

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

③ Cutting edge style

Symbol	Shape	Offset	Symbol	Shape	Offset	Symbol	Shape	Offset
A	 90°	Without	H	 100°	With	P *	 117.5°	Without
			I	 76.5°	Without	Q *	 45°	With
			J	 93°	With	S	 45°	With
B	 75°	Without	J2 *	 93°	Without	V	 72.5°	Without
C	 90°	Without	K	 75°	With	U	 93°	With
D	 45°	Without	L	 95° 95°	With	X	 100°	With
E	 60°	Without	L2 *	 95° 95°	Without	Y	 80°	With
F	 91°	With	N	 63°	Without	Z	 93°	Without
G	 91° 91°	With	N3 *	 63°	With	No mark: ISO symbol *mark: Tungaloy's symbol		
			P *	 62.5°	Without			

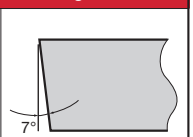
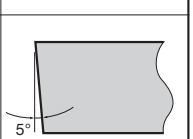
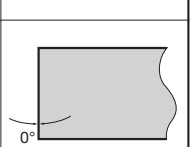
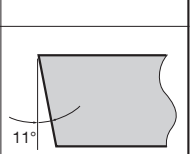
(Example)

①	②	③	④	⑤
A	W	L	N	R
P	T	G	N	R

② Insert shape

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

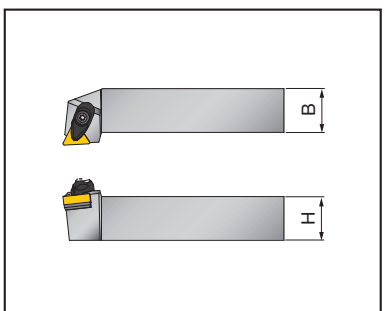
④ Relief angle of insert

C	 7°
B	 5°
N	 0°
P	 11°

⑤ Hand of tool

L	
N	
R	

ISO Designation

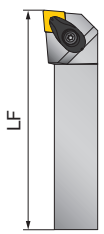


⑥ Height: H (mm) | ⑦ Width: B (mm)

Shank size

F	80
F	85*
H	100
X	120
K	125
M	150
P	170
Q	180
R	200
S	250
T	300
U	350

*MiniForceTurn



⑧ Holder length

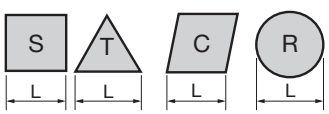
RD	Ceramic insert with dimple
C	M-type for ceramic insert
A	Turning A

⑪ Added symbol

⑥	⑦	⑧			⑪
25	25	M	08	-	A
20	20	K	3		3
			⑨		⑩

⑨ Insert size

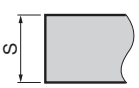
Symbol	Inscribed circle (mm)
3	9.525
4	12.7
5	15.875
6	19.05
8	25.4



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

⑩ Insert thickness

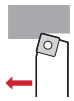
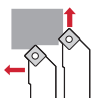
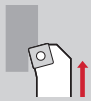
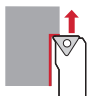
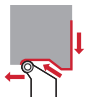
Symbol	Thickness (mm)
2	3.18
3	4.76



External Toolholder - Quick Guide (Negative type)

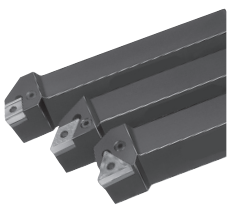
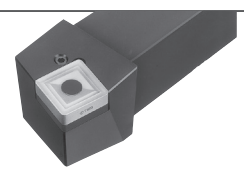
Name	Appearance/Feature	Turning / Facing	External profiling				Turning
		L 95°	J 93°	N 63°	V 72.5°	P 62.5°	G 91°
TURNTEEN FEED Double clamp	 • Economical, 10-cornered insert ensures high machining efficiency • Available in 2 types of holders: HD type for large depths of cut and HF type for high feed turning • Maximum 0.276" (7 mm) depth of cut, or maximum feed 0.079 ipr (2 mm) per rev is attainable!						
TURNINGA Double clamp	 • Improved clamping rigidity realizes excellent repeatability and long tool life. • The enlarged surface of insert pressing provides excellent repeatability. Great performance even with VNMG type (corner angle 35°), which is particularly prone to the displacement of the cutting edge position. *Corner angle 25° and YNMG type also can be used. • The simple structure contributes to cost reduction. Easy operation with one wrench.	80° CN□□ ACLNR/L C018, C020 70° GN□□ ACLNR/L C020 80° WN□□ AWLNR/L C031, C037	55° DN□□ ADJNR/L C040, C046 60° TN□□ ATJNR/L C055 35° VN□□ AVJNR/L C057, C062 25° YNMG AVJNR/L C062		35° VN□□ AVVNN C072, C073 25° YNMG AVVNN C073	55° DN□□ ADPNN C076	60° TN□□ ATGNR/L C091
D One-Double	 • Excellent usability that the clamp and the lever simultaneously hold the insert in tightening. • The tool can be handled from the back side and provides excellent usability even when the tool is placed in the reverse.	80° CN□□ DCLNR/L C025 70° GN□□ DCLNR/L C025 80° WN□□ DWLNR/L C039	55° DN□□ DDJNR/L C049				60° TN□□ DTGNR/L C094

Please see the page C*** for the product details.

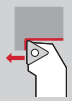
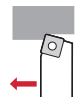
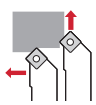
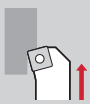
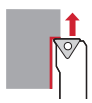
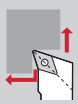
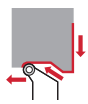
Turning	Turning / Chamfering	External profiling		Turning / Facing Chamfering	Facing		Profiling	External profiling
B·R 75° 	**D 45°** 	**X 22.5°** 	**X 48.5°** 	**S 45°** 	**K 75°** 	**F 91°** 	**Q*1 · H*1 45°** 	**Special** 
		22.5° POMG PPXOR/L-HF **C102**	**48.5°** POMG PPXOR/L-HD **C102**					
90° SN□□ ASBNR/L **C098**	**90°** SN□□ ASDNN **C108**			**90°** SN□□ ASSNR/L **C112**	**90°** SN□□ ASKNR/L **C115**	**60°** TN□□ ATFNR/L **C122**	**55°** DN□□ ADQNR/L **C125, C126** **60°** TN□□ ATQNR/L **C130** **35°** VN□□ AVQNR/L **C131, C132** **25°** YNMG AVQNR/L **C132**	- RN□□ ARGNR/L **C084**
90° SN□□ DSBNR/L **C099**	**90°** SN□□ DSDNN **C109**			**90°** SN□□ DSSNR/L **C115**	**90°** SN□□ DSKNR/L **C118**	**60°** TN□□ DTFNR/L **C124**	**55°** DN□□ DDQNR/L **C128**	- RN□□ DRGNR/L **C086**

*1: Symbol used exclusively by Tungaloy

External Toolholder - Quick Guide (Negative type)

Name	Appearance/Feature	Turning / Facing	External profiling			Turning
		L 95°	J 93°	V 72.5°	P 62.5°	A 91°
DIMPLEFX C Double clamp for dimple ceramic insert	 • Firmly clamp the insert at two locations: drawing by dimple and holding from the top. • Two locations can be clamped simultaneously with one screw. Excellent operability. • The tool can be handled from the back side. Easy to change inserts when mounting those on the back.	80° CN□□ CCLNR/L C024		55° DNGD CDNNN C070	35° VNGD CVVNN C074	
P Lever lock	 • Great repeatability of the cutting edge position with the two-face holding system. Excellent performance on NC lathes and special-purpose machines. • There are many types of geometries available such as rhombus, triangle, square and round. • Economical downsized type is also available.	80° CN□□ PCLNR/L C018, C019, C021, C022, C023, G057 80° CN□□ PCL2NR G057 70° GN□□ PCLNR/L C021, C022, C023, G057 70° GN□□ PCL2NR G057 80° CN□□ PCMNN C140 80° WN□□ PWLNR/L C031, C032, C038 70° GN□□ PCMNN C140 60° TN□□ PTL2NR/L C029	55° DN□□ PDJNR/L C040, C041, C046, C047, C048 60° TN□□ PTJNR/L C054 35° VN□□ PVJNR/L C058, C063, C064 25° YNMG PVJNR/L C063, C064	35° VN□□ PVVNN C072	55° DN□□ PDPNN C077 55° DN□□ PDMNL C141	
H Retract pin	 • Toolholder for super heavy cutting					
JT Back clamp	 • Tool holder with access on both sides to allow for insert changes in set ups with limited clearances such as gang tooling. • Inserts can be clamped with screws from the back side of the tool, providing good usability. • Shank sizes are available in 8, 10, 12, 16 mm.	60° TN□□ JTTLNR/L C030				60° TN□□ JTTANR/L C079

Please see the page C*** for the product details.

Turning		Turning / Chamfering	Turning / Facing Chamfering	Facing		Profiling	External profiling
G 91°	**B·R 75°**	**D 45°**	**S 45°**	**K 75°**	**F 91°**	**Q*1 · H*1 45°**	**Special**
							
			90° SNGD CSSNR/L **C114** 90° HNGD CHSNR/L **C111**				
60° TN□□ PTGNR/L **C090, C092, C093**	90° SN□□ PSBNR/L **C099** 100° CN□□ PCBNR/L **C096**	90° SN□□ PSDNN **C108**	90° SN□□ PSSNR/L **C113**	90° SN□□ PSKNR/L **C117**	60° TN□□ PTFNR/L **C121, C123** 80° CN□□ PCFNR/L **C119**	55° DN□□ PDQNR/L **C127** 35° VN□□ PVQNR/L **C131, C133** 25° YNMG PVQNR/L **C133**	- RNMG PRGNR/L **C085**
	90° SNMM HSRNR/L **C101**						

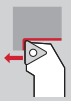
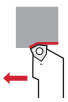
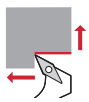
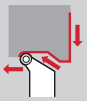
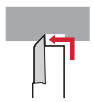
*1: Symbol used exclusively by Tungaloy

External Toolholder - Quick Guide (Positive type)

Name	Appearance/Feature	Turning / Facing	External profiling			Turning
		L 95°	J 93°	N 72.5°	N 62.5°	A 91°
X Double clamp (screw-on)	 • Super high feed machining increases productivity by 8 times. • The insert is secured by double clamping system with clamp + clamp screw. Both the insert and the tool body achieve high rigidity.					
P Lever lock	 • Clamping positive round insert with lever lock leads to good indexing accuracy. • Can be used for external turning, facing, and profiling. High-feed machining is possible. • Insert diameters: ø10, ø12, ø16, ø20, ø25 mm.	80° WXGU JPWL2XR/L C035	55° DXGU JPDJ2XR/L C044 35° VXGU JPVJ2XR/L C060			
J Screw-on	 • Suitable for machining complex small parts on small NC lathes. A great variety of cutting edge geometries. • The screw-on method firmly holds the small positive inserts. The clamp screw is a reliable and durable Torx® screw. • J type is high-precision shank with 4 faces ground.	80° CC□□ JSCLCR/L C026, G029 JSCL2CR/L*2 G027, G028 80° WXGU JSWLXR/L C034 JSWL2XR/L C034, C035, G023, G025 JSWLXR-F C036, G026 35° VP□□ JSVL2PR/L G030	55° DC□□ JSDJCR-F C052, G038 JSDJ2CR/L*2 C050, G036, G037 55° DXGU JSDJXR/L C042 JSDJ2XR/L C042, C043, G031, G033 JSDJXR-F C045, G034	35° VB□□ JSVJBR/L G046 JSVJ2BR/L C066, C067, G044, G045 35° VXGU JSVJXR/L C059 JSVJ2XR/L C059, C060, G040, G041 JSVJXR-F C061, G042	35° VB□□ JSVNBN G049	55° DC□□ JSDNCN G047 55° DC□□ JSDN3CR/L*3 G048	60° TC□□ JSTACR/L C080, G051 35° VB□□ JSVABR/L G052

*2: L2 and J2: without offset *3 

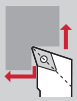
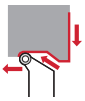
Please see the page C*** for the product details.

	Turning	Turning / Facing	Facing	Profiling	External profiling	Back turning	Front turning Reverse turning
	G 91° 	X 20° 	F 91° 	P 117.5° 	Special 		
		80° WPMT XWXPR/L C104					
					- RCM□ PRGCR/L C087 - RCM□ PRDCN C105		
	80° CC□□ JSCGCR/L G053		55° DC□□ JSDFCR/L G055	25° VP□□ JSVP2PR/L G050		JXB JSXBR/L G067 JTB JSTBR/L G061 JTB JS□□K-TBL G061 J10E JSEGR/L G064	JX□□ JSXGR/L G056 55° DC□□ JS□□K-SDUCL G039 55° DXGU JS□□□-SDUXL C137, G035 35° VXGU JS□□□-SVUXL C138, G042

External Toolholder - Quick Guide (Positive type)

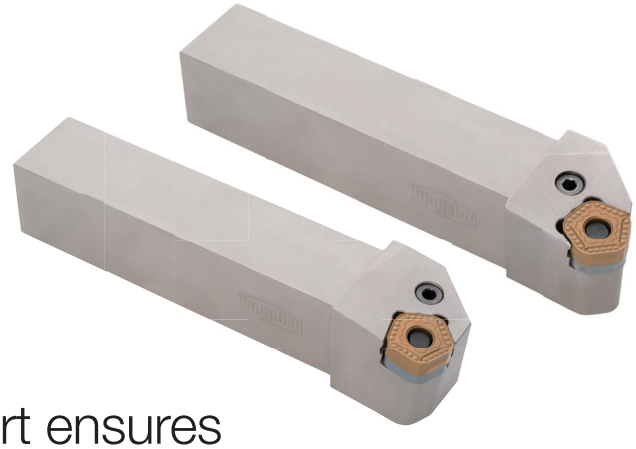
Name	Appearance/Feature	Turning / Facing	External profiling			Turning	Turning / Chamfering
		L 95°	J 93°	V 72.5°	N 62.5°	A 91°	D 45°
S Screw-on	 • Suitable for machining complex small parts on small NC lathes. A great variety of cutting edge geometries. • The screw-on method firmly holds the small positive inserts. The clamp screw is a reliable and durable Torx® screw.	80° CC□□ SCLCR/L C028	55° DC□□ SDJCR/L C053 35° VC□□ SVJCR/L C068 25° YWMT SYJBR/L C069	35° VC□□ SVVCN C075	55° DC□□ SDNCN C071	60° TC□□ STACR/L C081	90° SC□□ SSDCN C110 90° SP□□ SSDPN Tungaloy standard C110
JT Back clamp	 • Tool holder with access on both sides to allow for insert changes in set ups with limited clearances such as gang tooling. • Inserts can be clamped with screws from the back side of the tool, providing good usability. • Shank sizes are available in 0.315", 0.394", 0.472", 0.630" (8, 10, 12, 16 mm).	80° CC□□ JTCL2CR/L C027, G028	55° DC□□ JTDJ2CR/L C051, G036			60° TC□□ JTTACR/L C080, G051	

Please see the page C*** for the product details.

Profiling				External profiling	Back turning	Front turning Reverse turning
Q*1 45° · H*1 17.5°		H 100°	I 76.5°	Special		
						
35° VC□□ SVQCR/L **C134**	55° DC□□ SDQCR/L **C129**	25° YWMT SYHBR/L **C136**	25° YWMT SYIBN **C139**	- RCMT SRACR/L **C078**	Note: JSXBR/L can be used with JXT threading insert.	Note: JSXGR/L can be used with JXG grooving insert.
35° VCG□ SVHCR/L **C135**	25° YWMT SYQBR/L **C136**			- RCMT SRGCR/L **C088, C089**		
				- RCMT SRDCN **C106, C107**		

*1: Symbol used exclusively by Tungaloy

TURNTEN FEED

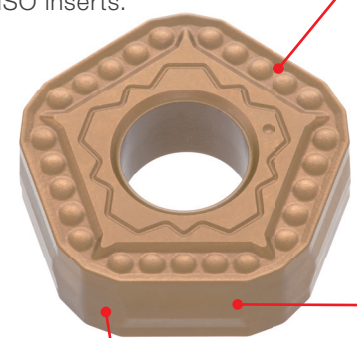


Economical, 10-cornered insert ensures high machining efficiency

- Available in 2 types of holders: HD type for large depths of cut and HF type for high feed turning
- Maximum 0.276" depth of cut, or maximum 0.079" feed per rev is attainable!

Economical 10-cornered, double-sided, M-class insert

Achieves outstanding cost efficiency over standard ISO inserts.

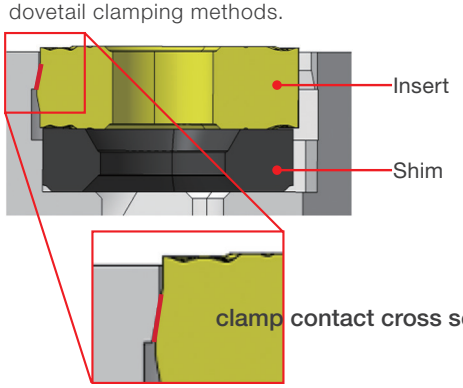


New – MNW style chipbreaker

Features protrusions on the rake face to facilitate smooth chip control, while achieving high crater wear resistance.

Dovetail clamping

Ensures secure insert retention while promoting smooth chip flow thanks to the integration of lever lock and dovetail clamping methods.



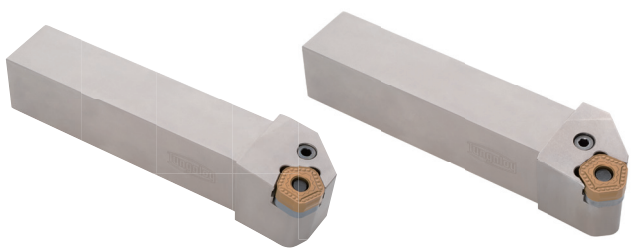
Flat Wiper

Built in the cutting edge to achieve superior machining surface at higher feed rates!

Holder selections

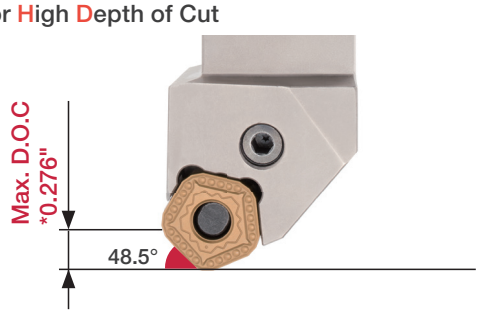
Available in 2 types:
- HD holder for large depths of cut
- HF holder for high feed turning

Inserts are interchangeable between these two holders.

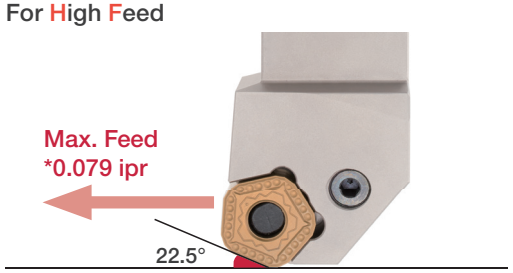


Features of Holders

HD holder
For High Depth of Cut



HF holder
For High Feed



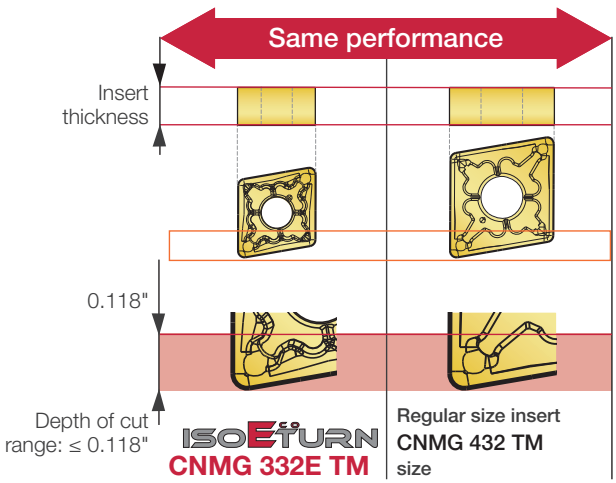
* Insert: POMG130612-MNW

Reference pages: C102

ISO-EcoTurn Small size inserts, for an economical advantage

Uncompromising insert performance

Comparison of ISO-EcoTurn and regular size inserts

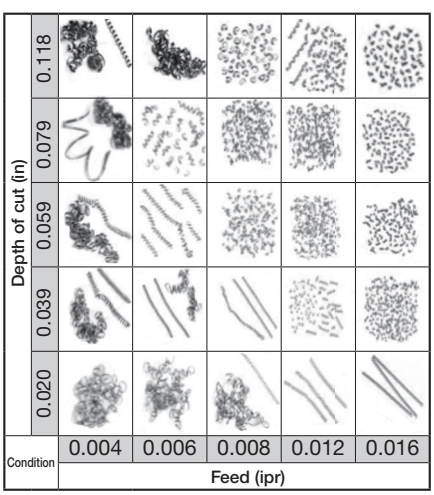


ISO-EcoTurn inserts feature the identical thickness and chipbreaker geometry as Tungaloy's regular size inserts.
These properties provide cutting performance equal to that of the regular size inserts, including chip control at a depth of cut up to 0.118".

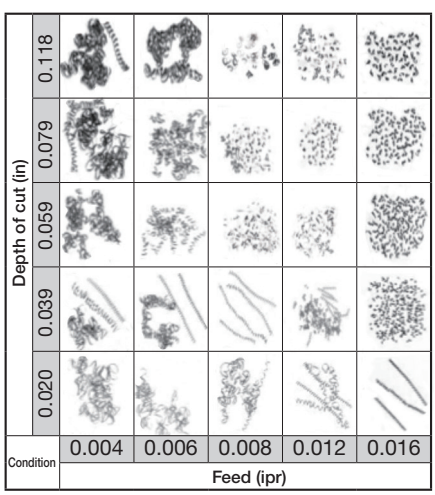
Chip control

ISO-EcoTurn inserts incorporate an identical chipbreaker geometry as regular size inserts providing the same chip removal at a depth of cut up to 0.118".

ISOEcoTurn
CNMG 332E TM



Regular size
CNMG 432 TM

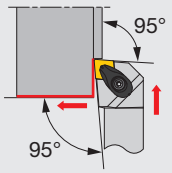


Workpiece : 1045
Cutting speed : *Vc* = 660 sfm
Coolant : Wet

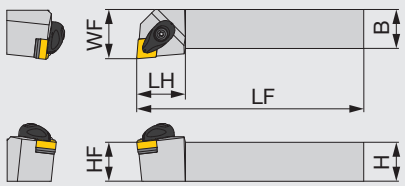
Reference pages: C018 -, C031 -, C040 -, C054, C057 -, C072, C090, C121, C125, C131

ACLNR/L-Eco

Double-clamp toolholder with 95° approach angle, for negative 80° rhombic inserts



Cutting edge style **L**



Right hand (R) shown.

Inch	H	B	LF	LH	HF	WF	RE**	Insert	Torque
ACLNR/L1233-A	0.750	0.750	4.500	0.900	0.750	1.000	0.031	CN**33...	2.2
ACLNR/L1633-A	1.000	1.000	6.000	1.000	1.000	1.250	0.031	CN**33...	2.2

Metric	H	B	LF	LH	HF	WF	RE**	Insert	Torque*
ACLNR/L2020K0904-A	20	20	125	25	20	25	0.8	CN**0904...	3
ACLNR/L2525M0904-A	25	25	150	25	25	32	0.8	CN**0904...	3

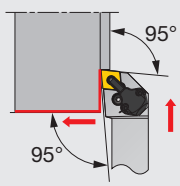
Torque: Recommended clamping torque: lbs·ft (*N·m)
**RE: Standard corner radius

SPARE PARTS

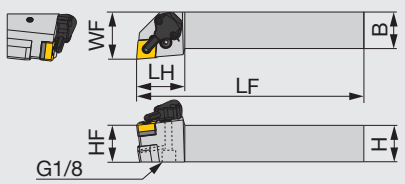
Designation	Clamp	Clamp screw	Spring	Spring pin	Shim	Shim screw	Wrench
ACLNR/L**-A	ACP3S-E	ACS-5W	BP-7	SP-2.5	ASC322	CSTB-3.5	T-15F

PCLNR/L-CHP-Eco

Lever-lock toolholder with 95° approach angle, for negative 80° rhombic inserts, with high pressure coolant capability



Cutting edge style **L**



Right hand (R) shown.

Inch	H	B	LF	LH	HF	WF	RE**	Insert	Torque
PCLNR/L1233-CHP	0.750	0.750	4.500	1.300	0.750	1.250	0.031	CN**33...	1.5
PCLNR/L1633-CHP	1.000	1.000	6.000	0.813	1.000	1.250	0.031	CN**33...	1.5

Metric	H	B	LF	LH	HF	WF	RE**	Insert	Torque*
PCLNR/L2020K0904-CHP	20	20	125	33	20	32	0.8	CN**0904...	2
PCLNR/L2525M0904-CHP	25	25	150	33	25	32	0.8	CN**0904...	2

Torque: Recommended clamping torque: lbs·ft (*N·m)
**RE: Standard corner radius

SPARE PARTS

Designation	Shim	Clamping screw	Wrench1	Spring pin	Lever
PCLNR/L**-CHP	LSC317	LCS3	P-2.5	LSP3	LCL33

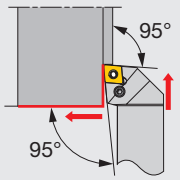
SPARE PARTS

Designation	Coolant unit	Mounting screw	Wrench2	O-ring	Coolant screw	Wrench3
PCLNR/L**-CHP	CU-CW-CHP	SRM3	T-8F	OR6.4X0.9N	SRM4X4TL360	P-2

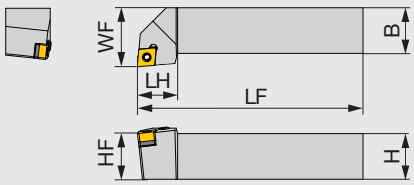
Reference pages: ACLNR/L-Eco, PCLNR/L-CHP-Eco: Inserts → B056 -
Parts for coolant hose → C142

PCLNR/L-Eco

Lever-lock toolholder with 95° approach angle, for negative 80° rhombic inserts



Cutting edge style **L**



Right hand (R) shown.

Inch	H	B	LF	LH	HF	WF	RE**	Insert	Torque
PCLNR/L1233	0.750	0.750	4.500	0.813	0.750	1.000	0.031	CN**33...	1.5
PCLNR/L1633	1.000	1.000	6.000	0.813	1.000	1.250	0.031	CN**33...	1.5

Metric	H	B	LF	LH	HF	WF	RE**	Insert	Torque*
PCLNR/L2020K0904	20	20	125	20	20	25	0.8	CN**0904...	2
PCLNR/L2525M0904	25	25	150	25	25	32	0.8	CN**0904...	2

Torque: Recommended clamping torque: lbs·ft (*N·m)
**RE: Standard corner radius

SPARE PARTS

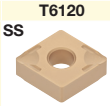
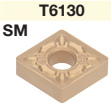
Designation	Shim	Clamping screw	Wrench	Spring pin	Lever
PCLNR/L...	LSC317	LCS3	P-2.5	LSP3	LCL33

INSERT SELECTION

P

Application	Finishing	Medium cutting
Grade	T9215	T9215
Chipbreaker shape	TSF 	TM 
Cutting conditions	B008	

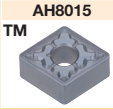
M

Application	Finishing	Medium cutting
Grade	T6120	T6130
Chipbreaker shape	SS 	SM 
Cutting conditions	B010	

K

Application	Medium cutting
Grade	T515
Chipbreaker shape	TM 
Cutting conditions	B012

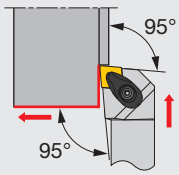
S

Application	Medium cutting
Grade	AH8015
Chipbreaker shape	TM 
Cutting conditions	B016

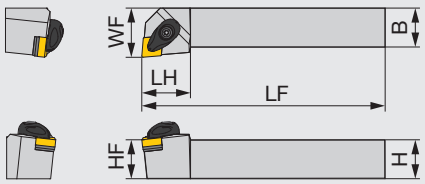
Reference pages: PCLNR/L-Eco: Inserts → B056 -

ACLNR/L

Double-clamp toolholder with 95° approach angle, for negative 80° rhombic inserts



Cutting edge style **L**



Right hand (R) shown.

Inch	H	B	LF	LH	HF	WF	RE**	Insert	Torque
ACLNR/L124-A	0.750	0.750	4.500	1.000	0.750	1.000	0.031	CN**43...	2.2
ACLNR/L164-A	1.000	1.000	6.000	1.250	1.000	1.250	0.031	CN**43...	2.2
ACLNR/L204-A	1.250	1.250	7.000	1.500	1.250	1.500	0.031	CN**43...	2.2
ACLNR/L205-A	1.250	1.250	7.000	1.500	1.250	1.500	0.047	CN**54...	4.7
ACLNR/L245-A	1.500	1.500	8.000	1.500	1.500	1.750	0.047	CN**54...	4.7
ACLNR/L206-A	1.250	1.250	7.000	1.500	1.250	1.500	0.047	CN**64...	4.7
ACLNR/L246-A	1.500	1.500	8.000	1.500	1.500	1.750	0.047	CN**64...	4.7

Metric	H	B	LF	LH	HF	WF	RE**	Insert	Torque*
ACLNR/L2020H12-A	20	20	120	26	20	25	0.8	CN**1204...	3
ACLNR/L2020K12-A	20	20	125	26	20	25	0.8	CN**1204...	3
ACLNR/L2525K12-A	25	25	125	30	25	32	0.8	CN**1204...	3
ACLNR/L2525M12-A	25	25	150	30	25	32	0.8	CN**1204...	3
ACLNR/L3225P12-A	32	25	170	30	32	32	0.8	CN**1204...	3
ACLNR/L2525M16-A	25	25	150	31	25	32	1.2	CN**1606...	6.4
ACLNR/L3225P16-A	32	25	170	31	32	32	1.2	CN**1606...	6.4
ACLNR/L3232P16-A	32	32	170	31	32	40	1.2	CN**1606...	6.4
ACLNR/L3232P19-A	32	32	170	40	32	40	1.2	CN**1906...	6.4
ACLNR/L4040S19-A	40	40	250	40	40	50	1.2	CN**1906...	6.4

Torque: Recommended clamping torque: lbs·ft (*N·m)
**RE: Standard corner radius

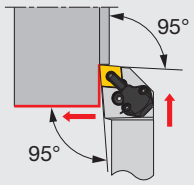
SPARE PARTS

Designation	Clamp	Clamp screw	Spring	Spring pin	Shim	Shim screw	Wrench1	Wrench2
ACLNR/L**4-A, ACLNR/L**12-A	ACP4S	ACS-5W	BP-7	SP-2.5	ASC422	CSTB-3.5	T-15F	-
ACLNR/L**5-A, ACLNR/L**16-A	ACP5S	ACS-6W	BP-8.8	SP-2.5	ASC533	CSTB-5	-	KEYV-T20
ACLNR/L**6-A, ACLNR/L**19-A	ACP6S	ACS-6W	BP-8.8	SP-2.5	ASC634	CSTB-5	-	KEYV-T20

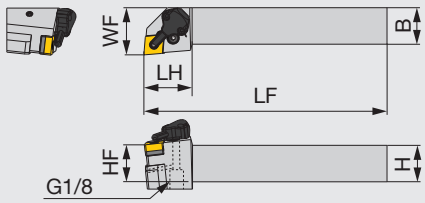
Reference pages: ACLNR/L: Inserts → B056 -, CBN → B172 -, PCD → B194 -

PCLNR/L-CHP

Lever-lock toolholder, for negative 80° rhombic inserts, with high pressure coolant capability



Cutting edge style **L**



Right hand (R) shown.

Inch	H	B	LF	LH	HF	WF	RE**	Insert	Torque
PCLNR/L124-CHP	0.750	0.750	4.500	1.300	0.750	1.250	0.031	CN**43...	2.2
PCLNR/L164-CHP	1.000	1.000	6.000	1.300	1.000	1.250	0.031	CN**43...	2.2

Metric	H	B	LF	LH	HF	WF	RE**	Insert	Torque*
PCLNR/L2020K12-CHP	20	20	125	33	20	32	0.8	CN/GN**1204...	3
PCLNR/L2525M12-CHP	25	25	150	33	25	32	0.8	CN/GN**1204...	3

Torque: Recommended clamping torque: lbs·ft (*N·m)
**RE: Standard corner radius

SPARE PARTS

Designation	Shim	Clamping screw	Wrench1	Spring pin	Lever
PCLNR/L**-CHP	LSC42	LCS4	P-3	LSP4	LCL4

SPARE PARTS

Designation	Coolant unit	Mounting screw	Wrench2	O-ring	Coolant screw	Wrench3
PCLNR/L**-CHP	CU-CW-CHP	SRM3	T-8F	OR6.4X0.9N	SRM4X4TL360	P-2

INSERT SELECTION

P

Application	Precision finishing	Finishing	Medium cutting	Medium to heavy cutting
Grade	NS9530	GT9530	T9215	T9215
Chipbreaker shape	TF	TSF	TM	TH
Cutting conditions	B008			

M

Application	Finishing	Medium cutting	Medium to heavy cutting
Grade	T6120	T6130	T6130
Chipbreaker shape	SF	SM	SH
Cutting conditions	B010		

K

Application	Finishing	Medium cutting	Medium to heavy cutting
Grade	T515	T515	T515
Chipbreaker shape	All-round	All-round	All-round
Cutting conditions	B012		

N

Application	Precision finishing	Finishing	Medium cutting
Grade	DX120	DX140	TH10
Chipbreaker shape	T-DIA	with rake T-DIA	P
Cutting conditions	B014		

S

Application	Precision finishing	Finishing	Medium cutting
Grade	BX470	AH8005	AH8005
Chipbreaker shape	T-CBN	HRF	HRM
Cutting conditions	B016		

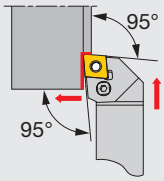
H

Application	Precision finishing	Finishing
Grade	BXM10	BXM20
Chipbreaker shape	T-CBN	T-CBN
Cutting conditions	B018	

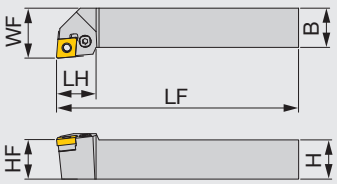
Reference pages: PCLNR/L-CHP: Inserts → B056 -, CBN → B172 -, PCD → B194 -
Parts for coolant hose → C142

PCLNR/L

Lever-lock toolholder with 95° approach angle, for negative 80° rhombic inserts



Cutting edge style **L**



Right hand (R) shown.

Metric	H	B	LF	LH	HF	WF	RE**	Insert
PCLNR/L1616H09	16	16	100	20	16	20	0.8	CN**0903...
PCLNR/L2020K09	20	20	125	20	20	25	0.8	CN**0903...
PCLNR/L2525M09	25	25	150	20	25	32	0.8	CN**0903...
PCLNR/L1616	16	16	100	26	16	20	0.8	CN/GN**1204...
PCLNR/L2020	20	20	125	28	20	25	0.8	CN/GN**1204...
PCLNR/L2525M4	25	25	150	28	25	32	0.8	CN/GN**1204...
PCLNR/L3225P4	32	25	170	28	32	32	0.8	CN/GN**1204...
PCLNR/L3232	32	32	170	40	32	40	1.2	CN**1906...
PCLNR/L1616H12E	16	16	100	26	16	20	0.8	CN/GN**1204...
PCLNR/L2020K12E	20	20	125	28	20	25	0.8	CN/GN**1204...
PCLNR/L2525M12E	25	25	150	28	25	32	0.8	CN/GN**1204...
PCLNR/L3225P12E	32	25	170	28	32	32	0.8	CN/GN**1204...
PCLNR/L2525M16E	25	25	150	31	25	25	1.2	CN**1606...
PCLNR/L3225P16E	32	25	150	31	32	32	1.2	CN**1606...
PCLNR3232P16E	32	32	170	31	32	40	1.2	CN**1606...
PCLNR/L3232P19E	32	32	170	40	32	40	1.2	CN**1906...

**RE: Standard corner radius

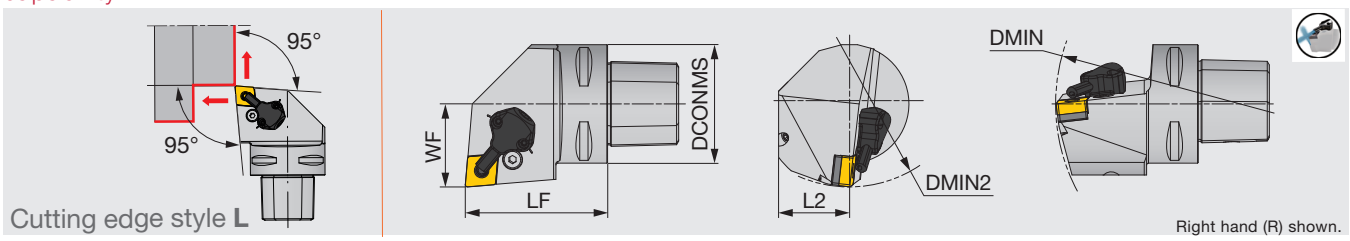
SPARE PARTS

Designation	Shim	Clamping screw	Wrench	Spring pin	Lever
PCLNR/L1616H09	ELSC32	LCS3	P-2.5	LSP3L	LCL33
PCLNR/L2020K09	ELSC32	LCS3	P-2.5	LSP3L	LCL33
PCLNR/L2525M09	ELSC32	LCS3	P-2.5	LSP3L	LCL33
PCLNR/L1616	LSC42	LCS4CA	P-3	LSP4	LCL4
PCLNR/L2020	LSC42	LCS4	P-3	LSP4	LCL4
PCLNR/L2525M4	LSC42	LCS4	P-3	LSP4	LCL4
PCLNR/L3225P4	LSC42	LCS4	P-3	LSP4	LCL4
PCLNR/L3232	LSC63	LCS6	P-4	LSP6	LCL6
PCLNR/L1616H12E	ELSC42	LCS4CA	P-3	LSP4S	LCL43S
PCLNR/L2020K12E	ELSC42	LCS4	P-3	LSP4S	LCL43M
PCLNR/L2525M12E	ELSC42	LCS4	P-3	LSP4S	LCL43M
PCLNR/L3225P12E	ELSC42	LCS4	P-3	LSP4S	LCL43M
PCLNR/L2525M16E	ELSC53	LCS5	P-3	LSP6C	LCL54
PCLNR/L3225P16E	ELSC53	LCS5	P-3	LSP6C	LCL54
PCLNR/L3232P16E	ELSC53	LCS5	P-3	LSP6C	LCL54
PCLNR/L3232P19E	ELSC63	LCS6	P-4	LSP6	LCL6

Reference pages: PCLNR/L: Inserts → B056 -, CBN → B172 -, PCD → B194 -

C-PCLNR/L-CHP

Lever-lock toolholder with TungCap connection, for negative 80° rhombic inserts, with high pressure coolant capability



Inch	DCONMS	LF	L2	WF	DMIN	DMIN2	RE**	Insert
C4PCLNR/L27050-0904-CHP	1.575	1.969	0.984	1.063	5.512	4.331	0.031	CN**33...
C4PCLNR/L27050-12-CHP	1.575	1.969	0.984	1.063	5.512	4.331	0.031	CN**43...
C5PCLNR/L35060-12-CHP	1.969	2.362	1.260	1.378	6.496	4.331	0.031	CN**43...
C6PCLNR/L45065-0904-CHP	2.480	2.559	1.614	1.772	7.480	4.921	0.031	CN**33...
C6PCLNR/L45065-12-CHP	2.480	2.559	1.614	1.772	7.480	4.921	0.031	CN**43...

Metric	DCONMS	LF	L2	WF	DMIN	DMIN2	RE**	Insert
C4PCLNR/L27050-0904-CHP	40	50	25	27	140	110	0.8	CN**0904...
C4PCLNR/L27050-12-CHP	40	50	25	27	140	110	0.8	CN/GN**1204...
C5PCLNR/L35060-12-CHP	50	60	32	35	165	110	0.8	CN/GN**1204...
C6PCLNR/L45065-0904-CHP	63	65	41	45	190	125	0.8	CN**0904...
C6PCLNR/L45065-12-CHP	63	65	41	45	190	125	0.8	CN/GN**1204...

**RE: Standard corner radius

SPARE PARTS

Designation	Shim	Clamping screw	Wrench 1	Spring pin	Lever
C*PCLNR/L**-0904-CHP	LSC317	LCS3	P-2.5	LSP3	LCL33
C*PCLNR**-12-CHP	LSC42	LCS4	P-3	LSP4	LCL4

SPARE PARTS

Designation	Coolant unit	Coolant screw	Wrench 2	Wrench 3
C*PCLNR/L**-0904-CHP	CU-CW-CHP	SRM4X4TL360	T-8F	P-2
C*PCLNR**-12-CHP	CU-CW-CHP	SRM4X4TL360	T-8F	P-2

INSERT SELECTION

P

Application	Precision finishing	Finishing	Medium cutting	Medium to heavy cutting
Grade	NS9530	GT9530	T9215	T9215
Chipbreaker shape	TF	TSF	TM	TH
Cutting conditions	B008			

M

Application	Finishing	Medium cutting	Medium to heavy cutting
Grade	T6120	T6130	T6130
Chipbreaker shape	SF	SM	SH
Cutting conditions	B010		

K

Application	Finishing	Medium cutting	Medium to heavy cutting
Grade	T515	T515	T515
Chipbreaker shape	All-round	All-round	All-round
Cutting conditions	B012		

N

Application	Precision finishing	Finishing	Medium cutting
Grade	DX120	DX140	TH10
Chipbreaker shape	T-DIA	with rake T-DIA	P
Cutting conditions	B014		

S

Application	Precision finishing	Finishing	Medium cutting
Grade	BX470	AH8005	AH8005
Chipbreaker shape	T-CBN	HRF	HRM
Cutting conditions	B016		

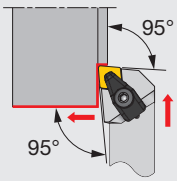
H

Application	Precision finishing	Finishing
Grade	BXM10	BXM20
Chipbreaker shape	T-CBN	T-CBN
Cutting conditions	B018	

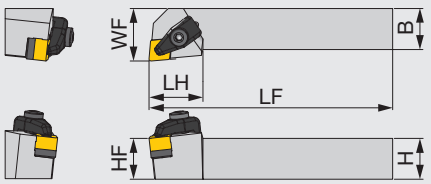
Reference pages: C-PCLNR/L-CHP: Inserts → B056 -, CBN → B172 -, PCD → B194 -
Parts for coolant hose → C142

CCLNR/L-RD

Double-clamp toolholder with 95° approach angle, for negative 80° rhombic ceramic inserts with dimple



Cutting edge style **L**



Right hand (R) shown.

Inch	H	B	LF	LH	HF	WF	RE**	Insert	Torque
CCLNR/L16M45-RD	1.000	1.000	6.000	1.300	1.000	1.250	0.047	CNGD45...	3.0

Torque: Recommended clamping torque: lb·ft
**RE: Standard corner radius

SPARE PARTS

Designation	Clamp	Clamp screw	Shim	Shim screw	Spring	Wrench1	Wrench2
CCLNR/L**-RD	CCP4-A	CCS4-A	CC44-A	BH5-10-A	BP-5-A	P-3	P-4

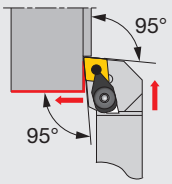
INSERT SELECTION

K	Application	Finishing to medium cutting
	Grade	FX105
	Chipbreaker shape	- 
	Cutting conditions	C144

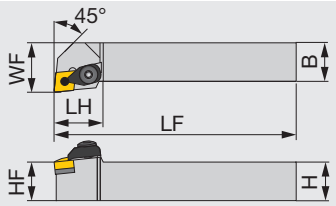
Reference pages: CCLNR/L-RD: Inserts → B066,
Standard cutting conditions → C144

DCLNR/L

"One-Double" toolholder with 95° approach angle, for negative 80° rhombic inserts



Cutting edge style **L**



Right hand (R) shown.

Metric	H	B	LF	LH	HF	WF	RE**	Insert
DCLNR/L2020K12	20	20	125	30	20	25	0.8	CN**1204...
DCLNR/L2525M12	25	25	150	30	25	32	0.8	CN**1204...
DCLNR/L3225P12	32	25	170	30	32	32	0.8	CN**1204...

Except for 57-type chipbreaker inserts
**RE: Standard corner radius

SPARE PARTS

Designation	Clamp	Lever	Piston	Clamp screw	Shim	Spring	Spring pin	Wrench1	Wrench2
DCLNR/L...	DCPM-43	DLCL43	DPIS43	DLCS43	LSC42	BP-10	LSP4	P-3	P-4

INSERT SELECTION

P

Application	Precision finishing	Finishing	Medium cutting	Medium to heavy cutting
Grade	NS9530	GT9530	T9215	T9215
Chipbreaker shape	TF	TSF	TM	TH
Cutting conditions	B008			

M

Application	Finishing	Medium cutting	Medium to heavy cutting
Grade	T6120	T6130	T6130
Chipbreaker shape	SF	SM	SH
Cutting conditions	B010		

K

Application	Finishing	Medium cutting	Medium to heavy cutting
Grade	T515	T515	T515
Chipbreaker shape	All-round	All-round	All-round
Cutting conditions	B012		

N

Application	Precision finishing	Finishing	Medium cutting
Grade	DX120	DX140	TH10
Chipbreaker shape	T-DIA with rake	T-DIA	P
Cutting conditions	B014		

S

Application	Precision finishing	Finishing	Medium cutting
Grade	BX480	AH8005	AH8005
Chipbreaker shape	T-CBN	HRF	HRM
Cutting conditions	B016		

H

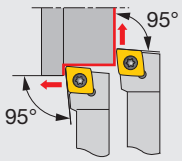
Application	Precision finishing	Finishing
Grade	BXM10	BXM20
Chipbreaker shape	T-CBN	T-CBN
Cutting conditions	B018	

Reference pages: DCLNR/L: Inserts → B056 -, CBN → B172 -, PCD → B194 -

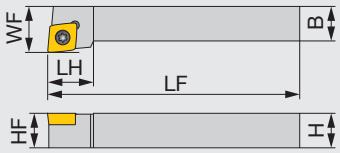
J-SERIES

JSCLCR/L

Screw-on toolholder with 95° approach angle, for positive 80° rhombic inserts



Cutting edge style **L**



Right hand (R) shown.

Metric	H	B	LF	LH	HF	WF	RE**	Insert	Torque
JSCLCR/L0808H06	8	8	100	12	8	10	0.4	CC**0602...	1.2
JSCLCR/L1010H06	10	10	100	12	10	12	0.4	CC**0602...	1.2
JSCLCR/L1212H09	12	12	100	16	12	16	0.8	CC**09T3...	1.2
JSCLCR/L1616H09	16	16	100	16	16	20	0.8	CC**09T3...	1.2

Torque: Recommended clamping torque: N·m
**RE: Standard corner radius

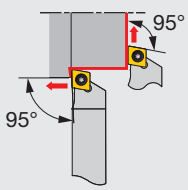
SPARE PARTS

Designation	Clamping screw	Wrench
JSCLCR/L**H06	CSTB-2.5	T-8F
JSCLCR/L**H09	CSTB-4SD	T-8F

J-SERIES

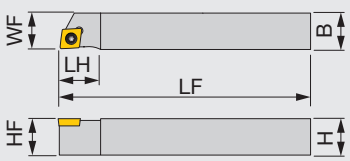
JSCL2CR/L

Screw-on toolholder without offset with 95° approach angle for positive 80° rhombic inserts



Cutting edge style **L2**

Without offset



Right hand (R) shown.

Inch	H	B	LF	LH	HF	WF	RE**	Insert	Torque
JSCL2CR/L062	0.375	0.375	5.000	0.400	0.375	0.375	0.016	CC**21.5...	0.89
JSCL2CR/L082	0.500	0.500	5.000	0.400	0.500	0.500	0.016	CC**21.5...	0.89
JSCL2CR/L103	0.625	0.625	5.000	0.680	0.625	0.625	0.031	CC**32.5...	0.89

Metric	H	B	LF	LH	HF	WF	RE**	Insert	Torque*
JSCL2CR/L1010X06	10	10	120	12	10	10	0.2	CC**0602...	1.2
JSCL2CR/L1212F06	12	12	85	12	12	12	0.2	CC**0602...	1.2
JSCL2CR/L1212X06	12	12	120	12	12	12	0.2	CC**0602...	1.2
JSCL2CR/L1212F09	12	12	85	16	12	12	0.2	CC**09T3...	1.2
JSCL2CR/L1212X09	12	12	120	16	12	12	0.2	CC**09T3...	1.2
JSCL2CR/L1616X09	16	16	120	16	16	16	0.2	CC**09T3...	1.2

Torque: Recommended clamping torque: lbs·ft (*N·m)
**RE: Standard corner radius

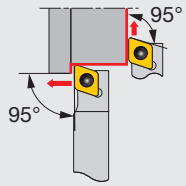
SPARE PARTS

Designation	Clamping screw	Wrench
JSCL2CR/L062, JSCL2CR/L082, JSCL2CR/L**06	CSTB-2.5	T-8F
JSCL2CR/L103, JSCL2CR/L**09	CSTB-4SD	T-8F

Reference pages: JSCLCR/L, JSCL2CR/L: Inserts → B111 -, CBN → B182 -, PCD → B196 -

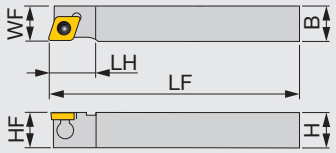
JTCL2CR/L

Back-clamp toolholder with 95° approach angle, for positive 80° rhombic inserts



Cutting edge style **L2**

Without offset



Right hand (R) shown.

Metric	H	B	LF	LH	HF	WF	RE**	Insert	Torque
JTCL2CR/L1010X06	10	10	120	12	10	10	0.2	CC**0602...	0.9
JTCL2CR/L1212F09	12	12	85	16	12	12	0.2	CC**09T3...	1.2
JTCL2CR/L1212X09	12	12	120	16	12	12	0.2	CC**09T3...	1.2
JTCL2CR/L1616X09	16	16	120	16	16	16	0.2	CC**09T3...	1.2
JTCL2CR1616M09	16	16	150	16	16	16	0.8	CC**09T3...	1.2

Torque: Recommended clamping torque: N·m
**RE: Standard corner radius

SPARE PARTS

Designation	Clamp	Clamping screw	Wrench
JTCL2CR/L**06	JCP-2	JDS-3525	P-2F
JTCL2CR/L**09	JCP-3	JDS-5040	P-2.5F

INSERT SELECTION

P

Application	Precision finishing	Finishing	Finishing to medium cutting	Medium cutting
Grade	SH725	SH725	T9215	T9215
Chipbreaker shape	01	JS	PS	PM
Cutting conditions	B020			

M

Application	Precision finishing	Finishing	Finishing to medium cutting	Medium cutting
Grade	SH725	SH725	T9215	T9215
Chipbreaker shape	01	JS	PS	PM
Cutting conditions	B022			

K

Application	Finishing to medium cutting
Grade	T515
Chipbreaker shape	CM
Cutting conditions	B024

N

Application	Precision finishing	Finishing	Medium cutting
Grade	DX120	TH10	KS05F
Chipbreaker shape	T-DIA	with rake W20	AL
Cutting conditions	B026		

S

Application	Precision finishing	Finishing to medium cutting
Grade	BX470	AH8005
Chipbreaker shape	T-CBN	PS
Cutting conditions	B028	

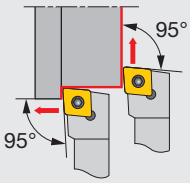
H

Application	Precision finishing	Finishing
Grade	BXM10	BXM20
Chipbreaker shape	T-CBN	T-CBN
Cutting conditions	B030	

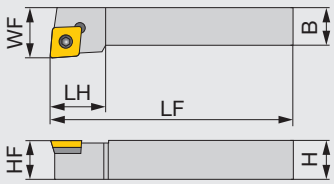
Reference pages: JTCL2CR/L: Inserts → B111 -, CBN → B182 -, PCD → B196 -

SCLCR/L

Screw-on toolholder with 95° approach angle, for positive 80° rhombic inserts



Cutting edge style **L**



Right hand (R) shown.

Inch	H	B	LF	LH	HF	WF	RE**	Insert
SCLCR/L 103	0.625	0.625	4.000	0.625	0.625	0.750	0.031	CC**32.5...
SCLCR/L 123	0.750	0.750	4.500	0.625	0.750	0.750	0.031	CC**32.5...
SCLCR/L 163	1.000	1.000	6.000	0.625	1.000	0.750	0.031	CC**32.5...
SCLCR/L 124B	0.750	0.750	4.500	0.625	0.750	0.750	0.031	CC**43...
SCLCR/L 164D	1.000	1.000	6.000	0.750	1.000	0.750	0.031	CC**43...

Metric	H	B	LF	LH	HF	WF	RE**	Insert
SCLCR/L1616H09	16	16	100	16	16	20	0.8	CC**09T3...
SCLCR/L2020K12	20	20	125	20	20	25	0.8	CC**1204...

**RE: Standard corner radius

SPARE PARTS

Designation	Clamping screw	Shim screw	Shim	Wrench1	Wrench2
SCLCR/L103, 123, 163 SCLCR/L1616H09	CSTB-3.5L	DTS5-3.5	SSC32	P-3.5	T-15F
SCLCR/L124B, 164D	CSPB-5	DTS6-4	SSC4T3	P-4	T20F
SCLCR/L2020K12	CSTB-4F	DTS6-4	SSC4T3	P-4	T-15F

INSERT SELECTION

P

Application	Precision finishing	Finishing	Finishing to medium cutting	Medium cutting
Grade	NS9530	NS9530	T9215	T9215
Chipbreaker shape	01	PSS	PS	PM
Cutting conditions	B020			

M

Application	Precision finishing	Finishing	Finishing to medium cutting	Medium cutting
Grade	GH330	AH725	AH630	T6130
Chipbreaker shape	W**	PSF	PSS	PM
Cutting conditions	B022			

K

Application	Finishing to medium cutting
Grade	T515
Chipbreaker shape	CM
Cutting conditions	B024

N

Application	Precision finishing	Finishing	Medium cutting
Grade	DX120	DX140	KS05F
Chipbreaker shape	T-DIA with rake	T-DIA	AL
Cutting conditions	B026		

S

Application	Finishing	Finishing to medium cutting
Grade	AH8015	AH8015
Chipbreaker shape	PSS	PS
Cutting conditions	B028	

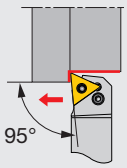
H

Application	Precision finishing	Finishing
Grade	BXM10	BXM20
Chipbreaker shape	T-CBN	T-CBN
Cutting conditions	B030	

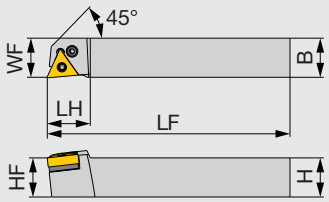
Reference pages: SCLCR/L: Inserts → B111 -, CBN → B182 -, PCD → B196 -

PTL2NR/L

Lever-lock toolholder with 95° approach angle, for negative 60° triangular inserts



Cutting edge style **L2**



Right hand (R) shown.

Metric	H	B	LF	LH	HF	WF	RE**	Insert	Torque
PTL2NR/L2020H16	20	20	100	22	20	20	0.4	TN**1604...	2

Torque: Recommended clamping torque: N·m
**RE: Standard corner radius

SPARE PARTS

Designation	Shim	Clamping screw	Wrench	Spring pin	Lever
PTL2NR/L...	LST317 D30	LCS3	P-2.5	LSP3	LCL3

INSERT SELECTION

P

Application	Precision finishing	Finishing	Medium cutting	Medium to heavy cutting
Grade	NS9530	GT9530	T9215	T9215
Chipbreaker shape	TF	TSF	TM	TH
Cutting conditions	B008			

M

Application	Finishing	Medium cutting
Grade	T6120	T6130
Chipbreaker shape	SF	SM
Cutting conditions	B010	

K

Application	Finishing	Medium cutting	Medium to heavy cutting
Grade	T515	T515	T515
Chipbreaker shape	All-round	All-round	All-round
Cutting conditions	B012		

N

Application	Precision finishing	Finishing	Medium cutting
Grade	DX120	DX140	TH10
Chipbreaker shape	T-DIA with rake	T-DIA	P
Cutting conditions	B014		

S

Application	Precision finishing	Finishing	Medium cutting
Grade	BX470	AH8005	AH8005
Chipbreaker shape	T-CBN	HRF	HRM
Cutting conditions	B016		

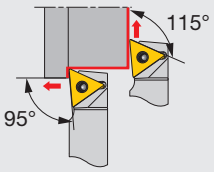
H

Application	Precision finishing	Finishing
Grade	BXM10	BXM20
Chipbreaker shape	T-CBN	T-CBN
Cutting conditions	B018	

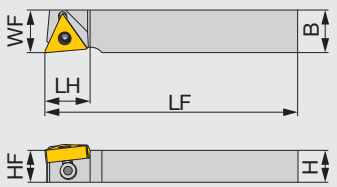
Reference pages: PTL2NR/L: Inserts → B086 -, CBN → B178 -, PCD → B194 -

JTTLNR/L

Back-clamp toolholder with 95° approach angle, for negative 60° triangular inserts



Cutting edge style **L**



Without offset

Right hand (R) shown.

Metric	H	B	LF	LH	HF	WF	RE**	Insert	Torque
JTTLNR/L1216F16	12	16	85	17	12	16	0.4	TN**1604...	1
JTTLNR/L1216X16	12	16	120	17	12	16	0.4	TN**1604...	1
JTTLNR/L1616X16	16	16	120	17	16	16	0.4	TN**1604...	1

Torque: Recommended clamping torque: N·m
**RE: Standard corner radius

SPARE PARTS

Designation	Clamp	Clamping screw	Wrench
JTTLNR/L...	JCP-3N	JDS-5040	P-2.5F

INSERT SELECTION

P

Application	Precision finishing
Grade	SH725
Chipbreaker shape	01 
Cutting conditions	B008

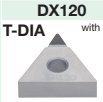
M

Application	Precision finishing
Grade	SH725
Chipbreaker shape	01 
Cutting conditions	B010

K

Application	Finishing to medium cutting
Grade	T515
Chipbreaker shape	CM 
Cutting conditions	B012

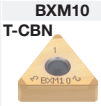
N

Application	Precision finishing
Grade	DX120
Chipbreaker shape	T-DIA with rake 
Cutting conditions	B014

S

Application	Precision finishing
Grade	BX470
Chipbreaker shape	T-CBN 
Cutting conditions	B016

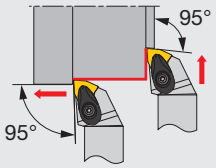
H

Application	Precision finishing	Finishing
Grade	BXM10	BXM20
Chipbreaker shape	T-CBN 	T-CBN 
Cutting conditions	B018	

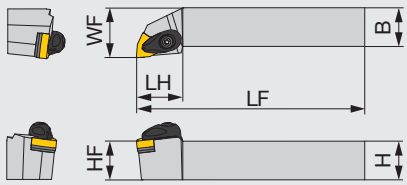
Reference pages: JTTLNR/L: Inserts → B086 -, CBN → B178 -, PCD → B194 -

AWLNR/L-Eco

Double-clamp toolholder with 95° approach angle, for negative 80° trigon inserts



Cutting edge style **L**



Right hand (R) shown.

Inch		B	LF	LH	HF	WF	RE**	Insert	Torque
AWLNR/L1233-A	0.750	0.750	4.500	1.125	0.750	1.000	0.031	WN**33...	2.21
AWLNR/L1633-A	1.000	1.000	6.000	1.125	1.000	1.250	0.031	WN**33...	2.21

Metric	H	B	LF	LH	HF	WF	RE**	Insert	Torque*
AWLNR/L2020K0604-A	20	20	125	27	20	25	0.8	WN**0604...	3
AWLNR/L2525M0604-A	25	25	150	27	25	32	0.8	WN**0604...	3

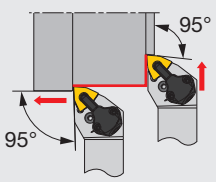
Torque: Recommended clamping torque: lbs·ft (*N·m) **RE: Standard corner radius

SPARE PARTS

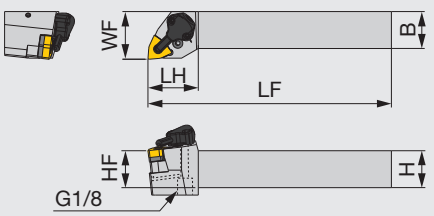
Designation	Clamp	Clamp screw	Spring	Spring pin	Shim	Shim screw	Wrench
AWLNR/L**-A	ACP3S-E	ACS-5W	BP-7	SP-2.5	ASW322	CSTB-3.5	T-15F

PWLNR/L-CHP

Lever-lock toolholder with 95° approach angle, for negative 80° trigon inserts, with high pressure coolant capability



Cutting edge style **L**



Right hand (R) shown.

Inch		B	LF	LH	HF	WF	RE**	Insert	Torque
PWLNR/L1233-CHP	0.750	0.750	4.500	1.969	0.750	1.250	0.031	WN**33...	1.48
PWLNR/L1633-CHP	1.000	1.000	6.000	1.969	1.000	1.250	0.031	WN**33...	1.48

Metric	H	B	LF	LH	HF	WF	RE**	Insert	Torque*
PWLNR/L2020K0604-CHP	20	20	125	34	20	32	0.8	WN**0604...	2
PWLNR/L2525M0604-CHP	25	25	150	34	25	32	0.8	WN**0604...	2

Torque: Recommended clamping torque: lbs·ft (*N·m) **RE: Standard corner radius

SPARE PARTS

Designation	Shim	Clamping screw	Wrench1	Spring pin	Lever
PWLNR/L**-CHP	LSW312	LCS3	P-2.5	LSP3	LCL3

SPARE PARTS

Designation	Coolant unit	Mounting screw	Wrench2	O-ring	Coolant screw	Wrench3
PWLNR/L**-CHP	CU-CW-CHP	SRM3	T-8F	OR6.4X0.9N	SRM4X4TL360	P-2

INSERT SELECTION

P

Application	Finishing	Medium cutting
Grade	T9215	T9215
Chipbreaker shape	TSF	TM
Cutting conditions	B008	

M

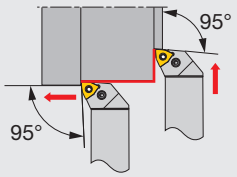
Application	Finishing	Medium cutting
Grade	T6120	T6130
Chipbreaker shape	SS	SM
Cutting conditions	B010	

K

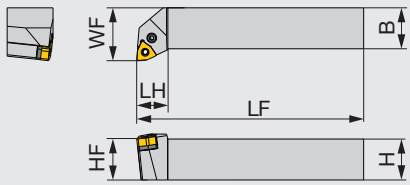
Application	Medium cutting
Grade	T515
Chipbreaker shape	TM
Cutting conditions	B012

Reference pages: AWLNR/L-Eco, PWLNR/L-CHP: Inserts → B102 -
Parts for coolant hose → C142

Lever-lock toolholder with 95° approach angle, for negative 80° trigon inserts



Cutting edge style **L**



Right hand (R) shown.

Inch	H	B	LF	LH	HF	WF	RE**	Insert	Torque
PWLNR/L1233	0.750	0.750	4.500	0.625	0.750	1.000	0.031	WN**33...	1.48
PWLNR/L1633	1.000	1.000	6.000	0.719	1.000	1.250	0.031	WN**33...	1.48

Metric	H	B	LF	LH	HF	WF	RE**	Insert	Torque*
PWLNR/L2020K0604	20	20	125	15	20	25	0.8	WN**0604...	2
PWLNR/L2525M0604	25	25	150	19	25	32	0.8	WN**0604...	2

Torque: Recommended clamping torque: lbs·ft (*N·m) **RE: Standard corner radius

SPARE PARTS

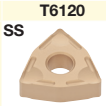
Designation	Shim	Clamping screw	Wrench	Spring pin	Lever
PWLNR/L...	LSW312	LCS3	P-2.5	LSP3	LCL3

INSERT SELECTION

P

Application	Finishing	Medium cutting
Grade	T9215	T9215
Chipbreaker shape	TSF 	TM 
Cutting conditions	B008	

M

Application	Finishing	Medium cutting
Grade	T6120	T6130
Chipbreaker shape	SS 	SM 
Cutting conditions	B010	

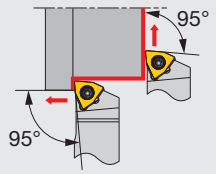
K

Application	Medium cutting
Grade	T515
Chipbreaker shape	TM 
Cutting conditions	B012

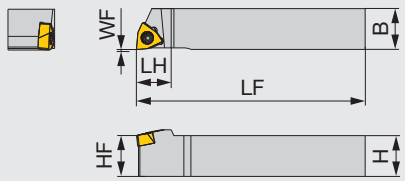
Reference pages: PWLNR/L-Eco: Inserts → B102 -

JSWL2XR/L

Screw-on toolholder with 95° approach angle, for WXGU inserts



Cutting edge style **L2**



Without offset

Right hand (R) shown.

Inch	H	B	LF	LH	HF	WF	RE**	Insert	Torque
JSWL2XR/L062	0.375	0.375	4.750	0.500	0.375	0	0.008	WXGU0403**L/R...	0.66
JSWL2XR/L082	0.500	0.500	4.750	0.500	0.500	0	0.008	WXGU0403**L/R...	0.66
JSWL2XR/L102	0.625	0.625	4.750	0.500	0.625	0	0.008	WXGU0403**L/R...	0.66

Metric	H	B	LF	LH	HF	WF	RE**	Insert	Torque*
JSWL2XR/L1010X04	10	10	120	11	10	0	0.2	WXGU0403**L/R...	0.9
JSWL2XR/L1212F04	12	12	85	11	12	0	0.2	WXGU0403**L/R...	0.9
JSWL2XR/L1212X04	12	12	120	11	12	0	0.2	WXGU0403**L/R...	0.9
JSWL2XR/L1616X04	16	16	120	13	16	0	0.2	WXGU0403**L/R...	0.9
JSWL2XR/L2020H04	20	20	100	13	20	0	0.2	WXGU0403**L/R...	0.9

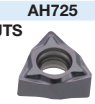
Torque: Recommended clamping torque: lbs·ft (*N·m) **RE: Standard corner radius
Use right-hand toolholders (R) with left-hand inserts (L); and left-hand toolholders (L) with right-hand inserts (R).

SPARE PARTS


Designation	Clamping screw	Wrench
JSWL2XR/L...	SR34-514	T-7F

INSERT SELECTION

Swiss lathes

P	Application	Finishing	Medium cutting
	Grade	SH725	AH725
	Chipbreaker shape	JSS 	JTS 
	Cutting conditions	C143	

M	Application	Finishing	Medium cutting
	Grade	SH725	AH725
	Chipbreaker shape	JSS 	JTS 
	Cutting conditions	C143	

Small CNC lathes

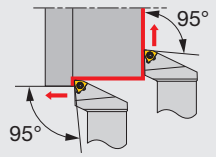
P	Application	Finishing	Medium cutting
	Grade	AH725	AH725
	Chipbreaker shape	SS 	TS 
	Cutting conditions	C143	

M	Application	Finishing	Medium cutting
	Grade	AH8015	AH8015
	Chipbreaker shape	SS 	TS 
	Cutting conditions	C143	

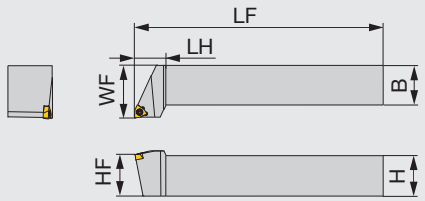
Reference pages: JSWL2XR/L: Inserts → B161 -
Standard cutting conditions → C143

JSWLXR/L

Lever-lock toolholder with 95° approach angle, for negative 80° trigon inserts



Cutting edge style **L**



Right hand (R) shown.

Inch	H	B	LF	LH	HF	WF	RE**	Insert	Torque
JSWLXR/122	0.750	0.750	4.500	0.625	0.750	1.000	0.008	WXGU0403**L/R...	0.66
JSWLXR/162	1.000	1.000	6.000	0.750	1.000	1.250	0.008	WXGU0403**L/R...	0.66

Metric	H	B	LF	LH	HF	WF	RE**	Insert	Torque*
JSWLXR/L2020K04	20	20	125	15	20	25	0.4	WXGU0403**L/R...	0.9
JSWLXR/L2525M04	25	25	150	19	25	32	0.4	WXGU0403**L/R...	0.9

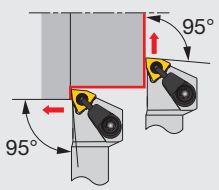
Torque: Recommended clamping torque: lbs·ft (*N·m) **RE: Standard corner radius
Use right-hand toolholders (R) with left-hand inserts (L); and left-hand toolholders (L) with right-hand inserts (R).

SPARE PARTS

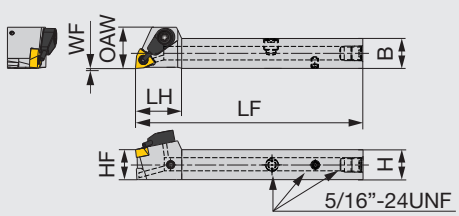

Designation	Clamping screw	Wrench
JSWLXR/L...	SR34-514	T-7F

JSWL2XR/L-CHP

Screw-on toolholder with 95° approach angle, for WXGU inserts, with high pressure coolant capability



Cutting edge style **L2**



Without offset

Right hand (R) shown.

Inch	H	B	LF	LH	HF	WF	OAW	RE**	Insert	Torque
JSWL2XR/L082-CHP	0.500	0.500	3.344	0.750	0.500	0	0.650	0.008	WXGU0403**L/R...	0.66
JSWL2XR082X-CHP	0.500	0.500	4.750	0.728	0.500	0	0.650	0.008	WXGU0403**L	0.66
JSWL2XR102X-CHP	0.625	0.625	4.750	0.728	0.625	0	0.650	0.008	WXGU0403**L	0.66

Metric	H	B	LF	LH	HF	WF	OAW	RE**	Insert	Torque*
JSWL2XR/L1212F04-CHP	12	12	85	18	12	0	16.5	0.2	WXGU0403**L/R...	0.9
JSWL2XR1212X04-CHP(1)	12	12	120	18.5	12	0	16.5	0.2	WXGU0403**L	0.9
JSWL2XR1616X04-CHP(1)	16	16	120	18.5	16	0	16.5	0.2	WXGU0403**L	0.9

Torque: Recommended clamping torque: lbs·ft (*N·m) **RE: Standard corner radius
Use right-hand toolholders (R) with left-hand inserts (L); and left-hand toolholders (L) with right-hand inserts (R).
(1) Compatible to the direct internal coolant supply system without the use of external coolant hose.

SPARE PARTS

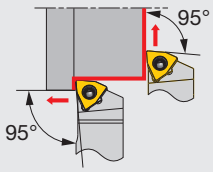


Designation	Clamping screw	Coolant unit	Wrench
JSWL2XR**-CHP	SR34-514	S-CU-CHP	T-7F

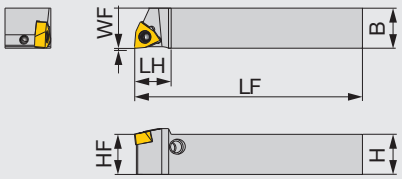
Reference pages: JSWLXR/L, JSWL2XR/L-CHP: Inserts → B161 -
Standard cutting conditions → C143

JPWL2XR/L

Back-clamp toolholder with 95° approach angle, for WXGU inserts



Cutting edge style **L2**



Without offset

Right hand (R) shown.

Inch	H	B	LF	LH	HF	WF	RE**	Insert	Torque
JPWL2XR/L062	0.375	0.375	4.750	0.500	0.375	0	0.008	WXGU0403**L/R...	0.66
JPWL2XR/L082	0.500	0.500	4.750	0.500	0.500	0	0.008	WXGU0403**L/R...	0.66
JPWL2XR/L102	0.625	0.625	4.750	0.500	0.625	0	0.008	WXGU0403**L/R...	0.66

Metric	H	B	LF	LH	HF	WF	RE**	Insert	Torque*
JPWL2XR/L1010X04	10	10	120	11	10	0	0.2	WXGU0403**L/R...	0.9
JPWL2XR/L1212F04	12	12	85	11	12	0	0.2	WXGU0403**L/R...	0.9
JPWL2XR/L1212X04	12	12	120	11	12	0	0.2	WXGU0403**L/R...	0.9
JPWL2XR/L1616X04	16	16	120	13	16	0	0.2	WXGU0403**L/R...	0.9

Torque: Recommended clamping torque: lbs·ft (*N·m) **RE: Standard corner radius
Use right-hand toolholders (R) with left-hand inserts (L); and left-hand toolholders (L) with right-hand inserts (R).

SPARE PARTS

Designation	Lever	Pin	Clamping screw	Wrench
JPWL2XR/L...	SLLV-2	SL-PI-2	SR10400611	HW2.0/5RED

INSERT SELECTION

Swiss lathes

P

Application	Finishing	Medium cutting
Grade	SH725	AH725
Chipbreaker shape	JSS	JTS
Cutting conditions	C143	

M

Application	Finishing	Medium cutting
Grade	SH725	AH725
Chipbreaker shape	JSS	JTS
Cutting conditions	C143	

Small CNC lathes

P

Application	Finishing	Medium cutting
Grade	AH725	AH725
Chipbreaker shape	SS	TS
Cutting conditions	C143	

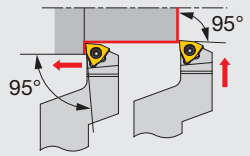
M

Application	Finishing	Medium cutting
Grade	AH8015	AH8015
Chipbreaker shape	SS	TS
Cutting conditions	C143	

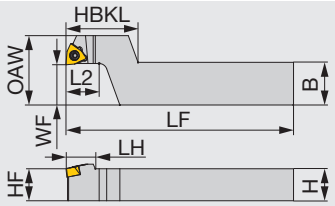
Reference pages: JPWL2XR/L: Inserts → B161 -
Standard cutting conditions → C143

JSWLXR-F

Screw-on stepped-head toolholder with 95° approach angle, for WXGU inserts



Cutting edge style **L**



Right hand (R) shown.

Inch	H	B	LF	L2	HBKL	LH	HF	WF	OAW	RE**	Insert	Torque
JSWLXR082-F10	0.500	0.625	4.750	0.500	1.125	0.750	0.500	0.625	1	0.008	WXGU0403**L...	0.66
JSWLXR102-F10	0.625	0.750	4.750	0.500	1.125	0.750	0.625	0.625	1	0.008	WXGU0403**L...	0.66

Metric	H	B	LF	L2	HBKL	LH	HF	WF	OAW	RE**	Insert	Torque*
JSWLXR1016X04-F15	10	16	120	12	27	11	10	15	26	0.2	WXGU0403**L...	0.9
JSWLXR1216F04-F15	12	16	85	12	27	11	12	15	26	0.2	WXGU0403**L...	0.9
JSWLXR1216X04-F15	12	16	120	12	27	11	12	15	26	0.2	WXGU0403**L...	0.9
JSWLXR1620X04-F15	16	20	120	12	27	11	16	15	26	0.2	WXGU0403**L...	0.9

Torque: Recommended clamping torque: lbs·ft (*N·m) **RE: Standard corner radius
Use right-hand toolholders (R) with left-hand inserts (L).

SPARE PARTS

Designation	Clamping screw	Wrench
JSWLXR**-F10 JSWLXR**-F15	SR34-514	T-7F

INSERT SELECTION

Swiss lathes

P

Application	Finishing	Medium cutting
Grade	SH725	AH725
Chipbreaker shape	JSS	JTS
Cutting conditions	C143	

M

Application	Finishing	Medium cutting
Grade	SH725	AH725
Chipbreaker shape	JSS	JTS
Cutting conditions	C143	

Small CNC lathes

P

Application	Finishing	Medium cutting
Grade	AH725	AH725
Chipbreaker shape	SS	TS
Cutting conditions	C143	

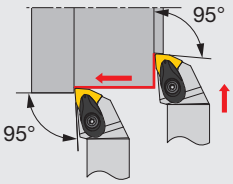
M

Application	Finishing	Medium cutting
Grade	AH8015	AH8015
Chipbreaker shape	SS	TS
Cutting conditions	C143	

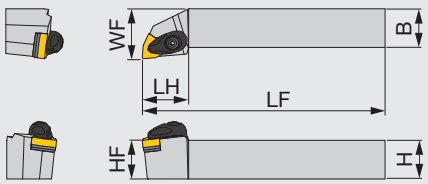
Reference pages: JSWLXR-F: Inserts → B161 -
Standard cutting conditions → C143

AWLNR/L

Double-clamp toolholder with 95° approach angle, for negative 80° trigon inserts



Cutting edge style **L**



Right hand (R) shown.

Inch	H	B	LF	LH	HF	WF	RE**	Insert	Torque
AWLNR/L123-A	0.750	0.750	4.500	1.125	0.750	1.000	0.031	WN**33...	2.2
AWLNR/L163-A	1.000	1.000	6.000	1.125	1.000	1.250	0.031	WN**33...	2.2
AWLNR/L124-A	0.750	0.750	4.500	1.250	0.750	1.000	0.031	WN**43...	2.2
AWLNR/L164-A	1.000	1.000	6.000	1.250	1.000	1.250	0.031	WN**43...	2.2
AWLNR/L204-A	1.250	1.250	7.000	1.250	1.250	1.500	0.031	WN**43...	2.2

Metric	H	B	LF	LH	HF	WF	RE**	Insert	Torque*
AWLNR/L2020H08-A	20	20	100	30	20	25	0.8	WN**0804...	3
AWLNR/L2020K08-A	20	20	125	30	20	25	0.8	WN**0804...	3
AWLNR/L2525K08-A	25	25	125	30	25	32	0.8	WN**0804...	3
AWLNR/L2525M08-A	25	25	150	30	25	32	0.8	WN**0804...	3
AWLNR/L3225P08-A	32	25	170	30	32	32	0.8	WN**0804...	3

Torque: Recommended clamping torque: lbs·ft (*N·m)
**RE: Standard corner radius

SPARE PARTS

Designation	Clamp	Clamp screw	Spring	Spring pin	Shim	Shim screw	Wrench
AWLNR/L**3-A	ACP3S	ACS-5W	BP-7	SP-2.5	ASW322	CSTB-3.5	T-15F
AWLNR/L**4-A, 08-A	ACP4S	ACS-5W	BP-7	SP-2.5	ASW422	CSTB-3.5	T-15F

INSERT SELECTION

P

Application	Precision finishing	Finishing	Medium cutting	Medium to heavy cutting
Grade	NS9530	GT9530	T9215	T9215
Chipbreaker shape	TF	TSF	TM	TH
Cutting conditions	B008			

M

Application	Finishing	Medium cutting	Medium to heavy cutting
Grade	T6120	T6130	T6130
Chipbreaker shape	SF	SM	SH
Cutting conditions	B010		

K

Application	Finishing	Medium cutting	Medium to heavy cutting
Grade	T515	T515	T515
Chipbreaker shape	All-round	All-round	All-round
Cutting conditions	B012		

S

Application	Precision finishing	Finishing	Medium cutting
Grade	BX480	AH8005	AH8005
Chipbreaker shape	T-CBN	HRF	HRM
Cutting conditions	B016		

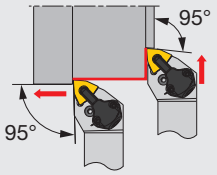
H

Application	Precision finishing	Finishing
Grade	BXM10	BXM20
Chipbreaker shape	T-CBN	T-CBN
Cutting conditions	B018	

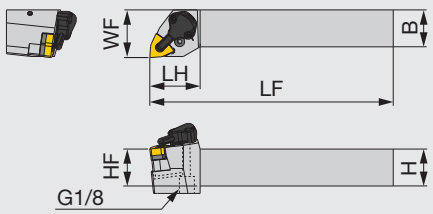
Reference pages: AWLNR/L: Inserts → B101 -, CBN → B181
Parts for coolant hose → C142

TUNGTJET URN
PWLNR/L-CHP

Lever-lock toolholder with 95° approach angle, for negative 80° trigon inserts, with high pressure coolant capability



Cutting edge style **L**



Right hand (R) shown.

Inch	H	B	LF	LH	HF	WF	RE**	Insert	Torque
PWLNR/L124-CHP	0.750	0.750	4.500	1.969	0.750	1.250	0.031	WN**43...	1.5
PWLNR/L164-CHP	1.000	1.000	6.000	1.969	1.000	1.250	0.031	WN**43...	1.5

Metric	H	B	LF	LH	HF	WF	RE**	Insert	Torque*
PWLNR/L2020K08-CHP	20	20	125	34	20	32	0.8	WN**0804...	3
PWLNR/L2525M08-CHP	25	25	150	34	25	32	0.8	WN**0804...	3

Torque: Recommended clamping torque: lbs·ft (*N·m)
**RE: Standard corner radius

SPARE PARTS

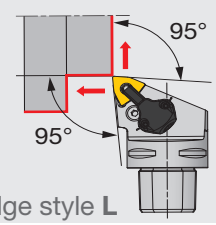
Designation	Shim	Clamping screw	Wrench1	Spring pin	Lever
PWLNR/L**4-CHP, PWLNR/L**08-CHP	LSW42	LCS4	P-2.5	LSP4	LCL4

SPARE PARTS

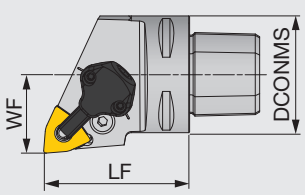
Designation	Coolant unit	Mounting screw	Wrench2	O-ring	Coolant screw	Wrench3
PWLNR/L**4-CHP, PWLNR/L**08-CHP	CU-CW-CHP	SRM3	T-8F	OR6.4X0.9N	SRM4X4TL360	P-2

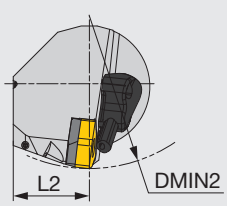
TUNGTJET URN — ISOECO TURN TUNGCAP
C-PWLNR/L-CHP

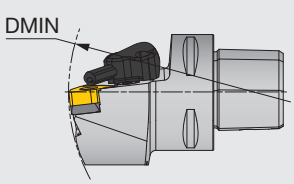
Lever-lock toolholder with TungCap connection, for negative 80° trigon inserts, with high pressure coolant capability



Cutting edge style **L**







Right hand (R) shown.

Inch	DCONMS	LF	L2	WF	DMIN	DMIN2	RE**	Insert
C4PWLNR/L27050-0604-CHP	1.575	1.969	0.984	1.063	5.512	4.331	0.031	WN**33...
C4PWLNR/L27050-08-CHP	1.575	1.969	0.984	1.063	5.512	4.331	0.031	WN**43...
C6PWLNR/L45065-08-CHP	2.480	2.559	1.614	1.772	7.480	4.331	0.031	WN**43...

Metric	DCONMS	LF	L2	WF	DMIN	DMIN2	RE**	Insert
C4PWLNR/L27050-0604-CHP	40	50	25	27	140	110	0.8	WN**0604...
C4PWLNR/L27050-08-CHP	40	50	25	27	140	110	0.8	WN**0804...
C6PWLNR/L45065-08-CHP	63	65	41	45	190	110	0.8	WN**0804...

**RE: Standard corner radius

SPARE PARTS FOR P-TYPE

Designation	Shim	Clamping screw	Wrench1	Spring pin	Lever
C*PWLNR/L**-0604-CHP	LSW312	LCS3	P-2.5	LSP3	LCL3
C*PWLNR/L**-08-CHP	LSW42BL	LCS4	P-3	LSP4	LCL4

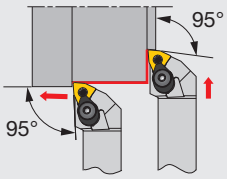
COOLANT SET

Designation	Coolant unit	Mounting screw	Wrench2	O-ring
C*PWLNR/L**-CHP	CU-CW-CHP	SRM3	T-8F	OR6.4X0.9N

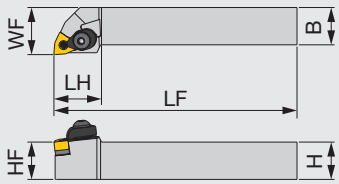
Reference pages: PWLNR/L-CHP, C-PWLNR/L-CHP: Inserts → B101 -, CBN → B181
Parts for coolant hose → C142

DWLNR/L

One-Double toolholder with 95° approach angle, for negative 80° trigon inserts



Cutting edge style **L**



Right hand (R) shown.

Metric	H	B	LF	LH	HF	WF	RE**	Insert
DWLNR/L2020K06	20	20	125	25.5	20	25	0.8	WN**0604...
DWLNR/L2020K08	20	20	125	31	20	25	0.8	WN**0804...
DWLNR/L2525M06	25	25	150	26	25	32	0.8	WN**0604...
DWLNR/L2525M08	25	25	150	31	25	32	0.8	WN**0804...
DWLNR/L3225P08	32	25	170	30	32	32	0.8	WN**0804...

Except for 57-type chipbreaker inserts
**RE: Standard corner radius

SPARE PARTS

Designation	Clamp	Lever	Piston	Clamp screw	Shim	Spring	Spring pin	Wrench1	Wrench2
DWLNR/L**06	DCPM-33	LCL33	DPIS33	DLCS33	LSW312	BP-9	LSP3	P-2.5	P-3
DWLNR/L**08	DCPM-43	DLCL43	DPIS43	DLCS43	LSW42	BP-10	LSP4	P-3	P-4

INSERT SELECTION

P

Application	Precision finishing	Finishing	Medium cutting	Medium to heavy cutting
Grade	NS9530	GT9530	T9215	T9215
Chipbreaker shape	TF	TSF	TM	TH
Cutting conditions	B008			

M

Application	Finishing	Medium cutting	Medium to heavy cutting
Grade	T6120	T6130	T6130
Chipbreaker shape	SF	SM	SH
Cutting conditions	B010		

K

Application	Finishing	Medium cutting	Medium to heavy cutting
Grade	T515	T515	T515
Chipbreaker shape	All-round	All-round	All-round
Cutting conditions	B012		

S

Application	Precision finishing	Finishing	Medium cutting
Grade	BX480	AH8005	AH8005
Chipbreaker shape	T-CBN	HRF	HRM
Cutting conditions	B016		

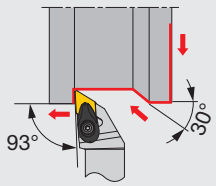
H

Application	Precision finishing	Finishing
Grade	BXM10	BXM20
Chipbreaker shape	T-CBN	T-CBN
Cutting conditions	B018	

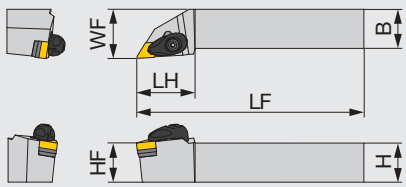
Reference pages: DWLNR/L: Inserts → B101 -, CBN → B181

ADJNR/L-Eco

Double-clamp toolholder with 93° approach angle, for negative 55° rhombic inserts



Cutting edge style **J**



Right hand (R) shown.

Inch	H	B	LF	LH	HF	WF	RE**	Insert	Torque
ADJNR/L1233-A	0.750	0.750	4.500	1.250	0.750	1.000	0.031	DN**33...	2.2
ADJNR/L1633-A	1.000	1.000	6.000	1.250	1.000	1.250	0.031	DN**33...	2.2

Metric	H	B	LF	LH	HF	WF	RE**	Insert	Torque*
ADJNR/L2020K1104-A	20	20	125	30	20	25	0.8	DN**1104...	3
ADJNR/L2525M1104-A	25	25	150	30	25	32	0.8	DN**1104...	3

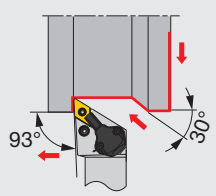
Torque: Recommended clamping torque: lbs·ft (*N·m) **RE: Standard corner radius

SPARE PARTS

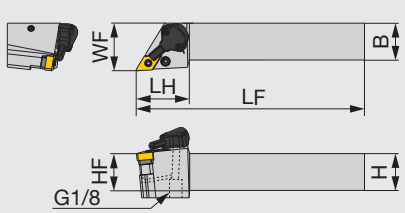
Designation	Clamp	Clamp screw	Spring	Spring pin	Shim	Shim screw	Wrench
ADJNR/L**-A	ACP3S-E	ACS-5W	BP-7	SP-2.5	ASD322	CSTB-3.5	T-15F

PDJNR/L-CHP-Eco

Lever-lock toolholder with 93° approach angle, for negative 55° rhombic inserts, with high pressure coolant capability



Cutting edge style **J**



Right hand (R) shown.

Inch	H	B	LF	LH	HF	WF	RE**	Insert	Torque
PDJNR/L1233-CHP	0.750	0.750	4.500	1.420	0.750	1.250	0.031	DN**33...	1.5
PDJNR/L1633-CHP	1.000	1.000	6.000	1.125	1.000	1.250	0.031	DN**33...	1.5

Metric	H	B	LF	LH	HF	WF	RE**	Insert	Torque*
PDJNR/L2020K1104-CHP	20	20	125	36	20	32	0.8	DN**1104...	2
PDJNR/L2525M1104-CHP	25	25	150	36	25	32	0.8	DN**1104...	2

Torque: Recommended clamping torque: lbs·ft (*N·m) **RE: Standard corner radius

SPARE PARTS

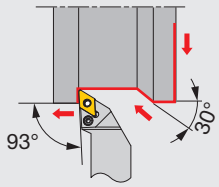
Designation	Shim	Clamping screw	Wrench1	Spring pin	Lever
PDJNR/L**-CHP	ELSD32	LCS3	P-2.5	LSP3	LCL33L

SPARE PARTS

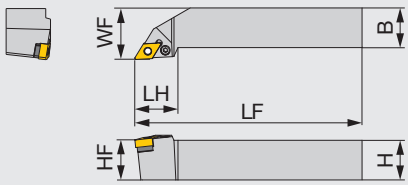
Designation	Coolant unit	Mounting screw	Wrench2	O-ring	Coolant screw	Wrench3
PDJNR/L**-CHP	CU-D-CHP	SRM3	T-8F	OR6.4X0.9N	SRM4X4TL360	P-2

Reference pages: ADJNR/L-Eco, PDJNR/L-CHP-Eco: Inserts → B067 -
Parts for coolant hose→ C142

Lever-lock toolholder with 93° approach angle, for negative 55° rhombic inserts



Cutting edge style **J**



Right hand (R) shown.

Inch	H	B	LF	LH	HF	WF	RE**	Insert	Torque
PDJNR/L1033	0.625	0.625	4.000	1.125	0.625	0.875	0.031	DN**33...	1.5
PDJNR/L1233	0.750	0.750	4.500	1.125	0.750	1.000	0.031	DN**33...	1.5
PDJNR/L1633	1.000	1.000	6.000	1.125	1.000	1.250	0.031	DN**33...	1.5

Metric	H	B	LF	LH	HF	WF	RE**	Insert	Torque*
PDJNR/L1616H1104	16	16	100	27	16	20	0.8	DN**1104...	2
PDJNR/L2020K1104	20	20	125	27	20	25	0.8	DN**1104...	2
PDJNR/L2525M1104	25	25	150	27	25	32	0.8	DN**1104...	2

Torque: Recommended clamping torque: lbs·ft (*N·m) **RE: Standard corner radius

SPARE PARTS

Designation	Shim	Clamping screw	Wrench	Spring pin	Lever
PDJNR/L...	ELSD32	LCS3	P-2.5	LSP3	LCL33L

INSERT SELECTION

P

Application	Finishing	Medium cutting
Grade	T9215	T9215
Chipbreaker shape	TSF	TM
Cutting conditions	B008	

M

Application	Finishing	Medium cutting
Grade	T6120	T6130
Chipbreaker shape	SS	SM
Cutting conditions	B010	

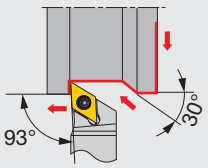
K

Application	Medium cutting
Grade	T515
Chipbreaker shape	TM
Cutting conditions	B012

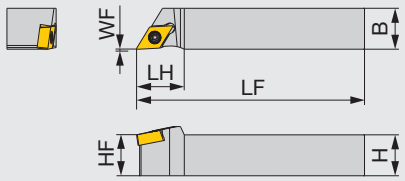
Reference pages: PDJNR/L-Eco: Inserts → B067 -
Parts for coolant hose→ C142

JSDJ2XR/L

Screw-on toolholder with 93° approach angle, for DXGU inserts



Cutting edge style **J2**



Without offset

Right hand (R) shown.

Inch	H	B	LF	LH	HF	WF	RE**	Insert	Torque
JSDJ2XR/L062	0.375	0.375	4.750	0.625	0.375	0	0.008	DXGU0703**L/R...	0.66
JSDJ2XR/L082	0.500	0.500	4.750	0.625	0.500	0	0.008	DXGU0703**L/R...	0.66
JSDJ2XR/L102	0.625	0.625	4.750	0.625	0.625	0	0.008	DXGU0703**L/R...	0.66

Metric	H	B	LF	LH	HF	WF	RE**	Insert	Torque*
JSDJ2XR/L1010X07	10	10	120	14	10	0	0.2	DXGU0703**L/R...	0.9
JSDJ2XR/L1212F07	12	12	85	14	12	0	0.2	DXGU0703**L/R...	0.9
JSDJ2XR/L1212X07	12	12	120	14	12	0	0.2	DXGU0703**L/R...	0.9
JSDJ2XR/L1616X07	16	16	120	18	16	0	0.2	DXGU0703**L/R...	0.9
JSDJ2XR/L2020H07	20	20	100	18	20	0	0.2	DXGU0703**L/R...	0.9

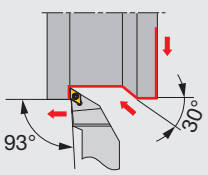
Torque: Recommended clamping torque: lbs·ft (*N·m) **RE: Standard corner radius
Use right-hand toolholders (R) with left-hand inserts (L); and left-hand toolholders (L) with right-hand inserts (R).

SPARE PARTS

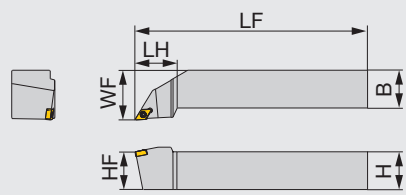
Designation	Clamping screw	Wrench
JSDJ2XR/L...	SR34-514	T-7F

JSDJXR/L

Screw-on toolholder with 93° approach angle, for DXGU inserts



Cutting edge style **J**



Right hand (R) shown.

Inch	H	B	LF	LH	HF	WF	RE**	Insert	Torque
JSDJXR/122	0.750	0.750	4.500	1.125	0.750	1.000	0.008	DXGU0703**L/R...	0.66
JSDJXR/162	1.000	1.000	6.000	1.125	1.000	1.250	0.008	DXGU0703**L/R...	0.66

Metric	H	B	LF	LH	HF	WF	RE**	Insert	Torque*
JSDJXR/L2020K07	20	20	125	27	20	25	0.4	DXGU0703**L/R...	0.9
JSDJXR/L2525M07	25	25	150	27	25	32	0.4	DXGU0703**L/R...	0.9

Torque: Recommended clamping torque: lbs·ft (*N·m) **RE: Standard corner radius
Use right-hand toolholders (R) with left-hand inserts (L); and left-hand toolholders (L) with right-hand inserts (R).

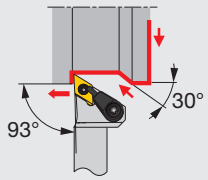
SPARE PARTS

Designation	Clamping screw	Wrench
JSDJXR/L...	SR34-514	T-7F

Reference pages: JSDJ2XR/L, JSDJXR/L: Inserts → B127 -
Standard cutting conditions → C143

JSDJ2XR/L-CHP

Screw-on toolholder with 93° approach angle, for DXGU inserts, with high pressure coolant capability



Cutting edge style **J2**

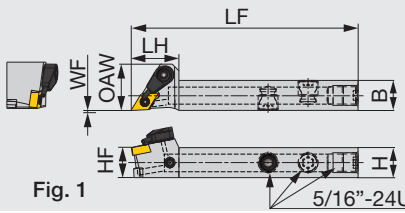


Fig. 1

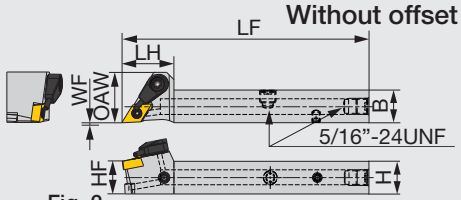


Fig. 2

Right hand (R) shown.

Inch	H	B	LF	LH	HF	WF	OAW	RE**	Insert	Torque	Fig.
JSDJ2XR/L082-CHP	0.500	0.500	3.344	0.750	0.500	0	0.730	0.008	DXGU0703**L/R...	0.66	1
JSDJ2XR082X-CHP(1)	0.500	0.500	4.750	0.748	0.500	0	0.728	0.008	DXGU0703**L...	0.66	2
JSDJ2XR102X-CHP(1)	0.625	0.625	4.750	0.748	0.625	0	0.728	0.008	DXGU0703**L...	0.66	2

Metric	H	B	LF	LH	HF	WF	OAW	RE**	Insert	Torque*	Fig.
JSDJ2XR/L1212F07-CHP	12	12	85	19	12	0	18.5	0.2	DXGU0703**L/R...	0.9	1
JSDJ2XR1212X07-CHP(1)	12	12	120	19	12	0	18.5	0.2	DXGU0703**L...	0.9	2
JSDJ2XR1616X07-CHP(1)	16	16	120	19	16	0	18.5	0.2	DXGU0703**L...	0.9	2

Torque: Recommended clamping torque: lbs·ft (*N·m) **RE: Standard corner radius
Use right-hand toolholders (R) with left-hand inserts (L); and left-hand toolholders (L) with right-hand inserts (R).
(1) Compatible to the direct internal coolant supply system without the use of external coolant hose.

SPARE PARTS



Designation	Clamping screw	Coolant unit	Wrench
JSDJ2XR/L**-CHP	SR34-514	S-CU-CHP	T-7F

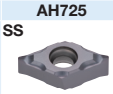
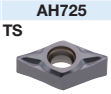
INSERT SELECTION

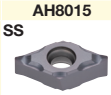
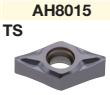
Swiss lathes

P	Application	Finishing	Medium cutting
	Grade	SH725	AH725
	Chipbreaker shape	JSS 	JTS 
	Cutting conditions	C143	

M	Application	Finishing	Medium cutting
	Grade	SH725	AH725
	Chipbreaker shape	JSS 	JTS 
	Cutting conditions	C143	

Small CNC lathes

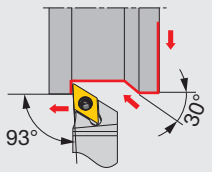
P	Application	Finishing	Medium cutting
	Grade	AH725	AH725
	Chipbreaker shape	SS 	TS 
	Cutting conditions	C143	

M	Application	Finishing	Medium cutting
	Grade	AH8015	AH8015
	Chipbreaker shape	SS 	TS 
	Cutting conditions	C143	

Reference pages: JSDJ2XR/L-CHP: Inserts → B127 -
Standard cutting conditions → C143

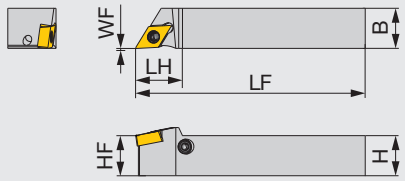
JPDJ2XR/L

Back-clamp toolholder with 93° approach angle, for DXGU inserts



Cutting edge style **J2**

Without offset



Right hand (R) shown.

Inch	H	B	LF	LH	HF	WF	RE**	Insert	Torque
JPDJ2XR/L062	0.375	0.375	4.750	0.625	0.375	0	0.008	DXGU0703**L/R...	0.66
JPDJ2XR/L082	0.500	0.500	4.750	0.625	0.500	0	0.008	DXGU0703**L/R...	0.66
JPDJ2XR/L102	0.625	0.625	4.750	0.625	0.625	0	0.008	DXGU0703**L/R...	0.66

Metric	H	B	LF	LH	HF	WF	RE**	Insert	Torque*
JPDJ2XR/L1010X07	10	10	120	14	10	0	0.2	DXGU0703**L/R...	0.9
JPDJ2XR/L1212F07	12	12	85	14	12	0	0.2	DXGU0703**L/R...	0.9
JPDJ2XR/L1212X07	12	12	120	14	12	0	0.2	DXGU0703**L/R...	0.9
JPDJ2XR/L1616X07	16	16	120	18	16	0	0.2	DXGU0703**L/R...	0.9

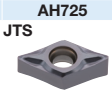
Torque: Recommended clamping torque: lbs·ft (*N·m) **RE: Standard corner radius
Use right-hand toolholders (R) with left-hand inserts (L); and left-hand toolholders (L) with right-hand inserts (R).

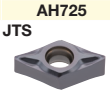
SPARE PARTS

Designation	Lever	Pin	Clamping screw	Wrench
JPDJ2XR/L...	SLLV-2	SL-PI-2	SR10400611	HW2.0/5RED

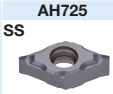
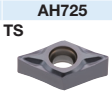
INSERT SELECTION

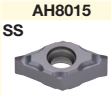
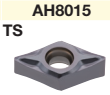
Swiss lathes

P	Application	Finishing	Medium cutting
	Grade	SH725	AH725
	Chipbreaker shape	JSS 	JTS 
	Cutting conditions	C143	

M	Application	Finishing	Medium cutting
	Grade	SH725	AH725
	Chipbreaker shape	JSS 	JTS 
	Cutting conditions	C143	

Small CNC lathes

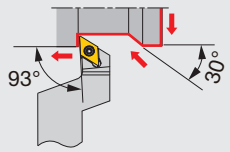
P	Application	Finishing	Medium cutting
	Grade	AH725	AH725
	Chipbreaker shape	SS 	TS 
	Cutting conditions	C143	

M	Application	Finishing	Medium cutting
	Grade	AH8015	AH8015
	Chipbreaker shape	SS 	TS 
	Cutting conditions	C143	

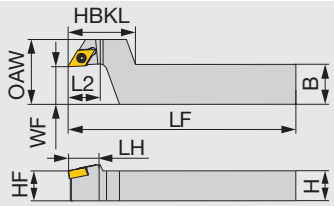
Reference pages: JPDJ2XR/L: Inserts → B127 -
Standard cutting conditions → C143

JSDJXR-F

Screw-on stepped-head toolholder with 93° approach angle, for DXGU inserts



Cutting edge style **J**



Right hand (R) shown.

Inch	H	B	LF	L2	HBKL	LH	HF	WF	OAW	RE**	Insert	Torque
JSDJXR082-F10	0.500	0.625	4.750	0.500	1.125	0.625	0.500	0.625	1	0.008	DXGU0703**L...	0.66
JSDJXR102-F10	0.625	0.750	4.750	0.500	1.125	0.625	0.625	0.625	1	0.008	DXGU0703**L...	0.66

Metric	H	B	LF	L2	HBKL	LH	HF	WF	OAW	RE**	Insert	Torque*
JSDJXR1016X07-F15	10	16	120	12	27	14	10	15	26	0.2	DXGU0703**L...	0.9
JSDJXR1216F07-F15	12	16	85	12	27	14	12	15	26	0.2	DXGU0703**L...	0.9
JSDJXR1216X07-F15	12	16	120	12	27	14	12	15	26	0.2	DXGU0703**L...	0.9
JSDJXR1620X07-F15	16	20	120	12	27	14	16	15	26	0.2	DXGU0703**L...	0.9

Torque: Recommended clamping torque: lbs·ft (*N·m) **RE: The holder measurements are true with this insert radius
Use the right-hand toolholder (R) for the left-hand insert (L)

SPARE PARTS

Designation	Clamping screw	Wrench
JSDJXR**-F...	SR34-514	T-7F

INSERT SELECTION

Swiss lathes

P

Application	Finishing	Medium cutting
Grade	SH725	AH725
Chipbreaker shape	JSS	JTS
Cutting conditions	C143	

M

Application	Finishing	Medium cutting
Grade	SH725	AH725
Chipbreaker shape	JSS	JTS
Cutting conditions	C143	

Small CNC lathes

P

Application	Finishing	Medium cutting
Grade	AH725	AH725
Chipbreaker shape	SS	TS
Cutting conditions	C143	

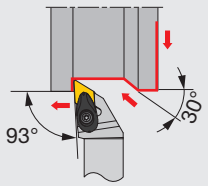
M

Application	Finishing	Medium cutting
Grade	AH8015	AH8015
Chipbreaker shape	SS	TS
Cutting conditions	C143	

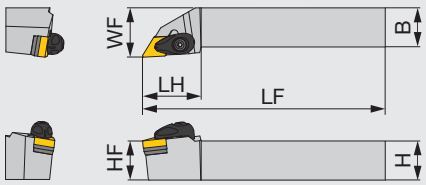
Reference pages: JSDJXR-F: Inserts → B127 -
Standard cutting conditions → C143

ADJNR/L

Double-clamp toolholder with 93° approach angle, for negative 55° rhombic inserts



Cutting edge style **J**



Right hand (R) shown.

Inch	H	B	LF	LH	HF	WF	RE**	Insert	Torque
ADJNR/L124-A	0.750	0.750	4.500	1.500	0.750	1.000	0.031	DN**43...	2.2
ADJNR/L164-A	1.000	1.000	6.000	1.500	1.000	1.250	0.031	DN**43...	2.2
ADJNR/L204-A	1.250	1.250	7.000	1.500	1.250	1.500	0.031	DN**43...	2.2

Metric	H	B	LF	LH	HF	WF	RE**	Insert	Torque*
ADJNR/L2020K15-A	20	20	125	36	20	25	0.8	DN**1504...	3
ADJNR/L2020K1506-A	20	20	125	36	20	25	0.8	DN**1506...	3
ADJNR/L2525M15-A	25	25	150	36	25	32	0.8	DN**1504...	3
ADJNR/L2525M1506-A	25	25	150	36	25	32	0.8	DN**1506...	3
ADJNR/L3225P15-A	32	25	170	36	32	32	0.8	DN**1504...	3

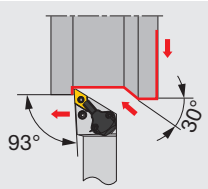
Torque: Recommended clamping torque: lbs·ft (*N·m) **RE: Standard corner radius

SPARE PARTS

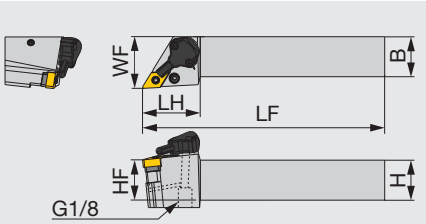
Designation	Clamp	Clamp screw	Spring	Spring pin	Shim	Shim screw	Wrench
ADJNR/L**15-A	ACP4S	ACS-5W	BP-7	SP-2.5	ASD432	CSTB-3.5	T-15F
ADJNR/L**4-A, 1506-A	ACP4S	ACS-5W	BP-7	SP-2.5	ASD423	CSTB-3.5	T-15F

PDJNR/L-CHP

Lever-lock toolholder, for negative 55° rhombic inserts, with high pressure coolant capability



Cutting edge style **J**



Right hand (R) shown.

Inch	H	B	LF	LH	HF	WF	RE**	Insert	Torque
PDJNR/L124-CHP	0.750	0.750	4.500	1.420	0.750	1.250	0.031	DN**43...	2.2
PDJNR/L164-CHP	1.000	1.000	6.000	1.420	1.000	1.250	0.031	DN**43...	2.2

Metric	H	B	LF	LH	HF	WF	RE**	Insert	Torque*
PDJNR/L2020K15-CHP	20	20	125	36	20	32	0.8	DN**1504...	3
PDJNR/L2525M15-CHP	25	25	150	36	25	32	0.8	DN**1504...	3

Torque: Recommended clamping torque: lbs·ft (*N·m) **RE: Standard corner radius

SPARE PARTS

Designation	Shim	Clamping screw	Wrench1	Spring pin	Lever
PDJNR/L**4-CHP, PDJNR/L**15-CHP	LSD43A	LCS4	P-3	LSP4	LCL4

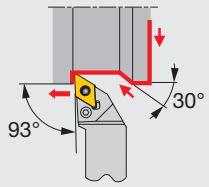
SPARE PARTS

Designation	Coolant unit	Mounting screw	Wrench2	O-ring	Coolant screw	Wrench3
PDJNR/L**4-CHP, PDJNR/L**15-CHP	CU-D-CHP	SRM3	T-8F	OR6.4X0.9N	SRM4X4TL360	P-2

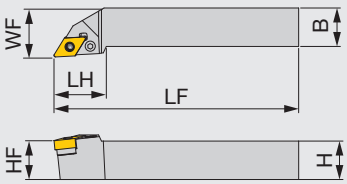
Reference pages: ADJNR/L, PDJNR/L-CHP: Inserts → B067 -, CBN → B174 -, PCD → B194 -
Parts for coolant hose → C142

PDJNR/L

Lever-lock toolholder with 93° approach angle, for negative 55° rhombic inserts



Cutting edge style **J**



Right hand (R) shown.

Metric	H	B	LF	LH	HF	WF	RE**	Insert
PDJNR/L1616H11	16	16	100	27	16	20	0.8	DN**1104...
PDJNR/L2020K11	20	20	125	27	20	25	0.8	DN**1104...
PDJNR/L2020	20	20	125	34	20	25	0.8	DN**1504...
PDJNR2020K15E	20	20	125	36	20	25	0.8	DN**1506...
PDJNR/L2520	25	20	150	34	25	25	0.8	DN**1504...
PDJNR/L2525M11	25	25	150	27	25	32	0.8	DN**1104...
PDJNR/L2525	25	25	150	34	25	32	0.8	DN**1504...
PDJNR/L2525M15E	25	25	150	36	25	32	0.8	DN**1506...
PDJNR/L3225	32	25	170	32	32	32	0.8	DN**1504...
PDJNR3225P15E	32	25	170	36	32	34	0.8	DN**1506...

**RE: Standard corner radius

SPARE PARTS

Designation	Shim	Clamping screw	Wrench	Spring pin	Lever
PDJNR/L*****11	ELSD32	LCS3	P-2.5	LSP3	LCL33L
PDJNR/L2020	LSD42	LCS4	P-3	LSP4	LCL4
PDJNR2020K15E	ELSD42	ELCS4	P-3	LSP4S	LCL44
PDJNR/L2520	LSD42	LCS4	P-3	LSP4	LCL4
PDJNR/L2525	LSD42	LCS4	P-3	LSP4	LCL4
PDJNR/L2525M15E	ELSD42	ELCS4	P-3	LSP4S	LCL44
PDJNR/L3225	LSD42	LCS4	P-3	LSP4	LCL4
PDJNR3225P15E	ELSD42	ELCS4	P-3	LSP4S	LCL44

INSERT SELECTION

P

Application	Precision finishing	Finishing	Medium cutting	Medium to heavy cutting
Grade	NS9530	GT9530	T9215	T9215
Chipbreaker shape	TF	TSF	TM	TH
Cutting conditions	B008			

M

Application	Finishing	Medium cutting	Medium to heavy cutting
Grade	T6120	T6130	T6130
Chipbreaker shape	SF	SM	SH
Cutting conditions	B010		

K

Application	Finishing	Medium cutting	Medium to heavy cutting
Grade	T515	T515	T515
Chipbreaker shape	All-round	All-round	All-round
Cutting conditions	B012		

N

Application	Precision finishing	Finishing	Medium cutting
Grade	DX120	DX140	TH10
Chipbreaker shape	T-DIA with rake	T-DIA	P
Cutting conditions	B014		

S

Application	Precision finishing	Finishing	Medium cutting
Grade	BX470	AH8005	AH8005
Chipbreaker shape	T-CBN	HRF	HRM
Cutting conditions	B016		

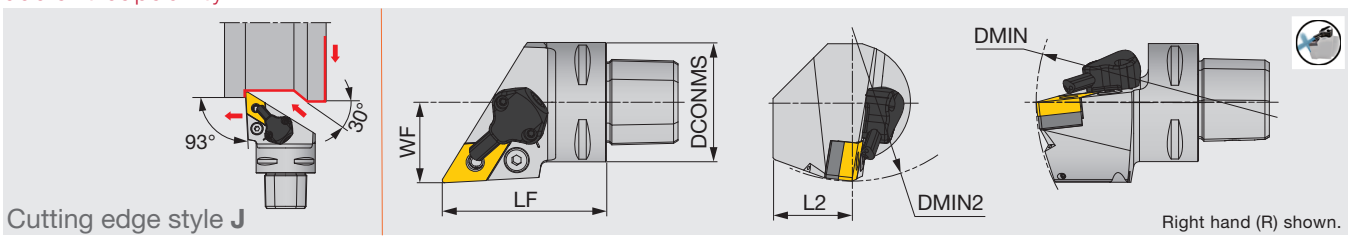
H

Application	Precision finishing	Finishing
Grade	BXM10	BXM20
Chipbreaker shape	T-CBN	T-CBN
Cutting conditions	B018	

Reference pages: PDJNR/L: Inserts → B067 -, CBN → B174 -, PCD → B194 -

C-PDJNR/L-CHP

Lever-lock toolholder with TungCap connection, for negative 55° rhombic inserts, with high pressure coolant capability



Cutting edge style **J**

Right hand (R) shown.

Metric	DCONMS	LF	L2	WF	DMIN	DMIN2	RE**	Insert
C4PDJNR/L27055-1104-CHP	40	55	25	27	140	110	0.8	DN**1104...
C4PDJNR/L27055-15-CHP	40	55	25	27	140	110	0.8	DN**1504(06)...
C5PDJNR/L35060-15-CHP	50	60	32	35	165	110	0.8	DN**1504(06)...
C6PDJNR/L45065-1104-CHP	63	65	41	45	190	110	0.8	DN**1104...
C6PDJNR/L45065-15-CHP	63	65	41	45	190	110	0.8	DN**1504(06)...

**RE: Standard corner radius

SPARE PARTS

Designation	Shim	Clamping screw	Wrench 1	Spring pin	Lever
C*PDJNR/L**1104-CHP	ELSD32	LCS3	P-2.5	LSP3	LCL33L
C*PDJNR/L**-15-CHP	LSD43A	LCS4	P-3	LSP4	LCL4

Option: LSD42A (Shim for DN**1506...), LSP4S (Spring pin for DN**1506...)

SPARE PARTS

Designation	Coolant unit	Coolant screw	Wrench 2	Wrench 3
C*PDJNR/L**1104-CHP	CU-D-CHP	SRM4X4TL360	T-8F	P-2
C*PDJNR/L**-15-CHP	CU-D-CHP	SRM4X4TL360	T-8F	P-2

INSERT SELECTION

P

Application	Precision finishing	Finishing	Medium cutting	Medium to heavy cutting
Grade	NS9530	GT9530	T9215	T9215
Chipbreaker shape	TF	TSF	TM	TH
Cutting conditions	B008			

M

Application	Finishing	Medium cutting	Medium to heavy cutting
Grade	T6120	T6130	T6130
Chipbreaker shape	SF	SM	SH
Cutting conditions	B010		

K

Application	Finishing	Medium cutting	Medium to heavy cutting
Grade	T515	T515	T515
Chipbreaker shape	All-round	All-round	All-round
Cutting conditions	B012		

N

Application	Precision finishing	Finishing	Medium cutting
Grade	DX120	DX140	TH10
Chipbreaker shape	T-DIA with rake	T-DIA	P
Cutting conditions	B014		

S

Application	Precision finishing	Finishing	Medium cutting
Grade	BX470	AH8005	AH8005
Chipbreaker shape	T-CBN	HRF	HRM
Cutting conditions	B016		

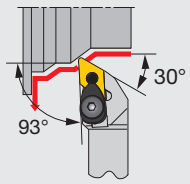
H

Application	Precision finishing	Finishing
Grade	BXM10	BXM20
Chipbreaker shape	T-CBN	T-CBN
Cutting conditions	B018	

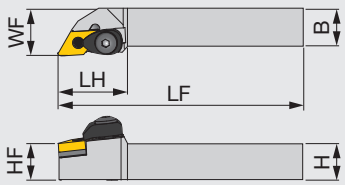
Reference pages: C-PDJNR/L-CHP: Inserts → B067 -, CBN → B174 -, PCD → B194 -
Parts for coolant hose → C142

DDJNR/L

One-Double toolholder with 93° approach angle, for negative 55° rhombic inserts



Cutting edge style **J**



Right hand (R) shown.

Metric	H	B	LF	LH	HF	WF	RE**	Insert
DDJNR/L2020K15	20	20	125	38	20	25	0.8	DN**1504...
DDJNR/L2020K1506	20	20	125	38	20	25	0.8	DN**1506...
DDJNR/L2525M15	25	25	150	38	25	32	0.8	DN**1504...
DDJNR/L2525M1506	25	25	150	38	25	32	0.8	DN**1506...
DDJNR/L3225P15	32	25	170	38	32	32	0.8	DN**1504...
DDJNR/L3225P1506	32	25	170	38	32	32	0.8	DN**1506...

Except for 57-type chipbreaker inserts
**RE: Standard corner radius

SPARE PARTS

Designation	Clamp	Lever	Piston	Clamp screw	Shim	Spring	Spring pin	Wrench1	Wrench2
DDJNR/L**15	DCPM-43	DLCL43	DPIS43	DLCS43	LSD42	BP-10	LSP4	P-3	P-4
DDJNR/L**1506	DCPM-43	DLCL43	DPIS44	DLCS43	LSD42	BP-10	LSP4	P-3	P-4

INSERT SELECTION

P

Application	Precision finishing	Finishing	Medium cutting	Medium to heavy cutting
Grade	NS9530	GT9530	T9215	T9215
Chipbreaker shape	TF	TSF	TM	TH
Cutting conditions	B008			

M

Application	Finishing	Medium cutting	Medium to heavy cutting
Grade	T6120	T6130	T6130
Chipbreaker shape	SF	SM	SH
Cutting conditions	B010		

K

Application	Finishing	Medium cutting	Medium to heavy cutting
Grade	T515	T515	T515
Chipbreaker shape	All-round	All-round	All-round
Cutting conditions	B012		

N

Application	Precision finishing	Finishing	Medium cutting
Grade	DX120	DX140	TH10
Chipbreaker shape	T-DIA with rake	T-DIA	P
Cutting conditions	B014		

S

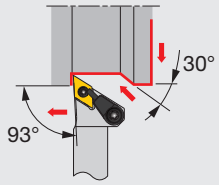
Application	Precision finishing	Finishing	Medium cutting
Grade	BX470	AH8005	AH8005
Chipbreaker shape	T-CBN	HRF	HRM
Cutting conditions	B016		

H

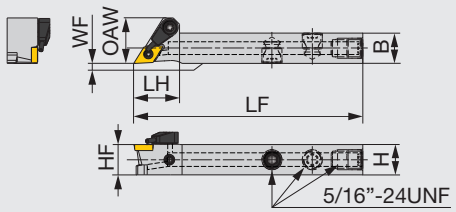
Application	Precision finishing	Finishing
Grade	BXM10	BXM20
Chipbreaker shape	T-CBN	T-CBN
Cutting conditions	B018	

Reference pages: DDJNR/L: Inserts → B067 -, CBN → B174 -, PCD → B194 -

Screw-on toolholder with 93° approach angle, for positive 55° rhombic inserts, with high pressure coolant capability



Cutting edge style **J2**



Without offset

Right hand (R) shown.

Inch	H	B	LF	LH	HF	WF	OAW	RE**	Insert	Torque
JSDJ2CR/L082-CHP	0.500	0.500	3.344	0.710	0.500	0	0.710	0.008	DC**21.5...	0.89
JSDJ2CR083X-CHP	0.500	0.500	4.750	0.748	0.500	0	0.807	0.008	DC**32.5...	0.89
JSDJ2CR103X-CHP	0.625	0.625	4.750	0.748	0.625	0	0.807	0.008	DC**32.5...	0.89

Metric	H	B	LF	LH	HF	WF	OAW	RE**	Insert	Torque*
JSDJ2CR/L1212F07-CHP	12	12	85	18	12	0	18	0.2	DC**0702...	1.2
JSDJ2CR/L1212F11-CHP	12	12	85	19	12	0	20.5	0.2	DC**11T3...	1.2
JSDJ2CR1212X11-CHP	12	12	120	19	12	0	20.5	0.2	DC**11T3...	1.2
JSDJ2CR1616X11-CHP	16	16	120	19	16	0	20.5	0.2	DC**11T3...	1.2

Torque: Recommended clamping torque: lbs·ft (*N·m)
**RE: Standard corner radius

SPARE PARTS

Designation	Clamping screw	Coolant unit	Wrench1	Coolant plug	Wrench2	DirectJet plug	Wrench3
JSDJ2CR/L082-CHP, JSDJ2CR/L1212F07-CHP	CSTB-2.5	S-CU-CHP	T-8F	-	-	-	-
JSDJ2CR/L1212F11-CHP	CSTB-4SD	S-CU-CHP	T-8F	-	-	-	-
JSDJ2CR**3X-CHP, JSDJ2CR**X11-CHP	CSTB-4SD	S-CU-CHP	T-8F	SR5/16UNFTL360	P-4	SSHM4-6-TB	P-2

INSERT SELECTION

P

Application	Finishing	Finishing to medium cutting	Medium cutting
Grade	NS9530	T9215	T9215
Chipbreaker shape	PSS	PS	PM
Cutting conditions	B020		

M

Application	Precision finishing	Finishing	Finishing to medium cutting	Medium cutting
Grade	GH330	AH725	AH630	T6130
Chipbreaker shape	W**	PSF	PSS	PM
Cutting conditions	B022			

K

Application	Finishing to medium cutting
Grade	T515
Chipbreaker shape	CM
Cutting conditions	B024

N

Application	Precision finishing	Finishing	Medium cutting
Grade	DX120	DX140	KS05F
Chipbreaker shape	T-DIA (with rake)	T-DIA	AL
Cutting conditions	B026		

S

Application	Finishing	Finishing to medium cutting
Grade	AH8015	AH8015
Chipbreaker shape	PSS	PS
Cutting conditions	B028	

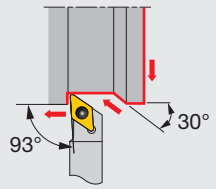
H

Application	Precision finishing	Finishing
Grade	BXM10	BXM20
Chipbreaker shape	T-CBN	T-CBN
Cutting conditions	B030	

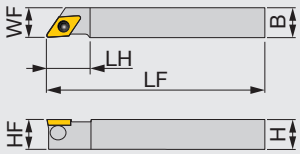
Reference pages: JSDJ2CR/L-CHP: Inserts → B121 -, CBN → B184 -, PCD → B196 -
Parts for coolant hose → C142

JTDJ2CR/L

Back-clamp toolholder with 93° approach angle, for positive 55° rhombic inserts

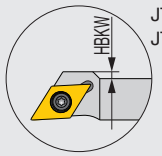


Cutting edge style **J2**



Without offset

JTDJ2CR/L1212F11
JTDJ2CR/L1212X11



Right hand (R) shown.

Metric	H	B	LF	LH	HF	WF	HBKW	RE**	Insert	Torque
JTDJ2CR/L1010X07	10	10	120	14	10	10	-	0.2	DC**0702...	0.9
JTDJ2CR/L1212F07	12	12	85	14	12	12	-	0.2	DC**0702...	0.9
JTDJ2CR/L1212X07	12	12	120	14	12	12	-	0.2	DC**0702...	0.9
JTDJ2CR/L1212F11	12	12	85	20	12	12	2	0.2	DC**11T3...	1.2
JTDJ2CR/L1212X11	12	12	120	20	12	12	2	0.2	DC**11T3...	1.2
JTDJ2CR/L1616X11	16	16	120	20	16	16	-	0.2	DC**11T3...	1.2

Torque: Recommended clamping torque: N·m
**RE: Standard corner radius

SPARE PARTS

Designation	Clamp	Clamping screw	Wrench
JTDJ2CR/L**07	JCP-2	JDS-3525	P-2F
JTDJ2CR/L**11	JCP-3	JDS-5040	P-2.5F

INSERT SELECTION

P

Application	Precision finishing	Finishing	Finishing to medium cutting	Medium cutting
Grade	SH725	SH725	T9215	T9215
Chipbreaker shape	01	JS	PS	PM
Cutting conditions	B020			

M

Application	Precision finishing	Finishing	Finishing to medium cutting	Medium cutting
Grade	SH725	SH725	T9215	T9215
Chipbreaker shape	01	JS	PS	PM
Cutting conditions	B022			

K

Application	Finishing to medium cutting
Grade	T515
Chipbreaker shape	CM
Cutting conditions	B024

N

Application	Precision finishing	Medium cutting
Grade	DX120	KS05F
Chipbreaker shape	T-DIA with rake	AL
Cutting conditions	B026	

S

Application	Precision finishing	Finishing to medium cutting
Grade	BX470	AH8005
Chipbreaker shape	T-CBN	PS
Cutting conditions	B028	

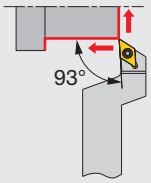
H

Application	Precision finishing	Finishing
Grade	BXM10	BXM20
Chipbreaker shape	T-CBN	T-CBN
Cutting conditions	B030	

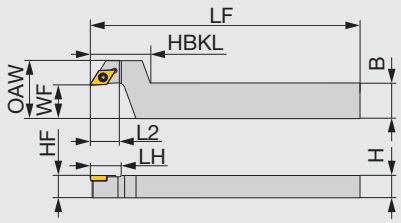
Reference pages: JTDJ2CR/L: Inserts → B121 -, CBN → B184 -, PCD → B196 -

JSDJCR-F

Screw-on stepped-head toolholder with 93° approach angle, for positive 55° rhombic inserts



Cutting edge style **J**



Right hand (R) shown.

Metric	H	B	LF	L2	HBKL	LH	HF	WF	OAW	RE**	Insert	Torque
JSDJCR1016X07-F15	10	16	120	12.5	27	14	10	15	26	0.2	DC**0702...	1.2
JSDJCR1216F07-F15	12	16	85	12.5	27	14	12	15	26	0.2	DC**0702...	1.2
JSDJCR1216X07-F15	12	16	120	12.5	27	14	12	15	26	0.2	DC**0702...	1.2
JSDJCR1216F11-F15	12	16	85	12.5	27	20	12	15	28	0.2	DC**11T3...	1.2
JSDJCR1216X11-F15	12	16	120	12.5	27	20	12	15	28	0.2	DC**11T3...	1.2
JSDJCR1620X11-F15	16	20	120	12.5	27	20	16	15	28	0.2	DC**11T3...	1.2

Torque: Recommended clamping torque: N·m
**RE: Standard corner radius

SPARE PARTS

Designation	Clamping screw	Wrench
JSDJCR**07-F15	CSTB-2.5	T-8F
JSDJCR**11-F15	CSTB-4SD	T-8F

INSERT SELECTION

P

Application	Precision finishing	Finishing	Finishing to medium cutting	Medium cutting
Grade	SH725	SH725	T9215	T9215
Chipbreaker shape	01	JS	PS	PM
Cutting conditions	B020			

M

Application	Precision finishing	Finishing	Finishing to medium cutting	Medium cutting
Grade	SH725	SH725	T9215	T9215
Chipbreaker shape	01	JS	PS	PM
Cutting conditions	B022			

K

Application	Finishing to medium cutting
Grade	T515
Chipbreaker shape	CM
Cutting conditions	B024

N

Application	Precision finishing	Medium cutting
Grade	DX120	KS05F
Chipbreaker shape	T-DIA with rake	AL
Cutting conditions	B026	

S

Application	Precision finishing	Finishing to medium cutting
Grade	BX470	AH8005
Chipbreaker shape	T-CBN	PS
Cutting conditions	B028	

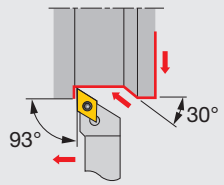
H

Application	Precision finishing	Finishing
Grade	BXM10	BXM20
Chipbreaker shape	T-CBN	T-CBN
Cutting conditions	B030	

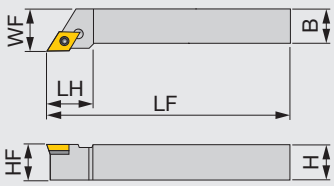
Reference pages: JSDJCR-F: Inserts → B121 -, CBN → B184 -, PCD → B196 -

SDJCR/L

Screw-on toolholder with 93° approach angle, for positive 55° rhombic inserts



Cutting edge style **J**



Right hand (R) shown.

Inch	H	B	LF	LH	HF	WF	RE**	Insert
SDJCR/L 062	0.375	0.375	2.500	0.625	0.375	0.500	0.016	DC**21.5...
SDJCR/L 082	0.500	0.500	3.500	0.625	0.500	0.625	0.016	DC**21.5...
SDJCR/L 083	0.500	0.500	3.500	-	0.500	0.625	0.016	DC**32.5...
SDJCR/L 103	0.625	0.625	4.000	-	0.625	0.750	0.031	DC**32.5...
SDJCR/L 123	0.750	0.750	4.500	-	0.750	1.000	0.031	DC**32.5...
SDJCR/L 163	1.000	1.000	6.000	-	1.000	1.250	0.031	DC**32.5...

Metric	H	B	LF	LH	HF	WF	RE**	Insert
SDJCR1616H11	16	16	100	20	16	20	0.8	DC**11T3...
SDJCR/L2020K11	20	20	125	20.5	20	25	0.8	DC**11T3...
SDJCR/L2525M11	25	25	150	21.5	25	32	0.8	DC**11T3...

**RE: Standard corner radius

SPARE PARTS

Designation	Clamping screw	Shim screw	Shim	Wrench1	Wrench2
SDJCR/L **2	CSTB-2.5	-	-	-	T-8F
SDJCR/L **3, SDJCR/L**11	CSTB-3.5L	DTS5-3.5	SSD32	P-3.5	T-15F

INSERT SELECTION

P

Application	Finishing	Finishing to medium cutting	Medium cutting
Grade	NS9530	T9215	T9215
Chipbreaker shape	PSS	PS	PM
Cutting conditions	B020		

M

Application	Precision finishing	Finishing	Finishing to medium cutting	Medium cutting
Grade	GH330	AH725	AH630	T6130
Chipbreaker shape	W**	PSF	PSS	PM
Cutting conditions	B022			

K

Application	Finishing to medium cutting
Grade	T515
Chipbreaker shape	CM
Cutting conditions	B024

N

Application	Precision finishing	Finishing	Medium cutting
Grade	DX120	DX140	KS05F
Chipbreaker shape	T-DIA with rake	T-DIA	AL
Cutting conditions	B026		

S

Application	Finishing	Finishing to medium cutting
Grade	AH8015	AH8015
Chipbreaker shape	PSS	PS
Cutting conditions	B028	

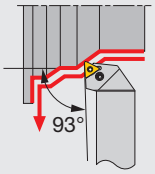
H

Application	Precision finishing	Finishing
Grade	BXM10	BXM20
Chipbreaker shape	T-CBN	T-CBN
Cutting conditions	B030	

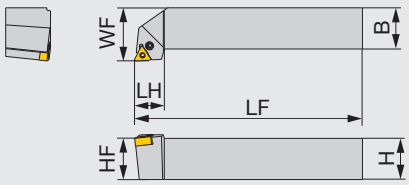
Reference pages: SDJCR/L: Inserts→ B121 -, CBN → B184 -, PCD → B196 -

PTJNR/L-Eco

Lever-lock toolholder with 93° approach angle, for negative triangular inserts



Cutting edge style **J**



Right hand (R) shown.

Metric	H	B	LF	LH	HF	WF	RE**	Insert	Torque
PTJNR/L2525M1104	25	25	150	18	25	32	0.8	TN**1104...	2

Torque: Recommended clamping torque: N·m
**RE: Standard corner radius

SPARE PARTS

Designation	Clamping screw	Wrench	Lever
PTJNR/L2525M1104	LCS23A	P-2.5	LCL23

INSERT SELECTION

P

Application	Finishing	Medium cutting
Grade	T9215	T9215
Chipbreaker shape	TSF	TM
Cutting conditions	B008	

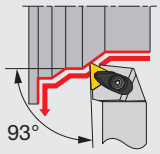
M

Application	Finishing	Medium cutting
Grade	T6120	T6130
Chipbreaker shape	SS	SM
Cutting conditions	B010	

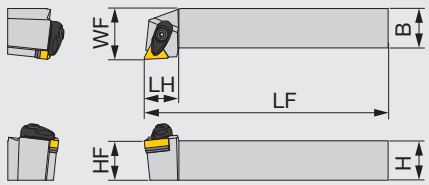
Reference pages: PTJNR/L-Eco: Inserts → B086 -

ATJNR/L

Double-clamp toolholder with 93° approach angle, for negative 60° triangular inserts



Cutting edge style **J**



Right hand (R) shown.

Inch	H	B	LF	LH	HF	WF	RE**	Insert	Torque
ATJNR/L123-A	0.750	0.750	4.500	0.875	0.750	1.000	0.031	TN**33...	2.2
ATJNR/L163-A	1.000	1.000	6.000	0.875	1.000	1.250	0.031	TN**33...	2.2

Metric	H	B	LF	LH	HF	WF	RE**	Insert	Torque*
ATJNR/L2020K16-A	20	20	125	22	20	25	0.8	TN**1604...	3
ATJNR/L2525M16-A	25	25	150	22	25	32	0.8	TN**1604...	3

Torque: Recommended clamping torque: lbs·ft (*N·m) **RE: Standard corner radius

SPARE PARTS

Designation	Clamp	Clamp screw	Spring	Spring pin	Shim	Shim screw	Wrench
ATJNR/L**3-A, 16-A	ACP3S	ACS-5W	BP-7	SP-2.5	AST322	CSTB-3.5	T-15F

INSERT SELECTION

P

Application	Precision finishing	Finishing	Medium cutting	Medium to heavy cutting
Grade	NS9530	GT9530	T9215	T9215
Chipbreaker shape	TF	TSF	TM	TH
Cutting conditions	B008			

M

Application	Finishing	Medium cutting
Grade	T6120	T6130
Chipbreaker shape	SF	SM
Cutting conditions	B010	

K

Application	Finishing	Medium cutting	Medium to heavy cutting
Grade	T515	T515	T515
Chipbreaker shape	All-round	All-round	All-round
Cutting conditions	B012		

N

Application	Precision finishing	Finishing	Medium cutting
Grade	DX120	DX140	TH10
Chipbreaker shape	T-DIA	with rake T-DIA	P
Cutting conditions	B014		

S

Application	Precision finishing	Finishing	Medium cutting
Grade	BX470	AH8005	AH8005
Chipbreaker shape	T-CBN	HRF	HRM
Cutting conditions	B016		

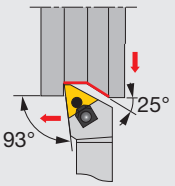
H

Application	Precision finishing	Finishing
Grade	BXM10	BXM20
Chipbreaker shape	T-CBN	T-CBN
Cutting conditions	B018	

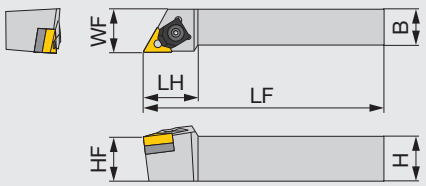
Reference pages: ATJNR/L: Inserts→ B086 -, CBN → B178 -, PCD → B194 -

WTJNR/L

Wedge-on toolholder with 93° approach angle, for negative 60° triangular inserts



Cutting edge style **J**



Right hand (R) shown.

Metric	H	B	LF	LH	HF	WF	RE**	Insert
WTJNR2020	20	20	125	31	20	25	0.8	TN**1604...
WTJNR/L2525M3	25	25	150	31	25	32	0.8	TN**1604...

**RE: Standard corner radius

SPARE PARTS

Designation	Clamp	E-ring	Nut	Pin	Clamping screw	Shim	Wrench
WTJNR2020	WCW3	5103-25	WCN3S	WCP3S	WCS3	WST33	P-3
WTJNR/L2525M3	WCW3	5103-25	WCN3	WCP3S	WCS3	WST33	P-3

INSERT SELECTION

P

Application	Precision finishing	Finishing	Medium cutting	Medium to heavy cutting
Grade	NS9530	GT9530	T9215	T9215
Chipbreaker shape	TF	TSF	TM	TH
Cutting conditions	B008			

M

Application	Finishing	Medium cutting
Grade	T6120	T6130
Chipbreaker shape	SF	SM
Cutting conditions	B010	

K

Application	Finishing	Medium cutting	Medium to heavy cutting
Grade	T515	T515	T515
Chipbreaker shape	All-round	All-round	All-round
Cutting conditions	B012		

N

Application	Precision finishing	Finishing	Medium cutting
Grade	DX120	DX140	TH10
Chipbreaker shape	T-DIA with rake	T-DIA	P
Cutting conditions	B014		

S

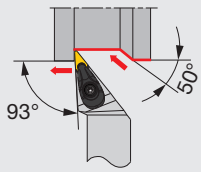
Application	Precision finishing	Finishing	Medium cutting
Grade	BX470	AH8005	AH8005
Chipbreaker shape	T-CBN	HRF	HRM
Cutting conditions	B016		

H

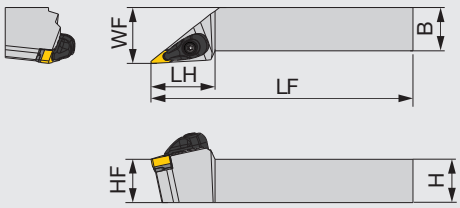
Application	Precision finishing	Finishing
Grade	BXM10	BXM20
Chipbreaker shape	T-CBN	T-CBN
Cutting conditions	B018	

Reference pages: WTJNR/L: Inserts→ B086 -, CBN → B178 -, PCD → B194 -

Double-clamp toolholder with 93° approach angle, for negative 35° rhombic inserts



Cutting edge style **J**



Right hand (R) shown.

Inch	H	B	LF	LH	HF	WF	RE**	Insert	Torque
AVJNR/L122.33-A	0.750	0.750	4.500	1.500	0.750	1.000	0.031	VN**2.33**E...	2.2
AVJNR/L162.33-A	1.000	1.000	6.000	1.500	1.000	1.250	0.031	VN**2.33**E...	2.2

Metric	H	B	LF	LH	HF	WF	RE**	Insert	Torque*
AVJNR/L2020K1204-A	20	20	125	37	20	25	0.8	VN**1204...	3
AVJNR/L2525M1204-A	25	25	150	37	25	32	0.8	VN**1204...	3

Torque: Recommended clamping torque: lbs·ft (*N·m) **RE: Standard corner radius

SPARE PARTS

Designation	Clamp	Clamp screw	Spring	Spring pin	Shim	Shim screw	Wrench
AVJNR/L**-A	ACP3L-E	ACS-5W	BP-7	SP-2.5	ASV222	CSTB-3.0	T-15F

INSERT SELECTION

P

Application	Finishing	Medium cutting
Grade	T9215	T9215
Chipbreaker shape	TSF	TM
Cutting conditions	B008	

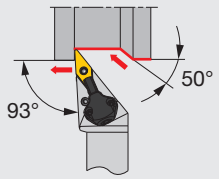
M

Application	Finishing	Medium cutting
Grade	T6120	T6130
Chipbreaker shape	SS	SM
Cutting conditions	B010	

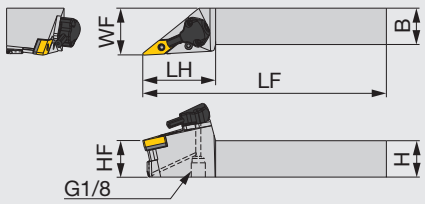
Reference pages: AVJNR/L-Eco: Inserts → B097 -
Parts for coolant hose → C142

PVJNR/L-CHP

Lever-lock toolholder with 93° approach angle, for negative 35° rhombic inserts, with high pressure coolant capability



Cutting edge style **J**



Right hand (R) shown.

Inch	H	B	LF	LH	HF	WF	RE**	Insert	Torque
PVJNR/L122.33-CHP	0.750	0.750	4.500	1.969	0.750	1.250	0.031	VN**2.33**E...	1.5
PVJNR/L162.33-CHP	1.000	1.000	6.000	1.969	1.000	1.250	0.8	VN**2.33**E...	1.5

Metric	H	B	LF	LH	HF	WF	RE**	Insert	Torque*
PVJNR/L2020K1204-CHP	20	20	125	50	20	32	0.8	VN**1204...	2
PVJNR/L2525M1204-CHP	25	25	150	50	25	32	0.8	VN**1204...	2

Torque: Recommended clamping torque: lbs·ft (*N·m) **RE: Standard corner radius

SPARE PARTS

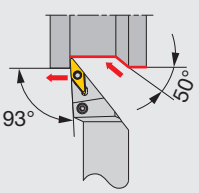
Designation	Shim	Clamping screw	Wrench1	Spring pin	Lever
PVJNR/L**-CHP	LSV212	LCS3V	P-2.5	LSP3	LCL3V

SPARE PARTS

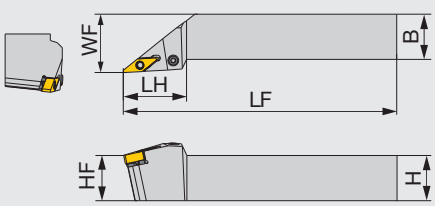
Designation	Coolant unit	Mounting screw	Wrench2	O-ring	Coolant screw	Wrench3
PVJNR/L**-CHP	CU-V-CHP	SRM3	T-8F	OR6.4X0.9N	SRM4X4TL360	P-2

ISOECO TURN PVJNR/L-Eco

Lever-lock toolholder with 93° approach angle, for negative 35° rhombic inserts



Cutting edge style **J**



Right hand (R) shown.

Metric	H	B	LF	LH	HF	WF	RE**	Insert	Torque
PVJNR/L2020K1204	20	20	125	35	20	25	0.8	VN**1204...	2
PVJNR/L2525M1204	25	25	150	35	25	32	0.8	VN**1204...	2

Torque: Recommended clamping torque: N·m **RE: Standard corner radius

SPARE PARTS

Designation	Shim	Clamping screw	Wrench	Spring pin	Lever
PVJNR/L**1204	LSV212	LCS3V	P-2.5	LSP3	LCL3V

INSERT SELECTION

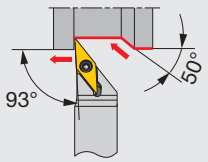
P	Application	Finishing	Medium cutting
	Grade	T9215	T9215
	Chipbreaker shape	TSF	TM
	Cutting conditions	B008	

M	Application	Finishing	Medium cutting
	Grade	T6120	T6130
	Chipbreaker shape	SS	SM
	Cutting conditions	B010	

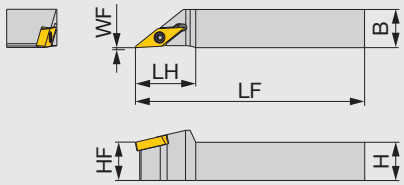
Reference pages: PVJNR/L-CHP, PVJNR/L-Eco: Inserts → B097 -
Parts for coolant hose → C142

MINIFORCE TURN
JSVJ2XR/L

Screw-on toolholder with 93° approach angle, for VXGU inserts



Cutting edge style **J2**



Without offset

Right hand (R) shown.

Inch	H	B	LF	LH	HF	WF	RE**	Insert	Torque
JSVJ2XR/L067	0.375	0.375	4.750	0.669	0.375	0	0.008	VXGU09T2**L/R...	0.66
JSVJ2XR/L087	0.500	0.500	4.750	0.748	0.500	0	0.008	VXGU09T2**L/R...	0.66
JSVJ2XR/L107	0.625	0.625	4.750	0.748	0.625	0	0.008	VXGU09T2**L/R...	0.66

Metric	H	B	LF	LH	HF	WF	RE**	Insert	Torque*
JSVJ2XR/L1010X09	10	10	120	17	10	0	0.2	VXGU09T2**L/R...	0.9
JSVJ2XR/L1212F09	12	12	85	19	12	0	0.2	VXGU09T2**L/R...	0.9
JSVJ2XR/L1212X09	12	12	120	19	12	0	0.2	VXGU09T2**L/R...	0.9
JSVJ2XR/L1616X09	16	16	120	19	16	0	0.2	VXGU09T2**L/R...	0.9
JSVJ2XR/L2020H09	20	20	100	19	20	0	0.2	VXGU09T2**L/R...	0.9

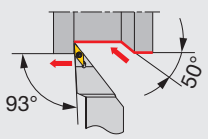
Torque: Recommended clamping torque: lbs·ft (*N·m) **RE: Standard corner radius
Use right-hand toolholders (R) with left-hand inserts (L); and left-hand toolholders (L) with right-hand inserts (R).

SPARE PARTS

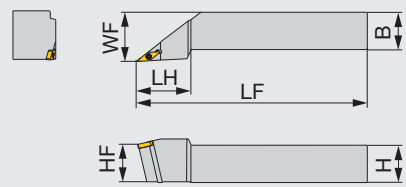

Designation	Clamping screw	Wrench
JSVJ2XR/L...	SR34-508	T-7F

MINIFORCE TURN
JSVJXR/L

Screw-on toolholder with 93° approach angle, for VXGU inserts



Cutting edge style **J**



Right hand (R) shown.

Inch	H	B	LF	LH	HF	WF	RE**	Insert	Torque
JSVJXR/127	0.750	0.750	4.500	1.500	0.750	1.000	0.008	VXGU09T2**L/R...	0.66
JSVJXR/167	1.000	1.000	6.000	1.500	1.000	1.250	0.008	VXGU09T2**L/R...	0.66

Metric	H	B	LF	LH	HF	WF	RE**	Insert	Torque*
JSVJXR/L2020K09	20	20	125	35	20	25	0.4	VXGU09T2**L/R...	0.9
JSVJXR/L2525M09	25	25	150	35	25	32	0.4	VXGU09T2**L/R...	0.9

Torque: Recommended clamping torque: lbs·ft (*N·m) **RE: Standard corner radius
Use right-hand toolholders (R) with left-hand inserts (L); and left-hand toolholders (L) with right-hand inserts (R).

SPARE PARTS


Designation	Clamping screw	Wrench
JSVJXR/L...	SR34-508	T-7F

INSERT SELECTION

P

Application	Finishing
Grade	SH725
Chipbreaker shape	JRP 
Cutting conditions	C143

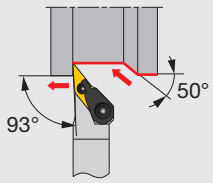
M

Application	Finishing
Grade	SH725
Chipbreaker shape	JRP 
Cutting conditions	C143

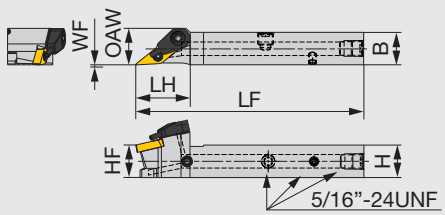
Reference pages: JSVJ2XR/L, JSVJXR/L: Inserts→ B158, Standard cutting conditions → C143

JSVJ2XR/L-CHP

Screw-on toolholder with 93° approach angle, for VXGU inserts, with high pressure coolant capability



Cutting edge style **J2**



Without offset

Right hand (R) shown.

Inch	H	B	LF	LH	HF	WF	OAW	RE**	Insert	Torque
JSVJ2XR/L087-CHP	0.500	0.500	4.750	0.748	0.500	0	0.535	0.008	VXGU09T2**L/R...	0.66
JSVJ2XR087X-CHP(1)	0.500	0.500	4.750	0.768	0.500	0	0.528	0.008	VXGU09T2**L...	0.66
JSVJ2XR107X-CHP(1)	0.625	0.625	4.750	0.768	0.625	0	0.625	0.008	VXGU09T2**L...	0.66

Metric	H	B	LF	LH	HF	WF	OAW	RE**	Insert	Torque*
JSVJ2XR/L1212F09-CHP	12	12	85	20	12	0	13.5	0.2	VXGU09T2**L/R...	0.9
JSVJ2XR1212X09-CHP(1)	12	12	120	19.5	12	0	13.4	0.2	VXGU09T2**L...	0.9
JSVJ2XR1616X09-CHP(1)	16	16	120	19.5	16	0	16	0.2	VXGU09T2**L...	0.9

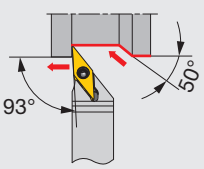
Torque: Recommended clamping torque: lbs·ft (*N·m) **RE: Standard corner radius
Use right-hand toolholders (R) with left-hand inserts (L); and left-hand toolholders (L) with right-hand inserts (R).
(1) Compatible to the direct internal coolant supply system without the use of external coolant hose.

SPARE PARTS

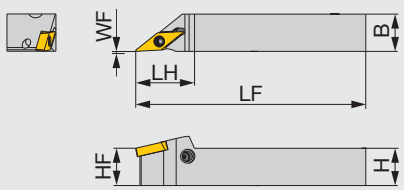
Designation	Clamping screw	Coolant unit	Wrench
JSVJ2XR/L**-CHP	SR34-508	S-CU-CHP	T-7F

JPVJ2XR/L

Back-clamp toolholder with 93° approach angle, for VXGU inserts



Cutting edge style **J2**



Without offset

Right hand (R) shown.

Inch	H	B	LF	LH	HF	WF	RE**	Insert	Torque
JPVJ2XR/L067	0.375	0.375	4.750	0.669	0.375	0	0.008	VXGU09T2**L/R...	0.66
JPVJ2XR/L087	0.500	0.500	4.750	0.748	0.500	0	0.008	VXGU09T2**L/R...	0.66
JPVJ2XR/L107	0.625	0.625	4.750	0.748	0.625	0	0.008	VXGU09T2**L/R...	0.66

Metric	H	B	LF	LH	HF	WF	RE**	Insert	Torque*
JPVJ2XR/L1010X09	10	10	120	19	10	0	0.2	VXGU09T2**L/R...	0.9
JPVJ2XR/L1212F09	12	12	85	19	12	0	0.2	VXGU09T2**L/R...	0.9
JPVJ2XR/L1212X09	12	12	120	19	12	0	0.2	VXGU09T2**L/R...	0.9
JPVJ2XR/L1616X09	16	16	120	19	16	0	0.2	VXGU09T2**L/R...	0.9

Torque: Recommended clamping torque: lbs·ft (*N·m) **RE: Standard corner radius
Use right-hand toolholders (R) with left-hand inserts (L); and left-hand toolholders (L) with right-hand inserts (R).

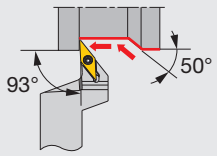
SPARE PARTS

Designation	Lever	Pin	Clamping screw	Wrench
JPVJ2XR/L...	SLLV-1	SL-PI-2	SR10400611	HW2.0/5RED

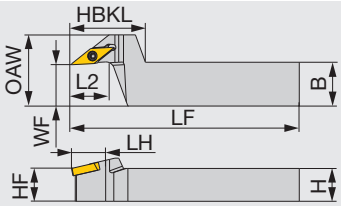
Reference pages: JSVJ2XR/L-CHP, JPVJ2XR/L: Inserts→ B158
Standard cutting conditions → C143

JSVJXR-F

Screw-on stepped-head toolholder with 93° approach angle, for VXGU inserts



Cutting edge style **J**



Right hand (R) shown.

Inch	H	B	LF	L2	HBKL	LH	HF	WF	OAW	RE**	Insert	Torque
JSVJXR087-F10	0.500	0.625	4.750	0.500	1.125	0.750	0.500	0.625	1	0.008	VXGU09T2**L...	0.66
JSVJXR107-F10	0.625	0.750	4.750	0.500	1.125	0.750	0.500	0.625	1	0.008	VXGU09T2**L...	0.66

Metric	H	B	LF	L2	HBKL	LH	HF	WF	OAW	RE**	Insert	Torque*
JSVJXR1016X09-F15	10	16	120	12	27	19	10	15	26	0.2	VXGU09T2**L...	0.9
JSVJXR1216F09-F15	12	16	85	12	27	19	12	15	26	0.2	VXGU09T2**L...	0.9
JSVJXR1216X09-F15	12	16	120	12	27	19	12	15	26	0.2	VXGU09T2**L...	0.9
JSVJXR1620X09-F15	16	20	120	12	27	19	16	15	26	0.2	VXGU09T2**L...	0.9

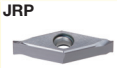
Torque: Recommended clamping torque: lbs·ft (*N·m) **RE: Standard corner radius
Use right-hand toolholders (R) with left-hand inserts (L).

SPARE PARTS


Designation	Clamping screw	Wrench
JSVJXR**-F...	SR34-508	T-7F

INSERT SELECTION

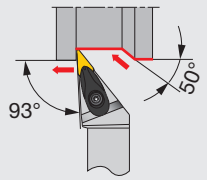
P	Application	Finishing
	Grade	SH725
	Chipbreaker shape	JRP 
	Cutting conditions	C143

M	Application	Finishing
	Grade	SH725
	Chipbreaker shape	JRP 
	Cutting conditions	C143

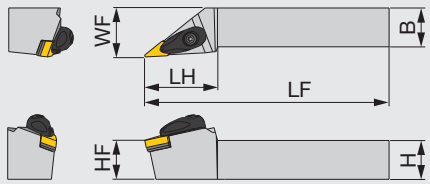
Reference pages: JSVJXR-F: Inserts→ B158
Standard cutting conditions → C143

AVJNR/L

Double-clamp toolholder with 93° approach angle, for negative 35° and 25° rhombic inserts



Cutting edge style **J**



Right hand (R) shown.

Inch	H	B	LF	LH	HF	WF	RE**	Insert	Torque
AVJNR/L123-A	0.750	0.750	4.500	1.750	0.750	1.000	0.031	V/YN**33...	2.2
AVJNR/L163-A	1.000	1.000	6.000	1.870	1.000	1.250	0.031	V/YN**33...	2.2

Metric	H	B	LF	LH	HF	WF	RE**	Insert	Torque*
AVJNR/L2020K16-A	20	20	125	43	20	25	0.8	V/YN**1604...	3
AVJNR/L2525M16-A	25	25	150	46	25	32	0.8	V/YN**1604...	3

Torque: Recommended clamping torque: lbs·ft (*N·m)
**RE: Standard corner radius

SPARE PARTS

Designation	Clamp	Clamp screw	Spring	Spring pin	Shim	Shim screw	Wrench
AVJNR/L**3-A, 16-A	ACP3L	ACS-5W	BP-7	SP-2.5	ASV322	CSTB-3.5	T-15F

INSERT SELECTION

P

Application	Precision finishing	Finishing	Medium cutting
Grade	NS9530	GT9530	T9215
Chipbreaker shape	TF	TSF	TM
Cutting conditions	B008		

M

Application	Finishing	Medium cutting
Grade	T6120	T6130
Chipbreaker shape	SF	SM
Cutting conditions	B010	

K

Application	Finishing	Medium cutting	Medium to heavy cutting
Grade	T515	T515	T515
Chipbreaker shape	All-round	All-round	All-round
Cutting conditions	B012		

N

Application	Precision finishing
Grade	DX120
Chipbreaker shape	T-DIA with rake
Cutting conditions	B014

S

Application	Precision finishing	Finishing	Medium cutting
Grade	BX480	AH8005	AH8005
Chipbreaker shape	T-CBN	HRF	HRM
Cutting conditions	B016		

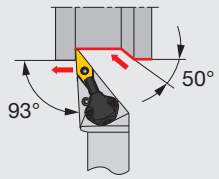
H

Application	Precision finishing	Finishing
Grade	BXM10	BXM20
Chipbreaker shape	T-CBN	T-CBN
Cutting conditions	B018	

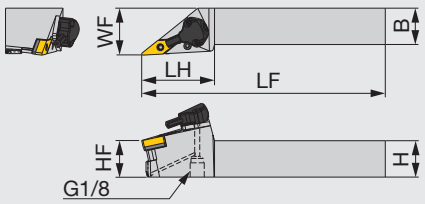
Reference pages: AVJNR/L: Inserts → B096 -, B109, CBN → B180, PCD → B194

PVJNR/L-CHP

Lever-lock toolholder with 93° approach angle, for negative 35° and 25° rhombic inserts, with high pressure coolant capability



Cutting edge style **J**



Right hand (R) shown.

Inch	H	B	LF	LH	HF	WF	RE**	Insert	Torque
PVJNR/L123-CHP	0.750	0.750	4.500	1.969	0.750	1.250	0.031	V/YN**33...	1.48
PVJNR/L163-CHP	1.000	1.000	6.000	1.969	1.000	1.250	0.031	V/YN**33...	1.48

Metric	H	B	LF	LH	HF	WF	RE**	Insert	Torque*
PVJNR/L2020K16-CHP	20	20	125	50	20	32	0.8	V/YN**1604...	2
PVJNR/L2525M16-CHP	25	25	150	50	25	32	0.8	V/YN**1604...	2

Torque: Recommended clamping torque: lbs·ft (*N·m) **RE: Standard corner radius

SPARE PARTS

Designation	Shim	Clamping screw	Wrench1	Spring pin	Lever
PVJNR/L**-CHP	LSV317	LCS3V	P-2.5	LSP3	LCL3V

SPARE PARTS

Designation	Coolant unit	Mounting screw	Wrench2	O-ring	Coolant screw	Wrench3
PVJNR/L**-CHP	CU-V-CHP	SRM3	T-8F	OR6.4X0.9N	SRM4X4TL360	P-2

INSERT SELECTION

P

Application	Precision finishing	Finishing	Medium cutting
Grade	NS9530	GT9530	T9215
Chipbreaker shape	TF	TSF	TM
Cutting conditions	B008		

M

Application	Finishing	Medium cutting
Grade	T6120	T6130
Chipbreaker shape	SF	SM
Cutting conditions	B010	

K

Application	Finishing	Medium cutting	Medium to heavy cutting
Grade	T515	T515	T515
Chipbreaker shape	All-round	All-round	All-round
Cutting conditions	B012		

N

Application	Precision finishing
Grade	DX120
Chipbreaker shape	T-DIA with rake
Cutting conditions	B014

S

Application	Precision finishing	Finishing	Medium cutting
Grade	BX480	AH8005	AH8005
Chipbreaker shape	T-CBN	HRF	HRM
Cutting conditions	B016		

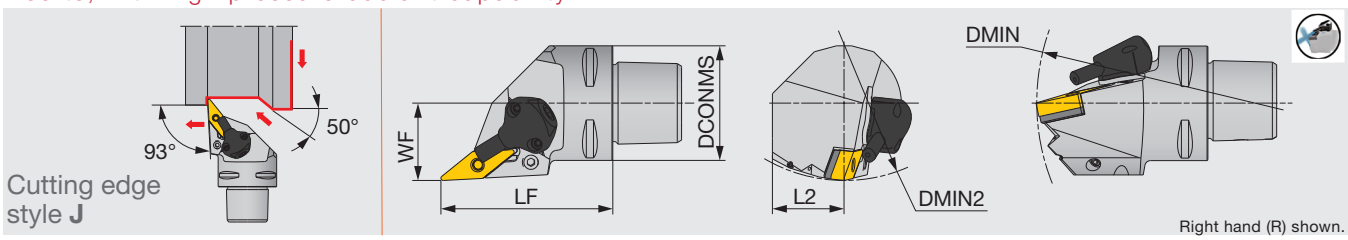
H

Application	Precision finishing	Finishing
Grade	BXM10	BXM20
Chipbreaker shape	T-CBN	T-CBN
Cutting conditions	B018	

Reference pages: PVJNR/L-CHP: Inserts→ B096 -, B109, CBN → B180, PCD → B194
Parts for coolant hose → C142

C-PVJNR/L-CHP

Lever-lock toolholder with TungCap connection, with 93° approach angle, for negative 35° and 25° inserts, with high pressure coolant capability



Inch	DCONMS	LF	L2	WF	DMIN	DMIN2	RE**	Insert
C4PVJNR/L27060-1204-CHP	1.575	2.362	0.787	1.063	5.512	3.543	0.031	VN**2.33**E...
C4PVJNR/L27060-16-CHP	1.575	2.362	-	1.063	5.512	4.331	0.031	V/YN**33...
C6PVJNR/L45065-1204-CHP	2.480	2.559	1.240	1.772	7.480	3.189	0.031	VN**2.33**E...
C6PVJNR/L45065-16-CHP	2.480	2.559	-	1.772	7.480	3.189	0.031	V/YN**33...

Metric	DCONMS	LF	L2	WF	DMIN	DMIN2	RE**	Insert
C4PVJNR/L27060-1204-CHP	40	60	20	27	140	90	0.8	VN**1204...
C4PVJNR/L27060-16-CHP	40	60	-	27	140	110	0.8	V/YN**1604...
C6PVJNR/L45065-1204-CHP	63	65	31.5	45	190	81	0.8	VN**1204...
C6PVJNR/L45065-16-CHP	63	65	-	45	190	81	0.8	V/YN**1604...

Applicable for 14 MPa coolant
**RE: Standard corner radius

SPARE PARTS

Designation	Shim	Clamping screw	Wrench1	Wrench2	Spring pin	Lever
C*PVJNR/L**-1204-CHP	LSV212	LCS3V	P-2.5	P-3	LSP3	LCL3V
C*PVJNR/L**-16-CHP	LSV317	LCS3V	P-2.5	-	LSP3	LCL3V

SPARE PARTS

Designation	Coolant unit	Mounting screw	Wrench3	O-ring
C*PVJNR/L**-CHP	CU-V-CHP	SRM3	T-8F	OR6.4X0.9N

INSERT SELECTION

P

Application	Precision finishing	Finishing	Medium cutting
Grade	NS9530	GT9530	T9215
Chipbreaker shape	TF	TSF	TM
Cutting conditions	B008		

M

Application	Finishing	Medium cutting
Grade	T6120	T6130
Chipbreaker shape	SF	SM
Cutting conditions	B010	

K

Application	Finishing	Medium cutting	Medium to heavy cutting
Grade	T515	T515	T515
Chipbreaker shape	All-round	All-round	All-round
Cutting conditions	B012		

N

Application	Precision finishing
Grade	DX120
Chipbreaker shape	T-DIA (with rake)
Cutting conditions	B014

S

Application	Precision finishing	Finishing	Medium cutting
Grade	BX470	AH8005	AH8005
Chipbreaker shape	T-CBN	HRF	HRM
Cutting conditions	B016		

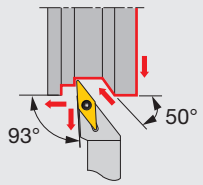
H

Application	Precision finishing	Finishing
Grade	BXM10	BXM20
Chipbreaker shape	T-CBN	T-CBN
Cutting conditions	B018	

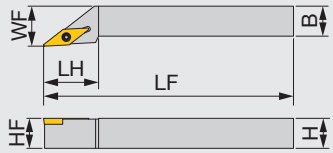
Reference pages: C-PVJNR/L-CHP: Insert→ B096 -, B109, CBN → B180, PCD → B194
Parts for coolant hose → C142

SVJBR/L

Screw-on clamp toolholder with 93° approach angle, for positive 35° rhombic inserts



Cutting edge style **J**



Right hand (R) shown.

Inch	H	B	LF	LH	HF	WF	RE**	Insert	Torque
SVJBR/L122	0.750	0.750	4.500	1.180	0.750	1.000	0.016	VB**22...	0.89
SVJBR/L123	0.750	0.750	4.500	1.180	0.750	1.000	0.032	VB**33...	0.89
SVJBR/L163	1.000	1.000	5.000	1.500	1.000	1.250	0.032	VB**33...	0.89

Torque: Recommended clamping torque: lbs·ft
**RE: Standard corner radius

SPARE PARTS

Designation	Clamping screw	Wrench
SVJBR/L122	CSTB-2.5	T-8F
SVJBR/L123, 163	CSTB-3.5	T-15F

INSERT SELECTION

P

Application	Finish cutting	Medium to finish cutting	Medium to finish cutting
Grade	SH725	AH725	SH725
Chipbreaker shape	JS	JS	J10
Cutting conditions	G068		

M

Application	Finish cutting	Medium to finish cutting	Medium to finish cutting
Grade	SH725	AH725	SH725
Chipbreaker shape	JS	JS	J10
Cutting conditions	G068		

K

Application	Medium to finish cutting
Grade	T515
Chipbreaker shape	CM
Cutting conditions	B024

S

Application	Finish cutting	Medium to finish cutting
Grade	SH725	AH725
Chipbreaker shape	JS	JS
Cutting conditions	G068	

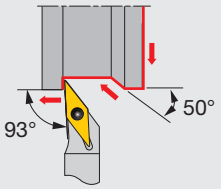
H

Application	Precision finishing	Finish cutting
Grade	BXM10	BXM10
Chipbreaker shape	T-CBN	T-CBN
Cutting conditions	B030	

Reference pages: SVJBR/L: Inserts → B152 -, CBN → B191 -

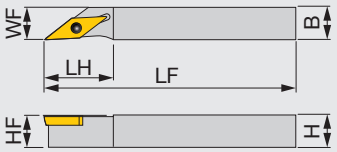
JSVJ2BR/L

Screw-on toolholder with 93° approach angle, for positive 35° rhombic inserts



Cutting edge style **J2**

Without offset



Right hand (R) shown.

Inch	H	B	LF	LH	HF	WF	RE**	Insert	Torque
JSVJ2BR/L062	0.375	0.375	5.000	0.813	0.375	0.375	0.008	VB**22...	0.89
JSVJ2BR/L082	0.500	0.500	5.000	0.813	0.500	0.500	0.008	VB**22...	0.89
JSVJ2BR/L102	0.625	0.625	5.000	0.813	0.625	0.625	0.008	VB**22...	0.89

Metric	H	B	LF	LH	HF	WF	RE**	Insert	Torque*
JSVJ2BR/L1010X11	10	10	120	21	10	10	0.2	VB**1103...	1.2
JSVJ2BR/L1212F11	12	12	85	21	12	12	0.2	VB**1103...	1.2
JSVJ2BR/L1212X11	12	12	120	21	12	12	0.2	VB**1103...	1.2
JSVJ2BR/L1616X11	16	16	120	21	16	16	0.2	VB**1103...	1.2

Torque: Recommended clamping torque: lbs·ft (*N·m)
**RE: Standard corner radius

SPARE PARTS


Designation	Clamping screw	Wrench
JSVJ2BR/L...	CSTB-2.5	T-8F

INSERT SELECTION

P

Application	Finish cutting	Medium to finish cutting	Medium to finish cutting
Grade	SH725	AH725	SH725
Chipbreaker shape	JS	JS	J10
Cutting conditions	G068		

M

Application	Finish cutting	Medium to finish cutting	Medium to finish cutting
Grade	SH725	AH725	SH725
Chipbreaker shape	JS	JS	J10
Cutting conditions	G068		

K

Application	Medium to finish cutting
Grade	T515
Chipbreaker shape	CM
Cutting conditions	B024

S

Application	Finish cutting	Medium to finish cutting
Grade	SH725	AH725
Chipbreaker shape	JS	JS
Cutting conditions	G068	

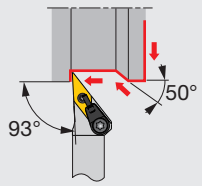
H

Application	Precision finishing	Finish cutting
Grade	BXM10	BXM10
Chipbreaker shape	T-CBN	T-CBN
Cutting conditions	B030	

Reference pages: JSVJ2BR/L: Inserts → B152 -, CBN → B191 -

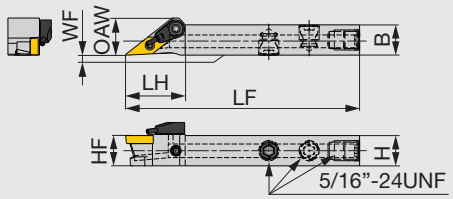
JSVJ2BR/L-CHP

Screw-on toolholder with 93° approach angle, for positive 35° rhombic inserts, with high pressure coolant capability



Cutting edge style **J2**

Without offset



Right hand (R) shown.

Inch	H	B	LF	LH	HF	WF	OAW	RE**	Insert	Torque
JSVJ2BR/L082-CHP	0.500	0.500	3.344	0.930	0.500	0	0.610	0.008	VB**22...	0.89
JSVJ2BR082X-CHP	0.500	0.500	4.750	0.929	0.500	0	0.575	0.008	VB**22...	0.89
JSVJ2BR102X-CHP	0.625	0.625	4.750	0.929	0.625	0	0.625	0.008	VB**22...	0.89

Metric	H	B	LF	LH	HF	WF	OAW	RE**	Insert	Torque*
JSVJ2BR/L1212F11-CHP	12	12	85	23.6	12	0	14.7	0.2	VB**1103...	1.2
JSVJ2BR1212X11-CHP	12	12	120	23.6	12	0	14.7	0.2	VB**1103...	1.2
JSVJ2BR1616X11-CHP	16	16	120	23.6	16	0	16	0.2	VB**1103...	1.2

Torque: Recommended clamping torque: lbs·ft (*N·m)
**RE: Standard corner radius

SPARE PARTS

Designation	Clamping screw	Coolant unit	Wrench	Coolant plug	Wrench	DirectJet plug	Wrench
JSVJ2BR/L082-CHP JSVJ2BR/L1212F11-CHP	CSTB-2.5	S-CU-CHP	T-8F	-	-	-	-
JSVJ2BR**2X-CHP JSVJ2BR**X11-CHP	CSTB-2.5	S-CU-CHP	T-8F	SR5/16UNFTL360	P-4	SSHM4-6-TB	P-2

INSERT SELECTION

P

Application	Finishing	Finishing to medium cutting
Grade	NS9530	T9215
Chipbreaker shape	PSS	PS
Cutting conditions	B020	

M

Application	Finishing	Finishing to medium cutting
Grade	AH725	AH630
Chipbreaker shape	PSF	PSS
Cutting conditions	B022	

K

Application	Finishing to medium cutting
Grade	T515
Chipbreaker shape	CM
Cutting conditions	B024

S

Application	Finishing	Finishing to medium cutting
Grade	AH8015	AH8015
Chipbreaker shape	PSS	PS
Cutting conditions	B028	

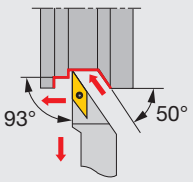
H

Application	Precision finishing	Finishing
Grade	BXM10	BXM20
Chipbreaker shape	T-CBN	T-CBN
Cutting conditions	B030	

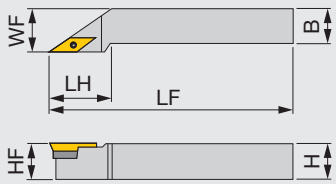
Reference pages: JSVJ2BR/L-CHP: Inserts → B152 -, CBN → B191 -
Parts for coolant hose → C142

SVJCR/L

Screw-on toolholder with 93° approach angle, for positive 35° rhombic inserts



Cutting edge style **J**



Right hand (R) shown.

Inch	H	B	LF	LH	HF	WF	RE**	Insert
SVJCR/L103	0.625	0.625	4.500	1.000	0.625	0.725	0.031	VC**33...
SVJCR/L123	0.750	0.750	4.500	1.250	0.750	0.955	0.031	VC**33...
SVJCR/L163	1.000	1.000	6.000	1.500	1.000	1.250	0.031	VC**33...

Metric	H	B	LF	LH	HF	WF	RE**	Insert
SVJCR/L1616H16	16	16	100	32	16	20	0.8	VC**1604...
SVJCR/L2020K16	20	20	125	32	20	25	0.8	VC**1604...
SVJCR/L2525M16	25	25	150	40	25	32	0.8	VC**1604...

**RE: Standard corner radius

SPARE PARTS

Designation	Clamping screw	Shim screw	Shim	Wrench1	Wrench2
SVJCR/L...	CSTB-3.5L	DTS5-3.5	SSV32	P-3.5	T-15F

INSERT SELECTION

P

Application	Finishing	Finishing to medium cutting
Grade	NS9530	T9215
Chipbreaker shape	PSS	PS
Cutting conditions	B020	

M

Application	Finishing	Finishing to medium cutting	Medium cutting
Grade	AH725	AH630	T6130
Chipbreaker shape	PSF	PSS	PM
Cutting conditions	B022		

K

Application	Finishing to medium cutting
Grade	T515
Chipbreaker shape	CM
Cutting conditions	B024

N

Application	Precision finishing	Finishing	Medium cutting
Grade	DX120	DX140	KS05F
Chipbreaker shape	T-DIA	with rake T-DIA	AL
Cutting conditions	B026		

S

Application	Finishing	Finishing to medium cutting
Grade	AH8015	AH8015
Chipbreaker shape	PSS	PS
Cutting conditions	B028	

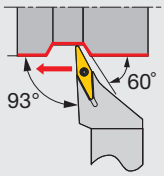
H

Application	Precision finishing	Finishing
Grade	BXM10	BXM20
Chipbreaker shape	T-CBN	T-CBN
Cutting conditions	B030	

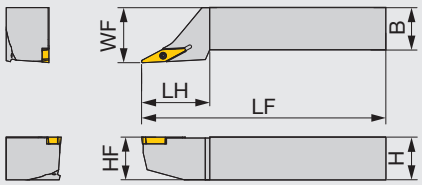
Reference pages: SVJCR/L:Inserts→ B155 -, CBN → B192, PCD → B196

SYJBR/L

Screw-on toolholder with 93° approach angle, for positive 25° rhombic inserts



Cutting edge style **J**



Right hand (R) shown.

Inch	H	B	LF	LH	HF	WF	RE**	Insert
SYJBR/L123	0.750	0.750	4.500	1.350	0.750	1.000	0.031	YWMT16T3...
SYJBR/L163	1.000	1.000	6.000	1.500	1.000	1.250	0.031	YWMT16T3...

Metric	H	B	LF	LH	HF	WF	RE**	Insert
SYJBR/L2020K16	20	20	125	35	20	25	0.8	YWMT16T3...
SYJBR/L2525M16	25	25	150	40	25	32	0.8	YWMT16T3...

**RE: Standard corner radius

SPARE PARTS


Designation	Clamping screw	Wrench
SYJBR/L...	CSTB-2.5L080	T-8F

INSERT SELECTION

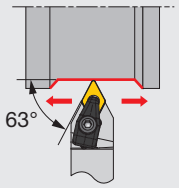
P	Application	Finishing to medium cutting
	Grade	T9225
	Chipbreaker shape	ZM 
	Cutting conditions	B008

K	Application	Finishing to medium cutting
	Grade	GT9530
	Chipbreaker shape	ZM 
	Cutting conditions	B012

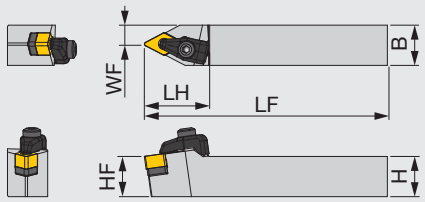
Reference pages: SYJBR/L: Inserts → B163

CDNNN-RD

Double-clamp toolholder with 63° approach angle, for negative 55° rhombic ceramic inserts with dimple



Cutting edge style **N**



Metric	H	B	LF	LH	HF	WF	RE**	Insert	Torque
CDNNN2525M1507-RD	25	25	150	40	25	12.5	1.2	DN*D1507...	4

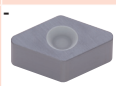
Torque: Recommended clamping torque: N·m
**RE: Standard corner radius

SPARE PARTS

Designation	Clamp	Clamp screw	Shim	Shim screw	Spring	Wrench1	Wrench2
CDNNN2525M1507-RD	CCP4-A	CCS4-A	CD44-A	BH5-10-A	BP-5-A	P-3	P-4

INSERT SELECTION

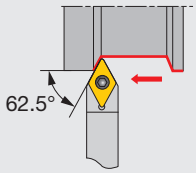
K

Application	Finishing to medium cutting
Grade	FX105
Chipbreaker shape	- 
Cutting conditions	C144

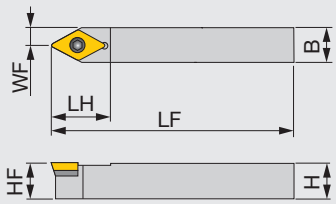
Reference pages: CDNNN-RD: Inserts→ B075
Standard cutting conditions → C144

SDNCN

Screw-on toolholder with 62.5° approach angle, for positive 55° rhombic inserts



Cutting edge style **N**



Metric	H	B	LF	LH	HF	WF	RE**	Insert
SDNCN1616H11	16	16	100	21	16	8	0.8	DC**11T3...
SDNCN2020K11	20	20	125	21	20	10	0.8	DC**11T3...
SDNCN2525M11	25	25	150	21	25	12.5	0.8	DC**11T3...

**RE: Standard corner radius

SPARE PARTS

Designation	Clamping screw	Shim screw	Shim	Wrench1	Wrench2
SDNCN...	CSTB-3.5L	DTS5-3.5	SSD32	P-3.5	T-15F

INSERT SELECTION

P

Application	Finishing	Finishing to medium cutting	Medium cutting
Grade	NS9530	T9215	T9215
Chipbreaker shape	PSS	PS	PM
Cutting conditions	B020		

M

Application	Precision finishing	Finishing	Finishing to medium cutting	Medium cutting
Grade	GH330	AH725	AH630	T6130
Chipbreaker shape	W**	PSF	PSS	PM
Cutting conditions	B022			

K

Application	Finishing to medium cutting
Grade	T515
Chipbreaker shape	CM
Cutting conditions	B024

N

Application	Precision finishing	Finishing	Medium cutting
Grade	DX120	DX140	KS05F
Chipbreaker shape	T-DIA with rake	T-DIA	AL
Cutting conditions	B026		

S

Application	Finishing	Finishing to medium cutting
Grade	AH8015	AH8015
Chipbreaker shape	PSS	PS
Cutting conditions	B028	

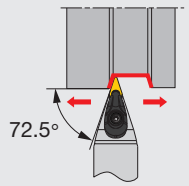
H

Application	Precision finishing	Finishing
Grade	BXM10	BXM20
Chipbreaker shape	T-CBN	T-CBN
Cutting conditions	B030	

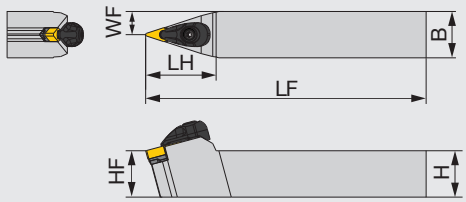
Reference pages: SDNCN:Inserts → B121 -, CBN → B184 -, PCD → B196 -

AVVNN-Eco

Double-clamp toolholder with 72.5° approach angle, for negative 35° rhombic inserts



Cutting edge style **V**



Right hand (R) shown.

Inch	H	B	LF	LH	HF	WF	RE**	Insert	Torque
AVVNN122.33-A	0.750	0.750	4.500	1.500	0.750	0.375	0.031	VN**2.33**E...	2.2
AVVNN162.33-A	1.000	1.000	6.000	1.500	1.000	0.500	0.031	VN**2.33**E...	2.2

Metric	H	B	LF	LH	HF	WF	RE**	Insert	Torque*
AVVNN2020K1204-A	20	20	125	38	20	10	0.8	VN**1204...	3
AVVNN2525M1204-A	25	25	150	38	25	13	0.8	VN**1204...	3

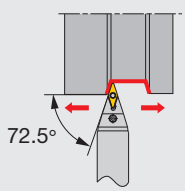
Torque: Recommended clamping torque: lbs·ft (*N·m) **RE: Standard corner radius

SPARE PARTS

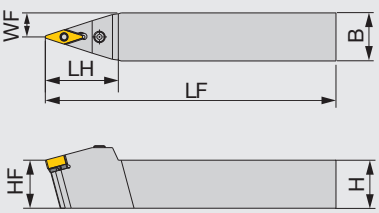
Designation	Clamp	Clamp screw	Spring	Spring pin	Shim	Shim screw	Wrench
AVVNN**-A	ACP3L-E	ACS-5W	BP-7	SP-2.5	ASV222	CSTB-3.0	T-15F

PVVNN-Eco

Lever-lock toolholder with 72.5° approach angle, for negative 35° rhombic inserts



Cutting edge style **V**



Right hand (R) shown.

Metric	H	B	LF	LH	HF	WF	RE**	Insert	Torque
PVVNN2020K1204	20	20	125	38	20	10	0.8	VN**1204...	2
PVVNN2525M1204	25	25	150	38	25	12.5	0.8	VN**1204...	2

Torque: Recommended clamping torque: N·m **RE: Standard corner radius

SPARE PARTS

Designation	Shim	Clamping screw	Wrench	Spring pin	Lever
PVVNN**1204	LSV212	LCS3V	P-2.5	LSP3	LCL3V

INSERT SELECTION

P

Application	Finishing	Medium cutting
Grade	T9215	T9215
Chipbreaker shape	TSF	TM
Cutting conditions	B008	

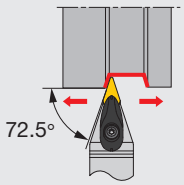
M

Application	Finishing	Medium cutting
Grade	T6120	T6130
Chipbreaker shape	SS	SM
Cutting conditions	B010	

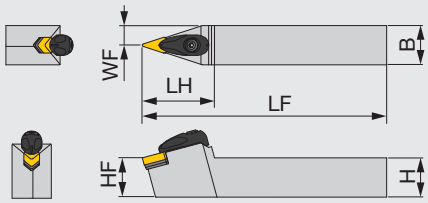
Reference pages: AVVNN-Eco, PVVNN-Eco: Inserts → B097 -

AVVNN

Double-clamp toolholder with 72.5° approach angle, for negative 35° and 25° rhombic inserts



Cutting edge style **V**



Inch	H	B	LF	LH	HF	WF	RE**	Insert	Torque
AVVNN123-A	0.750	0.750	4.500	1.870	0.750	0.375	0.031	V/YN**33...	2.2
AVVNN163-A	1.000	1.000	6.000	1.870	1.000	0.500	0.031	V/YN**33...	2.2

Metric	H	B	LF	LH	HF	WF	RE**	Insert	Torque*
AVVNN2020K16-A	20	20	125	46	20	10	0.8	V/YN**1604...	3
AVVNN2525M16-A	25	25	150	46	25	12.5	0.8	V/YN**1604...	3

Torque: Recommended clamping torque: lbs·ft (*N·m)
**RE: Standard corner radius

SPARE PARTS

Designation	Clamp	Clamp screw	Spring	Spring pin	Shim	Shim screw	Wrench
AVVNN**3-A, 16-A	ACP3L	ACS-5W	BP-7	SP-2.5	ASV322	CSTB-3.5	T-15F

INSERT SELECTION

P

Application	Precision finishing	Finishing	Medium cutting
Grade	NS9530	GT9530	T9215
Chipbreaker shape	TF	TSF	TM
Cutting conditions	B008		

M

Application	Finishing	Medium cutting
Grade	T6120	T6130
Chipbreaker shape	SF	SM
Cutting conditions	B010	

K

Application	Finishing	Medium cutting	Medium to heavy cutting
Grade	T515	T515	T515
Chipbreaker shape	All-round	All-round	All-round
Cutting conditions	B012		

N

Application	Precision finishing
Grade	DX120
Chipbreaker shape	T-DIA with rake
Cutting conditions	B014

S

Application	Precision finishing	Finishing	Medium cutting
Grade	BX480	AH8005	AH8005
Chipbreaker shape	T-CBN	HRF	HRM
Cutting conditions	B016		

H

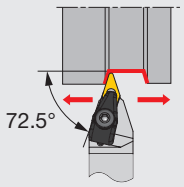
Application	Precision finishing	Finishing
Grade	BXM10	BXM20
Chipbreaker shape	T-CBN	T-CBN
Cutting conditions	B018	

Reference pages: AVVNN: Inserts → B096 -, B109, CBN → B180, PCD → B194

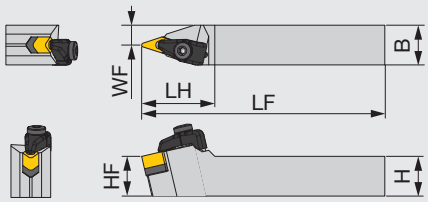
DIMPLEFX

CVVNN-RD

Double-clamp toolholder with 72.5° approach angle, for negative 35° rhombic ceramic inserts with dimple



Cutting edge style **V**



Metric	H	B	LF	LH	HF	WF	RE**	Insert	Torque
CVVNN2525M1607-RD	25	25	150	46	25	12.5	1.2	VN*D160712	4

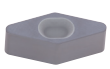
Torque: Recommended clamping torque: N·m
**RE: Standard corner radius

SPARE PARTS

Designation	Clamp	Clamp screw	Shim	Shim screw	Spring	Wrench1	Wrench2
CVVNN2525M1607-RD	CCP4-A	CCS4-A	CV34-A	BH-4-10-A	BP-5-A	P-3	P-4

INSERT SELECTION

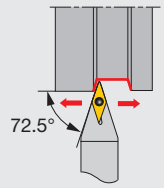
K

Application	Finishing to medium cutting
Grade	FX105
Chipbreaker shape	- 
Cutting conditions	C144

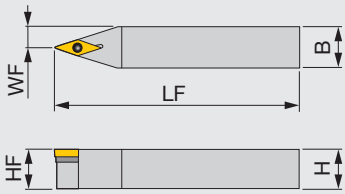
Reference pages: CVVNN-RD: Inserts → B101,
Standard cutting conditions → C144

SVVCN

Screw-on toolholder with 72.5° approach angle, for positive 35° rhombic inserts



Cutting edge style **V**



Metric	H	B	LF	HF	WF	RE**	Insert
SVVCN2020K16	20	20	125	20	10	0.8	VC**1604...
SVVCN2525M16	25	25	150	25	12.5	0.8	VC**1604...

**RE: Standard corner radius

SPARE PARTS

Designation	Clamping screw	Shim screw	Shim	Wrench1	Wrench2
SVVCN...	CSTB-3.5L	DTS5-3.5	SSV32	P-3.5	T-15F

INSERT SELECTION

P

Application	Finishing	Finishing to medium cutting
Grade	NS9530	T9215
Chipbreaker shape	PSS	PS
Cutting conditions	B020	

M

Application	Finishing	Finishing to medium cutting	Medium cutting
Grade	AH725	AH630	T6130
Chipbreaker shape	PSF	PSS	PM
Cutting conditions	B022		

K

Application	Finishing to medium cutting
Grade	T515
Chipbreaker shape	CM
Cutting conditions	B024

N

Application	Precision finishing	Finishing	Medium cutting
Grade	DX120	DX140	KS05F
Chipbreaker shape	T-DIA with rake	T-DIA	AL
Cutting conditions	B026		

S

Application	Finishing	Finishing to medium cutting
Grade	AH8015	AH8015
Chipbreaker shape	PSS	PS
Cutting conditions	B028	

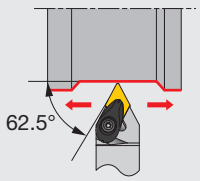
H

Application	Precision finishing	Finishing
Grade	BXM10	BXM20
Chipbreaker shape	T-CBN	T-CBN
Cutting conditions	B030	

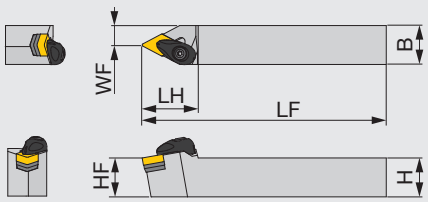
Reference pages: SVVCN: Inserts → B155 -, CBN → B192, PCD → B196

ADPNN

Double-clamp toolholder with 62.5° approach angle, for negative 55° rhombic inserts



Cutting edge style **P**



Inch	H	B	LF	LH	HF	WF	RE**	Insert	Torque
ADPNN124-A	0.750	0.750	4.500	1.500	0.750	0.375	0.031	DN**43...	2.2
ADPNN164-A	1.000	1.000	6.000	1.500	1.000	0.500	0.031	DN**43...	2.2

Metric	H	B	LF	LH	HF	WF	RE**	Insert	Torque*
ADPNN2020K15-A	20	20	125	36	20	7.5	0.8	DN**1504...	3
ADPNN2525M15-A	25	25	150	36	25	12.5	0.8	DN**1504...	3

Torque: Recommended clamping torque: lbs·ft (*N·m)
**RE: Standard corner radius

SPARE PARTS

Designation	Clamp	Clamp screw	Spring	Spring pin	Shim	Shim screw	Wrench
ADPNN**4-A, 15-A	ACP4S	ACS-5W	BP-7	SP-2.5	ASD432	CSTB-3.5	T-15F

INSERT SELECTION

P

Application	Precision finishing	Finishing	Medium cutting	Medium to heavy cutting
Grade	NS9530	GT9530	T9215	T9215
Chipbreaker shape	TF	TSF	TM	TH
Cutting conditions	B008			

M

Application	Finishing	Medium cutting	Medium to heavy cutting
Grade	T6120	T6130	T6130
Chipbreaker shape	SF	SM	SH
Cutting conditions	B010		

K

Application	Finishing	Medium cutting	Medium to heavy cutting
Grade	T515	T515	T515
Chipbreaker shape	All-round	All-round	All-round
Cutting conditions	B012		

N

Application	Precision finishing	Finishing	Medium cutting
Grade	DX120	DX140	TH10
Chipbreaker shape	T-DIA with rake	T-DIA	P
Cutting conditions	B014		

S

Application	Precision finishing	Finishing	Medium cutting
Grade	BX470	AH8005	AH8005
Chipbreaker shape	T-CBN	HRF	HRM
Cutting conditions	B016		

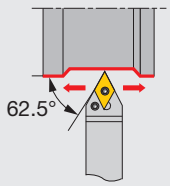
H

Application	Precision finishing	Finishing
Grade	BXM10	BXM20
Chipbreaker shape	T-CBN	T-CBN
Cutting conditions	B018	

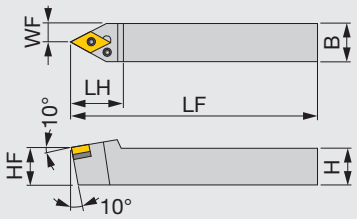
Reference pages: ADPNN: Inserts→ B067 -, CBN → B174 -, PCD → B194 -

PDPNN

Lever-lock toolholder with 62.5° approach angle, for negative 55° rhombic inserts



Cutting edge style **P**



Metric	H	B	LF	LH	HF	WF	RE**	Insert
PDPNN2525	25	25	150	36	25	12.5	0.8	DN**1504...
PDPNN2525M15E	25	25	150	36	25	12.5	0.8	DN**1506...

**RE: Standard corner radius

SPARE PARTS

Designation	Shim	Clamping screw	Wrench	Spring pin	Lever
PDPNN2525	LSD42	LCS4	P-3	LSP4	LCL4
PDPNN2525M15E	ELSD42	ELCS4	P-3	LSP4S	LCL44

INSERT SELECTION

P

Application	Precision finishing	Finishing	Medium cutting	Medium to heavy cutting
Grade	NS9530	GT9530	T9215	T9215
Chipbreaker shape	TF	TSF	TM	TH
Cutting conditions	B008			

M

Application	Finishing	Medium cutting	Medium to heavy cutting
Grade	T6120	T6130	T6130
Chipbreaker shape	SF	SM	SH
Cutting conditions	B010		

K

Application	Finishing	Medium cutting	Medium to heavy cutting
Grade	T515	T515	T515
Chipbreaker shape	All-round	All-round	All-round
Cutting conditions	B012		

N

Application	Precision finishing	Finishing	Medium cutting
Grade	DX120	DX140	TH10
Chipbreaker shape	T-DIA with rake	T-DIA	P
Cutting conditions	B014		

S

Application	Precision finishing	Finishing	Medium cutting
Grade	BX470	AH8005	AH8005
Chipbreaker shape	T-CBN	HRF	HRM
Cutting conditions	B016		

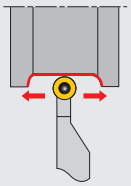
H

Application	Precision finishing	Finishing
Grade	BXM10	BXM20
Chipbreaker shape	T-CBN	T-CBN
Cutting conditions	B018	

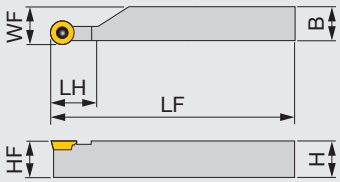
Reference pages: PDPNN: Inserts → B067 -, CBN → B174 -, PCD → B194 -

SRACR/L

Screw-on toolholder with 91° approach angle, for positive round inserts



Cutting edge style **A**



Right hand (R) shown.

Metric	H	B	LF	LH	HF	WF	Insert
SRACR1010H05	10	10	100	10	10	10.3	RCMT0502...
SRACR/L1212H05	12	12	100	10	12	12.3	RCMT0502...
SRACR/L1212H06	12	12	100	12	12	12.4	RC*T0602...
SRACR1616H05	16	16	100	10	16	16.3	RCMT0502...
SRACR/L1616H06	16	16	100	12	16	16.4	RC*T0602...
SRACR/L1616H08	16	16	100	16	16	16.5	RC*T0803...
SRACR/L2020K05	20	20	125	10	20	20.3	RCMT0502...
SRACR/L2020K06	20	20	125	12	20	20.4	RC*T0602...
SRACR/L2020K08	20	20	125	16	20	20.5	RC*T0803...
SRACR/L2525M05	25	25	150	10	25	25.3	RCMT0502...
SRACR/L2525M06	25	25	150	12	25	25.4	RC*T0602...
SRACR/L2525M08	25	25	150	16	25	25.5	RC*T0803...

SPARE PARTS

Designation	Clamping screw	Wrench
SRACR/L1*1*H05	CSTB-2.2R	T-7F
SRACR/L1212H06	CSTB-2.5	T-8F
SRACR1616H05	CSTB-2.2R	T-7F
SRACR/L1616H06	CSTB-2.5	T-8F
SRACR/L1616H08	CSTB-3	T-9F
SRACR/L2020K05	CSTB-2.2R	T-7F
SRACR/L2020K06	CSTB-2.5	T-8F
SRACR/L2020K08	CSTB-3	T-9F
SRACR/L2525M05	CSTB-2.2R	T-7F
SRACR/L2525M06	CSTB-2.5	T-8F
SRACR/L2525M08	CSTB-3	T-9F

INSERT SELECTION

P

Application	Finishing to medium cutting	heavy cutting
Grade	T9215	T9215
Chipbreaker shape	RS 	61 
Cutting conditions	B020	

M

Application	heavy cutting
Grade	T9215
Chipbreaker shape	61 
Cutting conditions	B022

K

Application	heavy cutting
Grade	T9215
Chipbreaker shape	61 
Cutting conditions	B024

N

Application	Finishing to medium cutting
Grade	KS05F
Chipbreaker shape	AL 
Cutting conditions	B026

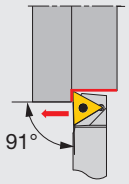
S

Application	Finishing to medium cutting	heavy cutting
Grade	AH8015	AH8015
Chipbreaker shape	RS 	61 
Cutting conditions	B028	

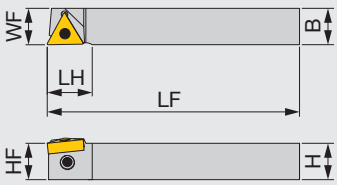
Reference pages: SRACR/L: Inserts → B131 -

JTTANR/L

Back-clamp toolholder with 91° approach angle, for negative 60° triangular inserts



Cutting edge style **A**



Without offset

Right hand (R) shown.

Metric	H	B	LF	LH	HF	WF	RE**	Insert	Torque
JTTANR/L1216K16	12	16	125	19.8	12	16	0.4	TN**1604...	1.2
JTTANR/L1616K16	16	16	125	19.8	16	16	0.4	TN**1604...	1.2

Torque: Recommended clamping torque: N·m
**RE: Standard corner radius

SPARE PARTS

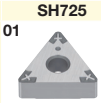
Designation	Clamp	Clamping screw	Wrench
JTTANR/L...	JCP-3N	JDS-5040	P-2.5F

INSERT SELECTION

P

Application	Precision finishing
Grade	SH725
Chipbreaker shape	01 
Cutting conditions	B008

M

Application	Precision finishing
Grade	SH725
Chipbreaker shape	01 
Cutting conditions	B010

K

Application	Finishing to medium cutting
Grade	T515
Chipbreaker shape	CM 
Cutting conditions	B012

N

Application	Precision finishing
Grade	DX120
Chipbreaker shape	T-DIA with rake 
Cutting conditions	B014

S

Application	Precision finishing
Grade	BX470
Chipbreaker shape	T-CBN 
Cutting conditions	B016

H

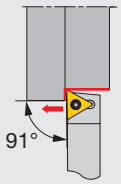
Application	Precision finishing	Finishing
Grade	BXM10	BXM20
Chipbreaker shape	T-CBN 	T-CBN 
Cutting conditions	B018	

Reference pages: JTTANR/L: Inserts → B086 -, CBN → B178 -, PCD → B194 -

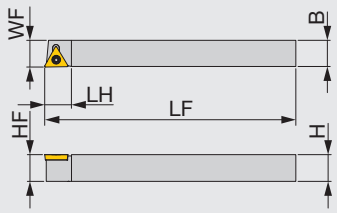
J-SERIES

JSTACR/L

Screw-on toolholder with 91° approach angle, for positive 60° triangular inserts



Cutting edge style **A**



Without offset

Right hand (R) shown.

Metric	H	B	LF	LH	HF	WF	RE**	Insert	Torque
JSTACR/L0808K08	8	8	125	10	8	8	0.2	TC**0802...	0.6
JSTACR/L1010K08	10	10	125	10	10	10	0.2	TC**0802...	0.6
JSTACR/L1212K11	12	12	125	12	12	12	0.4	TC**1102...	1.2
JSTACR/L1616H11	16	16	100	12	16	16	0.4	TC**1102...	1.2

Torque: Recommended clamping torque: N·m
**RE: Standard corner radius

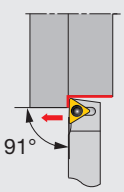
SPARE PARTS


Designation	Clamping screw	Wrench
JSTACR/L**K08	CSTB-2L	T-6F
JSTACR/L**11	CSTB-2.5	T-8F

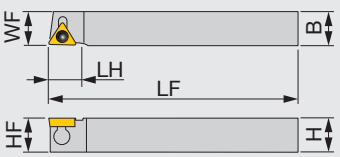
J-SERIES

JTTACR/L

Back-clamp toolholder with 91° approach angle, for positive 60° triangular inserts



Cutting edge style **A**



Without offset

Right hand (R) shown.

Metric	H	B	LF	LH	HF	WF	RE**	Insert	Torque
JTTACL0810K08	8	10	125	10	8	10	0.2	TC**0802...	0.9
JTTACR/L1212M11	12	12	150	12	12	12	0.4	TC**1102...	0.9
JTTACR/L1616M11	16	16	150	12	16	16	0.4	TC**1102...	0.9

Torque: Recommended clamping torque: N·m
**RE: Standard corner radius

SPARE PARTS



Designation	Clamp	Clamping screw	Wrench
JTTACL0810K08	JCP-1	JDS-3525	P-2F
JTTACR/L**M11	JCP-2	JDS-3525	P-2F

INSERT SELECTION

P

Application	Precision finishing	Finishing	Finishing to medium cutting	Medium cutting
Grade	SH725	SH725	T9215	T9215
Chipbreaker shape	01	JS	PS	PM
Cutting conditions	B020			

M

Application	Precision finishing	Finishing	Finishing to medium cutting	Medium cutting
Grade	SH725	SH725	T9215	T9215
Chipbreaker shape	01	JS	PS	PM
Cutting conditions	B022			

K

Application	Finishing to medium cutting
Grade	T515
Chipbreaker shape	CM
Cutting conditions	B024

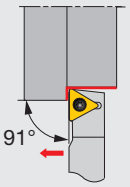
N

Application	Precision finishing	Medium cutting
Grade	DX120	KS05F
Chipbreaker shape	T-DIA	with rake AL
Cutting conditions	B026	

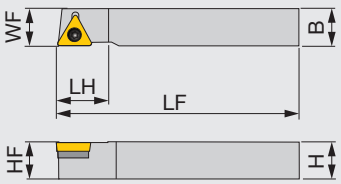
Reference pages: JSTACR/L, JTTACR/L: Inserts→ B139 -, PCD → B196

STACR/L

Screw-on toolholder with 91° approach angle, for positive 60° triangular inserts



Cutting edge style **A**



Without offset

Right hand (R) shown.

Metric	H	B	LF	LH	HF	WF	RE**	Insert
STACR/L1616H16	16	16	100	22.5	16	16	0.8	TC**16T3...

**RE: Standard corner radius

SPARE PARTS

Designation	Clamping screw	Shim screw	Shim	Wrench1	Wrench2
STACR/L...	CSTB-3.5L	DTS5-3.5	SST32	P-3.5	T-15F

INSERT SELECTION

P

Application	Precision finishing	Finishing	Finishing to medium cutting	Medium cutting
Grade	NS9530	NS9530	T9215	T9215
Chipbreaker shape	01	PSS	PS	PM
Cutting conditions	B020			

M

Application	Finishing	Medium cutting
Grade	AH725	T6130
Chipbreaker shape	PSF	PM
Cutting conditions	B022	

K

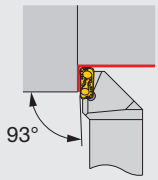
Application	Finishing to medium cutting
Grade	T515
Chipbreaker shape	CM
Cutting conditions	B024

N

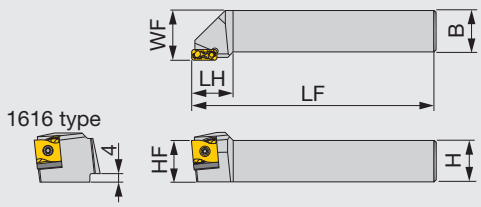
Application	Precision finishing
Grade	DX120
Chipbreaker shape	T-DIA (with rake)
Cutting conditions	B026

Reference pages: STACR/L: Inserts → **B139 -**

Screw-on toolholder for roughing with 93° approach angle, for negative tangential inserts



Cutting edge style **A**



Right hand (R) shown.

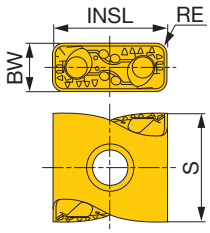
Inch	H	B	LF	LH	HF	WF	Insert
TLANR/L10-12	0.625	0.625	4.000	0.790	0.625	0.750	LNMX1204**R/L...
TLANR/L12-12	0.750	0.750	4.500	0.790	0.750	1.000	LNMX1204**R/L...
TLANR/L12-16	0.750	0.750	4.500	1.000	0.750	1.000	LNMX1606**R/L...
TLANR/L16-12	1.000	1.000	6.000	0.790	1.000	1.250	LNMX1204**R/L...
TLANR/L16-16	1.000	1.000	6.000	1.000	1.000	1.180	LNMX1606**R/L...
TLANR/L20-16	1.250	1.250	6.000	1.380	1.250	1.460	LNMX1606**R/L...
TLANR/L20-24	1.250	1.250	6.000	1.380	1.250	1.500	LNMX2410**R/L...
TLANR/L24-16	1.500	1.500	7.000	1.380	1.500	1.700	LNMX1606**R/L...
TLANR/L24-24	1.500	1.500	7.000	1.380	1.500	1.700	LNMX2410**R/L...
TLANR/L32-24	2.000	2.000	8.000	1.380	2.000	2.275	LNMX2410**R/L...

SPARE PARTS

Designation	Clamping screw	Shim screw	Shim	Spring	Wrench 1	Wrench 2
TLANR**-12	CSTB-3.5L115-S	CSTF-2L055-S	TSL12R	-	KEYV-T10	T-6F-S
TLANL**-12	CSTB-3.5L115-S	CSTF-2L055-S	TSL12L	-	KEYV-T10	T-6F-S
TLANR**-16	CSTB-4L115-S	-	TSL16R	PSP-16	KEYV-T15	-
TLANL**-16	CSTB-4L115-S	-	TSL16L	PSP-16	KEYV-T15	-
TLANR**-24	CSTB-5L163-S	-	TSL24R	PSP-16	KEYV-T20	-
TLANL**-24	CSTB-5L163-S	-	TSL24L	PSP-16	KEYV-T20	-

Reference pages: TLANR/L: Inserts → C083
Standard cutting conditions → C144

LNMX12/16/24



P	Steel	★	★	★			
M	Stainless			☆			
K	Cast iron	☆	☆	☆			
N	Non-ferrous						
S	Superalloys						
H	Hard materials						

★ : First choice
☆ : Second choice

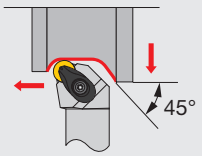
Designation	HAND	RE (in)	Coated										BW (in)	INSL (in)	S (in)
			T9115	T9125	AH725										
LNMX120408R-TDR	R	0.031	●	●									0.189	0.473	0.457
LNMX120408L-TDR	L	0.031	●	●									0.189	0.473	0.457
LNMX120412R-TDR	R	0.047	●	●									0.189	0.473	0.457
LNMX120412L-TDR	L	0.047	●	●									0.189	0.473	0.457
LNMX160608R-TDR	R	0.031	●	●									0.252	0.638	0.532
LNMX160608L-TDR	L	0.031	●	●									0.252	0.638	0.532
LNMX160612R-TDR	R	0.047	●	●									0.252	0.638	0.532
LNMX160612L-TDR	L	0.047	●	●									0.252	0.638	0.532
LNMX160616R-TDR	R	0.063	●	●									0.252	0.638	0.532
LNMX160616L-TDR	L	0.063	●	●									0.252	0.638	0.532
LNMX241016R-TDR	R	0.063	●	●									0.370	0.945	0.807
LNMX241016L-TDR	L	0.063	●	●									0.370	0.945	0.807
LNMX241024R-TDR	R	0.094	●	●									0.370	0.945	0.807
LNMX241024L-TDR	L	0.094	●	●									0.370	0.945	0.807
LNMX160608R-MDR	R	0.031	●	●	●								0.252	0.638	0.532
LNMX160608L-MDR	L	0.031	●	●	●								0.252	0.638	0.532
LNMX160612R-MDR	R	0.047	●	●	●								0.252	0.638	0.532
LNMX160612L-MDR	L	0.047	●	●	●								0.252	0.638	0.532
LNMX160608R-TWR	R	0.031	●	●									0.252	0.638	0.532
LNMX160608L-TWR	L	0.031	●	●									0.252	0.638	0.532
LNMX160612R-TWR	R	0.047	●	●									0.252	0.638	0.532
LNMX160612L-TWR	L	0.047	●	●									0.252	0.638	0.532

● : Line up

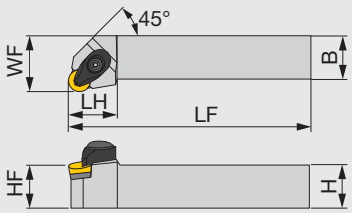
Reference pages: Standard cutting conditions → C144

ARGNR/L

Double-clamp toolholder with 91° approach angle, for negative round inserts



Cutting edge style **G**



Right hand (R) shown.

Inch	H	B	LF	LH	HF	WF	RE**	Insert	Torque
ARGNR/L164-A	1.000	1.000	6.000	1.125	1.000	1.250	0.250	RN**43...	2.2

Metric	H	B	LF	LH	HF	WF	RE**	Insert	Torque*
ARGNR/L2525M12-A	25	25	150	28	25	32	6.35	RN**120400	3

Torque: Recommended clamping torque: lb·ft (*N·m)
**RE: Standard corner radius

SPARE PARTS

Designation	Clamp	Clamp screw	Spring	Spring pin	Shim	Shim screw	Wrench
ARGNR/L...	ACP4S	ACS-5W	BP-7	SP-2.5	ASR420	CSTB-3.5	T-15F

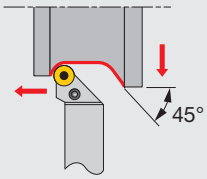
INSERT SELECTION

P		
	Application	Semi-finishing to medium cutting
	Grade	T9225
	Chipbreaker Shape	61 
	Cutting conditions	B008

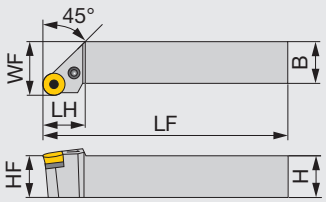
Reference pages: ARGNR/L: Inserts → B076

PRGNR/L

Lever-lock toolholder with 91° approach angle, for negative round inserts



Cutting edge style **G**



Right hand (R) shown.

Metric	H	B	LF	LH	HF	WF	RE**	Insert
PRGNR/L2020	20	20	125	19	20	25	4.76	RNMG090300-61
PRGNR/L2525M4	25	25	150	25	25	32	6.35	RN**120400

**RE: Standard corner radius

SPARE PARTS

Designation	Shim	Clamping screw	Wrench	Spring pin	Lever
PRGNR/L2020	LSR32	LCS3	P-2.5	LSP3	LCL3
PRGNR/L2525M4	LSR42	LCS4	P-3	LSP4	LCL4

INSERT SELECTION

P

Application	Heavy cutting
Grade	T9215
Chipbreaker Shape	61 
Cutting conditions	B008

M

Application	Heavy cutting
Grade	T9215
Chipbreaker Shape	61 
Cutting conditions	B010

K

Application	Heavy cutting
Grade	T9215
Chipbreaker Shape	61 
Cutting conditions	B012

N

Application	Heavy cutting
Grade	TH10
Chipbreaker Shape	61 
Cutting conditions	B014

S

Application	Heavy cutting
Grade	TH10
Chipbreaker Shape	61 
Cutting conditions	B016

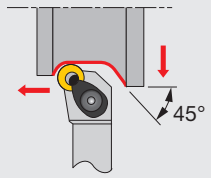
H

Application	Finishing to medium cutting
Grade	LX11
Chipbreaker Shape	- 
Cutting conditions	B018

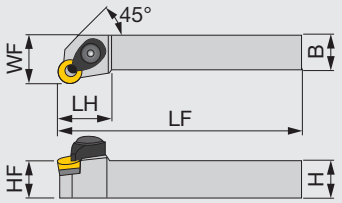
Reference pages: PRGNR/L: Inserts → B076

DRGNR/L

"One-Double" toolholder with 91° approach angle, for negative round inserts



Cutting edge style **G**



Right hand (R) shown.

Metric	H	B	LF	LH	HF	WF	RE**	Insert
DRGNR/L2525M12	25	25	150	28	25	32	6.35	RN**120400

**RE: Standard corner radius

SPARE PARTS

Designation	Clamp	Lever	Piston	Clamp screw	Shim	Spring	Spring pin	Wrench 1	Wrench 2
DRGNR/L...	DCPM-43	DLCL43	DPIS43	DLCS43	LSR42	BP-10	LSP4	P-3	P-4

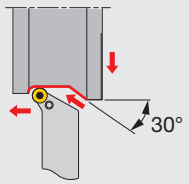
INSERT SELECTION

P	Application	Semi-finishing to medium cutting
	Grade	T9215
	Chipbreaker Shape	61 
	Cutting conditions	B008

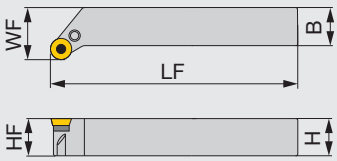
Reference pages: DRGNR/L: Inserts → B076

PRGCR/L

Lever-lock toolholder with 91° approach angle, for positive round inserts



Cutting edge style **G**



Right hand (R) shown.

Metric	H	B	LF	HF	WF	Insert
PRGCR/L2020K10	20	20	125	20	25	RCMM1003...
PRGCR/L2525M12	25	25	150	25	32	RCM*1204...
PRGCR/L3225P16	32	25	170	32	32	RCM*1606...
PRGCR/L3232P20	32	32	170	32	40	RCM*2006...

SPARE PARTS

Designation	Shim	Clamping screw	Wrench	Spring pin	Lever
PRGCR/L2020K10	LSR32C	LCS2	P-2	LSP3	LCL3C
PRGCR/L2525M12	LSR42C	LCS3	P-2.5	LSP3	LCL4C
PRGCR/L3225P16	LSR53C	LCS5	P-3	LSP4	LCL5C
PRGCR/L3232P20	LSR63C	LCS5	P-3	LSP6C	LCL6C

INSERT SELECTION

P

Application	Finishing to medium cutting	Heavy cutting
Grade	T9215	T9215
Chipbreaker Shape	RS 	61 
Cutting conditions	B020	

M

Application	Heavy cutting
Grade	T9215
Chipbreaker Shape	61 
Cutting conditions	B022

K

Application	Heavy cutting
Grade	T9215
Chipbreaker Shape	61 
Cutting conditions	B024

N

Application	Finishing to medium cutting
Grade	KS05F
Chipbreaker Shape	AL 
Cutting conditions	B026

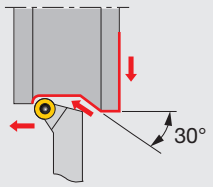
S

Application	Finishing to medium cutting	Heavy cutting
Grade	AH8015	AH8015
Chipbreaker Shape	RS 	61 
Cutting conditions	B028	

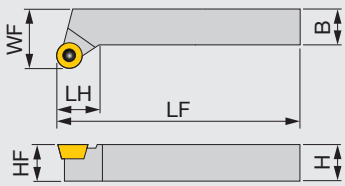
Reference pages: PRGCR/L: Inserts → B131 -

SRGCR/L

Screw-on toolholder with 91° approach angle, for positive round inserts



Cutting edge style **G**



Right hand (R) shown.

Metric	H	B	LF	LH	HF	WF	Insert
SRGCR1212H05	12	12	100	9.5	12	16	RCMT0502...
SRGCR/L1212H06	12	12	100	10	12	16	RC*T0602...
SRGCR/L1616H05	16	16	100	9.5	16	20	RCMT0502...
SRGCR/L1616H06	16	16	100	10	16	20	RC*T0602...
SRGCR/L1616H08	16	16	100	11	16	20	RC*T0803...
SRGCR/L2020K05	20	20	125	11.2	20	25	RCMT0502...
SRGCR/L2020K06	20	20	125	12	20	25	RC*T0602...
SRGCR/L2020K08	20	20	125	12.7	20	25	RC*T0803...
SRGCR/L2020K10	20	20	125	14	25	25	RC*T1003...
SRGCR/L2525M05	25	25	150	14.7	25	32	RCMT0502...
SRGCR/L2525M06	25	25	150	15	25	32	RC*T0602...
SRGCR/L2525M08	25	25	150	16.2	25	32	RC*T0803...
SRGCR/L2525M10	25	25	150	17.5	25	32	RC*T1003...

SPARE PARTS

Designation	Clamping screw	Shim screw	Shim	Wrench 1	Wrench 2
SRGCR1212H05	CSTB-2.2R	-	-	-	T-7F
SRGCR/L1212H06	CSTB-2.5	-	-	-	T-8F
SRGCR/L1616H05	CSTB-2.2R	-	-	-	T-7F
SRGCR/L1616H06	CSTB-2.5	-	-	-	T-8F
SRGCR/L1616H08	CSTB-3	-	-	-	T-9F
SRGCR/L2020K05	CSTB-2.2R	-	-	-	T-7F
SRGCR/L2020K06	CSTB-2.5	-	-	-	T-8F
SRGCR/L2020K08	CSTB-3	-	-	-	T-9F
SRGCR/L2020K10	CSTB-3.5L	DTS5-3.5	SSR32	P-3.5	T-15F
SRGCR/L2525M05	CSTB-2.2R	-	-	-	T-7F
SRGCR/L2525M06	CSTB-2.5	-	-	-	T-8F
SRGCR/L2525M08	CSTB-3	-	-	-	T-9F
SRGCR/L2525M10	CSTB-3.5L	DTS5-3.5	SSR32	P-3.5	T-15F

INSERT SELECTION

P

Application	Finishing to medium cutting	Heavy cutting
Grade	T9215	T9215
Chipbreaker Shape	RS 	61 
Cutting conditions	B020	

M

Application	Heavy cutting
Grade	T9215
Chipbreaker Shape	61 
Cutting conditions	B022

S

Application	Finishing to medium cutting	Heavy cutting
Grade	AH8015	AH8015
Chipbreaker Shape	RS 	61 
Cutting conditions	B028	

K

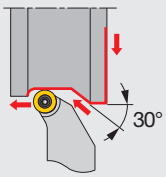
Application	Heavy cutting
Grade	T9215
Chipbreaker Shape	61 
Cutting conditions	B024

N

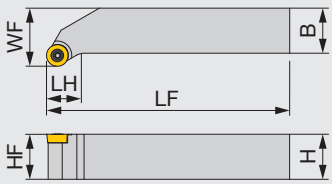
Application	Finishing to medium cutting
Grade	KS05F
Chipbreaker Shape	AL 
Cutting conditions	B026

Reference pages: SRGCR/L: Inserts → **B131 -**

Screw-on toolholder with 91° approach angle, for positive round inserts



Cutting edge style **G**



Right hand (R) shown.

Inch	H	B	LF	LH	HF	WF	Insert	Torque
SRGCR/L164-6F	1.00	1.00	6.00	0.69	1.00	1.25	RCMT1204M0-6RS/-6RM	2.21

Metric	H	B	LF	LH	HF	WF	Insert	Torque*
SRGCR/L2525M12-6F	25	25	150	18.6	25	32	RCMT1204M0-6RS/-6RM	3

Torque: Recommended clamping torque: lb·ft (*N·m)

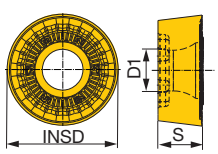
SPARE PARTS

Designation	Clamping screw	Lubricant	Wrench
SRGCR/L164-6F, SRGCR/L2525M12-6F	CSTB-4	M-1000	T-15F

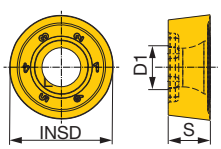
INSERT

RCMT

6RS



6RM



P	Steel	★	★	★	★			★			
M	Stainless										
K	Cast iron	☆	☆	☆	☆			☆			
N	Non-ferrous										
S	Superalloys										
H	Hard materials										

★ : First choice
☆ : Second choice

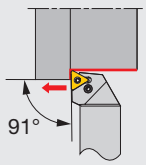
Designation	Coated					Cermet						INSD (in)	S (in)	D1 (in)
	T9225	T9215	T9115	T9125		NS9530								
RCMT1204M0-6RS	●	●	●	●		●						0.472	0.187	0.203
RCMT1204M0-6RM	●	●	●	●		●						0.472	0.187	0.203

● : Line up

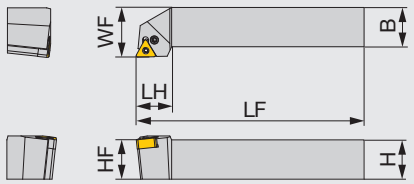
Reference pages: SRGCR/L: Standard cutting conditions → C142

PTGNR/L-Eco

Lever-lock toolholder with 91° approach angle, for negative triangular inserts



Cutting edge style **G**



Right hand (R) shown.

Inch	H	B	LF	LH	HF	WF	RE**	Insert	Torque
PTGNR/L1223	0.750	0.750	4.500	0.750	0.750	1.000	0.031	TN**23...	1.5
PTGNR/L1623	1.000	1.000	6.000	0.750	1.000	1.250	0.031	TN**23...	1.5

Metric	H	B	LF	LH	HF	WF	RE**	Insert	Torque*
PTGNR/L2020K1104	20	20	125	20	20	25	0.8	TN**1104...	2
PTGNR/L2525M1104	25	25	150	20	25	32	0.8	TN**1104...	2

Torque: Recommended clamping torque: lbs·ft (*N·m) **RE: Standard corner radius

SPARE PARTS

Designation	Clamping screw	Wrench	Lever
PTGNR/L...	LCS23A	P-2.5	LCL23

INSERT SELECTION

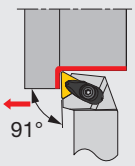
P	Application	Finishing	Medium cutting
	Grade	T9215	T9215
	Chipbreaker Shape	TSF	TM
	Cutting conditions	B008	

M	Application	Finishing	Medium cutting
	Grade	T6120	T6130
	Chipbreaker Shape	SS	SM
	Cutting conditions	B010	

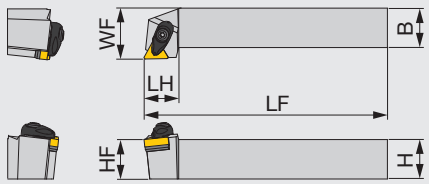
Reference pages: PTGNR/L-Eco: Inserts → B086 -

ATGNR/L

Double-clamp toolholder with 91° approach angle, for negative 60° triangular inserts



Cutting edge style **G**



Right hand (R) shown.

Inch	H	B	LF	LH	HF	WF	RE**	Insert	Torque
ATGNR/L123-A	0.750	0.750	4.500	0.875	0.750	1.000	0.031	TN**33...	2.2
ATGNR/L163-A	1.000	1.000	6.000	0.875	1.000	1.250	0.031	TN**33...	2.2
ATGNR/L164-A	1.000	1.000	6.000	1.000	1.000	1.250	0.031	TN**43...	2.2

Metric	H	B	LF	LH	HF	WF	RE**	Insert	Torque*
ATGNR/L2020K16-A	20	20	125	22	20	25	0.8	TN**1604...	3
ATGNR/L2525M16-A	25	25	150	22	25	32	0.8	TN**1604...	3
ATGNR/L2525M22-A	25	25	150	26	25	32	0.8	TN**2204...	3

Torque: Recommended clamping torque: lbs·ft (*N·m)
**RE: Standard corner radius

SPARE PARTS

Designation	Clamp	Clamp screw	Spring	Spring pin	Shim	Shim screw	Wrench
ATGNR/L**3-A, 16-A	ACP3S	ACS-5W	BP-7	SP-2.5	AST322	CSTB-3.5	T-15F
ATGNR/L**4-A, 22-A	ACP4S	ACS-5W	BP-7	SP-2.5	AST422	CSTB-3.5	T-15F

INSERT SELECTION

P

Application	Precision finishing	Finishing	Medium cutting	Medium to heavy cutting
Grade	NS9530	GT9530	T9215	T9215
Chipbreaker Shape	TF	TSF	TM	TH
Cutting conditions	B008			

M

Application	Finishing	Medium cutting
Grade	T6120	T6130
Chipbreaker Shape	SF	SM
Cutting conditions	B010	

K

Application	Finishing	Medium cutting	Medium to heavy cutting
Grade	T515	T515	T515
Chipbreaker Shape	All-round	All-round	All-round
Cutting conditions	B012		

N

Application	Precision finishing	Finishing	Medium cutting
Grade	DX120	DX140	TH10
Chipbreaker Shape	T-DIA with rake	T-DIA	P
Cutting conditions	B014		

S

Application	Precision finishing	Finishing	Medium cutting
Grade	BX470	AH8005	AH8005
Chipbreaker Shape	T-CBN	HRF	HRM
Cutting conditions	B016		

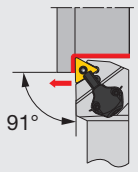
H

Application	Precision finishing	Finishing
Grade	BXM10	BXM20
Chipbreaker Shape	T-CBN	T-CBN
Cutting conditions	B018	

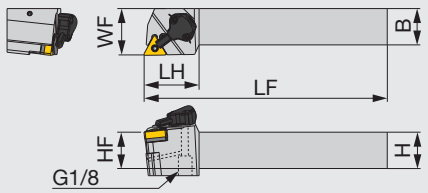
Reference pages: ATGNR/L: Inserts → B086 -, CBN → B178 -, PCD → B194 -

PTGNR/L-CHP

Lever-lock toolholders with 91° approach angle, for negative 60° triangular inserts, with high pressure coolant capability



Cutting edge style **G**



Right hand (R) shown.

Inch	H	B	LF	LH	HF	WF	RE**	Insert	Torque
PTGNR/L1223-CHP	0.750	0.750	4.500	1.500	0.750	1.250	0.031	TN**23...	1.5
PTGNR/L123-CHP	0.750	0.750	4.500	1.500	0.750	1.250	0.031	TN**33...	1.5
PTGNR/L1623-CHP	1.000	1.000	6.000	1.500	1.000	1.250	0.031	TN**23...	1.5
PTGNR/L163-CHP	1.000	1.000	6.000	1.500	1.000	1.250	0.031	TN**33...	1.5

Metric	H	B	LF	LH	HF	WF	RE**	Insert	Torque*
PTGNR/L2020K1104-CHP	20	20	125	38	20	32	0.8	TN**1104...	2
PTGNR/L2020K16-CHP	20	20	125	38	20	32	0.8	TN**1604...	2
PTGNR/L2525M1104-CHP	25	25	150	38	25	32	0.8	TN**1104...	2
PTGNR/L2525M16-CHP	25	25	150	38	25	32	0.8	TN**1604...	2

Torque: Recommended clamping torque: lbs·ft (*N·m)
**RE: Standard corner radius

SPARE PARTS

Designation	Shim	Clamping screw	Wrench 1	Spring pin	Lever
PTGNR/L**23-CHP, PTGNR/L**1104-CHP	-	LCS23A	P-2.5	LSP3	LCL23
PTGNR/L1*3-CHP, PTGNR/L**16-CHP	LST317	LCS3	P-2.5	LSP3	LCL3

SPARE PARTS

Designation	Coolant unit	Mounting screw	Wrench 2	O-ring	Coolant screw	Wrench 3
PTGNR/L**23-CHP, PTGNR/L**1104-CHP	CU-CW-CHP	SRM3	T-8F	OR6.4X0.9N	SRM4X4TL360	P-2
PTGNR/L1*3-CHP, PTGNR/L**16-CHP	CU-CW-CHP	SRM3	T-8F	OR6.4X0.9N	SRM4X4TL360	P-2

INSERT SELECTION

P

Application	Precision finishing	Finishing	Medium cutting	Medium to heavy cutting
Grade	NS9530	GT9530	T9215	T9215
Chipbreaker Shape	TF	TSF	TM	TH
Cutting conditions	B008			

M

Application	Finishing	Medium cutting
Grade	T6120	T6130
Chipbreaker Shape	SF	SM
Cutting conditions	B010	

K

Application	Finishing	Medium cutting	Medium to heavy cutting
Grade	T515	T515	T515
Chipbreaker Shape	All-round	All-round	All-round
Cutting conditions	B012		

N

Application	Precision finishing	Finishing	Medium cutting
Grade	DX120	DX140	TH10
Chipbreaker Shape	T-DIA with rake	T-DIA	P
Cutting conditions	B014		

S

Application	Precision finishing	Finishing	Medium cutting
Grade	BX470	AH8005	AH8005
Chipbreaker Shape	T-CBN	HRF	HRM
Cutting conditions	B016		

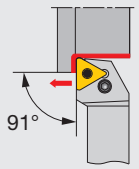
H

Application	Precision finishing	Finishing
Grade	BXM10	BXM20
Chipbreaker Shape	T-CBN	T-CBN
Cutting conditions	B018	

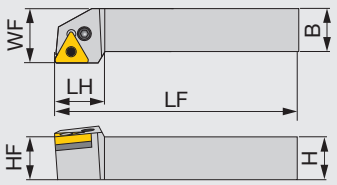
Reference pages: PTGNR/L-CHP: Inserts → B086 -, CBN → B178 -, PCD → B194 -
Parts for coolant hose → C142

PTGNR/L

Lever-lock toolholder with 91° approach angle, for negative 60° triangular inserts



Cutting edge style **G**



Right hand (R) shown.

Metric	H	B	LF	LH	HF	WF	RE**	Insert
PTGNR/L1616	16	16	100	22	16	20	0.8	TN**1604...
PTGNR/L2020	20	20	125	22	20	25	0.8	TN**1604...
PTGNR/L2525M3	25	25	150	22	25	32	0.8	TN**1604...
PTGNR/L2525M4	25	25	150	28	25	32	0.8	TN**2204...
PTGNR3225P4	32	25	170	28	32	32	0.8	TN**2204...

**RE: Standard corner radius

SPARE PARTS

Designation	Shim	Clamping screw	Wrench	Spring pin	Lever
PTGNR/L1616, 2020	LST317	LCS3	P-2.5	LSP3	LCL3
PTGNR/L2525M3	LST317	LCS3	P-2.5	LSP3	LCL3
PTGNR/L2525M4	LST42	LCS4	P-3	LSP4	LCL4
PTGNR3225P4	LST42	LCS4	P-3	LSP4	LCL4

INSERT SELECTION

P

Application	Precision finishing	Finishing	Medium cutting	Medium to heavy cutting
Grade	NS9530	GT9530	T9215	T9215
Chipbreaker Shape	TF	TSF	TM	TH
Cutting conditions	B008			

M

Application	Finishing	Medium cutting
Grade	T6120	T6130
Chipbreaker Shape	SF	SM
Cutting conditions	B010	

K

Application	Finishing	Medium cutting	Medium to heavy cutting
Grade	T515	T515	T515
Chipbreaker Shape	All-round	All-round	All-round
Cutting conditions	B012		

N

Application	Precision finishing	Finishing	Medium cutting
Grade	DX120	DX140	TH10
Chipbreaker Shape	T-DIA with rake	T-DIA	P
Cutting conditions	B014		

S

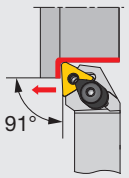
Application	Precision finishing	Finishing	Medium cutting
Grade	BX470	AH8005	AH8005
Chipbreaker Shape	T-CBN	HRF	HRM
Cutting conditions	B016		

H

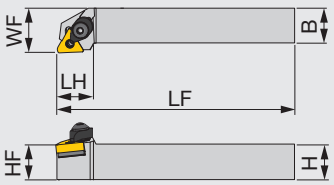
Application	Precision finishing	Finishing
Grade	BXM10	BXM20
Chipbreaker Shape	T-CBN	T-CBN
Cutting conditions	B018	

Reference pages: PTGNR/L: Inserts → B086 -, CBN → B178 -, PCD → B194 -

"One-Double" toolholder with 91° approach angle, for negative 60° triangular inserts



Cutting edge style **G**



Right hand (R) shown.

Metric	H	B	LF	LH	HF	WF	RE**	Insert
DTGNR/L2020K16	20	20	125	21	20	25	0.8	TN**1604...
DTGNR/L2525M16	25	25	150	21	25	32	0.8	TN**1604...
DTGNR/L2525M22	25	25	150	28	25	32	0.8	TN**2204...

Except for 57-type chipbreaker inserts
**RE: Standard corner radius

SPARE PARTS

Designation	Clamp	Lever	Piston	Clamp screw	Shim	Spring	Spring pin	Wrench 1	Wrench 2
DTGNR/L**16	DCPM-33	LCL33	DPIS33	DLCS33	LST317	BP-9	LSP3	P-2.5	P-3
DTGNR/L**22	DCPM-43	DLCL43	DPIS43	DLCS43	LST42	BP-10	LSP4	P-3	P-4

INSERT SELECTION

P

Application	Precision finishing	Finishing	Medium cutting	Medium to heavy cutting
Grade	NS9530	GT9530	T9215	T9215
Chipbreaker Shape	TF	TSF	TM	TH
Cutting conditions	B008			

M

Application	Finishing	Medium cutting
Grade	T6120	T6130
Chipbreaker Shape	SF	SM
Cutting conditions	B010	

K

Application	Finishing	Medium cutting	Medium to heavy cutting
Grade	T515	T515	T515
Chipbreaker Shape	All-round	All-round	All-round
Cutting conditions	B012		

N

Application	Precision finishing	Finishing	Medium cutting
Grade	DX120	DX140	TH10
Chipbreaker Shape	T-DIA with rake	T-DIA	P
Cutting conditions	B014		

S

Application	Precision finishing	Finishing	Medium cutting
Grade	BX470	AH8005	AH8005
Chipbreaker Shape	T-CBN	HRF	HRM
Cutting conditions	B016		

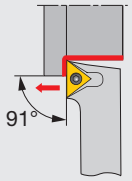
H

Application	Precision finishing	Finishing
Grade	BXM10	BXM20
Chipbreaker Shape	T-CBN	T-CBN
Cutting conditions	B018	

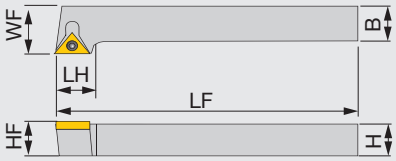
Reference pages: DTGNR/L: Inserts → B086 -, CBN → B178 -, PCD → B194 -

STGCR/L

Screw-on system toolholder with 91° approach angle for positive 60° triangular inserts



Cutting edge style **G**



Right hand (R) shown.

Inch	H	B	LF	LH	HF	WF	Insert
STGCR/L062	0.375	0.375	2.500	0.625	0.375	0.500	TC**21.5...
STGCR/L082	0.500	0.500	3.500	0.625	0.500	0.625	TC**21.5...
STGCR/L103	0.625	0.625	4.000	0.750	4.000	0.750	TC**32.5...
STGCR/L123	0.750	0.750	4.500	0.750	4.500	1.000	TC**32.5...

Except for 57-type chipbreaker inserts

SPARE PARTS

Designation	Shim	Shim screw	Clamp screw	Wrench
STGCR/L0...	-	-	CSTB2.5	T-7F
STGCR/L1...	SKTP-343	SRS-3	CSTB3.5	T-15F

INSERT SELECTION

P

Application	Precision finishing	Finishing	Finishing to medium cutting	Medium cutting
Grade	SH725	SH725	T9215	T9215
Chipbreaker shape	01	JS	PS	PM
Cutting conditions	B020			

M

Application	Precision finishing	Finishing	Finishing to medium cutting	Medium cutting
Grade	SH725	SH725	T9215	T9215
Chipbreaker shape	01	JS	PS	PM
Cutting conditions	B022			

K

Application	Finishing to medium cutting
Grade	T515
Chipbreaker shape	CM
Cutting conditions	B024

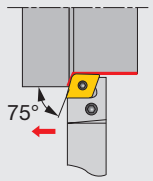
N

Application	Precision finishing	Medium cutting
Grade	DX120	KS05F
Chipbreaker shape	T-DIA	with rake AL
Cutting conditions	B026	

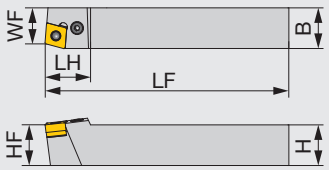
Reference pages: STGCR/L: Inserts→ B139 -, PCD → B196

PCBNR/L

Lever-lock toolholder with 75° approach angle, for negative 80° rhombic inserts



Cutting edge style **B**



Right hand (R) shown.

Metric	H	B	LF	LH	HF	WF	RE**	Insert
PCBNR/L2525	25	25	150	28	25	22	0.8	CN**1204...

100° corner is used.
**RE: Standard corner radius

SPARE PARTS

Designation	Shim	Clamping screw	Wrench	Spring pin	Lever
PCBNR/L2525	LSC42	LCS4	P-3	LSP4	LCL4

INSERT SELECTION

P

Application	Precision finishing	Finishing	Medium cutting	Medium to heavy cutting
Grade	NS9530	GT9530	T9215	T9215
Chipbreaker Shape	TF	TSF	TM	TH
Cutting conditions	B008			

M

Application	Finishing	Medium cutting	Medium to heavy cutting
Grade	T6120	T6130	T6130
Chipbreaker Shape	SF	SM	SH
Cutting conditions	B010		

K

Application	Finishing	Medium cutting	Medium to heavy cutting
Grade	T515	T515	T515
Chipbreaker Shape	All-round	All-round	All-round
Cutting conditions	B012		

N

Application	Medium cutting
Grade	TH10
Chipbreaker Shape	P
Cutting conditions	B014

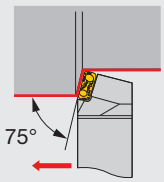
S

Application	Finishing	Medium cutting
Grade	AH8005	AH8005
Chipbreaker Shape	HRF	HRM
Cutting conditions	B016	

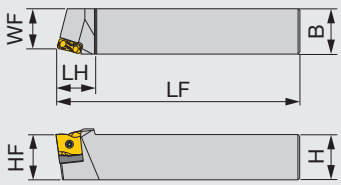
Reference pages: PCBNR/L: Inserts → B056 -, CBN → B172 -, PCD → B194 -

TLBNR/L

Screw-on toolholder for roughing with 75° approach angle, for negative tangential inserts



Cutting edge style **B**



Right hand (R) shown.

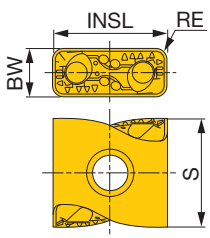
Inch	H	B	LF	LH	HF	WF	Insert
TLBNR/L24-24	1.500	1.500	7.874	1.378	1.500	1.378	LNMX2410**R/L...

SPARE PARTS

Designation	Clamping screw	Shim	Spring pin	Wrench
TLBNR24-24	CSTB-5L163-S	TSL24R	PSP-16	KEYV-T20
TLBNL24-24	CSTB-5L163-S	TSL24L	PSP-16	KEYV-T20

INSERT

LNMX12/16/24



P	Steel	★	★	★
M	Stainless			☆
K	Cast iron	☆	☆	☆
N	Non-ferrous			
S	Superalloys			
H	Hard materials			

★ : First choice
☆ : Second choice

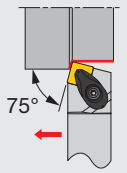
Designation	HAND	RE (in)	Coated T9115	Coated T9125	Coated AH725	BW (in)	INSL (in)	S (in)
LNMX120408R-TDR	R	0.031	●	●		0.189	0.472	0.457
LNMX120408L-TDR	L	0.031	●	●		0.189	0.472	0.457
LNMX120412R-TDR	R	0.047	●	●		0.189	0.472	0.457
LNMX120412L-TDR	L	0.047	●	●		0.189	0.472	0.457
LNMX160608R-TDR	R	0.031	●	●		0.252	0.638	0.531
LNMX160608L-TDR	L	0.031	●	●		0.252	0.638	0.531
LNMX160612R-TDR	R	0.047	●	●		0.252	0.638	0.531
LNMX160612L-TDR	L	0.047	●	●		0.252	0.638	0.531
LNMX160616R-TDR	R	0.063	●	●		0.252	0.638	0.531
LNMX160616L-TDR	L	0.063	●	●		0.252	0.638	0.531
LNMX241016R-TDR	R	0.063	●	●		0.370	0.945	0.807
LNMX241016L-TDR	L	0.063	●	●		0.370	0.945	0.807
LNMX241024R-TDR	R	0.094	●	●		0.370	0.945	0.807
LNMX241024L-TDR	L	0.094	●	●		0.370	0.945	0.807
LNMX160608R-MDR	R	0.031	●	●	●	0.252	0.638	0.531
LNMX160608L-MDR	L	0.031	●	●	●	0.252	0.638	0.531
LNMX160612R-MDR	R	0.047	●	●	●	0.252	0.638	0.531
LNMX160612L-MDR	L	0.047	●	●	●	0.252	0.638	0.531
LNMX160608R-TWR	R	0.031	●	●		0.252	0.638	0.531
LNMX160608L-TWR	L	0.031	●	●		0.252	0.638	0.531
LNMX160612R-TWR	R	0.047	●	●		0.252	0.638	0.531
LNMX160612L-TWR	L	0.047	●	●		0.252	0.638	0.531

● : Line up

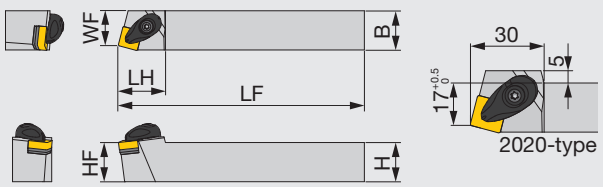
Reference pages:
Standard cutting conditions → C144

ASBNR/L

Double-clamp toolholder with 75° approach angle, for negative square inserts



Cutting edge style **B**



Right hand (R) shown.

Inch	H	B	LF	LH	HF	WF	RE**	Insert	Torque
ASBNR/L124-A	0.750	0.750	4.500	1.180	0.750	0.625	0.031	SN**43...	2.2
ASBNR/L164-A	1.000	1.000	6.000	1.180	1.000	0.875	0.031	SN**43...	2.2
ASBNR/L205-A	1.250	1.250	7.000	1.500	1.250	1.100	0.031	SN**54...	4.7
ASBNR/L245-A	1.500	1.500	8.000	1.500	1.500	1.350	0.031	SN**54...	4.7
ASBNR/L206-A	1.250	1.250	7.000	1.625	1.250	1.100	0.031	SN**64...	4.7
ASBNR/L246-A	1.500	1.500	8.000	1.625	1.500	1.350	0.031	SN**64...	4.7

Metric	H	B	LF	LH	HF	WF	RE**	Insert	Torque*
ASBNR/L2020K12-A	20	20	125	30	20	17	0.8	SN**1204...	3
ASBNR/L2525M12-A	25	25	150	30	25	22	0.8	SN**1204...	3
ASBNR/L2525M15-A	25	25	150	42.5	25	22	1.2	SN**1506...	6.4
ASBNR/L3232P15-A	32	32	170	42.5	32	27	1.2	SN**1506...	6.4
ASBNR/L3232P19-A	32	32	170	47.5	32	27	1.2	SN**1906...	6.4
ASBNR/L4040S19-A	40	40	250	47.5	40	35	1.2	SN**1906...	6.4

Torque: Recommended clamping torque: lbs·ft (*N·m)
**RE: Standard corner radius

SPARE PARTS

Designation	Clamp	Clamp screw	Spring	Spring pin	Shim	Shim screw	Wrench 1	Wrench 2
ASBNR/L**4-A, 12-A	ACP4S	ACS-5W	BP-7	SP-2.5	ASS422	CSTB-3.5	T-15F	-
ASBNR/L**5-A, 15-A	ACP5S	ACS-6W	BP-8.8	SP-2.5	ASS533	CSTB-5	-	KEYV-T20
ASBNR/L**6-A, 19-A	ACP6S	ACS-6W	BP-8.8	SP-2.5	ASS634	CSTB-5	-	KEYV-T20

INSERT SELECTION

P

Application	Precision finishing	Finishing	Medium cutting	Medium to heavy cutting
Grade	NS9530	GT9530	T9215	T9215
Chipbreaker Shape	TF	TSF	TM	TH
Cutting conditions	B008			

M

Application	Finishing	Medium cutting	Medium to heavy cutting
Grade	T6120	T6130	T6130
Chipbreaker Shape	SF	SM	SH
Cutting conditions	B010		

K

Application	Finishing	Medium cutting	Medium to heavy cutting
Grade	T515	T515	T515
Chipbreaker Shape	All-round	All-round	All-round
Cutting conditions	B012		

N

Application	Finishing	Medium cutting
Grade	DX140	TH10
Chipbreaker Shape	T-DIA	P
Cutting conditions	B014	

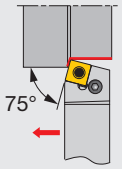
S

Application	Precision finishing	Finishing	Medium cutting
Grade	BX480	AH8005	AH8005
Chipbreaker Shape	T-CBN	HRF	HRM
Cutting conditions	B016		

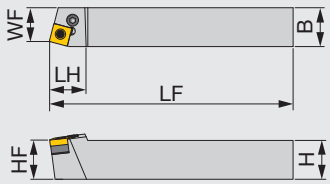
Reference pages: ASBNR/L: Inserts → B077 -, CBN → B177, PCD → B195

PSBNR/L

Lever-lock toolholder with 75° approach angle, for negative square inserts



Cutting edge style **B**



Right hand (R) shown.

Metric	H	B	LF	LH	HF	WF	RE**	Insert
PSBNR/L1616	16	16	100	22	16	13	0.8	SN**0903...
PSBNR/L2020	20	20	125	28	20	17	0.8	SN**1204...
PSBNR/L2525	25	25	150	24	25	22	0.8	SN**1204...
PSBNR/L3232	32	32	170	40	32	27	1.2	SN**1906...

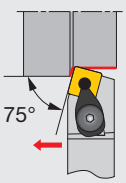
**RE: Standard corner radius

SPARE PARTS

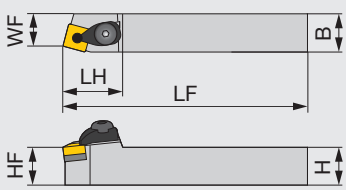
Designation	Shim	Clamping screw	Wrench	Spring pin	Lever
PSBNR/L1616	LSS33	LCS3	P-2.5	LSP3L	LCL3
PSBNR/L2*2*	LSS42	LCS4	P-3	LSP4	LCL4
PSBNR/L3232	LSS63	LCS6	P-4	LSP6	LCL6

DSBNR/L

"One-Double" toolholder with 75° approach angle, for negative square inserts



Cutting edge style **B**



Right hand (R) shown.

Metric	H	B	LF	LH	HF	WF	RE**	Insert
DSBNR/L2020K12	20	20	125	35	20	17	0.8	SN**1204...
DSBNR/L2525M12	25	25	150	35	25	22	0.8	SN**1204...

Except for 57-type chipbreaker inserts **RE: Standard corner radius

SPARE PARTS

Designation	Clamp	Lever	Piston	Clamp screw	Shim	Spring	Spring pin	Wrench 1	Wrench 2
DSBNR/L...	DCPM-43	DLCL43	DPIS43	DLCS43	LSS42	BP-10	LSP4	P-3	P-4

INSERT SELECTION

P

Application	Precision finishing	Finishing	Medium cutting	Medium to heavy cutting
Grade	NS9530	GT9530	T9215	T9215
Chipbreaker Shape	TF	TSF	TM	TH
Cutting conditions	B008			

M

Application	Finishing	Medium cutting	Medium to heavy cutting
Grade	T6120	T6130	T6130
Chipbreaker Shape	SF	SM	SH
Cutting conditions	B010		

K

Application	Finishing	Medium cutting	Medium to heavy cutting
Grade	T515	T515	T515
Chipbreaker Shape	All-round	All-round	All-round
Cutting conditions	B012		

N

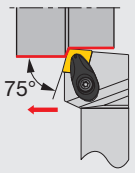
Application	Finishing	Medium cutting
Grade	DX140	TH10
Chipbreaker Shape	T-DIA	P
Cutting conditions	B014	

S

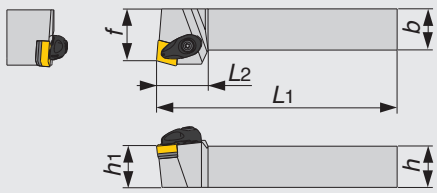
Application	Precision finishing	Finishing	Medium cutting
Grade	BX480	AH8005	AH8005
Chipbreaker Shape	T-CBN	HRF	HRM
Cutting conditions	B016		

Reference pages: PSBNR/L, DSBNR/L:
Inserts → B077 -, CBN → B177, PCD → B195

Double-clamp toolholder with 75° approach angle, for negative 80° rhombic inserts



Cutting edge style **R**



Right hand (R) shown.

Inch	H	B	LF	LH	HF	WF	RE**	Insert	Torque
ACRNR/L164-A	1.000	1.000	6.000	1.25	1.000	1.25	0.032	CN**43...	2.2

Torque: Recommended clamping torque: lbs·ft
**RE: Standard corner radius

SPARE PARTS

Designation	Clamp	Clamp screw	Spring	Spring pin	Shim	Shim screw	Wrench 1
ACRNR/L164-A	ACP4S	ACS-5W	BP-7	SP-2.5	ASC422	CSTB-3.5	T-15F

INSERT SELECTION

P

Application	Precision finishing	Finishing	Medium cutting	Medium to heavy cutting
Grade	NS9530	GT9530	T9215	T9215
Chipbreaker shape	TF	TSF	TM	TH
Cutting conditions	B008			

M

Application	Finishing	Medium cutting	Medium to heavy cutting
Grade	T6120	T6130	T6130
Chipbreaker shape	SF	SM	SH
Cutting conditions	B010		

K

Application	Finishing	Medium cutting	Medium to heavy cutting
Grade	T515	T515	T515
Chipbreaker shape	All-round	All-round	All-round
Cutting conditions	B012		

N

Application	Precision finishing	Finishing	Medium cutting
Grade	DX120	DX140	TH10
Chipbreaker shape	T-DIA with rake	T-DIA	P
Cutting conditions	B014		

S

Application	Precision finishing	Finishing	Medium cutting
Grade	BX470	AH8005	AH8005
Chipbreaker shape	T-CBN	HRF	HRM
Cutting conditions	B016		

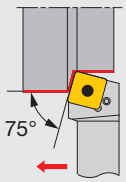
H

Application	Precision finishing	Finishing
Grade	BXM10	BXM20
Chipbreaker shape	T-CBN	T-CBN
Cutting conditions	B018	

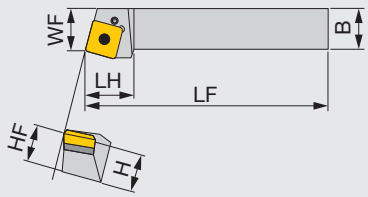
Reference pages: ACRNR/L: Inserts → B056 -, CBN → B172 -, PCD → B194 -

HSRNR/L

Retract-pin toolholder with 75° approach angle, for negative square inserts



Cutting edge style **R**



Right hand (R) shown.

Metric	H	B	LF	LH	HF	WF	RE**	Insert
HSRNR/L4040R	40	40	200	50	40	43	1.6	SNMM3109...
HSRNR/L5050S	50	50	250	60	50	53	1.6	SNMM3109...

**RE: Standard corner radius

SPARE PARTS

Designation	Pin	Clamping screw	Shim	Wrench
HSRNR/L...	SW99	LS-8	NAS-04	P-4

INSERT SELECTION

P

Application	Precision finishing	Finishing	Medium cutting	Medium to heavy cutting
Grade	NS9530	GT9530	T9215	T9215
Chipbreaker Shape	TF	TSF	TM	TH
Cutting conditions	B008			

M

Application	Finishing	Medium cutting	Medium to heavy cutting
Grade	T6120	T6130	T6130
Chipbreaker Shape	SF	SM	SH
Cutting conditions	B010		

K

Application	Finishing	Medium cutting	Medium to heavy cutting
Grade	T515	T515	T515
Chipbreaker Shape	All-round	All-round	All-round
Cutting conditions	B012		

N

Application	Finishing	Medium cutting
Grade	DX140	TH10
Chipbreaker Shape	T-DIA	P
Cutting conditions	B014	

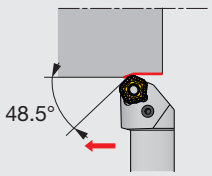
S

Application	Precision finishing	Finishing	Medium cutting
Grade	BX480	AH8005	AH8005
Chipbreaker Shape	T-CBN	HRF	HRM
Cutting conditions	B016		

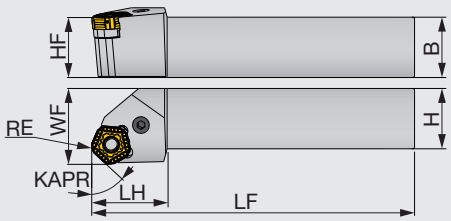
Reference pages: HSRNR/L: Inserts → B083

PPXOR/L-HD

Lever-lock toolholder with 48.5° approach angle, for negative 108° pentagonal inserts



Cutting edge style **X**



Inch	H	B	LF	LH	HF	WF	KAPR	RE	Insert
PPXOR/L165-HD	1.000	1.000	6.000	1.380	1.000	1.260	48.5°	0.047	POMG110612
PPXOR/L206-HD	1.250	1.250	7.000	1.500	1.250	1.510	48.5°	0.047	POMG130612

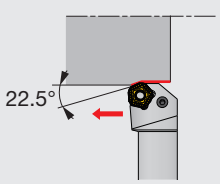
Metric	H	B	LF	LH	HF	WF	KAPR	RE	Insert
PPXOR/L2525M11-HD	25	25	150	35	25	32	48.5°	1.2	POMG110612
PPXOR/L3232P13-HD	32	32	170	40	32	40	48.5°	1.2	POMG130612

SPARE PARTS

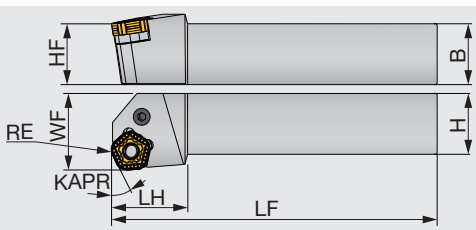
Designation	Shim	Spring pin	Lever	Clamping screw	Wrench
PPXOR/L165-HD PPXOR/L2525M11-HD	LSPO53	LSP5	LCL5	LCS5	P-3
PPXOR/L206-HD PPXOR/L3232P13-HD	LSPO63	LSP6	LCL6	LCS6	P-4

PPXOR/L-HF

Lever-lock toolholder with 22.5° approach angle, for negative 108° pentagonal inserts



Cutting edge style **X**



Inch	H	B	LF	LH	HF	WF	KAPR	RE	Insert
PPXOR/L165-HF	1.000	1.000	6.000	1.380	1.000	1.260	22.5°	0.047	POMG110612
PPXOR/L206-HF	1.250	1.250	7.000	1.500	1.250	1.510	22.5°	0.047	POMG130612

Metric	H	B	LF	LH	HF	WF	KAPR	RE	Insert
PPXOR/L2525M11-HF	25	25	150	35	25	32	22.5°	1.2	POMG110612
PPXOR/L3232P13-HF	32	32	170	40	32	40	22.5°	1.2	POMG130612

SPARE PARTS

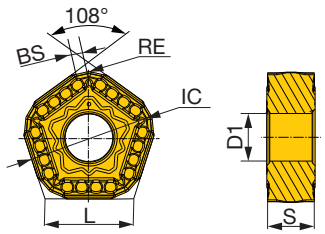
Designation	Shim	Spring pin	Lever	Clamping screw	Wrench
PPXOR/L165-HF PPXOR/L2525M11-HF	LSPO53	LSP5	LCL5	LCS5	P-3
PPXOR/L206-HF PPXOR/L3232P13-HF	LSPO63	LSP6	LCL6	LCS6	P-4

Note : Since the corner angle of TurnTenFeed insert is 108°, the workpiece corner may require additional post-process to remove stock to achieve a right angle.

Reference pages: Inserts → C103, Standard cutting conditions → C143

INSERT

POMG-MNW



P	Steel	★	★	★			
M	Stainless				☆		
K	Cast iron	☆	☆	☆			
N	Non-ferrous						
S	Superalloys				★		
H	Hard materials						

★ : First choice
☆ : Second choice

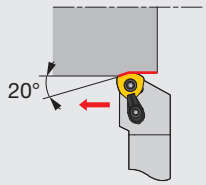
Designation	RE (in)	Coated									IC (in)	L (in)	BS (in)	S (in)	D1 (in)
		T9225	T9215	T9125	AH8015										
POMG110612-MNW	0.047	●	●	●	●						0.625	0.454	0.059	0.250	0.047
POMG130612-MNW	0.047	●	●	●	●						0.750	0.545	0.079	0.250	0.047

● : Line up

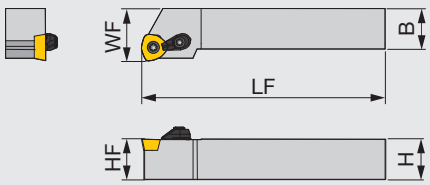
Reference pages: Standard cutting conditions → C143

XWXPR/L

Double-clamp toolholder for roughing with 20° approach angle, for positive 80° trigon inserts



Cutting edge style **X**



Right hand (R) shown.

Inch	H	B	LF	HF	WF	Insert
XWXPR/L16-09	1.000	1.000	6.000	1.000	1.250	WPMT090725ZPR/L-ML
XWXPR/L20-09	1.250	1.250	7.000	1.250	1.500	WPMT090725ZPR/L-ML
XWXPR/L24-09	1.500	1.500	7.000	1.500	2.000	WPMT090725ZPR/L-ML

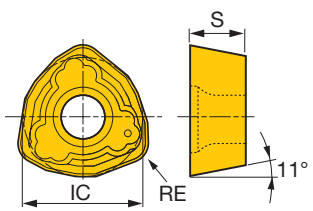
SPARE PARTS

Designation	Clamp set	Clamping screw	Wrench
XWXPR/L....	CSY-20	CSPB-5	IP-20T

Each insert is either right- or left-handed. Please be sure not to use a wrong insert.

INSERT

WPMT09-ML



P	Steel	★	★	★	★	★			
M	Stainless					☆			
K	Cast iron	☆	☆	☆	☆	☆			
N	Non-ferrous								
S	Superalloys								
H	Hard materials								

★ : First choice
☆ : Second choice

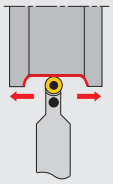
Designation	Max. *ap* (in)	RE (in)	Coated								IC (in)	S (in)
			T9225	T9215	T9115	T9125	AH120					
WPMT090725ZPR-ML	0.118	0.098	●	●	●	●	●				0.059	0.276
WPMT090725ZPL-ML	0.118	0.098	●	●	●	●	●				0.059	0.276

● : Line up

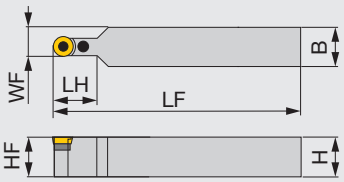
Reference pages: Standard cutting conditions → C143

PRDCN

Lever-lock toolholder with 45° approach angle, for positive round inserts



Cutting edge style **D**



Metric	H	B	LF	LH	HF	WF	Insert
PRDCN2020K10	20	20	125	22	20	15	RCMM1003...
PRDCN2525M12	25	25	150	24	25	18.5	RCM*1204...
PRDCN3225P12	32	25	170	24	32	18.5	RCM*1204...
PRDCN3225P16	32	25	170	28	32	20.5	RCM*1606...
PRDCN3232P20	32	32	170	32	32	26	RCM*2006...
PRDCN4040R25	40	40	200	42	40	32.5	RCM*2507...

SPARE PARTS

Designation	Shim	Clamping screw	Wrench	Spring pin	Lever
PRDCN2020K10	LSR32C	LCS2	P-2	LSP3	LCL3C
PRDCN**25*12	LSR42C	LCS3	P-2.5	LSP3	LCL4C
PRDCN3225P16	LSR53C	LCS5	P-3	LSP4	LCL5C
PRDCN3232P20	LSR63C	LCS5	P-3	LSP6C	LCL6C
PRDCN4040R25	LSR84C	LCS8C	P-4	LSP6	LCL8C

INSERT SELECTION

P

Application	Finishing to medium cutting	Heavy cutting
Grade	T9215	T9215
Chipbreaker Shape	RS 	61 
Cutting conditions	B020	

M

Application	Heavy cutting
Grade	T9215
Chipbreaker Shape	61 
Cutting conditions	B022

K

Application	Heavy cutting
Grade	T9215
Chipbreaker Shape	61 
Cutting conditions	B024

N

Application	Finishing to medium cutting
Grade	KS05F
Chipbreaker Shape	AL 
Cutting conditions	B026

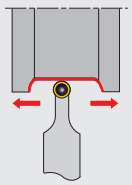
S

Application	Finishing to medium cutting	Heavy cutting
Grade	AH8015	AH8015
Chipbreaker Shape	RS 	61 
Cutting conditions	B028	

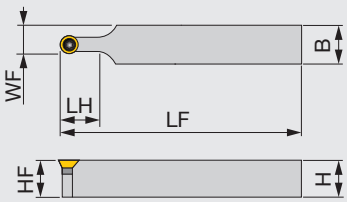
Reference pages: PRDCN: Inserts → **B131 -**

SRDCN

Screw-on toolholder with 45° approach angle, for positive round inserts



Cutting edge style **D**



Metric	H	B	LF	LH	HF	WF	Insert
SRDCN2020K06	20	20	125	12	20	13	RC*T0602...
SRDCN2020K08	20	20	125	16	20	14	RC*T0803...
SRDCN2020K10	20	20	125	20.3	25	15	RC*T1003...
SRDCN2525M06	25	25	150	12	25	15.5	RC*T0602...
SRDCN2525M08	25	25	150	16	25	16.5	RC*T0803...
SRDCN2525M10	25	25	150	20.3	25	17.5	RC*T1003...

SPARE PARTS

Designation	Clamping screw	Shim screw	Shim	Wrench 1	Wrench 2
SRDCN2020K06	CSTB-2.5	-	-	-	T-8F
SRDCN2020K08	CSTB-3	-	-	-	T-9F
SRDCN2020K10	CSTB-3.5L	DTS5-3.5	SSR32	P-3.5	T-15F
SRDCN2525M06	CSTB-2.5	-	-	-	T-8F
SRDCN2525M08	CSTB-3	-	-	-	T-9F
SRDCN2525M10	CSTB-3.5L	DTS5-3.5	SSR32	P-3.5	T-15F

INSERT SELECTION

P

Application	Finishing to medium cutting	Heavy cutting
Grade	T9215	T9215
Chipbreaker Shape	RS 	61 
Cutting conditions	B020	

M

Application	Heavy cutting
Grade	T9215
Chipbreaker Shape	61 
Cutting conditions	B022

K

Application	Heavy cutting
Grade	T9215
Chipbreaker Shape	61 
Cutting conditions	B024

N

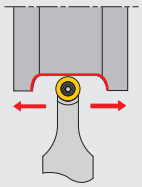
Application	Finishing to medium cutting
Grade	KS05F
Chipbreaker Shape	AL 
Cutting conditions	B026

S

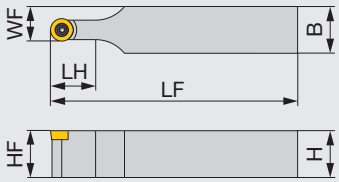
Application	Finishing to medium cutting	Heavy cutting
Grade	AH8015	AH8015
Chipbreaker Shape	RS 	61 
Cutting conditions	B028	

Reference pages: SRDCN: Inserts → **B131 -**

Screw-on toolholder with 45° approach angle, for positive round inserts



Cutting edge style **D**



Inch	H	B	LF	LH	HF	WF	Insert	Torque
SRDCN164-6F	1.00	1.00	6.00	0.95	1.00	0.74	RCMT1204M0-6RS/-6RM	2.21

Metric	H	B	LF	LH	HF	WF	Insert	Torque*
SRDCN2525M12-6F	25	25	150	24.1	25	18.5	RCMT1204M0-6RS/-6RM	3

Torque: Recommended clamping torque: lb·ft (*N·m)

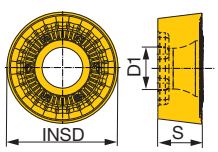
SPARE PARTS

Designation	Clamping screw	Lubricant	Wrench
SRDCN164-6F, SRDCN2525M12-6F	CSTB-4	M-1000	T-15F

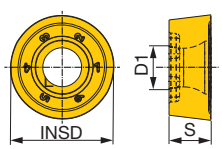
INSERT

RCMT

6RS



6RM



		6RS					6RM			
P	Steel	★	★	★	★		★			
M	Stainless									
K	Cast iron	☆	☆	☆	☆		☆			
N	Non-ferrous									
S	Superalloys									
H	Hard materials									

★ : First choice
☆ : Second choice

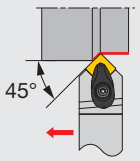
Designation	Coated					Cermet					INSD (in)	S (in)	D1 (in)
	T9225	T9215	T9115	T9125		NS9530							
RCMT1204M0-6RS	●	●	●	●		●					0.472	0.187	0.203
RCMT1204M0-6RM	●	●	●	●		●					0.472	0.187	0.203

● : Line up

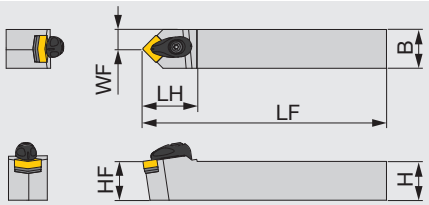
Reference pages: SRDCN: Standard cutting conditions → C142

ASDNN

Double-clamp toolholder with 45° approach angle, for negative square inserts



Cutting edge style **D**



Inch	H	B	LF	LH	HF	WF	RE**	Insert	Torque
ASDNN124-A	0.750	0.750	4.500	1.380	0.750	0.375	0.031	SN**43...	2.2
ASDNN164-A	1.000	1.000	6.000	1.380	1.000	0.500	0.031	SN**43...	2.2

Metric	H	B	LF	LH	HF	WF	RE**	Insert	Torque*
ASDNN2020K12-A	20	20	125	35	20	10	0.8	SN**1204...	3
ASDNN2525M12-A	25	25	150	35	25	12.5	0.8	SN**1204...	3

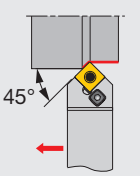
Torque: Recommended clamping torque: lbs·ft (*N·m) **RE: Standard corner radius

SPARE PARTS

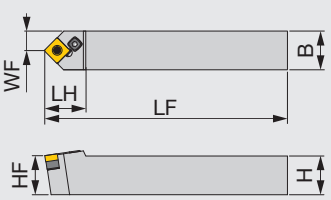
Designation	Clamp	Clamp screw	Spring	Spring pin	Shim	Shim screw	Wrench
ASDNN**4-A, 12-A	ACP4S	ACS-5W	BP-7	SP-2.5	ASS422	CSTB-3.5	T-15F

PSDNN

Lever-lock toolholder with 45° approach angle, for positive round inserts



Cutting edge style **D**



Metric	H	B	LF	LH	HF	WF	RE**	Insert
PSDNN1616	16	16	100	22	16	8	0.8	SN**0903...
PSDNN2020	20	20	125	30	20	10.3	0.8	SN**1204...
PSDNN2525	25	25	150	30	25	12.8	0.8	SN**1204...

**RE: Standard corner radius

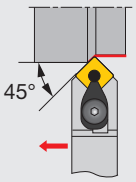
SPARE PARTS

Designation	Shim	Clamping screw	Wrench	Spring pin	Lever
PSDNN1616	LSS33	LCS3	P-2.5	LSP3L	LCL3
PSDNN2020	LSS42	LCS4	P-3	LSP4	LCL4
PSDNN2525	LSS42	LCS4	P-3	LSP4	LCL4

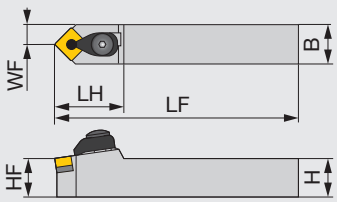
Reference pages: ASDNN, PSDNN: Inserts → B077 -, CBN → B177, PCD → B195

DSDNN

One-Double toolholder with 45° approach angle, for negative square inserts



Cutting edge style **D**



Metric	H	B	LF	LH	HF	WF	RE**	Insert
DSDNN2020K12	20	20	125	36	20	10	0.8	SN**1204...
DSDNN2525M12	25	25	150	36	25	12.5	0.8	SN**1204...

Except for 57-type chipbreaker inserts
**RE: Standard corner radius

SPARE PARTS

Designation	Clamp	Lever	Piston	Clamp screw	Shim	Spring	Spring pin	Wrench 1	Wrench 2
DSDNN...	DCPM-43	DLCL43	DPIS43	DLCS43	LSS42	BP-10	LSP4	P-3	P-4

INSERT SELECTION

P

Application	Precision finishing	Finishing	Medium cutting	Medium to heavy cutting
Grade	NS9530	GT9530	T9215	T9215
Chipbreaker Shape	TF	TSF	TM	TH
Cutting conditions	B008			

M

Application	Finishing	Medium cutting	Medium to heavy cutting
Grade	T6120	T6130	T6130
Chipbreaker Shape	SF	SM	SH
Cutting conditions	B010		

K

Application	Finishing	Medium cutting	Medium to heavy cutting
Grade	T515	T515	T515
Chipbreaker Shape	All-round	All-round	All-round
Cutting conditions	B012		

N

Application	Finishing	Medium cutting
Grade	DX140	TH10
Chipbreaker Shape	T-DIA	P
Cutting conditions	B014	

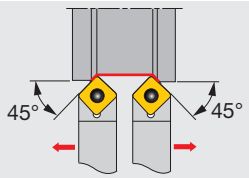
S

Application	Precision finishing	Finishing	Medium cutting
Grade	BX480	AH8005	AH8005
Chipbreaker Shape	T-CBN	HRF	HRM
Cutting conditions	B016		

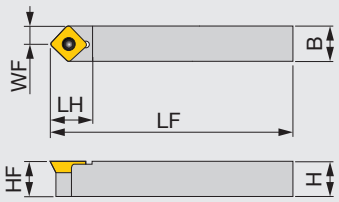
Reference pages: DSDNN: Inserts → B077 -, CBN → B177, PCD → B195

SSDC/PN

Screw-on toolholder with 45° approach angle, for positive square inserts



Cutting edge style **D**



Metric	H	B	LF	LH	HF	WF	RE**	Insert
SSDCN1010K07	10	10	125	12	10	5	0.4	SC**0702...
SSDPN1010H	10	10	100	12	10	5	0.4	SP*P042...
SSDCN1212K09	12	12	125	15	12	6	0.8	SC**09T3...
SSDPN1212H	12	12	100	12	12	6	0.4	SP*P042...
SSDCN1616H09	16	16	100	15	16	8	0.8	SC**09T3...
SSDPN1616H	16	16	100	14	16	8	0.8	SP*M322...

**RE: Standard corner radius

SPARE PARTS

Designation	Clamping screw	Shim screw	Shim	Wrench 1	Wrench 2
SSDCN1010K07	CSTB-3	-	-	-	T-9F
SSDPN1010H	CSTA-NO3	-	-	-	T-9F
SSDCN1212K09	CSTB-4	-	-	-	T-15F
SSDPN1212H	CSTA-NO3	-	-	-	T-9F
SSDCN1616H09	CSTB-3.5L	DTS5-3.5	SSS32	P-3.5	T-15F
SSDPN1616H	CSTA-NO5	-	-	-	T-9F

INSERT SELECTION

P

Application	Finishing to medium cutting	Medium cutting
Grade	T9215	T9215
Chipbreaker Shape	PS	PM
Cutting conditions	B020	

M

Application	Medium cutting
Grade	T6130
Chipbreaker Shape	PM
Cutting conditions	B022

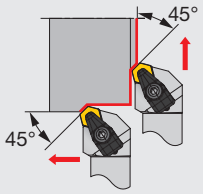
K

Application	Finishing to medium cutting
Grade	T515
Chipbreaker Shape	CM
Cutting conditions	B024

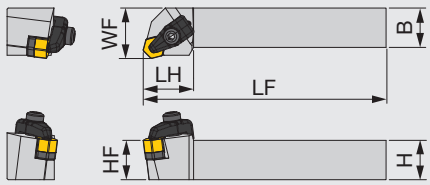
Reference pages: SSDC/PN: Inserts → B135, J092

CHSNR-RD

Double-clamp toolholder with 45° approach angle, for negative 120° hexagonal ceramic inserts with dimple



Cutting edge style **S**



Right hand (R) shown.

Inch	H	B	LF	LH	HF	WF	RE**	Insert	Torque
CHSNR16M45-RD	1.000	1.000	6.000	1.260	1.000	1.250	0.047	HNGD45...	3.0

Torque: Recommended clamping torque: lb·ft
**RE: Standard corner radius

SPARE PARTS

Designation	Clamp	Clamp screw	Shim	Shim screw	Spring	Wrench 1	Wrench 2
CHSNR16M45-RD	CCP4-A	CCS4-A	CH44-A	BH-40050-A	BP-5-A	P-3	P-4

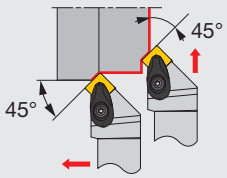
INSERT SELECTION

K	Application	Finishing to medium cutting
	Grade	FX105
	Chipbreaker Shape	- 
	Cutting conditions	C144

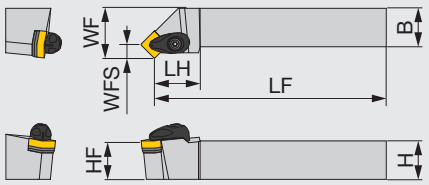
Reference pages: CHSNR-RD: Inserts → B110
Standard cutting conditions → C144

ASSNR/L

Double-clamp toolholder with 45° approach angle (S-style), for negative square inserts



Cutting edge style **S**



Right hand (R) shown.

Inch	H	B	LF	LH	HF	WF	WFS	RE**	Insert	Torque
ASSNR/L124-A	0.750	0.750	4.500	1.250	0.750	1.000	0.327	0.031	SN**43...	2.2
ASSNR/L164-A	1.000	1.000	6.000	1.250	1.000	1.250	0.327	0.031	SN**43...	2.2
ASSNR/L205-A	1.250	1.250	7.000	1.500	1.250	1.500	0.406	0.031	SN**54...	4.7
ASSNR/L245-A	1.500	1.500	8.000	1.500	1.500	1.750	0.406	0.031	SN**54...	4.7
ASSNR/L206-A	1.250	1.250	7.000	1.500	1.250	1.500	0.492	0.031	SN**64...	4.7
ASSNR/L246-A	1.500	1.500	8.000	1.500	1.500	1.750	0.492	0.031	SN**64...	4.7

Metric	H	B	LF	LH	HF	WF	WFS	RE**	Insert	Torque*
ASSNR/L2020K12-A	20	20	125	30	20	25	8.3	0.8	SN**1204...	3
ASSNR/L2525M12-A	25	25	150	30	25	32	8.3	0.8	SN**1204...	3
ASSNR/L2525M15-A	25	25	150	25	25	32	10.3	1.2	SN**1506...	6.4
ASSNR/L3232P15-A	32	32	170	25	32	40	10.3	1.2	SN**1506...	6.4
ASSNR/L3232P19-A	32	32	170	27.5	32	40	12.5	1.2	SN**1906...	6.4
ASSNR/L4040S19-A	40	40	250	27.5	40	50	12.5	1.2	SN**1906...	6.4

Torque: Recommended clamping torque: lbs·ft (*N·m)
**RE: Standard corner radius

SPARE PARTS

Designation	Clamp	Clamp screw	Spring	Spring pin	Shim	Shim screw	Wrench 1	Wrench 2
ASSNR/L**4-A, 12-A	ACP4S	ACS-5W	BP-7	SP-2.5	ASS422	CSTB-3.5	T-15F	-
ASSNR/L**5-A, 15-A	ACP5S	ACS-6W	BP-8.8	SP-2.5	ASS533	CSTB-5	-	KEYV-T20
ASSNR/L**6-A, 19-A	ACP6S	ACS-6W	BP-8.8	SP-2.5	ASS634	CSTB-5	-	KEYV-T20

INSERT SELECTION

P

Application	Precision finishing	Finishing	Medium cutting	Medium to heavy cutting
Grade	NS9530	GT9530	T9215	T9215
Chipbreaker Shape	TF	TSF	TM	TH
Cutting conditions	B008			

M

Application	Finishing	Medium cutting	Medium to heavy cutting
Grade	T6120	T6130	T6130
Chipbreaker Shape	SF	SM	SH
Cutting conditions	B010		

K

Application	Finishing	Medium cutting	Medium to heavy cutting
Grade	T515	T515	T515
Chipbreaker Shape	All-round	All-round	All-round
Cutting conditions	B012		

N

Application	Medium cutting
Grade	TH10
Chipbreaker Shape	P
Cutting conditions	B014

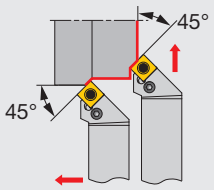
S

Application	Precision finishing	Finishing	Medium cutting
Grade	BX480	AH8005	AH8005
Chipbreaker Shape	T-CBN	HRF	HRM
Cutting conditions	B016		

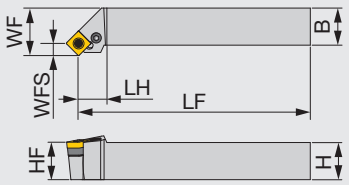
Reference pages: ASSNR/L: Inserts → B077 -, CBN → B177, PCD → B195

PSSNR/L

Lever-lock toolholder with 45° approach angle, for positive round inserts



Cutting edge style **S**



Right hand (R) shown.

Metric	H	B	LF	LH	HF	WF	WFS	RE**	Insert
PSSNR/L1616	16	16	94	16	16	20	6.1	0.8	SN**0903...
PSSNR/L2020	20	20	116	21	20	25	8.3	0.8	SN**1204...
PSSNR/L2525	25	25	141	21	25	32	8.3	0.8	SN**1204...
PSSNR3225	32	25	161	21	32	32	8.3	0.8	SN**1204...
PSSNR/L3232	32	32	157.5	27.5	32	40	12.5	1.2	SN**1906...

**RE: Standard corner radius

SPARE PARTS

Designation	Shim	Clamping screw	Wrench	Spring pin	Lever
PSSNR/L1616	LSS33	LCS3	P-2.5	LSP3L	LCL3
PSSNR/L2020	LSS42	LCS4	P-3	LSP4	LCL4
PSSNR/L**25	LSS42	LCS4	P-3	LSP4	LCL4
PSSNR/L3232	LSS63	LCS6	P-4	LSP6	LCL6

INSERT SELECTION

P

Application	Precision finishing	Finishing	Medium cutting	Medium to heavy cutting
Grade	NS9530	GT9530	T9215	T9215
Chipbreaker Shape	TF	TSF	TM	TH
Cutting conditions	B008			

M

Application	Finishing	Medium cutting	Medium to heavy cutting
Grade	T6120	T6130	T6130
Chipbreaker Shape	SF	SM	SH
Cutting conditions	B010		

K

Application	Finishing	Medium cutting	Medium to heavy cutting
Grade	T515	T515	T515
Chipbreaker Shape	All-round	All-round	All-round
Cutting conditions	B012		

N

Application	Medium cutting
Grade	TH10
Chipbreaker Shape	P
Cutting conditions	B014

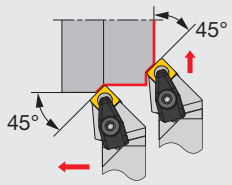
S

Application	Precision finishing	Finishing	Medium cutting
Grade	BX480	AH8005	AH8005
Chipbreaker Shape	T-CBN	HRF	HRM
Cutting conditions	B016		

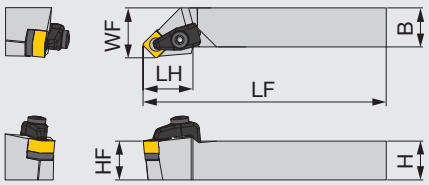
Reference pages: PSSNR/L: Inserts → B077 -, CBN → B177, PCD → B195

CSSNR/L-RD

Double-clamp toolholder with 45° approach angle, for negative square ceramic inserts with dimple



Cutting edge style **S**



Right hand (R) shown.

Inch	H	B	LF	LH	HF	WF	RE**	Insert	Torque
CSSNR/L16M45-RD	1.000	1.000	6.000	1.260	1.000	1.250	0.047	SNGD45...	3.0

Torque: Recommended clamping torque: lb·ft
**RE : Standard corner radius

SPARE PARTS

Designation	Clamp	Clamp screw	Shim	Shim screw	Spring	Wrench 1	Wrench 2
CSSNR/L16M45-RD	CCP4-A	CCS4-A	CS44-A	BH5-10-A	BP-5-A	P-3	P-4

INSERT SELECTION

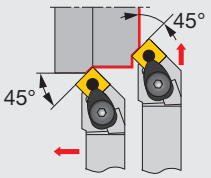
K

Application	Finishing to medium cutting
Grade	FX105
Chipbreaker Shape	- 
Cutting conditions	C144

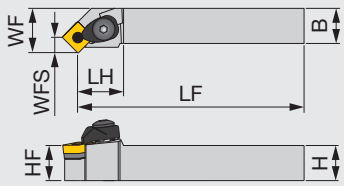
Reference pages: CSSNR/L-RD: Insert → B085
Standard cutting conditions → C144

DSSNR/L

"One-Double" toolholder with 45° approach angle, for negative square inserts



Cutting edge style **S**



Right hand (R) shown.

Metric	H	B	LF	LH	HF	WF	WFS	RE**	Insert
DSSNR/L2020K12	20	20	125	34.3	20	25	8.3	0.8	SN**1204...
DSSNR/L2525M12	25	25	150	34.3	25	32	8.3	0.8	SN**1204...

Except for 57-type chipbreaker inserts
**RE : Standard corner radius

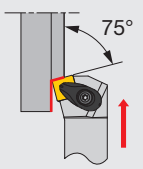
SPARE PARTS

Designation	Clamp	Lever	Piston	Clamp screw	Shim	Spring	Spring pin	Wrench 1	Wrench 2
DSSNR/L...	DCPM-43	DLCL43	DPIS43	DLCS43	LSS42	BP-10	LSP4	P-3	P-4

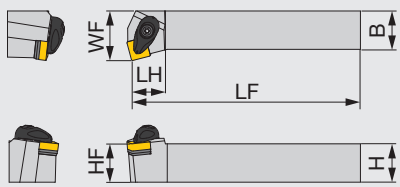
TURNINGA

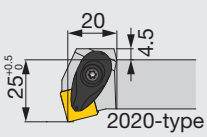
ASKNR/L

Double-clamp toolholder with 75° approach angle, for negative square inserts



Cutting edge style **K**





Right hand (R) shown.

Inch	H	B	LF	LH	HF	WF	RE**	Insert	Torque
ASKNR/L124-A	0.750	0.750	4.500	0.875	0.750	1.000	0.031	SN**43...	2.21
ASKNR/L164-A	1.000	1.000	6.000	1.000	1.000	1.260	0.031	SN**43...	2.21

Torque: Recommended clamping torque: lbs·ft
**RE : Standard corner radius

SPARE PARTS

Designation	Clamp	Clamp screw	Spring	Spring pin	Shim	Shim screw	Wrench
ASKNR/L**4-A	ACP4S	ACS-5W	BP-7	SP-2.5	ASS422	CSTB-3.5	T-15F

INSERT SELECTION

P

Application	Precision finishing	Finishing	Medium cutting	Medium to heavy cutting
Grade	NS9530	GT9530	T9215	T9215
Chipbreaker Shape	TF	TSF	TM	TH
Cutting conditions	B008			

M

Application	Finishing	Medium cutting	Medium to heavy cutting
Grade	T6120	T6130	T6130
Chipbreaker Shape	SF	SM	SH
Cutting conditions	B010		

K

Application	Finishing	Medium cutting	Medium to heavy cutting
Grade	T515	T515	T515
Chipbreaker Shape	All-round	All-round	All-round
Cutting conditions	B012		

N

Application	Finishing	Medium cutting
Grade	DX140	TH10
Chipbreaker Shape	T-DIA	P
Cutting conditions	B014	

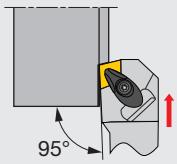
S

Application	Precision finishing	Finishing	Medium cutting
Grade	BX480	AH8005	AH8005
Chipbreaker Shape	T-CBN	HRF	HRM
Cutting conditions	B016		

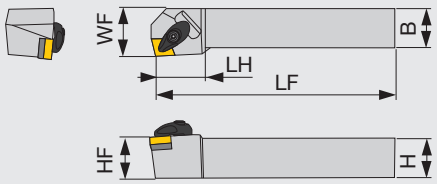
Reference pages: DSSNR/L, ASKNR/L:
Inserts → B077 -, CBN → B177, PCD → B195

ACKNR/L

Double-clamp toolholder with 95° approach angle, for negative 80° rhombic inserts



Cutting edge style **K**



Right hand (R) shown.

Inch	H	B	LF	LH	HF	WF	RE**	Insert	Torque
ACKNR/L164-A	1.000	1.000	6.000	1.375	1.000	1.312	0.032	CN**43...	2.2

Torque: Recommended clamping torque: lbs·ft
**RE : Standard corner radius

SPARE PARTS

Designation	Clamp	Clamp screw	Spring	Spring pin	Shim	Shim screw	Wrench 1
ACKNR/L164-A	ACP4S	ACS-5W	BP-7	SP-2.5	ASC422	CSTB-3.5	T-15F

INSERT SELECTION

P

Application	Precision finishing	Finishing	Medium cutting	Medium to heavy cutting
Grade	NS9530	GT9530	T9215	T9215
Chipbreaker shape	TF	TSF	TM	TH
Cutting conditions	B008			

M

Application	Finishing	Medium cutting	Medium to heavy cutting
Grade	T6120	T6130	T6130
Chipbreaker shape	SF	SM	SH
Cutting conditions	B010		

K

Application	Finishing	Medium cutting	Medium to heavy cutting
Grade	T515	T515	T515
Chipbreaker shape	All-round	All-round	All-round
Cutting conditions	B012		

N

Application	Precision finishing	Finishing	Medium cutting
Grade	DX120	DX140	TH10
Chipbreaker shape	T-DIA with rake	T-DIA	P
Cutting conditions	B014		

S

Application	Precision finishing	Finishing	Medium cutting
Grade	BX470	AH8005	AH8005
Chipbreaker shape	T-CBN	HRF	HRM
Cutting conditions	B016		

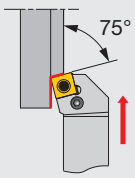
H

Application	Precision finishing	Finishing
Grade	BXM10	BXM20
Chipbreaker shape	T-CBN	T-CBN
Cutting conditions	B018	

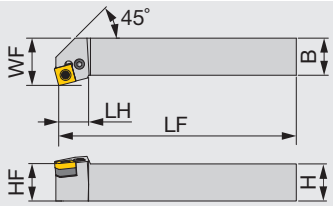
Reference pages: ACKNR/L: Inserts → B056 -, CBN → B172 -, PCD → B194 -

PSKNR/L

Lever-lock toolholder with 75° approach angle, for negative square inserts



Cutting edge style **K**



Right hand (R) shown.

Metric	H	B	LF	LH	HF	WF	RE**	Insert
PSKNR/L1616	16	16	100	17	16	25	0.8	SN**0903...
PSKNR/L2020	20	20	125	22	20	25	0.8	SN**1204...
PSKNR/L2525	25	25	150	22	25	32	0.8	SN**1204...
PSKNR3232	32	32	170	40	32	40	1.2	SN**1906...

**RE : Standard corner radius

SPARE PARTS

Designation	Shim	Clamping screw	Wrench	Spring pin	Lever
PSKNR/L1616	LSS33	LCS3	P-2.5	LSP3L	LCL3
PSKNR/L2*2*	LSS42	LCS4	P-3	LSP4	LCL4
PSKNR3232	LSS63	LCS6	P-4	LSP6	LCL6

INSERT SELECTION

P

Application	Precision finishing	Finishing	Medium cutting	Medium to heavy cutting
Grade	NS9530	GT9530	T9215	T9215
Chipbreaker Shape	TF	TSF	TM	TH
Cutting conditions	B008			

M

Application	Finishing	Medium cutting	Medium to heavy cutting
Grade	T6120	T6130	T6130
Chipbreaker Shape	SF	SM	SH
Cutting conditions	B010		

K

Application	Finishing	Medium cutting	Medium to heavy cutting
Grade	T515	T515	T515
Chipbreaker Shape	All-round	All-round	All-round
Cutting conditions	B012		

N

Application	Finishing	Medium cutting
Grade	DX140	TH10
Chipbreaker Shape	T-DIA	P
Cutting conditions	B014	

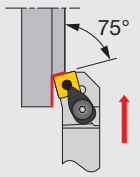
S

Application	Precision finishing	Finishing	Medium cutting
Grade	BX480	AH8005	AH8005
Chipbreaker Shape	T-CBN	HRF	HRM
Cutting conditions	B016		

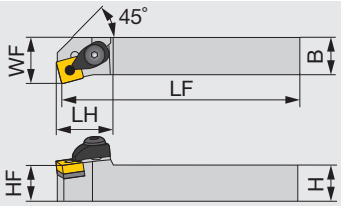
Reference pages: PSKNR/L: Inserts → B077 -, CBN → B177, PCD → B195

DSKNR/L

"One-Double" toolholder with 75° approach angle, for negative square inserts



Cutting edge style **K**



Right hand (R) shown.

Metric	H	B	LF	LH	HF	WF	RE**	Insert
DSKNR/L2020K12	20	20	125	31	20	25	0.8	SN**1204...
DSKNR/L2525M12	25	25	150	31	25	32	0.8	SN**1204...

Except for 57-type chipbreaker inserts
**RE : Standard corner radius

SPARE PARTS

Designation	Clamp	Lever	Piston	Clamp screw	Shim	Spring	Spring pin	Wrench 1	Wrench 2
DSKNR/L...	DCPM-43	DLCL43	DPIS43	DLCS43	LSS42	BP-10	LSP4	P-3	P-4

INSERT SELECTION

P

Application	Precision finishing	Finishing	Medium cutting	Medium to heavy cutting
Grade	NS9530	GT9530	T9215	T9215
Chipbreaker Shape	TF 	TSF 	TM 	TH 
Cutting conditions	B008			

M

Application	Finishing	Medium cutting	Medium to heavy cutting
Grade	T6120	T6130	T6130
Chipbreaker Shape	SF 	SM 	SH 
Cutting conditions	B010		

K

Application	Finishing	Medium cutting	Medium to heavy cutting
Grade	T515	T515	T515
Chipbreaker Shape	All-round 	All-round 	All-round 
Cutting conditions	B012		

N

Application	Finishing	Medium cutting
Grade	DX140	TH10
Chipbreaker Shape	T-DIA 	P 
Cutting conditions	B014	

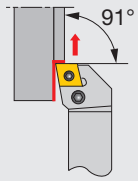
S

Application	Precision finishing	Finishing	Medium cutting
Grade	BX480	AH8005	AH8005
Chipbreaker Shape	T-CBN 	HRF 	HRM 
Cutting conditions	B016		

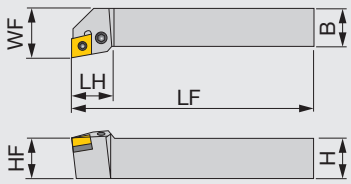
Reference pages: DSKNR/L: Inserts → B077 -, CBN → B177, PCD → B195

PCFNR/L

Lever-lock type toolholder for facing with 91° approach angle, for negative 80° rhombic inserts



Cutting edge style **F**



Right hand (R) shown.

Metric	H	B	LF	LH	HF	WF	RE**	Insert
PCFNR/L2020	20	20	125	28	20	25	0.8	CN**1204...
PCFNR/L2525	25	25	150	28	25	32	0.8	CN**1204...

**RE : Standard corner radius

SPARE PARTS

Designation	Shim	Clamping screw	Wrench	Spring pin	Lever
PCFNR/L...	LSC42 D30	LCS4	P-3	LSP4	LCL4

INSERT SELECTION

P

Application	Precision finishing	Finishing	Medium cutting	Medium to heavy cutting
Grade	NS9530	GT9530	T9215	T9215
Chipbreaker Shape	TF	TSF	TM	TH
Cutting conditions	B008			

M

Application	Finishing	Medium cutting	Medium to heavy cutting
Grade	T6120	T6130	T6130
Chipbreaker Shape	SF	SM	SH
Cutting conditions	B010		

K

Application	Finishing	Medium cutting	Medium to heavy cutting
Grade	T515	T515	T515
Chipbreaker Shape	All-round	All-round	All-round
Cutting conditions	B012		

N

Application	Precision finishing	Finishing	Medium cutting
Grade	DX120	DX140	TH10
Chipbreaker Shape	T-DIA with rake	T-DIA	P
Cutting conditions	B014		

S

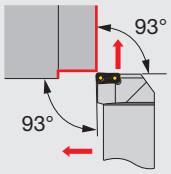
Application	Precision finishing	Finishing	Medium cutting
Grade	BX470	AH8005	AH8005
Chipbreaker Shape	T-CBN	HRF	HRM
Cutting conditions	B016		

H

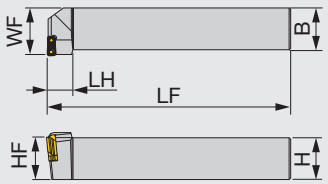
Application	Precision finishing	Finishing
Grade	BXM10	BXM20
Chipbreaker Shape	T-CBN	T-CBN
Cutting conditions	B018	

Reference pages: PCFNR/L: Inserts → B056 -, CBN → B172 -, PCD → B194 -

Screw-on toolholder for roughing with 93° approach angle, for negative tangential inserts



Cutting edge style **F**



Right hand (R) shown.

Inch	H	B	LF	LH	HF	WF	Insert
TLFNR/L16-16	1.000	1.000	6.000	0.780	1.000	1.000	LNMX1606**L/R...
TLFNR/L20-16	1.250	1.300	6.000	0.780	1.250	1.000	LNMX1606**L/R...

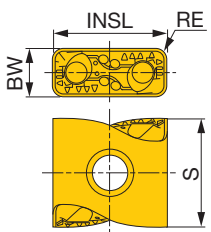
Use right-hand toolholders (R) with left-hand inserts (L); and left-hand toolholders (L) with right-hand inserts (R).

SPARE PARTS

Designation	Clamping screw	Shim	Spring pin	Wrench
TLFNR16-16	CSTB-4L115-S	TSL16L	PSP-16	KEYV-T15
TLFNL16-16	CSTB-4L115-S	TSL16R	PSP-16	KEYV-T15
TLFNR20-16	CSTB-4L115-S	TSL16L	PSP-16	KEYV-T15
TLFNL20-16	CSTB-4L115-S	TSL16R	PSP-16	KEYV-T15

INSERT

LNMX16



P	Steel	★	★	★		
M	Stainless			☆		
K	Cast iron	☆	☆	☆		
N	Non-ferrous					
S	Superalloys					
H	Hard materials					

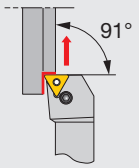
★ : First choice
☆ : Second choice

Designation	HAND	RE (in)	Coated T9115	Coated T9125	Coated AH725	BW (in)	INSL (in)	S (in)
LNMX160608R-TDR	R	0.031	●	●		0.252	0.638	0.532
LNMX160608L-TDR	L	0.031	●	●		0.252	0.638	0.532
LNMX160612R-TDR	R	0.047	●	●		0.252	0.638	0.532
LNMX160612L-TDR	L	0.047	●	●		0.252	0.638	0.532
LNMX160616R-TDR	R	0.063	●	●		0.252	0.638	0.532
LNMX160616L-TDR	L	0.063	●	●		0.252	0.638	0.532
LNMX160608R-MDR	R	0.031	●	●	●	0.252	0.638	0.532
LNMX160608L-MDR	L	0.031	●	●	●	0.252	0.638	0.532
LNMX160612R-MDR	R	0.047	●	●	●	0.252	0.638	0.532
LNMX160612L-MDR	L	0.047	●	●	●	0.252	0.638	0.532
LNMX160608R-TWR	R	0.031	●	●		0.252	0.638	0.532
LNMX160608L-TWR	L	0.031	●	●		0.252	0.638	0.532
LNMX160612R-TWR	R	0.047	●	●		0.252	0.638	0.532
LNMX160612L-TWR	L	0.047	●	●		0.252	0.638	0.532

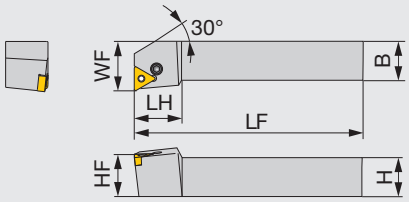
● : Line up

Reference pages: TLFNR/L: Standard cutting conditions → C144

Lever-lock toolholder with 91° approach angle, for negative triangular inserts



Cutting edge style **F**



Right hand (R) shown.

Metric	H	B	LF	LH	HF	WF	RE**	Insert	Torque
PTFNR/L2020K1104	20	20	125	16	20	25	0.8	TN**1104...	2
PTFNR/L2525M1104	25	25	150	22	25	32	0.8	TN**1104...	2

Torque: Recommended clamping torque: N·m
**RE : Standard corner radius

SPARE PARTS

Designation	Clamping screw	Wrench	Lever
PTFNR/L**1104	LCS23A	P-2.5	LCL23

INSERT SELECTION

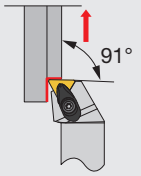
P	Application	Finishing	Medium cutting
	Grade	T9215	T9215
	Chipbreaker Shape	TSF	TM
	Cutting conditions	B008	

M	Application	Finishing	Medium cutting
	Grade	T6120	T6130
	Chipbreaker Shape	SS	SM
	Cutting conditions	B010	

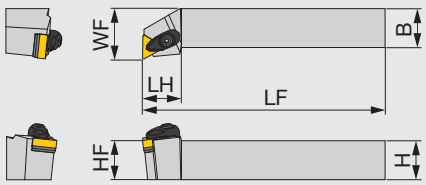
Reference pages: PTFNR/L-Eco: Inserts → B086 -

ATFNR/L

Double-clamp toolholder for facing with 91° approach angle, for negative 60° triangular inserts



Cutting edge style **F**



Right hand (R) shown.

Inch	H	B	LF	LH	HF	WF	RE**	Insert	Torque
ATFNR/L123-A	0.750	0.750	4.500	1.000	0.750	1.000	0.032	TN**33...	2.2
ATFNR/L163-A	1.000	1.000	6.000	1.000	1.000	1.250	0.032	TN**33...	2.2

Metric	H	B	LF	LH	HF	WF	RE**	Insert	Torque*
ATFNR/L2020K16-A	20	20	125	25	20	25	0.8	TN**1604...	3
ATFNR/L2525M16-A	25	25	150	25	25	32	0.8	TN**1604...	3
ATFNR/L2525M22-A	25	25	150	29	25	32	0.8	TN**2204...	3

Torque: Recommended clamping torque: lbs·ft (*N·m)
**RE : Standard corner radius

SPARE PARTS

Designation	Clamp	Clamp screw	Spring	Spring pin	Shim	Shim screw	Wrench
ATFNR/L**3-A, 16-A	ACP3S	ACS-5W	BP-7	SP-2.5	AST322	CSTB-3.5	T-15F
ATFNR/L**22-A	ACP4S	ACS-5W	BP-7	SP-2.5	AST422	CSTB-3.5	T-15F

INSERT SELECTION

P

Application	Precision finishing	Finishing	Medium cutting	Medium to heavy cutting
Grade	NS9530	GT9530	T9215	T9215
Chipbreaker Shape	TF	TSF	TM	TH
Cutting conditions	B008			

M

Application	Finishing	Medium cutting
Grade	T6120	T6130
Chipbreaker Shape	SF	SM
Cutting conditions	B010	

K

Application	Finishing	Medium cutting	Medium to heavy cutting
Grade	T515	T515	T515
Chipbreaker Shape	All-round	All-round	All-round
Cutting conditions	B012		

N

Application	Precision finishing	Finishing	Medium cutting
Grade	DX120	DX140	TH10
Chipbreaker Shape	T-DIA with rake	T-DIA	P
Cutting conditions	B014		

S

Application	Precision finishing	Finishing	Medium cutting
Grade	BX470	AH8005	AH8005
Chipbreaker Shape	T-CBN	HRF	HRM
Cutting conditions	B016		

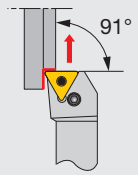
H

Application	Precision finishing	Finishing
Grade	BXM10	BXM20
Chipbreaker Shape	T-CBN	T-CBN
Cutting conditions	B018	

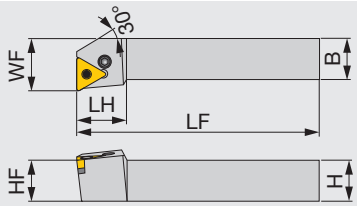
Reference pages: ATFNR/L: Inserts → B086 -, CBN → B178 -, PCD → B194 -

PTFNR/L

Lever-lock toolholder with 91° approach angle, for negative 60° triangular inserts



Cutting edge style **F**



Right hand (R) shown.

Metric	H	B	LF	LH	HF	WF	RE**	Insert
PTFNR/L1616	16	16	100	22	16	20	0.8	TN**1604...
PTFNR/L2020	20	20	125	22	20	25	0.8	TN**1604...
PTFNR/L2525M3	25	25	150	22	25	32	0.8	TN**1604...
PTFNR/L2525M4	25	25	150	28	25	32	0.8	TN**2204...
PTFNR/L3225P4	32	25	170	28	32	32	0.8	TN**2204...

**RE : Standard corner radius

SPARE PARTS

Designation	Shim	Clamping screw	Wrench	Spring pin	Lever
PTFNR/L1616, 2020	LST317	LCS3	P-2.5	LSP3	LCL3
PTFNR/L2525M3	LST317	LCS3	P-2.5	LSP3	LCL3
PTFNR/L**25*4	LST42	LCS4	P-3	LSP4	LCL4

INSERT SELECTION

P

Application	Precision finishing	Finishing	Medium cutting	Medium to heavy cutting
Grade	NS9530	GT9530	T9215	T9215
Chipbreaker Shape	TF	TSF	TM	TH
Cutting conditions	B008			

M

Application	Finishing	Medium cutting
Grade	T6120	T6130
Chipbreaker Shape	SF	SM
Cutting conditions	B010	

K

Application	Finishing	Medium cutting	Medium to heavy cutting
Grade	T515	T515	T515
Chipbreaker Shape	All-round	All-round	All-round
Cutting conditions	B012		

N

Application	Precision finishing	Finishing	Medium cutting
Grade	DX120	DX140	TH10
Chipbreaker Shape	T-DIA with rake	T-DIA	P
Cutting conditions	B014		

S

Application	Precision finishing	Finishing	Medium cutting
Grade	BX470	AH8005	AH8005
Chipbreaker Shape	T-CBN	HRF	HRM
Cutting conditions	B016		

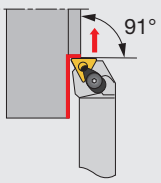
H

Application	Precision finishing	Finishing
Grade	BXM10	BXM20
Chipbreaker Shape	T-CBN	T-CBN
Cutting conditions	B018	

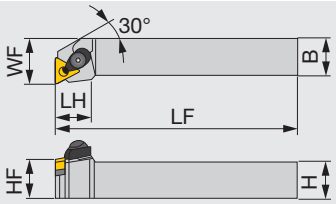
Reference pages: PTFNR/L: Inserts → B086 -, CBN → B178 -, PCD → B194 -

DTFNR/L

"One-Double" toolholder with 91° approach angle, for negative 60° triangular inserts



Cutting edge style **F**



Right hand (R) shown.

Metric	H	B	LF	LH	HF	WF	RE**	Insert
DTFNR/L2020K16	20	20	125	23	20	25	0.8	TN**1604...
DTFNR/L2525M16	25	25	150	23	25	32	0.8	TN**1604...
DTFNR/L2525M22	25	25	150	31	25	32	0.8	TN**2204...

Except for 57-type chipbreaker inserts
**RE : Standard corner radius

SPARE PARTS

Designation	Clamp	Lever	Piston	Clamp screw	Shim	Spring	Spring pin	Wrench 1	Wrench 2
DTFNR/L**16	DCPM-33	LCL33	DPIS33	DLCS33	LST317	BP-9	LSP3	P-2.5	P-3
DTFNR/L**22	DCPM-43	DLCL43	DPIS43	DLCS43	LST42	BP-10	LSP4	P-3	P-4

INSERT SELECTION

P

Application	Precision finishing	Finishing	Medium cutting	Medium to heavy cutting
Grade	NS9530	GT9530	T9215	T9215
Chipbreaker Shape	TF	TSF	TM	TH
Cutting conditions	B008			

M

Application	Finishing	Medium cutting
Grade	T6120	T6130
Chipbreaker Shape	SF	SM
Cutting conditions	B010	

K

Application	Finishing	Medium cutting	Medium to heavy cutting
Grade	T515	T515	T515
Chipbreaker Shape	All-round	All-round	All-round
Cutting conditions	B012		

N

Application	Precision finishing	Finishing	Medium cutting
Grade	DX120	DX140	TH10
Chipbreaker Shape	T-DIA with rake	T-DIA	P
Cutting conditions	B014		

S

Application	Precision finishing	Finishing	Medium cutting
Grade	BX470	AH8005	AH8005
Chipbreaker Shape	T-CBN	HRF	HRM
Cutting conditions	B016		

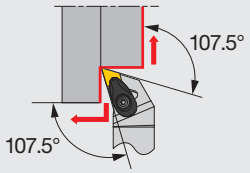
H

Application	Precision finishing	Finishing
Grade	BXM10	BXM20
Chipbreaker Shape	T-CBN	T-CBN
Cutting conditions	B018	

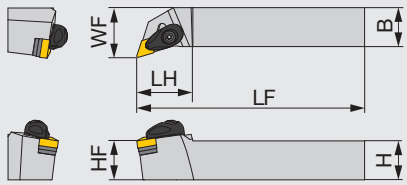
Reference pages: DTFNR/L: Inserts → B086 -, CBN → B178 -, PCD → B194 -

ADQNR/L-Eco

Double-clamp toolholder with 107.5° approach angle, for negative 55° rhombic inserts



Cutting edge style **Q**



Right hand (R) shown.

Inch	H	B	LF	LH	HF	WF	RE**	Insert	Torque
ADQNR/L1233-A	0.750	0.750	4.500	1.150	0.750	1.000	0.031	DN**33...	2.2
ADQNR/L1633-A	1.000	1.000	6.000	1.150	1.000	1.250	0.031	DN**33...	2.2

Metric	H	B	LF	LH	HF	WF	RE**	Insert	Torque*
ADQNR/L2020K1104-A	20	20	125	30	20	25	0.8	DN**1104...	3
ADQNR/L2525M1104-A	25	25	150	30	25	32	0.8	DN**1104...	3

Torque: Recommended clamping torque: lbs·ft (*N·m)
**RE : Standard corner radius

SPARE PARTS

Designation	Clamp	Clamp screw	Spring	Spring pin	Shim	Shim screw	Wrench
ADQNR/L**-A	ACP3S-E	ACS-5W	BP-7	SP-2.5	ASD322	CSTB-3.5	T-15F

INSERT SELECTION

P

Application	Finishing	Medium cutting
Grade	T9215	T9215
Chipbreaker Shape	TSF	TM
Cutting conditions	B008	

M

Application	Finishing	Medium cutting
Grade	T6120	T6130
Chipbreaker Shape	SS	SM
Cutting conditions	B010	

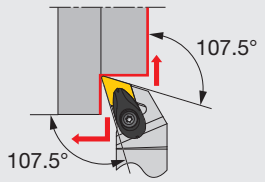
K

Application	Medium cutting
Grade	T515
Chipbreaker Shape	TM
Cutting conditions	B012

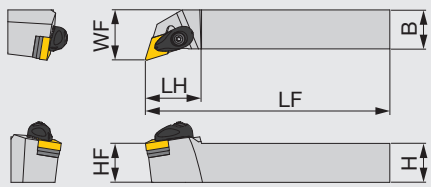
Reference pages: ADQNR/L-Eco: Inserts → B067 -

ADQNR/L

Double-clamp toolholder with 107.5° approach angle, for negative 55° rhombic inserts



Cutting edge style **Q**



Right hand (R) shown.

Inch	H	B	LF	LH	HF	WF	RE**	Insert	Torque
ADQNR/L124-A	0.750	0.750	4.500	1.250	0.750	1.000	0.031	DN**43...	2.2
ADQNR/L164-A	1.000	1.000	6.000	1.500	1.000	1.250	0.031	DN**43...	2.2

Metric	H	B	LF	LH	HF	WF	RE**	Insert	Torque*
ADQNR/L2020K15-A	20	20	125	32	20	25	0.8	DN**1504...	3
ADQNR/L2020K1506-A	20	20	125	32	20	25	0.8	DN**1506...	3
ADQNR/L2525M15-A	25	25	150	36	25	32	0.8	DN**1504...	3
ADQNR/L2525M1506-A	25	25	150	36	25	32	0.8	DN**1506...	3

Torque: Recommended clamping torque: lbs·ft (*N·m)
**RE : Standard corner radius

SPARE PARTS

Designation	Clamp	Clamp screw	Spring	Spring pin	Shim	Shim screw	Wrench
ADQNR/L**4-A, 15-A	ACP4S	ACS-5W	BP-7	SP-2.5	ASD432	CSTB-3.5	T-15F
ADQNR/L**1506-A	ACP4S	ACS-5W	BP-7	SP-2.5	ASD423	CSTB-3.5	T-15F

INSERT SELECTION

P

Application	Precision finishing	Finishing	Medium cutting	Medium to heavy cutting
Grade	NS9530	GT9530	T9215	T9215
Chipbreaker Shape	TF	TSF	TM	TH
Cutting conditions	B008			

M

Application	Finishing	Medium cutting	Medium to heavy cutting
Grade	T6120	T6130	T6130
Chipbreaker Shape	SF	SM	SH
Cutting conditions	B010		

K

Application	Finishing	Medium cutting	Medium to heavy cutting
Grade	T515	T515	T515
Chipbreaker Shape	All-round	All-round	All-round
Cutting conditions	B012		

N

Application	Precision finishing	Finishing	Medium cutting
Grade	DX120	DX140	TH10
Chipbreaker Shape	T-DIA with rake	T-DIA	P
Cutting conditions	B014		

S

Application	Precision finishing	Finishing	Medium cutting
Grade	BX470	AH8005	AH8005
Chipbreaker Shape	T-CBN	HRF	HRM
Cutting conditions	B016		

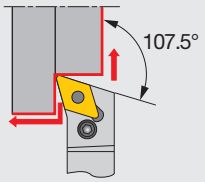
H

Application	Precision finishing	Finishing
Grade	BXM10	BXM20
Chipbreaker Shape	T-CBN	T-CBN
Cutting conditions	B018	

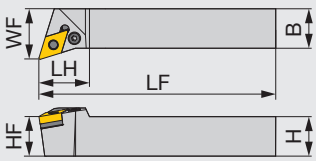
Reference pages: ADQNR/L: Inserts → B067 -, CBN → B174 -, PCD → B194 -

PDQNR/L

Lever-lock toolholder with 107.5° approach angle, for negative 55° rhombic inserts



Cutting edge style **Q**



Right hand (R) shown.

Metric	H	B	LF	LH	HF	WF	RE**	Insert
PDQNR/L2525	25	25	150	32	25	32	0.8	DN**1504...

**RE : Standard corner radius

SPARE PARTS

Designation	Shim	Clamping screw	Wrench	Spring pin	Lever
PDQNR/L...	LSD42 D30	LCS4	P-3	LSP4	LCL4

INSERT SELECTION

P

Application	Precision finishing	Finishing	Medium cutting	Medium to heavy cutting
Grade	NS9530	GT9530	T9215	T9215
Chipbreaker Shape	TF	TSF	TM	TH
Cutting conditions	B008			

M

Application	Finishing	Medium cutting	Medium to heavy cutting
Grade	T6120	T6130	T6130
Chipbreaker Shape	SF	SM	SH
Cutting conditions	B010		

K

Application	Finishing	Medium cutting	Medium to heavy cutting
Grade	T515	T515	T515
Chipbreaker Shape	All-round	All-round	All-round
Cutting conditions	B012		

N

Application	Precision finishing	Finishing	Medium cutting
Grade	DX120	DX140	TH10
Chipbreaker Shape	T-DIA	with rake T-DIA	P
Cutting conditions	B014		

S

Application	Precision finishing	Finishing	Medium cutting
Grade	BX470	AH8005	AH8005
Chipbreaker Shape	T-CBN	HRF	HRM
Cutting conditions	B016		

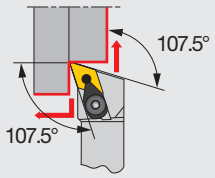
H

Application	Precision finishing	Finishing
Grade	BXM10	BXM20
Chipbreaker Shape	T-CBN	T-CBN
Cutting conditions	B018	

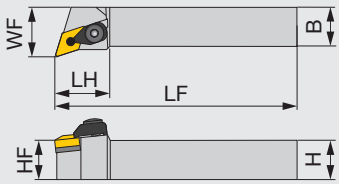
Reference pages: PDQNR/L: Inserts → B067 -, CBN → B174 -, PCD → B194 -

DDQNR/L

"One-Double" toolholder with 107.5° approach angle, for negative 55° rhombic inserts



Cutting edge style **Q**



Metric	H	B	LF	LH	HF	WF	RE**	Insert
DDQNR/L2020K15	20	20	125	35	20	25	0.8	DN**1504...
DDQNR/L2020K1506	20	20	125	35	20	25	0.8	DN**1506...
DDQNR/L2525M15	25	25	150	35	25	32	0.8	DN**1504...
DDQNR/L2525M1506	25	25	150	35	25	32	0.8	DN**1506...
DDQNR/L3225P15	32	25	170	35	32	32	0.8	DN**1504...
DDQNR/L3225P1506	32	25	170	35	32	32	0.8	DN**1506...

Except for 57-type chipbreaker inserts
**RE : Standard corner radius

SPARE PARTS

Designation	Clamp	Lever	Piston	Clamp screw	Shim	Spring	Spring pin	Wrench 1	Wrench 2
DDQNR/L**15	DCPM-43	DLCL43	DPIS43	DLCS43	LSD42	BP-10	LSP4	P-3	P-4
DDQNR/L**1506	DCPM-43	DLCL43	DPIS44	DLCS43	LSD42	BP-10	LSP4	P-3	P-4

INSERT SELECTION

P

Application	Precision finishing	Finishing	Medium cutting	Medium to heavy cutting
Grade	NS9530	GT9530	T9215	T9215
Chipbreaker Shape	TF	TSF	TM	TH
Cutting conditions	B008			

M

Application	Finishing	Medium cutting	Medium to heavy cutting
Grade	T6120	T6130	T6130
Chipbreaker Shape	SF	SM	SH
Cutting conditions	B010		

K

Application	Finishing	Medium cutting	Medium to heavy cutting
Grade	T515	T515	T515
Chipbreaker Shape	All-round	All-round	All-round
Cutting conditions	B012		

N

Application	Precision finishing	Finishing	Medium cutting
Grade	DX120	DX140	TH10
Chipbreaker Shape	T-DIA with rake	T-DIA	P
Cutting conditions	B014		

S

Application	Precision finishing	Finishing	Medium cutting
Grade	BX470	AH8005	AH8005
Chipbreaker Shape	T-CBN	HRF	HRM
Cutting conditions	B016		

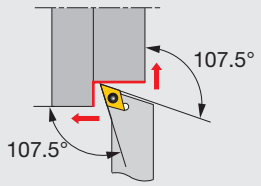
H

Application	Precision finishing	Finishing
Grade	BXM10	BXM20
Chipbreaker Shape	T-CBN	T-CBN
Cutting conditions	B018	

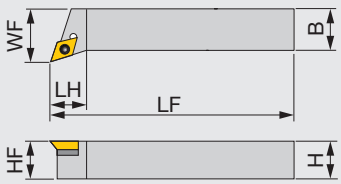
Reference pages: DDQNR/L: Inserts → B067 -, CBN → B174 -, PCD → B194 -

SDQCR/L

Screw-on toolholder with 107.5° approach angle, for positive 55° rhombic inserts



Cutting edge style **Q**



Right hand (R) shown.

Metric	H	B	LF	LH	HF	WF	RE**	Insert
SDQCR/L2020K11	20	20	125	20.5	20	25	0.8	DC**11T3...
SDQCR2525M11	25	25	150	21.5	25	32	0.8	DC**11T3...

**RE : Standard corner radius

SPARE PARTS

Designation	Clamping screw	Shim screw	Shim	Wrench 1	Wrench 2
SDQCR/L...	CSTB-3.5L	DTS5-3.5	SSD32	P-3.5	T-15F

INSERT SELECTION

P

Application	Finishing	Finishing to medium cutting	Medium cutting
Grade	NS9530	T9215	T9215
Chipbreaker Shape	PSS	PS	PM
Cutting conditions	B020		

M

Application	Precision finishing	Finishing	Finishing to medium cutting	Medium cutting
Grade	GH330	AH725	AH630	T6130
Chipbreaker Shape	W**	PSF	PSS	PM
Cutting conditions	B022			

K

Application	Finishing to medium cutting
Grade	T515
Chipbreaker Shape	CM
Cutting conditions	B024

N

Application	Precision finishing	Finishing	Medium cutting
Grade	DX120	DX140	KS05F
Chipbreaker Shape	T-DIA (with rake)	T-DIA	AL
Cutting conditions	B026		

S

Application	Finishing	Finishing to medium cutting
Grade	AH8015	AH8015
Chipbreaker Shape	PSS	PS
Cutting conditions	B028	

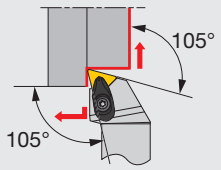
H

Application	Precision finishing	Finishing
Grade	BXM10	BXM20
Chipbreaker Shape	T-CBN	T-CBN
Cutting conditions	B030	

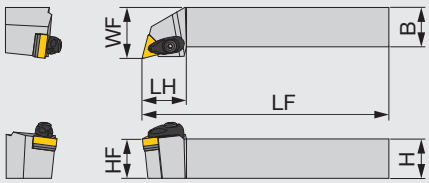
Reference pages: SDQCR/L: Inserts → B121 -, CBN → B184 -, PCD → B196 -

ATQNR/L

Double-clamp toolholder with 105° approach angle, for negative 60° triangular inserts



Cutting edge style **Q**



Right hand (R) shown.

Inch	H	B	LF	LH	HF	WF	RE**	Insert	Torque
ATQNR/L123-A	0.750	0.750	4.500	1.125	0.750	1.000	0.031	TN**33...	2.2
ATQNR/L163-A	1.000	1.000	6.000	1.125	1.000	1.250	0.031	TN**33...	2.2

Metric	H	B	LF	LH	HF	WF	RE**	Insert	Torque*
ATQNR/L2020K16-A	20	20	125	28	20	25	0.8	TN**1604...	3
ATQNR/L2525M16-A	25	25	150	28	25	32	0.8	TN**1604...	3

Torque: Recommended clamping torque: lbs·ft (*N·m)
**RE : Standard corner radius

SPARE PARTS

Designation	Clamp	Clamp screw	Spring	Spring pin	Shim	Shim screw	Wrench
ATQNR/L**3-A, 16-A	ACP3S	ACS-5W	BP-7	SP-2.5	AST322	CSTB-3.5	T-15F

INSERT SELECTION

P

Application	Precision finishing	Finishing	Medium cutting	Medium to heavy cutting
Grade	NS9530	GT9530	T9215	T9215
Chipbreaker Shape	TF	TSF	TM	TH
Cutting conditions	B008			

M

Application	Finishing	Medium cutting
Grade	T6120	T6130
Chipbreaker Shape	SF	SM
Cutting conditions	B010	

K

Grade Application	Finishing	Medium cutting	Medium to heavy cutting
Chipbreaker	T515	T515	T515
Shape	All-round	All-round	All-round
Cutting conditions	B012		

N

Application	Precision finishing	Finishing	Medium cutting
Grade	DX120	DX140	TH10
Chipbreaker Shape	T-DIA with rake	T-DIA	P
Cutting conditions	B014		

S

Application	Precision finishing	Finishing	Medium cutting
Grade	BX470	AH8005	AH8005
Chipbreaker Shape	T-CBN	HRF	HRM
Cutting conditions	B016		

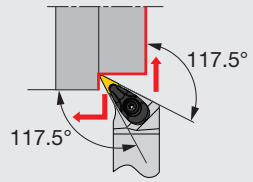
H

Application	Precision finishing	Finishing
Grade	BXM10	BXM20
Chipbreaker Shape	T-CBN	T-CBN
Cutting conditions	B018	

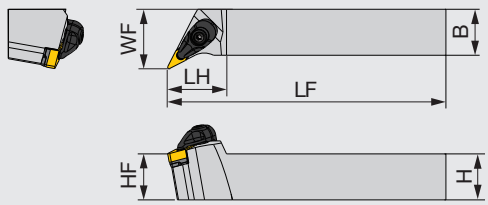
Reference pages: ATQNR/L: Inserts → B086 -, CBN → B178 -, PCD → B194 -

AVQNR/L-Eco

Double-clamp toolholder with 117.5° approach angle, for negative 35° rhombic inserts



Cutting edge style **Q**



Right hand (R) shown.

Inch	H	B	LF	LH	HF	WF	RE**	Insert	Torque
AVQNR/L122.33-A	0.750	0.750	4.500	1.250	0.750	1.000	0.031	VN**2.33...	2.21
AVQNR/L162.33-A	1.000	1.000	6.000	1.250	1.000	1.250	0.031	VN**2.33...	2.21

Metric	H	B	LF	LH	HF	WF	RE**	Insert	Torque*
AVQNR/L2020K1204-A	20	20	125	32	20	25	0.8	VN**1204...	3
AVQNR/L2525M1204-A	25	25	150	32	25	32	0.8	VN**1204...	3

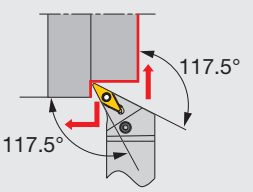
Torque: Recommended clamping torque: lbs·ft (*N·m) **RE: Standard corner radius

SPARE PARTS

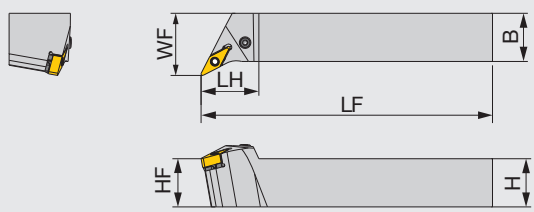
Designation	Clamp	Clamp screw	Spring	Spring pin	Shim	Shim screw	Wrench
AVQNR/L**-A	ACP3L-E	ACS-5W	BP-7	SP-2.5	ASV222	CSTB-3.0	T-15F

PVQNR/L-Eco

Lever-lock toolholder with 117.5° approach angle, for negative 35° rhombic inserts



Cutting edge style **Q**



Right hand (R) shown.

Metric	H	B	LF	LH	HF	WF	RE**	Insert	Torque
PVQNR/L2020K1204	20	20	125	30	20	25	0.8	VN**1204...	2
PVQNR/L2525M1204	25	25	150	30	25	32	0.8	VN**1204...	2

Torque: Recommended clamping torque: N·m **RE: Standard corner radius

SPARE PARTS

Designation	Shim	Clamping screw	Wrench	Spring pin	Lever
PVQNR/L**1204	LSV212	LCS3V	P-2.5	LSP3	LCL3V

INSERT SELECTION

P

Application	Finishing	Medium cutting
Grade	T9215	T9215
Chipbreaker Shape	TSF	TM
Cutting conditions	B008	

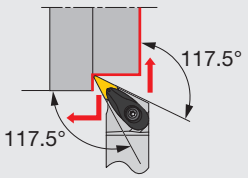
M

Application	Finishing	Medium cutting
Grade	T6120	T6130
Chipbreaker Shape	SS	SM
Cutting conditions	B010	

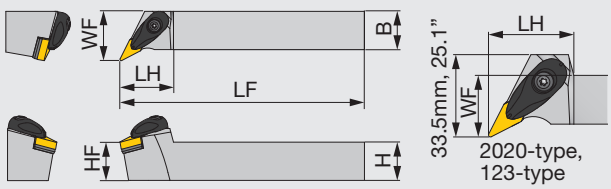
Reference pages: AVQNR/L-Eco, PVQNR/L-Eco: Insert → B097 -

AVQNR/L

Double-clamp toolholder with 117.5° approach angle, for negative 35° and 25° rhombic inserts



Cutting edge style **Q**



Right hand (R) shown.

Inch	H	B	LF	LH	HF	WF	RE**	Insert	Torque
AVQNR/L123-A	0.750	0.750	4.500	1.380	0.750	1.000	0.031	V/YN**33...	2.2
AVQNR/L163-A	1.000	1.000	6.000	1.380	1.000	1.250	0.031	V/YN**33...	2.2

Metric	H	B	LF	LH	HF	WF	RE**	Insert	Torque*
AVQNR/L2020K16-A	20	20	125	35	20	25	0.8	V/YN**1604...	3
AVQNR/L2525M16-A	25	25	150	35	25	32	0.8	V/YN**1604...	3

Torque: Recommended clamping torque: lbs·ft (*N·m)
**RE : Standard corner radius

SPARE PARTS

Designation	Clamp	Clamp screw	Spring	Spring pin	Shim	Shim screw	Wrench
AVQNR/L...	ACP3L	ACS-5W	BP-7	SP-2.5	ASV322	CSTB-3.5	T-15F

INSERT SELECTION

P

Application	Precision finishing	Finishing	Medium cutting
Grade	NS9530	GT9530	T9215
Chipbreaker Shape	TF	TSF	TM
Cutting conditions	B008		

M

Application	Finishing	Medium cutting
Grade	T6120	T6130
Chipbreaker Shape	SF	SM
Cutting conditions	B010	

K

Application	Finishing	Medium cutting	Medium to heavy cutting
Grade	T515	T515	T515
Chipbreaker Shape	All-round	All-round	All-round
Cutting conditions	B012		

N

Application	Precision finishing
Grade	DX120
Chipbreaker Shape	T-DIA with rake
Cutting conditions	B014

S

Application	Precision finishing	Finishing	Medium cutting
Grade	BX480	AH8005	AH8005
Chipbreaker Shape	T-CBN	HRF	HRM
Cutting conditions	B016		

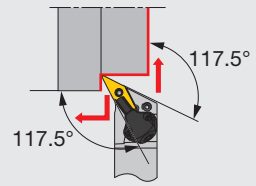
H

Application	Precision finishing	Finishing
Grade	BXM10	BXM20
Chipbreaker Shape	T-CBN	T-CBN
Cutting conditions	B018	

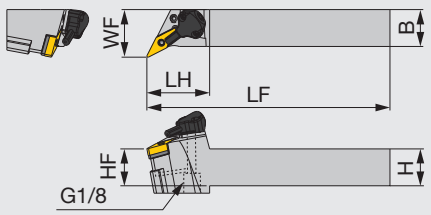
Reference pages: AVQNR/L: Inserts → B096 -, B109, CBN → B180, PCD → B194

PVQNR/L-CHP

Lever-lock toolholders with 117.5° approach angle, for negative 35° and 25° rhombic inserts, with high pressure coolant capability



Cutting edge style **Q**



Right hand (R) shown.

Inch	H	B	LF	LH	HF	WF	RE**	Insert	Torque
PVQNR/L123-CHP	0.750	0.750	4.500	1.688	0.750	1.250	0.031	V/YN**33...	1.48
PVQNR/L163-CHP	1.000	1.000	6.000	1.688	1.000	1.250	0.031	V/YN**33...	1.48

Metric	H	B	LF	LH	HF	WF	RE**	Insert	Torque*
PVQNR/L2020K16-CHP	20	20	125	42.5	20	32	0.8	V/YN**1604...	2
PVQNR/L2525M16-CHP	25	25	150	42.5	25	32	0.8	V/YN**1604...	2

Torque: Recommended clamping torque: lbs·ft (*N·m)
**RE : Standard corner radius

SPARE PARTS

Designation	Shim	Clamping screw	Wrench 1	Spring pin	Lever
PVQNR/L**-CHP	LSV317	LCS3V	P-2.5	LSP3	LCL3V

SPARE PARTS

Designation	Coolant unit	Mounting screw	Wrench 2	O-ring	Coolant screw	Wrench 3
PVQNR/L**-CHP	CU-V-CHP	SRM3	T-8F	OR6.4X0.9N	SRM4X4TL360	P-2

INSERT SELECTION

P

Application	Precision finishing	Finishing	Medium cutting
Grade	NS9530	GT9530	T9215
Chipbreaker Shape	TF	TSF	TM
Cutting conditions	B008		

M

Application	Finishing	Medium cutting
Grade	T6120	T6130
Chipbreaker Shape	SF	SM
Cutting conditions	B010	

K

Application	Finishing	Medium cutting	Medium to heavy cutting
Grade	T515	T515	T515
Chipbreaker Shape	All-round	All-round	All-round
Cutting conditions	B012		

N

Application	Precision finishing
Grade	DX120
Chipbreaker Shape	T-DIA with rake
Cutting conditions	B014

S

Application	Precision finishing	Finishing	Medium cutting
Grade	BX480	AH8005	AH8005
Chipbreaker Shape	T-CBN	HRF	HRM
Cutting conditions	B016		

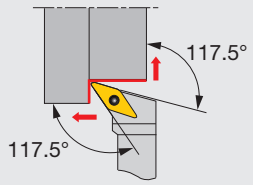
H

Application	Precision finishing	Finishing
Grade	BXM10	BXM20
Chipbreaker Shape	T-CBN	T-CBN
Cutting conditions	B018	

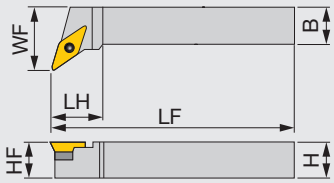
Reference pages: PVQNR/L-CHP: Inserts → B096 -, B109, CBN → B180, PCD → B194
Parts for coolant hose → C142

SVQCR/L

Screw-on toolholder with 117.5° approach angle, for positive 35° rhombic inserts



Cutting edge style **Q**



Right hand (R) shown.

Inch	H	B	LF	LH	HF	WF	RE**	Insert
SVQCR/L163	1.00	1.00	6.00	1.50	1.00	1.25	0.031	VC**33...

Metric	H	B	LF	LH	HF	WF	RE**	Insert
SVQCR/L2020K16	20	20	125	35	20	27	0.8	VC**1604...
SVQCR/L2525M16	25	25	150	35	25	32	0.8	VC**1604...

**RE : Standard corner radius

SPARE PARTS

Designation	Clamping screw	Shim screw	Shim	Wrench 1	Wrench 2
SVQCR/L...	CSTB-3.5L	DTS5-3.5	SSV32	P-3.5	T-15F

INSERT SELECTION

P

Application	Finishing	Finishing to medium cutting
Grade	NS9530	T9215
Chipbreaker Shape	PSS	PS
Cutting conditions	B020	

M

Application	Finishing	Finishing to medium cutting	Medium cutting
Grade	AH725	AH630	T6130
Chipbreaker Shape	PSF	PSS	PM
Cutting conditions	B022		

K

Application	Finishing to medium cutting
Grade	T515
Chipbreaker Shape	CM
Cutting conditions	B024

N

Application	Precision finishing	Finishing	Medium cutting
Grade	DX120	DX140	KS05F
Chipbreaker Shape	T-DIA	T-DIA (with rake)	AL
Cutting conditions	B026		

S

Application	Finishing	Finishing to medium cutting
Grade	AH8015	AH8015
Chipbreaker Shape	PSS	PS
Cutting conditions	B028	

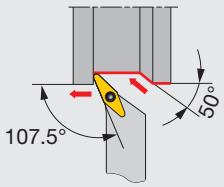
H

Application	Precision finishing	Finishing
Grade	BXM10	BXM20
Chipbreaker Shape	T-CBN	T-CBN
Cutting conditions	B030	

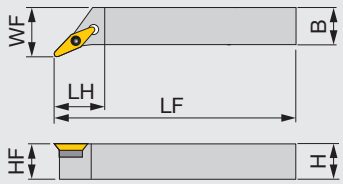
Reference pages: SVQCR/L: Inserts → B155 -, CBN → B192, PCD → B196

SVHCR/L

Screw-on toolholder with 107.5° approach angle, for positive 35° rhombic inserts



Cutting edge style **H**



Right hand (R) shown.

Metric	H	B	LF	LH	HF	WF	RE**	Insert
SVHCR/L2525M22	25	25	150	33.8	25	32	0.8	VCG*2205...

**RE : Standard corner radius

SPARE PARTS

Designation	Clamping screw	Shim screw	Shim	Wrench 1	Wrench 2
SVHCR/L2525M22	CSTB-4.5L110P	DTS6-4.5	SSV42	P-4.5	T-15F

INSERT SELECTION

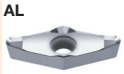
K

Application	Finishing to medium cutting
Grade	KS05F
Chipbreaker Shape	AL 
Cutting conditions	B024

N

Application	Finishing to medium cutting
Grade	KS05F
Chipbreaker Shape	AL 
Cutting conditions	B026

S

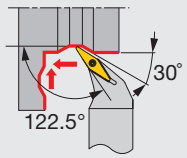
Application	Finishing to medium cutting
Grade	KS05F
Chipbreaker Shape	AL 
Cutting conditions	B028

Reference pages: SVHCR/L: Inserts → B156

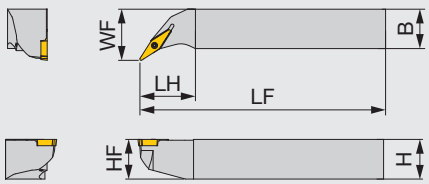
Y-PRO SERIES

SYQBR/L

Screw-on toolholder with 122.5° approach angle, for positive 25° rhombic inserts



Cutting edge style **Q**



Right hand (R) shown.

Inch	H	B	LF	LH	HF	WF	RE**	Insert
SYQBR/L123	0.750	0.750	4.500	1.350	0.750	1.000	0.031	YWMT16T3...
SYQBR/L163	1.000	1.000	6.000	1.500	1.000	1.250	0.031	YWMT16T3...

Metric	H	B	LF	LH	HF	WF	RE**	Insert
SYQBR/L2020K16	20	20	125	35	20	27	0.8	YWMT16T3...
SYQBR/L2525M16	25	25	150	35	25	32	0.8	YWMT16T3...

**RE : Standard corner radius

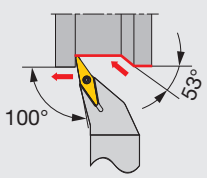
SPARE PARTS

Designation	Clamping screw	Wrench
SYQBR/L...	CSTB-2.5L080	T-8F

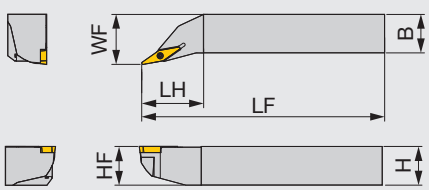
Y-PRO SERIES

SYHBR/L

Screw-on toolholder with 100° approach angle, for positive 25° rhombic inserts



Cutting edge style **H**



Right hand (R) shown.

Inch	H	B	LF	LH	HF	WF	RE**	Insert
SYHBR/L123	0.750	0.750	4.500	1.350	0.750	1.000	0.031	YWMT16T3...
SYHBR/L163	1.000	1.000	6.000	1.500	1.000	1.250	0.031	YWMT16T3...

Metric	H	B	LF	LH	HF	WF	RE**	Insert
SYHBR/L2020K16	20	20	125	35	20	27	0.8	YWMT16T3...
SYHBR/L2525M16	25	25	150	40	25	32	0.8	YWMT16T3...

**RE : Standard corner radius

SPARE PARTS

Designation	Clamping screw	Wrench
SYHBR/L...	CSTB-2.5L080	T-8F

INSERT SELECTION

P

Application	Finishing to medium cutting
Grade	T9225
Chipbreaker Shape	ZM 
Cutting conditions	B008

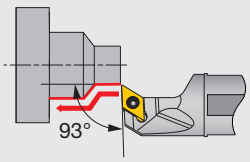
K

Application	Finishing to medium cutting
Grade	GT9530
Chipbreaker Shape	ZM 
Cutting conditions	B012

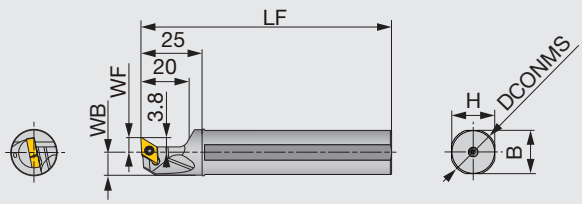
Reference pages: SYQBR/L, SYHBR/L: Inserts → **B163**

JS-SDUXL

Screw-on round-shank toolholder with 93° approach angle, for DXGU inserts



Cutting edge style **U**



Left hand (L) shown.

Inch	DCONMS	WF	LF	H	B	WB	RE**	Insert	Torque
JS159F-SDUXL07	0.625	0.236	3.346	0.591	0.591	0.303	0.008	DXGU0703**L...	0.66
JS19G-SDUXL07	0.750	0.236	3.543	0.709	0.709	0.365	0.008	DXGU0703**L...	0.66
JS19X-SDUXL07	0.750	0.236	4.724	0.709	0.709	0.365	0.008	DXGU0703**L...	0.66
JS254X-SDUXL07	1.000	0.394	4.724	0.945	0.945	0.490	0.008	DXGU0703**L...	0.66

Metric	DCONMS	WF	LF	H	B	WB	RE**	Insert	Torque*
JS14H-SDUXL07	14	6	100	13	13	6.75	0.2	DXGU0703**L...	0.9
JS159F-SDUXL07	15.875	6	85	15	15	7.687	0.2	DXGU0703**L...	0.9
JS16F-SDUXL07	16	6	85	15	15	7.75	0.2	DXGU0703**L...	0.9
JS19G-SDUXL07	19.05	6	90	18	18	9.275	0.2	DXGU0703**L...	0.9
JS19X-SDUXL07	19.05	6	120	18	18	9.275	0.2	DXGU0703**L...	0.9
JS20G-SDUXL07	20	6	90	19	19	9.75	0.2	DXGU0703**L...	0.9
JS20X-SDUXL07	20	6	120	19	19	9.75	0.2	DXGU0703**L...	0.9
JS22X-SDUXL07	22	10	120	21	21	10.75	0.2	DXGU0703**L...	0.9
JS25H-SDUXL07	25	10	100	24	24	12.25	0.2	DXGU0703**L...	0.9
JS254X-SDUXL07	25.4	10	120	24	24	12.45	0.2	DXGU0703**L...	0.9

Torque: Recommended clamping torque: lbs·ft (*N·m) **RE: Standard corner radius
Use left-hand toolholders (L) with left-hand inserts (L).

SPARE PARTS


Designation	Clamping screw	Wrench
JS**-SDUXL07	SR34-514	T-7F

INSERT SELECTION

Swiss lathes

P	Application	Finishing	Medium cutting
	Grade	SH725	AH725
	Chipbreaker Shape	JSS	JTS
	Cutting conditions	C143	

M	Application	Finishing	Medium cutting
	Grade	SH725	AH725
	Chipbreaker Shape	JSS	JTS
	Cutting conditions	C143	

Small CNC lathes

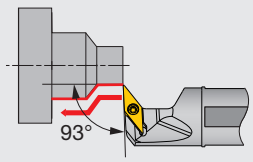
P	Application	Finishing	Medium cutting
	Grade	AH725	AH725
	Chipbreaker Shape	SS	TS
	Cutting conditions	C143	

M	Application	Finishing	Medium cutting
	Grade	AH8015	AH8015
	Chipbreaker Shape	SS	TS
	Cutting conditions	C143	

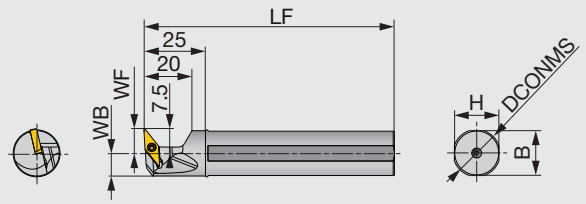
Reference pages: JS-SDUXL: Inserts → B127 -
Standard cutting conditions → C143

JS-SVUXL

Screw-on round-shank toolholder with 93° approach angle, for VXGU inserts



Cutting edge style **U**



Left hand (L) shown.

Inch	DCONMS	WF	LF	H	B	WB	RE**	Insert	Torque
JS159F-SVUXL09	0.625	0.394	3.346	0.591	0.591	0.303	0.008	VXGU09T2**L...	0.66
JS19G-SVUXL09	0.750	0.394	3.543	0.709	0.709	0.362	0.008	VXGU09T2**L...	0.66
JS19X-SVUXL09	0.750	0.394	4.724	0.709	0.709	0.362	0.008	VXGU09T2**L...	0.66
JS254X-SVUXL09	1.000	0.394	4.724	0.945	0.945	0.488	0.008	VXGU09T2**L...	0.66

Metric	DCONMS	WF	LF	H	B	WB	RE**	Insert	Torque*
JS159F-SVUXL09	15.875	10	85	15	15	7.7	0.2	VXGU09T2**L...	0.9
JS16F-SVUXL09	16	10	85	15	15	7.7	0.2	VXGU09T2**L...	0.9
JS19G-SVUXL09	19.05	10	90	18	18	9.2	0.2	VXGU09T2**L...	0.9
JS19X-SVUXL09	19.05	10	120	18	18	9.2	0.2	VXGU09T2**L...	0.9
JS20G-SVUXL09	20	10	90	19	19	9.7	0.2	VXGU09T2**L...	0.9
JS20X-SVUXL09	20	10	120	19	19	9.7	0.2	VXGU09T2**L...	0.9
JS22X-SVUXL09	22	10	120	21	21	10.7	0.2	VXGU09T2**L...	0.9
JS25H-SVUXL09	25	10	100	24	24	12.2	0.2	VXGU09T2**L...	0.9
JS254X-SVUXL09	25.4	10	120	24	24	12.4	0.2	VXGU09T2**L...	0.9

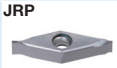
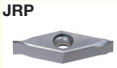
Torque: Recommended clamping torque: lbs·ft (*N·m) **RE: Standard corner radius
Use left-hand toolholders (L) with left-hand inserts (L).

SPARE PARTS

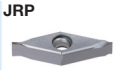
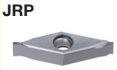

Designation	Clamping screw	Wrench
JS**-SVUXL09	SR34-508	T-7F

INSERT SELECTION

Swiss lathes

P		M	
Application	Finishing	Application	Finishing
Grade	SH725	Grade	SH725
Chipbreaker Shape	JRP 	Chipbreaker Shape	JRP 
Cutting conditions	C143	Cutting conditions	C143

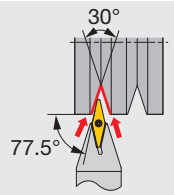
Small CNC lathes

P		M	
Application	Finishing	Application	Finishing
Grade	SH725	Grade	SH725
Chipbreaker Shape	JRP 	Chipbreaker Shape	JRP 
Cutting conditions	C143	Cutting conditions	C143

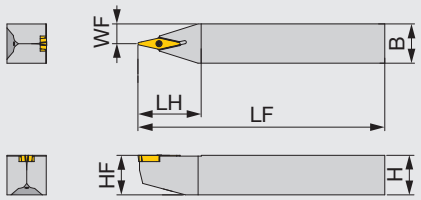
Reference pages: JS-SVUXL: Inserts → B158
Standard cutting conditions → C143

SYIBN

Screw-on toolholder with 77.5° approach angle, for positive 25° rhombic inserts



Cutting edge style **I**



Inch	H	B	LF	LH	HF	WF	RE**	Insert
SYIBN123	0.750	0.750	4.500	1.250	0.750	0.375	0.031	YWMT16T3...
SYIBN163	1.000	1.000	6.000	1.500	1.000	0.500	0.031	YWMT16T3...

Metric	H	B	LF	LH	HF	WF	RE**	Insert
SYIBN2020K16	20	20	125	32	20	10	0.8	YWMT16T3...
SYIBN2525M16	25	25	150	40	25	12.5	0.8	YWMT16T3...

**RE : Standard corner radius

SPARE PARTS


Designation	Clamping screw	Wrench
SYIBN...	CSTB-2.5L080	T-8F

INSERT SELECTION

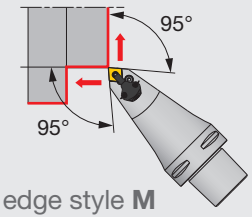
P	Application	Finishing to medium cutting
	Grade	T9225
	Chipbreaker Shape	ZM 
	Cutting conditions	B008

K	Application	Finishing to medium cutting
	Grade	GT9530
	Chipbreaker Shape	ZM 
	Cutting conditions	B012

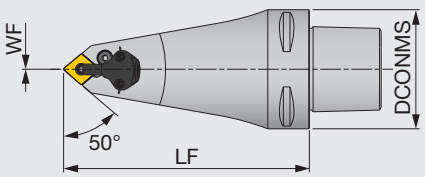
Reference pages: SYIBN: Inserts → B163

C-PCMNN-CHP

Lever-lock toolholder with TungCap connection, for negative 80° rhombic inserts, with high pressure coolant capability



Cutting edge style **M**



Metric	DCONMS	LF	WF	RE	Insert
C6PCMNN00130-12-CHP	63	115	0	0.8	CN/GN**1204...

Applicable for 14 MPa coolant
**RE : Standard corner radius

For external turning only

SPARE PARTS

Designation	Shim	Clamping screw	Wrench 1	Spring pin	Lever
C6PCMNN00130-12-CHP	LSC42	LCS4	P-3	LSP4	LCL4

SPARE PARTS

Designation	Coolant unit	Mounting screw	Wrench 2	O-ring
C6PCMNN00130-12-CHP	CU-CW-CHP	SRM3	T-8F	OR6.4X0.9N

INSERT SELECTION

P

Application	Precision finishing	Finishing	Medium cutting	Medium to heavy cutting
Grade	NS9530	GT9530	T9215	T9215
Chipbreaker Shape	TF	TSF	TM	TH
Cutting conditions	B008			

M

Application	Finishing	Medium cutting	Medium to heavy cutting
Grade	T6120	T6130	T6130
Chipbreaker Shape	SF	SM	SH
Cutting conditions	B010		

K

Application	Finishing	Medium cutting	Medium to heavy cutting
Grade	T515	T515	T515
Chipbreaker Shape	All-round	All-round	All-round
Cutting conditions	B012		

N

Application	Precision finishing	Finishing	Medium cutting
Grade	DX120	DX140	TH10
Chipbreaker Shape	T-DIA with rake	T-DIA	P
Cutting conditions	B014		

S

Application	Precision finishing	Finishing	Medium cutting
Grade	BX470	AH8005	AH8005
Chipbreaker Shape	T-CBN	HRF	HRM
Cutting conditions	B016		

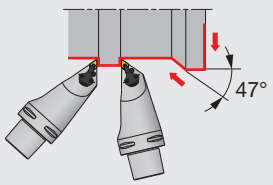
H

Application	Precision finishing	Finishing
Grade	BXM10	BXM20
Chipbreaker Shape	T-CBN	T-CBN
Cutting conditions	B018	

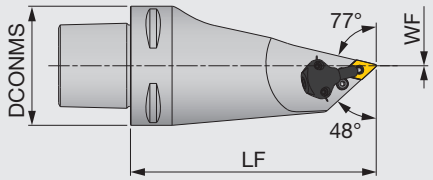
Reference pages: C-PCMNN-CHP: Inserts → B056 -, CBN → B172 -, PCD → B194 -
Parts for coolant hose → C142

C-PDMNL-CHP

Lever-lock toolholder with TungCap connection, for negative 55° rhombic inserts, with high pressure coolant capability



Cutting edge style **M**



Left hand (L) shown.

Metric	DCONMS	LF	WF	RE**	Insert
C6PDMNL00130-1104-CHP	63	130	0	0.8	DN**1104...

Applicable for 14 MPa coolant
**RE : Standard corner radius

For external turning only

SPARE PARTS

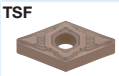
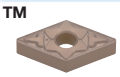
Designation	Shim	Clamping screw	Wrench 1	Spring pin	Lever
C6PDMNL00130-1104-CHP	ELSD32	LCS3	P-2.5	LSP3	LCL33L

SPARE PARTS

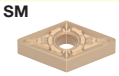
Designation	Coolant unit	Mounting screw	Wrench 2	O-ring
C6PDMNL00130-1104-CHP	CU-D-CHP	SRM3	T-8F	OR6.4X0.9N

INSERT SELECTION

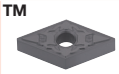
P

Application	Finishing	Medium cutting
Grade	T9215	T9215
Chipbreaker Shape	TSF 	TM 
Cutting conditions	B008	

M

Application	Finishing	Medium cutting
Grade	T6120	T6130
Chipbreaker Shape	SS 	SM 
Cutting conditions	B010	

K

Application	Medium cutting
Grade	T515
Chipbreaker Shape	TM 
Cutting conditions	B012

Reference pages: C-PDMNL-CHP: Inserts → B067 -
Parts for coolant hose → C142

PARTS FOR COOLANT HOSE

Connecting hose

Fig. 1

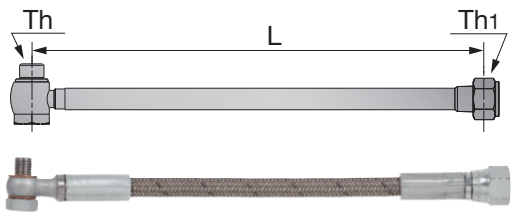
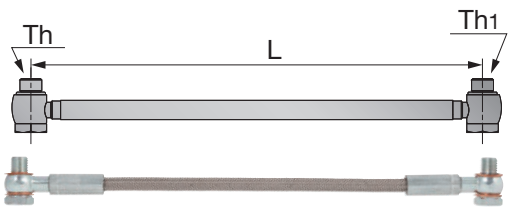
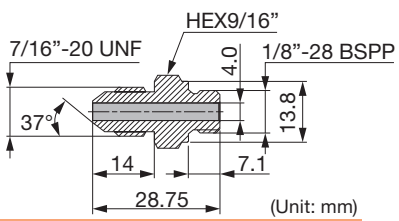


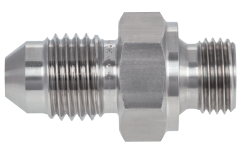
Fig. 2



Metric	L	Th	Th1	Max. pressure (Mpa)	Fig.
CHP-HOSE-G1/8-7/16-200BS	200	G1/8"-28 BSPP	7/16"-20 UNF	26	1
CHP-HOSE-G1/8-7/16-250BS	250	G1/8"-28 BSPP	7/16"-20 UNF	26	1
CHP-HOSE-5/16-7/16-200BS	200	5/16"-24UNF	7/16"-20 UNF	20	1
CHP-HOSE-5/16-G1/8-200BS	200	5/16"-24UNF	G1/8"-28 BSPP	20	1
CHP-HOSE-G1/8-G1/8-200BB	200	G1/8"-28 BSPP	G1/8"-28 BSPP	26	2
CHP-HOSE-G1/8-G1/8-250BB	250	G1/8"-28 BSPP	G1/8"-28 BSPP	26	2

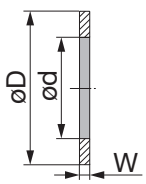
Connector

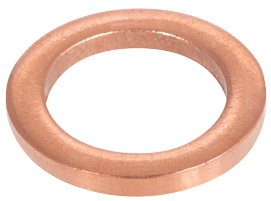




Metric
CHP-NIPPLE-G1/8-7/16UNF

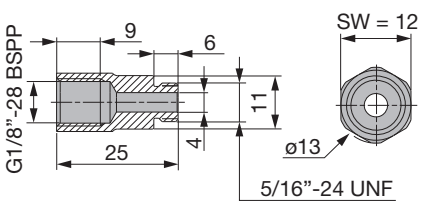
Seal washer

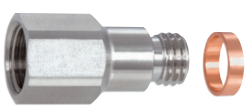




Metric	øD	ød	W
CHP-COPPER-SEAL1/8	15	10	1
CHP-COPPER-SEAL5/16	11	8	1
CHP-COPPER-SEAL5/16-2.5	11	8	2.5

Connector for small lathe with seal washer





Metric	L	Fig.
CHP-CONECTOR/5/16-G1/8	2.5	1
CHP-CONECTOR-G1/8-R1/8	2.54	2

STANDARD CUTTING CONDITIONS

FIXRTURN

ISO	Workpiece material	Chipbreaker	Grade	Cutting Speed *Vc* (sfm)	Depth of cut *ap* (in)	Feed *f* (ipr)
P	Steels 1045, etc.	6RS	T9215	492 - 984	0.020 - 0.079	0.020 - 0.039
		6RS	T9225	394 - 820	0.020 - 0.079	0.020 - 0.039
		6RS	NS9530	492 - 820	0.020 - 0.079	0.020 - 0.039
		6RM	T9215	492 - 984	0.039 - 0.118	0.020 - 0.039
		6RM	T9225	394 - 820	0.039 - 0.118	0.020 - 0.039
		6RM	NS9530	492 - 820	0.039 - 0.118	0.020 - 0.039

Reference pages: SRGCR/L → C089, SRDCN → C107

STANDARD CUTTING CONDITIONS

MINIFORCE TURN

Applications	ISO	Workpiece material	Priority	Chipbreaker	Grade	Cutting speed *Vc* (sfm)	Depth of cut *ap* (in)	Feed *f* (ipr)
Swiss lathes	P	Low carbon steels , Carbon steels 1045, etc. Low alloy steels, Alloy steels 4140, etc.	First choice	JS	SH725	164 - 590	0.004 - 0.118	0.001 - 0.004
			Sharpness	JSS	SH725	164 - 590	0.004 - 0.059	0.001 - 0.004
	M	Stainless steels (Austenitic) 304, etc. Stainless steels (Martensitic and ferritic) 430, etc. Stainless steels (Precipitation hardened) 174, etc.	First choice	JS	SH725	164 - 590	0.004 - 0.049	0.001 - 0.004
			Sharpness	JSS	SH725	164 - 590	0.004 - 0.059	0.001 - 0.004
Small CNC lathes	P	Low carbon steels, Carbon steels 1045, etc. Low alloy steels, Alloy steels 4140, etc.	First choice	SS	AH725	164 - 590	0.006 - 0.059	0.002 - 0.008
				TS	AH725	164 - 590	0.012 - 0.079	0.003 - 0.012
			Surface quality	SS	NS9530	164 - 656	0.006 - 0.059	0.002 - 0.008
				TS	NS9530	164 - 656	0.012 - 0.079	0.003 - 0.012
			Wear resistance	SS	GT9530	164 - 820	0.006 - 0.059	0.002 - 0.008
				TS	GT9530	164 - 820	0.012 - 0.079	0.003 - 0.012
	M	Stainless steels (Austenitic) 304, etc. Stainless steels (Martensitic and ferritic) 430, etc. Stainless steels (Precipitation hardened) 174, etc.	First choice	SS	AH725	164 - 492	0.006 - 0.059	0.002 - 0.008
			Fracture resistance	TS	AH725	164 - 492	0.012 - 0.079	0.003 - 0.012

TURNTEEN FEED

For HD holder (High Depth of Cut)

ISO	Insert	Depth of cut *ap* (in)	Feed *f* (ipr)	Cutting speed: *Vc* (sfm)		
				T9215	T9125	T9225
P	POMG110612-MNW	0.031 - 0.217	0.016 - 0.047	150 - 400	80 - 180	120 - 300
	POMG130612-MNW	0.039 - 0.051	0.016 - 0.051	150 - 400	80 - 180	120 - 300

For HF holder (High Feed)

ISO	Insert	Depth of cut *ap* (in)	Feed *f* (ipr)	Cutting speed: *Vc* (sfm)		
				T9215	T9125	T9225
P	POMG110612-MNW	0.039 - 0.098	0.020 - 0.059	150 - 400	80 - 180	120 - 300
	POMG130612-MNW	0.039 - 0.118	0.020 - 0.079	150 - 400	80 - 180	120 - 300

TURNFEED

ISO	Workpiece material	Grade	Chipbreaker	Cutting speed *Vc* (sfm)	Depth of cut *ap* (in)	Feed *f* (ipr)
P	Mild and low carbon steels 400SS, 1025, etc. < 180 HB	T9225	ML	330 - 990	0.025 - 0.100	0.025 - 0.100
	Carbon and alloy steels 1049, 4142, etc. < 300HB	T9215	ML	390 - 1150	0.025 - 0.100	0.025 - 0.100
M	Stainless steels 304, 316, etc. < 250 HB	T9225	ML	330 - 990	0.025 - 0.100	0.025 - 0.100
K	Gray and ductile cast irons No35B, 60-40-18, etc.	AH120	ML	330 - 820	0.025 - 0.100	0.025 - 0.100

When the side cutting edge is used for facing, the maximum feed is limited to within 0.040 ipr.

Reference pages: JSWL2XR/L, JSWLXR/L, JSWL2XR/L-CHP, JPWL2XR/L, JSWLXR-F → C033 - C036
JSDJ2XR/L, JSDJXR/L, JSDJ2XR/L-CHP, JPDJ2XR/L, JSDJXR-F → C042 - C045
JSVJ2XR/L, JSVJXR/L, JSVJ2XR/L-CHP, JPVJ2XR/L, JSVJXR-F → C059 - C061
PPXOR/L-HD, PPXOR/L-HF → C102, XWXPR/L → C104
JS-SDUXL, JS-SVUXL → C137 - C138

STANDARD CUTTING CONDITIONS

TURNTEC

*Values in red are for facing.

LNMX1204

ISO	Workpiece material	Chip breaker	Grade	Cutting speed *Vc* (sfm)	Depth of cut: *ap* (in)		Feed: *f* (ipr)	
					RE : 0.031	RE : 0.047	RE : 0.031	RE : 0.047
P	Steels 1045, 4130, etc.	TDR	T9115	390 - 820	0.020 - 0.195 0.020 - 0.086	0.031 - 0.195 0.031 - 0.086	0.006 - 0.024	0.010 - 0.031
		TDR	T9125	260 - 590	0.020 - 0.195 0.020 - 0.086	0.031 - 0.195 0.031 - 0.086	0.006 - 0.024	0.010 - 0.031
M	Stainless steels 304, 316, etc.	TDR	T9115	330 - 590	0.020 - 0.195 0.020 - .086	0.031 - 0.195 0.031 - 0.086	0.006 - 0.024	0.010 - 0.031
		TDR	T9125	260 - 590	0.020 - 0.195 0.020 - 0.086	0.031 - 0.195 0.031 - 0.086	0.006 - 0.024	0.010 - 0.031

LNMX1606

ISO	Workpiece material	Chip breaker	Grade	Cutting speed *Vc* (sfm)	Depth of cut: *ap* (in)			Feed: *f* (ipr)		
					RE : 0.031	RE : 0.047	RE : 0.063	RE : 0.031	RE : 0.047	RE : 0.063
P	Steels 1045, 4130, etc.	TDR	T9115	390 - 820	0.020 - 0.197 0.020 - 0.126	0.031 - 0.236 .031 - 0.126	0.039 - 0.315 0.039 - 0.126	0.006 - 0.024	0.010 - 0.031	0.012 - 0.039
		TDR	T9125	260 - 590	0.020 - 0.197 0.020 - 0.126	0.031 - 0.236 .031 - 0.126	0.039 - 0.315 0.039 - 0.126	0.006 - 0.024	0.010 - 0.031	0.012 - 0.039
		TWR	T9115	390 - 820	0.020 - 0.197 0.020 - 0.126	0.031 - 0.236 0.031 - 0.126	-	0.006 - 0.024	0.010 - 0.031	-
		TWR	T9125	260 - 590	0.020 - 0.197 0.020 - 0.126	0.031 - 0.236 0.031 - 0.126	-	0.006 - 0.024	0.010 - 0.031	-
M	Stainless steels 304, 316, etc.	TDR	T9115	330 - 590	0.020 - 0.197 0.020 - 0.126	0.031 - 0.236 0.031 - 0.126	0.039 - 0.315 0.039 - 0.126	0.006 - 0.024	0.010 - 0.031	0.012 - 0.039
		TDR	T9125	260 - 590	0.020 - 0.197 0.020 - 0.126	0.031 - 0.236 0.031 - 0.126	0.039 - 0.315 0.039 - 0.126	0.006 - 0.024	0.010 - 0.031	0.012 - 0.039
		MDR	T9115	330 - 490	0.059 - 0.236 0.020 - 0.126	0.059 - 0.276 0.031 - 0.126	-	0.004 - 0.020	0.006 - 0.028	-
		MDR	AH725	160 - 490	0.059 - 0.236 0.020 - 0.126	0.059 - 0.276 0.031 - 0.126	-	0.004 - 0.020	0.006 - 0.028	-
		TWR	T9115	330 - 590	0.020 - 0.197 0.020 - 0.126	0.031 - 0.236 0.031 - 0.126	-	0.006 - 0.024	0.010 - 0.031	-
		TWR	T9125	260 - 590	0.020 - 0.197 0.020 - 0.126	0.031 - 0.236 0.031 - 0.126	-	0.006 - 0.024	0.010 - 0.031	-

LNMX2410

ISO	Workpiece material	Chip breaker	Grade	Cutting speed *Vc* (sfm)	Depth of cut: *ap* (in)		Feed: *f* (ipr)	
					RE : 0.063	RE : 0.094	RE : 0.063	RE : 0.094
P	Steels 1045, 4130, etc.	TDR	T9115	390 - 820	0.156 - 0.585 0.039 - 0.176	0.195 - 0.585 0.039 - 0.176	0.012 - 0.039	0.012 - 0.043
		TDR	T9125	260 - 490	0.156 - 0.585 0.039 - 0.176	0.195 - 0.585 0.039 - 0.176	0.012 - 0.039	0.012 - 0.043
M	Stainless steels 304, 316, etc.	TDR	T9115	330 - 590	0.156 - 0.585 0.039 - 0.176	0.195 - 0.585 0.039 - 0.176	0.012 - 0.039	0.012 - 0.043
		TDR	T9125	260 - 490	0.156 - 0.585 0.039 - 0.176	0.195 - 0.585 0.039 - 0.176	0.012 - 0.039	0.012 - 0.043

DIMPLEFX

ISO	Workpiece material	Grade	Cutting speed *Vc* (sfm)	Depth of cut *ap* (in)	Feed *f* (ipr)
K	Gray cast irons	FX105	2300 (1000 - 3300)	0.040 (0.002 - 0.120)	0.012 (0.002 - 0.024)
	Ductile cast irons	FX105	650 (330 - 1000)	0.040 (0.002 - 0.120)	0.008 (0.002 - 0.016)

Reference pages: CCLNR/L-RD → C024, CDNNN-RD → C070, CVVNN-RD → C074
TLANR/L → C082, TLBNR/L → C097, CHSNR/L → C111
CSSNR/L → C114, TLFNR/L → C120