

Tungaloy

Member IMC Group

Tungaloy Report No. 371-US

TURNLINE J series: Cutting tools for small lathes

Extended version
with toolholders and
inserts

JS/JRP/JPP/JSP type

Excellent chip control, high quality finishes & productivity levels



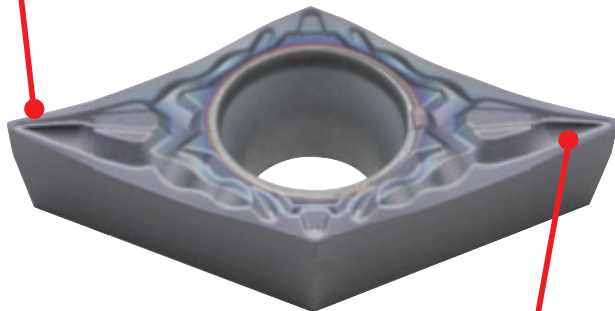
JS type New 3 dimensional chipbreaker



Excellent cutting performance for Superalloys

Dynamic inclination

- Excellent chip control
- Lowers cutting force



Steep protrusion

- Breaks chips at small depths of cut
- Improves chip coiling at large depth of cut



Stainless

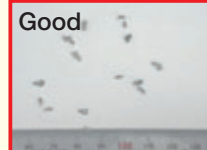
Work material : Stainless steels (SUS316L)

Insert : DCGT32.50-**
Cutting speed : $V_c = 160$ sfm
Feed : $f = .001$ ipr

Excellent chip control

Depth of cut
 $a_p = .020"$

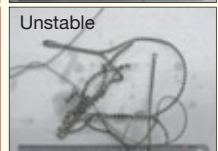
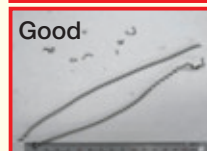
JS type



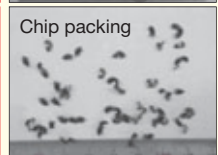
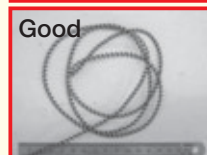
Competitor



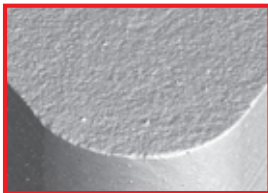
Depth of cut
 $a_p = .060"$



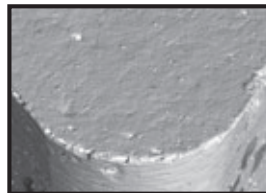
Depth of cut
 $a_p = .080"$



Super fine cutting edge



JS type
Fine edge,
no chipping



Competitor A
Micro chipping

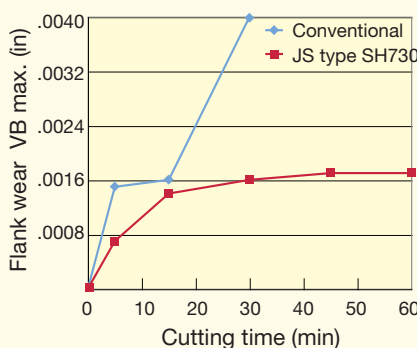
Long tool life and excellent stability



Stainless

Work Material: Stainless Steels (316L)

Inserts : DCGT32.50-**
Cutting speed : $V_c = 600$ sfm
Depth of cut : $a_p = .020" \sim .080"$
Feed : $f = .0006 \sim .001$ ipr



JS type After 60 min



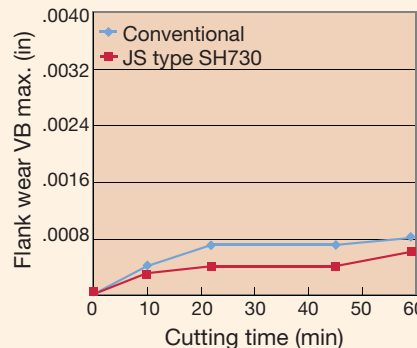
Conventional: After 30 min



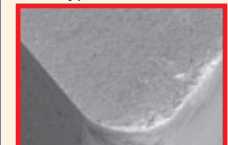
Superalloys

Work Material: Titanium Alloys (Ti-6Al-4V)

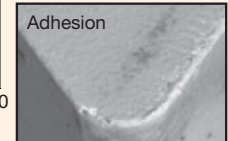
Inserts : DCGT32.50-**
Cutting speed : $V_c = 600$ sfm
Depth of cut : $a_p = .020" \sim .080"$
Feed : $f = .0006 \sim .001$ ipr



JS type After 60 min



Conventional: After 60 min



JRP / JPP / JSP type

High Tolerance Inserts

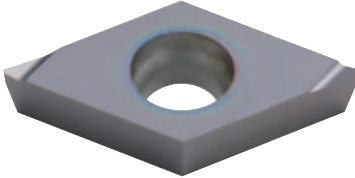


3 types of ground chipbreaker available

JRP type

Lead (Ramp) type chipbreaker

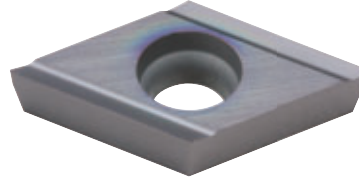
For excellent chip control



JPP type

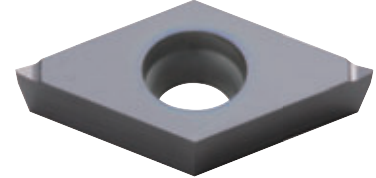
Parallel type chipbreaker

Suitable for profiling



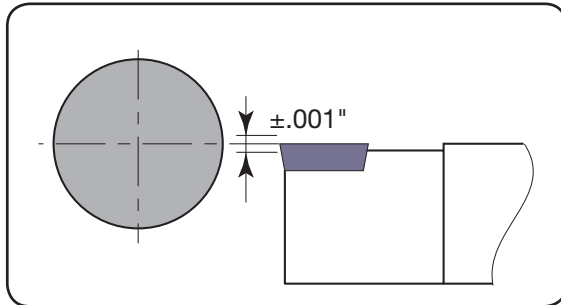
JSP type

Neutral (symmetric) type chipbreaker



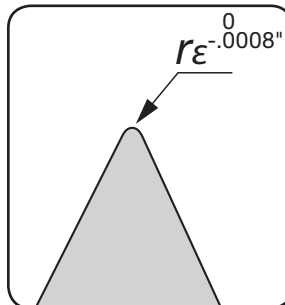
Tolerance of inserts

Height of cutting edge:
 $\pm .001''$



Tolerance of corner radius:

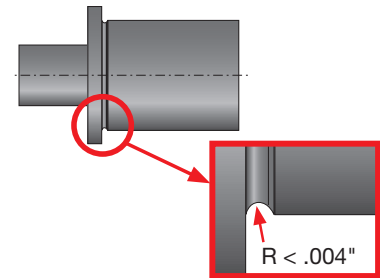
Minus tolerance



Example:

Electrical equipment

Effective performance for the specified corner radius (see below)



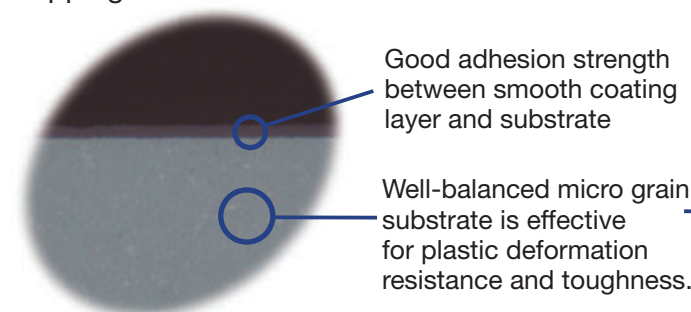
Grades

New PVD coated grade

SH730



The unique (Ti,Al)N coating layer increases the welding resistance. The **SH730** also has an excellent balance between sharpness and chipping resistance.

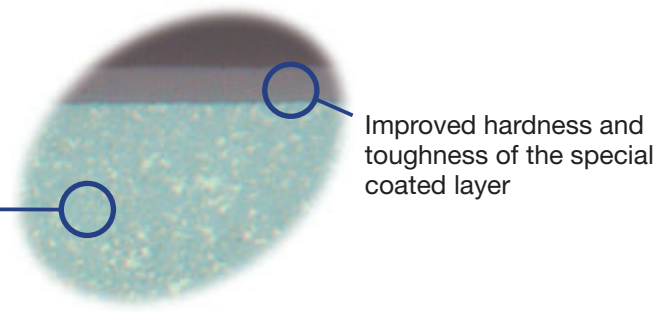


New PVD coated grade

AH725

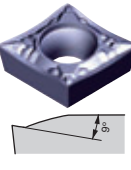
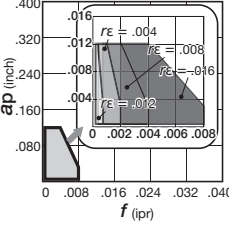
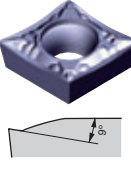
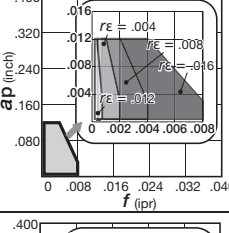
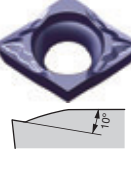
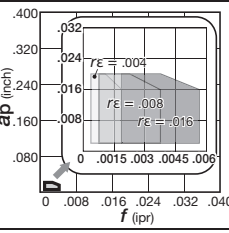


The special (Ti,Al)N coating layer and substrate improve features such as wear resistance and toughness.

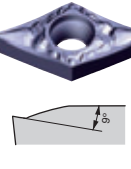
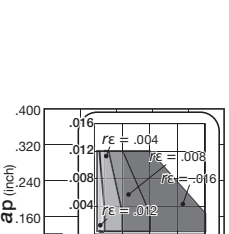
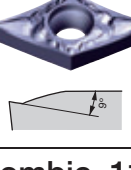
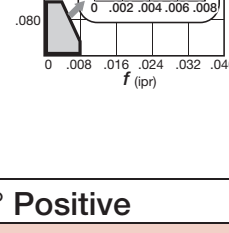


Inserts (JS type)

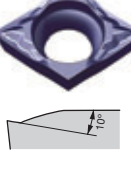
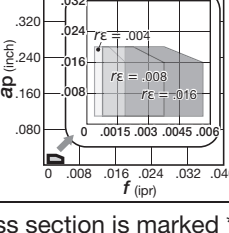
80° Rhombic, 7° Positive

Application	Chipbreaker	<i>f</i> - <i>ap</i>	Cat. No.		Grades		Dimensions (inch)			
	Appearance (Cross section)		Inch	Metric	Coated		I.C.dia ød	Thick- ness s	Hole dia ød ₁	Corner radius r _E
					SH730	AH725				
For external turning on small lathes Sharp edge			CCGT21.5VFN-JS	CCGT060200FN-JS	●		.250	.094	.110	.0012
			CCGT21.50FN-JS	CCGT060201FN-JS	●					.004
			CCGT21.50.5FN-JS	CCGT060202FN-JS	●					.008
			CCGT21.51FN-JS	CCGT060204FN-JS	●					.016
			CCGT32.5VFN-JS	CCGT09T300FN-JS	●					.0012
			*CCGT32.50FN-JS	CCGT09T301FN-JS	●		.375	.156	.173	.004
			CCGT32.50.5FN-JS	CCGT09T302FN-JS	●					.008
			CCGT32.51FN-JS	CCGT09T304FN-JS	●					.016
For external turning on small lathes			CCGT21.50N-JS	CCGT060201N-JS		●	.250	.094	.110	.004
			CCGT21.50.5N-JS	CCGT060202N-JS		●				.008
			CCGT21.51N-JS	CCGT060204N-JS		●				.016
			*CCGT32.50N-JS	CCGT09T301N-JS		●	.375	.156	.173	.004
			CCGT32.50.5N-JS	CCGT09T302N-JS		●				.008
			CCGT32.51N-JS	CCGT09T304N-JS		●				.016
For internal turning on small lathes			CCGT51.80-JS	CCGT03X101-JS	●		.141	.055	.075	.004
			CCGT51.80.5-JS	CCGT03X102-JS	●					.008
			CCGT51.81-JS	CCGT03X104-JS	●					.016
			*CCGT5.52.20-JS	CCGT04T101-JS	●		.172	.070	.091	.004
			CCGT5.52.20.5-JS	CCGT04T102-JS	●					.008
			CCGT5.52.21-JS	CCGT04T104-JS	●					.010

55° Rhombic, 7° Positive

Application	Chipbreaker	<i>f</i> - <i>ap</i>	Cat. No.		Grades		Dimensions (inch)			
	Appearance (Cross section)		Inch	Metric	Coated		I.C.dia ød	Thick- ness s	Hole dia ød ₁	Corner radius r _E
					SH730	AH725				
For external turning on small lathes Sharp edge			DCGT21.5VFN-JS	DCGT070200FN-JS	●		.250	.094	.110	.0012
			DCGT21.50FN-JS	DCGT070201FN-JS	●					.004
			DCGT21.50.5FN-JS	DCGT070202FN-JS	●					.008
			DCGT32.5VFN-JS	DCGT11T300FN-JS	●		.375	.156	.173	.0012
			*DCGT32.50FN-JS	DCGT11T301FN-JS	●					.004
			DCGT32.50.5FN-JS	DCGT11T302FN-JS	●					.008
			DCGT32.51FN-JS	DCGT11T304FN-JS	●					.016
For external turning on small lathes			DCGT21.50N-JS	DCGT070201N-JS		●	.250	.094	.110	.004
			DCGT21.50.5N-JS	DCGT070202N-JS		●				.008
			*DCGT32.50N-JS	DCGT11T301N-JS		●	.375	.156	.173	.004
			DCGT32.50.5N-JS	DCGT11T302N-JS		●				.008
			DCGT32.51N-JS	DCGT11T304N-JS		●				.016

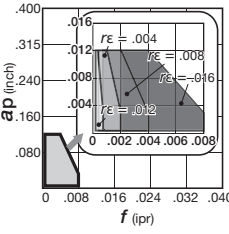
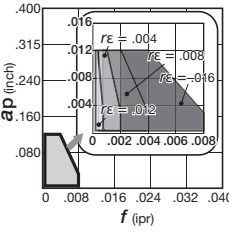
75° Rhombic, 11° Positive

Application	Chipbreaker	<i>f</i> - <i>ap</i>	Cat. No.		Grades		Dimensions (inch)			
	Appearance (Cross section)		Inch	Metric	Coated		I.C.dia ød	Thick- ness s	Hole dia ød ₁	Corner radius r _E
					SH730	AH725				
For internal turning on small lathes			EPGT4.51.80-JS	EPGT03X101-JS	●		.141	.055	.075	.004
			EPGT4.51.80.5-JS	EPGT03X102-JS	●					.008
			EPGT4.51.81-JS	EPGT03X104-JS	●					.016
			*EPGT520-JS	EPGT040101-JS	●		.156	.063	.091	.004
			EPGT520.5-JS	EPGT040102-JS	●					.008
			EPGT521-JS	EPGT040104-JS	●					.016

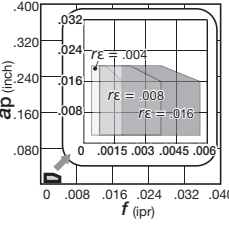
Note: Chipbreaker Cross section is marked * next to the Cat. No.

● : Stocked items

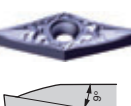
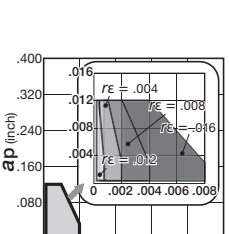
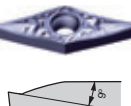
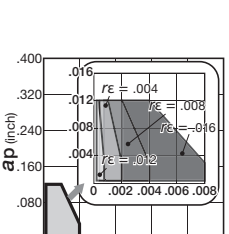
60° Triangular, 7° positive

Application	Chipbreaker	$f - ap$	Cat. No.		Grades		Dimensions (inch)			
	Appearance (Cross section)		Inch	Metric	Coated		I.C.dia ød	Thick- ness s	Hole dia ød ₁	Corner radius r_E
					SH730	AH725				
For external turning on small lathes	JS 		TCGT21.5VFN-JS	TCGT110200FN-JS	●		.250	.094	.110	.0012
			*TCGT21.50FN-JS	TCGT110201FN-JS	●					.004
			TCGT21.50.5FN-JS	TCGT110202FN-JS	●					.008
			TCGT21.51FN-JS	TCGT110204FN-JS	●					.016
For external turning on small lathes	JS 		*TCGT21.50N-JS	TCGT110201N-JS		●	.250	.094	.110	.004
			TCGT21.50.5N-JS	TCGT110202N-JS		●				.008
			TCGT21.51N-JS	TCGT110204N-JS		●				.016

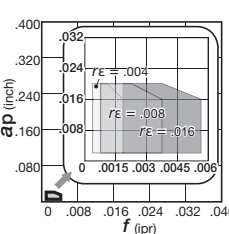
60° Triangular, 11° positive

Application	Chipbreaker	$f - ap$	Cat. No.		Grades		Dimensions (inch)			
	Appearance (Cross section)		Inch	Metric	Coated		I.C.dia ød	Thick- ness s	Hole dia ød ₁	Corner radius r_E
					SH730	AH725				
For internal turning on small lathes	JS 		*TPGT5.520-JS	TPGT070101-JS	●		.172	.063	.102	.004
			TPGT5.520.5-JS	TPGT070102-JS	●					.008
			TPGT5.521-JS	TPGT070104-JS	●					.016

35° Rhombic, 5° Positive

Application	Chipbreaker	$f - ap$	Cat. No.		Grades		Dimensions (inch)			
	Appearance (Cross section)		Inch	Metric	Coated		I.C.dia ød	Thick- ness s	Hole dia ød ₁	Corner radius r_E
					SH730	AH725				
For external turning on small lathes	JS 		VBGT22VFN-JS	VBGT110300FN-JS	●		.250	.094	.110	.0012
			*VBGT220FN-JS	VBGT110301FN-JS	●					.004
			VBGT220.5FN-JS	VBGT110302FN-JS	●					.008
			VBGT221FN-JS	VBGT110304FN-JS	●					.016
For external turning on small lathes	JS 		*VBGT220N-JS	VBGT110301N-JS		●	.250	.125	.110	.004
			VBGT220.5N-JS	VBGT110302N-JS		●				.008
			VBGT221N-JS	VBGT110304N-JS		●				.016

80° Trigon, 5° positive

Application	Chipbreaker	$f - ap$	Cat. No.		Grades		Dimensions (inch)			
	Appearance (Cross section)		Inch	Metric	Coated		I.C.dia ød	Thick- ness s	Hole dia ød ₁	Corner radius r_E
					SH730	AH725				
For internal turning on small lathes	JS 		*WBGT520R-JS	WBGT030101R-JS	●		.156	.063	.091	.004
			WBGT520L-JS	WBGT030101L-JS	●					.004
			WBGT520.5R-JS	WBGT030102R-JS	●					.008
			WBGT520.5L-JS	WBGT030102L-JS	●					.008
			WBGT521R-JS	WBGT030104R-JS	●					.016
			WBGT521L-JS	WBGT030104L-JS	●					.016

Note: Chipbreaker Cross section is marked * next to the Cat. No.

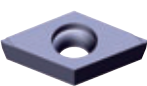
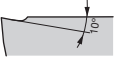
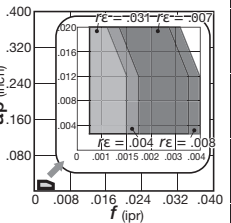
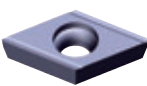
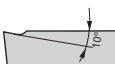
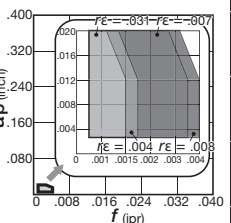
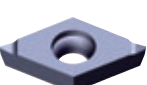
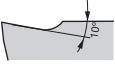
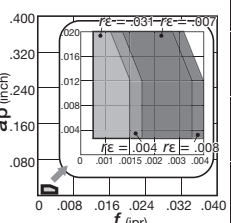
● : Stocked items

Standard cutting conditions JS types

Work material	chip-breaker	Grades	Cutting speed Vc (sfm)	Depth of cut ap (in)	Feed: f (ipr)			
					$r_{\epsilon} = .0012''$	$r_{\epsilon} = .004''$	$r_{\epsilon} = .008''$	$r_{\epsilon} = .016''$
Steels 1045, 4137 etc.	JS	AH725	150 - 480	.004 - .080	-	.0004 - .002	.0008 - .004	.002 - .008
Stainless steels 303, 304 etc.		SH730	100 - 500	.004 - .080	.0002 - .0008			.002 - .006
		AH725	160 - 500		-			.002 - .008
Titanium alloys (Ti-6AL-4v etc.)		SH730	100 - 330	.004 - .120	.0002 - .0008			.002 - .006
		AH725			-			.002 - .008

Inserts (JRP / JPP / JSP type)

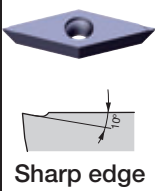
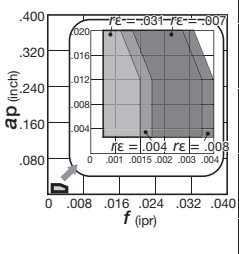
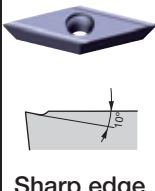
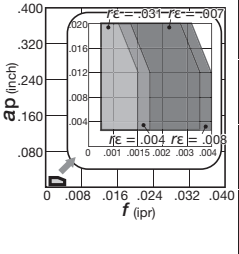
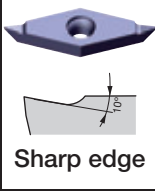
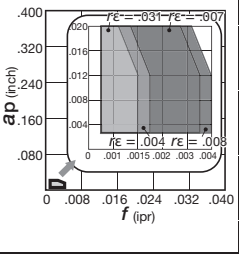
55° Rhombic, 7° Positive

Appli- cation	Chipbreaker	f - ap	Cat. No.		Grades	Dimensions (inch)			
	Appearance (Cross section)		Inch	Metric	Coated SH730	I.C.dia ød	Thick- ness s	Hole dia ød1	Corner radius rε
For external turning on small lathes	JRP   Sharp edge		DCET21.5YMFR-JRP	DCET0702008MFR-JRP	●	.250	.094	.110	.003
			DCET21.5YMFL-JRP	DCET0702008MFL-JRP	●				.004
			DCET21.50MFR-JRP	DCET070201 MFR-JRP	●				.007
			DCET21.50MFL-JRP	DCET070201 MFL-JRP	●				.008
			DCET21.50.4MFR-JRP	DCET0702018MFR-JRP	●				.003
			DCET21.50.4MFL-JRP	DCET0702018MFL-JRP	●				.004
			DCET21.50.5MFR-JRP	DCET070202 MFR-JRP	●				.007
			DCET21.50.5MFL-JRP	DCET070202 MFL-JRP	●				.008
			DCET32.5YMFR-JRP	DCET11T3008MFR-JRP	●	.375	.156	.173	.003
			DCET32.5YMFL-JRP	DCET11T3008MFL-JRP	●				.004
			DCET32.50MFR-JRP	DCET11T301 MFR-JRP	●				.007
			DCET32.50MFL-JRP	DCET11T301 MFL-JRP	●				.008
			DCET32.50.4MFR-JRP	DCET11T3018MFR-JRP	●				.003
			DCET32.50.4MFL-JRP	DCET11T3018MFL-JRP	●				.004
			*DCET32.50.5MFR-JRP	DCET11T302 MFR-JRP	●				.007
			DCET32.50.5MFL-JRP	DCET11T302 MFL-JRP	●				.008
For external turning on small lathes	JPP   Sharp edge		DCET21.5YMFR-JPP	DCET0702008MFR-JPP	●	.250	.094	.110	.003
			DCET21.5YMFL-JPP	DCET0702008MFL-JPP	●				.004
			DCET21.50MFR-JPP	DCET070201 MFR-JPP	●				.007
			DCET21.50MFL-JPP	DCET070201 MFL-JPP	●				.008
			DCET21.50.4MFR-JPP	DCET0702018MFR-JPP	●				.003
			DCET21.50.4MFL-JPP	DCET0702018MFL-JPP	●				.004
			DCET21.50.5MFR-JPP	DCET070202 MFR-JPP	●				.007
			DCET21.50.5MFL-JPP	DCET070202 MFL-JPP	●				.008
			DCET32.5YMFR-JPP	DCET11T3008MFR-JPP	●	.375	.156	.173	.003
			DCET32.5YMFL-JPP	DCET11T3008MFL-JPP	●				.004
			DCET32.50MFR-JPP	DCET11T301 MFR-JPP	●				.007
			DCET32.50MFL-JPP	DCET11T301 MFL-JPP	●				.008
			DCET32.50.4MFR-JPP	DCET11T3018MFR-JPP	●				.003
			DCET32.50.4MFL-JPP	DCET11T3018MFL-JPP	●				.004
			*DCET32.50.5MFR-JPP	DCET11T302 MFR-JPP	●				.007
			DCET32.50.5MFL-JPP	DCET11T302 MFL-JPP	●				.008
For external turning on small lathes	JSP   Sharp edge		DCET21.5YMFN-JSP	DCET0702008MFN-JSP	●	.250	.094	.110	.003
			DCET21.50MFN-JSP	DCET070201 MFN-JSP	●				.004
			DCET21.50.4MFN-JSP	DCET0702018MFN-JSP	●				.007
			DCET21.50.5MFN-JSP	DCET070202 MFN-JSP	●				.008
			DCET32.5YMFN-JSP	DCET11T3008MFN-JSP	●	.375	.156	.173	.003
			DCET32.50MFN-JSP	DCET11T301 MFN-JSP	●				.004
			DCET32.50.4MFN-JSP	DCET11T3018MFN-JSP	●				.007
			*DCET32.50.5MFN-JSP	DCET11T302 MFN-JSP	●				.008

Note: Chipbreaker Cross section is marked * next to the Cat. No.

● : Stocked items

35° Rhombic, 11° Positive

Applica- tion	Chipbreaker	<i>f</i> - <i>ap</i>	Cat. No.		Grades	Dimensions (inch)			
	Appearance (Cross section)		Inch	Metric	Coated SH730	I.C. dia ød	Thick- ness s	Hole dia ød ₁	Corner radius <i>r</i> ε
For external turning on small lathes	JRP  Sharp edge		VPET53YMFR-JRP	VPET0802008MFR-JRP	●	.187	.094	.091	.003
			VPET53YMFL-JRP	VPET0802008MFL-JRP	●				.004
			VPET530MFR-JRP	VPET080201 MFR-JRP	●				.007
			VPET530MFL-JRP	VPET080201 MFL-JRP	●				.008
			VPET530.4MFR-JRP	VPET0802018MFR-JRP	●				.003
			VPET530.4MFL-JRP	VPET0802018MFL-JRP	●				.004
			VPET530.5MFR-JRP	VPET080202 MFR-JRP	●				.007
			VPET530.5MFL-JRP	VPET080202 MFL-JRP	●				.008
			VPET22YMFR-JRP	VPET1103008MFR-JRP	●	.250	.125	.110	.003
			VPET22YMFL-JRP	VPET1103008MFL-JRP	●				.004
			VPET220MFR-JRP	VPET110301 MFR-JRP	●				.007
			VPET220MFL-JRP	VPET110301 MFL-JRP	●				.008
			VPET220.4MFR-JRP	VPET1103018MFR-JRP	●				.003
			VPET220.4MFL-JRP	VPET1103018MFL-JRP	●				.004
			*VPET220.5MFR-JRP	VPET110302 MFR-JRP	●				.007
			VPET220.5MFL-JRP	VPET110302 MFL-JRP	●				.008
For external turning on small lathes	JPP  Sharp edge		VPET53YMFR-JPP	VPET0802008MFR-JPP	●	.187	.094	.091	.003
			VPET53YMFL-JPP	VPET0802008MFL-JPP	●				.004
			VPET530MFR-JPP	VPET080201 MFR-JPP	●				.007
			VPET530MFL-JPP	VPET080201 MFL-JPP	●				.008
			VPET530.4MFR-JPP	VPET0802018MFR-JPP	●				.003
			VPET530.4MFL-JPP	VPET0802018MFL-JPP	●				.004
			VPET530.5MFR-JPP	VPET080202 MFR-JPP	●				.007
			VPET530.5MFL-JPP	VPET080202 MFL-JPP	●				.008
			VPET22YMFR-JPP	VPET1103008MFR-JPP	●	.250	.125	.110	.003
			VPET22YMFL-JPP	VPET1103008MFL-JPP	●				.004
			VPET220MFR-JPP	VPET110301 MFR-JPP	●				.007
			VPET220MFL-JPP	VPET110301 MFL-JPP	●				.008
			VPET220.4MFR-JPP	VPET1103018MFR-JPP	●				.003
			VPET220.4MFL-JPP	VPET1103018MFL-JPP	●				.004
			*VPET220.5MFR-JPP	VPET110302 MFR-JPP	●				.007
			VPET220.5MFL-JPP	VPET110302 MFL-JPP	●				.008
For external turning on small lathes	JSP  Sharp edge		VPET53YMFN-JSP	VPET0802008MFN-JSP	●	.187	.094	.091	.003
			VPET530MFN-JSP	VPET080201 MFN-JSP	●				.004
			VPET530.4MFN-JSP	VPET0802018MFN-JSP	●				.007
			VPET530.5MFN-JSP	VPET080202 MFN-JSP	●				.008
			VPET22YMFN-JSP	VPET1103008MFN-JSP	●	.250	.125	.110	.003
			VPET220MFN-JSP	VPET110301 MFN-JSP	●				.004
			VPET220.4MFN-JSP	VPET1103018MFN-JSP	●				.007
			*VPET220.5MFN-JSP	VPET110302 MFN-JSP	●				.008

Note: Chipbreaker Cross section is marked * next to the Cat. No.

● : Stocked items

Standard cutting conditions JPP / JRP / JSP types

Work material	chip- breaker	Grade	Cutting speed Vc (sfm)	Depth of cut ap (inch)	Feed: <i>f</i> (ipr)			
					<i>r</i> ε = .003"	<i>r</i> ε = .004"	<i>r</i> ε = .007"	<i>r</i> ε = .008"
Steels 1045, 4137 etc.	JPP JRP JSP	SH730	160 - 500	.004 - .020	.0004 - .0016	.0004 - .002	.0008 - .0036	.0008 - .004
Stainless steels 303, 304 etc.			100 - 500					
Titanium alloys (Ti-6AL-4v etc.)			100 - 330					

● : Stocked items

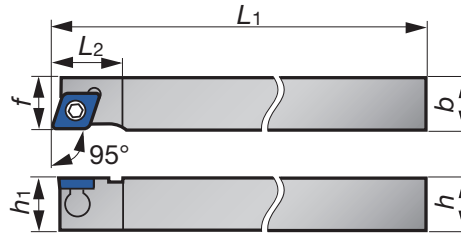
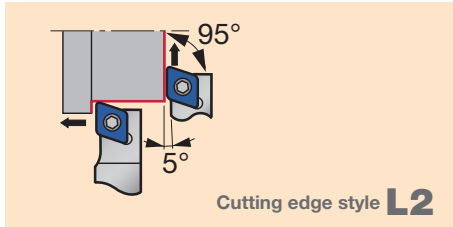
Toolholder

External turning / Positive rake

JTCL2C R/L Turning & facing

JT-type (Positive rake, back clamping system)

Without offset



Right hand (R) shown

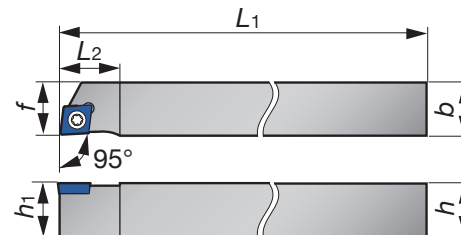
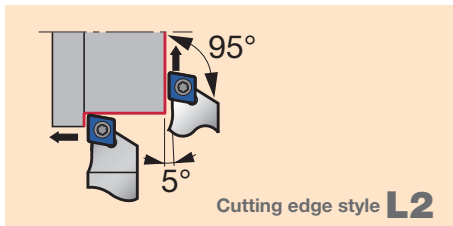
Metric

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

JSCL2C R/L Turning & facing

J-type (Positive rake, screw-on system)

Without offset



Right hand (R) shown

Inch

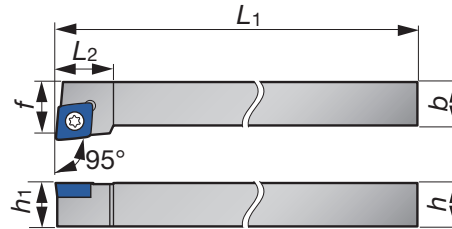
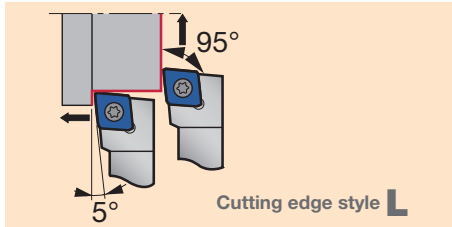
NEW

Cat. No.	Stock		Dimensions (in)						Standard corner radius r_E	Applicable inserts	Parts		Torque (N·m)
	R	L	h	b	L_1	L_2	h_1	f			Clamping screw	Wrench	
JSCL2CR/L062	●	●	0.375	0.375	5	0.4375	0.375	0.375	0.008	CC□□21.5	CSTB-2.5	T-8F	1.2
JSCL2CR/L082	●	●	0.500	0.500	5	0.4375	0.500	0.500					
JSCL2CR/L103	●	●	0.625	0.625	5	0.625	0.625	0.625	0.008	CC□□32.5	CSTB-4SD		

Metric

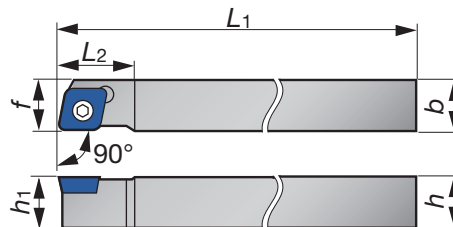
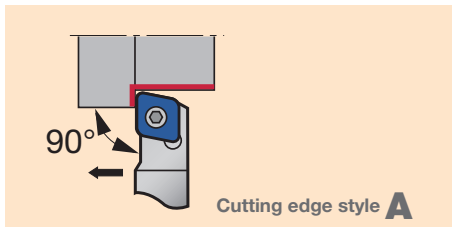
Cat. No.	Stock		Dimensions (mm)						Standard corner radius r_E	Applicable inserts	Parts		Torque (N·m)
	R	L	h	b	L_1	L_2	h_1	f			Clamping screw	Wrench	
JSCL2CR/L1010K06	●	●	10	10	125	12	10	10	0.4	CC□□0602	CSTB-2.5	T-8F	1.2
JSCL2CR/L1212K06	●	●	12	12	125	12	12	12	0.4				

● : Stocked items

JSCLC R/L**Turning & facing****J-type (Positive rake, screw-on system)**

Right hand (R) shown

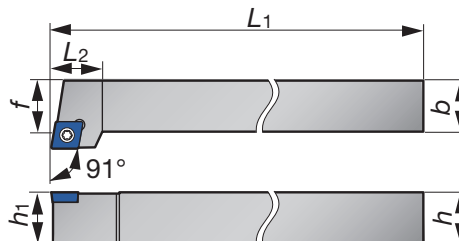
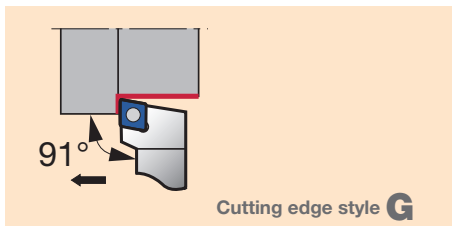
Cat. No.	Stock		Dimensions (mm)						Standard corner radius r_E	Applicable inserts	Parts		Torque (N·m)
	R	L	h	b	L_1	L_2	h_1	f			Clamping screw	Wrench	
JSCLCR/L0808H06	●	●	8	8	100	12	8	10	0.4	CC□□0602	CSTB-2.5	T-8F	1.2
JSCLCR/L1010H06	●	●	10	10	100	12	10	12	0.4				
JSCLCR/L1212H09	●	●	12	12	100	16	12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

JSCAC R/L**Turning****J-type (Positive rake, screw-on system)**

Without offset

Right hand (R) shown

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

JSCGC R/L**Turning****J-type (Positive rake, screw-on system)**

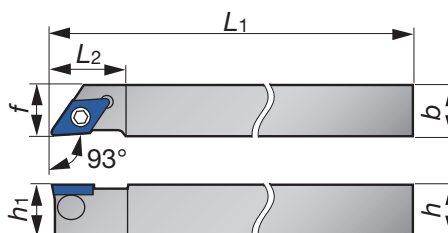
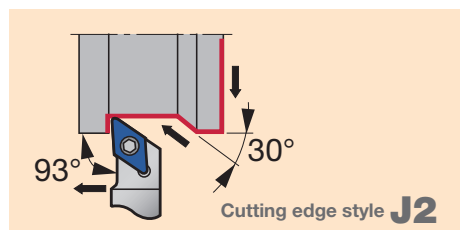
Right hand (R) shown

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

● : Stocked items

JTDJ2C R/L Turning & profiling

JT-type (Positive rake, back clamping system)



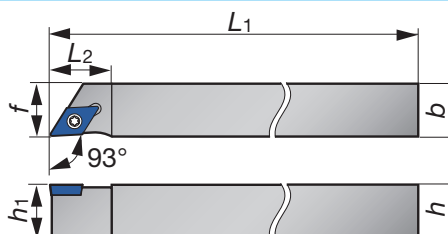
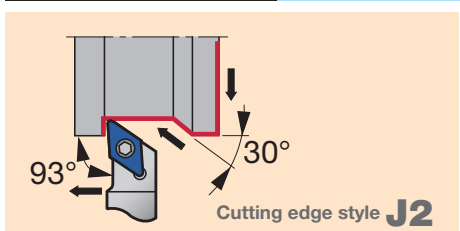
Without offset

Right hand (R) shown

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

JSDJ2C R/L Profiling

J-type (Positive rake, screw-on system)



Without offset

Right hand (R) shown

Inch

NEW

Cat. No.	Stock		Dimensions (in)						Standard corner radius r_E	Applicable inserts	Parts		Torque (N·m)
	R	L	h	b	L_1	L_2	h_1	f			Clamping screw	Wrench	
JSDJ2CR/L062	●	●	0.375	0.375	5	0.5625	0.375	0.375	0.008	DC□□21.5	CSTB-2.5	T-8F	1.2
JSDJ2CR/L082	●	●	0.500	0.500	5	0.5625	0.500	0.500		DC□□32.5			
JSDJ2CR/L103	●	●	0.625	0.625	5	0.8125	0.625	0.625		DC□□32.5			

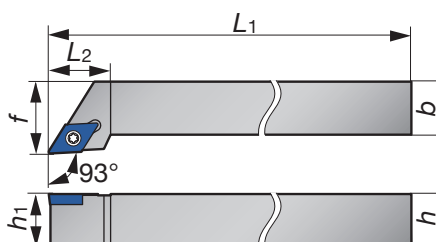
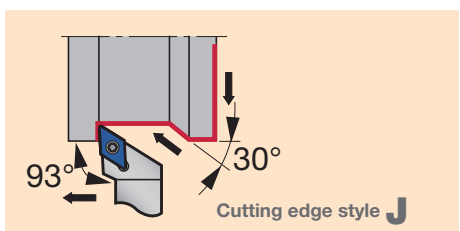
Metric

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

External turning / Positive rake

JSDJC R/L Profiling

J-type (Positive rake, screw-on system)



Right hand (R) shown

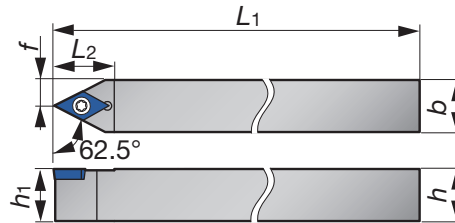
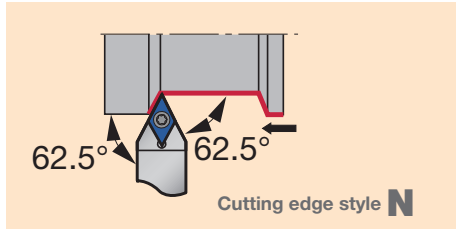
Cat. No.	Stock		Dimensions (mm)						Standard corner radius r_E	Applicable inserts	Parts		Torque (N·m)
	R	L	h	b	L_1	L_2	h_1	f			Clamping screw	Wrench	
JSDJCR/L0808H07	●	●	8	8	100	14	8	10	0.4	DC□□0702	CSTB-2.5	T-8F	1.2
JSDJCR/L1212H07	●	●	12	12	100	14	12	16	0.4				
JSDJCR/L1010H11	●	●	10	10	100	18	10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

● : Stocked items

JSDNC N

Profiling

J-type (Positive rake, screw-on system)



Without offset

Inch

NEW

Cat. No.	Stock	Dimensions (in)						Standard corner radius r_E	Applicable inserts	Parts		Torque (N-m)
		h	b	L_1	L_2	h_1	f			Clamping screw	Wrench	
JSDNCN062	●	0.375	0.375	5	0.5625	0.375	0.1875	0.008	DC□□21.5	CSTB-2.5	T-8F	1.2
JSDNCN082	●	0.500	0.500	5	0.5625	0.500	0.250		DC□□32.5	CSTB-4SD		
JSDNCN103	●	0.625	0.625	5	0.8125	0.625	0.3125		DC□□32.5	CSTB-4SD		

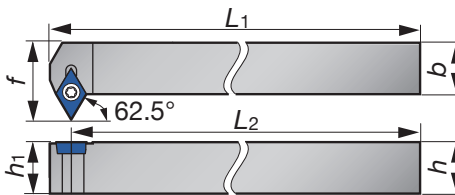
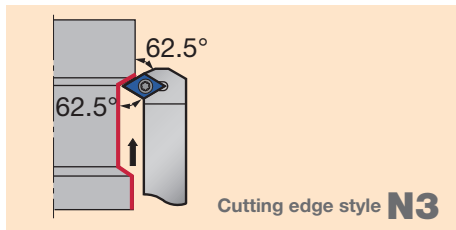
Metric

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

JSDN3C R/L

Profiling

J-type (Positive rake, screw-on system)



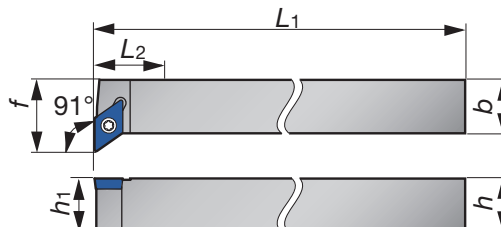
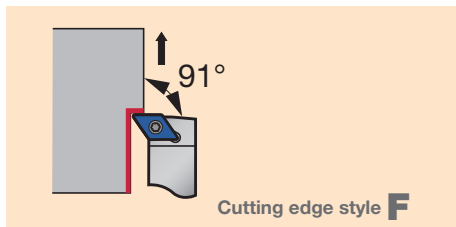
Right hand (R) shown

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

JSDFC R/L

Facing

J-type (Positive rake, screw-on system)



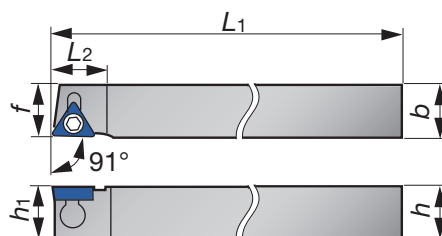
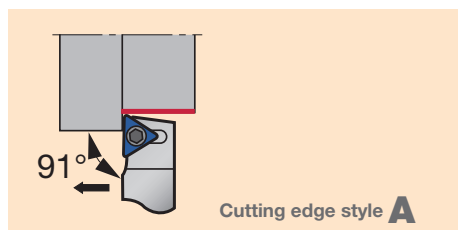
Right hand (R) shown

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

● : Stocked items

JTTAC R/L Turning

JT-type (Positive rake, back clamping system)



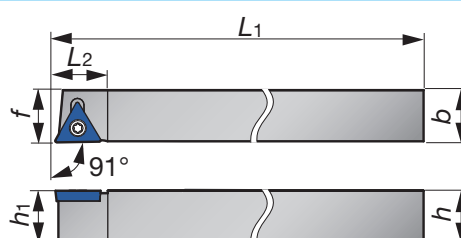
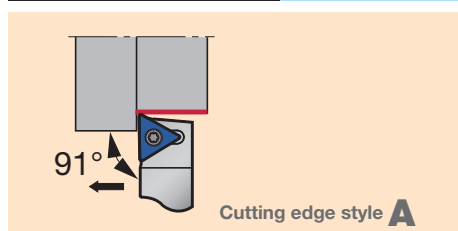
Without offset

Right hand (R) shown

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

JSTAC R/L Turning

J-type (Positive rake, screw-on system)



Without offset

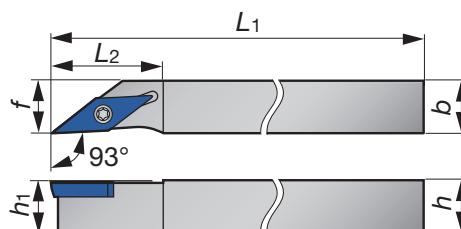
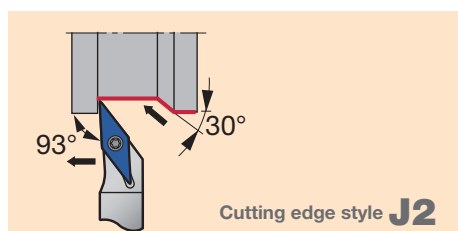
Right hand (R) shown

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

External turning / Positive rake

JSVJ2B R/L Profiling

J-type (Positive rake, screw-on system)



Without offset

Right hand (R) shown

Inch

NEW

Cat. No.	Stock		Dimensions (in)						Standard corner radius r_E	Applicable inserts	Parts		Torque (N·m)
	R	L	h	b	L ₁	L ₂	h ₁	f			Clamping screw	Wrench	
JSVJ2BR/L062	●	●	0.375	0.375	5	0.8125	0.375	0.375	0.008	VB□□22□	CSTB-2.5	T-8F	1.2
JSVJ2BR/L082	●	●	0.500	0.500	5	0.8125	0.500	0.500					
JSVJ2BR/L102	●	●	0.625	0.625	5	0.8125	0.625	0.625					

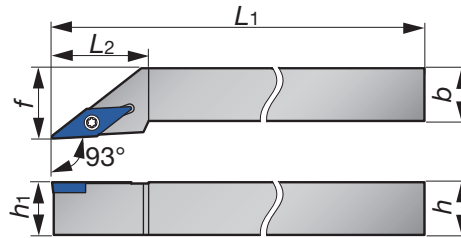
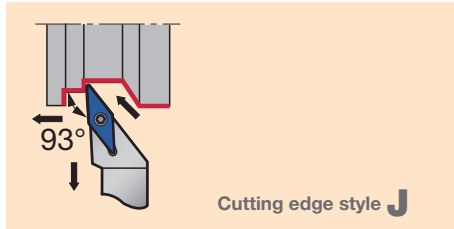
Metric

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

● : Stocked items

JSVJB R/L Profiling

J-type (Positive rake, screw-on system)

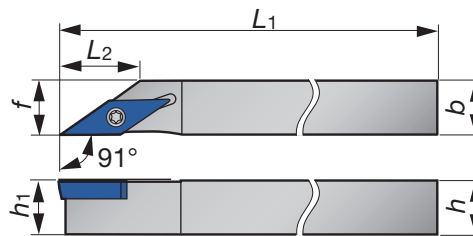
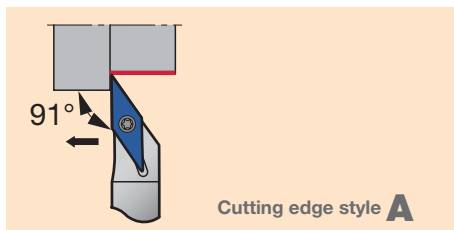


Right hand (R) shown

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

JSVAB R/L Turning

J-type (Positive rake, screw-on system)



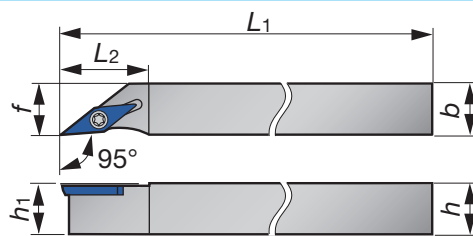
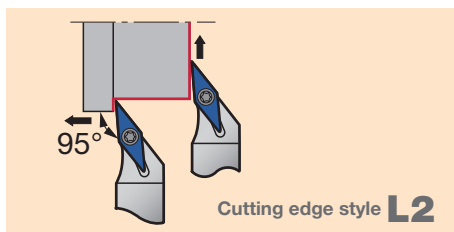
Without offset

Right hand (R) shown

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

JSVL2P R/L Turning & facing

J-type (Positive rake, screw-on system)



Without offset

Right hand (R) shown

Inch

NEW

Cat. No.	Stock		Dimensions (in)						Standard corner radius r_E	Applicable inserts	Parts		Torque (N·m)
	R	L	h	b	L_1	L_2	h_1	f			Clamping screw	Wrench	
JSVL2PR/L082	●	●	0.500	0.500	5	0.8125	0.500	0.500	0.008	VP□□22□	CSTB-2.5	T-8F	1.2
JSVL2PR/L102	●	●	0.625	0.625	5	0.8125	0.625	0.625					

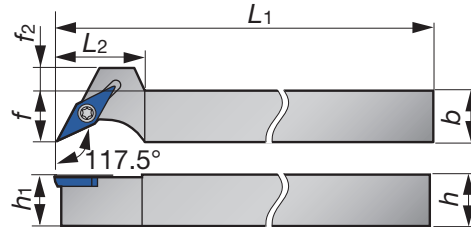
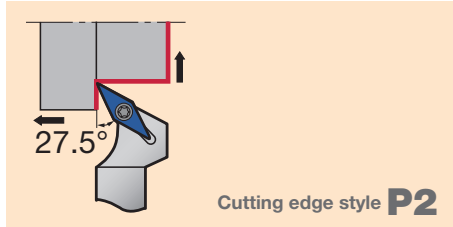
Metric

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

● : Stocked items

JSVP2P R/L Profiling

J-type (Positive rake, screw-on system)



Without offset

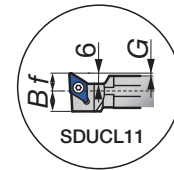
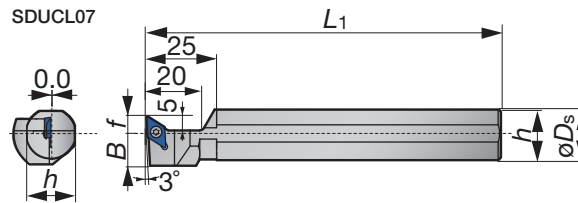
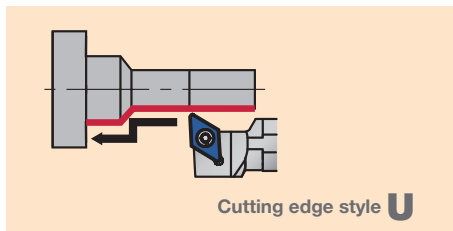
Right hand (R) shown

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

External turning / Positive rake / Round shank

JS-SDUC L Profiling

J-type (Positive rake, screw-on system)



Left hand (L) shown

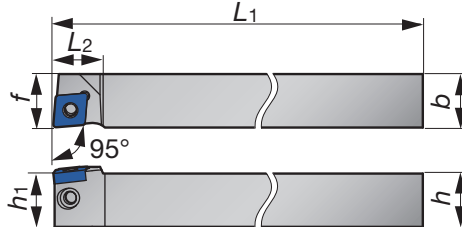
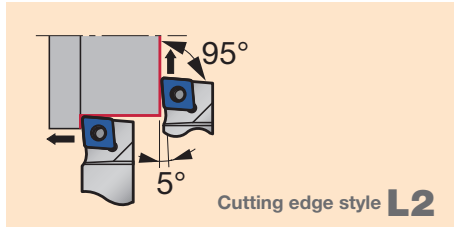
Cat. No.	Stock	Dimensions (mm)							Standard corner radius r_E	Applicable inserts	Parts		Torque (N·m)
		ϕD_s	f	L_1	L_2	h	B	G			Clamping screw	Wrench	
JS19K-SDUCL07	●	19.05	6	125	-	18	11.5	-	0.4	DC□□0702	CSTB-2.5	T-8F	1.2
JS20K-SDUCL07	●	20	6	125	-	19	11.5	-	0.4				
JS22K-SDUCL07	●	22	6	125	-	21	11.5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

● : Stocked items

External turning / Negative rake

JTCL2N R/L Turning & facing

JT-type (Negative rake, back clamping system)



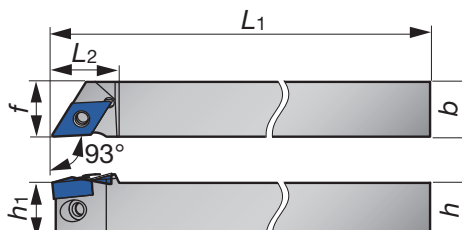
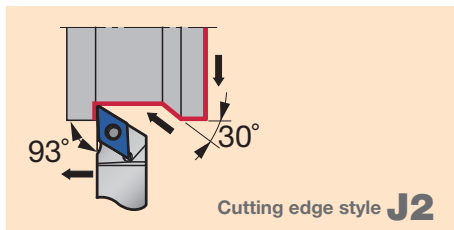
Without offset

Right hand (R) shown

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

JTDJ2N R/L Turning & profiling

JT-type (Negative rake, back clamping system)



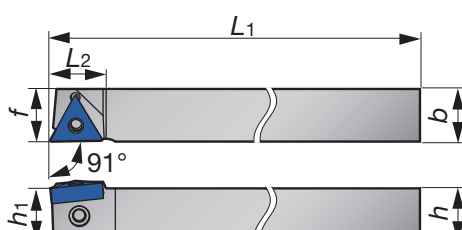
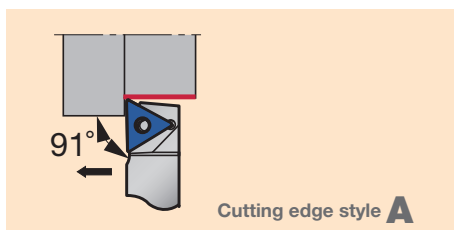
Without offset

Right hand (R) shown

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

JTTAN R/L Turning

JT-type (Negative rake, back clamping system)



Without offset

Right hand (R) shown

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

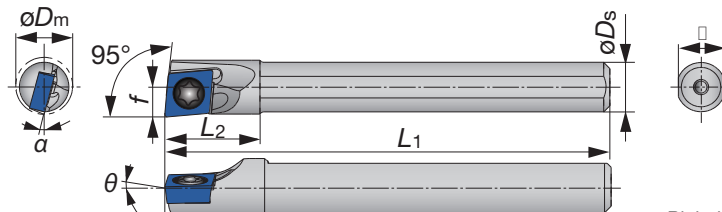
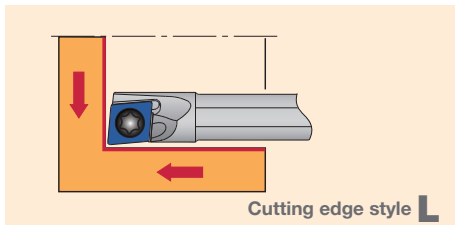
● : Stocked items

Internal turning / Positive rake

SCLCR/L

Boring & internal facing

S-type (Positive, screw-on)



Right hand (R) shown

Steel shank

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

Carbide shank

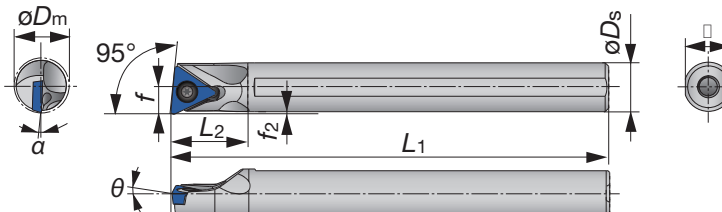
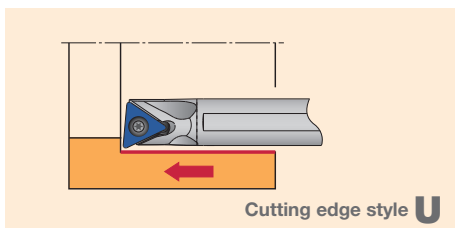
Toolholder Cat. No.	Stock		Min bore dia. ϕD_m	Dimensions (mm)								Std. corner radius r_E	Applicable inserts	Parts		Torque (N·m)
	R	L		ϕD_s	f	L_1	L_2	h	f_2	θ	α			Clamping screw	Wrench	
E04G-SCLCR/L03-D050	●	●	5	4	2.5	90	9	3.8	-	0°	-15°	0.2	CC□□03X1	CSTA-1.6	T-6F	0.6
E05G-SCLCR/L03-D060	●	●	6	5	3	90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

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

STUPR/L

Boring

S-type (Positive, screw-on)



Right hand (R) shown

Steel shank

Toolholder Cat. No.	Stock		Min bore dia. ϕD_m	Dimensions (mm)								Std. corner radius r_E	Applicable inserts	Parts		Torque (N·m)
	R	L		ϕD_s	f	L_1	L_2	h	f_2	θ	α			Clamping screw	Wrench	
A07G-STUPR/L07-D080	●	●	8	7	4	90	12	6.75	0.4	+5°	-10°	0.4	TP□□0701	CSTB-2.2L038	T-7F	0.9

Carbide shank

Toolholder Cat. No.	Stock		Min bore dia. ϕD_m	Dimensions (mm)								Std. corner radius r_E	Applicable inserts	Parts		Torque (N·m)
	R	L		ϕD_s	f	L_1	L_2	h	f_2	θ	α			Clamping screw	Wrench	
E07H-STUPR/L07-D080	●	●	8	7	4	100	14	6.75	0.3	+5°	-10°	0.4	TP□□0701	CSTB-2.2L038	T-7F	0.9

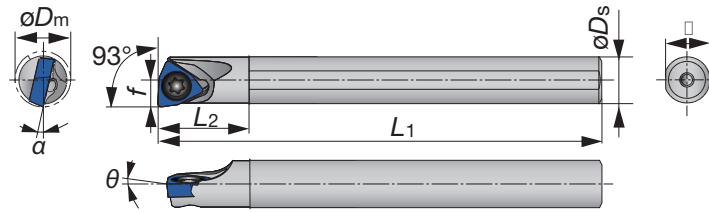
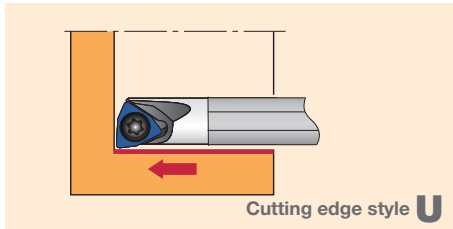
When using a right or left hand insert, the right hand insert (R) is used for the left hand toolholder (STUPL □□ type), and the left hand insert (L) is used for the right hand toolholder (STUPR □□ type).

● : Stocked in Japan

SWUBR/L

Boring

S-type (Positive, screw-on)



Right hand (R) shown

Steel shank

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

Carbide shank

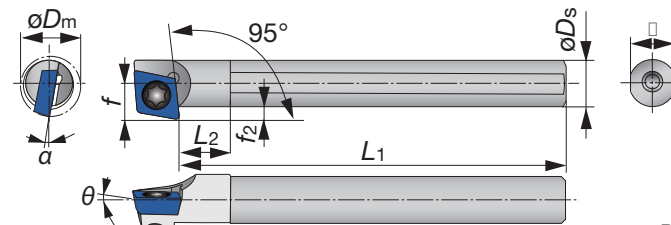
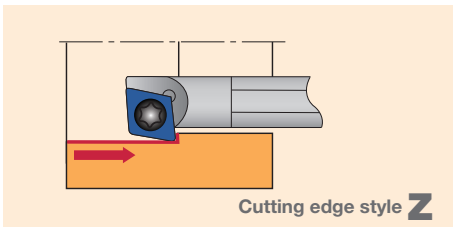
Toolholder Cat. No.	Stock		Min bore.dia. øDm	Dimensions (mm)							Std. corner radius rE	Applicable inserts	Parts		Torque (N·m)	
	R	L		øDs	f	L1	L2	h	f2	θ			α	Clamping screw		Wrench
E05G-SWUBR/L03-D060	●	●	6	5	3	90	10	4.8	-	0°	-13°	0.4	WB□□0301	CSTB-2	T-6F	0.6
E06H-SWUBR/L03-D070	●	●	7	6	3.5	100	12	5.75			-12°					
E07H-SWUBR/L03-D080	●	●	8	7	4	100	14	6.75			-11°					

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

SEZPR/L

Internal retracting

S-type (Positive, screw-on)



Right hand (R) shown

Steel shank

Toolholder Cat. No.	Stock		Min bore.dia. øDm	Dimensions (mm)							Std. corner radius rE	Applicable inserts	Parts		Torque (N·m)	
	R	L		øDs	f	L1	L2	h	f2	θ			α	Clamping screw		Wrench
A04F-SEZPR/L03-D055	●	●	5.5	4	3.2	80	4	3.8	1.2	0°	-8°	0.2	EP□□03X1	CSTA-1.6	T-6F	0.6
A05F-SEZPR/L03-D065	●	●	6.5	5	3.7	80	5	4.8			-6°					

Carbide shank

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

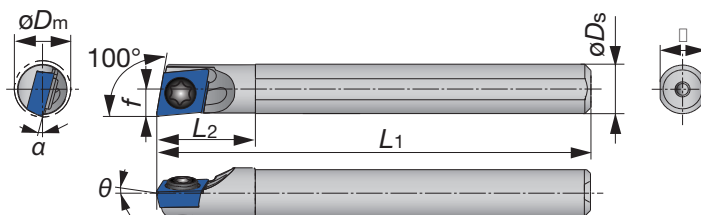
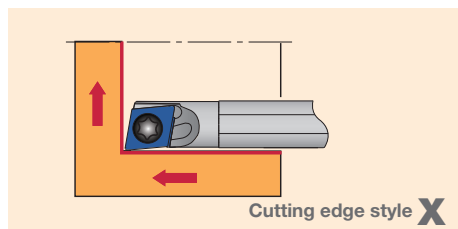
When using a right or left hand insert, the right hand insert (R) is used for the right hand toolholder (SEZPR □□ type), and the left hand insert (L) is used for the left hand toolholder (SEZPL □□ type).

● : Stocked in Japan

SEXPR/L

Boring & internal facing

S-type (Positive, screw-on)



Right hand (R) shown

Steel shank

Toolholder Cat. No.	Stock		Min bore dia. ϕD_m	Dimensions (mm)								Std. corner radius r_E	Applicable inserts	Parts		Torque (N·m)
	R	L		ϕD_s	f	L_1	L_2	h	f_2	θ	α			Clamping screw	Wrench	
A04F-SEXPR/L03-D045	●	●	4.5	4	2.3	80	8	3.8	-	0°	-15°	0.2	EP□□03X1	CSTA-1.6	T-6F	0.6
A04F-SEXPR/L03-D050	●	●	5	4	2.5	80	8	3.8	-	0°	-13°	0.2	EP□□03X1	CSTA-1.6	T-6F	0.6
A05F-SEXPR/L04-D055	●	●	5.5	5	2.75	80	9	4.8	-	0°	-12°	0.4	EP□□0401	CSTB-2	T-6F	0.6
A06G-SEXPR/L04-D070	●	●	7	6	3.6	90	11	5.75	-	0°	-12°	0.4	EP□□0401	CSTB-2	T-6F	0.6

Carbide shank

Toolholder Cat. No.	Stock		Min bore dia. ϕD_m	Dimensions (mm)								Std. corner radius r_E	Applicable inserts	Parts		Torque (N·m)
	R	L		ϕD_s	f	L_1	L_2	h	f_2	θ	α			Clamping screw	Wrench	
E04G-SEXPR/L03-D045	●	●	4.5	4	2.3	90	9	3.8	-	0°	-15°	0.2	EP□□03X1	CSTA-1.6	T-6F	0.6
E04G-SEXPR/L03-D050	●	●	5	4	2.5	90	9	3.8	-	0°	-13°	0.2	EP□□03X1	CSTA-1.6	T-6F	0.6
E05G-SEXPR/L04-D055	●	●	5.5	5	2.75	90	10	4.8	-	0°	-12°	0.4	EP□□0401	CSTB-2	T-6F	0.6
E06H-SEXPR/L04-D070	●	●	7	6	3.6	100	12	5.75	-	0°	-12°	0.4	EP□□0401	CSTB-2	T-6F	0.6

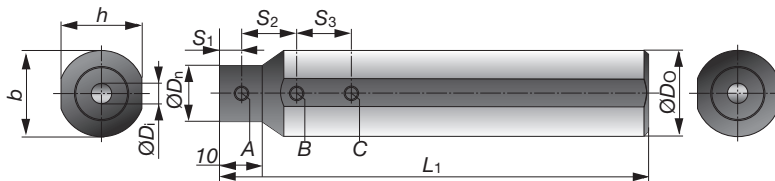
When using a right or left hand insert, the right hand insert (R) is used for the left hand toolholder (SEXPL □□ type), and the left hand insert (L) is used for the right hand toolholder (SEXPR □□ type).

● : Stocked in Japan

Sleeves

BLM type

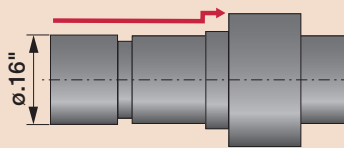
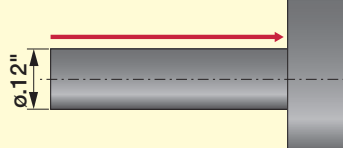
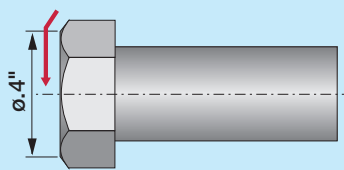
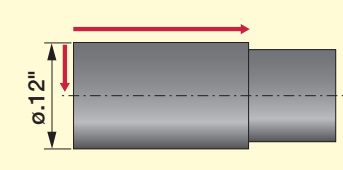
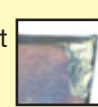
(Round shank for Stream Jet Bar MINI)

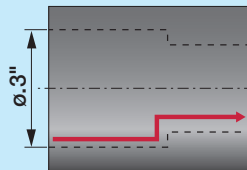
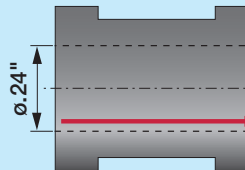


Cat. No.	Stock	Dimensions (mm)									Pièces détachées				
		ϕD_0	ϕD_1	ϕD_n	L_1	h	b	S_1	S_2	S_3	Clamping screws			Wrench	Seal cap (Inner screw)
BLM159-04	●	15.875 (.625")	4	15	100	15	15.875	5	15	15	SSHM4-4	SSHM4-4	SSHM4-4	P-2	CA-16 (M6)
BLM159-05	●		5						20	20					
BLM159-06	●		6						20	20					
BLM159-07	●		7						20	20					
BLM16-04	●	16	4	15	100	15	16	5	15	15	SSHM4-4	SSHM4-4	SSHM4-4	P-2	CA-16 (M6)
BLM16-05	●		5						20	20					
BLM16-06	●		6						20	20					
BLM16-07	●		7						20	20					
BLM19-04	●	19.05 (.750")	4	18	100	18	19.05	5	15	15	SSHM4-4	SSHM4-6	SSHM4-6	P-2	CA-16 (M6)
BLM19-05	●		5						20	20		SSHM4-4	SSHM4-4		
BLM19-06	●		6						20	20		SSHM4-4	SSHM4-4		
BLM19-07	●		7						20	20		SSHM4-4	SSHM4-4		
BLM20-04	●	20	4	13	100	19	20	5	15	15	SSHM4-4	SSHM4-6	SSHM4-6	P-2	CA-16 (M6)
BLM20-05	●		5						20	20		SSHM4-4	SSHM4-4		
BLM20-06	●		6						20	20		SSHM4-4	SSHM4-4		
BLM20-07	●		7						20	20		SSHM4-4	SSHM4-4		
BLM22-04	●	22	4	13	125	21	22	5	15	15	SSHM4-4	SSHM4-6	SSHM4-6	P-2	CA-16 (M6)
BLM22-05	●		5						20	20		SSHM4-4	SSHM4-4		
BLM22-06	●		6						20	20		SSHM4-4	SSHM4-4		
BLM22-07	●		7						20	20		SSHM4-4	SSHM4-4		
BLM25-04	●	25	4	13	125	24	25	5	15	15	SSHM4-4	SSHM4-8	SSHM4-8	P-2	CA-16 (M6)
BLM25-05	●		5						20	20		SSHM4-6	SSHM4-6		
BLM25-06	●		6						20	20		SSHM4-4	SSHM4-4		
BLM25-07	●		7						20	20		SSHM4-4	SSHM4-4		
BLM254-04	●	25.4 (1.000")	4	13	125	24	25.4	5	15	15	SSHM4-4	SSHM4-8	SSHM4-8	P-2	CA-16 (M6)
BLM254-05	●		5						20	20		SSHM4-6	SSHM4-6		
BLM254-06	●		6						20	20		SSHM4-4	SSHM4-4		
BLM254-07	●		7						20	20		SSHM4-4	SSHM4-4		

*Seal cap (optional)

Practical examples

Workpiece type		Medical parts	Machine component
Toolholder		JTDJ2CR1010K07	JTDJ2CR1212M11
Insert		DCGT21.50FN-JS	DCGT32.50FN-JS
Grade		SH730	SH730
Work material		Titanium alloy / Ti-6Al-4V	Stainless steel / AISI 304
			
Cutting conditions	Cutting speed: Vc (sfm)	100	70
	Feed: f (ipr)	.008	.001
	Depth of cut: ap (in)	.030	.010
	Method of machining	External turning	External turning
	Coolant	Oil	Oil
	Machine	CNC lathes	CNC lathes
Results		Number of parts/corner 25% tool life improvement! JS type (SH730)  200 pcs. Current insert  150 pcs. - Excellent surface finish and chip control.	Tool failure after machining Current insert  200 pcs / corner  150 ~ 200 pcs / corner - Stable tool life! - Excellent chipping and wear resistance
Workpiece type		Automotive component	Electrical Components
Toolholder		JTDJ2CR1212M11	JSDJ2CR1212K07
Insert		DCGT32.50.5N-JS	DCET21.50MFR-JRP
Grade		AH725	SH730
Work material		Alloy steels	Stainless steel AISI 420
			
Cutting conditions	Cutting speed: Vc (sfm)	330	130 ~ 200
	Feed: f (ipr)	.004	.0004
	Depth of cut: ap (in)	.012	.002
	Method of machining	Facing	External turning and facing
	Coolant	Oil	Oil
	Machine	CNC lathes	CNC lathes
Results		Tool failure after machining 1000 pcs / corner JS type (AH725)  Current insert  Chip shapes of JS  - Excellent chip control - Good wear resistance	Number of parts/corner 100% tool life improvement! JRP type (SH730)  4000 pcs. Current insert  2000 pcs. - Improved wear resistance - Reduced down-time

Workpiece type		Micro bearing	Machine component
Toolholder		A05F-SWUBR03-D060	A04F-SEXPR03-D050
Insert		WBG520.5L-JS	EPGT4.51.80.5-JS
Grade		SH730	SH730
Work material		Carbon steel (JIS S45C)	Alloy Steel (JIS SCM435)
			
Cutting conditions	Cutting speed: V_c (sfm)	100	200
	Feed: f (ipr)	.002	.001
	Depth of cut: a_p (in)	.012	.008
	Method of machining	Internal turning (continuous)	Internal turning (continuous)
	Coolant	Water soluble	Water soluble
Machine		CNC lathes	CNC lathes
Results		■ Number of work piece 100% tool life improvement! JS type  1,000 pcs. competitor  500 pcs. - Tool life and chip control were improved drastically.	■ Number of pieces 130% tool life improvement! JS type  230 pcs. competitor  100 pcs. - Chip control and surface finish were improved.



Tungaloy America, Inc.

3726 N Ventura Drive, Arlington Heights, IL 60004, U.S.A.
Phone: +1-888-554-8394 Fax: +1-888-554-8392

Tungaloy Canada

432 Elgin St. Unit 3, Brantford, Ontario N3S 7P7, Canada
Phone: +1-519-758-5779 Fax: +1-519-758-5791

Tungaloy de Mexico S.A.

C Los Arellano 113, Parque Industrial Siglo XXI
Aguascalientes, AGS, Mexico 20290
Phone: +52-449-929-5410 Fax: +52-449-929-5411

www.tungaloyamerica.com



Scan for instant
web access



Distributed by: