

External turning tool

ISO E^{CO}TURN

Tungaloy Report No. 426S4-US

Economical internal coolant toolholder for external turning with CNMG33... (CNMG0904...) inserts

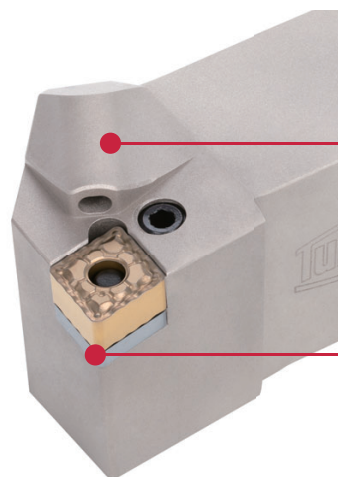




Cost-efficient toolholder design for effective chip control and maximum tool life

Through-coolant toolholder for external turning with integrated coolant hole

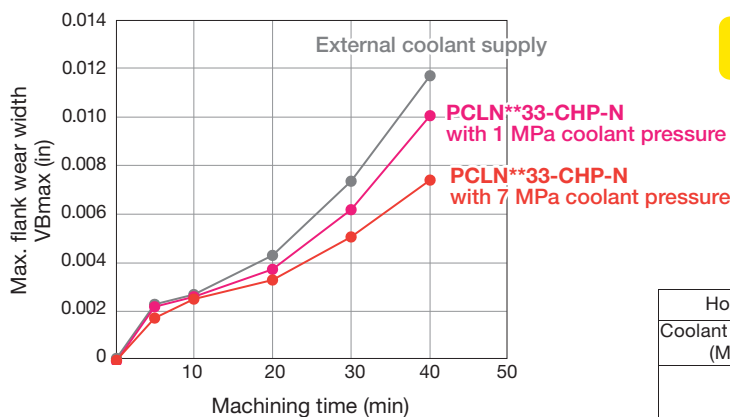
- Improved chip control and tool life thanks to direct coolant delivery to the cutting point
- Applicable for high-pressure coolant
- Streamlined holder design provides both cost efficiency and high performance
- Dedicated for ISO-EcoTurn inserts for additional economical advantage
- ISO-EcoTurn CNMG33... (CNMG0904...) insert provides identical cutting performance as regular size CNMG43... (CNMG1204...) insert, only smaller



Coolant outlet with streamlined design
(Applicable for high pressure coolant)

Dedicated for ISO-EcoTurn
CNMG33... (CNMG0904...) inserts

■ Comparison of tool life with external coolant holder



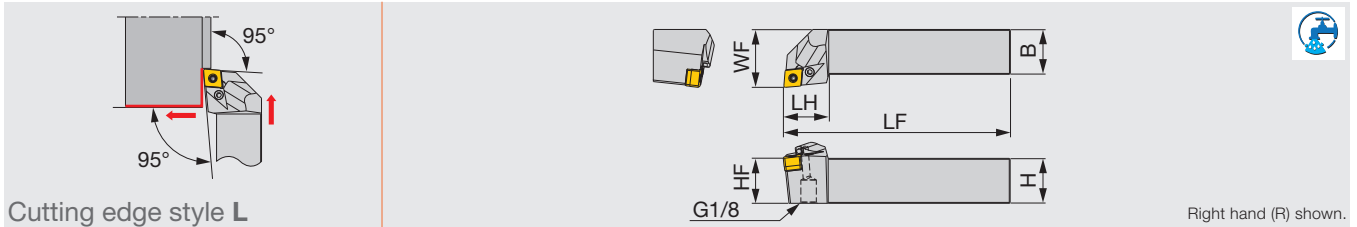
New holder : **PCLNL1633-CHP-N**
 Conventional : PCLNL1633
 Insert : CNMG 332E SM T6120
 Workpiece material : 304SS
 Cutting speed : $V_c = 591$ sfm
 Feed : $f = 0.010$ ipr
 Depth of cut : $a_p = 0.059$ "
 Coolant pressure : 1/7 MPa

New PCLN33-CHP-N holder provided better chip control and long tool life over holder with external coolant supply**

Holder	New internal coolant supply		External coolant supply
Coolant pressure (MPa)	1	7	1
Chipbreaker			

PCLNR/L-Eco

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



Right hand (R) shown.

Inch	H	B	LF	LH	HF	WF	RE**	Air hole	Insert	Torque
PCLNR/L1233-CHP-N	0.750	0.750	4.000	1.300	0.750	1.250	0.031	With	CNMG33*E...	1.48
PCLNR/L1633-CHP-N	1.000	1.000	5.000	1.300	1.000	1.250	0.031	With	CNMG33*E...	1.48
Metric	H	B	LF	LH	HF	WF	RE**	Air hole	Insert	Torque*
PCLNR/L2020H0904-CHP-N	20	20	100	25	20	25	0.8	With	CNMG0904**E...	2
PCLNR/L2525K0904-CHP-N	25	25	125	25	25	32	0.8	With	CNMG0904**E...	2

Torque: Recommended clamping torque: lbs-ft (**N-m)

**RE: The holder measurements are true with this insert radius

Applicable for 14 MPa pressure coolant

SPARE PARTS

Designation	Shim	Clamping screw	Wrench	Spring pin	Lever
PCLNR/L**33-CHP-N	LSC317	LCS3	P-2.5	LSP3	LCL33
PCLNR/L**0904-CHP-N					

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Jan. 2022 (TJ)