

External turning tool

ISO E^{CO}TURN

Tungaloy Report No. 426S4-G

Economical internal coolant toolholder for external turning with CNMG0904... inserts

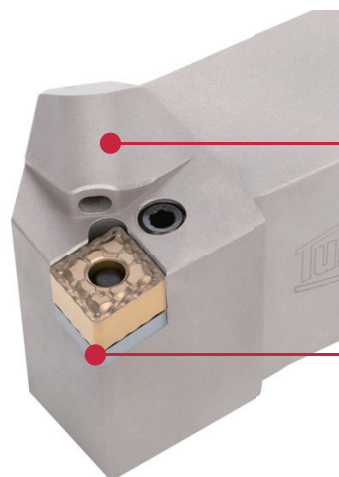




Cost-efficient toolholder design for effective chip control and maximum tool life

Through-coolant toolholder for external turning with integrated coolant hole

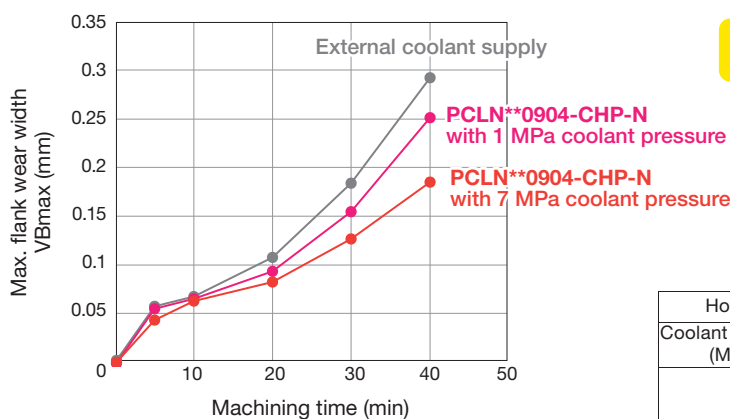
- Improved chip control and tool life thanks to direct coolant delivery to the cutting point
- Applicable for high-pressure coolant
- Streamlined holder design provides both cost efficiency and high performance
- Dedicated for ISO-EcoTurn inserts for additional economical advantage
- ISO-EcoTurn CNMG0904...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



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

Dedicated for ISO-EcoTurn CNMG0904... inserts

■ Comparison of tool life with external coolant holder



New holder : PCLNL2525K0904-CHP-N

Conventional : PCLNL2525M0904

Insert : CNMG090408E-SM T6120

Workpiece material : SUS304 / X5CrNi18-9

Cutting speed : $V_c = 180$ m/min

Feed : $f = 0.25$ mm/rev

Depth of cut : $a_p = 1.5$ mm

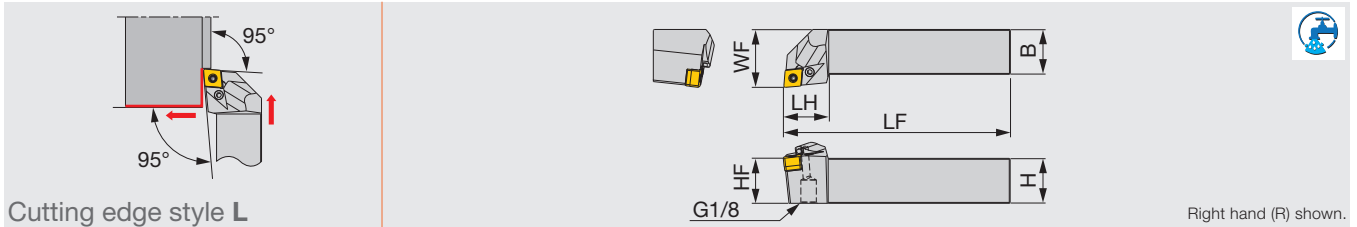
Coolant pressure : 1/7 MPa

New PCLN0904-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.

Designation	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 torque (N-m) for clamping

**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**0904-CHP-N	LSC317	LCS3	P-2.5	LSP3	LCL33

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