Member IMC Group Tungaloy

TurnLine

For more information

Toolholders for high pressure coolant supply

TUNGTURN TJET

Tungaloy Report No. 432-G

Expansion of new double clamp tool holders with coolant through capability!

TUNGALOY ADDFORCE ACCELERATED LINES

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ACCELERATED TURNING & THREADING

TUNGTURN JET

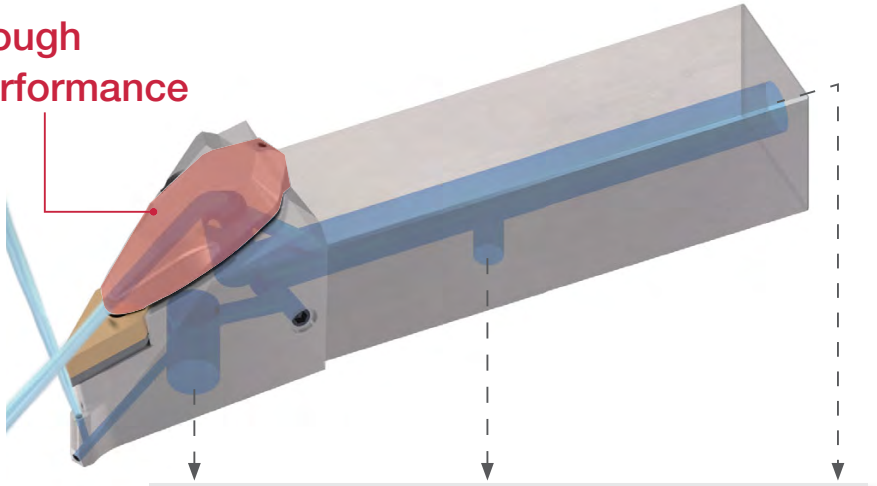
Wider lineup enables improvements across all applications

New double clamp coolant through tool holders for V/YN**1604**, TN**1604**inserts

High rigidity double clamp coolant through tool holders

Tool holders	New	New			
Insert	V/YN***1604** P.11	TN***1604** P.10	CN**1204** P.7	WN**0804** P.8	DN**1504/06** P.9

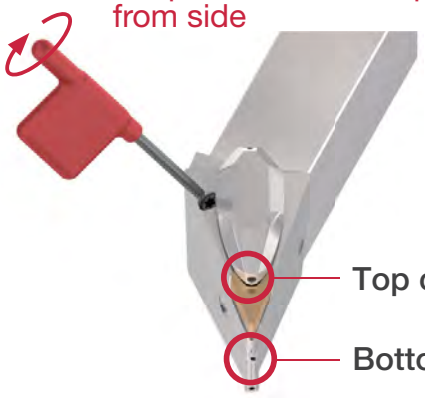
New Optimized coolant through channel maximizes performance



Applicable: Tube or Direct connection

*Detail page 6

Simple & stable clamping from side



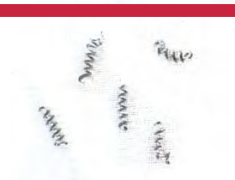
Improved chip control with internal coolant

S **Heat-resistant alloys (Inconel 718)**

Insert : VNMG160408-HRM AH8015
Cutting speed : *Vc* = 60 m/min
Feed : *f* = 0.1 mm/rev
Depth of cut : *ap* = 1 mm

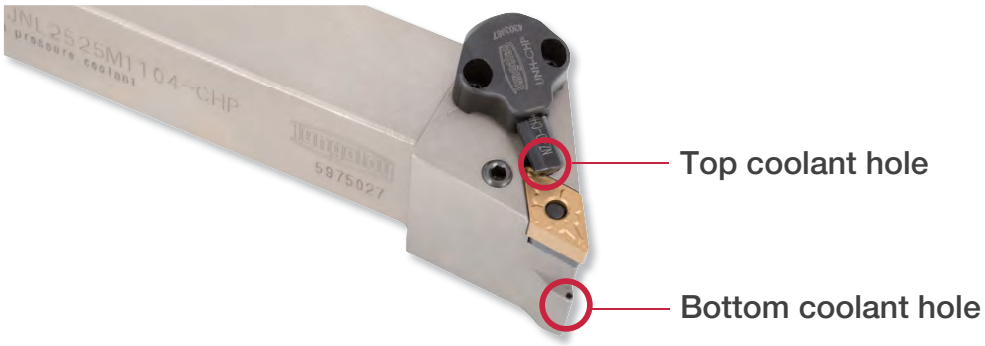
M **Stainless steel (SUS304 / X5CrNi18-9)**

Insert : VNMG160408-SM AH6225
Cutting speed : *Vc* = 180 m/min
Feed : *f* = 0.2 mm/rev
Depth of cut : *ap* = 1 mm

TUNGTURNJET 14 MPa	TUNGTURNJET 7 MPa	External coolant (Normal pressure 1 MPa)
		

Lever lock clamp (Nozzle style) turning tool holders

Tool holders					
Insert	V/YN***1604** P.11	TN***1604** P.10	CN**1204** P.7	WN**0804** P.8	DN**1504** P.9



Supplying coolant closer to the cutting edge provides effective internal cooling

■ Improved chip control with high pressure coolant

S **Heat-resistant alloys (Inconel 718)**

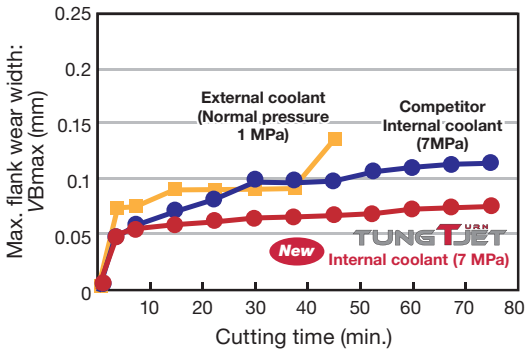
Insert : CNMG120408-HRM AH8005
Cutting speed : *Vc* = 60 m/min
Feed : *f* = 0.1 mm/rev
Depth of cut : *ap* = 1 mm

TUNGTJET 14 MPa	TUNGTJET 7 MPa	External coolant (Normal pressure 1MPa)

Drastically improved tool life with internal coolant

M Stainless steel (SUS304 / X5CrNi18-9)

Workpiece material : SUS304 / X5CrNi18-9
Toolholder : AVJNR2525X16-CHP
Insert : VNMG160408-SM AH6225
Cutting speed : *Vc* = 180 m/min
Feed rate : *f* = 0.2 mm/rev
Depth of cut : *a*p = 1 mm



After machining for 45 min.

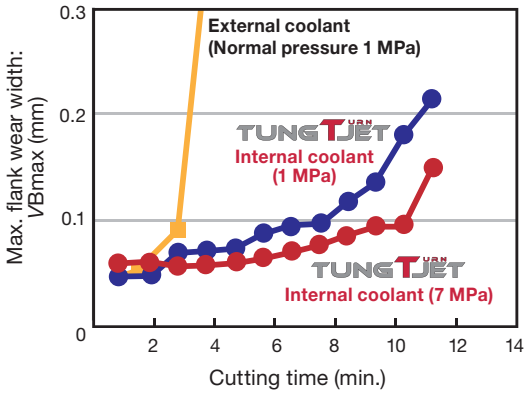
New TUNGTJET Internal coolant (7 MPa)

Competitor Internal coolant (7 MPa)

External coolant (Normal pressure 1 MPa)

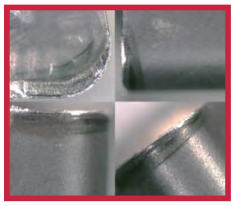
S Heat-resistant alloys (Inconel 718)

Workpiece material : Inconel 718
Toolholder : ACLNL2525X-12-CHP-MC
Insert : CNMG120408-HRM AH8005
Cutting speed : *Vc* = 60 m/min
Feed : *f* = 0.15 mm/rev
Depth of cut : *a*p = 2 mm

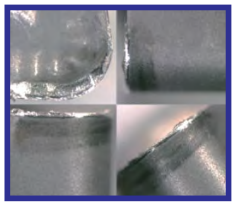


After machining for 4 min.

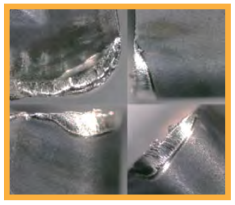
TUNGTJET Internal coolant (7 MPa)



TUNGTJET Internal coolant (1 MPa)



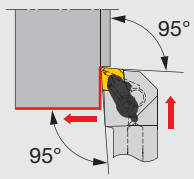
External coolant (Normal pressure 1 MPa)



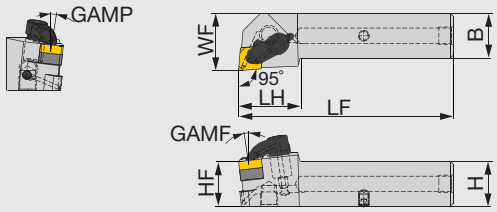
ACLNR/L-CHP-MC

Direct connection | Tube connection

Double clamping tool holders-95°approach angle
For negative 80°/70° rhombic insert. High-pressure coolant capability with tube and direct connections



Cutting edge style **L**



Right hand (R) shown.

Designation	H	B	LF	LH	HF	WF	GAMP	GAMF	Insert	Torque*
ACLNR/L2020X-12-CHP-MC	20	20	105	35	20	25	6°	6°	CN**/GNGA1204...	4
ACLNR/L2525X-12-CHP-MC	25	25	120	35	25	32	6°	6°	CN**/GNGA1204...	4

*Torque: Recommended torque (N·m) for clamping
Applicable for 14 MPa pressure coolant

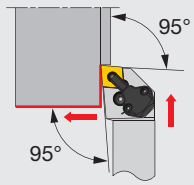
SPARE PARTS

Designation	Clamp set	Shim	Shim screw	screw for tube connection	Coolant plug	O-ring	Wrench 1
ACLNL**X-12-CHP-MC	LCGL-4JC SET	RCT443	SR14-506	PLUGG1/8-6.5TL360	SRM5X5 DIN913TL360	OR 4X3 NBR70	KEYV-T20
ACLNR**X-12-CHP-MC	LCGR-4JC SET	RCT443	SR14-506	PLUGG1/8-6.5TL360	SRM5X5 DIN913TL360	OR 4X3 NBR70	KEYV-T20

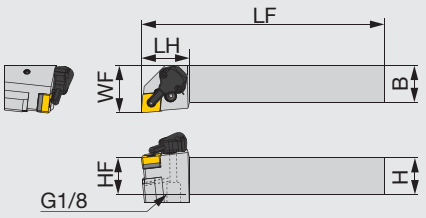
PCLNR/L-CHP

Tube connection

Lever lock toolholders – 95° approach angle.
For negative 80°/70° rhombic insert. High-pressure coolant capability.



Cutting edge style **L**



Right hand (R) shown.

Designation	H	B	LF	LH	HF	WF	RE**	Insert	Torque*
PCLNR/L2020K0904-CHP	20	20	125	33	20	32	0.8	CN**/GNMG0904...	2
PCLNR/L2020K12-CHP	20	20	125	33	20	32	0.8	CN**/GNGA1204...	3
PCLNR/L2525M0904-CHP	25	25	150	33	25	32	0.8	CN**/GNMG0904...	2
PCLNR/L2525M12-CHP	25	25	150	33	25	32	0.8	CN**/GNGA1204...	3

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

SPARE PARTS

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

SPARE PARTS

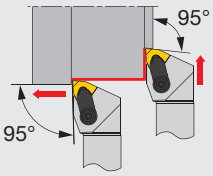
Designation	Coolant unit	Mounting screw	Wrench 2	O-ring	Coolant screw	Wrench 3
PCLNR/L**0904-CHP	CU-CW-CHP	SR M3	T-8F	OR 6.4X0.9N	SR M4X4 DIN913 TL360	P-2
PCLNR/L**12-CHP	CU-CW-CHP	SR M3	T-8F	OR 6.4X0.9N	SR M4X4 DIN913 TL360	P-2

For hose connection to the tool holder, refer to page 13

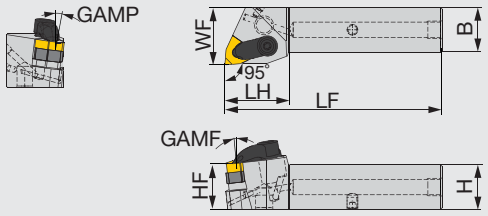
AWLNR/L-CHP-MC

Direct connection | Tube connection

Double clamping tool holders-95°approach angle
For negative 80°trigon insert. High-pressure coolant capability with tube and direct connections



Cutting edge style **L**



Right hand (R) shown.

Designation	H	B	LF	LH	HF	WF	GAMP	GAMF	Insert	Torque*
AWLNR/L2020X-08-CHP-MC	20	20	106	36	20	25	6°	6°	WN**0804...	4
AWLNR/L2525X-08-CHP-MC	25	25	121	36	25	32	6°	6°	WN**0804...	4

*Torque: Recommended torque (N·m) for clamping
Applicable for 14 MPa pressure coolant

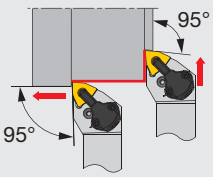
SPARE PARTS

Designation	Clamp set	Shim	Shim screw	screw for tube connection	Coolant plug	O-ring	Wrench 1
AWLNL**X-08-CHP-MC	LCGL-4JC SET	RWT443	SR14-506	PLUGG1/8-6.5TL360	SRM5X5 DIN913TL360	OR 4X3 NBR70	KEYV-T20
AWLNR**X-08-CHP-MC	LCGR-4JC SET	RWT443	SR14-506	PLUGG1/8-6.5TL360	SRM5X5 DIN913TL360	OR 4X3 NBR70	KEYV-T20

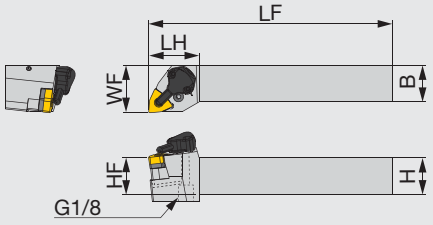
PWLNR/L-CHP

Tube connection

Lever lock toolholders – 95° approach angle.
For negative 80° trigon insert. High-pressure coolant capability.



Cutting edge style **L**



Right hand (R) shown.

Designation	H	B	LF	LH	HF	WF	RE**	Insert	Torque*
PWLNR/L2020K0604-CHP	20	20	125	34	20	32	0.8	WN**0604...	2
PWLNR/L2020K08-CHP	20	20	125	34	20	32	0.8	WN**0804...	3
PWLNR/L2525M0604-CHP	25	25	150	34	25	32	0.8	WN**0604...	2
PWLNR/L2525M08-CHP	25	25	150	34	25	32	0.8	WN**0804...	3

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

SPARE PARTS

Designation	Shim	Clamping screw	Wrench 1	Spring pin	Lever
PWLNR/L**0604-CHP	LSW312	LCS3	P-2.5	LSP3	LCL3
PWLNR/L**08-CHP	LSW42	LCS4	P-2.5	LSP4	LCL4

SPARE PARTS

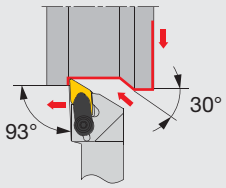
Designation	Coolant unit	Mounting screw	Wrench 2	O-ring	Coolant screw	Wrench 3
PWLNR/L**0604-CHP	CU-CW-CHP	SR M3	T-8F	OR 6.4X0.9N	SR M4X4 DIN913 TL360	P-2
PWLNR/L**08-CHP	CU-CW-CHP	SR M3	T-8F	OR 6.4X0.9N	SR M4X4 DIN913 TL360	P-2

For hose connection to the tool holder, refer to page 13

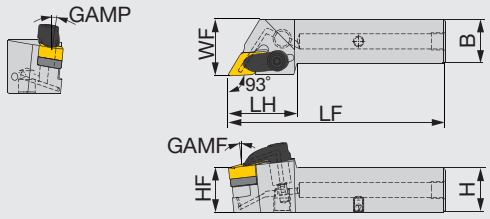
ADJNR/L-CHP-MC

Direct connection | Tube connection

Double clamping tool holders-93°approach angle
For negative 55°/45°rhombic insert. High-pressure coolant capability with tube and direct connections



Cutting edge style **J**



Right hand (R) shown.

Designation	H	B	LF	LH	HF	WF	GAMP	GAMF	Insert	Torque*
ADJNR/L2020X-15-CHP-MC	20	20	110	40	20	25	6°	6°	DN**/FNGA1506...	4
ADJNR/L2525X-15-CHP-MC	25	25	125	40	25	32	6°	6°	DN**/FNGA1506...	4

*Torque: Recommended torque (N·m) for clamping
**Use shim RDT443 when using insert DN1504...
Applicable for 14 MPa pressure coolant

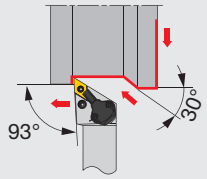
SPARE PARTS

Designation	Clamp set	Shim	Shim screw	screw for tube connection	Coolant plug	O-ring	Wrench 1
ADJNL***X-15-CHP-MC	LCGL-4JC SET	RDT433	SR14-506	PLUGG1/8-6.5TL360	SRM5X5 DIN913TL360	OR 4X3 NBR70	KEYV-T20
ADJNR***X-15-CHP-MC	LCGR-4JC SET	RDT433	SR14-506	PLUGG1/8-6.5TL360	SRM5X5 DIN913TL360	OR 4X3 NBR70	KEYV-T20

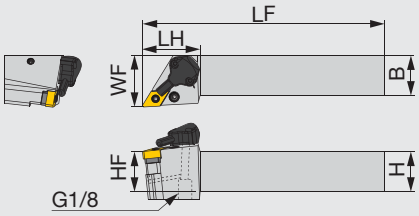
PDJNR/L-CHP

Tube connection

Lever lock toolholders – 93° approach angle.
For negative 55°/45° rhombic insert. High-pressure coolant capability.



Cutting edge style **J**



Right hand (R) shown.

Designation	H	B	LF	LH	HF	WF	RE**	Insert	Torque*
PDJNR/L2020K1104-CHP	20	20	125	36	20	32	0.8	DN**/FNMG1104...	2
PDJNR/L2020K15-CHP	20	20	125	36	20	32	0.8	DN**/FNGA1504...	3
PDJNR/L2525M1104-CHP	25	25	150	36	25	32	0.8	DN**/FNMG1104...	2
PDJNR/L2525M15-CHP	25	25	150	36	25	32	0.8	DN**/FNGA1504...	3

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

SPARE PARTS

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

SPARE PARTS

Designation	Coolant unit	Mounting screw	Wrench 2	O-ring	Coolant screw	Wrench 3
PDJNR/L**1104-CHP	CU-D-CHP	SR M3	T-8F	OR 6.4X0.9N	SR M4X4 DIN913 TL360	P-2
PDJNR/L**15-CHP	CU-D-CHP	SR M3	T-8F	OR 6.4X0.9N	SR M4X4 DIN913 TL360	P-2

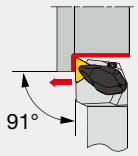
For hose connection to the tool holder, refer to page 13

New

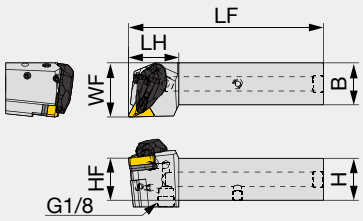
ATGNR/L-CHP

Direct connection | Tube connection

Double clamping tool holders-91°approach angle.
For negative triangle insert. High-pressure coolant capability with tube and direct connections.



Cutting edge style **G**



Right hand (R) shown.

Designation	H	B	LF	LH	HF	WF	RE	Insert	Torque
ATGNR/L2020X16-CHP	20	20	102	30	20	25	0.8	TN**1604**	3
ATGNR/L2525X16-CHP	25	25	115	30	25	32	0.8	TN**1604**	3

Torque: Recommended clamping torque: N·m

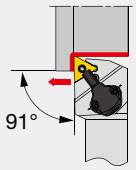
SPARE PARTS

Designation	Clamp	Clamping screw	Shim	Shim screw	Spring	Wrench	O-ring
ATGN****16-CHP	ACP3S-CHP	SR 11800782	AST322	CSTB-3.5	BP-4.5	T-15F	ORAS568-2.62X7.59

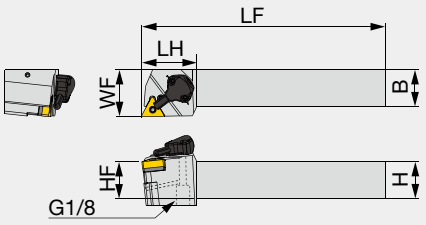
PTGNR/L-CHP

Tube connection

Lever lock toolholders – 91° approach angle.
For negative triangle insert. High-pressure coolant capability.



Cutting edge style **G**



Right hand (R) shown.

Designation	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 torque (N·m) for clamping
**RE: Standard corner radius

SPARE PARTS

Designation	Shim	Clamping screw	Wrench 1	Spring pin	Lever
PTGNR/L**1104-CHP	-	LCS23A	P-2.5	LSP3	LCL23
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**1104-CHP	CU-CW-CHP	SR M3	T-8F	OR 6.4X0.9N	SR M4X4 DIN913 TL360	P-2
PTGNR/L**16-CHP	CU-CW-CHP	SR M3	T-8F	OR 6.4X0.9N	SR M4X4 DIN913 TL360	P-2

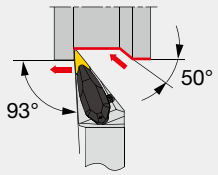
For hose connection to the tool holder, refer to page 13

New

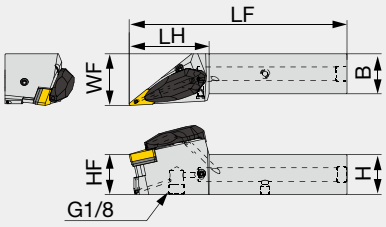
AVJNR/L-CHP

Direct connection | Tube connection

Double clamping tool holders-93°approach angle.
For negative 35° or 25° rhombic insert. High-pressure coolant capability with tube and direct connections.



Cutting edge style **J**



Right hand (R) shown.

Designation	H	B	LF	LH	HF	WF	RE	Insert	Torque
AVJNR/L2020X16-CHP	20	20	122	50	20	25	0.8	V/YN***1604**	3
AVJNR/L2525X16-CHP	25	25	135	50	25	32	0.8	V/YN***1604**	3

Torque: Recommended clamping torque: N·m

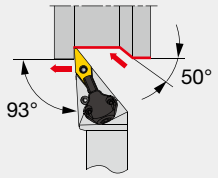
SPARE PARTS

Designation	Clamp	Clamping screw	Shim	Shim screw	Spring	Wrench	O-ring
AVJNR/L****16-CHP	ACP3L-CHP	SR 11800782	ASV322	CSTB-3.5	BP-4.5	T-15F	ORAS568-2.62X7.59

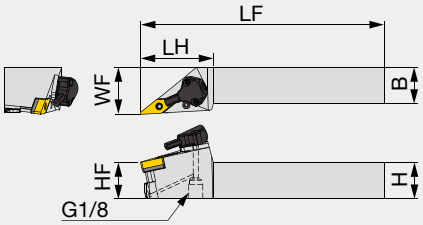
PVJNR/L-CHP

Tube connection

Lever lock toolholders – 93° approach angle.
For negative 35°/25° rhombic insert. High-pressure coolant capability.



Cutting edge style **J**



Right hand (R) shown.

Designation	H	B	LF	LH	HF	WF	RE**	Insert	Torque*
PVJNR/L2020K1204-CHP	20	20	125	50	20	32	0.8	VN**1204...	2
PVJNR/L2020K16-CHP	20	20	125	50	20	32	0.8	VN**/YN**1604...	2
PVJNR/L2525M1204-CHP	25	25	150	50	25	32	0.8	VN**1204...	2
PVJNR/L2525M16-CHP	25	25	150	50	25	32	0.8	VN**/YN**1604...	2

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

SPARE PARTS

Designation	Shim	Clamping screw	Wrench 1	Spring pin	Lever
PVJNR/L**1204-CHP	LSV212	LCS3V	P-2.5	LSP3	LCL3V
PVJNR/L**16-CHP	LSV317	LCS3V	P-2.5	LSP3	LCL3V

SPARE PARTS

Designation	Coolant unit	Mounting screw	Wrench 2	O-ring	Coolant screw	Wrench 3
PVJNR/L**1204-CHP	CU-V-CHP	SR M3	T-8F	OR 6.4X0.9N	SR M4X4 DIN913 TL360	P-2
PVJNR/L**16-CHP	CU-V-CHP	SR M3	T-8F	OR 6.4X0.9N	SR M4X4 DIN913 TL360	P-2

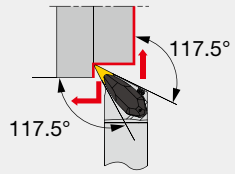
For hose connection to the tool holder, refer to page 13

New

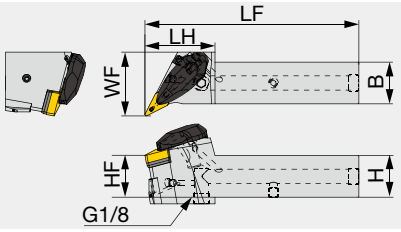
AVQNR/L-CHP

Direct connection | Tube connection

Double clamping tool holders-117.5°approach angle.
For negative 35° or 25° rhombic insert. High-pressure coolant capability with tube and direct connections.



Cutting edge style **Q**



Right hand (R) shown.

Designation	H	B	LF	LH	HF	WF	RE	Insert	Torque
AVQNR/L2020X16-CHP	20	20	114	41	20	25	0.8	V/YN**1604**	3
AVQNR/L2525X16-CHP	25	25	127	42	25	32	0.8	V/YN**1604**	3

Torque: Recommended clamping torque: N·m

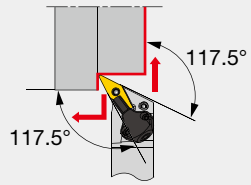
SPARE PARTS

Designation	Clamp	Clamping screw	Shim	Shim screw	Spring	Wrench	O-ring
AVQNR/L****16-CHP	ACP3L-CHP	SR 11800782	ASV322	CSTB-3.5	BP-4.5	T-15F	ORAS568-2.62X7.59

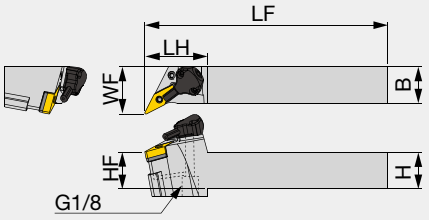
PVQNR/L-CHP

Tube connection

Lever lock toolholders – 117.5° approach angle.
For negative 35°/25° rhombic insert. High-pressure coolant capability.



Cutting edge style **Q**



Right hand (R) shown.

Designation	H	B	LF	LH	HF	WF	RE **	Insert	Torque*
PVQNR/L2020K16-CHP	20	20	125	42.5	20	32	0.8	VN**/YN**1604...	2
PVQNR/L2525M16-CHP	25	25	150	42.5	25	32	0.8	VN**/YN**1604...	2

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

SPARE PARTS

Designation	Shim	Clamping screw	Wrench 1	Spring pin	Lever
PVQNR/L**16-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**16-CHP	CU-V-CHP	SR M3	T-8F	OR 6.4X0.9N	SR M4X4 DIN913 TL360	P-2

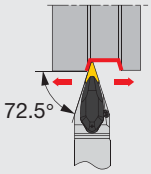
For hose connection to the tool holder, refer to page 13

New

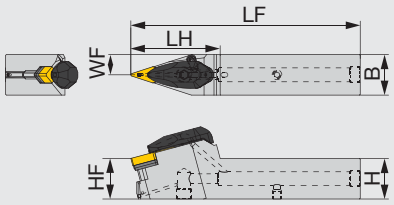
AVVNN-CHP

Direct connection | Tube connection

Double clamping tool holders-72.5°approach angle.
For negative 35° or 25° rhombic insert. High-pressure coolant capability with tube and direct connections.



Cutting edge style **V**



Right hand (R) shown.

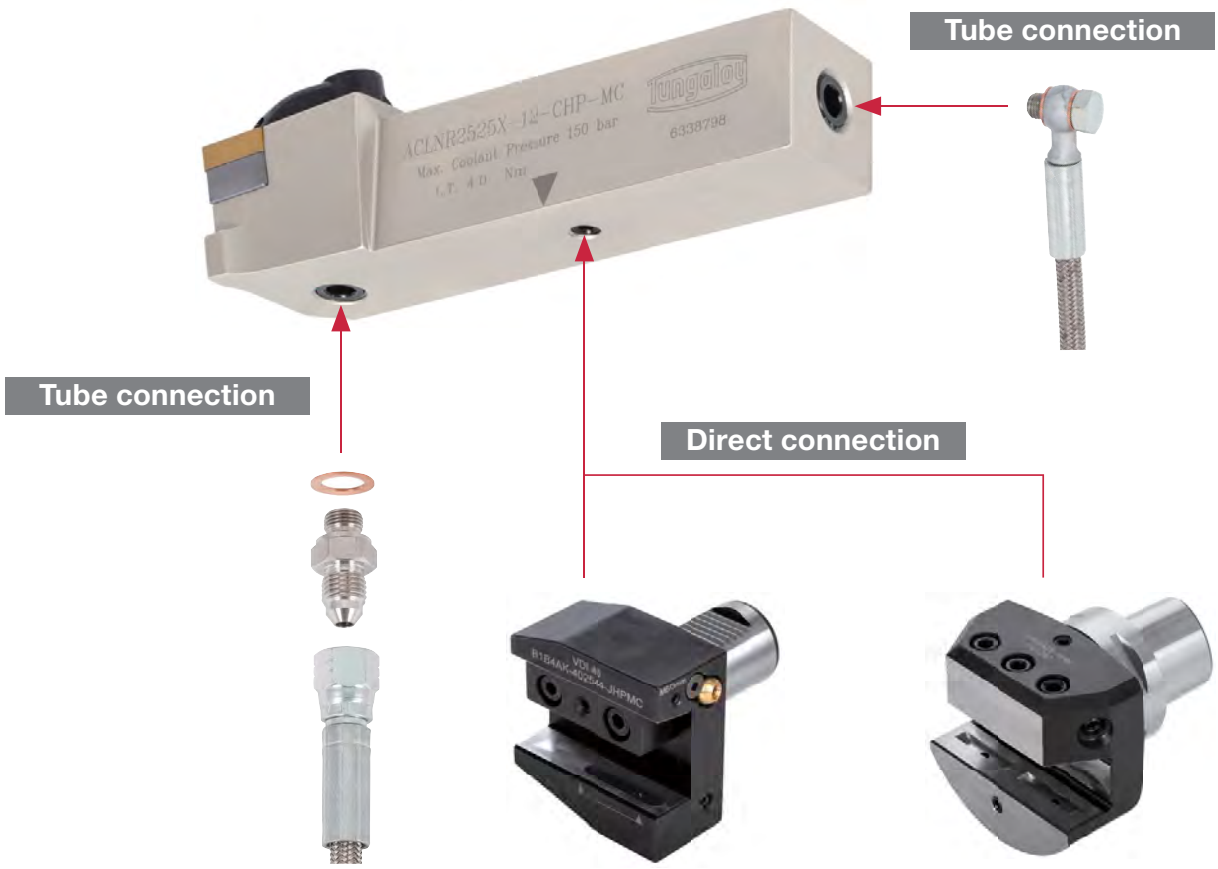
Designation	H	B	LF	LH	HF	WF	RE	Insert	Torque
AVVNN2020X16-CHP	20	20	127	55	20	10	0.8	V/YN**1604**	3
AVVNN2525X16-CHP	25	25	140	55	25	12.5	0.8	V/YN**1604**	3

Torque: Recommended clamping torque: N·m

SPARE PARTS

Designation	Clamp	Clamping screw	Shim	Shim screw	Spring	Wrench	O-ring
AVVNN****16-CHP	ACP3L-CHP	SR 11800782	ASV322	CSTB-3.5	BP-4.5	T-15F	ORAS568-2.62X7.59

PARTS FOR COOLANT HOSE



VDI adapter

For more information

TUNGCAP

For more information

PARTS FOR COOLANT HOSE

Connecting hose

Fig. 1

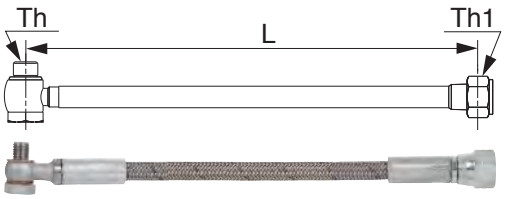
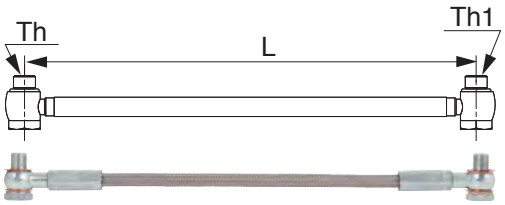
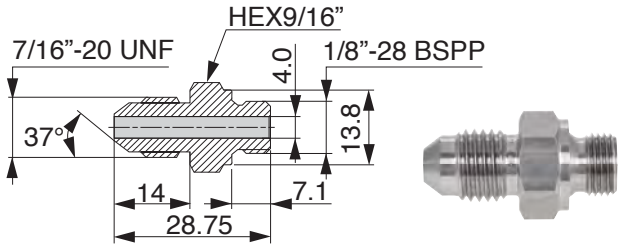


Fig. 2



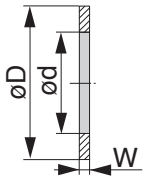
Designation	Length	Threading size		Max. pressure	Fig.
	L	Th	Th1	(Mpa)	
CHP-HOSE-G1/8-7/16-200BS	200	G1/8"-28 BSPP	7/16"-20 UNF	20	1
CHP-HOSE-G1/8-7/16-250BS	250	G1/8"-28 BSPP	7/16"-20 UNF	20	1
CHP-HOSE-5/16-7/16-200BS	200	5/16"-24UNF	7/16"-20 UNF	20	1
CHP-HOSE-5/16-G1/8-200BS	200	5/16"-24UNF	G1/8"-28 BSPP	20	1
CHP-HOSE-G1/8-G1/8-200BB	200	G1/8"-28 BSPP	G1/8"-28 BSPP	20	2
CHP-HOSE-G1/8-G1/8-250BB	250	G1/8"-28 BSPP	G1/8"-28 BSPP	20	2

Connector



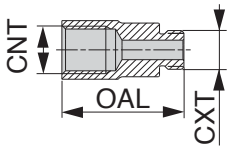
Designation
CHP-NIPPLE-G1/8-7/16UNF

Seal washer



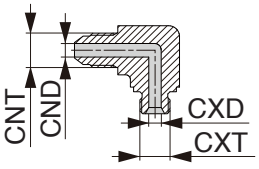
Designation	øD	ød	W
CHP-COPPER-SEAL1/8	15	10	1
CHP-COPPER-SEAL5/16	11.9	8.15	1.35
CHP-COPPER-SEAL5/16-2.5	9.4	8	2.5

Connector for small lathe with seal washer



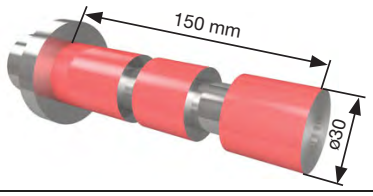
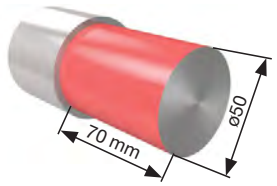
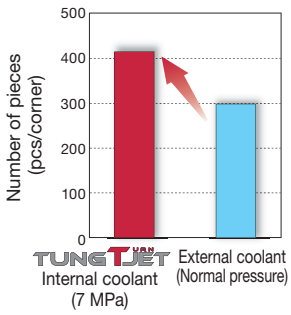
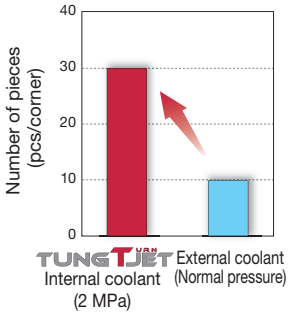
Designation	CNT	CXT	OAL
CHP-CONECTOR5/16-G1/8	G1/8"-28 BSPP	5/16"-24 UNF	25
CHP-CONNECTOR-G1/8-R1/8	G1/8"-28 BSPP	R1/8"-28 BSPT	25

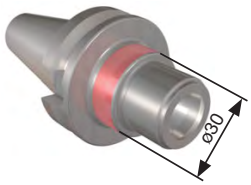
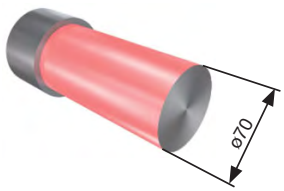
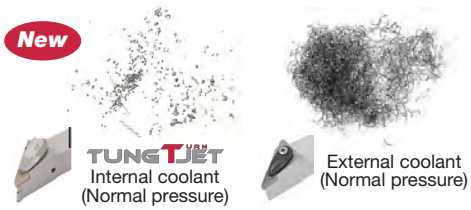
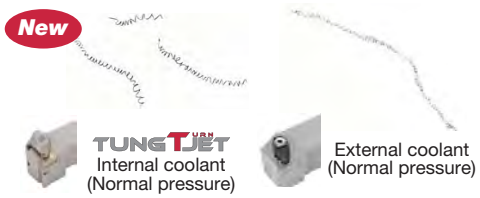
Connector elbow



Designation	CNT	CND	CXT	CXD
CHP-ELBOW-90-G1/8-7/16UNF	7/16"-20 UNF	4.4	1/8"-28 BSPP	4
CHP-ELBOW-90-5/16-7/16UNF	7/16"-20 UNF	4.4	5/16"-24 UNF	4

PRACTICAL EXAMPLES

	Workpiece type	Valve parts	Tube parts
	Toolholder	PDJNR2525M15-CHP	PCLNR2525M12-CHP
	Insert	DNMG150408-HRM	CNMG120408-HRM
	Grade	AH8015	AH8015
	Workpiece material	Inconel 718	Ti-6AL-4V
		 S	 S
Cutting conditions	Cutting speed : *Vc*(m/min)	80	60
	Feed : *f* (mm/rev)	0.3	0.2
	Depth of cut : *ap* (mm)	2	2
	Machining	External turning	External turning
	Coolant	Wet	Wet
	Results	 **Tool life 1.3 times longer** Due to cooling effect of high pressure coolant, tool life is 1.3 times longer than machining with normal pressure coolant.	 **Tool life 3 times longer** Due to its high pressure coolant system, TungTurn-Jet provides excellent chip control and tool life is 3 times longer than machining with normal pressure coolant.

	Workpiece type	Toolholder	Machine parts
	Toolholder	AVJNR2525X16-CHP	ATGNR2525X16-CHP
	Insert	2QP-VNGA160404-LC	TNMG160404
	Grade	BXA20	T9215
	Workpiece material	SNCM420 (60HRC)	SNCM240 /41CrNiMo2
		 H	 P
Cutting conditions	Cutting speed : *Vc*(m/min)	100	200
	Feed : *f* (mm/rev)	0.1	0.5
	Depth of cut : *ap* (mm)	0.1	0.2
	Machining	External turning	External turning
	Coolant	Wet	Wet
	Results	 **Improved chip control** Drastically improved chip control in hardened steel turning compared to external coolant supply.	 **Improved chip control** Improved chip control in small D.O.C. turning compared to external coolant supply.

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