

TurnLine

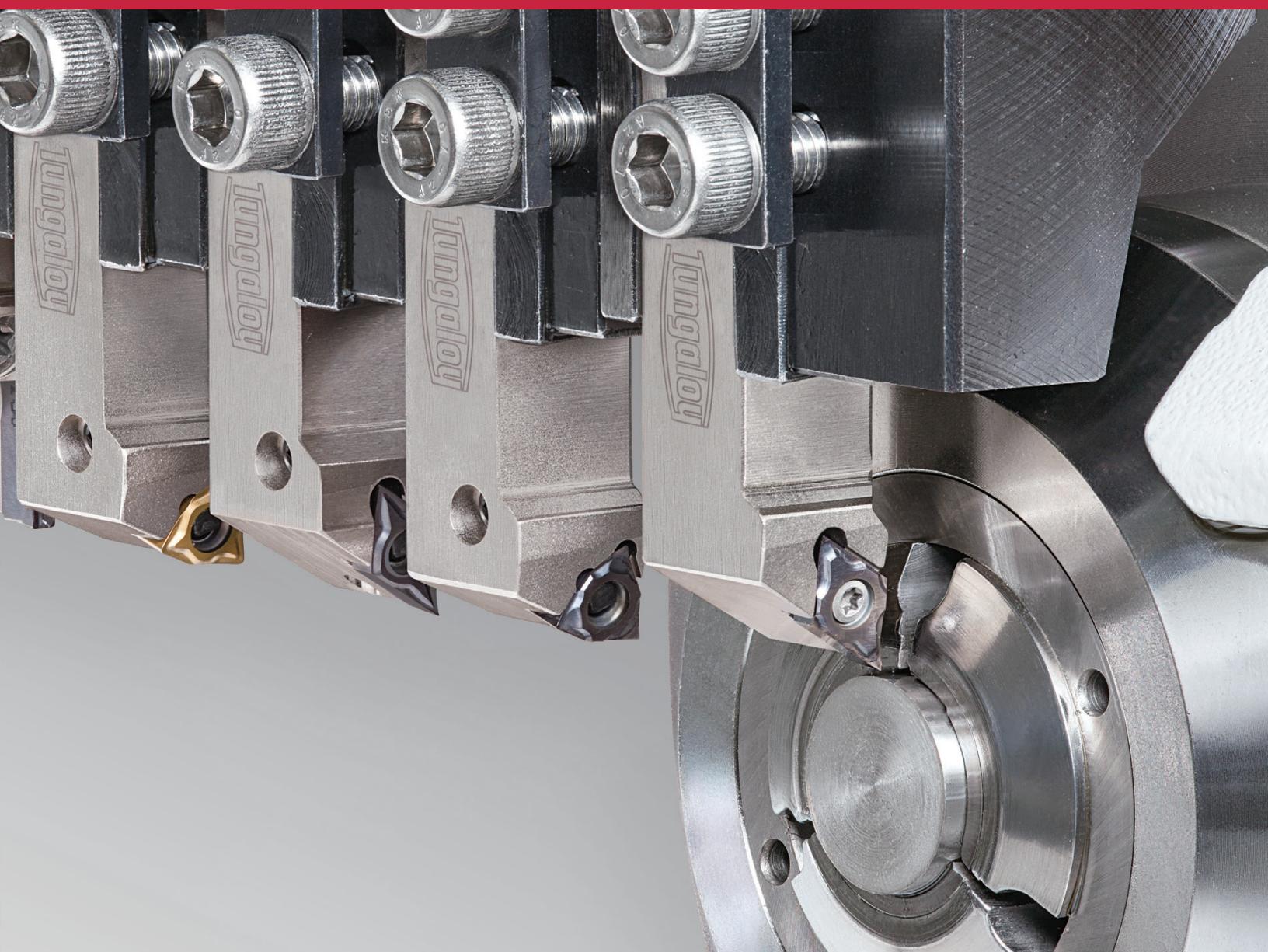
SH725

www.tungaloyamerica.com

Tungaloy Report No. 436-US

j_NL

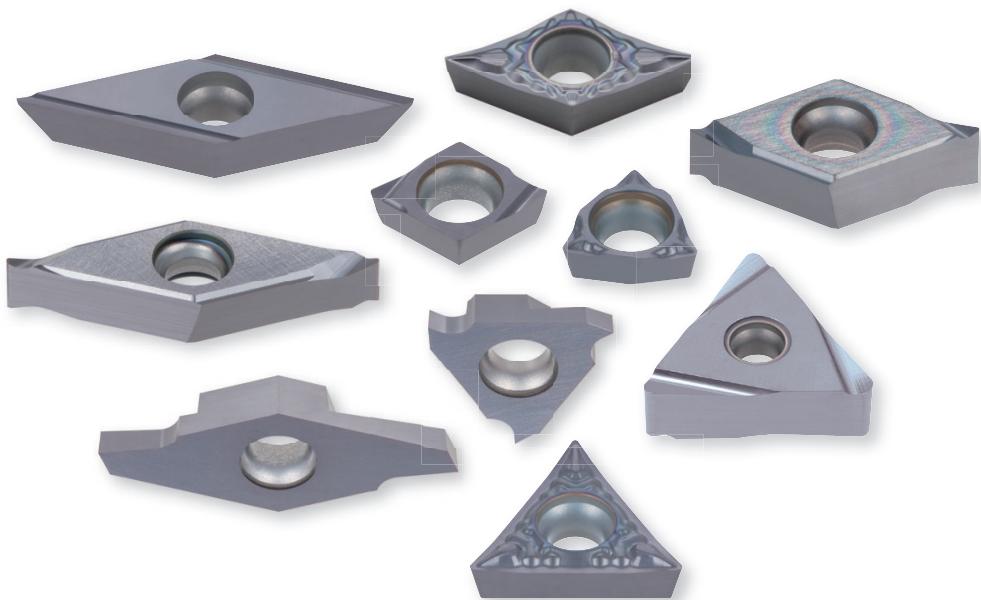
Ideal grade for small-part machining



Member IMC Group
Tungaloy



ACCELERATED MACHINING



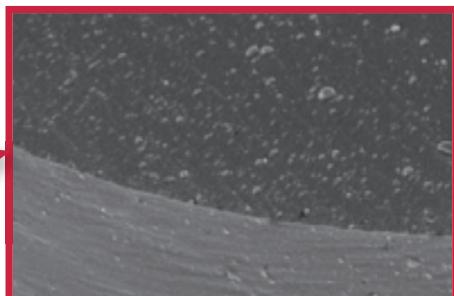
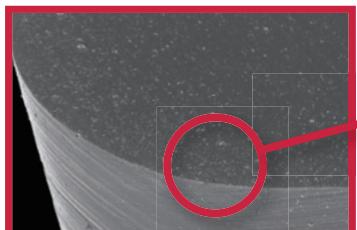
- Excellent sharpness and high adhesion strength offer incredible wear resistance.
- The line-up of the toolholders is greatly expanded.

PVD grade exclusively designed for precise-part machining
 "High adhesion strength and sharp cutting edge"
 → Amazing tool life with excellent sharpness!

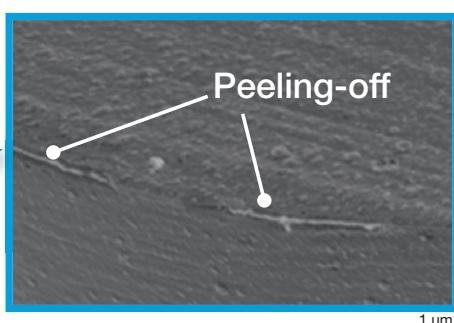
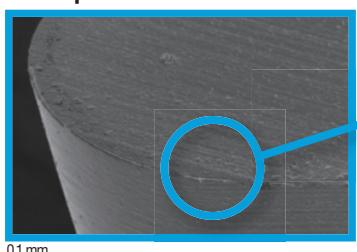
Newly developed coating layer

No peeling-off even on sharp cutting edges

SH725

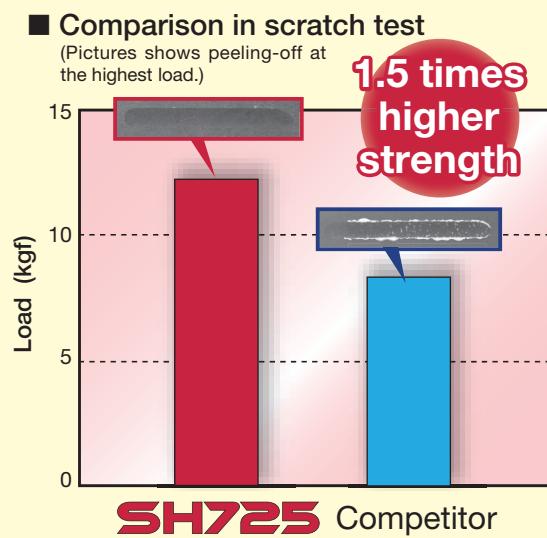


Competitor



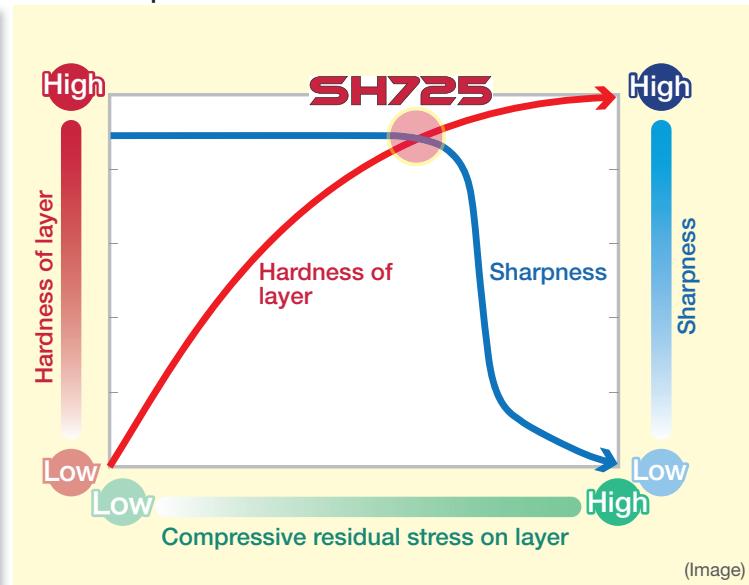
Drastically improved adhesion strength

Latest coating technology is effectively applied.



Hard coating layer on the sharp cutting edge

Innovative coating with both hardness and sharpness



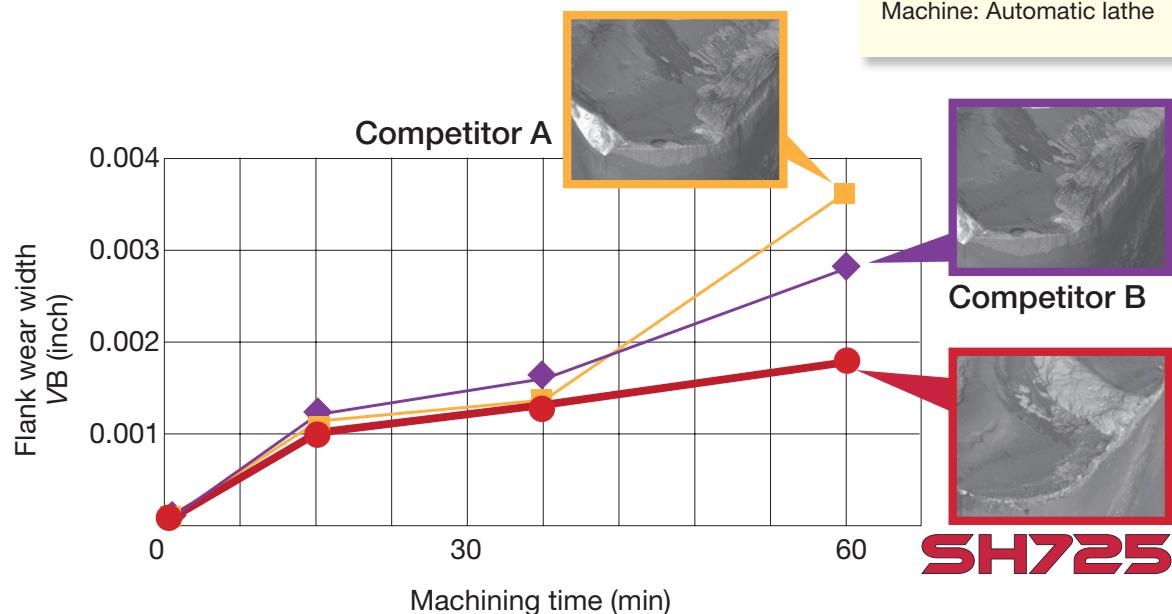
Cutting performance

External continuous cutting

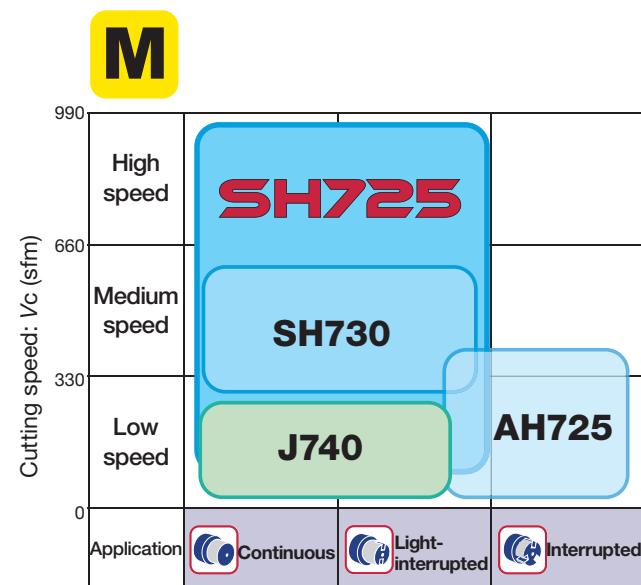
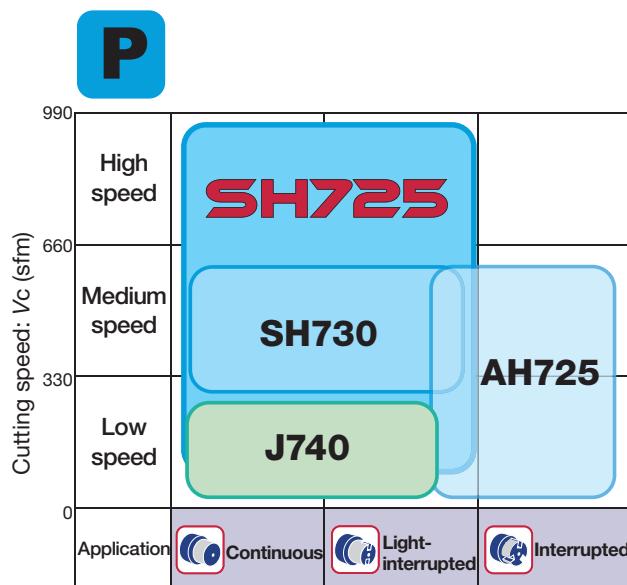


Carbon steel
(1045)

High adhesion strength provides excellent wear resistance.



Application range



Inserts

Rhombic 55°

MINIFTURN

Application	Appearance (Cross section)	$f - ap$	Cat. No.	Grade	Dimensions (in)			
				Coated	I.C. dia.	Thick- ness	Hole dia.	Corner radius
				SH725	ød	s	ød1	r_ϵ
Finishing (External, sharp edge)	JRP		DXGU070301MFRE-JRP	●	0.250	0.125	0.106	< 0.004*
			DXGU070301MFLE-JRP	●	0.250	0.125	0.106	< 0.004*
			DXGU070302MFRE-JRP	●	0.250	0.125	0.106	< 0.008*
			DXGU070302MFLE-JRP	●	0.250	0.125	0.106	< 0.008*
Finishing to medium cutting (External, sharp edge)	JTS		DXGU070301MFR-JTS	●	0.250	0.125	0.106	< 0.004*
			DXGU070301MFL-JTS	●	0.250	0.125	0.106	< 0.004*
			DXGU070302MFR-JTS	●	0.250	0.125	0.106	< 0.008*
			DXGU070302MFL-JTS	●	0.250	0.125	0.106	< 0.008*
Finishing (Low cutting force) (External, sharp edge)	JSS		DXGU070301MFR-JSS	●	0.250	0.125	0.106	< 0.004*
			DXGU070301MFL-JSS	●	0.250	0.125	0.106	< 0.004*
			DXGU070302MFR-JSS	●	0.250	0.125	0.106	< 0.008*
			DXGU070302MFL-JSS	●	0.250	0.125	0.106	< 0.008*

Rhombic 35°

Application	Appearance (Cross section)	$f - ap$	Cat. No.	Grade	Dimensions (in)			
				Coated	I.C. dia.	Thick- ness	Hole dia.	Corner radius
				SH725	ød	s	ød1	r_ϵ
Finishing (External, sharp edge)	JRP		VXGU09T201MFRE-JRP	●	0.219	0.109	0.098	< 0.004*
			VXGU09T201MFLE-JRP	●	0.219	0.109	0.098	< 0.004*
			VXGU09T202MFRE-JRP	●	0.219	0.109	0.098	< 0.008*
			VXGU09T202MFLE-JRP	●	0.219	0.109	0.098	< 0.008*

Trigon 80°

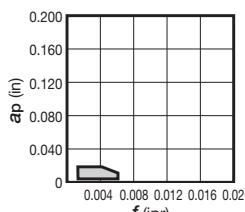
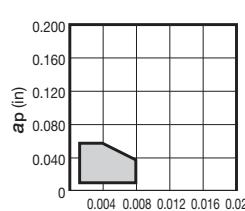
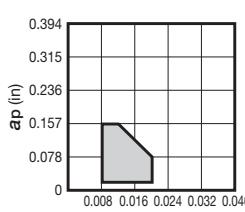
Application	Appearance (Cross section)	$f - ap$	Cat. No.	Grade	Dimensions (in)			
				Coated	I.C. dia.	Thick- ness	Hole dia.	Corner radius
				SH725	ød	s	ød1	r_ϵ
Finishing to medium cutting (External, sharp edge)	JTS		WXGU040301MFR-JTS	●	0.250	0.125	0.106	< 0.004*
			WXGU040301MFL-JTS	●	0.250	0.125	0.106	< 0.004*
			WXGU040302MFR-JTS	●	0.250	0.125	0.106	< 0.008*
			WXGU040302MFL-JTS	●	0.250	0.125	0.106	< 0.008*
Finishing (Low cutting force) (External, sharp edge)	JSS		WXGU040301MFR-JSS	●	0.250	0.125	0.106	< 0.004*
			WXGU040301MFL-JSS	●	0.250	0.125	0.106	< 0.004*
			WXGU040302MFR-JSS	●	0.250	0.125	0.106	< 0.008*
			WXGU040302MFL-JSS	●	0.250	0.125	0.106	< 0.008*

Toolholders
P19 - 28

* JRP, JTS, and JSS have minus tolerance of corner radius.

● : Stocked items

Triangular 60°, Negative

Application	Appearance (Cross section)	$f - a_p$	Cat. No.	Grades	Dimensions (in)			
				Coated	I.C. dia.	Thickness	Hole dia.	Corner radius
				SH725	ϕd	s	ϕd_1	r_ϵ
Precision finishing (External, sharp edge)	01		TNGG330.5F-01 TNGG331F-01 * TNGG332F-01	●	0.375	0.187	0.150	0.008
	W		TNGG330.5FR-W TNGG330.5FL-W TNGG331FR-W TNGG331FL-W * TNGG332FR-W TNGG332FL-W	●	0.375	0.187	0.150	0.008
	P		TNGG330.5FR-P TNGG330.5FL-P TNGG331FR-P TNGG331FL-P * TNGG332FR-P TNGG332FL-P	●	0.375	0.187	0.150	0.008

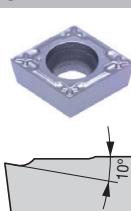
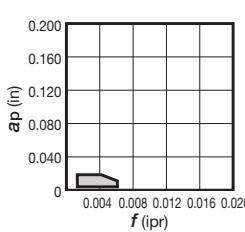
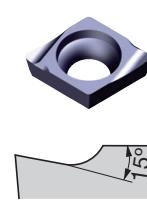
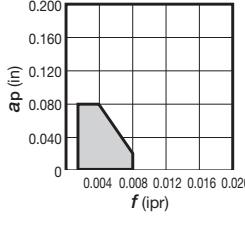
Note: Chipbreaker that shows the cross section is marked with * on the designation.

Toolholders
P46, 47

● : Stocked items

Rhombic 80°, Positive 7°

J-SERIES

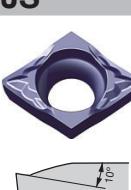
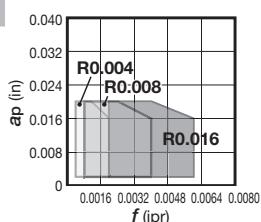
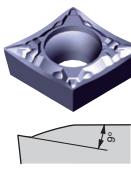
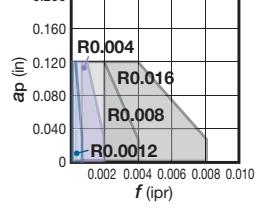
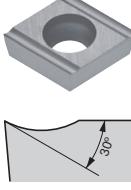
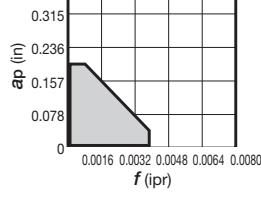
Application	Appearance (Cross section)	$f - a_p$	Cat. No.	Grades	Dimensions (in)			
				Coated	I.C. dia.	Thickness	Hole dia.	Corner radius
				SH725	ϕd	s	ϕd_1	r_ϵ
Precision finishing (External, sharp edge)	01 		CCGT060202F-01	●	0.250	0.094	0.110	0.008
			*CCGT060204F-01	●	0.250	0.094	0.110	0.016
			CCGT09T302F-01	●	0.375	0.156	0.173	0.008
Finishing (Internal, sharp edge)	W08 		CCGT03X100FR-W08	●	0.156	0.055	0.075	0.0012
			CCGT03X100FL-W08	●	0.156	0.055	0.075	0.0012
			*CCGT03X101FR-W08	●	0.156	0.055	0.075	0.004
			CCGT03X101FL-W08	●	0.156	0.055	0.075	0.004
			CCGT03X102FR-W08	●	0.156	0.055	0.075	0.008
			CCGT03X102FL-W08	●	0.156	0.055	0.075	0.008
			CCGT03X104FR-W08	●	0.156	0.055	0.075	0.016
			CCGT03X104FL-W08	●	0.156	0.055	0.075	0.016
			CCGT04T100FR-W08	●	0.187	0.070	0.091	0.0012
			CCGT04T100FL-W08	●	0.187	0.070	0.091	0.0012
			CCGT04T101FR-W08	●	0.187	0.070	0.091	0.004
			CCGT04T101FL-W08	●	0.187	0.070	0.091	0.004
			CCGT04T102FR-W08	●	0.187	0.070	0.091	0.008
			CCGT04T102FL-W08	●	0.187	0.070	0.091	0.008
			CCGT04T104FR-W08	●	0.187	0.070	0.091	0.016
			CCGT04T104FL-W08	●	0.187	0.070	0.091	0.016

Note: Chipbreaker that shows the cross section is marked with * on the designation.

Toolholders
P30 - 33, P50

● : Stocked items

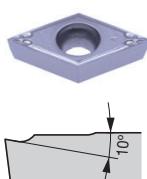
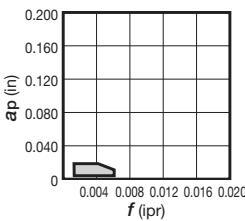
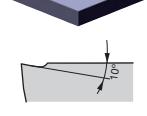
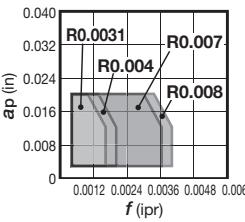
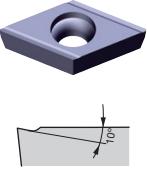
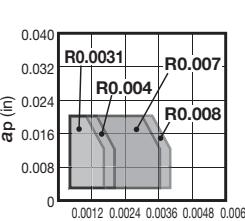
Rhombic 80°, Positive 7°

Application	Chipbreaker (Cross section)	f - ap	Cat. No.	Grade	Dimensions (in)			
				Coated	I.C. dia.	Thickness	Hole dia.	Corner radius
				SH725	ød	s	ød1	r _E
Finishing (Internal, External, sharp edge)	JS 	 <p>ap (in)</p> <p>R0.004 R0.008 R0.016</p> <p>f (inpr)</p>	CCGT03X101F-JS	●	0.141	0.055	0.075	0.004
			CCGT03X102F-JS	●	0.141	0.055	0.075	0.008
			CCGT03X104F-JS	●	0.141	0.055	0.075	0.016
			* CCGT04T101F-JS	●	0.172	0.070	0.091	0.004
			CCGT04T102F-JS	●	0.172	0.070	0.091	0.008
			CCGT04T104F-JS	●	0.172	0.070	0.091	0.016
Finishing (Internal, sharp edge)	JS 	 <p>ap (in)</p> <p>R0.004 R0.016 R0.008 R0.0012</p> <p>f (inpr)</p>	CCGT060200FN-JS	●	0.250	0.094	0.110	0.0012
			CCGT060201FN-JS	●	0.250	0.094	0.110	0.004
			CCGT060202FN-JS	●	0.250	0.094	0.110	0.008
			CCGT060204FN-JS	●	0.250	0.094	0.110	0.016
			CCGT09T300FN-JS	●	0.375	0.156	0.173	0.0012
			* CCGT09T301FN-JS	●	0.375	0.156	0.173	0.004
			CCGT09T302FN-JS	●	0.375	0.156	0.173	0.008
			CCGT09T304FN-JS	●	0.375	0.156	0.173	0.016
Finishing to medium cutting (External, sharp edge)	J10 	 <p>ap (in)</p> <p>R0.004 R0.016 R0.008 R0.0012</p> <p>f (inpr)</p>	CCGT060200FR-J10	●	0.250	0.094	0.110	0.0012
			CCGT060200FL-J10	●	0.250	0.094	0.110	0.0012
			* CCGT060201FR-J10	●	0.250	0.094	0.110	0.004
			CCGT060201FL-J10	●	0.250	0.094	0.110	0.004
			CCGT060202FR-J10	●	0.250	0.094	0.110	0.008
			CCGT060202FL-J10	●	0.250	0.094	0.110	0.008
			CCGT09T300FR-J10	●	0.375	0.156	0.173	0.0012
			CCGT09T300FL-J10	●	0.375	0.156	0.173	0.0012
			CCGT09T301FR-J10	●	0.375	0.156	0.173	0.004
			CCGT09T301FL-J10	●	0.375	0.156	0.173	0.004
			CCGT09T302FR-J10	●	0.375	0.156	0.173	0.008
			CCGT09T302FL-J10	●	0.375	0.156	0.173	0.008
			CCGT09T304FR-J10	●	0.375	0.156	0.173	0.016

Note: Chipbreaker that shows the cross section is marked with * on the designation.

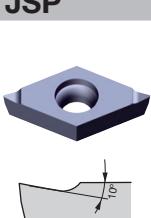
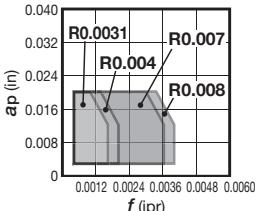
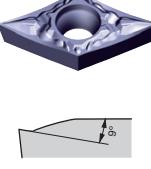
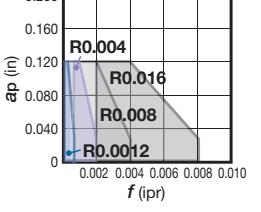
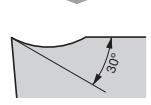
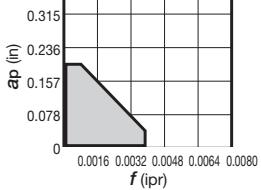
Rhombic 55°, Positive 7°

J-SERIES

Application	Chipbreaker (Cross section)	$f - a_p$	Cat. No.	Grade	Dimensions (in)			
				Coated	I.C. dia. ød	Thick- ness s	Hole dia. ød1	Corner radius r_e
				SH725				
Precision finishing (External, sharp edge)	01 		DCGT070202F-01 * DCGT11T302F-01	●	0.250	0.094	0.110	0.008
JRP			DCET0702008MFR-JRP DCET070201MFR-JRP DCET070201MFL-JRP DCET0702018MFL-JRP DCET070202MFR-JRP DCET070202MFL-JRP DCET11T3008MFR-JRP DCET11T301MFR-JRP DCET11T3018MFL-JRP * DCET11T302MFR-JRP DCET11T302MFL-JRP	● ● ● ● ● ● ● ● ● ● ● ●	0.250 0.250 0.250 0.250 0.250 0.250 0.375 0.375 0.375 0.375 0.375	0.094 0.094 0.094 0.094 0.094 0.094 0.156 0.156 0.156 0.156 0.156	0.110 0.110 0.110 0.110 0.110 0.110 0.173 0.173 0.173 0.173 0.173	< 0.003* < 0.004* < 0.004* < 0.007* < 0.008* < 0.008* < 0.003* < 0.004* < 0.007* 0.173 < 0.008* 0.173 < 0.008*
Finishing (External, sharp edge)	JPP 		DCET0702008MFR-JPP DCET070201MFR-JPP DCET070201MFL-JPP DCET070202MFR-JPP DCET070202MFL-JPP DCET11T3008MFR-JPP DCET11T301MFR-JPP DCET11T301MFL-JPP DCET11T3018MFR-JPP DCET11T3018MFL-JPP * DCET11T302MFR-JPP DCET11T302MFL-JPP	● ● ● ● ● ● ● ● ● ● ●	0.250 0.250 0.250 0.250 0.250 0.375 0.375 0.375 0.375 0.375	0.094 0.094 0.094 0.094 0.094 0.156 0.156 0.156 0.156 0.156	0.110 0.110 0.110 0.110 0.110 0.173 0.173 0.173 0.173 0.173	< 0.003* < 0.004* < 0.004* < 0.008* < 0.008* 0.173 < 0.003* 0.173 < 0.004* 0.173 < 0.004* 0.173 < 0.007* 0.173 < 0.007* 0.173 < 0.008* 0.173 < 0.008*

Note: Chipbreaker that shows the cross section is marked with * on the designation.

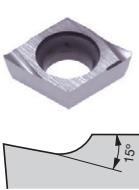
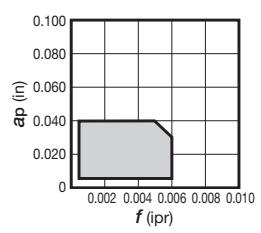
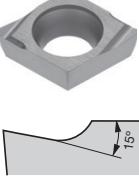
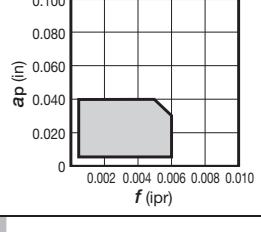
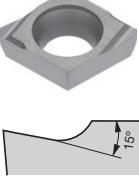
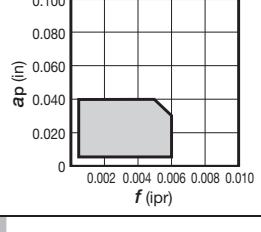
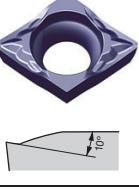
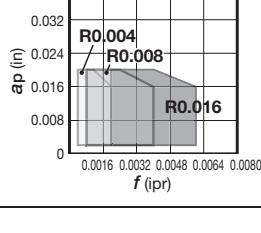
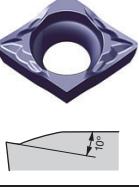
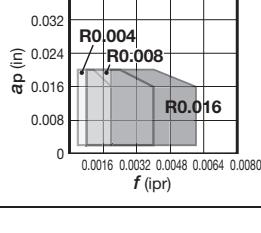
Rhombic 55°, Positive 7°

Application	Chipbreaker (Cross section)	f - ap	Cat. No.	Grade	Dimensions (in)			
				Coated	I.C. dia.	Thick- ness s	Hole dia. ød1	Corner radius rε
				SH725	ød	s	ød1	rε
Finishing (External, sharp edge)	JSP 	 <p>ap (in) vs f (ipr)</p>	DCET0702008MFN-JSP	●	0.250	0.094	0.110	< 0.003*
			DCET0702010MFN-JSP	●	0.250	0.094	0.110	< 0.004*
			DCET0702018MFN-JSP	●	0.250	0.094	0.110	< 0.007*
			DCET070202MFN-JSP	●	0.250	0.094	0.110	< 0.008*
			DCET11T3008MFN-JSP	●	0.375	0.156	0.173	< 0.003*
	JS 	 <p>ap (in) vs f (ipr)</p>	DCGT070200FN-JS	●	0.250	0.094	0.110	0.0012
			DCGT070201FN-JS	●	0.250	0.094	0.110	0.004
			DCGT070202FN-JS	●	0.250	0.094	0.110	0.008
			DCGT11T300FN-JS	●	0.375	0.156	0.173	0.0012
			*DCGT11T301FN-JS	●	0.375	0.156	0.173	0.004
Finishing to medium cutting (External, sharp edge)	J10 	 <p>ap (in) vs f (ipr)</p>	DCGT070200FR-J10	●	0.250	0.094	0.110	0.0012
			DCGT070200FL-J10	●	0.250	0.094	0.110	0.0012
			*DCGT070201FR-J10	●	0.250	0.094	0.110	0.004
			DCGT070201FL-J10	●	0.250	0.094	0.110	0.004
			DCGT070202FR-J10	●	0.250	0.094	0.110	0.008
			DCGT070202FL-J10	●	0.250	0.094	0.110	0.008
			DCGT070204FR-J10	●	0.250	0.094	0.110	0.016
			DCGT070204FL-J10	●	0.250	0.094	0.110	0.016
			DCGT11T300FR-J10	●	0.375	0.156	0.173	0.0012
			DCGT11T300FL-J10	●	0.375	0.156	0.173	0.0012
			DCGT11T301FR-J10	●	0.375	0.156	0.173	0.004
			DCGT11T301FL-J10	●	0.375	0.156	0.173	0.004
			DCGT11T302FR-J10	●	0.375	0.156	0.173	0.008
			DCGT11T302FL-J10	●	0.375	0.156	0.173	0.008

Note: Chipbreaker that shows the cross section is marked with * on the designation.

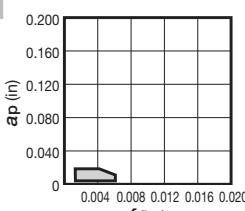
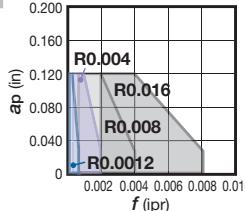
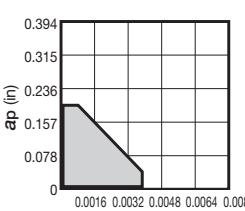
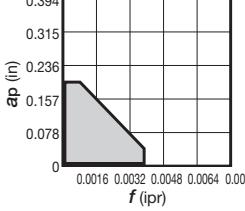
Rhombic 75°, Positive 11°

J-SERIES

Application	Chipbreaker Appearance (Cross section)	$f - a_p$	Cat. No.	Grade	Dimensions (in)			
				Coated	I.C. dia.	Thickness	Hole dia.	Corner radius
				SH725	ϕd	s	ϕd_1	r_e
Finishing (Internal, sharp edge)	W08	 	EPGT03X100FR-W08	●	0.141	0.055	0.075	0.0012
			EPGT03X100FL-W08	●	0.141	0.055	0.075	0.0012
			EPGT03X101FR-W08	●	0.141	0.055	0.075	0.004
			EPGT03X101FL-W08	●	0.141	0.055	0.075	0.004
			EPGT03X102FR-W08	●	0.141	0.055	0.075	0.008
			EPGT03X102FL-W08	●	0.141	0.055	0.075	0.008
			*EPGT03X104FR-W08	●	0.141	0.055	0.075	0.016
			EPGT03X104FL-W08	●	0.141	0.055	0.075	0.016
			EPGT040100FR-W08	●	0.172	0.063	0.091	0.0012
			EPGT040100FL-W08	●	0.172	0.063	0.091	0.0012
			EPGT040101FR-W08	●	0.172	0.063	0.091	0.004
			EPGT040101FL-W08	●	0.172	0.063	0.091	0.004
			EPGT040102FR-W08	●	0.172	0.063	0.091	0.008
			EPGT040102FL-W08	●	0.172	0.063	0.091	0.008
			EPGT040104FR-W08	●	0.172	0.063	0.091	0.016
			EPGT040104FL-W08	●	0.172	0.063	0.091	0.016
J08	 	 	EPGT040100FL-J08	●	0.172	0.063	0.091	0.0012
			EPGT040102FL-J08	●	0.172	0.063	0.091	0.008
			EPGT040104FL-J08	●	0.172	0.063	0.091	0.016
JS	 	 	EPGT03X101F-JS	●	0.141	0.055	0.075	0.004
			EPGT03X102F-JS	●	0.141	0.055	0.075	0.008
			EPGT03X104F-JS	●	0.141	0.055	0.075	0.016
			*EPGT040101F-JS	●	0.172	0.063	0.091	0.004
			EPGT040102F-JS	●	0.172	0.063	0.091	0.008
			EPGT040104F-JS	●	0.172	0.063	0.091	0.016

Note: Chipbreaker that shows the cross section is marked with * on the designation.

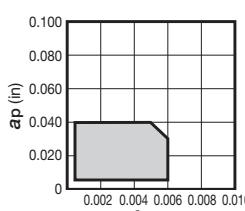
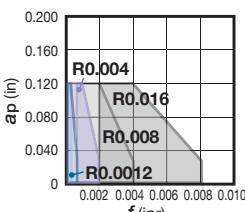
Triangular 60°, Positive 7°

Application	Appearance (Cross section)	$f - a_p$	Cat. No.	Grade	Dimensions (in)			
				Coated	I.C. dia.	Thickness	Hole dia.	Corner radius
				SH725	ϕd	s	ϕd_1	r_e
	01 Precision finishing (External, sharp edge)		* TCGT110202F-01	●	0.250	0.094	0.110	0.008
	JS Finishing to medium cutting (External, sharp edge)		TCGT110200FN-JS * TCGT110201FN-JS TCGT110202FN-JS TCGT110204FN-JS	● ● ● ●	0.250	0.094	0.110	0.0012 0.004 0.008 0.016
	J08 Finishing to medium cutting (External, sharp edge)		* TCGT080200FR-J08 TCGT080200FL-J08 TCGT080201FR-J08 TCGT080201FL-J08 TCGT080202FR-J08 TCGT080202FL-J08 TCGT080204FR-J08	● ● ● ● ● ● ●	0.187	0.094	0.091	0.0012 0.0012 0.004 0.004 0.008 0.008 0.016
	J10 Finishing to medium cutting (External, sharp edge)		* TCGT110200FR-J10 TCGT110200FL-J10 TCGT110201FR-J10 TCGT110201FL-J10 TCGT110202FR-J10 TCGT110202FL-J10 TCGT110204FR-J10 TCGT110300FR-J10 TCGT110300FL-J10 TCGT110301FR-J10 TCGT110301FL-J10 TCGT110302FR-J10 TCGT110302FL-J10	● ● ● ● ● ● ● ● ● ● ● ● ●	0.250	0.094	0.110	0.0012 0.0012 0.004 0.004 0.008 0.008 0.016 0.250

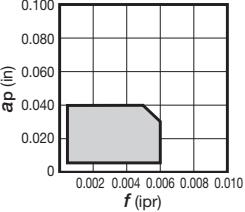
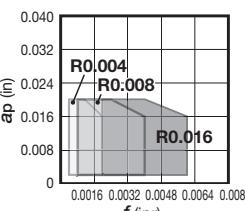
Note: Chipbreaker that shows the cross section is marked with * on the designation.

Triangular 60°, Positive 11°

J-SERIES

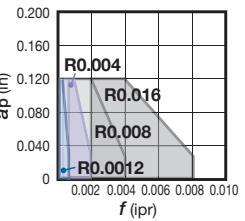
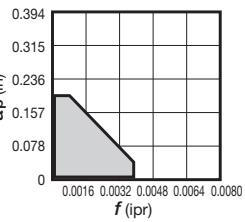
Application	Chipbreaker	$f - ap$	Cat. No.	Grade	Dimensions (in)			
				Coated	I.C. dia.	Thickness	Hole dia.	Corner radius
				SH725	$\varnothing d$	s	$\varnothing d_1$	r_ϵ
Finishing (Internal, sharp edge)	W08		*TPGT070100FR-W08 TPGT070100FL-W08 TPGT070101FR-W08 TPGT070101FL-W08 TPGT070102FR-W08 TPGT070102FL-W08 TPGT070104FR-W08 TPGT070104FL-W08	●	0.172	0.063	0.102	0.0012
	JS		*TPGT070101F-JS TPGT070102F-JS TPGT070104F-JS	●	0.172	0.063	0.102	0.004

Trigon 80°, Positive 5°

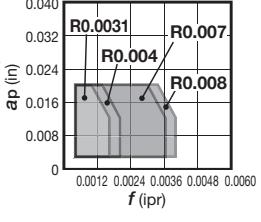
Application	Chipbreaker	$f - ap$	Cat. No.	Grade	Dimensions (in)			
				Coated	I.C. dia.	Thickness	Hole dia.	Corner radius
				SH725	$\varnothing d$	s	$\varnothing d_1$	r_ϵ
Finishing (Internal, sharp edge)	W08		WBGT030100FR-W08 WBGT030100FL-W08 WBGT030101FR-W08 WBGT030101FL-W08 * WBGT030102FR-W08 WBGT030102FL-W08 WBGT030104FR-W08 WBGT030104FL-W08	●	0.219	0.063	0.091	0.0012
	JS		*WBGT030101FR-JS WBGT030101FL-JS WBGT030102FR-JS WBGT030102FL-JS WBGT030104FR-JS WBGT030104FL-JS	●	0.219	0.063	0.091	0.004

Note: Chipbreaker that shows the cross section is marked with * on the designation.

Rhombic 35°, Positive 5°

Application	Appearance (Cross section)	Chipbreaker	$f - ap$	Cat. No.	Grade	Dimensions (in)			
					Coated	I.C. dia.	Thickness	Hole dia.	Corner radius
					SH725	ød	s	ød1	r_ϵ
		JS		VBGT110300FN-JS *VBGT110301FN-JS VBGT110302FN-JS VBGT110304FN-JS	●	0.250	0.125	0.110	0.0012
Finishing to medium cutting (External, sharp edge)		J10		VBGT110300FR-J10 VBGT110300FL-J10 *VBGT110301FR-J10 VBGT110301FL-J10 VBGT110302FR-J10 VBGT110302FL-J10 VBGT110304FR-J10 VBGT110304FL-J10	●	0.250	0.125	0.110	0.0012

Rhombic 35°, Positive 11°

Application	Appearance (Cross section)	Chipbreaker	$f - ap$	Cat. No.	Grade	Dimensions (in)			
					Coated	I.C. dia.	Thickness	Hole dia.	Corner radius
					SH725	ød	s	ød1	r_ϵ
		JRP		VPET0802008MFR-JRP VPET080201MFR-JRP VPET080201MFL-JRP VPET0802018MFR-JRP VPET0802018MFL-JRP VPET080202MFR-JRP VPET080202MFL-JRP VPET1103008MFR-JRP VPET110301MFR-JRP VPET110301MFL-JRP VPET1103018MFR-JRP VPET1103018MFL-JRP *VPET110302MFR-JRP VPET110302MFL-JRP	●	0.187	0.094	0.091	< 0.003*
Finishing (External, sharp edge)					●	0.187	0.094	0.091	< 0.004*
					●	0.187	0.094	0.091	< 0.004*
					●	0.187	0.094	0.091	< 0.007*
					●	0.187	0.094	0.091	< 0.007*
					●	0.187	0.094	0.091	< 0.008*
					●	0.187	0.094	0.091	< 0.008*
					●	0.250	0.125	0.110	< 0.003*
					●	0.250	0.125	0.110	< 0.004*
					●	0.250	0.125	0.110	< 0.004*
					●	0.250	0.125	0.110	< 0.007*
					●	0.250	0.125	0.110	< 0.007*
					●	0.250	0.125	0.110	< 0.008*
					●	0.250	0.125	0.110	< 0.008*

* Minus tolerance of corner radius.

Note: Chipbreaker that shows the cross section is marked with * on the designation.

Rhombic 35°, Positive 11°

J-SERIES

Application	Appearance (Cross section)	f - ap	Cat. No.	Grade	Dimensions (in)			
				Coated	I.C. dia.	Thickness	Hole dia.	Corner radius
				SH725	ød	s	ød1	r _ε
	JPP		VPET0802008MFR-JPP VPET0802008MFL-JPP VPET080201MFR-JPP VPET080201MFL-JPP VPET0802018MFR-JPP VPET0802018MFL-JPP VPET080202MFR-JPP VPET080202MFL-JPP VPET1103008MFR-JPP VPET110301MFR-JPP VPET110301MFL-JPP VPET1103018MFR-JPP *VPET110302MFR-JPP VPET110302MFL-JPP	●	0.187	0.094	0.091	< 0.003*
Finishing (External, sharp edge)				●	0.187	0.094	0.091	< 0.003*
	JSP		VPET0802008MFN-JSP VPET080201MFN-JSP VPET0802018MFN-JSP VPET080202MFN-JSP VPET1103008MFN-JSP VPET110301MFN-JSP VPET1103018MFN-JSP *VPET110302MFN-JSP	●	0.187	0.094	0.091	< 0.003*
				●	0.187	0.094	0.091	< 0.004*
				●	0.187	0.094	0.091	< 0.004*
				●	0.187	0.094	0.091	< 0.007*
				●	0.187	0.094	0.091	< 0.008*
				●	0.250	0.125	0.110	< 0.003*
				●	0.250	0.125	0.110	< 0.004*
				●	0.250	0.125	0.110	< 0.004*
				●	0.250	0.125	0.110	< 0.007*
				●	0.250	0.125	0.110	< 0.008*
				●	0.250	0.125	0.110	< 0.008*

* Minus tolerance of corner radius.

Back turning

Application	Appearance	f - ap	Cat. No.	Grade	Dimensions (in)			
				Coated	I.C. dia.	Thickness	Hole dia.	Corner radius
				SH725	ød	s	ød1	r _ε
	JTB		JTBR3000F JTBL3000F JTBR3005F JTBL3005F JTBR3010F JTBL3010F JTBR3015F JTBL3015F	●	0.372	0.125	0.098	0.0012
Back turning (sharp edge)				●	0.372	0.125	0.098	0.0012
	J10E		J10ER005BF J10EL005BF J10ER010BF J10EL010BF J10ER015BF J10EL015BF	●	0.250	0.125	0.118	0.002
				●	0.250	0.125	0.118	0.002
				●	0.250	0.125	0.118	0.004
				●	0.250	0.125	0.118	0.004
				●	0.250	0.125	0.118	0.006
				●	0.250	0.125	0.118	0.006

Note: Chipbreaker that shows the cross section is marked with * on the designation.

Grooving

J-SERIES

Application	Chipbreaker Appearance	Cat. No.	Grade	Dimensions (in)				
			Coated	I.C. dia. ød	Thickness s	Cutting edge width W	Max.groove depth ar	Corner radius r_ε
			SH725					
JVG		JVGR033F	●	0.313	0.125	0.013	0.028	-
		JVGL033F	●	0.313	0.125	0.013	0.028	-
		JVGR050F	●	0.313	0.125	0.020	0.043	-
		JVGL050F	●	0.313	0.125	0.020	0.043	-
		JVGR075F	●	0.313	0.125	0.030	0.075	-
		JVGL075F	●	0.313	0.125	0.030	0.075	-
		JVGR095F	●	0.313	0.125	0.037	0.075	-
		JVGL095F	●	0.313	0.125	0.037	0.075	-
		JVGR100F	●	0.313	0.125	0.039	0.217	-
		JVGL100F	●	0.313	0.125	0.039	0.217	-
		JVGR125F	●	0.313	0.125	0.049	0.197	-
		JVGL125F	●	0.313	0.125	0.049	0.197	-
		JVGR150F	●	0.313	0.125	0.059	0.217	-
		JVGL150F	●	0.313	0.125	0.059	0.217	-
JTG		JTGR3033F	●	0.375	0.125	0.013	0.028	0.0012
		JTGR3033F-005	●	0.375	0.125	0.013	0.028	0.002
		JTGR3050F	●	0.375	0.125	0.020	0.043	0.0012
		JTGL3050F	●	0.375	0.125	0.020	0.043	0.0012
		JTGR3050F-005	●	0.375	0.125	0.020	0.043	0.002
		JTGL3050F-005	●	0.375	0.125	0.020	0.043	0.002
		JTGR3065F	●	0.375	0.125	0.026	0.075	0.0012
		JTGR3065F-010	●	0.375	0.125	0.026	0.075	0.004
		JTGR3075F	●	0.375	0.125	0.030	0.075	0.0012
		JTGL3075F	●	0.375	0.125	0.030	0.075	0.0012
		JTGR3075F-010	●	0.375	0.125	0.030	0.075	0.004
		JTGL3075F-010	●	0.375	0.125	0.030	0.075	0.004
		JTGR3080F	●	0.375	0.125	0.031	0.075	0.0012
		JTGR3080F-010	●	0.375	0.125	0.031	0.075	0.004
		JTGR3085F	●	0.375	0.125	0.033	0.075	0.0012
		JTGR3095F	●	0.375	0.125	0.037	0.075	0.0012
		JTGL3095F	●	0.375	0.125	0.037	0.075	0.0012
		JTGR3095F-010	●	0.375	0.125	0.037	0.075	0.004
		JTGL3095F-010	●	0.375	0.125	0.037	0.075	0.004
		JTGR3100F	●	0.375	0.125	0.039	0.083	0.002
		JTGL3100F	●	0.375	0.125	0.039	0.083	0.002
		JTGR3100F-010	●	0.375	0.125	0.039	0.083	0.004
		JTGL3100F-010	●	0.375	0.125	0.039	0.083	0.004
		JTGR3110F	●	0.375	0.125	0.043	0.083	0.002
		JTGR3120F	●	0.375	0.125	0.047	0.083	0.002
		JTGR3120F-010	●	0.375	0.125	0.047	0.083	0.004

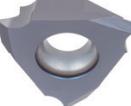
Note: Chipbreaker Cross section is marked * next to the Cat. No.

Grooving

J-SERIES

Application	Appearance	Cat. No.	Grade	Dimensions (in)					
			Coated	I.C. dia. ød	Thickness s	Cutting edge width W	Max.groove depth ar		
			SH725						
Grooving (sharp edge)		JTG	JTGR3125F	●	0.375	0.125	0.049	0.083	0.002
			JTGL3125F	●	0.375	0.125	0.049	0.083	0.002
			JTGR3125F-010	●	0.375	0.125	0.049	0.083	0.004
			JTGL3125F-010	●	0.375	0.125	0.049	0.083	0.004
			JTGR3130F	●	0.375	0.125	0.051	0.083	0.002
			JTGR3140F	●	0.375	0.125	0.055	0.083	0.002
			JTGR3140F-010	●	0.375	0.125	0.055	0.083	0.004
			JTGR3145F	●	0.375	0.125	0.057	0.083	0.002
			JTGR3145F-010	●	0.375	0.125	0.057	0.083	0.004
			JTGR3150F	●	0.375	0.125	0.059	0.083	0.002
			JTGL3150F	●	0.375	0.125	0.059	0.083	0.002
			JTGR3150F-010	●	0.375	0.125	0.059	0.083	0.004
			JTGL3150F-010	●	0.375	0.125	0.059	0.083	0.004
			JTGR3175F	●	0.375	0.125	0.069	0.083	0.002
			JTGR3175F-010	●	0.375	0.125	0.069	0.083	0.004
			JTGR3180F	●	0.375	0.125	0.071	0.083	0.002
			JTGR3200F	●	0.375	0.125	0.079	0.102	0.002
			JTGL3200F	●	0.375	0.125	0.079	0.102	0.002
			JTGR3200F-010	●	0.375	0.125	0.079	0.102	0.004
			JTGL3200F-010	●	0.375	0.125	0.079	0.102	0.004
			JTGR3225F	●	0.375	0.125	0.089	0.102	0.002
			JTGR3250F	●	0.375	0.125	0.098	0.102	0.002
			JTGL3250F	●	0.375	0.125	0.098	0.102	0.002
			JTGR3250F-010	●	0.375	0.125	0.098	0.102	0.004
			JTGL3250F-010	●	0.375	0.125	0.098	0.102	0.004
			JTGR3300F	●	0.375	0.125	0.118	0.102	0.002
			JTGR3300F-010	●	0.375	0.125	0.118	0.102	0.004

Threading

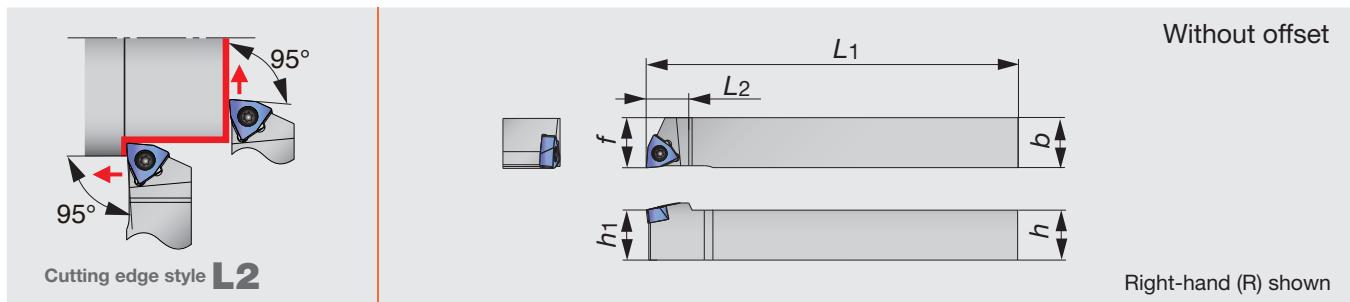
Application	Appearance	Cat. No.	Grade	Dimensions (in)				
			Coated	I.C. dia. ød	Thickness T	Cutting edge angle θ	Corner radius r_e	
			SH725					
Threading (sharp edge)		JTT	JTTR3005F-55	●	0.375	0.125	55°	0.002
			JTTR3005F	●	0.375	0.125	60°	0.002
			JTTL3005F	●	0.375	0.125	60°	0.002
			JTTR3010F	●	0.375	0.125	60°	0.004
			JTTL3010F	●	0.375	0.125	60°	0.004

Toolholders

JSWL2XR/L

External turning and facing

JS type (Positive rake, screw-on system)

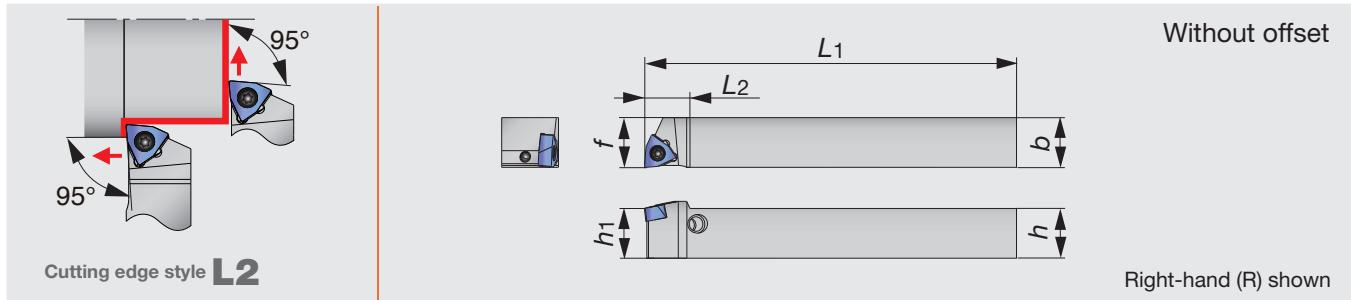


Inch	Dimensions (in)						Std. corner radius r_e	Insert	Parts		Torque (lb·ft)
	h	b	L_1	L_2	h_1	f			Clamping screw	Wrench	
JSWL2XR/L062	0.375	0.375	4.750	0.500	0.375	0.375	0.008	WXGU0403**L/R	SR34-514	T-7F	0.66
JSWL2XR/L082	0.500	0.500	4.750	0.500	0.500	0.500	0.008	WXGU0403**L/R	SR34-514	T-7F	0.66
JSWL2XR/L102	0.625	0.625	4.750	0.500	0.625	0.625	0.008	WXGU0403**L/R	SR34-514	T-7F	0.66

Metric	Dimensions (mm)						Std. corner radius r_e	Insert	Parts		Torque (N·m)
	h	b	L_1	L_2	h_1	f			Clamping screw	Wrench	
JSWL2XR/L1010X04	10	10	120	11	10	10	0.2	WXGU0403**L/R	SR34-514	T-7F	0.9
JSWL2XR/L1212F04	12	12	85	11	12	12	0.2	WXGU0403**L/R	SR34-514	T-7F	0.9
JSWL2XR/L1212X04	12	12	120	11	12	12	0.2	WXGU0403**L/R	SR34-514	T-7F	0.9
JSWL2XR/L1616X04	16	16	120	13	16	16	0.2	WXGU0403**L/R	SR34-514	T-7F	0.9
JSWL2XR/L2020H04	20	20	100	13	20	20	0.2	WXGU0403**L/R	SR34-514	T-7F	0.9

① Right-hand toolholders (R) are used with left-hand inserts (L)

② Left-hand toolholders (L) are used with right-hand inserts (R)

JPWL2XR/L External turning and facing JP type (Positive rake, side-clamping system)


Inch	Dimensions (in)						Std. corner radius r_e	Insert	Parts				Torque (lb·ft)
	<i>h</i>	<i>b</i>	<i>L₁</i>	<i>L₂</i>	<i>h₁</i>	<i>f</i>			Lever	Pin	Clamping screw	Wrench	
JPWL2XR/L062	0.375	0.375	4.750	0.500	0.375	0.375	0.008	WXGU0403**L/R	SLLV-2	SL-PI-2	SR10400611	HW 2.0/5	0.66
JPWL2XR/L082	0.500	0.500	4.750	0.500	0.500	0.500	0.008	WXGU0403**L/R	SLLV-2	SL-PI-2	SR10400611	HW 2.0/5	0.66
JPWL2XR/L102	0.625	0.625	4.750	0.500	0.625	0.625	0.008	WXGU0403**L/R	SLLV-2	SL-PI-2	SR10400611	HW 2.0/5	0.66

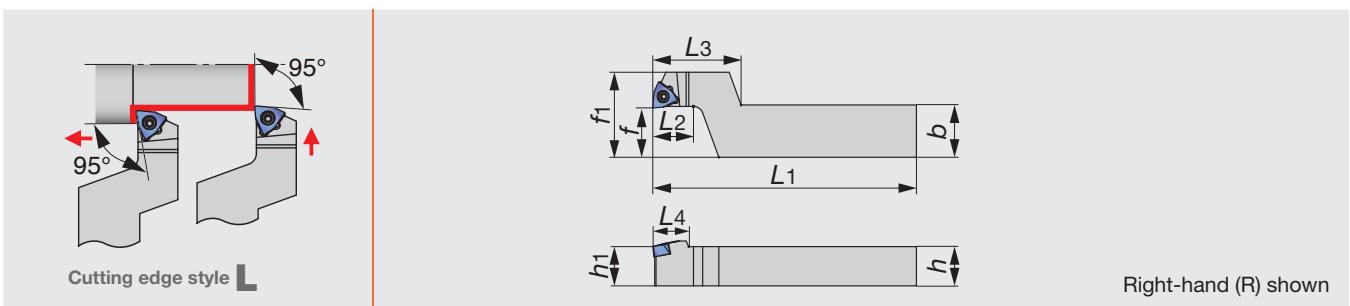
Metric	Dimensions (mm)						Std. corner radius r_e	Insert	Parts				Torque (N·m)
	<i>h</i>	<i>b</i>	<i>L₁</i>	<i>L₂</i>	<i>h₁</i>	<i>f</i>			Lever	Pin	Clamping screw	Wrench	
JPWL2XR/L1010X04	10	10	120	11	10	10	0.2	WXGU0403**L/R	SLLV-2	SL-PI-2	SR10400611	HW 2.0/5	0.9
JPWL2XR/L1212F04	12	12	85	11	12	12	0.2	WXGU0403**L/R	SLLV-2	SL-PI-2	SR10400611	HW 2.0/5	0.9
JPWL2XR/L1212X04	12	12	120	11	12	12	0.2	WXGU0403**L/R	SLLV-2	SL-PI-2	SR10400611	HW 2.0/5	0.9
JPWL2XR/L1616X04	16	16	120	13	16	16	0.2	WXGU0403**L/R	SLLV-2	SL-PI-2	SR10400611	HW 2.0/5	0.9

① Right-hand toolholders (R) are used with left-hand inserts (L)

② Left-hand toolholders (L) are used with right-hand inserts (R)

JSWLXR-F

External turning and facing Neck-down type (Positive rake, screw-on system)



Inch	Dimensions (in)									Std. corner radius r_ϵ	Insert	Parts		Torque (lb·ft)
	h	b	L ₁	L ₂	L ₃	L ₄	h ₁	f	f ₁			Clamping screw	Wrench	
JSWLXR082-F10	0.500	0.625	4.750	0.500	1.125	0.750	0.500	0.625	1.000	0.008	WXGU0403**L	SR34-514	T-7F	0.66
JSWLXR102-F10	0.625	0.750	4.750	0.500	1.125	0.750	0.625	0.625	1.000	0.008	WXGU0403**L	SR34-514	T-7F	0.66

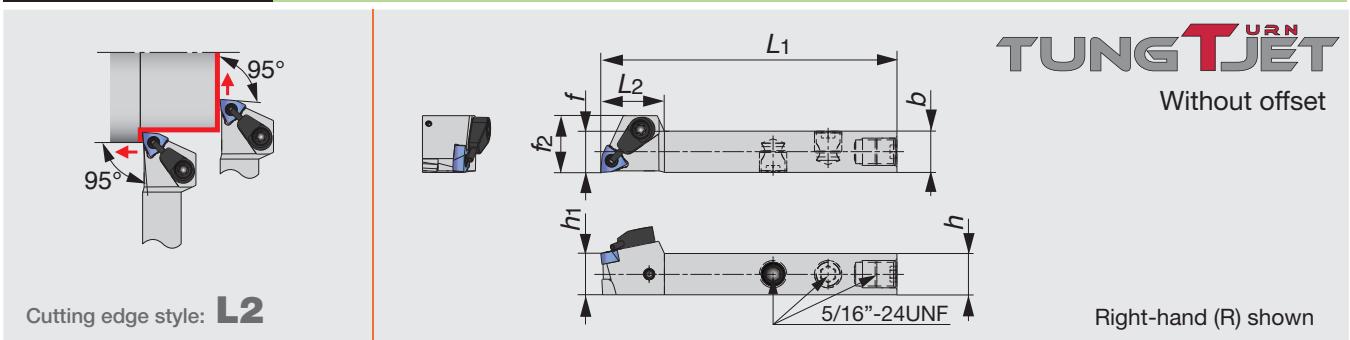
Metric	Dimensions (mm)									Std. corner radius r_ϵ	Insert	Parts		Torque (N·m)
	h	b	L ₁	L ₂	L ₃	L ₄	h ₁	f	f ₁			Clamping screw	Wrench	
JSWLXR1016X04-F15	10	16	120	12	27	11	10	15	26	0.2	WXGU0403**L	SR34-514	T-7F	0.9
JSWLXR1216F04-F15	12	16	85	12	27	11	12	15	26	0.2	WXGU0403**L	SR34-514	T-7F	0.9
JSWLXR1216X04-F15	12	16	120	12	27	11	12	15	26	0.2	WXGU0403**L	SR34-514	T-7F	0.9
JSWLXR1620X04-F15	16	20	120	12	27	11	16	15	26	0.2	WXGU0403**L	SR34-514	T-7F	0.9

① Right-hand toolholders (R) are used with left-hand inserts (L)

Works with high-pressure coolant

JSWL2XR/L-CHP

External turning and facing CHP type (Positive rake, screw-on system)



Inch	Dimensions (in)									Std. corner radius r_ϵ	Insert	Parts		Torque (lb·ft)
	h	b	L ₁	L ₂	h ₁	f	f ₂	Clamping screw	Wrench			Clamping screw	Wrench	
JSWL2XR/L082-CHP	0.500	0.500	3.344	0.750	0.500	0.500	0.650	0.008	WXGU0403**L/R	SR34-514	T-7F	0.66		

Metric	Dimensions (mm)									Std. corner radius r_ϵ	Insert	Parts		Torque (N·m)
	h	b	L ₁	L ₂	h ₁	f	f ₂	Clamping screw	Wrench			Clamping screw	Wrench	
JSWL2XR/L1212F04-CHP	12	12	85	18	12	12	16.5	0.2	WXGU0403**L/R	SR34-514	T-7F	0.9		

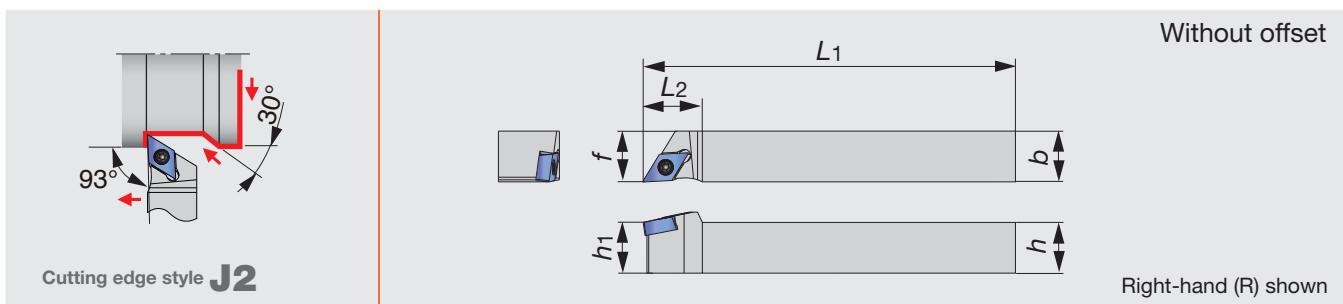
① Right-hand toolholders (R) are used with left-hand inserts (L)

② Left-hand toolholders (L) are used with right-hand inserts (R)

JSDJ2XR/L

External turning and profiling

JS type (Positive rake, screw-on system)



Cutting edge style **J2**

Without offset

Right-hand (R) shown

Inch	Dimensions (in)						Std. corner radius r_ϵ	Insert	Parts		Torque (lb·ft)
	<i>h</i>	<i>b</i>	<i>L</i> ₁	<i>L</i> ₂	<i>h</i> ₁	<i>f</i>			Clamping screw	Wrench	
JSDJ2XR/L062	0.375	0.375	4.750	0.625	0.375	0.375	0.008	DXGU0703**L/R	SR34-514	T-7F	0.66
JSDJ2XR/L082	0.500	0.500	4.750	0.625	0.500	0.500	0.008	DXGU0703**L/R	SR34-514	T-7F	0.66
JSDJ2XR/L102	0.625	0.625	4.750	0.625	0.625	0.625	0.008	DXGU0703**L/R	SR34-514	T-7F	0.66

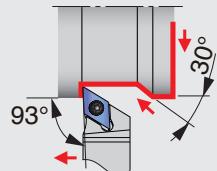
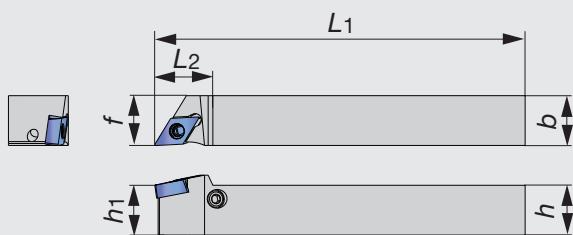
Metric	Dimensions (mm)						Std. corner radius r_ϵ	Insert	Parts		Torque (N·m)
	<i>h</i>	<i>b</i>	<i>L</i> ₁	<i>L</i> ₂	<i>h</i> ₁	<i>f</i>			Clamping screw	Wrench	
JSDJ2XR/L1010X07	10	10	120	14	10	10	0.2	DXGU0703**L/R	SR34-514	T-7F	0.9
JSDJ2XR/L1212F07	12	12	85	14	12	12	0.2	DXGU0703**L/R	SR34-514	T-7F	0.9
JSDJ2XR/L1212X07	12	12	120	14	12	12	0.2	DXGU0703**L/R	SR34-514	T-7F	0.9
JSDJ2XR/L1616X07	16	16	120	18	16	16	0.2	DXGU0703**L/R	SR34-514	T-7F	0.9
JSDJ2XR/L2020H07	20	20	100	18	20	20	0.2	DXGU0703**L/R	SR34-514	T-7F	0.9

① Right-hand toolholders (R) are used with left-hand inserts (L)

② Left-hand toolholders (L) are used with right-hand inserts (R)

JPDJ2XR/L

External turning and profiling JP type (Positive rake, side-clamping system)

Cutting edge style **J2**

Without offset

Right-hand (R) shown

Inch	Dimensions (in)						Std. corner radius r_ϵ	Insert	Parts				Torque (lb·ft)
	<i>h</i>	<i>b</i>	<i>L</i> ₁	<i>L</i> ₂	<i>h</i> ₁	<i>f</i>			Lever	Pin	Clamping screw	Wrench	
JPDJ2XR/L062	0.375	0.375	4.750	0.625	0.375	0.375	0.008	DXGU0703**L/R	SLLV-2	SL-PI-2	SR10400611	HW 2.0/5	0.66
JPDJ2XR/L082	0.500	0.500	4.750	0.625	0.500	0.500	0.008	DXGU0703**L/R	SLLV-2	SL-PI-2	SR10400611	HW 2.0/5	0.66
JPDJ2XR/L102	0.625	0.625	4.750	0.625	0.625	0.625	0.008	DXGU0703**L/R	SLLV-2	SL-PI-2	SR10400611	HW 2.0/5	0.66

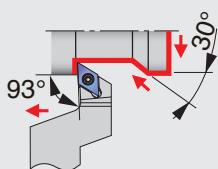
Metric	Dimensions (mm)						Std. corner radius r_ϵ	Insert	Parts				Torque (N·m)
	<i>h</i>	<i>b</i>	<i>L</i> ₁	<i>L</i> ₂	<i>h</i> ₁	<i>f</i>			Lever	Pin	Clamping screw	Wrench	
JPDJ2XR/L1010X07	10	10	120	14	10	10	0.2	DXGU0703**L/R	SLLV-2	SL-PI-2	SR10400611	HW 2.0/5	0.9
JPDJ2XR/L1212F07	12	12	85	14	12	12	0.2	DXGU0703**L/R	SLLV-2	SL-PI-2	SR10400611	HW 2.0/5	0.9
JPDJ2XR/L1212X07	12	12	120	14	12	12	0.2	DXGU0703**L/R	SLLV-2	SL-PI-2	SR10400611	HW 2.0/5	0.9
JPDJ2XR/L1616X07	16	16	120	18	16	16	0.2	DXGU0703**L/R	SLLV-2	SL-PI-2	SR10400611	HW 2.0/5	0.9

① Right-hand toolholders (R) are used with left-hand inserts (L)

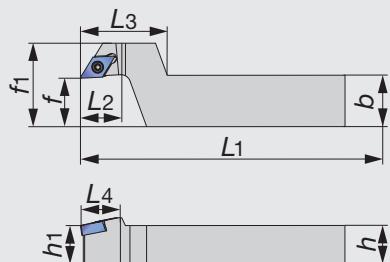
② Left-hand toolholders (L) are used with right-hand inserts (R)

JSDJXR-F

External turning and profiling Neck-down type (Positive rake, screw-on system)



Cutting edge style **J**



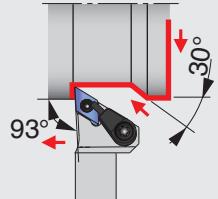
Right-hand (R) shown

Inch	Dimensions (in)										Std. corner radius r_ϵ	Insert	Parts		Torque (lb·ft)
	h	b	L_1	L_2	L_3	L_4	h_1	f	f_1	Clamping screw			Wrench		
JSDJXR082-F10	0.500	0.625	4.750	0.500	1.125	0.625	0.500	0.625	1.000	0.008	DXGU0703**L	SR34-514	T-7F	0.66	
JSDJXR102-F10	0.625	0.750	4.750	0.500	1.125	0.625	0.625	0.625	1.000	0.008	DXGU0703**L	SR34-514	T-7F	0.66	
Metric	Dimensions (mm)										Std. corner radius r_ϵ	Insert	Parts		Torque (N·m)
	h	b	L_1	L_2	L_3	L_4	h_1	f	f_1	Clamping screw			Wrench		
JSDJXR1016X07-F15	10	16	120	12	27	14	10	15	26	0.2	DXGU0703**L	SR34-514	T-7F	0.9	
JSDJXR1216F07-F15	12	16	85	12	27	14	12	15	26	0.2	DXGU0703**L	SR34-514	T-7F	0.9	
JSDJXR1216X07-F15	12	16	120	12	27	14	12	15	26	0.2	DXGU0703**L	SR34-514	T-7F	0.9	
JSDJXR1620X07-F15	16	20	120	12	27	14	16	15	26	0.2	DXGU0703**L	SR34-514	T-7F	0.9	

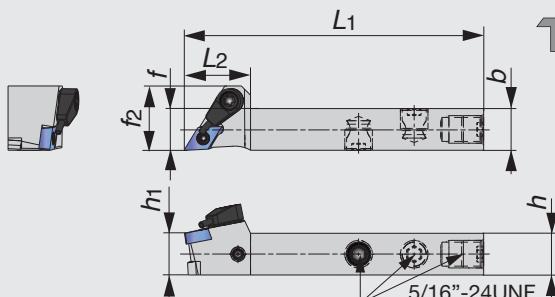
① Right-hand toolholders (R) are used with left-hand inserts (L)

Works with high-pressure coolant

JSDJ2XR/L-CHP External turning and profiling CHP type (Positive rake, screw-on system)



Cutting edge style: **J2**



TUNG TURN
Without offset

Right-hand (R) shown

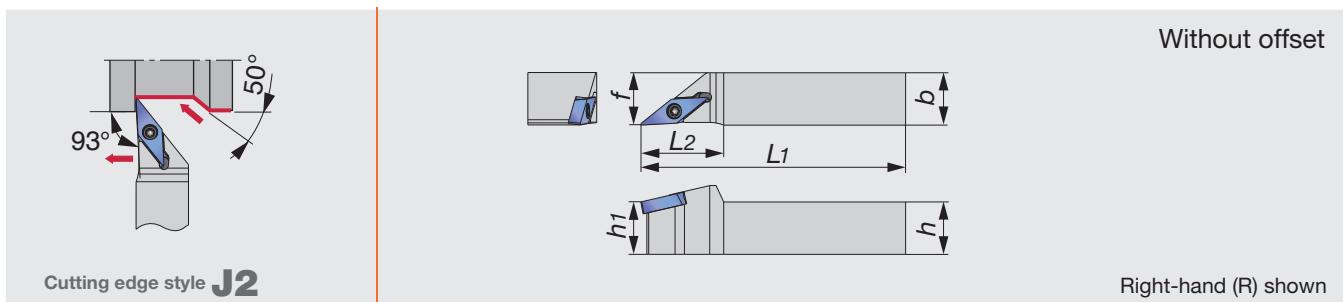
Inch	Dimensions (in)										Std. corner radius r_ϵ	Insert	Parts		Torque (lb·ft)
	h	b	L_1	L_2	h_1	f	f_2	Clamping screw	Wrench	Clamping screw			Wrench		
JSDJ2XR/L082-CHP	0.500	0.500	3.344	0.750	0.500	0.500	0.730	0.008	DXGU0703**L/R	SR34-514	T-7F	0.66			
Metric	Dimensions (mm)										Std. corner radius r_ϵ	Insert	Parts		Torque (N·m)
	h	b	L_1	L_2	h_1	f	f_2	Clamping screw	Wrench	Clamping screw			Wrench		
JSDJ2XR/L1212F07-CHP	12	12	85	19	12	12	18.5	0.2	DXGU0703**L/R	SR34-514	T-7F	0.9			

① Right-hand toolholders (R) are used with left-hand inserts (L)

② Left-hand toolholders (L) are used with right-hand inserts (R)

JSVJ2XR/L**External turning and profiling**

JS type (Positive rake, screw-on system)

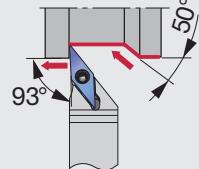


Inch	Dimensions (in)						Std. corner radius r_ϵ	Insert	Parts		Torque (lb·ft)
	<i>h</i>	<i>b</i>	<i>L₁</i>	<i>L₂</i>	<i>h₁</i>	<i>f</i>			Clamping screw	Wrench	
JSVJ2XR/L067	0.375	0.375	4.750	0.669	0.375	0.375	0.008	VXGU09T2**L/R	SR34-508	T-7F	0.66
JSVJ2XR/L087	0.500	0.500	4.750	0.748	0.500	0.500	0.008	VXGU09T2**L/R	SR34-508	T-7F	0.66
JSVJ2XR/L107	0.625	0.625	4.750	0.748	0.625	0.625	0.008	VXGU09T2**L/R	SR34-508	T-7F	0.66

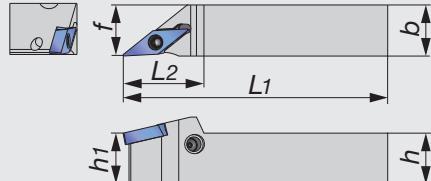
Metric	Dimensions (mm)						Std. corner radius r_ϵ	Insert	Parts		Torque (N·m)
	<i>h</i>	<i>b</i>	<i>L₁</i>	<i>L₂</i>	<i>h₁</i>	<i>f</i>			Clamping screw	Wrench	
JSVJ2XR/L1010X09	10	10	120	17	10	10	0.2	VXGU09T2**L/R	SR34-508	T-7F	0.9
JSVJ2XR/L1212F09	12	12	85	19	12	12	0.2	VXGU09T2**L/R	SR34-508	T-7F	0.9
JSVJ2XR/L1212X09	12	12	120	19	12	12	0.2	VXGU09T2**L/R	SR34-508	T-7F	0.9
JSVJ2XR/L1616X09	16	16	120	19	16	16	0.2	VXGU09T2**L/R	SR34-508	T-7F	0.9
JSVJ2XR/L2020H09	20	20	100	19	20	20	0.2	VXGU09T2**L/R	SR34-508	T-7F	0.9

① Right-hand toolholders (R) are used with left-hand inserts (L)

② Left-hand toolholders (L) are used with right-hand inserts (R)

JPVJ2XR/L External turning and profiling JP type (Positive rake, side-clamping system)

Cutting edge style J2

Without offset

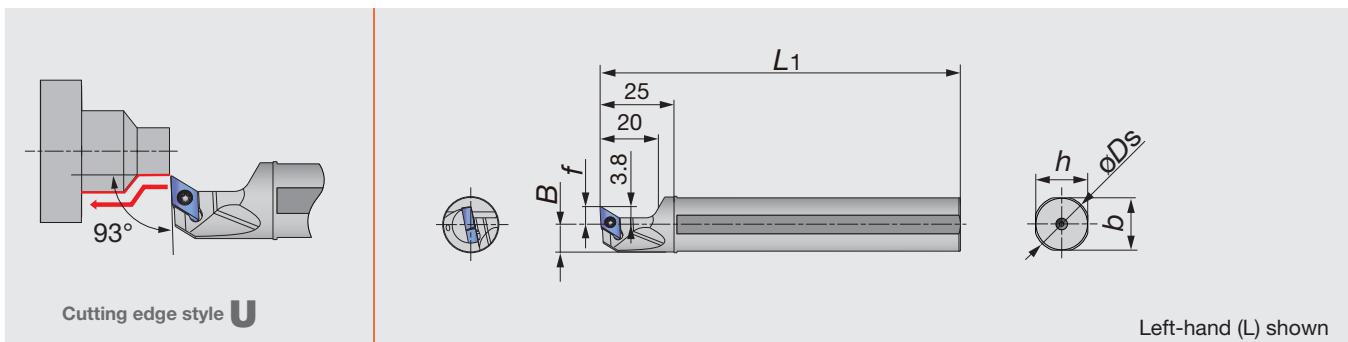


Inch	Dimensions (in)						Std. corner radius r_e	Insert	Parts				Torque (lb·ft)
	<i>h</i>	<i>b</i>	<i>L</i> ₁	<i>L</i> ₂	<i>h</i> ₁	<i>f</i>			Lever	Pin	Clamping screw	Wrench	
JPVJ2XR/L067	0.375	0.375	4.750	0.669	0.375	0.375	0.008	VXGU09T2**L/R	SLLV-1	SL-PI-2	SR 10400611	HW 2.0/5 RED	0.66
JPVJ2XR/L087	0.500	0.500	4.750	0.748	0.500	0.500	0.008	VXGU09T2**L/R	SLLV-1	SL-PI-2	SR 10400611	HW 2.0/5 RED	0.66
JPVJ2XR/L107	0.625	0.625	4.750	0.748	0.625	0.625	0.008	VXGU09T2**L/R	SLLV-1	SL-PI-2	SR 10400611	HW 2.0/5 RED	0.66

Metric	Dimensions (mm)						Std. corner radius r_e	Insert	Parts				Torque (N·m)
	<i>h</i>	<i>b</i>	<i>L</i> ₁	<i>L</i> ₂	<i>h</i> ₁	<i>f</i>			Lever	Pin	Clamping screw	Wrench	
JPVJ2XR/L1010X09	10	10	120	19	10	10	0.2	VXGU09T2**L/R	SLLV-1	SL-PI-2	SR 10400611	HW 2.0/5 RED	0.9
JPVJ2XR/L1212F09	12	12	85	19	12	12	0.2	VXGU09T2**L/R	SLLV-1	SL-PI-2	SR 10400611	HW 2.0/5 RED	0.9
JPVJ2XR/L1212X09	12	12	120	19	12	12	0.2	VXGU09T2**L/R	SLLV-1	SL-PI-2	SR 10400611	HW 2.0/5 RED	0.9
JPVJ2XR/L1616X09	16	16	120	19	16	16	0.2	VXGU09T2**L/R	SLLV-1	SL-PI-2	SR 10400611	HW 2.0/5 RED	0.9

① Right-hand toolholders (R) are used with left-hand inserts (L)

② Left-hand toolholders (L) are used with right-hand inserts (R)

JS-SDUXL**External turning and profiling****JS type (Positive rake, screw-on system)**

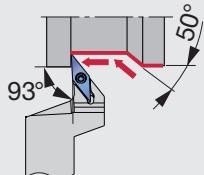
Inch	Dimensions (in)					Std. corner radius r_ϵ	Insert	Parts		Torque (lb·ft)
	ϕD_s	f	L_1	h/b	B			Clamping screw	Wrench	
JS159F-SDUXL07	0.625	0.236	3.346	0.591	0.303	0.008	DXGU0703**L	SR34-514	T-7F	0.66
JS19G-SDUXL07	0.750	0.236	3.543	0.709	0.366	0.008	DXGU0703**L	SR34-514	T-7F	0.66
JS19X-SDUXL07	0.750	0.236	4.724	0.709	0.366	0.008	DXGU0703**L	SR34-514	T-7F	0.66
JS254X-SDUXL07	1.000	0.394	4.724	0.945	0.492	0.008	DXGU0703**L	SR34-514	T-7F	0.66

Metric	Dimensions (mm)					Std. corner radius r_ϵ	Insert	Parts		Torque (N·m)
	ϕD_s	f	L_1	h/b	B			Clamping screw	Wrench	
JS14H-SDUXL07	14	6	100	13	6.75	0.2	DXGU0703**L	SR34-514	T-7F	0.9
JS159F-SDUXL07	15.875	6	85	15	7.687	0.2	DXGU0703**L	SR34-514	T-7F	0.9
JS16F-SDUXL07	16	6	85	15	7.75	0.2	DXGU0703**L	SR34-514	T-7F	0.9
JS19G-SDUXL07	19.05	6	90	18	9.275	0.2	DXGU0703**L	SR34-514	T-7F	0.9
JS19X-SDUXL07	19.05	6	120	18	9.275	0.2	DXGU0703**L	SR34-514	T-7F	0.9
JS20G-SDUXL07	20	6	90	19	9.75	0.2	DXGU0703**L	SR34-514	T-7F	0.9
JS20X-SDUXL07	20	6	120	19	9.75	0.2	DXGU0703**L	SR34-514	T-7F	0.9
JS22X-SDUXL07	22.0	10	120	21	10.75	0.2	DXGU0703**L	SR34-514	T-7F	0.9
JS25H-SDUXL07	25.0	10	100	24	12.25	0.2	DXGU0703**L	SR34-514	T-7F	0.9
JS254X-SDUXL07	25.4	10	120	24	12.45	0.2	DXGU0703**L	SR34-514	T-7F	0.9

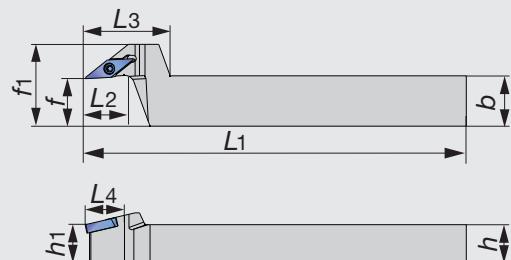
① Left-hand toolholders (L) are used with left-hand inserts (L)

JSVJXR-F

External turning and profiling Neck-down type (Positive rake, screw-on system)



Cutting edge style **J**



Right-hand (R) shown

Inch	Dimensions (in)									Std. corner radius r_ϵ	Insert	Parts		Torque (lb·ft)
	<i>h</i>	<i>b</i>	<i>L</i> ₁	<i>L</i> ₂	<i>L</i> ₃	<i>L</i> ₄	<i>h</i> ₁	<i>f</i>	<i>f</i> ₁			Clamping screw	Wrench	
JSVJXR087-F10	0.500	0.625	4.750	0.500	1.125	0.750	0.500	0.625	1.000	0.008	VXGU09T2**L	SR34-508	T-7F	0.66
JSVJXR107-F10	0.625	0.750	4.750	0.500	1.125	0.750	0.500	0.625	1.000	0.008	VXGU09T2**L	SR34-508	T-7F	0.66
Metric	Dimensions (mm)									Std. corner radius r_ϵ	Insert	Parts		Torque (N·m)
	<i>h</i>	<i>b</i>	<i>L</i> ₁	<i>L</i> ₂	<i>L</i> ₃	<i>L</i> ₄	<i>h</i> ₁	<i>f</i>	<i>f</i> ₁			Clamping screw	Wrench	
JSVJXR1016X09-F15	10	16	120	12	27	19	10	15	26	0.2	VXGU09T2**L	SR34-508	T-7F	0.9
JSVJXR1216F09-F15	12	16	85	12	27	19	12	15	26	0.2	VXGU09T2**L	SR34-508	T-7F	0.9
JSVJXR1216X09-F15	12	16	120	12	27	19	12	15	26	0.2	VXGU09T2**L	SR34-508	T-7F	0.9
JSVJXR1620X09-F15	16	20	120	12	27	19	16	15	26	0.2	VXGU09T2**L	SR34-508	T-7F	0.9

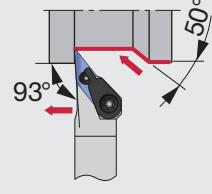
① Right-hand toolholders (R) are used with left-hand inserts (L)

MINIFURN

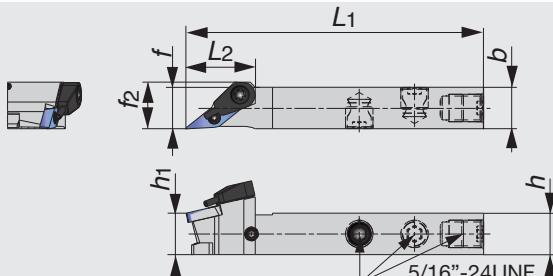
Works with high-pressure coolant

JSVJ2XR/L-CHP External turning and profiling

CHP type (Positive rake, screw-on system)



Cutting edge style **J2**



TUNG TURN
Without offset

Inch	Dimensions (in)							Std. corner radius r_ϵ	Insert	Parts		Torque (lb·ft)
	<i>h</i>	<i>b</i>	<i>L</i> ₁	<i>L</i> ₂	<i>h</i> ₁	<i>f</i>	<i>f</i> ₂			Clamping screw	Wrench	
JSVJ2XR/L087-CHP	0.500	0.500	4.750	0.748	0.500	0.500	0.531	0.008	VXGU09T2**L/R	SR34-508	T-7F	0.66
Metric	Dimensions (mm)							Std. corner radius r_ϵ	Insert	Parts		Torque (N·m)
	<i>h</i>	<i>b</i>	<i>L</i> ₁	<i>L</i> ₂	<i>h</i> ₁	<i>f</i>	<i>f</i> ₂			Clamping screw	Wrench	
JSVJ2XR/L1212F09-CHP	12	12	85	17.5	12	12	13.5	0.2	VXGU09T2**L/R	SR34-508	T-7F	0.9

① Right-hand toolholders (R) are used with left-hand inserts (L)

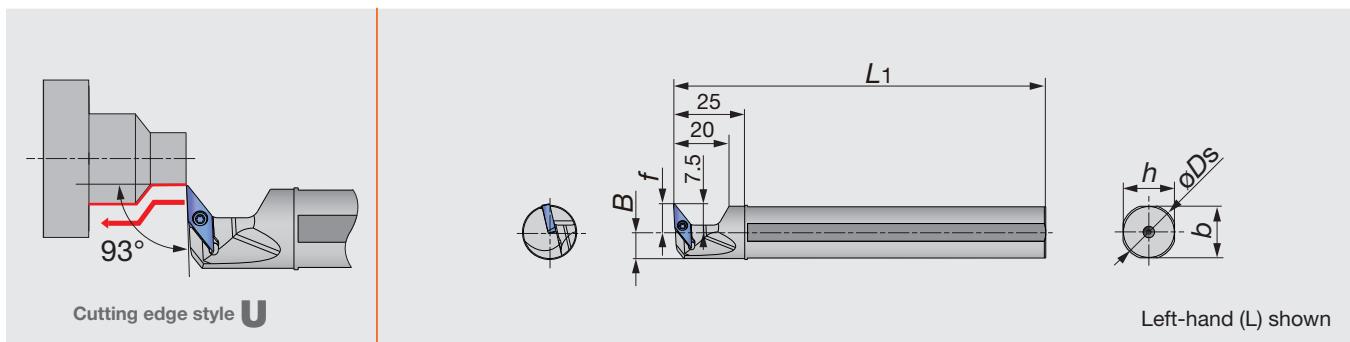
② Left-hand toolholders (L) are used with right-hand inserts (R)

TungTurn-Jet parts
P57 - 58

JS-SVUXL

External turning and profiling

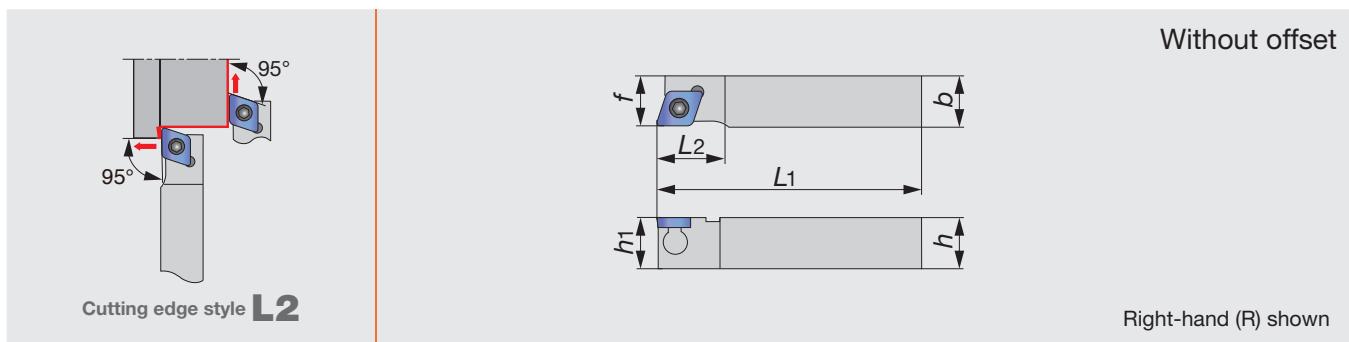
JS type (Positive rake, screw-on system)



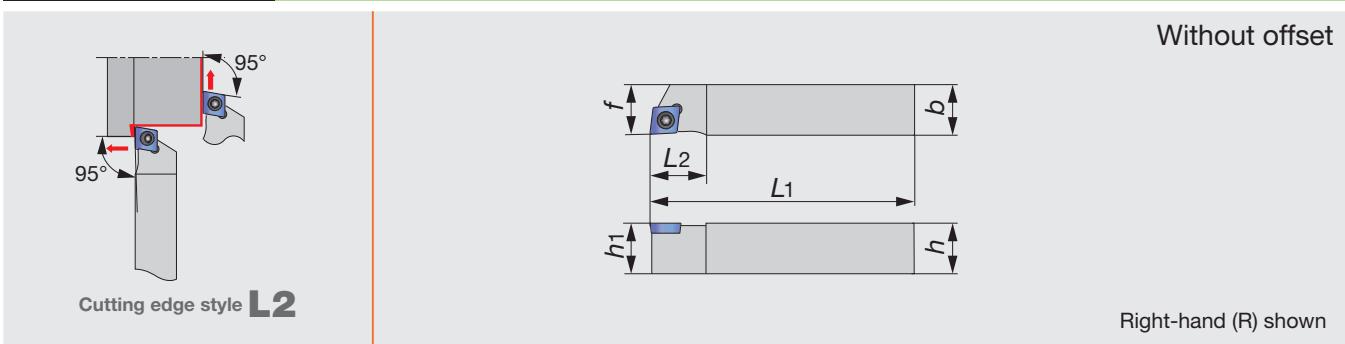
Inch	Dimensions (in)					Std. corner radius r_e	Insert	Parts		Torque (lb·ft)
	ϕD_s	f	L_1	h/b	B			Clamping screw	Wrench	
JS159F-SVUXL09	0.625	0.394	3.346	0.591	0.303	0.008	VXGU09T2**L	SR34-508	T-7F	0.66
JS19G-SVUXL09	0.750	0.394	3.543	0.709	0.362	0.008	VXGU09T2**L	SR34-508	T-7F	0.66
JS19G-SVUXL09	0.750	0.394	4.724	0.709	0.362	0.008	VXGU09T2**L	SR34-508	T-7F	0.66
JS254X-SVUXL09	1.000	0.394	4.724	0.945	0.488	0.008	VXGU09T2**L	SR34-508	T-7F	0.66

Metric	Dimensions (mm)					Std. corner radius r_e	Insert	Parts		Torque (N·m)
	ϕD_s	f	L_1	h/b	B			Clamping screw	Wrench	
JS159F-SVUXL09	15.875	10	85	15	7.7	0.2	VXGU09T2**L	SR34-508	T-7F	0.9
JS16F-SVUXL09	16	10	85	15	7.7	0.2	VXGU09T2**L	SR34-508	T-7F	0.9
JS19G-SVUXL09	19.05	10	90	18	9.2	0.2	VXGU09T2**L	SR34-508	T-7F	0.9
JS19X-SVUXL09	19.05	10	120	18	9.2	0.2	VXGU09T2**L	SR34-508	T-7F	0.9
JS20G-SVUXL09	20	10	90	19	9.7	0.2	VXGU09T2**L	SR34-508	T-7F	0.9
JS20X-SVUXL09	20	10	120	19	9.7	0.2	VXGU09T2**L	SR34-508	T-7F	0.9
JS22X-SVUXL09	22	10	120	21	10.7	0.2	VXGU09T2**L	SR34-508	T-7F	0.9
JS25H-SVUXL09	25	10	100	24	12.2	0.2	VXGU09T2**L	SR34-508	T-7F	0.9
JS254X-SVUXL09	25.4	10	120	24	12.4	0.2	VXGU09T2**L	SR34-508	T-7F	0.9

① Left-hand toolholders (L) are used with left-hand inserts (L)

JTCL2CR/L External turning and facing JT type (Positive rake, back-clamping system)


Cat. No.	Dimensions (mm)						Standard corner radius r_E	Insert	Parts			Torque (N·m)
	<i>h</i>	<i>b</i>	<i>L₁</i>	<i>L₂</i>	<i>h₁</i>	<i>f</i>			Clamp	Clamping screw	Wrench	
JTCL2CR/L0810K06	8	10	125	12	8	10	0.4	CC**0602	JCP-2	JDS-3525	P-2F	0.9
JTCL2CR/L1010X06	10	10	120	12	10	10	0.2	CC**0602	JCP-2	JDS-3525	P-2F	0.9
JTCL2CR/L1010K06	10	10	125	12	10	10	0.4	CC**0602	JCP-2	JDS-3525	P-2F	0.9
JTCL2CR/L1212F09	12	12	85	16	12	12	0.2	CC**09T3	JCP-3	JDS-5040	P-2.5F	1.2
JTCL2CR/L1212X09	12	12	120	16	12	12	0.2	CC**09T3	JCP-3	JDS-5040	P-2.5F	1.2
JTCL2CR/L1212M09	12	12	150	16	12	12	0.8	CC**09T3	JCP-3	JDS-5040	P-2.5F	1.2
JTCL2CR/L1616X09	16	16	120	16	16	16	0.2	CC**09T3	JCP-3	JDS-5040	P-2.5F	1.2
JTCL2CR/L1616M09	16	16	125	16	16	16	0.8	CC**09T3	JCP-3	JDS-5040	P-2.5F	1.2

JSCL2CR/L External turning and facing JS type (Positive rake, screw-on system)


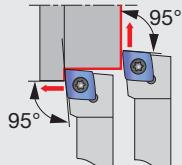
Inch	Dimensions (in)						Standard corner radius r_ε	Insert	Parts		Torque (lb·ft)
	h	b	L_1	L_2	h_1	f			Clamping screw	Wrench	
JSCL2CR/L062	0.375	0.375	5.000	0.400	0.375	0.375	0.016	CC**0602	CSTB-2.5	T-8F	0.89
JSCL2CR/L082	0.500	0.500	5.000	0.400	0.500	0.500	0.016	CC**0602	CSTB-2.5	T-8F	0.89
JSCL2CR/L103	0.625	0.625	5.000	0.680	0.625	0.625	0.016	CC**09T3	CSTB-2.5	T-8F	0.89

Metric	Dimensions (mm)						Standard corner radius r_ε	Insert	Parts		Torque (N·m)
	h	b	L_1	L_2	h_1	f			Clamping screw	Wrench	
JSCL2CR/L1010X06	10	10	120	12	10	10	0.2	CC**0602	CSTB-2.5	T-8F	1.2
JSCL2CR/L1212F06	12	12	85	12	12	12	0.2	CC**0602	CSTB-2.5	T-8F	1.2
JSCL2CR/L1212X06	12	12	120	12	12	12	0.2	CC**0602	CSTB-2.5	T-8F	1.2
JSCL2CR/L1212F09	12	12	85	16	12	12	0.2	CC**09T3	CSTB-4SD	T-8F	1.2
JSCL2CR/L1212X09	12	12	120	16	12	12	0.2	CC**09T3	CSTB-4SD	T-8F	1.2
JSCL2CR/L1616X09	16	16	120	16	16	16	0.2	CC**09T3	CSTB-4SD	T-8F	1.2

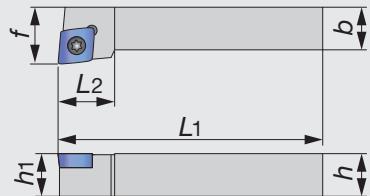
JSCLCR/L

External turning and facing

JS type (Positive rake, screw-on system)



Cutting edge style L

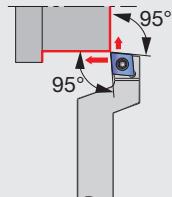


Right-hand (R) shown

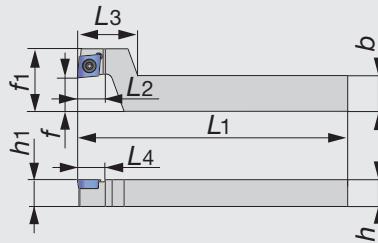
Metric	Dimensions (mm)						Standard corner radius r_E	Insert	Parts		Torque (N·m)
	h	b	L_1	L_2	h_1	f			Clamping Screw	Wrench	
JSCLCR/L0808H06	8	8	100	12	8	10	0.4	CC**0602	CSTB-2.5	T-8F	1.2
JSCLCR/L1010H06	10	10	100	12	10	12	0.4	CC**0602	CSTB-2.5	T-8F	1.2
JSCLCR/L1212H09	12	12	100	16	12	16	0.8	CC**09T3	CSTB-4SD	T-8F	1.2
JSCLCR/L1616H09	16	16	100	16	16	20	0.8	CC**09T3	CSTB-4SD	T-8F	1.2

JSCLCR-F

External turning and facing Neck-down type (Positive rake, screw-on system)



Cutting edge style L



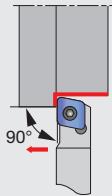
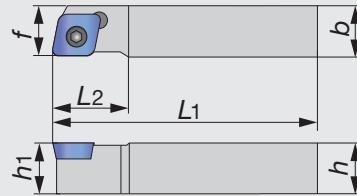
Right-hand (R) shown

Metric	Dimensions (mm)									Standard corner radius r_E	Insert	Parts		Torque (N·m)
	h	b	L_1	L_2	L_3	L_4	h_1	f	f_1			Clamping Screw	Wrench	
JSCLCR1216F09-F15	12	16	85	12	27	12.5	12	15	28	0.2	CC**09T3**	CSTB-4SD	T-8F	1.2
JSCLCR1216X09-F15	12	16	120	12	27	12.5	12	15	28	0.2	CC**09T3**	CSTB-4SD	T-8F	1.2
JSCLCR1620X09-F15	16	20	120	12	27	12.5	16	15	28	0.2	CC**09T3**	CSTB-4SD	T-8F	1.2

JSCACR/L

External turning

JS type (Positive rake, screw-on system)

Cutting edge style **A**

Without offset

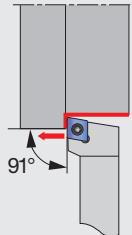
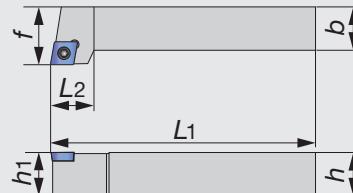
Right-hand (R) shown

Metric	Dimensions (mm)						Standard corner radius r_E	Insert	Parts		Torque (N·m)
	<i>h</i>	<i>b</i>	<i>L₁</i>	<i>L₂</i>	<i>h₁</i>	<i>f</i>			Clamping screw	Wrench	
JSCACR/L1010H06	10	10	100	12	10	10	0.4	CC**0602	CSTB-2.5	T-8F	1.2
JSCACR/L1212H09	12	12	100	16	12	12	0.8	CC**09T3	CSTB-4SD	T-8F	1.2

JSCGCR/L

External turning

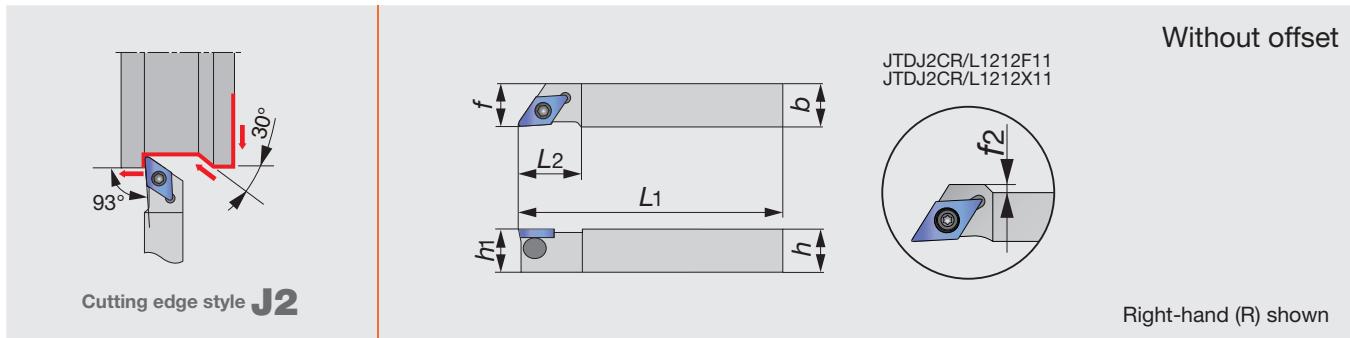
JS type (Positive rake, screw-on system)

Cutting edge style **G**

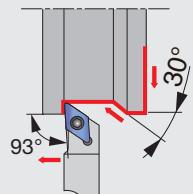
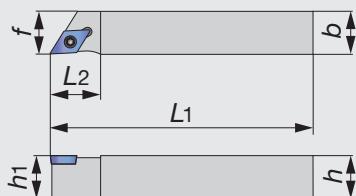
Right-hand (R) shown

Metric	Dimensions (mm)						Standard corner radius r_E	Insert	Parts		Torque (N·m)
	<i>h</i>	<i>b</i>	<i>L₁</i>	<i>L₂</i>	<i>h₁</i>	<i>f</i>			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

JTDJ2CR/L External turning and profiling JT type (Positive rake, back-clamping system)

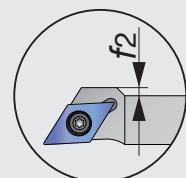


Metric	Dimensions (mm)							Standard corner radius r_E	Insert	Parts			Torque (N·m)
	<i>h</i>	<i>b</i>	<i>L₁</i>	<i>L₂</i>	<i>h₁</i>	<i>f</i>	<i>f₂</i>			Clamp	Clamping Screw	Wrench	
JTDJ2CR/L1010X07	10	10	120	14	10	10	-	0.2	DC**0702	JCP-2	JDS-3525	P-2F	0.9
JTDJ2CR/L1212F07	12	12	85	14	12	12	-	0.2	DC**0702	JCP-2	JDS-3525	P-2F	0.9
JTDJ2CR/L1212X07	12	12	120	14	12	12	-	0.2	DC**0702	JCP-2	JDS-3525	P-2F	0.9
JTDJ2CR/L1212F11	12	12	85	20	12	12	2	0.2	DC**11T3	JCP-3	JDS-5040	P-2.5F	1.2
JTDJ2CR/L1212X11	12	12	120	20	12	12	2	0.2	DC**11T3	JCP-3	JDS-5040	P-2.5F	1.2
JTDJ2CR/L1212M11	12	12	150	20	12	12	-	0.8	DC**11T3	JCP-3	JDS-5040	P-2.5F	1.2
JTDJ2CR/L1616X11	16	16	120	20	16	16	-	0.2	DC**11T3	JCP-3	JDS-5040	P-2.5F	1.2

JSDJ2CR/L**External profiling****JS type (Positive rake, screw-on system)**Cutting edge style **J2**

JSDJ2CR/L1010F07
JSDJ2CR/L1212F11
JSDJ2CR/L1212X11

Without offset



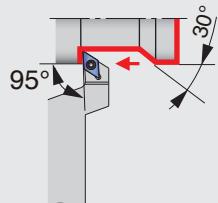
Right-hand (R) shown

Inch	Dimensions (in)							Standard corner radius r_ϵ	Insert	Parts			Torque (lb·ft)
	h	b	L_1	L_2	h_1	f	f_2			Clamp	Clamping Screw	Wrench	
JSDJ2CR/L062	0.375	0.375	5.000	0.500	0.375	0.375	-	0.016	DC**0702	CSTB-2.5	T-8F	0.88	0.9
JSDJ2CR/L082	0.500	0.500	5.000	0.500	0.500	0.500	-	0.016	DC**0702	CSTB-2.5	T-8F	0.88	0.9
JSDJ2CR/L103	0.625	0.625	5.000	0.780	0.625	0.625	-	0.031	DC**11T3	CSTB-4SD	T-8F	0.88	0.9

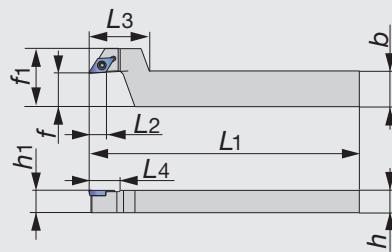
Cat. No.	Dimensions (mm)							Standard corner radius r_ϵ	Insert	Parts			Torque (N·m)
	h	b	L_1	L_2	h_1	f	f_2			Clamp	Clamping Screw	Wrench	
JSDJ2CR/L0808F07	8	8	85	14	8	8	-	0.2	DC**0702	CSTB-2.5	T-8F	1.2	
JSDJ2CR/L1010X07	10	10	120	14	10	10	-	0.2	DC**0702	CSTB-2.5	T-8F	1.2	
JSDJ2CR/L1010X11	10	10	120	20	10	10	4	0.2	DC**11T3	CSTB-4SD	T-8F	1.2	
JSDJ2CR/L1212F07	12	12	85	14	12	12	-	0.2	DC**0702	CSTB-2.5	T-8F	1.2	
JSDJ2CR/L1212F11	12	12	85	20	12	12	2	0.2	DC**11T3	CSTB-4SD	T-8F	1.2	
JSDJ2CR/L1212X07	12	12	120	14	12	12	-	0.2	DC**0702	CSTB-2.5	T-8F	1.2	
JSDJ2CR/L1212K07	12	12	125	14	12	12	-	0.4	DC**0702	CSTB-2.5	T-8F	1.2	
JSDJ2CR/L1212X11	12	12	120	20	12	12	2	0.2	DC**11T3	CSTB-4SD	T-8F	1.2	
JSDJ2CR/L1616X11	16	16	120	20	16	16	-	0.2	DC**11T3	CSTB-4SD	T-8F	1.2	

JSDJCR-F

External turning and facing Neck-down type (Positive rake, screw-on system)



Cutting edge style **J**

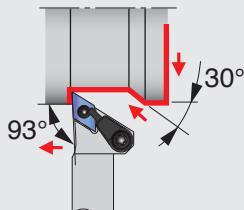
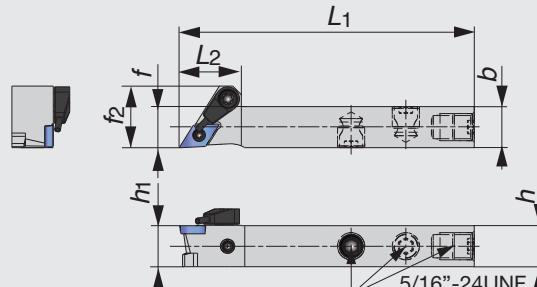


Right-hand (R) shown

Inch	Dimensions (in)										Standard corner radius r_ϵ	Insert	Parts		Torque (lb·ft)
	h	b	L_1	L_2	L_3	L_4	h_1	f	f_1	Clamping Screw	Wrench				
JSDJCR082-F10	0.500	0.625	4.750	0.500	1.125	0.625	0.500	0.625	1.000	0.008	DC**0702**	CSTB-2.5	T-8F	0.88	
JSDJCR103-F10	0.625	0.750	4.750	0.500	1.125	0.875	0.625	0.625	1.125	0.008	DC**1103**	CSTB-4SD	T-8F	0.88	

Metric	Dimensions (mm)										Standard corner radius r_ϵ	Insert	Parts		Torque (N·m)
	h	b	L_1	L_2	L_3	L_4	h_1	f	f_1	Clamping Screw	Wrench				
JSDJCR1016X07-F15	10	16	120	12.5	27	14	10	15	26	0.2	DC**0702**	CSTB-2.5	T-8F	1.2	
JSDJCR1216F07-F15	12	16	85	12.5	27	14	12	15	26	0.2	DC**0702**	CSTB-2.5	T-8F	1.2	
JSDJCR1216X07-F15	12	16	120	12.5	27	14	12	15	26	0.2	DC**0702**	CSTB-2.5	T-8F	1.2	
JSDJCR1216F11-F15	12	16	85	12.5	27	20	12	15	26	0.2	DC**1103**	CSTB-4SD	T-8F	1.2	
JSDJCR1216X11-F15	12	16	120	12.5	27	20	12	15	26	0.2	DC**1103**	CSTB-4SD	T-8F	1.2	
JSDJCR1620X11-F15	16	20	120	12.5	27	20	16	15	26	0.2	DC**1103**	CSTB-4SD	T-8F	1.2	

Works with high-pressure coolant

JSDJ2CR/L-CHP External turning and profiling CHP type (Positive rake, screw-on system)Cutting edge style: **J2**
TUNG^{URN}
TJET
Without offset

Right-hand (R) shown

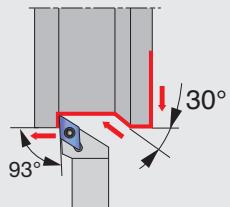
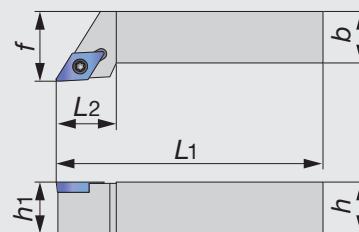
Inch	Dimensions (in)							Std. corner radius r_ϵ	Insert	Parts			Torque (lb·ft)
	<i>h</i>	<i>b</i>	<i>L</i> ₁	<i>L</i> ₂	<i>h</i> ₁	<i>f</i>	<i>f</i> ₂			Clamping screw	Wrench		
JSDJ2CR/L082-CHP	0.500	0.500	3.344	0.710	0.500	0.500	0.710	0.008	DC**0702**	CSTB-2.5	T-8F		0.66

Metric	Dimensions (mm)							Std. corner radius r_ϵ	Insert	Parts			Torque (N·m)
	<i>h</i>	<i>b</i>	<i>L</i> ₁	<i>L</i> ₂	<i>h</i> ₁	<i>f</i>	<i>f</i> ₂			Clamping screw	Wrench		
JSDJ2CR/L1212F07-CHP	12	12	85	18	12	12	18	0.2	DC**0702**	CSTB-2.5	T-8F		0.9
JSDJ2CR/L1212F11-CHP	12	12	85	19	12	12	20.5	0.2	DC**11T3**	CSTB-4SD	T-8F		0.9

TungTurn-Jet parts
P57 - 58
JSDJCR/L

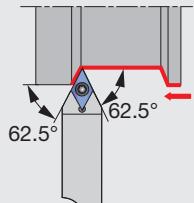
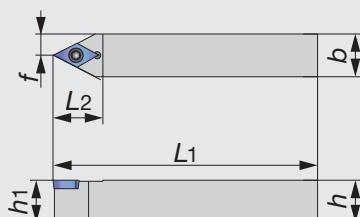
External profiling

JS type (Positive rake, screw-on system)

Cutting edge style **J**

Right-hand (R) shown

Metric	Dimensions (mm)						Standard corner radius r_ϵ	Insert	Parts			Torque (N·m)
	<i>h</i>	<i>b</i>	<i>L</i> ₁	<i>L</i> ₂	<i>h</i> ₁	<i>f</i>			Clamping screw	Wrench		
JSDJCR/L0808H07	8	8	100	14	8	10	0.4	DC**0702	CSTB-2.5	T-8F		1.2
JSDJCR/L1010H11	10	10	100	18	10	12	0.8	DC**11T3	CSTB-4SD	T-8F		1.2
JSDJCR/L1212H07	12	12	100	14	12	16	0.4	DC**0702	CSTB-2.5	T-8F		1.2
JSDJCR/L1212H11	12	12	100	18	12	16	0.8	DC**11T3	CSTB-4SD	T-8F		1.2
JSDJCR/L1616H11	16	16	100	18	16	20	0.8	DC**11T3	CSTB-4SD	T-8F		1.2

JSDNCN
External profiling
JS type (Positive rake, screw-on system)

 Cutting edge style **N**


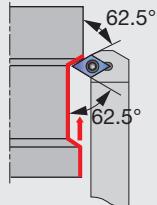
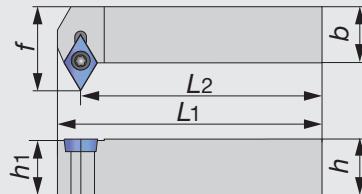
Right-hand (R) shown

Inch	Dimensions (in)						Standard corner radius r_ϵ	Insert	Parts		Torque (lb·ft)
	h	b	L_1	L_2	h_1	f			Clamping screw	Wrench	
JSDNCN062	0.375	0.375	5.000	0.550	0.375	0.375	0.016	DC**0702	CSTB-2.5	T-8F	0.88
JSDNCN082	0.500	0.500	5.000	0.550	0.500	0.500	0.016	DC**0702	CSTB-2.5	T-8F	0.88
JSDNCN103	0.625	0.625	5.000	0.826	0.625	0.625	0.031	DC**11T3	CSTB-4SD	T-8F	0.88

Metric	Dimensions (mm)						Standard corner radius r_ϵ	Insert	Parts		Torque (N·m)
	h	b	L_1	L_2	h_1	f			Clamping screw	Wrench	
JSDNCN1010X07	10	10	120	15	10	5	0.2	DC**0702	CSTB-2.5	T-8F	1.2
JSDNCN1010X11	10	10	120	21	10	5	0.2	DC**11T3	CSTB-4SD	T-8F	1.2
JSDNCN1212F07	12	12	85	15	12	6	0.2	DC**0702	CSTB-2.5	T-8F	1.2
JSDNCN1212X07	12	12	120	15	12	6	0.2	DC**0702	CSTB-2.5	T-8F	1.2
JSDNCN1212F11	12	12	85	21	12	6	0.2	DC**11T3	CSTB-4SD	T-8F	1.2
JSDNCN1212X11	12	12	120	21	12	6	0.2	DC**11T3	CSTB-4SD	T-8F	1.2
JSDNCN1616X11	16	16	120	21	16	8	0.2	DC**11T3	CSTB-4SD	T-8F	1.2

JSFN3CR/L Profiling

JS type (Positive rake, screw-on system)

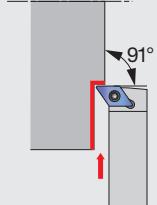
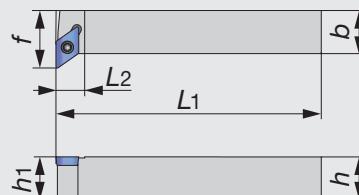
Cutting edge style **N3**

Right-hand (R) shown

Metric	Dimensions (mm)						Standard corner radius $r\epsilon$	Insert	Parts		Torque (N·m)
	h	b	L_1	L_2	h_1	f			Clamping screw	Wrench	
JSFN3CR/L1212H07	12	12	105	100	12	18	0.4	DC**0702	CSTB-2.5	T-8F	1.2
JSFN3CR/L1616H11	16	16	107	100	16	25	0.8	DC**11T3	CSTB-4SD	T-8F	1.2

JSDFCR/L Facing

JS type (Positive rake, screw-on system)

Cutting edge style **F**

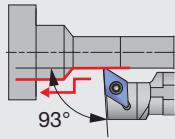
Right-hand (R) shown

Metric	Dimensions (mm)						Standard corner radius $r\epsilon$	Insert	Parts		Torque (N·m)
	h	b	L_1	L_2	h_1	f			Clamping screw	Wrench	
JSDFCR1212H07	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

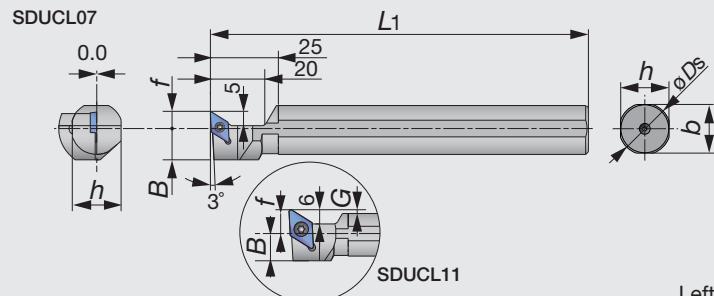
JS-SDUCL

External profiling

JS type (Positive rake, screw-on system)



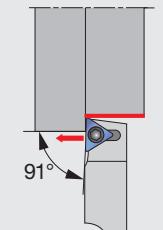
Cutting edge style **U**



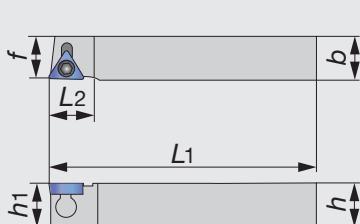
Left-hand (L) shown

Inch	Dimensions (in)							Standard corner radius $r\epsilon$	Insert	Parts		Torque (lb·ft)
	ϕD_s	f	L_1	L_2	h	B	G			Clamping screw	Wrench	
JS19K-SDUCL07	0.750	0.236	4.921	-	0.709	0.453	-	0.016	DC**21.5	CSTB-2.5	T-8F	0.88
JS19K-SDUCL11	0.750	0.394	4.921	-	0.709	0.453	0.059	0.031	DC**32.5	CSTB-4SD	T-8F	0.88
JS25K-SDUCL11	1.000	0.472	4.921	-	0.945	0.500	0.028	0.031	DC**32.5	CSTB-4SD	T-8F	0.88

Metric	Dimensions (mm)							Standard corner radius $r\epsilon$	Insert	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	DC**0702	CSTB-2.5	T-8F	1.2
JS22K-SDUCL07	22	6	125	-	21	11.5	-	0.4	DC**0702	CSTB-2.5	T-8F	1.2
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	DC**11T3	CSTB-4SD	T-8F	1.2
JS22K-SDUCL11	22	11	125	-	21	11.5	1.0	0.8	DC**11T3	CSTB-4SD	T-8F	1.2
JS25K-SDUCL11	25.4	12	125	-	24	12.7	0.7	0.8	DC**11T3	CSTB-4SD	T-8F	1.2



Cutting edge style **A**



Without offset

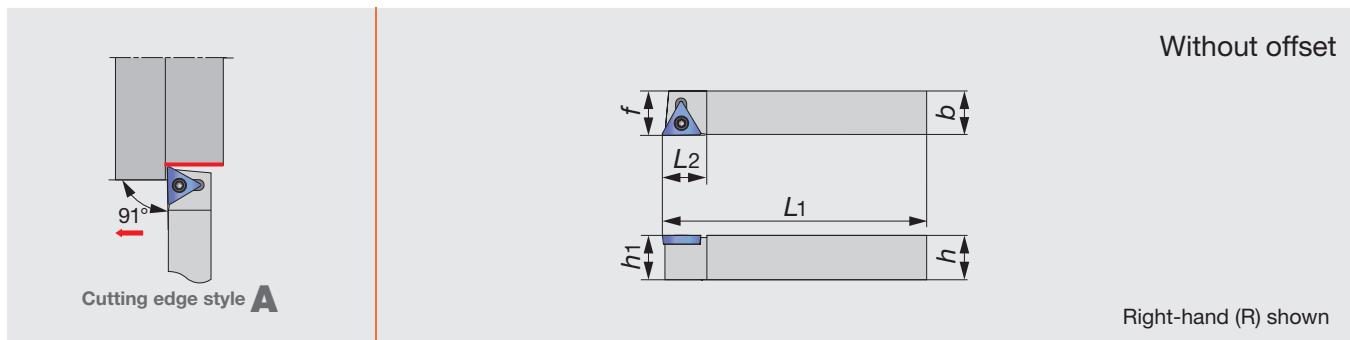
Right-hand (R) shown

Metric	Dimensions (mm)						Standard corner radius $r\epsilon$	Insert	Parts			Torque (N·m)
	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	0.9
JTTACR/L1010K08	10	10	125	10	10	10	0.2	TC**0802	JCP-1	JDS-3525	P-2F	0.9
JTTACR/L1212M11	12	12	150	12	12	12	0.4	TC**1102	JCP-2	JDS-3525	P-2F	0.9
JTTACR/L1616M11	16	16	150	12	16	16	0.4	TC**1102	JCP-2	JDS-3525	P-2F	0.9

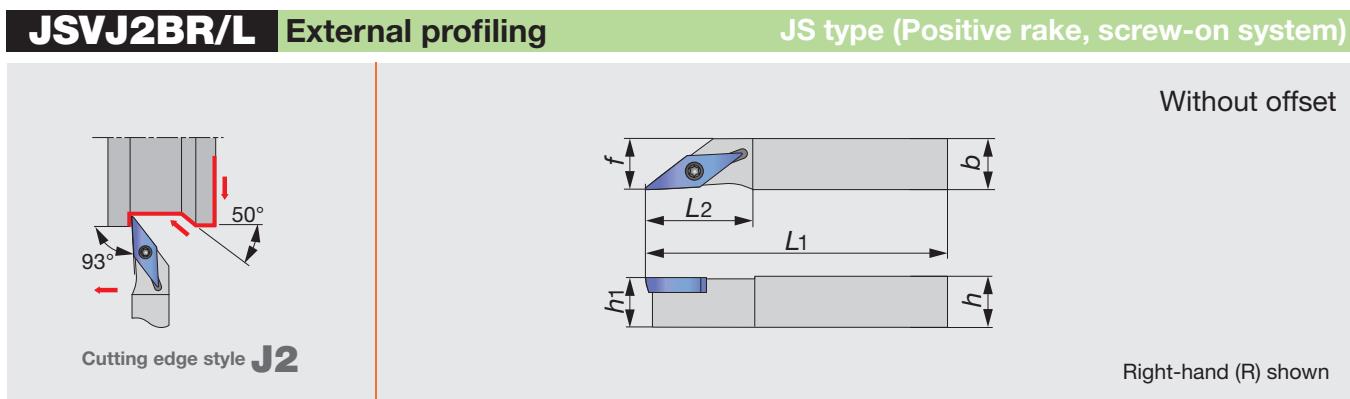
JSTACR/L

External turning

JS type (Positive rake, screw-on system)



Metric	Dimensions (mm)						Standard corner radius $r\epsilon$	Insert	Parts		Torque (N·m)
	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/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	TC**1102	CSTB-2.5	T-8F	1.2



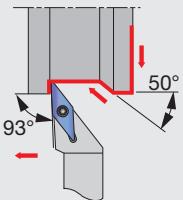
Inch	Dimensions (in)						Standard corner radius $r\epsilon$	Insert	Parts		Torque (lb·ft)
	h	b	L_1	L_2	h_1	f			Clamping screw	Wrench	
JSVJ2BR/L062	0.375	0.375	5.000	0.780	0.375	0.375	0.008	VB**1103	CSTB-2.5	T-8F	0.88
JSVJ2BR/L082	0.500	0.500	5.000	0.780	0.500	0.500	0.008	VB**1103	CSTB-2.5	T-8F	0.88
JSVJ2BR/L102	0.625	0.625	5.000	0.780	0.625	0.625	0.008	VB**1103	CSTB-2.5	T-8F	0.88

Metric	Dimensions (mm)						Standard corner radius $r\epsilon$	Insert	Parts		Torque (N·m)
	h	b	L_1	L_2	h_1	f			Clamping screw	Wrench	
JSVJ2BR/L1010X11	10	10	120	21	10	10	0.2	VB**1103	CSTB-2.5	T-8F	1.2
JSVJ2BR/L1010K11	10	10	125	21	10	10	0.2	VB**1103	CSTB-2.5	T-8F	1.2
JSVJ2BR/L1212F11	12	12	85	21	12	12	0.2	VB**1103	CSTB-2.5	T-8F	1.2
JSVJ2BR/L1212X11	12	12	120	21	12	12	0.2	VB**1103	CSTB-2.5	T-8F	1.2
JSVJ2BR/L1212K11	12	12	125	21	12	12	0.2	VB**1103	CSTB-2.5	T-8F	1.2
JSVJ2BR/L1616X11	16	16	120	21	16	16	0.2	VB**1103	CSTB-2.5	T-8F	1.2

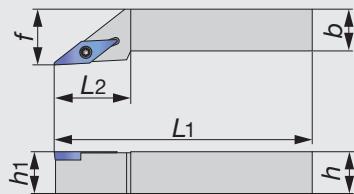
JSVJBR/L

External profiling

JS type (Positive rake, screw-on system)



Cutting edge style **J**

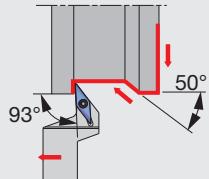


Right-hand (R) shown

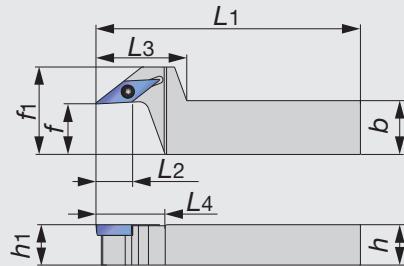
Metric	Dimensions (mm)						Standard corner radius r_ϵ	Insert	Parts		Torque (N·m)
	<i>h</i>	<i>b</i>	<i>L</i> ₁	<i>L</i> ₂	<i>h</i> ₁	<i>f</i>			Clamping screw	Wrench	
JSVJBR/L1010H11	10	10	100	20	10	12	0.4	VB**1103	CSTB-2.5	T-8F	1.2
JSVJBR/L1212H11	12	12	100	22	12	16	0.4	VB**1103	CSTB-2.5	T-8F	1.2
JSVJBR/L1616H11	16	16	100	22	16	20	0.4	VB**1103	CSTB-2.5	T-8F	1.2

JSVJBR-F

External turning and profiling Neck-down type (Positive rake, screw-on system)



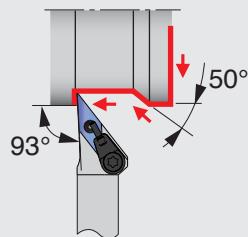
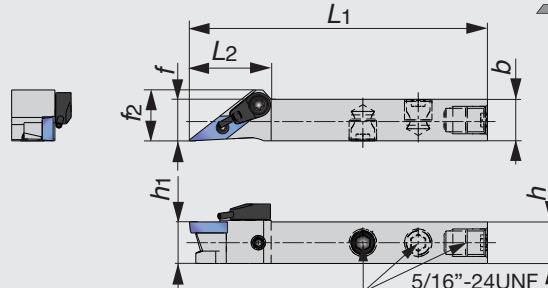
Cutting edge style **J**



Right-hand (R) shown

Inch	Dimensions (in)									Standard corner radius r_ϵ	Insert	Parts		Torque (lb·ft)
	<i>h</i>	<i>b</i>	<i>L</i> ₁	<i>L</i> ₂	<i>L</i> ₃	<i>L</i> ₄	<i>h</i> ₁	<i>f</i>	<i>f</i> ₁			Clamping screw	Wrench	
JSVJBR082-F10	0.500	0.625	4.75	0.500	1.125	0.875	0.500	0.625	1.000	0.008	VB**1103**	CSTB-2.5	T-8F	0.88
JSVJBR102-F10	0.625	0.750	4.75	0.500	1.125	0.875	0.625	0.625	1.000	0.008	VB**1103**	CSTB-2.5	T-8F	0.88

Metric	Dimensions (mm)									Standard corner radius r_ϵ	Insert	Parts		Torque (N·m)
	<i>h</i>	<i>b</i>	<i>L</i> ₁	<i>L</i> ₂	<i>L</i> ₃	<i>L</i> ₄	<i>h</i> ₁	<i>f</i>	<i>f</i> ₁			Clamping screw	Wrench	
JSVJBR1216F11-F15	12	16	85	12.6	27	21	12	15	26	0.2	VB**1103**	CSTB-2.5	T-8F	1.2
JSVJBR1216X11-F15	12	16	120	12.6	27	21	12	15	26	0.2	VB**1103**	CSTB-2.5	T-8F	1.2
JSVJBR1620X11-F15	16	20	120	12.6	27	21	16	15	26	0.2	VB**1103**	CSTB-2.5	T-8F	1.2

JSVJ2BR/L External turning and profiling CHP type (Positive rake, screw-on system)Cutting edge style: **J2**

Without offset

Right-hand (R) shown

Inch	Dimensions (in)							Std. corner radius r_ϵ	Insert	Parts			Torque (lb·ft)
	h	b	L_1	L_2	h_1	f	f_2			Clamping screw	Wrench		
JSVJ2BR/L082-CHP	0.500	0.500	3.344	0.930	0.500	0.500	0.610	0.008	VB**1103**	CSTB-2.5	T-8F		0.88

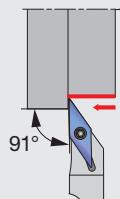
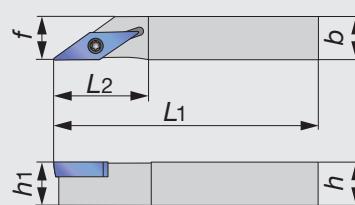
Metric	Dimensions (mm)							Std. corner radius r_ϵ	Insert	Parts			Torque (N·m)
	h	b	L_1	L_2	h_1	f	f_2			Clamping screw	Wrench		
JSVJ2BR/L1212F11-CHP	12	12	85	23.6	12	12	14.7	0.2	VB**1103**	CSTB-2.5	T-8F		1.2

TungTurn-Jet parts
P57 - 58

JSVABR/L

External turning

JS type (Positive rake, screw-on system)

Cutting edge style **A**

Without offset

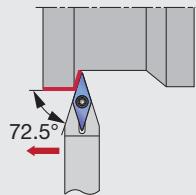
Right-hand (R) shown

Metric	Dimensions (mm)						Standard corner radius r_ϵ	Insert	Parts			Torque (N·m)
	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	VB**1103	CSTB-2.5	T-8F		1.2
JSVABR/L1616K11	16	16	125	21	16	16	0.2	VB**1103	CSTB-2.5	T-8F		1.2

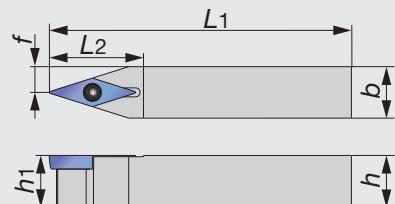
JSVNBN

External profiling

JS type (Positive rake, screw-on system)

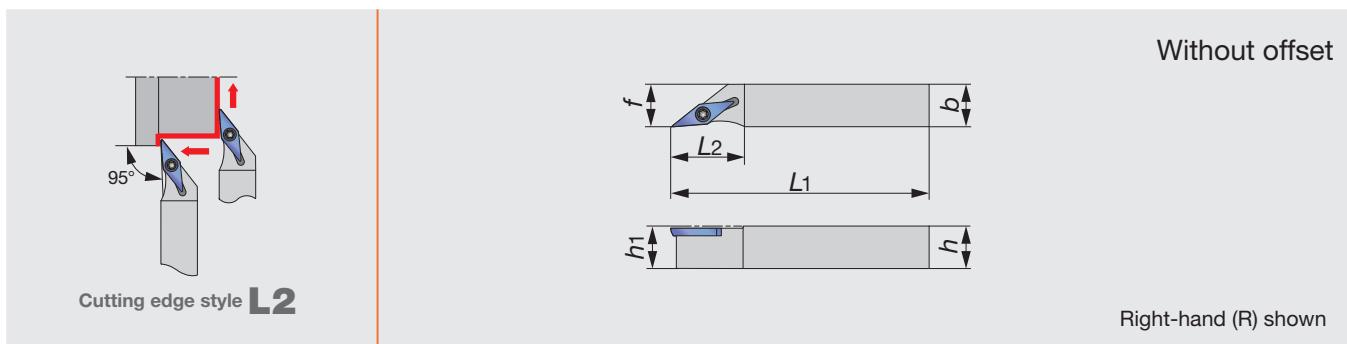


Cutting edge style **N**



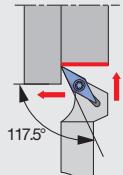
Right-hand (R) shown

Metric	Dimensions (mm)						Standard corner radius r_E	Insert	Parts		Torque (N·m)
	<i>h</i>	<i>b</i>	<i>L</i> ₁	<i>L</i> ₂	<i>h</i> ₁	<i>f</i>			Clamping screw	Wrench	
JSVNBN1010X11	10	10	120	22	10	5	0.2	VB**1103	CSTB-2.5	T-8F	1.2
JSVNBN1212F11	12	12	85	22	12	6	0.2	VB**1103	CSTB-2.5	T-8F	1.2
JSVNBN1212X11	12	12	120	22	12	6	0.2	VB**1103	CSTB-2.5	T-8F	1.2
JSVNBN1616X11	16	16	120	22	16	8	0.2	VB**1103	CSTB-2.5	T-8F	1.2

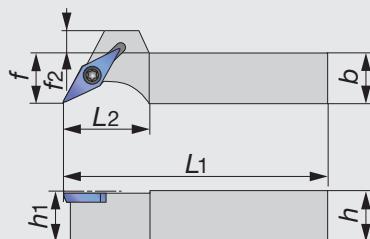
JSVL2PR/L External turning and facing JS type (Positive rake, screw-on system)


Inch	Dimensions (in)						Standard corner radius r_E	Insert	Parts		Torque (lb·ft)
	h	b	L_1	L_2	h_1	f			Clamping Screw	Wrench	
JSVL2PR/L082	0.500	0.500	5.000	18.000	0.500	0.500	0.008	VP**0802	CSTB-2L	T-8F	0.88
JSVL2PR/L102	0.625	0.625	5.000	20.000	0.625	0.625	0.008	VP**0802	CSTB-2L	T-8F	0.88
Metric	Dimensions (mm)						Standard corner radius r_E	Insert	Parts		Torque (N·m)
	h	b	L_1	L_2	h_1	f			Clamping Screw	Wrench	
JSVL2PR/L1010X08	10	10	120	16	10	10	0.2	VP**0802	CSTB-2L	T-6F	0.6
JSVL2PR/L1010K08	10	10	125	16	10	10	0.2	VP**0802	CSTB-2L	T-6F	0.6
JSVL2PR/L1212F08	12	12	85	16	12	12	0.2	VP**0802	CSTB-2L	T-6F	0.6
JSVL2PR/L1212F11	12	12	85	21	12	12	0.2	VP**1103	CSTB-2.5	T-8F	1.2
JSVL2PR/L1212X08	12	12	120	16	12	12	0.2	VP**0802	CSTB-2L	T-6F	0.6
JSVL2PR/L1212X11	12	12	120	21	12	12	0.2	VP**1103	CSTB-2.5	T-8F	1.2
JSVL2PR/L1212K08	12	12	125	16	12	12	0.2	VB**0802	CSTB-2L	T-6F	0.6
JSVL2PR/L1616X08	16	16	120	16	16	16	0.2	VP**0802	CSTB-2L	T-6F	0.6
JSVL2PR/L1616K08	16	16	125	16	16	16	0.2	VP**0802	CSTB-2L	T-6F	0.6
JSVL2PR/L1616X11	16	16	120	21	16	16	0.2	VP**1103	CSTB-2.5	T-8F	1.2

JSVP2PR/L External profiling and undercut JS type (Positive rake, screw-on system)



Cutting edge style **P2**



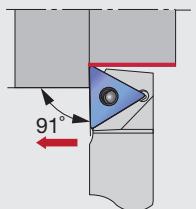
Without offset

Right-hand (R) shown

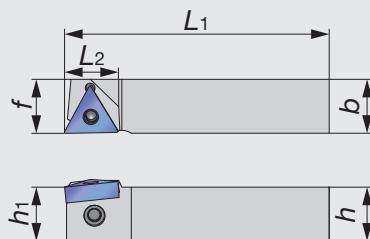
Metric	Dimensions (mm)							Standard corner radius r_E	Insert	Parts		Torque (N·m)
	h	b	L_1	L_2	h_1	f	f_2			Clamping screw	Wrench	
JSVP2PR/L1010K08	10	10	125	16	10	10	4	0.2	VP**0802	CSTB-2L	T-6F	0.6
JSVP2PR/L1212K08	12	12	125	16	12	12	2	0.2	VP**0802	CSTB-2L	T-6F	0.6
JSVP2PR/L1616K08	16	16	125	16	16	16	2	0.2	VP**0802	CSTB-2L	T-6F	0.6
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	VP**1103	CSTB-2.5	T-8F	1.2
JSVP2PR/L1616K11	16	16	125	20	16	16	6	0.2	VP**1103	CSTB-2.5	T-8F	1.2

JTTANR/L External turning

JT type (Negative rake, back-clamping system)



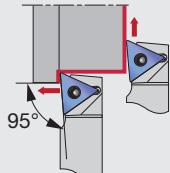
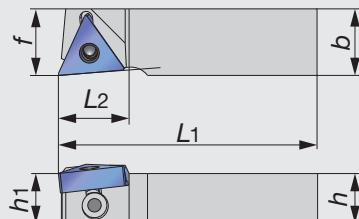
Cutting edge style **A**



Without offset

Right-hand (R) shown

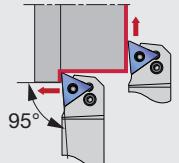
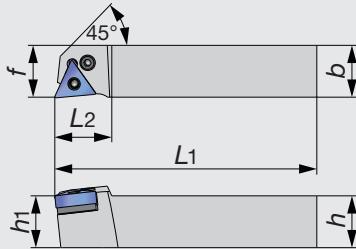
Metric	Dimensions (mm)						Standard corner radius r_E	Insert	Parts			Torque (N·m)
	h	b	L_1	L_2	h_1	f			Clamp	Clamping Screw	Wrench	
JTTANR/L1216K16	12	16	125	19.8	12	16	0.4	TN**1604	JCP-3N	JDS-5040	P-2.5F	1.2
JTTANR/L1616K16	16	16	125	19.8	16	16	0.4	TN**1604	JCP-3N	JDS-5040	P-2.5F	1.2

JTTLNR/L**External turning and facing JT type (Negative rake, back-clamping system)**Cutting edge style **L**

Without offset

Right-hand (R) shown

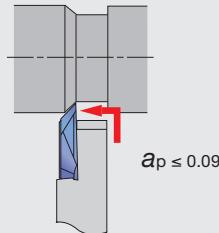
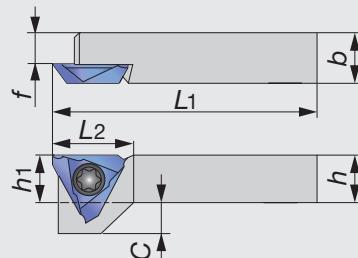
Metric	Dimensions (mm)						Standard corner radius r_e	Insert	Parts			Torque (N·m)
	<i>h</i>	<i>b</i>	<i>L</i> ₁	<i>L</i> ₂	<i>h</i> ₁	<i>f</i>			Clamp	Clamping Screw	Wrench	
JTTLNR/L1216F16	12	16	85	17	12	16	0.4	TN**1604**	JCP-3N	JDS-5040	P-2.5F	1.0
JTTLNR/L1216X16	12	16	120	17	12	16	0.4	TN**1604**	JCP-3N	JDS-5040	P-2.5F	1.0
JTTLNR/L1616X16	16	16	120	17	16	16	0.4	TN**1604**	JCP-3N	JDS-5040	P-2.5F	1.0

PTL2NR/L**External turning and facing****P type (Negative rake, lever-lock system)**Cutting edge style **L2**

Without offset

Right-hand (R) shown

Metric	Dimensions (mm)						Standard corner radius r_e	Insert	Parts				Torque (N·m)	
	<i>h</i>	<i>b</i>	<i>L</i> ₁	<i>L</i> ₂	<i>h</i> ₁	<i>f</i>			Shim	Clamping screw	Lever	Spring		
PTL2NR/L2020H16	20	20	100	22	20	20	0.4	TN**1604**	LST317	LCS3	LCL3	LSP3	P-2.5	2.0

JSTBR/L
Back turning
JS type (Screw-on system)

 $a_p \leq 0.098"$


Can be wrench from the back side with double-socket torx screw.

Right-hand (R) shown

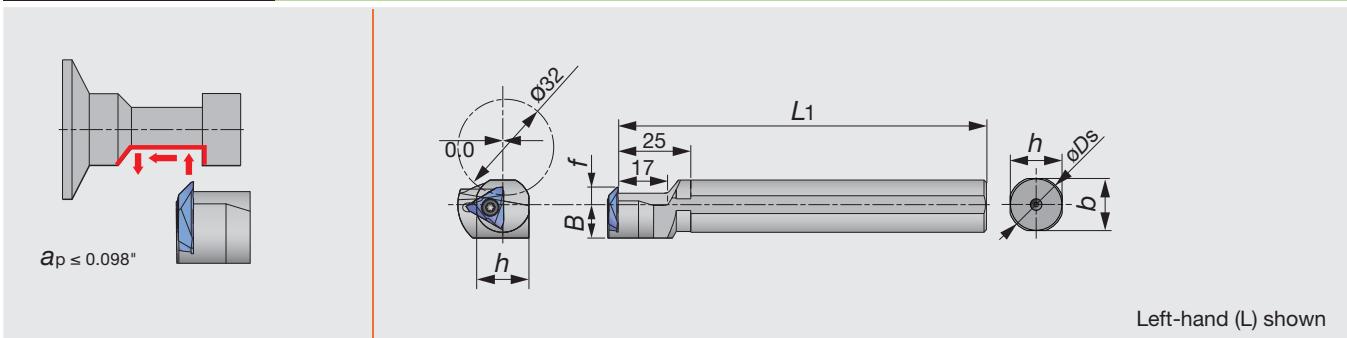
Inch	Dimensions (in)							Insert	Parts		Torque (lb·ft)
	<i>h</i>	<i>b</i>	<i>L</i> ₁	<i>L</i> ₂	<i>h</i> ₁	<i>f</i>	<i>C</i>		Clamping screw	Wrench (Optional)	
JSTBR/L063	0.375	0.375	5.000	0.625	0.375	0.219	0.250	JTBR/L3**	CSTB-4SD	T-8F (T-8L)	0.88
JSTBR/L083	0.500	0.500	5.000	0.625	0.500	0.313	0.125	JTBR/L3**	CSTB-4SD	T-8F (T-8L)	0.88
JSTBR/L103	0.625	0.625	5.000	0.625	0.625	0.469	-	JTBR/L3**	CSTB-4SD	T-8F (T-8L)	0.88

Metric	Dimensions (mm)							Insert	Parts		Torque (N·m)
	<i>h</i>	<i>b</i>	<i>L</i> ₁	<i>L</i> ₂	<i>h</i> ₁	<i>f</i>	<i>C</i>		Clamping screw	Wrench (Optional)	
JSTBR/L1010X3	10	10	120	15	12	10	5	JTBR/L3**	CSTB-4SD	T-8F (T-8L)	1.2
JSTBR/L1010K3	12	12	125	15	10	10	5	JTBR/L3**	CSTB-4SD	T-8F (T-8L)	1.2
JSTBR/L1212F3	12	12	85	15	12	12	3	JTBR/L3**	CSTB-4SD	T-8F (T-8L)	1.2
JSTBR/L1212X3	12	12	120	15	12	12	3	JTBR/L3**	CSTB-4SD	T-8F (T-8L)	1.2
JSTBR/L1616X3	16	16	120	15	16	16	-	JTBR/L3**	CSTB-4SD	T-8F (T-8L)	1.2

JS-TBL3

Back turning

JS type (Screw-on system)



Inch	Dimensions (in)						Insert	Parts		Torque (lb·ft)
	ϕD_s	f	L_1	L_2	h	B		Clamping screw	Wrench	
JS19K-TBL3	0.750	0.236	4.921	-	0.709	0.453	JTBR3***	CSTB-4S	T-15F	2.2
JS25K-TBL3	1.000	0.394	4.921	-	0.945	0.500	JTBR3***	CSTB-4S	T-15F	2.2

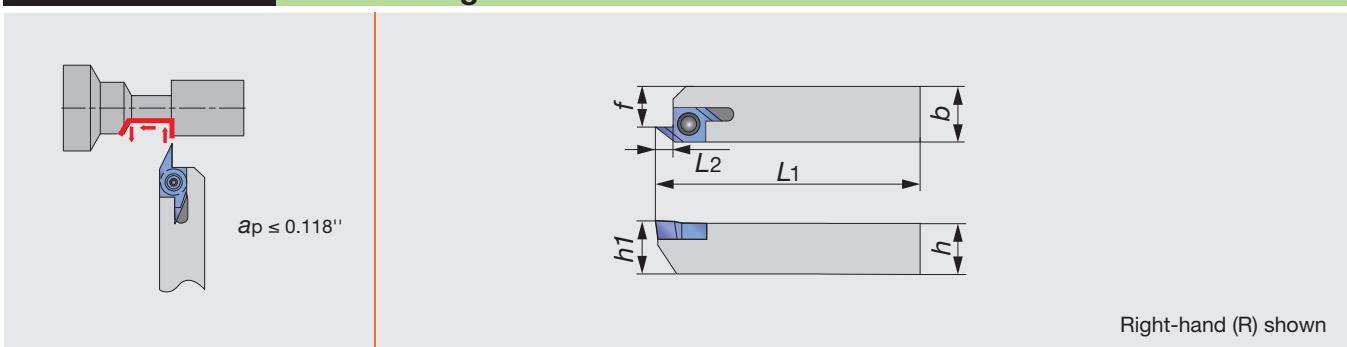
Metric	Dimensions (mm)						Insert	Parts		Torque (N·m)
	ϕD_s	f	L_1	L_2	h	B		Clamping screw	Wrench	
JS19K-TBL3	19.05	6	125	-	18	11.5	JTBR3***	CSTB-4S	T-15F	3.0
JS20K-TBL3	20	6	125	-	19	11.5	JTBR3***	CSTB-4S	T-15F	3.0
JS22K-TBL3	22	6	125	-	21	11.5	JTBR3***	CSTB-4S	T-15F	3.0
JS25K-TBL3	25.4	10	125	-	24	12.7	JTBR3***	CSTB-4S	T-15F	3.0

Notes: Left-hand holder use right-hand insert.

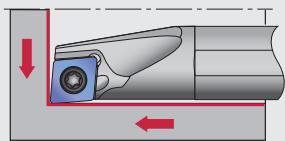
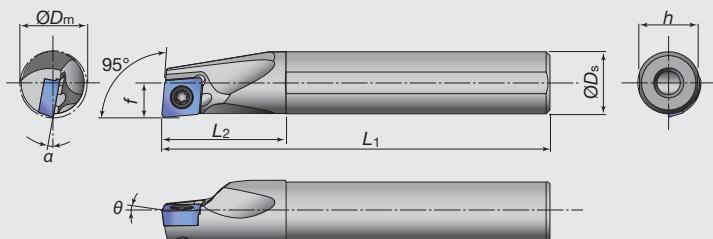
J-SERIES**JSEGR/L**

Back turning

JS type (Screw-on system)



Metric	Dimensions (mm)						Insert	Parts		Torque (N·m)
	h	b	L_1	L_2	h_1	f		Clamping screw	Wrench (Optional)	
JSEGR/L1010K10	10	10	125	3.3	10	7.5	J10ER/L*****	CSTB-2.5	T-8F (T-8L)	1.2
JSEGR/L1212K10	12	12	125	3.3	12	9.5	J10ER/L*****	CSTB-2.5	T-8F (T-8L)	1.2
JSEGR/L1616K10	16	16	125	3.3	16	13.5	J10ER/L*****	CSTB-2.5	T-8F (T-8L)	1.2

SCLCR/L**Boring & internal facing****S type (Positive, screw-on)**Cutting edge style **L**

Right-hand (R) shown

**Steel shank**

Metric	Min. bore.dia. ϕD_m	Dimensions (mm)								Std. corner radius r_E	Insert	Parts		Torque (lb·ft)
		ϕD_s	f	L1	L2	h	f2	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

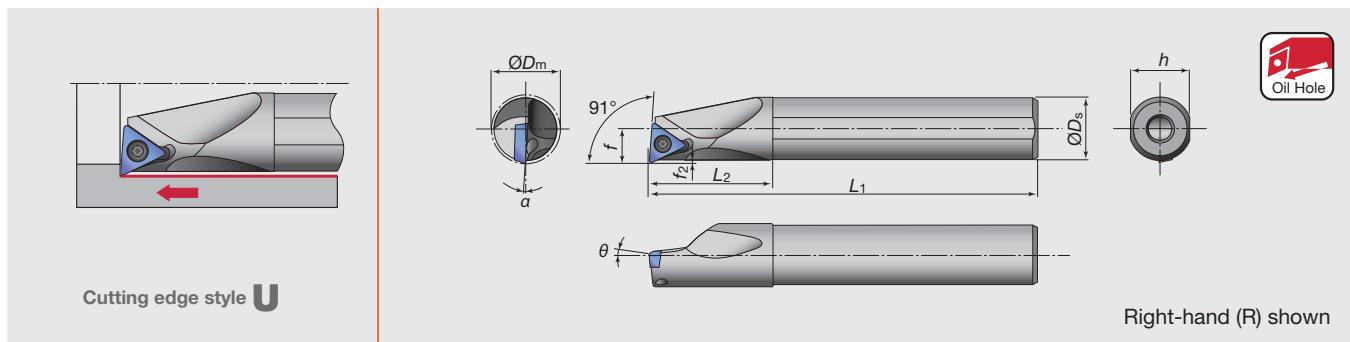
Carbide shank

Metric	Min. bore.dia. ϕD_m	Dimensions (mm)								Std. corner radius r_E	Insert	Parts		Torque (N·m)
		ϕD_s	f	L1	L2	h	f2	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)

**Steel shank**

Metric	Min. bore.dia. ϕD_m	Dimensions (mm)							Std. corner radius r_ϵ	Insert	Parts		Torque (lb·ft)	
		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
A08H-STUPR/L07-D080	8	8	4	100	19.5	7.5	0.5	+5°	-10°	0.4	TP**0701	CSTB-2.2L038	T-7F	0.9

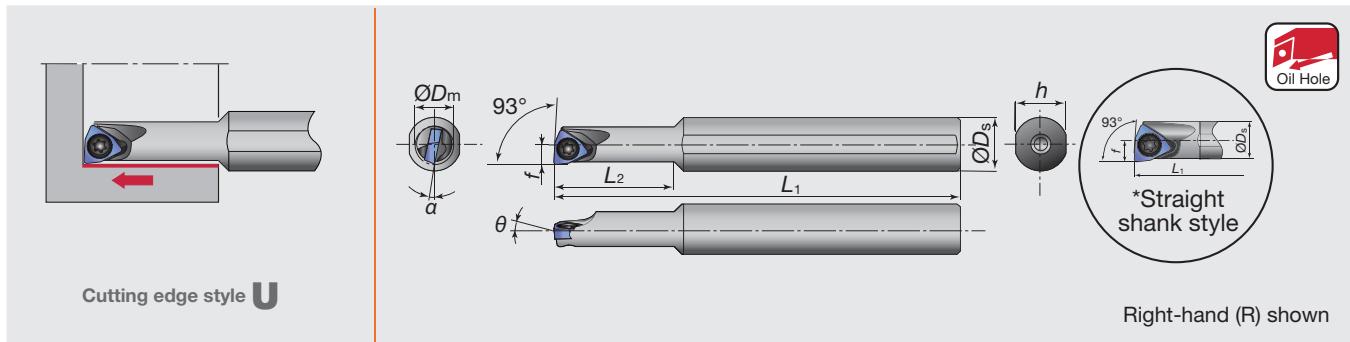
Carbide shank

Metric	Min. bore.dia. ϕD_m	Dimensions (mm)							Std. corner radius r_ϵ	Insert	Parts		Torque (N·m)	
		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
E08G-STUPR/L07-D080	8	8	4	90	44.5	7.5	0.5	+5°	-10°	0.4	TP**0701	CSTB-2.2L038	T-7F	0.9
E08K-STUPR/L07-D080	8	8	4	125	44.5	7.5	0.5	+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).

SWUBR/L Boring

S type (Positive, screw-on)



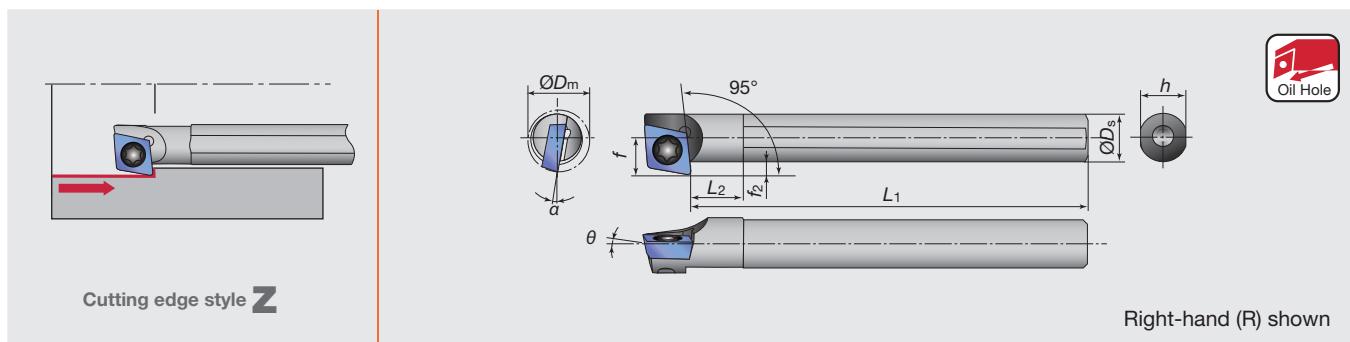
Steel shank

Metric	Min. bore.dia. ϕD_m	Dimensions (mm)							Std. corner radius r_e	Insert	Parts		Torque (lb·ft)	
		ϕD_s	f	L_1	L_2	h	f_2	θ			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	-	0°	-12°	0.4	WB**0301	CSTB-2	T-6F	0.6
*A07G-SWUBR/L03-D080	8	7	4	90	12	6.75	-	0°	-11°	0.4	WB**0301	CSTB-2	T-6F	0.6
A08H-SWUBR03-D060	6	8	3.1	100	18	7.5	-	0°	-12°	0.4	WB**0301	CSTB-2	T-6F	0.6
A08H-SWUBR03-D070	7	8	3.6	100	20	7.5	-	0°	-12°	0.4	WB**0301	CSTB-2	T-6F	0.6

Carbide shank

Metric	Min. bore.dia. ϕD_m	Dimensions (mm)							Std. corner radius r_e	Insert	Parts		Torque (N·m)	
		ϕD_s	f	L_1	L_2	h	f_2	θ			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	-	0°	-12°	0.4	WB**0301	CSTB-2	T-6F	0.6
*E07H-SWUBR/L03-D080	8	7	4	100	14	6.75	-	0°	-11°	0.4	WB**0301	CSTB-2	T-6F	0.6
E08K-SWUBR03-D060	6	8	3.1	125	30	7.5	-	0°	-12°	0.4	WB**0301	CSTB-2	T-6F	0.6
E08K-SWUBR03-D070	7	8	3.6	125	40	7.5	-	0°	-12°	0.4	WB**0301	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 (SWUBL ** type), and the left-hand insert (L) is used for the right-hand toolholder (SWUBR ** type).

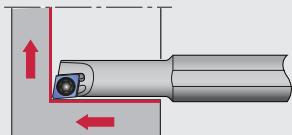
SEZPR/L**Internal retracting****S type (Positive, screw-on)****Steel shank**

Metric	Min. bore.dia. ϕD_m	ϕD_s	f	Dimensions (mm)					Std. corner radius r_ϵ	Insert	Parts		Torque (lb·ft)	
				L1	L2	h	f2	θ			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	1.2	0°	-6°	0.2	EP**03X1	CSTA-1.6	T-6F	0.6

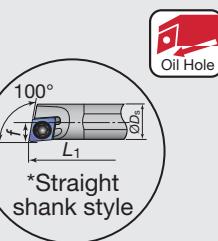
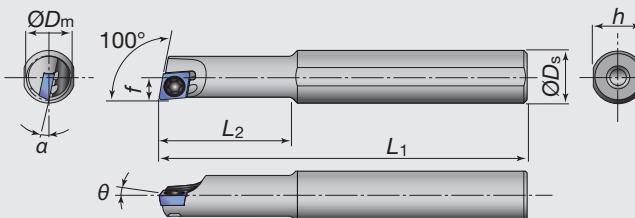
Carbide shank

Metric	Min. bore.dia. ϕD_m	ϕD_s	f	Dimensions (mm)					Std. corner radius r_ϵ	Insert	Parts		Torque (N·m)	
				L1	L2	h	f2	θ			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	1.2	0°	-6°	0.2	EP**03X1	CSTA-1.6	T-6F	0.6

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).

SEXPRL**Boring and internal facing**

Cutting edge style X



Right-hand (R) shown

Steel shank

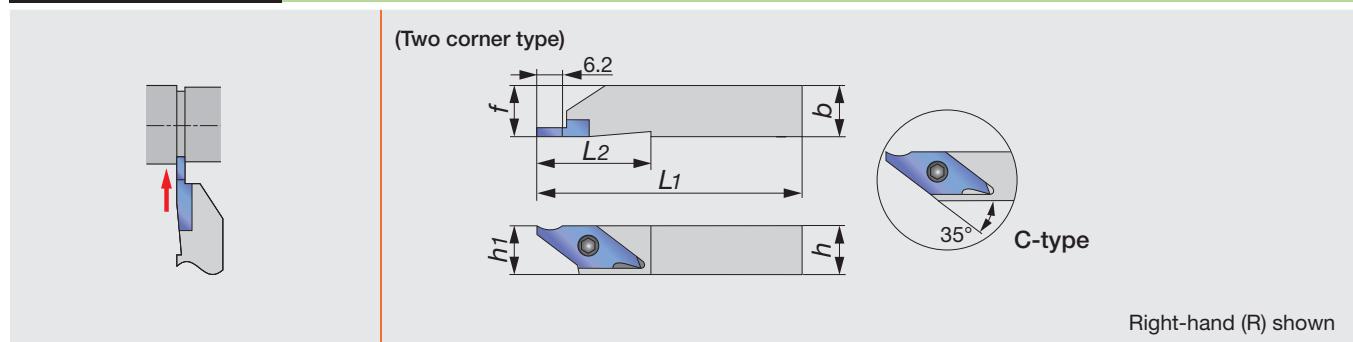
Metric	Min. bore.dia. ϕD_m	Dimensions (mm)							Std. corner radius r_e	Insert	Parts		Torque (lb·ft)	
		ϕD_s	f	L1	L2	h	f_2	θ	α		Clamping screw	Wrench		
*A04F-SEXPRL03-D045	4.5	4	2.3	80	8	3.8	-	0°	-15°	0.2	EP**03X1	CSTA-1.6	T-6F	0.6
*A04F-SEXPRL03-D050	5	4	2.5	80	8	3.8	-	0°	-13°	0.2	EP**03X1	CSTA-1.6	T-6F	0.6
*A05F-SEXPRL04-D055	5.5	5	2.75	80	9	4.8	-	0°	-12°	0.4	EP**0401	CSTB-2	T-6F	0.6
A06G-SEXPRL04-D070	7	6	3.6	90	11	5.75	-	0°	-12°	0.4	EP**0401	CSTB-2	T-6F	0.6
A08H-SEXPRL04-D055	5.5	8	2.75	100	16	7.5	-	0°	-12°	0.4	EP**0401	CSTB-2	T-6F	0.6
A08H-SEXPRL04-D070	7	8	3.6	100	20	7.5	-	0°	-12°	0.4	EP**0401	CSTB-2	T-6F	0.6

Carbide shank

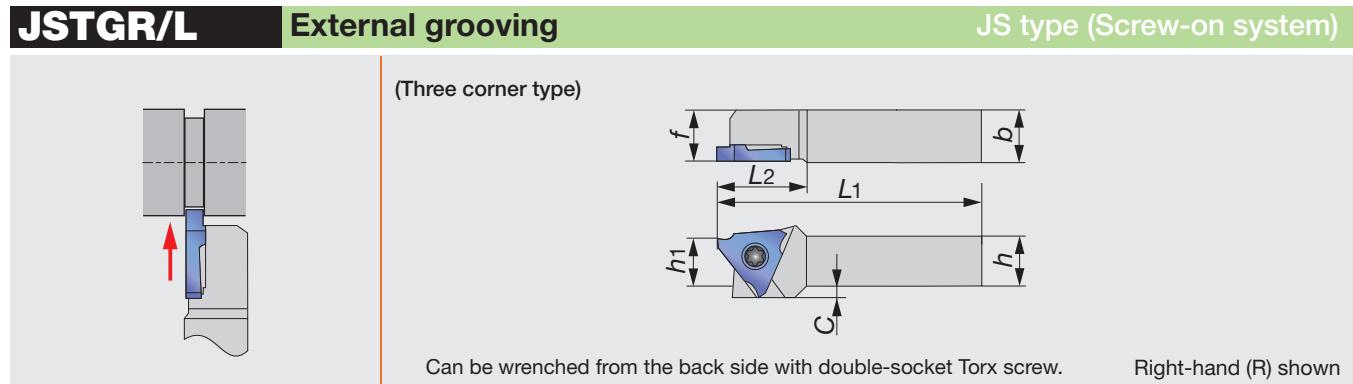
Metric	Min. bore.dia. ϕD_m	Dimensions (mm)							Std. corner radius r_e	Insert	Parts		Torque (N·m)	
		ϕD_s	f	L1	L2	h	f_2	θ	α		Clamping screw	Wrench		
*E04G-SEXPRL03-D045	4.5	4	2.3	90	9	3.8	-	0°	-15°	0.2	EP**03X1	CSTA-1.6	T-6F	0.6
*E04G-SEXPRL03-D050	5	4	2.5	90	9	3.8	-	0°	-13°	0.2	EP**03X1	CSTA-1.6	T-6F	0.6
*E05G-SEXPRL04-D055	5.5	5	2.75	90	10	4.8	-	0°	-12°	0.4	EP**0401	CSTB-2	T-6F	0.6
E06H-SEXPRL04-D070	7	6	3.6	100	12	5.75	-	0°	-12°	0.4	EP**0401	CSTB-2	T-6F	0.6
E08K-SEXPRL04-D055	5.5	8	2.75	125	28	7.5	-	0°	-12°	0.4	EP**0401	CSTB-2	T-6F	0.6
E08K-SEXPRL04-D070	7	8	3.6	125	40	7.5	-	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 (SEXPRL type), and the left-hand insert (L) is used for the right-hand toolholder (SEXPRL type).

Grooving toolholders

J-SERIES**JSVGR/L****External grooving****JS type (Screw-on system)**

Metric	Dimensions (mm)						Insert	Parts		Torque (N·m)
	h	b	L_1	L_2	h_1	f		Clamping screw	Wrench (Optional)	
JSVGR/L1010K-C	10	10	125	23	10	10	JVGR/L***F	CSTB-3S	T-9F (T-9L)	2.3
JSVGR/L1212K-C	12	12	125	23	12	12	JVGR/L***F	CSTB-3S	T-9F (T-9L)	2.3
JSVGR/L1616K	16	16	125	23	16	16	JVGR/L***F	CSTB-3S	T-9F (T-9L)	2.3

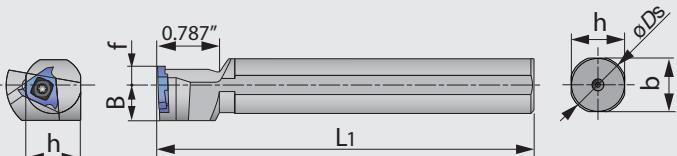
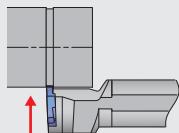


Metric	Dimensions (mm)							Insert	Parts		Torque (N·m)
	h	b	L_1	L_2	h_1	f	C		Clamping screw	Wrench (Optional)	
JSTGR/L1010X3	10	10	120	18.5	10	10	2	JTGR/L3**	CSTB-4SD	T-8F (T-8L)	1.2
JSTGR/L1010K3	10	10	125	18.5	10	10	2	JTGR/L3**	CSTB-4SD	T-8F (T-8L)	1.2
JSTGR/L1212F3	12	12	85	18.5	12	12	-	JTGR/L3**	CSTB-4SD	T-8F (T-8L)	1.2
JSTGR/L1212X3	12	12	120	18.5	12	12	-	JTGR/L3**	CSTB-4SD	T-8F (T-8L)	1.2
JSTGR/L1616X3	16	16	120	18.5	16	16	-	JTGR/L3**	CSTB-4SD	T-8F (T-8L)	1.2

JS-TGL3

External grooving

JS type (Screw-on system)



Left-hand (L) shown

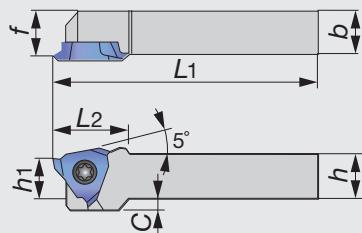
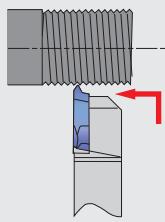
Inch	Dimensions (in)						Insert	Parts		Torque (lb·ft)
	øDs	f	L ₁	L ₂	h/b	B		Clamping screw	Wrench	
JS19K-TGL3	0.750	0.236	4.921	-	0.709	0.453	JTGR3*** (F)	CSTB-4S	T-15F	2.2
JS25K-TGL3	1.000	0.394	4.921	-	0.945	0.500	JTGR3*** (F)	CSTB-4S	T-15F	2.2

Metric	Dimensions (mm)						Insert	Parts		Torque (N·m)
	øDs	f	L ₁	L ₂	h/b	B		Clamping screw	Wrench	
JS19K-TGL3	19.05	6	125	-	18	11.5	JTGR3*** (F)	CSTB-4S	T-15F	3.0
JS20K-TGL3	20	6	125	-	19	11.5	JTGR3*** (F)	CSTB-4S	T-15F	3.0
JS22K-TGL3	22	6	125	-	21	11.5	JTGR3*** (F)	CSTB-4S	T-15F	3.0
JS25K-TGL3	25.4	10	125	-	24	12.7	JTGR3*** (F)	CSTB-4S	T-15F	3.0

Threading
JSTTR

External threading

JS type (Screw-on system)



Can be wrenched from the back side with double-socket Torx screw.

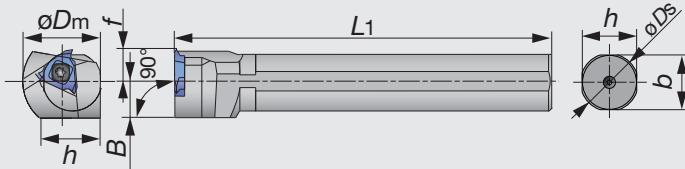
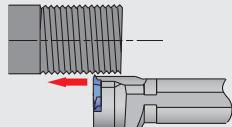
Right-hand (R) shown

Metric	Dimensions (mm)							Insert	Parts		Torque (N·m)
	h	b	L ₁	L ₂	h ₁	f	C		Clamping screw	Wrench (Optional)	
JSTTR/L1010X3	10	10	120	18.5	10	9.5	2	JTTR/L3**	CSTB-4SD	T-8F (T-8L)	1.2
JSTTR/L1010K3	10	10	125	18.5	10	9.5	2	JTTR/L3**	CSTB-4SD	T-8F (T-8L)	1.2
JSTTR/L1212F3	12	12	85	18.5	12	11.5	-	JTTR/L3**	CSTB-4SD	T-8F (T-8L)	1.2
JSTTR/L1212X3	12	12	120	18.5	12	11.5	-	JTTR/L3**	CSTB-4SD	T-8F (T-8L)	1.2
JSTTR/L1616X3	16	16	120	18.5	16	15.5	-	JTTR/L3**	CSTB-4SD	T-8F (T-8L)	1.2

JS-TTL3

External threading

JS-type (Screw-on system)



Right-hand (R) shown

Inch	Dimensions (in)					Insert	Parts		Torque (lb·ft)
	øDs	f	L ₁	h/b	B		Clamping screw	Wrench	
JS19K-TTL3	0.750	0.394	4.921	0.709	0.453	JTTR30**F	CSTB-4S	T-15F	2.6
JS25K-TTL3	1.000	0.394	4.921	0.945	0.500	JTTR30**F	CSTB-4S	T-15F	2.6
Metric	Dimensions (mm)					Insert	Parts		Torque (N·m)
	øDs	f	L ₁	h/b	B		Clamping screw	Wrench	
JS19K-TTL3	19.05	10	125	18	11.5	JTTR30**F	CSTB-4S	T-15F	3.5
JS20K-TTL3	20	10	125	19	11.5	JTTR30**F	CSTB-4S	T-15F	3.5
JS22K-TTL3	22	10	125	21	11.5	JTTR30**F	CSTB-4S	T-15F	3.5
JS25K-TTL3	25.4	10	125	24	12.7	JTTR30**F	CSTB-4S	T-15F	3.5

Spare parts for TungTurn-Jet toolholders

Toolholder Cat. No	Applicable inserts	Screw	Wrench	Coolant unit
JSDJ2XR/L1212F07-CHP JSDJ2XR/L082-CHP	MINIFTURN DXGU0703□□L/R	SR34-514	T-7F	S-CU-CHP
JSWL2XR/L1212F04-CHP JSWL2XR/L082-CHP	MINIFTURN WXGU0403□□L/R	SR34-514	T-7F	S-CU-CHP
JSVJ2XR/L1212F09-CHP JSVJ2XR/L087-CHP	MINIFTURN VXGU09T2□□L/R	SR34-508	T-7F	S-CU-CHP
JSDJ2CR/L1212F07-CHP JSDJ2CR/L082-CHP	J-SERIES DC□□0702□□	CSTB-2.5	T-8F	S-CU-CHP
JSDJ2CR/L1212F11-CHP	J-SERIES DC□□11T3□□	CSTB-4SD	T-8F	S-CU-CHP
JSVJ2BR/L1212F11-CHP JSVJ2BR/L082-CHP	J-SERIES VB□□1103□□	CSTB-2.5	T-8F	S-CU-CHP

Connection of toolholder and coolant hose

The hose can be connected on the back side, front side, or back-end side.

Toolholder Cat. No	JSDJ2X*** / JSWL2X*** / JSDJ2C*** / JSVJ2B***		
Shank size	≤ 16 mm		
Connection	Back	Front	Back end
Example of connection	<p>Connector Hose $5/16''\text{-}24UNF$</p>	<p>Front</p> <p>$5/16''\text{-}24UNF$</p>	<p>Back end</p> <p>$5/16''\text{-}24UNF$</p>
Connector for toolholder	CHP-CONECTOR5/16-G1/8	-	-
Hose	CHP-HOSE-G1/8-7/16-200BS⁽³⁾ CHP-HOSE-G1/8-7/16-250BS⁽³⁾ CHP-HOSE-G1/8-G1/8-200BB⁽⁴⁾ CHP-HOSE-G1/8-G1/8-250BB⁽⁴⁾	CHP-HOSE-5/16-7/16-200BS⁽³⁾ - - -	CHP-HOSE-5/16-7/16-200BS⁽³⁾ - - -
Connector for machine	CHP-NIPPLE-G1/8-7/16UNF⁽⁵⁾	CHP-NIPPLE-G1/8-7/16UNF⁽⁵⁾	CHP-NIPPLE-G1/8-7/16UNF⁽⁵⁾
Washer for machine	CHP-COPPER-SEAL1/8⁽⁵⁾	CHP-COPPER-SEAL1/8⁽⁵⁾	CHP-COPPER-SEAL1/8⁽⁵⁾

Thread size of hose for machine: ⁽³⁾7/16"-20UNF (G1/8 internal thread)

Must purchase connector⁽⁵⁾ and washer⁽⁵⁾ that apply to the internal thread

⁽⁴⁾G1/8-28 BSPP (External thread)

Parts for coolant hose

Connecting hose

Fig. 1

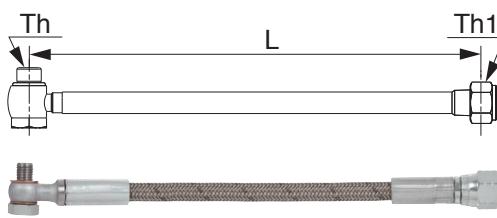
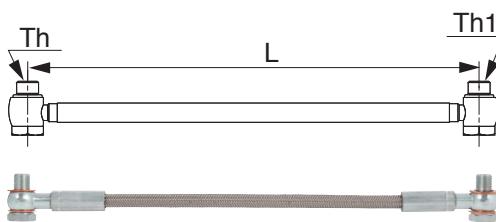
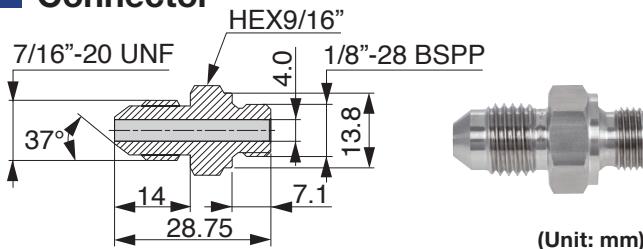


Fig. 2



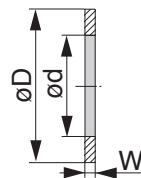
Cat. No	Dimensions (mm)			Max. pressure (Mpa)	Fig.	
	Length	Threading size				
		L	Th	Th1		
CHP-HOSE-G1/8-7/16-200BS	200	G1/8"-28 BSPP	7/16"-20 UNF	26	1	
CHP-HOSE-G1/8-7/16-250BS	250	G1/8"-28 BSPP	7/16"-20 UNF	26	1	
CHP-HOSE-5/16-7/16-200BS	200	5/16"-24UNF	7/16"-20 UNF	20	1	
CHP-HOSE-5/16-G1/8-200BS	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

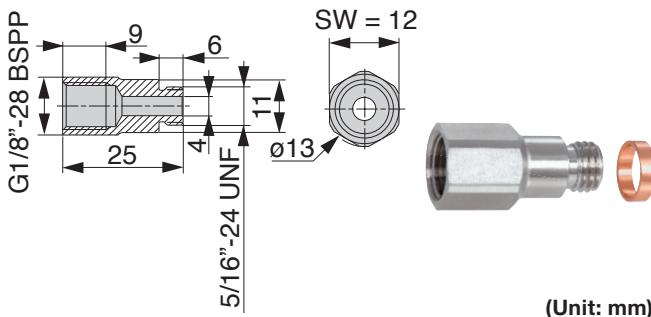


Cat. No
CHP-NIPPLE-G1/8-7/16UNF

■ Seal washer



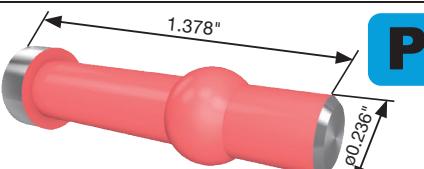
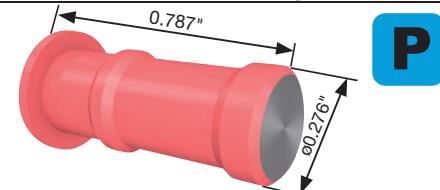
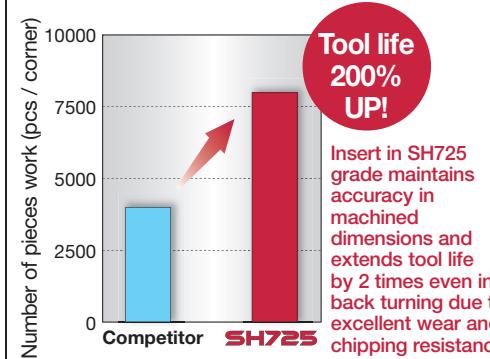
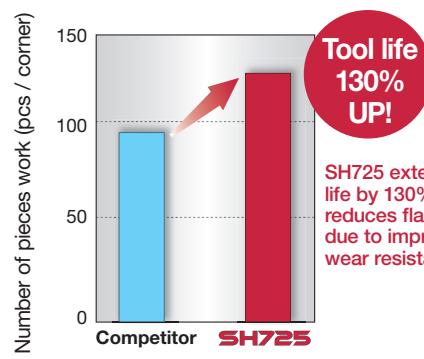
■ Connector for small lathe with seal washer



Cat. No
CHP-CONECTOR/5/16-G1/8

Cat. No	Dimensions (mm)		
	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

PRACTICAL EXAMPLES

Workpiece type	Shaft	Shaft
Toolholder	JSEGR1212K10	JSVL2PL102
Insert	J10ER010BF	VPET1103008MFR-JRP
Grade	SH725	SH725
	12L14	Low carbon alloy
Workpiece material		
Cutting conditions	328	492
Feed : f (ipr)	0.002	0.001
Depth of cut : ap (in)	0.047	0.020
Machining	Back Turning	External turning
Coolant	Wet	Wet
Results	 <p>Tool life 200% UP!</p> <p>Insert in SH725 grade maintains accuracy in machined dimensions and extends tool life by 2 times even in back turning due to excellent wear and chipping resistance.</p>	 <p>Tool life 130% UP!</p> <p>SH725 extends tool life by 130% and reduces flank wear due to improved wear resistance.</p>



Accuracy and excellence in surface quality of small parts

Ground insert with **4 cutting edges** for highly accurate grooving operations.

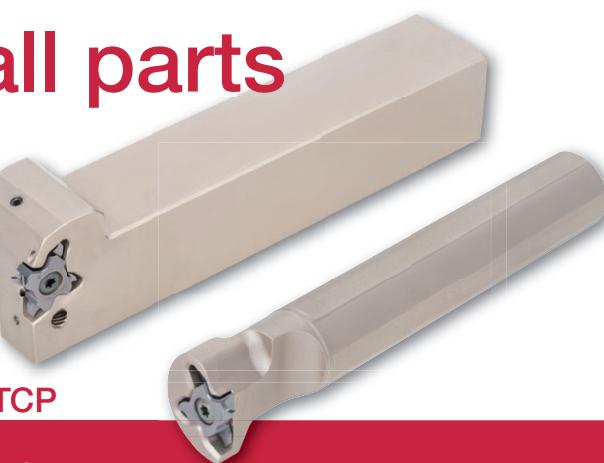
Sharp cutting edge for high accuracy and surface quality.

Designed for machining next to shoulder with no interference.

TCT



TCP



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