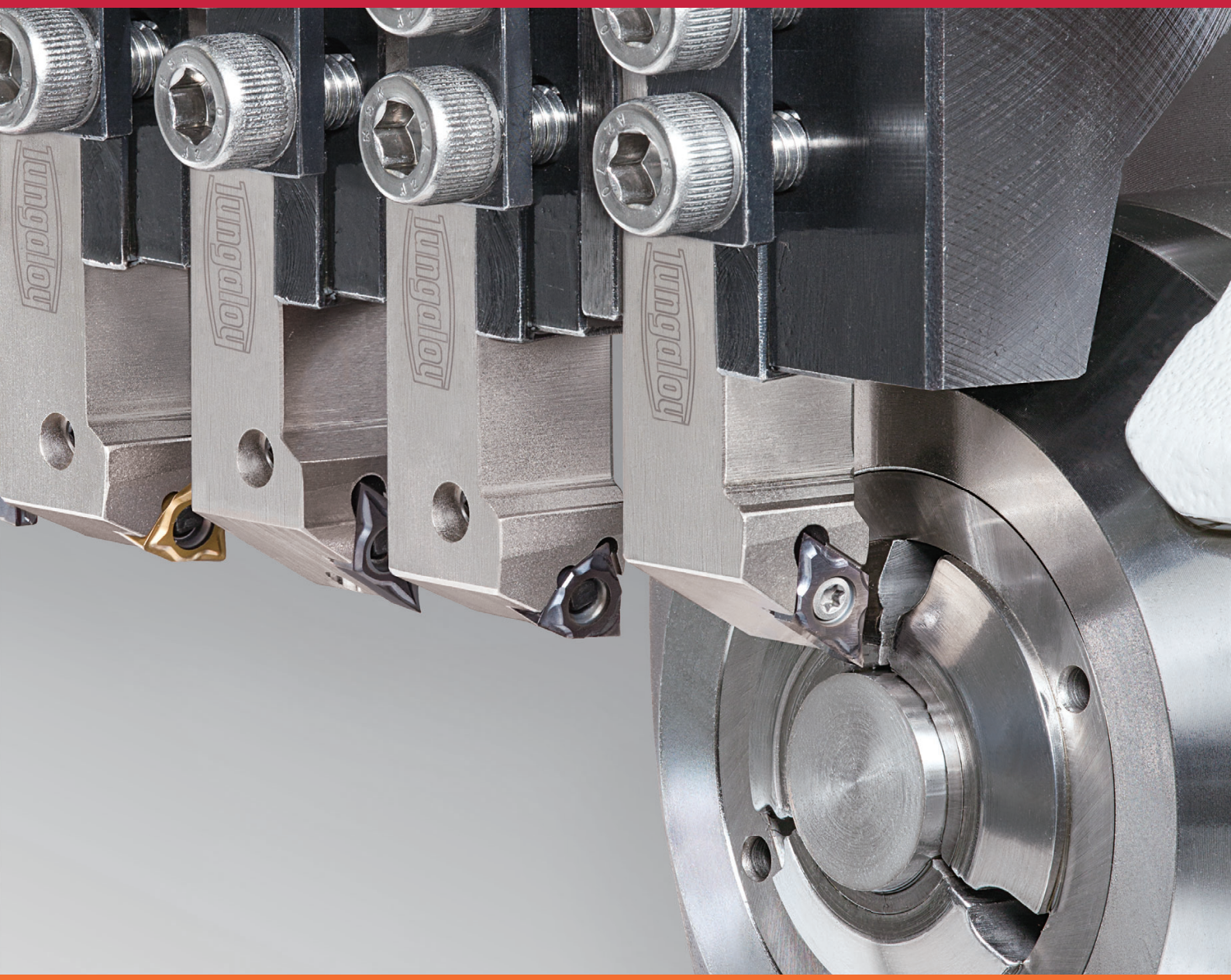
TurnLine

SH725

www.tungaloy.com

Tungaloy Report No. 436-G

Ideal grade for small-part machining



INDUSTRY 4.0

FEED the SPEED!

ACCELERATED MACHINING

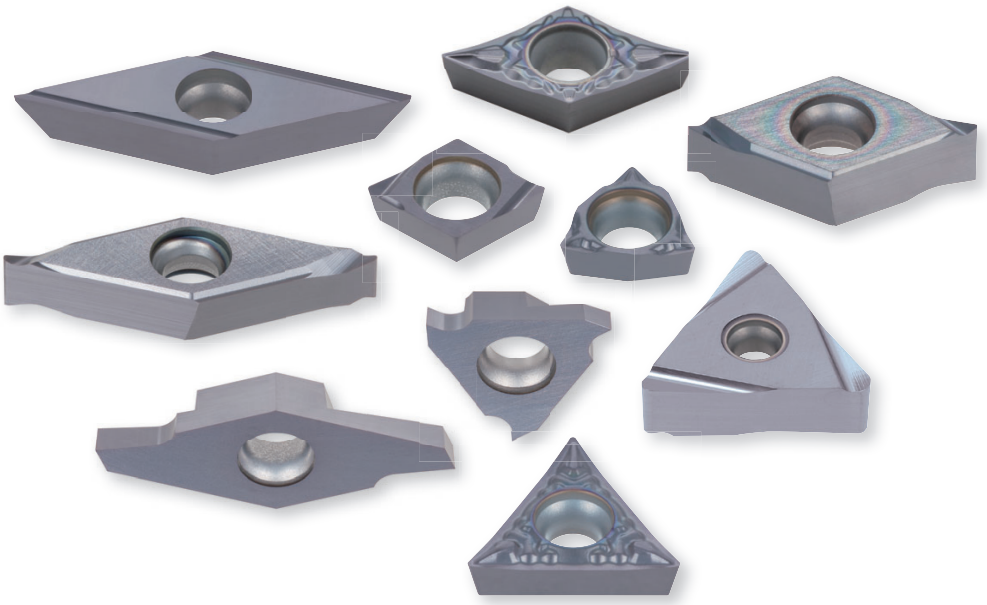
TurnLine

SH725

TUNGALOY

TUNGTURN FORCE

ACCELERATED MACHINING



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

SH725
TUNGALOY

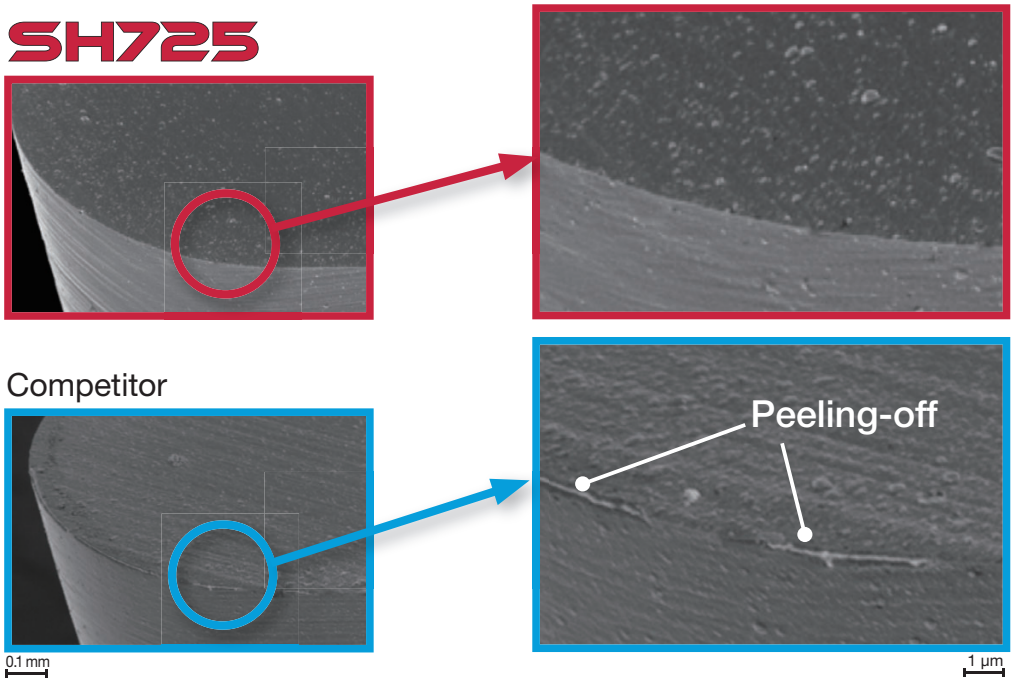
PVD grade exclusively designed for precise-part machining

"High adhesion strength and sharp cutting edge"

➡ Amazing tool life with excellent sharpness!

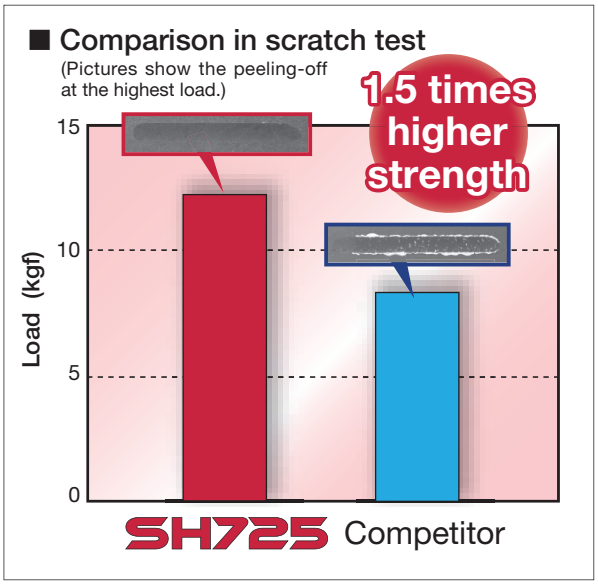
Newly developed coating layer

No peeling-off even on sharp cutting edges



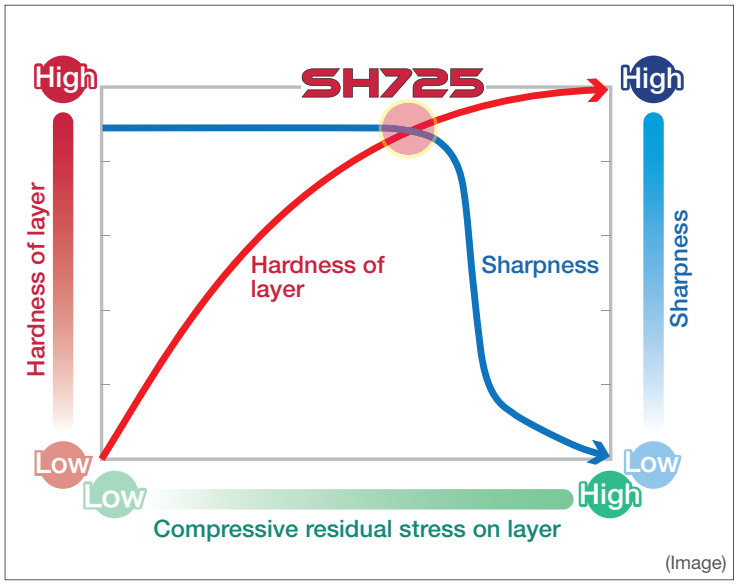
Drastically improved adhesion strength

Latest coating technology is effectively applied.



Hard coating layer on the sharp cutting edge

Innovative coating with both hardness and sharpness



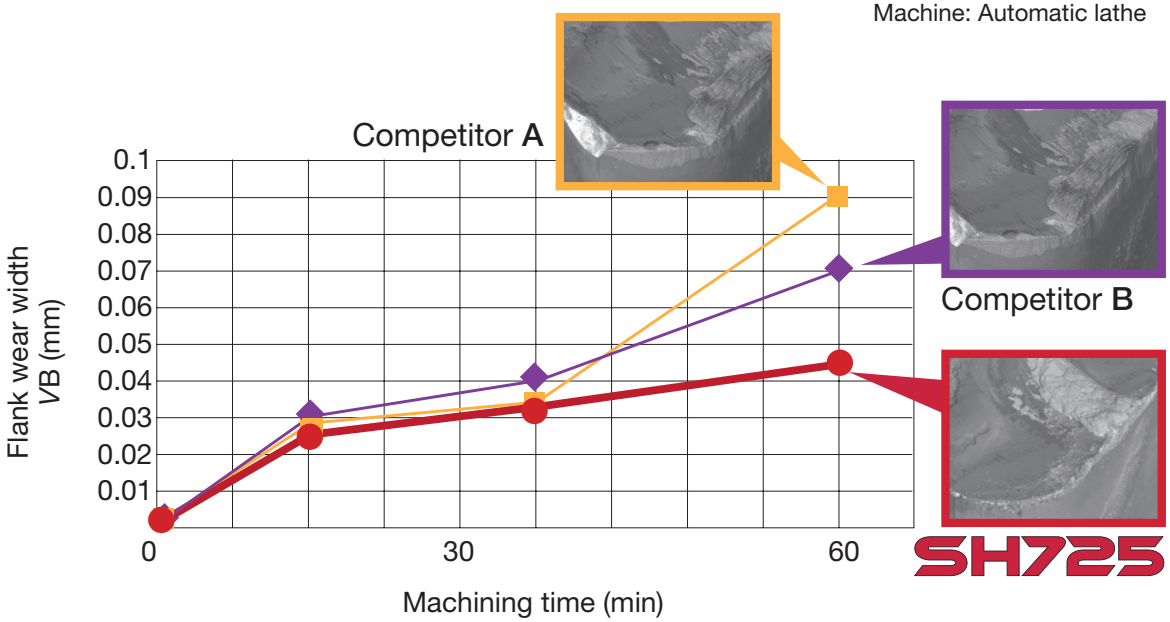
Cutting performance

■ External continuous cutting

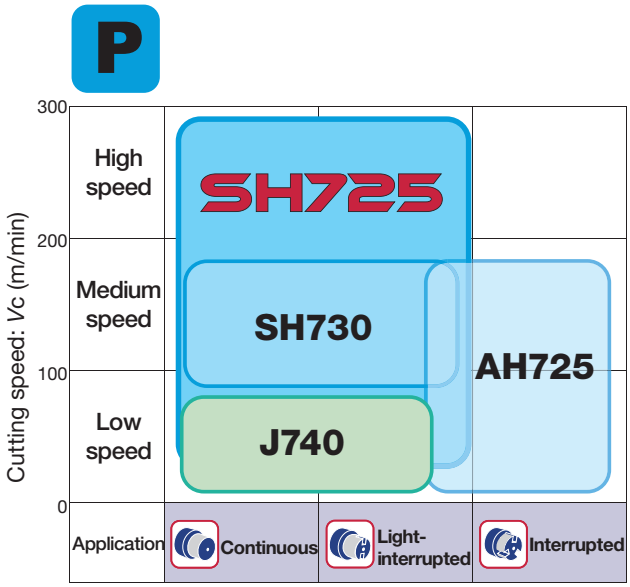
P Carbon steel (S45C / C45)

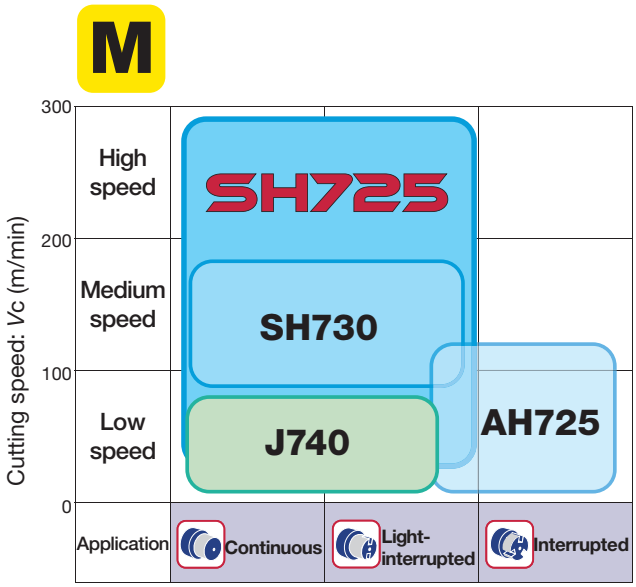
High adhesion strength provides excellent wear resistance.

Workpiece material: S45C / C45 (180HB)
Cutting speed: *Vc* = 150 m/min
Depth of cut: *ap* = 0.5 mm
Feed: *f* = 0.05 mm/rev
Coolant: Oil
Machine: Automatic lathe



Application range





MINIFORCE TURN

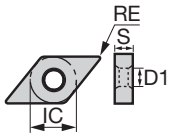
Insert POSITIVE TYPE/DOUBLE-SIDED

● : Continuous cutting
◐ : Light interrupted cutting
✣ : Heavy interrupted cutting

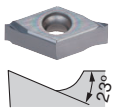
DX

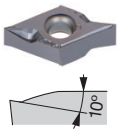
Rhombic, 55° with hole

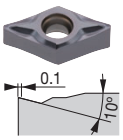
P	Steel	●◐
M	Stainless	●◐
K	Cast iron	
N	Non-ferrous	
S	Superalloys	
H	Hard materials	

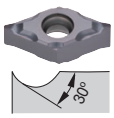


Application	Chipbreaker	Designation	Coated SH725	RE	IC	S	D1
Finishing (sharp edge)	JRP	DXGU070301MFRE-JRP	●	<0.1	6.35	3.18	2.7
		DXGU070301MFLE-JRP	●	<0.1	6.35	3.18	2.7
		DXGU070302MFRE-JRP	●	<0.2	6.35	3.18	2.7
		DXGU070302MFLE-JRP	●	<0.2	6.35	3.18	2.7
Finishing to medium cutting (sharp edge)	JS	DXGU070301MFR-JS	●	<0.1	6.35	3.18	2.7
		DXGU070301MFL-JS	●	<0.1	6.35	3.18	2.7
		DXGU070302MFR-JS	●	<0.2	6.35	3.18	2.7
		DXGU070302MFL-JS	●	<0.2	6.35	3.18	2.7
		DXGU070304MFR-JS	●	<0.4	6.35	3.18	2.7
		DXGU070304MFL-JS	●	<0.4	6.35	3.18	2.7
	JTS	DXGU070301MFR-JTS	●	<0.1	6.35	3.18	2.7
		DXGU070301MFL-JTS	●	<0.1	6.35	3.18	2.7
		DXGU070302MFR-JTS	●	<0.2	6.35	3.18	2.7
		DXGU070302MFL-JTS	●	<0.2	6.35	3.18	2.7
Finishing (Low cutting force) (sharp edge)	JSS	DXGU070301MFR-JSS	●	<0.1	6.35	3.18	2.7
		DXGU070301MFL-JSS	●	<0.1	6.35	3.18	2.7
		DXGU070302MFR-JSS	●	<0.2	6.35	3.18	2.7
		DXGU070302MFL-JSS	●	<0.2	6.35	3.18	2.7





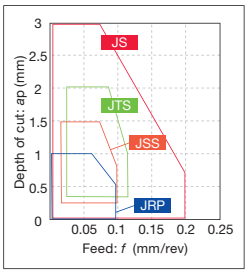




*Corner radius (RE) with a sign of inequality (<) means minus tolerance.

● : Line up

Chip control range



* Corner radius **RE** = 0.1, 0.2, (0.4 for JS only)

Reference pages : External toolholders → P.26 - Internal toolholders → P.50 -

MINIFORCE TURN

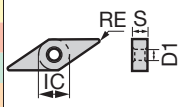
Insert POSITIVE TYPE/DOUBLE-SIDED

● : Continuous cutting
◐ : Light interrupted cutting
✠ : Heavy interrupted cutting

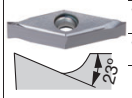
VX

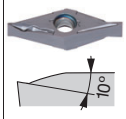
Rhombic, 35° with hole

P	Steel	●◐
M	Stainless	●◐
K	Cast iron	
N	Non-ferrous	
S	Superalloys	
H	Hard materials	



Application	Chipbreaker	Designation	Coated SH725	RE	IC	S	D1
Finishing (sharp edge)	JRP	VXGU09T201MFRE-JRP	●	<0.1	5.56	2.47	2.5
		VXGU09T201MFLE-JRP	●	<0.1	5.56	2.47	2.5
		VXGU09T202MFRE-JRP	●	<0.2	5.56	2.47	2.5
		VXGU09T202MFLE-JRP	●	<0.2	5.56	2.47	2.5
Finishing to medium cutting (sharp edge)	JS	VXGU09T201MFR-JS	●	<0.1	5.56	2.47	2.5
		VXGU09T201MFL-JS	●	<0.1	5.56	2.47	2.5
		VXGU09T202MFR-JS	●	<0.2	5.56	2.47	2.5
		VXGU09T202MFL-JS	●	<0.2	5.56	2.47	2.5
		VXGU09T204MFR-JS	●	<0.4	5.56	2.47	2.5
		VXGU09T204MFL-JS	●	<0.4	5.56	2.47	2.5

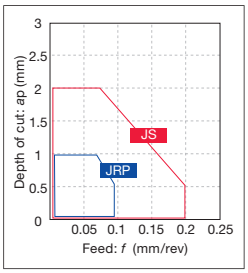




*Corner radius (RE) with a sign of inequality (<) means minus tolerance.

● : Line up

Chip control range



* Corner radius **RE** = 0.1, 0.2, (0.4 for JS only)

Reference pages : External toolholders → P.29 -

MINIFORCE TURN

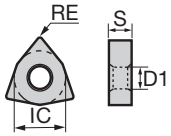
Insert POSITIVE TYPE/DOUBLE-SIDED

● : Continuous cutting
◐ : Light interrupted cutting
✠ : Heavy interrupted cutting

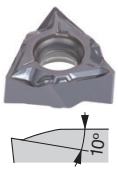
WX

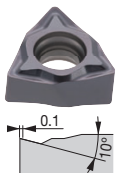
Trigon, 80° with hole

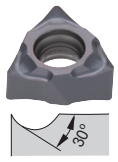
P	Steel	●◐
M	Stainless	●◐
K	Cast iron	
N	Non-ferrous	
S	Superalloys	
H	Hard materials	



Application	Chipbreaker	Designation	Coated SH725	RE	IC	S	D1
Finishing to medium cutting (sharp edge)	JS	WXGU040301MFR-JS	●	<0.1	6.35	3.18	2.7
		WXGU040301MFL-JS	●	<0.1	6.35	3.18	2.7
		WXGU040302MFR-JS	●	<0.2	6.35	3.18	2.7
		WXGU040302MFL-JS	●	<0.2	6.35	3.18	2.7
		WXGU040304MFR-JS	●	<0.4	6.35	3.18	2.7
		WXGU040304MFL-JS	●	<0.4	6.35	3.18	2.7
	JTS	WXGU040301MFR-JTS	●	<0.1	6.35	3.18	2.7
		WXGU040301MFL-JTS	●	<0.1	6.35	3.18	2.7
		WXGU040302MFR-JTS	●	<0.2	6.35	3.18	2.7
		WXGU040302MFL-JTS	●	<0.2	6.35	3.18	2.7
Finishing (Low cutting force) (sharp edge)	JSS	WXGU040301MFR-JSS	●	<0.1	6.35	3.18	2.7
		WXGU040301MFL-JSS	●	<0.1	6.35	3.18	2.7
		WXGU040302MFR-JSS	●	<0.2	6.35	3.18	2.7
		WXGU040302MFL-JSS	●	<0.2	6.35	3.18	2.7



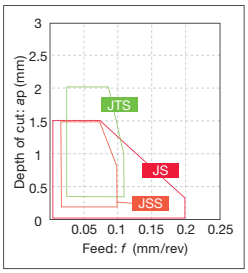




*Corner radius (RE) with a sign of inequality (<) means minus tolerance.

● : Line up

Chip control range



* Corner radius **RE** = 0.1, 0.2, (0.4 for JS only)

Reference pages : External toolholders → P.32 - Internal toolholders → P.52

J-SERIES

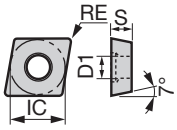
Insert POSITIVE TYPE

● : Continuous cutting
◐ : Light interrupted cutting
✠ : Heavy interrupted cutting

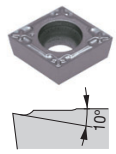
CC

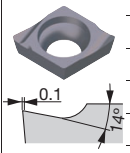
Rhombic, 80° with hole Positive 7°

P	Steel	●◐
M	Stainless	●◐
K	Cast iron	
N	Non-ferrous	
S	Superalloys	
H	Hard materials	



Application	Chipbreaker	Designation	Coated SH725	Dimension (mm) RE	IC	S	D1
Precision finishing (Sharp edge)	01	CCGT060202F-01	●	<0.2	6.35	2.38	2.8
		CCGT060204F-01	●	<0.4	6.35	2.38	2.8
		CCGT09T302F-01	●	<0.2	9.525	3.97	4.4
		CCGT09T304F-01	●	<0.4	9.525	3.97	4.4
Finishing (Sharp edge)	W08	CCGT03X100FL-W08	●	0.03	3.57	1.39	1.9
		CCGT03X100FR-W08	●	0.03	3.57	1.39	1.9
		CCGT03X101FL-W08	●	0.1	3.57	1.39	1.9
		CCGT03X101FR-W08	●	0.1	3.57	1.39	1.9
		CCGT03X102FL-W08	●	0.2	3.57	1.39	1.9
		CCGT03X102FR-W08	●	0.2	3.57	1.39	1.9
		CCGT03X104FL-W08	●	0.4	3.57	1.39	1.9
		CCGT03X104FR-W08	●	0.4	3.57	1.39	1.9
		CCGT04T100FL-W08	●	0.03	4.37	1.79	2.2
		CCGT04T100FR-W08	●	0.03	4.37	1.79	2.2
		CCGT04T101FL-W08	●	0.1	4.37	1.79	2.2
		CCGT04T101FR-W08	●	0.1	4.37	1.79	2.2
		CCGT04T102FL-W08	●	0.2	4.37	1.79	2.2
		CCGT04T102FR-W08	●	0.2	4.37	1.79	2.2
		CCGT04T104FL-W08	●	0.4	4.37	1.79	2.2
		CCGT04T104FR-W08	●	0.4	4.37	1.79	2.2

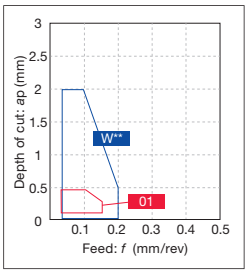




*Corner radius (RE) with a sign of inequality (<) means minus tolerance.

● : Line up

Chip control range



Reference pages : External toolholders → P.35 - Internal toolholders → P.53

J-SERIES

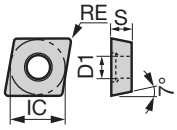
Insert POSITIVE TYPE

● : Continuous cutting
◐ : Light interrupted cutting
✠ : Heavy interrupted cutting

CC

Rhombic, 80° with hole Positive 7°

P	Steel	●◐
M	Stainless	●◐
K	Cast iron	
N	Non-ferrous	
S	Superalloys	
H	Hard materials	

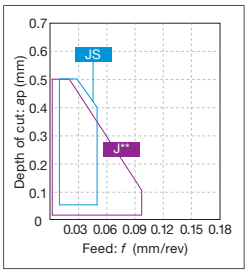


Application	Chipbreaker	Designation	Coated SH725	Dimension (mm) RE	IC	S	D1
For internal turning on small lathes (Sharp edge)	JS	CCGT03X101F-JS	●	<0.1	3.57	1.39	1.9
		CCGT03X102F-JS	●	<0.2	3.57	1.39	1.9
		CCGT03X104F-JS	●	<0.4	3.57	1.39	1.9
		CCGT04T101F-JS	●	<0.1	4.37	1.79	2.2
		CCGT04T102F-JS	●	<0.2	4.37	1.79	2.2
		CCGT04T104F-JS	●	<0.4	4.37	1.79	2.2
For external turning on small lathes (Sharp edge)	JS	CCGT060200FN-JS	●	0.03	6.35	2.38	2.8
		CCGT060201FN-JS	●	<0.1	6.35	2.38	2.8
		CCGT060202FN-JS	●	<0.2	6.35	2.38	2.8
		CCGT060204FN-JS	●	<0.4	6.35	2.38	2.8
		CCGT09T300FN-JS	●	0.03	9.525	3.97	4.4
		CCGT09T301FN-JS	●	<0.1	9.525	3.97	4.4
		CCGT09T302FN-JS	●	<0.2	9.525	3.97	4.4
		CCGT09T304FN-JS	●	<0.4	9.525	3.97	4.4
For external turning on small lathes (Sharp edge)	J10	CCGT060200FR-J10	●	0.03	6.35	2.38	2.8
		CCGT060200FL-J10	●	0.03	6.35	2.38	2.8
		CCGT060201FR-J10	●	0.1	6.35	2.38	2.8
		CCGT060201FL-J10	●	0.1	6.35	2.38	2.8
		CCGT060202FR-J10	●	0.2	6.35	2.38	2.8
		CCGT060202FL-J10	●	0.2	6.35	2.38	2.8
		CCGT09T300FR-J10	●	0.03	9.525	3.97	4.4
		CCGT09T300FL-J10	●	0.03	9.525	3.97	4.4
		CCGT09T301FR-J10	●	0.1	9.525	3.97	4.4
		CCGT09T301FL-J10	●	0.1	9.525	3.97	4.4
		CCGT09T302FR-J10	●	0.2	9.525	3.97	4.4
		CCGT09T302FL-J10	●	0.2	9.525	3.97	4.4
		CCGT09T304FR-J10	●	0.4	9.525	3.97	4.4

*Corner radius (RE) with a sign of inequality (<) means minus tolerance.

● : Line up

Chip control range



* Chip control range with typical R0.1

Reference pages : External toolholders → P.35 - Internal toolholders → P.53

J-SERIES

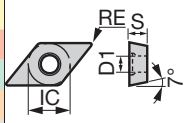
Insert POSITIVE TYPE

● : Continuous cutting
◐ : Light interrupted cutting
✠ : Heavy interrupted cutting

DC

Rhombic, 55° with hole Positive 7°

P	Steel	●◐
M	Stainless	●◐
K	Cast iron	
N	Non-ferrous	
S	Superalloys	
H	Hard materials	

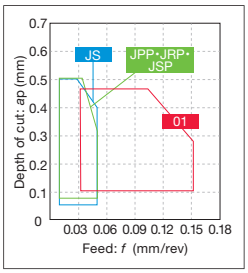


Application	Chipbreaker	Designation	Coated SH725	Dimension (mm) RE	IC	S	D1
Precision finishing (Sharp edge)	01	DCGT070202F-01	●	<0.2	6.35	2.38	2.8
		DCGT070204F-01	●	<0.4	6.35	2.38	2.8
		DCGT11T302F-01	●	<0.2	9.525	3.97	4.4
		DCGT11T304F-01	●	<0.4	9.525	3.97	4.4
For external turning on small lathes (Sharp edge)	JS	DCGT070200FN-JS	●	0.03	6.35	2.38	2.8
		DCGT070201FN-JS	●	<0.1	6.35	2.38	2.8
		DCGT070202FN-JS	●	<0.2	6.35	2.38	2.8
		DCGT11T300FN-JS	●	0.03	9.525	3.97	4.4
		DCGT11T301FN-JS	●	<0.1	9.525	3.97	4.4
		DCGT11T302FN-JS	●	<0.2	9.525	3.97	4.4
		DCGT11T304FN-JS	●	<0.4	9.525	3.97	4.4
For external turning on small lathes (Sharp edge)	JPP	DCET0702008MFR-JPP	●	<0.08	6.35	2.38	2.8
		DCET070201MFR-JPP	●	<0.1	6.35	2.38	2.8
		DCET070201MFL-JPP	●	<0.1	6.35	2.38	2.8
		DCET070202MFR-JPP	●	<0.2	6.35	2.38	2.8
		DCET070202MFL-JPP	●	<0.2	6.35	2.38	2.8
		DCET11T3008MFR-JPP	●	<0.08	9.525	3.97	4.4
		DCET11T301MFR-JPP	●	<0.1	9.525	3.97	4.4
		DCET11T301MFL-JPP	●	<0.1	9.525	3.97	4.4
		DCET11T3018MFR-JPP	●	<0.18	9.525	3.97	4.4
		DCET11T3018MFL-JPP	●	<0.18	9.525	3.97	4.4
		DCET11T302MFR-JPP	●	<0.2	9.525	3.97	4.4
		DCET11T302MFL-JPP	●	<0.2	9.525	3.97	4.4

*Corner radius (RE) with a sign of inequality (<) means minus tolerance.

● : Line up

Chip control range



* Chip control range with typical R0.1

Reference pages : External toolholders → P.37 -

J-SERIES

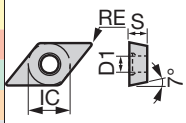
Insert POSITIVE TYPE

● : Continuous cutting
◐ : Light interrupted cutting
✠ : Heavy interrupted cutting

DC

Rhombic, 55° with hole Positive 7°

P	Steel	●◐
M	Stainless	●◐
K	Cast iron	
N	Non-ferrous	
S	Superalloys	
H	Hard materials	

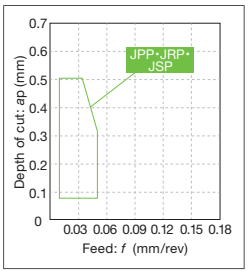


Application	Chipbreaker	Designation	Coated SH725	RE	IC	S	D1
For external turning on small lathes (Sharp edge)	JRP	DCET0702008MFR-JRP	●	<0.08	6.35	2.38	2.8
		DCET070201MFR-JRP	●	<0.1	6.35	2.38	2.8
		DCET070201MFL-JRP	●	<0.1	6.35	2.38	2.8
		DCET0702018MFL-JRP	●	<0.18	6.35	2.38	2.8
		DCET070202MFR-JRP	●	<0.2	6.35	2.38	2.8
		DCET070202MFL-JRP	●	<0.2	6.35	2.38	2.8
		DCET11T3008MFR-JRP	●	<0.08	9.525	3.97	4.4
		DCET11T301MFR-JRP	●	<0.1	9.525	3.97	4.4
		DCET11T3018MFL-JRP	●	<0.18	9.525	3.97	4.4
		DCET11T302MFR-JRP	●	<0.2	9.525	3.97	4.4
		DCET11T302MFL-JRP	●	<0.2	9.525	3.97	4.4
	JSP	DCET0702008MFN-JSP	●	<0.08	6.35	2.38	2.8
		DCET070201MFN-JSP	●	<0.1	6.35	2.38	2.8
		DCET070202MFN-JSP	●	<0.2	6.35	2.38	2.8
		DCET11T3008MFN-JSP	●	<0.08	9.525	3.97	4.4
		DCET11T301MFN-JSP	●	<0.1	9.525	3.97	4.4
		DCET11T3018MFN-JSP	●	<0.18	9.525	3.97	4.4
		DCET11T302MFN-JSP	●	<0.2	9.525	3.97	4.4

*Corner radius (RE) with a sign of inequality (<) means minus tolerance.

● : Line up

Chip control range



* Chip control range with typical R0.1

Reference pages : External toolholders → P.37 -

J-SERIES

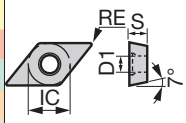
Insert POSITIVE TYPE

● : Continuous cutting
◐ : Light interrupted cutting
✠ : Heavy interrupted cutting

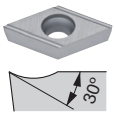
DC

Rhombic, 55° with hole Positive 7°

P	Steel	●◐
M	Stainless	●◐
K	Cast iron	
N	Non-ferrous	
S	Superalloys	
H	Hard materials	

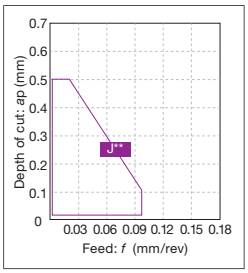


Application	Chipbreaker	Designation	Coated SH725	Dimension (mm) RE	IC	S	D1
For external turning on small lathes (Sharp edge)	J10	DCGT070200FR-J10	●	0.03	6.35	2.38	2.8
		DCGT070200FL-J10	●	0.03	6.35	2.38	2.8
		DCGT070201FR-J10	●	0.1	6.35	2.38	2.8
		DCGT070201FL-J10	●	0.1	6.35	2.38	2.8
		DCGT070202FR-J10	●	0.2	6.35	2.38	2.8
		DCGT070202FL-J10	●	0.2	6.35	2.38	2.8
		DCGT070204FR-J10	●	0.4	6.35	2.38	2.8
		DCGT070204FL-J10	●	0.4	6.35	2.38	2.8
		DCGT11T300FR-J10	●	0.03	9.525	3.97	4.4
		DCGT11T300FL-J10	●	0.03	9.525	3.97	4.4
		DCGT11T301FR-J10	●	0.1	9.525	3.97	4.4
		DCGT11T301FL-J10	●	0.1	9.525	3.97	4.4
		DCGT11T302FR-J10	●	0.2	9.525	3.97	4.4
		DCGT11T302FL-J10	●	0.2	9.525	3.97	4.4



● : Line up

Chip control range



Reference pages : External toolholders → P.37 -

J-SERIES

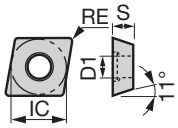
Insert POSITIVE TYPE

● : Continuous cutting
◐ : Light interrupted cutting
✠ : Heavy interrupted cutting

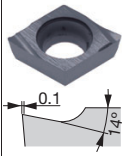
EP

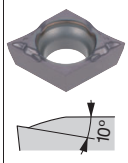
Rhombic, 75° with hole Positive 11°

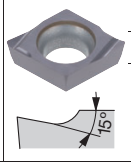
P	Steel	●◐
M	Stainless	●◐
K	Cast iron	
N	Non-ferrous	
S	Superalloys	
H	Hard materials	



Application	Chipbreaker	Designation	Coated SH725	RE	IC	S	D1
Finishing (Sharp edge)	W08	EPGT03X100FL-W08	●	0.03	3.57	1.39	1.9
		EPGT03X100FR-W08	●	0.03	3.57	1.39	1.9
		EPGT03X101FL-W08	●	0.1	3.57	1.39	1.9
		EPGT03X101FR-W08	●	0.1	3.57	1.39	1.9
		EPGT03X102FL-W08	●	0.2	3.57	1.39	1.9
		EPGT03X102FR-W08	●	0.2	3.57	1.39	1.9
		EPGT03X104FL-W08	●	0.4	3.57	1.39	1.9
		EPGT03X104FR-W08	●	0.4	3.57	1.39	1.9
		EPGT040100FL-W08	●	0.03	3.97	1.59	2.3
		EPGT040100FR-W08	●	0.03	3.97	1.59	2.3
		EPGT040101FL-W08	●	0.1	3.97	1.59	2.3
		EPGT040101FR-W08	●	0.1	3.97	1.59	2.3
		EPGT040102FL-W08	●	0.2	3.97	1.59	2.3
		EPGT040102FR-W08	●	0.2	3.97	1.59	2.3
		EPGT040104FL-W08	●	0.4	3.97	1.59	2.3
		EPGT040104FR-W08	●	0.4	3.97	1.59	2.3
For internal turning on small lathes (Sharp edge)	JS	EPGT03X101F-JS	●	<0.1	3.57	1.39	1.9
		EPGT03X102F-JS	●	<0.2	3.57	1.39	1.9
		EPGT03X104F-JS	●	<0.4	3.57	1.39	1.9
		EPGT040101F-JS	●	<0.1	3.97	1.59	2.3
		EPGT040102F-JS	●	<0.2	3.97	1.59	2.3
		EPGT040104F-JS	●	<0.4	3.97	1.59	2.3
Finishing (Sharp edge)	J08	EPGT040100FL-J08	●	0.03	3.97	1.59	2.3
		EPGT040102FL-J08	●	0.2	3.97	1.59	2.3
		EPGT040104FL-J08	●	0.4	3.97	1.59	2.3



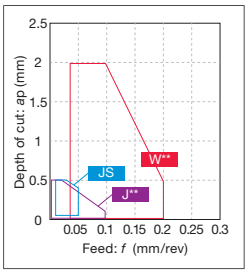




*Corner radius (RE) with a sign of inequality (<) means minus tolerance.

● : Line up

Chip control range



* Chip control range with typical R0.1

Reference pages : Internal toolholders → P.53 -

J-SERIES

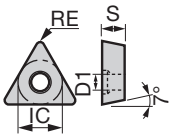
Insert POSITIVE TYPE

● : Continuous cutting
◐ : Light interrupted cutting
✠ : Heavy interrupted cutting

TC

Triangular, 60° with hole Positive 7°

P	Steel	●◐
M	Stainless	●◐
K	Cast iron	
N	Non-ferrous	
S	Superalloys	
H	Hard materials	

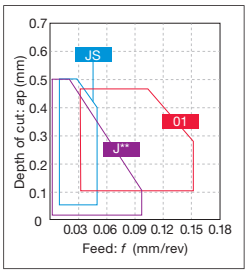


Application	Chipbreaker	Designation	Coated SH725	RE	IC	S	D1
Precision finishing (Sharp edge)	01	TCGT110202F-01	●	<0.2	6.35	2.38	2.8
		TCGT110204F-01	●	<0.4	6.35	2.38	2.8
For external turning on small lathes (Sharp edge)	JS	TCGT110200FN-JS	●	0.03	6.35	2.38	2.8
		TCGT110201FN-JS	●	<0.1	6.35	2.38	2.8
		TCGT110202FN-JS	●	<0.2	6.35	2.38	2.8
		TCGT110204FN-JS	●	<0.4	6.35	2.38	2.8
	J08	TCGT080200FR-J08	●	0.03	4.76	2.38	2.3
		TCGT080200FL-J08	●	0.03	4.76	2.38	2.3
		TCGT080201FR-J08	●	0.1	4.76	2.38	2.3
		TCGT080201FL-J08	●	0.1	4.76	2.38	2.3
		TCGT080202FR-J08	●	0.2	4.76	2.38	2.3
		TCGT080202FL-J08	●	0.2	4.76	2.38	2.3
		TCGT080204FR-J08	●	0.4	4.76	2.38	2.3
	J10	TCGT110200FR-J10	●	0.03	6.35	2.38	2.8
		TCGT110200FL-J10	●	0.03	6.35	2.38	2.8
		TCGT110201FR-J10	●	0.1	6.35	2.38	2.8
		TCGT110201FL-J10	●	0.1	6.35	2.38	2.8
		TCGT110202FR-J10	●	0.2	6.35	2.38	2.8
		TCGT110202FL-J10	●	0.2	6.35	2.38	2.8
		TCGT110204FR-J10	●	0.4	6.35	2.38	2.8
		TCGT110300FR-J10	●	0.03	6.35	3.18	2.8
		TCGT110300FL-J10	●	0.03	6.35	3.18	2.8
		TCGT110301FR-J10	●	0.1	6.35	3.18	2.8
		TCGT110301FL-J10	●	0.1	6.35	3.18	2.8
		TCGT110302FR-J10	●	0.2	6.35	3.18	2.8
		TCGT110302FL-J10	●	0.2	6.35	3.18	2.8

*Corner radius (RE) with a sign of inequality (<) means minus tolerance.

● : Line up

Chip control range



* Chip control range with typical R0.1

Reference pages : External toolholders → P.42

J-SERIES

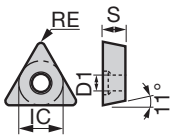
Insert POSITIVE TYPE

● : Continuous cutting
◐ : Light interrupted cutting
✠ : Heavy interrupted cutting

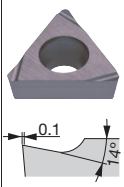
TP

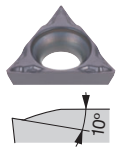
Triangular, 60° with hole Positive 11°

P	Steel	●◐
M	Stainless	●◐
K	Cast iron	
N	Non-ferrous	
S	Superalloys	
H	Hard materials	



Application	Chipbreaker	Designation	Coated SH725	Dimension (mm) RE	IC	S	D1
Finishing (Sharp edge)	W08	TPGT070100FL-W08	●	0.03	4.37	1.59	2.58
		TPGT070100FR-W08	●	0.03	4.37	1.59	2.58
		TPGT070101FL-W08	●	0.1	4.37	1.59	2.58
		TPGT070101FR-W08	●	0.1	4.37	1.59	2.58
		TPGT070102FL-W08	●	0.2	4.37	1.59	2.58
		TPGT070102FR-W08	●	0.2	4.37	1.59	2.58
		TPGT070104FL-W08	●	0.4	4.37	1.59	2.58
		TPGT070104FR-W08	●	0.4	4.37	1.59	2.58
For internal turning on small lathes (Sharp edge)	JS	TPGT070101F-JS	●	<0.1	4.37	1.59	2.58
		TPGT070102F-JS	●	<0.2	4.37	1.59	2.58
		TPGT070104F-JS	●	<0.4	4.37	1.59	2.58

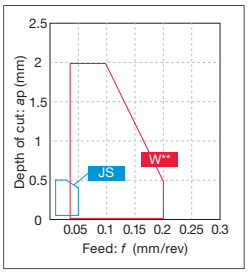




*Corner radius (RE) with a sign of inequality (<) means minus tolerance.

● : Line up

Chip control range



* Chip control range with typical R0.1

Reference pages : Internal toolholders → P.55

J-SERIES

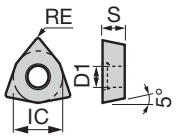
Insert POSITIVE TYPE

● : Continuous cutting
◐ : Light interrupted cutting
✠ : Heavy interrupted cutting

WB

Trigon, 80° with hole Positive 5°

P	Steel	●◐
M	Stainless	●◐
K	Cast iron	
N	Non-ferrous	
S	Superalloys	
H	Hard materials	

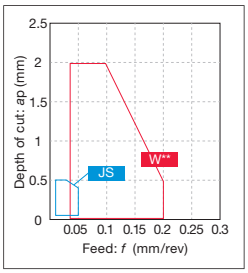


Application	Chipbreaker	Designation	Coated SH725	RE	IC	S	D1
Finishing (Sharp edge)	W08	WBGT030100FL-W08	●	0.03	3.97	1.59	2.3
		WBGT030100FR-W08	●	0.03	3.97	1.59	2.3
		WBGT030101FL-W08	●	0.1	3.97	1.59	2.3
		WBGT030101FR-W08	●	0.1	3.97	1.59	2.3
		WBGT030102FL-W08	●	0.2	3.97	1.59	2.3
		WBGT030102FR-W08	●	0.2	3.97	1.59	2.3
		WBGT030104FL-W08	●	0.4	3.97	1.59	2.3
		WBGT030104FR-W08	●	0.4	3.97	1.59	2.3
For internal turning on small lathes (Sharp edge)	JS	WBGT030101FL-JS	●	<0.1	3.97	1.59	2.3
		WBGT030101FR-JS	●	<0.1	3.97	1.59	2.3
		WBGT030102FL-JS	●	<0.2	3.97	1.59	2.3
		WBGT030102FR-JS	●	<0.2	3.97	1.59	2.3
		WBGT030104FL-JS	●	<0.4	3.97	1.59	2.3
		WBGT030104FR-JS	●	<0.4	3.97	1.59	2.3

*Corner radius (RE) with a sign of inequality (<) means minus tolerance.

● : Line up

Chip control range



* Chip control range with typical R0.1

Reference pages : Internal toolholders → P.55

J-SERIES

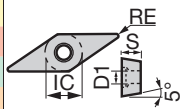
Insert POSITIVE TYPE

● : Continuous cutting
◐ : Light interrupted cutting
✠ : Heavy interrupted cutting

VB

Rhombic, 35° with hole Positive 5°

P	Steel	●◐
M	Stainless	●◐
K	Cast iron	
N	Non-ferrous	
S	Superalloys	
H	Hard materials	

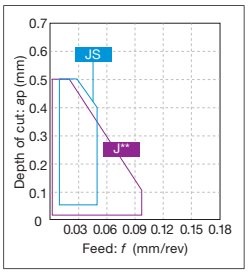


Application	Chipbreaker	Designation	Coated SH725	RE	IC	S	D1
For external turning on small lathes (Sharp edge)	JS	VBGT110300FN-JS	●	0.03	6.35	3.18	2.8
		VBGT110301FN-JS	●	<0.1	6.35	3.18	2.8
		VBGT110302FN-JS	●	<0.2	6.35	3.18	2.8
		VBGT110304FN-JS	●	<0.4	6.35	3.18	2.8
	J10	VBGT110300FR-J10	●	0.03	6.35	3.18	2.8
		VBGT110300FL-J10	●	0.03	6.35	3.18	2.8
		VBGT110301FR-J10	●	0.1	6.35	3.18	2.8
		VBGT110301FL-J10	●	0.1	6.35	3.18	2.8
		VBGT110302FR-J10	●	0.2	6.35	3.18	2.8
		VBGT110302FL-J10	●	0.2	6.35	3.18	2.8
		VBGT110304FR-J10	●	0.4	6.35	3.18	2.8
		VBGT110304FL-J10	●	0.4	6.35	3.18	2.8

*Corner radius (RE) with a sign of inequality (<) means minus tolerance.

● : Line up

Chip control range



* Chip control range with typical R0.1

Reference pages : External toolholders → P.43 -

J-SERIES

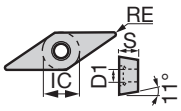
Insert POSITIVE TYPE

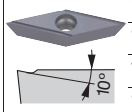
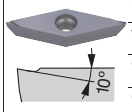
● : Continuous cutting
◐ : Light interrupted cutting
✠ : Heavy interrupted cutting

VP

Rhombic, 35° with hole Positive 11°

P	Steel	●◐
M	Stainless	●◐
K	Cast iron	
N	Non-ferrous	
S	Superalloys	
H	Hard materials	



Application	Chipbreaker	Designation	Coated SH725	RE	IC	S	D1
				Dimension (mm)			
For external turning on small lathes (Sharp edge)	JPP	VPET0802008MFR-JPP	●	<0.08	4.76	2.38	2.3
		VPET0802008MFL-JPP	●	<0.08	4.76	2.38	2.3
		VPET080201MFR-JPP	●	<0.1	4.76	2.38	2.3
		VPET080201MFL-JPP	●	<0.1	4.76	2.38	2.3
		VPET0802018MFR-JPP	●	<0.18	4.76	2.38	2.3
		VPET0802018MFL-JPP	●	<0.18	4.76	2.38	2.3
		VPET080202MFR-JPP	●	<0.2	4.76	2.38	2.3
		VPET080202MFL-JPP	●	<0.2	4.76	2.38	2.3
		VPET1103008MFR-JPP	●	<0.08	6.35	3.18	2.8
		VPET110301MFR-JPP	●	<0.1	6.35	3.18	2.8
		VPET110301MFL-JPP	●	<0.1	6.35	3.18	2.8
		VPET1103018MFR-JPP	●	<0.18	6.35	3.18	2.8
		VPET110302MFR-JPP	●	<0.2	6.35	3.18	2.8
		VPET110302MFL-JPP	●	<0.2	6.35	3.18	2.8
	JRP	VPET0802008MFR-JRP	●	<0.08	4.76	2.38	2.3
		VPET080201MFR-JRP	●	<0.1	4.76	2.38	2.3
		VPET080201MFL-JRP	●	<0.1	4.76	2.38	2.3
		VPET0802018MFR-JRP	●	<0.18	4.76	2.38	2.3
		VPET0802018MFL-JRP	●	<0.18	4.76	2.38	2.3
		VPET080202MFR-JRP	●	<0.2	4.76	2.38	2.3
		VPET080202MFL-JRP	●	<0.2	4.76	2.38	2.3
		VPET1103008MFR-JRP	●	<0.08	6.35	3.18	2.8
		VPET110301MFR-JRP	●	<0.1	6.35	3.18	2.8
		VPET110301MFL-JRP	●	<0.1	6.35	3.18	2.8
		VPET1103018MFR-JRP	●	<0.18	6.35	3.18	2.8
		VPET1103018MFL-JRP	●	<0.18	6.35	3.18	2.8
		VPET110302MFR-JRP	●	<0.2	6.35	3.18	2.8
		VPET110302MFL-JRP	●	<0.2	6.35	3.18	2.8

*Corner radius (RE) with a sign of inequality (<) means minus tolerance.

● : Line up

Reference pages : Chip control range → P.20 External toolholders → P.46

J-SERIES

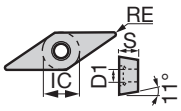
Insert POSITIVE TYPE

● : Continuous cutting
◐ : Light interrupted cutting
✠ : Heavy interrupted cutting

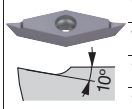
VP

Rhombic, 35° with hole Positive 11°

P	Steel	●◐
M	Stainless	●◐
K	Cast iron	
N	Non-ferrous	
S	Superalloys	
H	Hard materials	



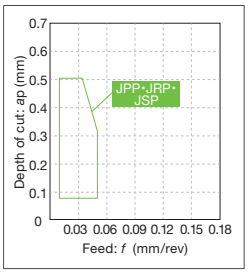
Application	Chipbreaker	Designation	Coated SH725	RE	IC	S	D1
For external turning on small lathes (Sharp edge)	JSP	VPET0802008MFN-JSP	●	<0.08	4.76	2.38	2.3
		VPET080201MFN-JSP	●	<0.1	4.76	2.38	2.3
		VPET0802018MFN-JSP	●	<0.18	4.76	2.38	2.3
		VPET080202MFN-JSP	●	<0.2	4.76	2.38	2.3
		VPET1103008MFN-JSP	●	<0.08	6.35	3.18	2.8
		VPET110301MFN-JSP	●	<0.1	6.35	3.18	2.8
		VPET1103018MFN-JSP	●	<0.18	6.35	3.18	2.8
		VPET110302MFN-JSP	●	<0.2	6.35	3.18	2.8



*Corner radius (RE) with a sign of inequality (<) means minus tolerance.

● : Line up

Chip control range



* Chip control range with typical R0.1

Reference pages : External toolholders → P.46

J-SERIES

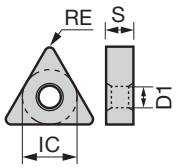
Insert NEGATIVE TYPE

● : Continuous cutting
◐ : Light interrupted cutting
✠ : Heavy interrupted cutting

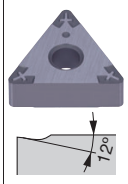
TN

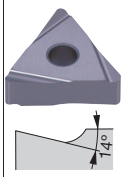
Triangular, 60° with hole

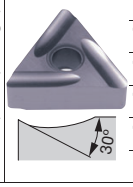
P	Steel	●◐
M	Stainless	●◐
K	Cast iron	
N	Non-ferrous	
S	Superalloys	
H	Hard materials	



Application	Chipbreaker	Designation	Coated SH725	RE	IC	S	D1
Precision finishing (Sharp edge)	01	TNGG160402F-01	●	0.2	9.525	4.76	3.81
		TNGG160404F-01	●	0.4	9.525	4.76	3.81
		TNGG160408F-01	●	0.8	9.525	4.76	3.81
	W	TNGG160402FR-W	●	0.2	9.525	4.76	3.81
		TNGG160402FL-W	●	0.2	9.525	4.76	3.81
		TNGG160404FR-W	●	0.4	9.525	4.76	3.81
		TNGG160404FL-W	●	0.4	9.525	4.76	3.81
		TNGG160408FR-W	●	0.8	9.525	4.76	3.81
		TNGG160408FL-W	●	0.8	9.525	4.76	3.81
Medium cutting (Sharp edge)	P	TNGG160402FR-P	●	0.2	9.525	4.76	3.81
		TNGG160402FL-P	●	0.2	9.525	4.76	3.81
		TNGG160404FR-P	●	0.4	9.525	4.76	3.81
		TNGG160404FL-P	●	0.4	9.525	4.76	3.81
		TNGG160408FR-P	●	0.8	9.525	4.76	3.81
		TNGG160408FL-P	●	0.8	9.525	4.76	3.81

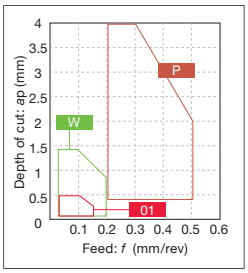






● : Line up

Chip control range



Reference pages : External toolholders → P.47 -

J-SERIES

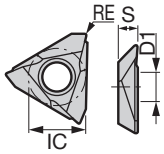
Insert POSITIVE TYPE

● : Continuous cutting
◐ : Light interrupted cutting
✠ : Heavy interrupted cutting

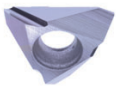
JTB*

Back turning Insert

P	Steel	●◐
M	Stainless	●◐
K	Cast iron	
N	Non-ferrous	
S	Superalloys	
H	Hard materials	



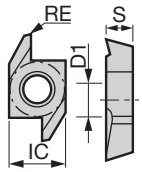
Application	Chipbreaker	Designation	Coated SH725	RE	IC	S	D1
Back turning	-	JTBR3000F	●	0.03	9.5	3.18	4.4
		JTBL3000F	●	0.03	9.5	3.18	4.4
		JTBR3005F	●	0.05	9.5	3.18	4.4
		JTBL3005F	●	0.05	9.5	3.18	4.4
		JTBR3010F	●	0.10	9.5	3.18	4.4
		JTBL3010F	●	0.10	9.5	3.18	4.4
		JTBR3015F	●	0.15	9.5	3.18	4.4
		JTBL3015F	●	0.15	9.5	3.18	4.4



J10E*

Back turning Insert

P	Steel	●◐
M	Stainless	●◐
K	Cast iron	
N	Non-ferrous	
S	Superalloys	
H	Hard materials	



Application	Chipbreaker	Designation	Coated SH725	RE	IC	S	D1
Back turning	-	J10ER005BF	●	0.05	6.35	3.18	3.0
		J10EL005BF	●	0.05	6.35	3.18	3.0
		J10ER010BF	●	0.10	6.35	3.18	3.0
		J10EL010BF	●	0.10	6.35	3.18	3.0
		J10EL015BF	●	0.15	6.35	3.18	3.0
		J10ER015BF	●	0.15	6.35	3.18	3.0

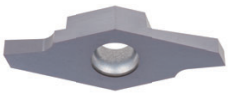
● : Line up

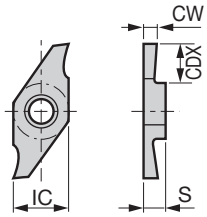
Reference pages : External toolholders → P.48 -

J-SERIES

Inserts for grooving

JVG (handed insert with sharp edge)





Right hand (R) shown.

Designation	Coated SH725 R	Coated SH725 L	IC	S	$CW^{+0.05}_{0}$	CDX	Max. groove depth
JVGR/L033F	●	●	7.94	3.18	0.33	0.8	0.7
JVGR/L050F	●	●	7.94	3.18	0.5	1.2	1.1
JVGR/L075F	●	●	7.94	3.18	0.75	2	1.9
JVGR/L095F	●	●	7.94	3.18	0.95	2	1.9
JVGR/L100F	●	●	7.94	3.18	1	6	5.5
JVGR/L125F	●	●	7.94	3.18	1.25	5.5	5
JVGR/L150F	●	●	7.94	3.18	1.5	6	5.5
JVGR/L200F	●	●	7.94	3.18	2	6	5.5

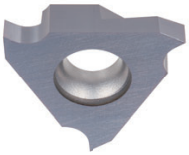
● : Line up

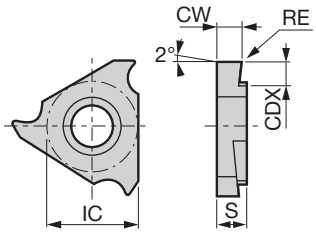
Reference pages : Grooving toolholders → P.56

J-SERIES

Inserts for grooving

JTG (sharp edge)





Right hand (R) shown.

Designation	CW$^{+0.05}_{0}$	RE	Coated SH725 R	Coated SH725 L	IC	S	CDX	Max. groove depth
JTGR/L3033F	0.33	0.03	●		9.525	3.18	0.8	0.7
JTGR/L3033F-005	0.33	0.05	●		9.525	3.18	0.8	0.7
JTGR/L3050F	0.5	0.03	●	●	9.525	3.18	1.2	1.1
JTGR/L3050F-005	0.5	0.05	●	●	9.525	3.18	1.2	1.1
JTGR/L3065F	0.65	0.03	●		9.525	3.18	2	1.9
JTGR/L3065F-010	0.65	0.1	●		9.525	3.18	2	1.9
JTGR/L3075F	0.75	0.03	●	●	9.525	3.18	2	1.9
JTGR/L3075F-010	0.75	0.1	●	●	9.525	3.18	2	1.9
JTGR/L3080F	0.8	0.03	●		9.525	3.18	2	1.9
JTGR/L3080F-010	0.8	0.1	●		9.525	3.18	2	1.9
JTGR/L3085F	0.85	0.03	●		9.525	3.18	2	1.9
JTGR/L3095F	0.95	0.03	●	●	9.525	3.18	2	1.9
JTGR/L3095F-010	0.95	0.1	●	●	9.525	3.18	2	1.9
JTGR/L3100F	1	0.05	●	●	9.525	3.18	2.2	2.1
JTGR/L3100F-010	1	0.1	●	●	9.525	3.18	2.2	2.1
JTGR/L3110F	1.1	0.05	●		9.525	3.18	2.2	2.1
JTGR/L3120F	1.2	0.05	●		9.525	3.18	2.2	2.1
JTGR/L3120F-010	1.2	0.1	●		9.525	3.18	2.2	2.1
JTGR/L3125F	1.25	0.05	●	●	9.525	3.18	2.2	2.1
JTGR/L3125F-010	1.25	0.1	●	●	9.525	3.18	2.2	2.1
JTGR/L3130F	1.3	0.05	●		9.525	3.18	2.2	2.1
JTGR/L3140F	1.4	0.05	●		9.525	3.18	2.2	2.1
JTGR/L3140F-010	1.4	0.1	●		9.525	3.18	2.2	2.1
JTGR/L3145F	1.45	0.05	●		9.525	3.18	2.2	2.1
JTGR/L3145F-010	1.45	0.1	●		9.525	3.18	2.2	2.1
JTGR/L3150F	1.5	0.05	●	●	9.525	3.18	2.2	2.1
JTGR/L3150F-010	1.5	0.1	●	●	9.525	3.18	2.2	2.1
JTGR/L3175F	1.75	0.05	●		9.525	3.18	2.2	2.1
JTGR/L3175F-010	1.75	0.1	●		9.525	3.18	2.2	2.1
JTGR/L3180F	1.8	0.05	●		9.525	3.18	2.2	2.1
JTGR/L3200F	2	0.05	●	●	9.525	3.18	2.7	2.6
JTGR/L3200F-010	2	0.1	●	●	9.525	3.18	2.7	2.6
JTGR/L3225F	2.25	0.05	●		9.525	3.18	2.7	2.6
JTGR/L3250F	2.5	0.05	●	●	9.525	3.18	2.7	2.6
JTGR/L3250F-010	2.5	0.1	●	●	9.525	3.18	2.7	2.6
JTGR/L3300F	3	0.05	●		9.525	3.18	2.7	2.6
JTGR/L3300F-010	3	0.1	●		9.525	3.18	2.7	2.6

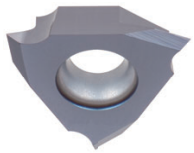
● : Line up

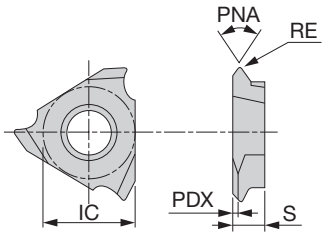
Reference pages : Grooving toolholders → P.56 -

J-SERIES

Inserts for threading

JTT (sharp edge)





Right hand (R) shown.

Designation	RE	Coated SH725 R	Coated SH725 L	PNA	IC	S	PDX
JTTR/L3005F-55	0.05	●		55°	9.525	3.18	0.6
JTTR/L3005F	0.05	●	●	60°	9.525	3.18	0.9
JTTR/L3010F	0.1	●	●	60°	9.525	3.18	0.9

Machinable pitch range: 0.5 to 1 mm.

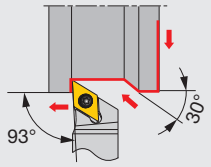
● : Line up

Reference pages : Threading toolholders → P.58

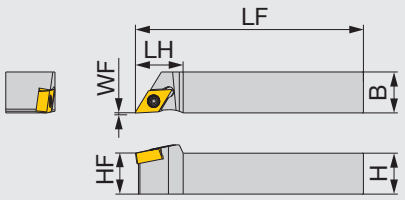
External toolholders

JSDJ2XR/L

Screw-on toolholder without offset with 93° approach angle, for DXGU inserts



Cutting edge style **J2**



Without offset

Right hand (R) shown.

Designation	H	B	LF	LH	HF	WF	RE**	Insert	Torque*
JSDJ2XR/L1010X07	10	10	120	14	10	0	0.2	DXGU0703**L/R...	0.9
JSDJ2XR/L1212F07	12	12	85	14	12	0	0.2	DXGU0703**L/R...	0.9
JSDJ2XR/L1212X07	12	12	120	14	12	0	0.2	DXGU0703**L/R...	0.9
JSDJ2XR/L1616X07	16	16	120	18	16	0	0.2	DXGU0703**L/R...	0.9
JSDJ2XR/L2020H07	20	20	100	18	20	0	0.2	DXGU0703**L/R...	0.9

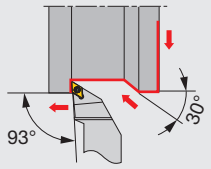
*Torque: Recommended torque (N·m) for clamping **RE: The holder measurements are true with this insert radius
Note: Use the right-hand toolholder (R) for the left-hand insert (L). Use the left-hand toolholder (L) for the right-hand insert (R)

SPARE PARTS

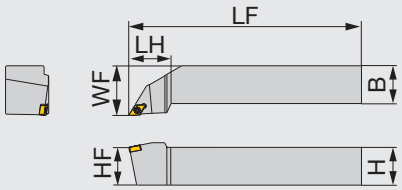
Designation	Clamping screw	Wrench
JSDJ2XR/L...	SR34-514	T-7F

JSDJXR/L

Screw-on toolholder without offset with 93° approach angle, for DXGU inserts



Cutting edge style **J**



Right hand (R) shown.

Designation	H	B	LF	LH	HF	WF	RE**	Insert	Torque*
JSDJXR/L2020K07	20	20	125	27	20	25	0.4	DXGU0703**L/R...	0.9
JSDJXR/L2525M07	25	25	150	27	25	32	0.4	DXGU0703**L/R...	0.9

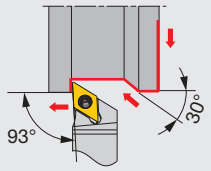
*Torque: Recommended torque (N·m) for clamping **RE: The holder measurements are true with this insert radius
Note: Use the right-hand toolholder (R) for the left-hand insert (L). Use the left-hand toolholder (L) for the right-hand insert (R)

SPARE PARTS

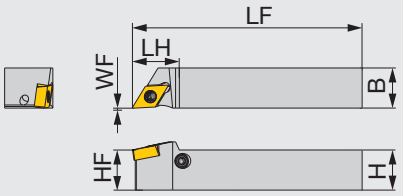
Designation	Clamping screw	Wrench
JSDJXR/L...	SR34-514	T-7F

MINIFORCE TURN
JPDJ2XR/L

Lever lock type toolholder without offset with 93° approach angle, for DXGU inserts



Cutting edge style **J2**



Without offset

Right hand (R) shown.

Designation	H	B	LF	LH	HF	WF	RE**	Insert	Torque*
JPDJ2XR/L1010X07	10	10	120	14	10	0	0.2	DXGU0703**L/R...	0.9
JPDJ2XR/L1212F07	12	12	85	14	12	0	0.2	DXGU0703**L/R...	0.9
JPDJ2XR/L1212X07	12	12	120	14	12	0	0.2	DXGU0703**L/R...	0.9
JPDJ2XR/L1616X07	16	16	120	18	16	0	0.2	DXGU0703**L/R...	0.9

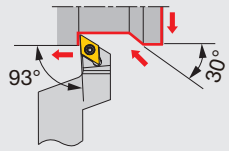
*Torque: Recommended torque (N·m) for clamping **RE: The holder measurements are true with this insert radius
Note: Use the right-hand toolholder (R) for the left-hand insert (L). Use the left-hand toolholder (L) for the right-hand insert (R)

SPARE PARTS

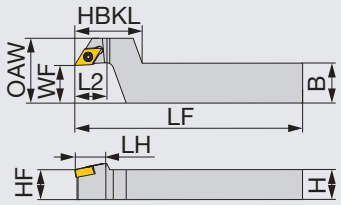
Designation	Lever	Pin	Clamping screw	Wrench
JPDJ2XR/L...	SLLV-2	SL-PI-2	SR10400611	HW2.0/5RED

MINIFORCE TURN
JSDJXR-F

Screw-on stepped-head toolholder with 93° approach angle, for DXGU inserts



Cutting edge style **J**



Right hand (R) shown.

Designation	H	B	LF	L2	HBKL	LH	HF	WF	OAW	RE**	Insert	Torque*
JSDJXR1016X07-F15	10	16	120	12	27	14	10	15	26	0.2	DXGU0703**L...	0.9
JSDJXR1216F07-F15	12	16	85	12	27	14	12	15	26	0.2	DXGU0703**L...	0.9
JSDJXR1216X07-F15	12	16	120	12	27	14	12	15	26	0.2	DXGU0703**L...	0.9
JSDJXR1620X07-F15	16	20	120	12	27	14	16	15	26	0.2	DXGU0703**L...	0.9

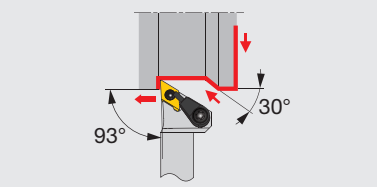
*Torque: Recommended torque (N·m) for clamping **RE: The holder measurements are true with this insert radius
Note: Use the right-hand toolholder (R) for the left-hand insert (L)

SPARE PARTS

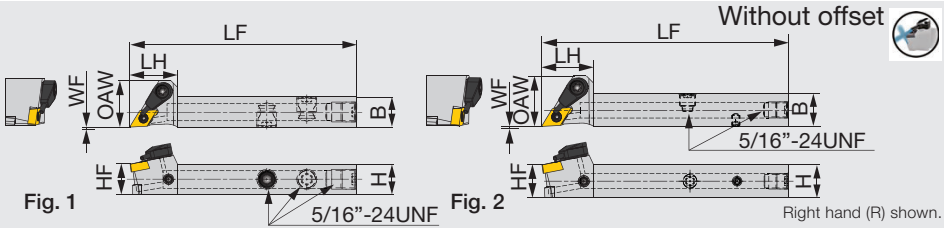
Designation	Clamping screw	Wrench
JSDJXR**-F15	SR34-514	T-7F

JSDJ2XR/L-CHP

Screw-on toolholder without offset with 93° approach angle, for DXGU inserts, with channels for high pressure coolant



Cutting edge style **J2**



Designation	H	B	LF	LH	HF	W	OAW	RE**	Insert	Torque*	Fig.
JSDJ2XR/L1212F07-CHP	12	12	85	19	12	0	18.5	0.2	DXGU0703**L/R...	0.9	1
JSDJ2XR1212X07-CHP	12	12	120	19	12	0	18.5	0.2	DXGU0703**L...	0.9	2
JSDJ2XR1616X07-CHP	16	16	120	19	16	0	18.5	0.2	DXGU0703**L...	0.9	2

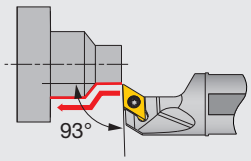
*Torque: Recommended torque (N·m) for clamping **RE: The holder measurements are true with this insert radius
Note: Use the right-hand tool holder (R) for the left-hand insert (L). Use the left-hand tool holder (L) for the right-hand insert (R).

SPARE PARTS

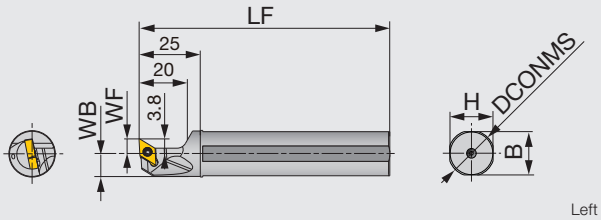
Designation	Clamping screw	Coolant unit	Wrench
JSDJ2XR**07-CHP	SR34-514	S-CU-CHP	T-7F

JS-SDUXL

Screw-on toolholder with 93° approach angle, for DXGU inserts



Cutting edge style **U**



Left hand (L) shown.

Designation	DCONMS	WF	LF	H	B	WB	RE**	Insert	Torque*
JS14H-SDUXL07	14	6	100	13	13	6.75	0.2	DXGU0703**L...	0.9
JS159F-SDUXL07	15.875	6	85	15	15	7.687	0.2	DXGU0703**L...	0.9
JS16F-SDUXL07	16	6	85	15	15	7.75	0.2	DXGU0703**L...	0.9
JS19G-SDUXL07	19.05	6	90	18	18	9.275	0.2	DXGU0703**L...	0.9
JS19X-SDUXL07	19.05	6	120	18	18	9.275	0.2	DXGU0703**L...	0.9
JS20G-SDUXL07	20	6	90	19	19	9.75	0.2	DXGU0703**L...	0.9
JS20X-SDUXL07	20	6	120	19	19	9.75	0.2	DXGU0703**L...	0.9
JS22X-SDUXL07	22	10	120	21	21	10.75	0.2	DXGU0703**L...	0.9
JS25H-SDUXL07	25	10	100	24	24	12.25	0.2	DXGU0703**L...	0.9
JS254X-SDUXL07	25.4	10	120	24	24	12.45	0.2	DXGU0703**L...	0.9

*Torque: Recommended torque (N·m) for clamping **RE: The holder measurements are true with this insert radius
Note: Use the left-hand toolholder (L) for the left-hand insert (L)

SPARE PARTS

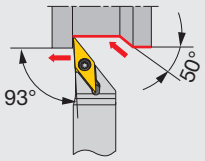
Designation	Clamping screw	Wrench
JS**-SDUXL07	SR34-514	T-7F

Reference pages : JSDJ2XR/L-CHP: Parts for coolant hose → P.59 -

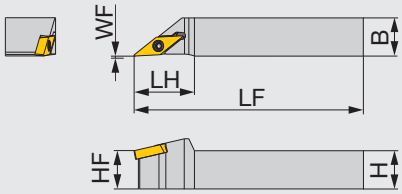
MINIFORCE TURN

JSVJ2XR/L

Screw-on toolholder without offset with 93° approach angle, for VXGU inserts



Cutting edge style **J2**



Without offset

Right hand (R) shown.

Designation	H	B	LF	LH	HF	WF	RE**	Insert	Torque*
JSVJ2XR/L1010X09	10	10	120	17	10	0	0.2	VXGU09T2**L/R...	0.9
JSVJ2XR/L1212F09	12	12	85	19	12	0	0.2	VXGU09T2**L/R...	0.9
JSVJ2XR/L1212X09	12	12	120	19	12	0	0.2	VXGU09T2**L/R...	0.9
JSVJ2XR/L1616X09	16	16	120	19	16	0	0.2	VXGU09T2**L/R...	0.9
JSVJ2XR/L2020H09	20	20	100	19	20	0	0.2	VXGU09T2**L/R...	0.9

*Torque: Recommended torque (N·m) for clamping **RE: The holder measurements are true with this insert radius
Note: Use the right-hand toolholder (R) for the left-hand insert (L). Use the left-hand toolholder (L) for the right-hand insert (R)

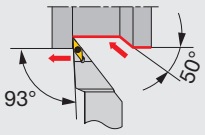
SPARE PARTS

Designation	Clamping screw	Wrench
JSVJ2XR/L...	SR34-508	T-7F

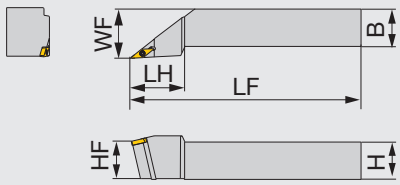
MINIFORCE TURN

JSVJXR/L

Screw-on toolholder without offset with 93° approach angle, for VXGU inserts



Cutting edge style **J**



Right hand (R) shown.

Designation	H	B	LF	LH	HF	WF	RE**	Insert	Torque*
JSVJXR/L2020K09	20	20	125	35	20	25	0.4	VXGU09T2**L/R...	0.9
JSVJXR/L2525M09	25	25	150	35	25	32	0.4	VXGU09T2**L/R...	0.9

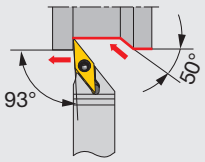
*Torque: Recommended torque (N·m) for clamping **RE: The holder measurements are true with this insert radius
Note: Use the right-hand toolholder (R) for the left-hand insert (L). Use the left-hand toolholder (L) for the right-hand insert (R)

SPARE PARTS

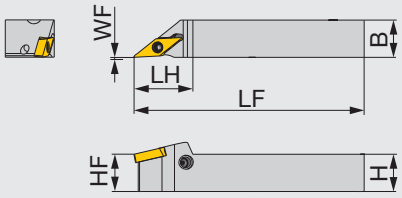
Designation	Clamping screw	Wrench
JSVJXR/L...	SR34-508	T-7F

JPVJ2XR/L

Lever lock type toolholder without offset with 93° approach angle, for VXGU inserts



Cutting edge style **J2**



Without offset

Right hand (R) shown.

Designation	H	B	LF	LH	HF	WF	RE**	Insert	Torque*
JPVJ2XR/L1010X09	10	10	120	19	10	0	0.2	VXGU09T2**L/R...	0.9
JPVJ2XR/L1212F09	12	12	85	19	12	0	0.2	VXGU09T2**L/R...	0.9
JPVJ2XR/L1212X09	12	12	120	19	12	0	0.2	VXGU09T2**L/R...	0.9
JPVJ2XR/L1616X09	16	16	120	19	16	0	0.2	VXGU09T2**L/R...	0.9

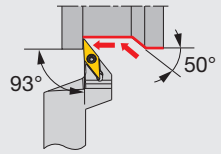
*Torque: Recommended torque (N·m) for clamping **RE: The holder measurements are true with this insert radius
Note: Use the right-hand toolholder (R) for the left-hand insert (L). Use the left-hand toolholder (L) for the right-hand insert (R)

SPARE PARTS

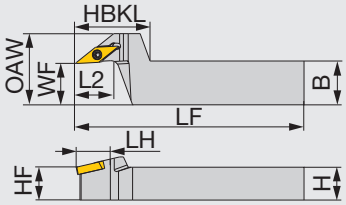
Designation	Lever	Pin	Clamping screw	Wrench
JPVJ2XR/L...	SLLV-1	SL-PI-2	SR10400611	HW2.0/5RED

JSVJXR-F

Screw-on stepped-head toolholder with 93° approach angle, for VXGU inserts



Cutting edge style **J**



Right hand (R) shown.

Designation	H	B	LF	L2	HBKL	LH	HF	WF	OAW	RE**	Insert	Torque*
JSVJXR1016X09-F15	10	16	120	12	27	19	10	15	26	0.2	VXGU09T2**L...	0.9
JSVJXR1216F09-F15	12	16	85	12	27	19	12	15	26	0.2	VXGU09T2**L...	0.9
JSVJXR1216X09-F15	12	16	120	12	27	19	12	15	26	0.2	VXGU09T2**L...	0.9
JSVJXR1620X09-F15	16	20	120	12	27	19	16	15	26	0.2	VXGU09T2**L...	0.9

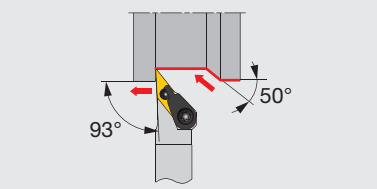
*Torque: Recommended torque (N·m) for clamping **RE: The holder measurements are true with this insert radius
Note: Use the right-hand toolholder (R) for the left-hand insert (L)

SPARE PARTS

Designation	Clamping screw	Wrench
JSVJXR**-F15	SR34-508	T-7F

JSVJ2XR/L-CHP

Screw-on toolholder without offset with 93° approach angle, for VXGU inserts, with coolant nozzle for high pressure



Cutting edge style **J2**

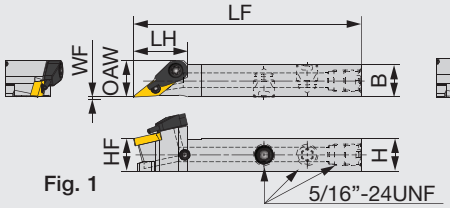


Fig. 1

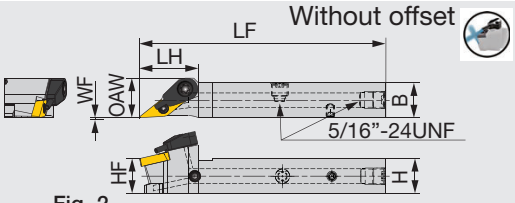


Fig. 2

Right hand (R) shown.

Designation	H	B	LF	LH	HF	WF	OAW	RE**	Insert	Torque*	Fig.
JSVJ2XR/L1212F09-CHP	12	12	85	20	12	0	13.5	0.2	VXGU09T2**L/R...	0.9	1
JSVJ2XR1212X09-CHP	12	12	120	19.5	12	0	13.4	0.2	VXGU09T2**L...	0.9	2
JSVJ2XR1616X09-CHP	16	16	120	19.5	16	0	16	0.2	VXGU09T2**L...	0.9	2

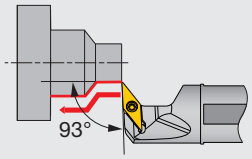
*Torque: Recommended torque (N·m) for clamping **RE: The holder measurements are true with this insert radius
Note: Use the right-hand toolholder (R) for the left-hand insert (L). Use the left-hand toolholder (L) for the right-hand insert (R)

SPARE PARTS

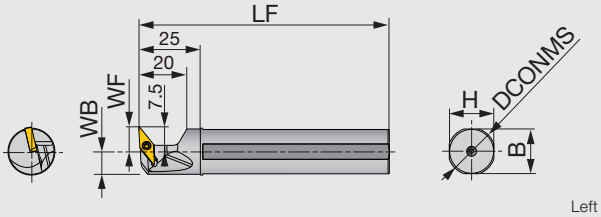
Designation	Clamping screw	Coolant unit	Wrench
JSVJ2XR**F09-CHP	SR34-508	S-CU-CHP	T-7F

JS-SVUXL

Screw-on toolholder with 93° approach angle, for VXGU inserts



Cutting edge style **U**



Left hand (L) shown.

Designation	DCONMS	WF	LF	H	B	WB	RE**	Insert	Torque*
JS159F-SVUXL09	15.875	10	85	15	15	7.7	0.2	VXGU09T2**L...	0.9
JS16F-SVUXL09	16	10	85	15	15	7.7	0.2	VXGU09T2**L...	0.9
JS19G-SVUXL09	19.05	10	90	18	18	9.2	0.2	VXGU09T2**L...	0.9
JS19X-SVUXL09	19.05	10	120	18	18	9.2	0.2	VXGU09T2**L...	0.9
JS20G-SVUXL09	20	10	90	19	19	9.7	0.2	VXGU09T2**L...	0.9
JS20X-SVUXL09	20	10	120	19	19	9.7	0.2	VXGU09T2**L...	0.9
JS22X-SVUXL09	22	10	120	21	21	10.7	0.2	VXGU09T2**L...	0.9
JS25H-SVUXL09	25	10	100	24	24	12.2	0.2	VXGU09T2**L...	0.9
JS254X-SVUXL09	25.4	10	120	24	24	12.4	0.2	VXGU09T2**L...	0.9

*Torque: Recommended torque (N·m) for clamping **RE: The holder measurements are true with this insert radius
Note: Use the left-hand toolholder (L) for the left-hand insert (L)

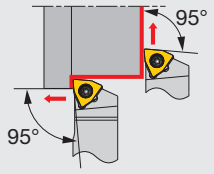
SPARE PARTS

Designation	Clamping screw	Wrench
JS**-SVUXL09	SR34-508	T-7F

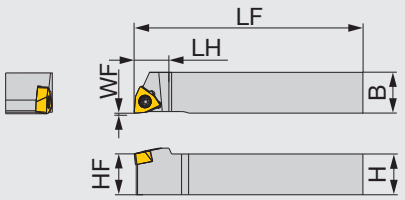
Reference pages : JSVJ2XR/L-CHP: Parts for coolant hose → P.59 -

JSWL2XR/L

Screw-on toolholder without offset with 95° approach angle, for WXGU inserts



Cutting edge style **L2**



Without offset

Right hand (R) shown.

Designation	H	B	LF	LH	HF	WF	RE**	Insert	Torque*
JSWL2XR/L1010X04	10	10	120	11	10	0	0.2	WXGU0403**L/R...	0.9
JSWL2XR/L1212F04	12	12	85	11	12	0	0.2	WXGU0403**L/R...	0.9
JSWL2XR/L1212X04	12	12	120	11	12	0	0.2	WXGU0403**L/R...	0.9
JSWL2XR/L1616X04	16	16	120	13	16	0	0.2	WXGU0403**L/R...	0.9
JSWL2XR/L2020H04	20	20	100	13	20	0	0.2	WXGU0403**L/R...	0.9

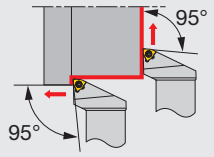
*Torque: Recommended torque (N·m) for clamping **RE: The holder measurements are true with this insert radius
Note: Use the right-hand toolholder (R) for the left-hand insert (L). Use the left-hand toolholder (L) for the right-hand insert (R)

SPARE PARTS

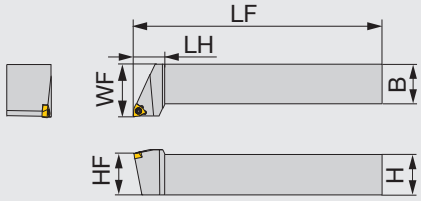
Designation	Clamping screw	Wrench
JSWL2XR/L...	SR34-514	T-7F

JSWLXR/L

Screw-on toolholder without offset with 95° approach angle, for WXGU inserts



Cutting edge style **L**



Right hand (R) shown.

Designation	H	B	LF	LH	HF	WF	RE**	Insert	Torque*
JSWLXR/L2020K04	20	20	125	15	20	25	0.4	WXGU0403**L/R...	0.9
JSWLXR/L2525M04	25	25	150	19	25	32	0.4	WXGU0403**L/R...	0.9

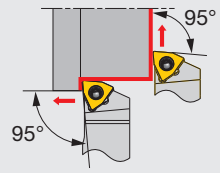
*Torque: Recommended torque (N·m) for clamping **RE: The holder measurements are true with this insert radius
Note: Use the right-hand toolholder (R) for the left-hand insert (L). Use the left-hand toolholder (L) for the right-hand insert (R)

SPARE PARTS

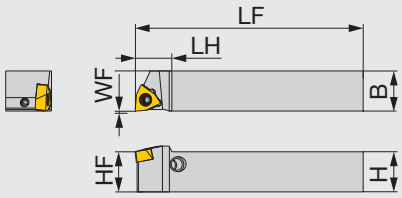
Designation	Clamping screw	Wrench
JSWLXR/L...	SR34-514	T-7F

MINIFORCE TURN
JPWL2XR/L

Lever lock type toolholder without offset with 95° approach angle, for WXGU inserts



Cutting edge style **L2**



Without offset

Right hand (R) shown.

Designation	H	B	LF	LH	HF	WF	RE**	Insert	Torque*
JPWL2XR/L1010X04	10	10	120	11	10	0	0.2	WXGU0403**L/R...	0.9
JPWL2XR/L1212F04	12	12	85	11	12	0	0.2	WXGU0403**L/R...	0.9
JPWL2XR/L1212X04	12	12	120	11	12	0	0.2	WXGU0403**L/R...	0.9
JPWL2XR/L1616X04	16	16	120	13	16	0	0.2	WXGU0403**L/R...	0.9

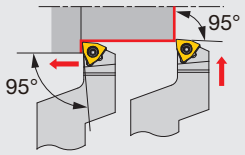
*Torque: Recommended torque (N·m) for clamping **RE: The holder measurements are true with this insert radius
Note: Use the right-hand toolholder (R) for the left-hand insert (L). Use the left-hand toolholder (L) for the right-hand insert (R)

SPARE PARTS

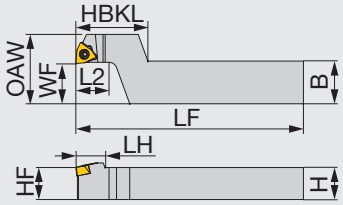
Designation	Lever	Pin	Clamping screw	Wrench
JPWL2XR/L...	SLLV-2	SL-PI-2	SR10400611	HW2.0/5RED

MINIFORCE TURN
JSWLXR-F

Screw-on stepped-head toolholder with 95° approach angle, for WXGU inserts



Cutting edge style **L**



Right hand (R) shown.

Designation	H	B	LF	L2	HBKL	LH	HF	WF	OAW	RE**	Insert	Torque*
JSWLXR1016X04-F15	10	16	120	12	27	11	10	15	26	0.2	WXGU0403**L...	0.9
JSWLXR1216F04-F15	12	16	85	12	27	11	12	15	26	0.2	WXGU0403**L...	0.9
JSWLXR1216X04-F15	12	16	120	12	27	11	12	15	26	0.2	WXGU0403**L...	0.9
JSWLXR1620X04-F15	16	20	120	12	27	11	16	15	26	0.2	WXGU0403**L...	0.9

*Torque: Recommended torque (N·m) for clamping **RE: The holder measurements are true with this insert radius
Note: Use the right-hand toolholder (R) for the left-hand insert (L)

SPARE PARTS

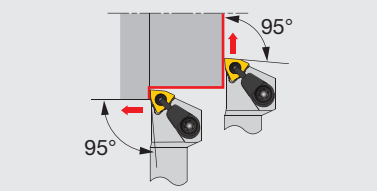
Designation	Clamping screw	Wrench
JSWLXR**-F15	SR34-514	T-7F

TUNGTURN JET

JSWL2XR/L-CHP

MINIFORCE TURN

Screw-on toolholder without offset with 95° approach angle, for WXGU inserts, with channels for high pressure coolant



Cutting edge style **L2**

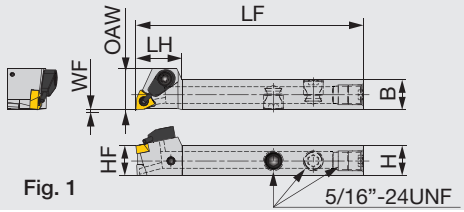


Fig. 1

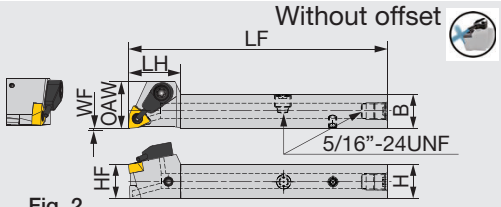


Fig. 2

Right hand (R) shown.

Designation	H	B	LF	LH	HF	WF	OAW	RE**	Insert	Torque*	Fig.
JSWL2XR/L1212F04-CHP	12	12	85	18	12	0	16.5	0.2	WXGU0403**L/R...	0.9	1
JSWL2XR1212X04-CHP	12	12	120	18.5	12	0	16.5	0.2	WXGU0403**L...	0.9	2
JSWL2XR1616X04-CHP	16	16	120	18.5	16	0	16.5	0.2	WXGU0403**L...	0.9	2

*Torque: Recommended torque (N·m) for clamping **RE: The holder measurements are true with this insert radius
Note: Use the right-hand toolholder (R) for the left-hand insert (L). Use the left-hand toolholder (L) for the right-hand insert (R)

SPARE PARTS

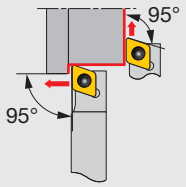
Designation	Clamping screw	Coolant unit	Wrench
JSWL2XR**04-CHP	SR34-514	S-CU-CHP	T-7F

Reference pages : JSWL2XR/L-CHP: Parts for coolant hose → P.59 -

J-SERIES

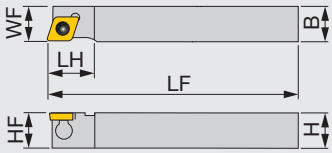
JTCL2CR/L

Back clamp toolholder without offset with 95° approach angle for positive 80° rhombic inserts



Cutting edge style **L2**

Without offset



Right hand (R) shown.

Designation	H	B	LF	LH	HF	WF	RE**	Insert	Torque*
JTCL2CL0810K06	8	10	125	12	8	10	0.4	CC**0602...	0.9
JTCL2CR/L1010X06	10	10	120	12	10	10	0.2	CC**0602...	0.9
JTCL2CR/L1212F09	12	12	85	16	12	12	0.2	CC**09T3...	1.2
JTCL2CR/L1212X09	12	12	120	16	12	12	0.2	CC**09T3...	1.2
JTCL2CR/L1616X09	16	16	120	16	16	16	0.2	CC**09T3...	1.2
JTCL2CR1616M09	16	16	150	16	16	16	0.8	CC**09T3...	1.2

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

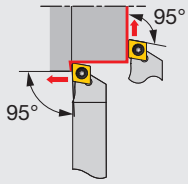
SPARE PARTS

Designation	Clamp	Clamping screw	Wrench
JTCL2CR/L**06	JCP-2	JDS-3525	P-2F
JTCL2CR/L**09	JCP-3	JDS-5040	P-2.5F

J-SERIES

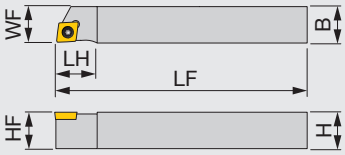
JSCL2CR/L

Screw-on toolholder without offset with 95° approach angle for positive 80° rhombic inserts



Cutting edge style **L2**

Without offset



Right hand (R) shown.

Designation	H	B	LF	LH	HF	WF	RE**	Insert	Torque*
JSCL2CR/L1010X06	10	10	120	12	10	10	0.2	CC**0602...	1.2
JSCL2CR/L1212F06	12	12	85	12	12	12	0.2	CC**0602...	1.2
JSCL2CR/L1212X06	12	12	120	12	12	12	0.2	CC**0602...	1.2
JSCL2CR/L1212F09	12	12	85	16	12	12	0.2	CC**09T3...	1.2
JSCL2CR/L1212X09	12	12	120	16	12	12	0.2	CC**09T3...	1.2
JSCL2CR/L1616X09	16	16	120	16	16	16	0.2	CC**09T3...	1.2

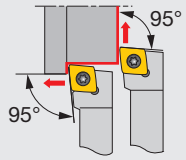
*Torque: Recommended torque (N·m) for clamping **RE: Standard corner radius

SPARE PARTS

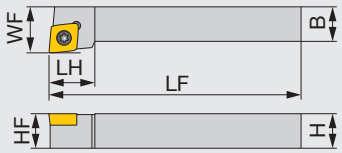
Designation	Clamping screw	Wrench
JSCL2CR/L**06	CSTB-2.5	T-8F
JSCL2CR/L**09	CSTB-4SD	T-8F

JSCLCR/L

Screw-on toolholder with 95° approach angle for positive 80° rhombic inserts



Cutting edge style **L**



Right hand (R) shown.

Designation	H	B	LF	LH	HF	WF	RE**	Insert	Torque*
JSCLCR/L0808H06	8	8	100	12	8	10	0.4	CC**0602...	1.2
JSCLCR/L1010H06	10	10	100	12	10	12	0.4	CC**0602...	1.2
JSCLCR/L1212H09	12	12	100	16	12	16	0.8	CC**09T3...	1.2
JSCLCR/L1616H09	16	16	100	16	16	20	0.8	CC**09T3...	1.2

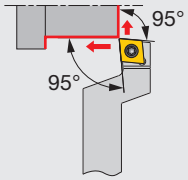
*Torque: Recommended torque (N·m) for clamping **RE: Standard corner radius

SPARE PARTS

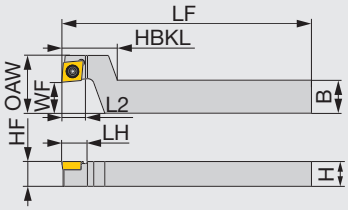
Designation	Clamping screw	Wrench
JSCLCR/L**H06	CSTB-2.5	T-8F
JSCLCR/L**H09	CSTB-4SD	T-8F

JSCLCR-F

Screw-on stepped-head toolholder with 95° approach angle for positive 80° rhombic inserts



Cutting edge style **L**



Right hand (R) shown.

Designation	H	B	LF	L2	HBKL	LH	HF	WF	OAW	RE**	Insert	Torque*
JSCLCR1216F09-F15	12	16	85	12	27	12.5	12	15	28	0.2	CC**09T3...	1.2
JSCLCR1216X09-F15	12	16	120	12	27	12.5	12	15	28	0.2	CC**09T3...	1.2
JSCLCR1620X09-F15	16	20	120	12	27	12.5	16	15	28	0.2	CC**09T3...	1.2

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

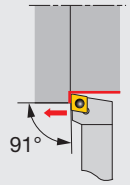
SPARE PARTS

Designation	Clamping screw	Wrench
JSCLCR**F15	CSTB-4SD	T-8F

J-SERIES

JSCGCR/L

Screw-on toolholder with 91° approach angle for positive 80° rhombic inserts



Cutting edge style **G**

Right hand (R) shown.

Designation	H	B	LF	LH	HF	WF	RE**	Insert	Torque*
JSCGCR/L1212H06	12	12	100	12	12	16	0.4	CC**0602...	1.2
JSCGCR/L1616H09	16	16	100	16	16	20	0.8	CC**09T3...	1.2

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

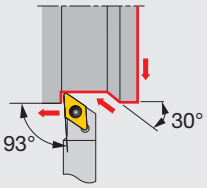
SPARE PARTS

Designation	Clamping screw	Wrench
JSCGCR/L1212H06	CSTB-2.5	T-8F
JSCGCR/L1616H09	CSTB-4SD	T-8F

J-SERIES

JTDJ2CR/L

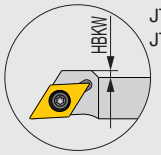
Back clamp toolholder without offset with 93° approach angle for positive 55° rhombic inserts



Cutting edge style **J2**

Without offset

JTDJ2CR/L1212F11
JTDJ2CR/L1212X11



Right hand (R) shown.

Designation	H	B	LF	LH	HF	WF	HBKW	RE**	Insert	Torque*
JTDJ2CR/L1010X07	10	10	120	14	10	10	-	0.2	DC**0702...	0.9
JTDJ2CR/L1212F07	12	12	85	14	12	12	-	0.2	DC**0702...	0.9
JTDJ2CR/L1212X07	12	12	120	14	12	12	-	0.2	DC**0702...	0.9
JTDJ2CR/L1212F11	12	12	85	20	12	12	2	0.2	DC**11T3...	1.2
JTDJ2CR/L1212X11	12	12	120	20	12	12	2	0.2	DC**11T3...	1.2
JTDJ2CR/L1616X11	16	16	120	20	16	16	-	0.2	DC**11T3...	1.2

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

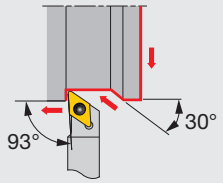
SPARE PARTS

Designation	Clamp	Clamping screw	Wrench
JTDJ2CR/L**07	JCP-2	JDS-3525	P-2F
JTDJ2CR/L**11	JCP-3	JDS-5040	P-2.5F

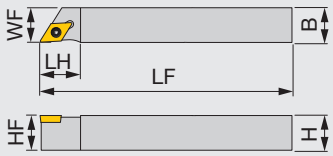
J-SERIES

JSDJ2CR/L

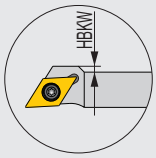
Screw-on toolholder without offset with 93° approach angle for positive 55° rhombic inserts



Cutting edge style **J2**



Without offset



JSDJ2CR/L1010X11
JSDJ2CR/L1212F11
JSDJ2CR/L1212X11

Right hand (R) shown.

Designation	H	B	LF	LH	HF	WF	HBKW	RE**	Insert	Torque*
JSDJ2CR/L0808F07	8	8	85	14	8	8	-	0.2	DC**0702...	1.2
JSDJ2CR/L1010X07	10	10	120	14	10	10	-	0.2	DC**0702...	1.2
JSDJ2CR/L1010X11	10	10	120	20	10	10	4	0.2	DC**11T3...	1.2
JSDJ2CR/L1212F07	12	12	85	14	12	12	-	0.2	DC**0702...	1.2
JSDJ2CR/L1212F11	12	12	85	20	12	12	2	0.2	DC**11T3...	1.2
JSDJ2CR/L1212X07	12	12	120	14	12	12	-	0.2	DC**0702...	1.2
JSDJ2CR/L1212X11	12	12	120	20	12	12	2	0.2	DC**11T3...	1.2
JSDJ2CR/L1616X11	16	16	120	20	16	16	-	0.2	DC**11T3...	1.2

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

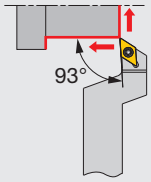
SPARE PARTS

Designation	Clamping screw	Wrench
JSDJ2CR/L**07	CSTB-2.5	T-8F
JSDJ2CR/L**11	CSTB-4SD	T-8F

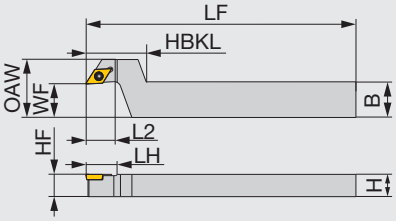
J-SERIES

JSDJCR-F

Screw-on stepped-head toolholder with 93° approach angle for positive 55° rhombic inserts



Cutting edge style **J**



Right hand (R) shown.

Designation	H	B	LF	L2	HBKL	LH	HF	WF	OAW	RE**	Insert	Torque*
JSDJCR1016X07-F15	10	16	120	12.5	27	14	10	15	26	0.2	DC**0702...	1.2
JSDJCR1216F07-F15	12	16	85	12.5	27	14	12	15	26	0.2	DC**0702...	1.2
JSDJCR1216X07-F15	12	16	120	12.5	27	14	12	15	26	0.2	DC**0702...	1.2
JSDJCR1216F11-F15	12	16	85	12.5	27	20	12	15	28	0.2	DC**11T3...	1.2
JSDJCR1216X11-F15	12	16	120	12.5	27	20	12	15	28	0.2	DC**11T3...	1.2
JSDJCR1620X11-F15	16	20	120	12.5	27	20	16	15	28	0.2	DC**11T3...	1.2

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

SPARE PARTS

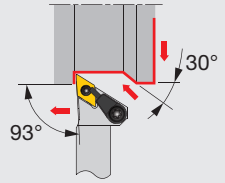
Designation	Clamping screw	Wrench
JSDJCR**07-F15	CSTB-2.5	T-8F
JSDJCR**11-F15	CSTB-4SD	T-8F

TUNGTURN JET

JSDJ2CR/L-CHP

J-SERIES

Screw-on toolholder without offset with 93° approach angle for positive 55° rhombic inserts, with channels for high pressure coolant



Cutting edge style **J2**

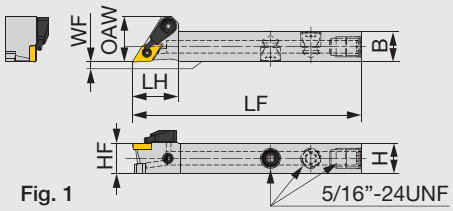


Fig. 1

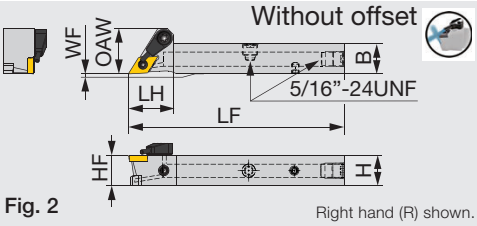


Fig. 2

Right hand (R) shown.

Designation	H	B	LF	LH	HF	WF	OAW	RE**	Insert	Torque*	Fig.
JSDJ2CR/L1212F07-CHP	12	12	85	18	12	0	18	0.2	DC**0702...	0.9	1
JSDJ2CR/L1212F11-CHP	12	12	85	19	12	0	20.5	0.2	DC**11T3...	0.9	1
JSDJ2CR1212X11-CHP	12	12	120	19	12	0	20.5	0.2	DC**11T3...	1.2	2
JSDJ2CR1616X11-CHP	16	16	120	19	16	0	20.5	0.2	DC**11T3...	1.2	2

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

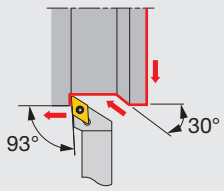
SPARE PARTS

Designation	Clamping screw	Coolant unit	Wrench	Coolant plug	Wrench	DirectJet plug	Wrench
JSDJ2CR/L1212F07-CHP	CSTB-2.5	S-CU-CHP	T-8F	-	-	-	-
JSDJ2CR/L1212F11-CHP	CSTB-4SD	S-CU-CHP	T-8F	-	-	-	-
JSDJ2CR**11-CHP	CSTB-4SD	S-CU-CHP	T-8F	SR5/16UNFTL360	P-4	SSHM4-6-TB	P-2

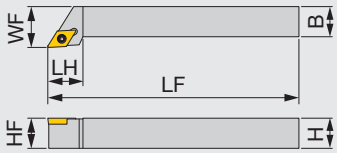
J-SERIES

JSDJCR/L

Screw-on toolholder with 93° approach angle for positive 55° rhombic inserts



Cutting edge style **J**



Right hand (R) shown.

Designation	H	B	LF	LH	HF	WF	RE**	Insert	Torque*
JSDJCR/L0808H07	8	8	100	14	8	10	0.4	DC**0702...	1.2
JSDJCR/L1010H11	10	10	100	18	10	12	0.8	DC**11T3...	1.2
JSDJCR/L1212H07	12	12	100	14	12	16	0.4	DC**0702...	1.2
JSDJCR/L1212H11	12	12	100	18	12	16	0.8	DC**11T3...	1.2
JSDJCR/L1616H11	16	16	100	18	16	20	0.8	DC**11T3...	1.2

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

SPARE PARTS

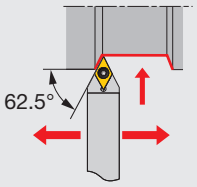
Designation	Clamping screw	Wrench
JSDJC**H07	CSTB-2.5	T-8F
JSDJC**H11	CSTB-4SD	T-8F

Reference pages : JSDJ2CR/L-CHP: Parts for coolant hose → P.59 -

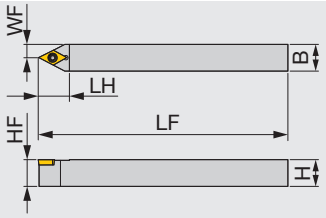
J-SERIES

JSDNCN

Screw-on toolholder with 62.5° approach angle for positive 55° rhombic inserts



Cutting edge style **N**



Designation	H	B	LF	LH	HF	WF	RE**	Insert	Torque*
JSDNCN1010X07	10	10	120	15	10	5	0.2	DC**0702...	1.2
JSDNCN1010X11	10	10	120	21	10	5	0.2	DC**11T3...	1.2
JSDNCN1212F07	12	12	85	15	12	6	0.2	DC**0702...	1.2
JSDNCN1212X07	12	12	120	15	12	6	0.2	DC**0702...	1.2
JSDNCN1212F11	12	12	85	21	12	6	0.2	DC**11T3...	1.2
JSDNCN1212X11	12	12	120	21	12	6	0.2	DC**11T3...	1.2
JSDNCN1616X11	16	16	120	21	16	8	0.2	DC**11T3...	1.2

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

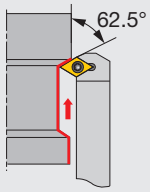
SPARE PARTS

Designation	Clamping screw	Wrench
JSDNCN**07	CSTB-2.5	T-8F
JSDNCN**11	CSTB-4SD	T-8F

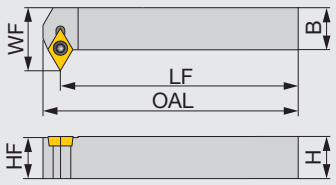
J-SERIES

JSDN3CR/L

Screw-on toolholder with 62.5° approach angle (N3-style) for positive 55° rhombic inserts



Cutting edge style **N3**



Right hand (R) shown.

Designation	H	B	OAL	LF	HF	WF	RE**	Insert	Torque*
JSDN3CR1212H07	12	12	105	100	12	18	0.4	DC**0702...	1.2
JSDN3CR1616H11	16	16	107	100	16	25	0.8	DC**11T3...	1.2

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

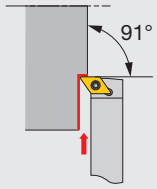
SPARE PARTS

Designation	Clamping screw	Wrench
JSDN3CR1212H07	CSTB-2.5	T-8F
JSDN3CR1616H11	CSTB-4SD	T-8F

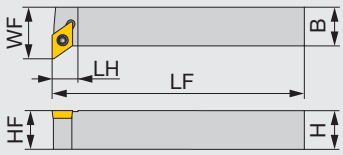
J-SERIES

JSDFCR/L

Screw-on toolholder for facing with 91° approach angle for positive 55° rhombic inserts



Cutting edge style **F**



Right hand (R) shown.

Designation	H	B	LF	LH	HF	WF	RE**	Insert	Torque*
JSDFCR/L1212H07	12	12	100	8	12	16	0.4	DC**0702...	1.2
JSDFCR/L1616H11	16	16	100	10.5	16	22	0.8	DC**11T3...	1.2

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

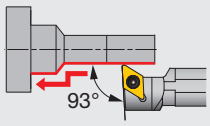
SPARE PARTS

Designation	Clamping screw	Wrench
JSDFCR/L1212H07	CSTB-2.5	T-8F
JSDFCR/L1616H11	CSTB-4SD	T-8F

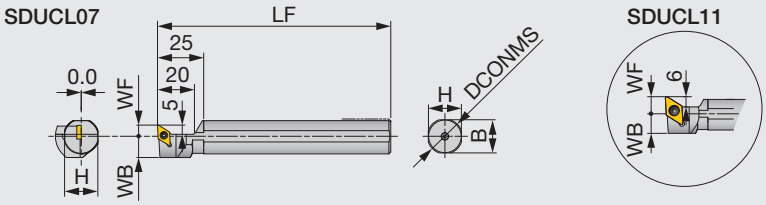
J-SERIES

JS-SDUCL

Screw-on toolholder with 93° approach angle for positive 55° rhombic inserts



Cutting edge style **U**



Left hand (L) shown.

Designation	DCONMS	WF	LF	H	B	WB	RE**	Insert	Torque*
JS19K-SDUCL07	19.05	6	125	18	18	11.5	0.4	DC**0702...	1.2
JS20K-SDUCL07	20	6	125	19	19	11.5	0.4	DC**0702...	1.2
JS22K-SDUCL07	22	6	125	21	21	11.5	0.4	DC**0702...	1.2
JS19K-SDUCL11	19.05	10	125	18	18	11.5	0.8	DC**11T3...	1.2
JS20K-SDUCL11	20	10	125	19	19	11.5	0.8	DC**11T3...	1.2
JS22K-SDUCL11	22	11	125	21	21	11.5	0.8	DC**11T3...	1.2
JS25K-SDUCL11	25.4	12	125	24	24	12.7	0.8	DC**11T3...	1.2

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

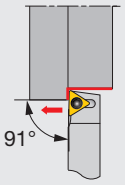
SPARE PARTS

Designation	Clamping screw	Wrench
JS**K-SDUCL07	CSTB-2.5	T-8F
JS**K-SDUCL11	CSTB-4SD	T-8F

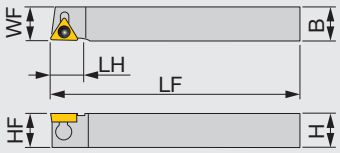
J-SERIES

JTTACR/L

Back clamp toolholder without offset with 91° approach angle for positive 60° triangle inserts



Cutting edge style **A**



Without offset

Right hand (R) shown.

Designation	H	B	LF	LH	HF	WF	RE**	Insert	Torque*
JTTACL0810K08	8	10	125	10	8	10	0.2	TC**0802...	0.9
JTTACR/L1212M11	12	12	150	12	12	12	0.4	TC**1102...	0.9
JTTACR/L1616M11	16	16	150	12	16	16	0.4	TC**1102...	0.9

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

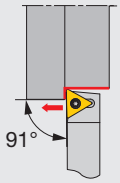
SPARE PARTS

Designation	Clamp	Clamping screw	Wrench
JTTACL0810K08	JCP-1	JDS-3525	P-2F
JTTACR/L**M11	JCP-2	JDS-3525	P-2F

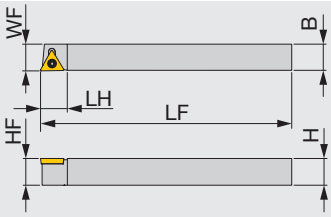
J-SERIES

JSTACR/L

Screw-on toolholder without offset with 91° approach angle for positive 60° triangle inserts



Cutting edge style **A**



Without offset

Right hand (R) shown.

Designation	H	B	LF	LH	HF	WF	RE**	Insert	Torque*
JSTACR/L0808K08	8	8	125	10	8	8	0.2	TC**0802...	0.6
JSTACR/L1010K08	10	10	125	10	10	10	0.2	TC**0802...	0.6
JSTACR/L1212K11	12	12	125	12	12	12	0.4	TC**1102...	1.2
JSTACR/L1616H11	16	16	100	12	16	16	0.4	TC**1102...	1.2

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

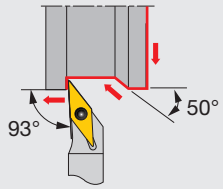
SPARE PARTS

Designation	Clamping screw	Wrench
JSTACR/L**K08	CSTB-2L	T-6F
JSTACR/L**11	CSTB-2.5	T-8F

J-SERIES

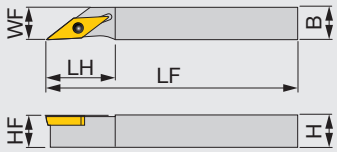
JSVJ2BR/L

Screw-on toolholder without offset with 93° approach angle for positive 35° rhombic inserts



Cutting edge style **J2**

Without offset



Right hand (R) shown.

Designation	H	B	LF	LH	HF	WF	RE**	Insert	Torque*
JSVJ2BR/L1010X11	10	10	120	21	10	10	0.2	VB**1103...	1.2
JSVJ2BR/L1212F11	12	12	85	21	12	12	0.2	VB**1103...	1.2
JSVJ2BR/L1212X11	12	12	120	21	12	12	0.2	VB**1103...	1.2
JSVJ2BR/L1616X11	16	16	120	21	16	16	0.2	VB**1103...	1.2

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

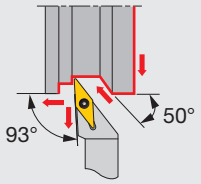
SPARE PARTS

Designation	Clamping screw	Wrench
JSVJ2BR/L...	CSTB-2.5	T-8F

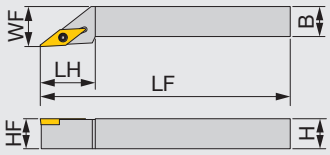
J-SERIES

JSVJBR/L

Screw-on toolholder with 93° approach angle for positive 35° rhombic inserts



Cutting edge style **J**



Right hand (R) shown.

Designation	H	B	LF	LH	HF	WF	RE**	Insert	Torque*
JSVJBR/L1010H11	10	10	100	20	10	12	0.4	VB**1103...	1.2
JSVJBR/L1212H11	12	12	100	22	12	16	0.4	VB**1103...	1.2
JSVJBR/L1616H11	16	16	100	22	16	20	0.4	VB**1103...	1.2

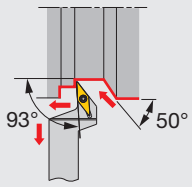
*Torque: Recommended torque (N·m) for clamping **RE: Standard corner radius

SPARE PARTS

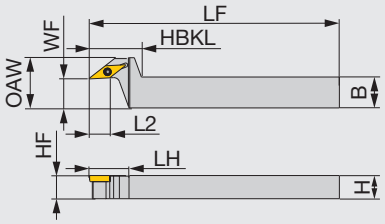
Designation	Clamping screw	Wrench
JSVJBR/L...	CSTB-2.5	T-8F

JSVJBR-F

Screw-on stepped-head toolholder with 93° approach angle for positive 35° rhombic inserts



Cutting edge style **J**



Right hand (R) shown.

Designation	H	B	LF	L2	HBKL	LH	HF	WF	OAW	RE**	Insert	Torque*
JSVJBR1216F11-F15	12	16	85	12.6	27	21	12	15	26	0.2	VB**1103...	1.2
JSVJBR1216X11-F15	12	16	120	12.6	27	21	12	15	26	0.2	VB**1103...	1.2
JSVJBR1620X11-F15	16	20	120	12.6	27	21	16	15	26	0.2	VB**1103...	1.2

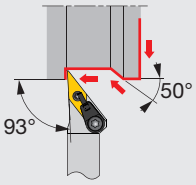
*Torque: Recommended torque (N·m) for clamping **RE: Standard corner radius

SPARE PARTS

Designation	Clamping screw	Wrench
JSVJBR**-F15	CSTB-2.5	T-8F

JSVJ2BR/L-CHP

Screw-on toolholder without offset with 93° approach angle for positive 35° rhombic inserts, with channels for high pressure coolant



Cutting edge style **J2**

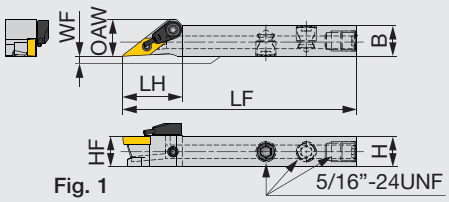


Fig. 1

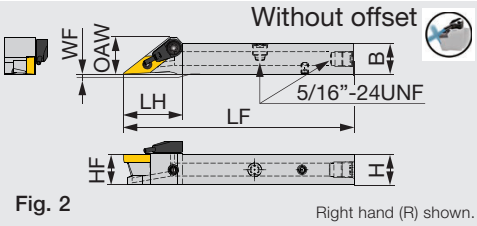


Fig. 2

Right hand (R) shown.

Designation	H	B	LF	LH	HF	WF	OAW	RE**	Insert	Torque*	Fig.
JSVJ2BR/L1212F11-CHP	12	12	85	23.6	12	0	14.7	0.2	VB**1103...	1.2	1
JSVJ2BR1212X11-CHP	12	12	120	23.6	12	0	14.7	0.2	VB**1103...	1.2	2
JSVJ2BR1616X11-CHP	16	16	120	23.6	16	0	16	0.2	VB**1103...	1.2	2

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

SPARE PARTS

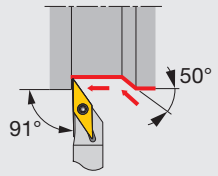
Designation	Clamping screw	Coolant unit	Wrench	Coolant plug	Wrench	DirectJet plug	Wrench
JSVJ2BR/L1212F11-CHP	CSTB-2.5	S-CU-CHP	T-8F	-	-	-	-
JSVJ2B**11-CHP	CSTB-2.5	S-CU-CHP	T-8F	SR5/16UNFTL360	P-4	SSHM4-6-TB	P-2

Reference pages : JSVJ2BR/L-CHP: Parts for coolant hose → P.59 -

J-SERIES

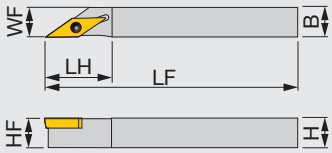
JSVABR/L

Screw-on toolholder without offset with 91° approach angle for positive 35° rhombic inserts



Cutting edge style **A**

Without offset



Right hand (R) shown.

Designation	H	B	LF	LH	HF	WF	RE**	Insert	Torque*
JSVABR/L1010K11	10	10	125	21	10	10	0.2	VB**1103...	1.2
JSVABL1212K11	12	12	125	21	12	12	0.2	VB**1103...	1.2

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

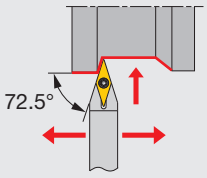
SPARE PARTS

Designation	Clamping screw	Wrench
JSVABR/L...	CSTB-2.5	T-8F

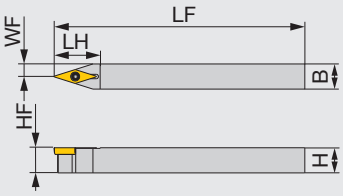
J-SERIES

JSVNBN

Screw-on toolholder with 72.5° approach angle for positive 35° rhombic inserts



Cutting edge style **N**



Designation	H	B	LF	LH	HF	WF	RE**	Insert	Torque*
JSVNBN1010X11	10	10	120	22	10	5	0.2	VB**1103...	1.2
JSVNBN1212F11	12	12	85	22	12	6	0.2	VB**1103...	1.2
JSVNBN1212X11	12	12	120	22	12	6	0.2	VB**1103...	1.2
JSVNBN1616X11	16	16	120	22	16	8	0.2	VB**1103...	1.2

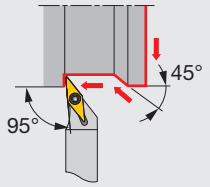
*Torque: Recommended torque (N·m) for clamping **RE: Standard corner radius

SPARE PARTS

Designation	Clamping screw	Wrench
JSVNBN...	CSTB-2.5	T-8F

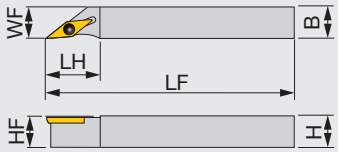
JSVL2PR/L

Screw-on toolholder without offset with 95° approach angle for positive 35° rhombic inserts



Cutting edge style **L2**

Without offset



Right hand (R) shown.

Designation	H	B	LF	LH	HF	WF	RE**	Insert	Torque*
JSVL2PR/L1010X08	10	10	120	16	10	10	0.2	VP**0802...	0.6
JSVL2PR/L1010K08	10	10	125	16	10	10	0.2	VP**0802...	0.6
JSVL2PR/L1212F08	12	12	85	16	12	12	0.2	VP**0802...	0.6
JSVL2PR/L1212F11	12	12	85	21	12	12	0.2	VP**1103...	1.2
JSVL2PR/L1212X08	12	12	120	16	12	12	0.2	VP**0802...	0.6
JSVL2PR/L1212X11	12	12	120	21	12	12	0.2	VP**1103...	1.2
JSVL2PR/L1212K08	12	12	125	16	12	12	0.2	VP**0802...	0.6
JSVL2PR/L1616X08	16	16	120	16	16	16	0.2	VP**0802...	0.6
JSVL2PL1616K08	16	16	125	16	16	16	0.2	VP**0802...	0.6
JSVL2PR/L1616X11	16	16	120	21	16	16	0.2	VP**1103...	1.2

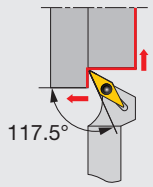
*Torque: Recommended torque (N·m) for clamping **RE: Standard corner radius

SPARE PARTS

Designation	Clamping screw	Wrench
JSVL2PR/L**08	CSTB-2L	T-6F
JSVL2PR/L**11	CSTB-2.5	T-8F

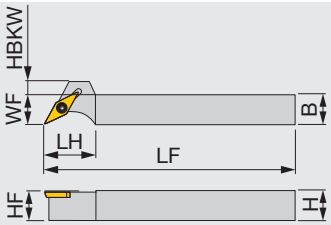
JSVP2PR/L

Screw-on toolholder without offset with 117.5° approach angle for positive 35° rhombic inserts



Cutting edge style **P2**

Without offset



Right hand (R) shown.

Designation	H	B	LF	LH	HF	WF	HBKW	RE**	Insert	Torque*
JSVP2PR/L1010K08	10	10	125	16	10	10	4	0.2	VP**0802...	0.6
JSVP2PR/L1010K11	10	10	125	20	10	10	8	0.2	VP**1103...	1.2
JSVP2PR/L1212K08	12	12	125	16	12	12	2	0.2	VP**0802...	0.6
JSVP2PR/L1212K11	12	12	125	20	12	12	6	0.2	VP**1103...	1.2
JSVP2PR/L1616K08	16	16	125	16	16	16	2	0.2	VP**0802...	0.6
JSVP2PR/L1616K11	16	16	125	20	16	16	6	0.2	VP**1103...	1.2

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

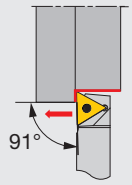
SPARE PARTS

Designation	Clamping screw	Wrench
JSVP2PR/L**08	CSTB-2L	T-6F
JSVP2PR/L**11	CSTB-2.5	T-8F

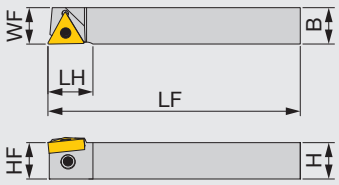
J-SERIES

JTTANR/L

Back clamp toolholder without offset with 91° approach angle for negative 60° triangular inserts



Cutting edge style **A**



Without offset

Right hand (R) shown.

Designation	H	B	LF	LH	HF	WF	RE**	Insert	Torque*
JTTANR/L1216K16	12	16	125	19.8	12	16	0.4	TN**1604...	1.2
JTTANR/L1616K16	16	16	125	19.8	16	16	0.4	TN**1604...	1.2

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

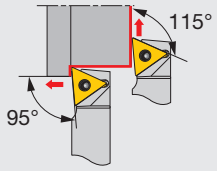
SPARE PARTS

Designation	Clamp	Clamping screw	Wrench
JTTANR/L...	JCP-3N	JDS-5040	P-2.5F

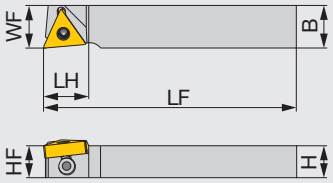
J-SERIES

JTTLNR/L

Back clamp toolholder without offset with 95° approach angle for negative 60° triangular inserts



Cutting edge style **L**



Without offset

Right hand (R) shown.

Designation	H	B	LF	LH	HF	WF	RE**	Insert	Torque*
JTTLNR/L1216F16	12	16	85	17	12	16	0.4	TN**1604...	1
JTTLNR/L1216X16	12	16	120	17	12	16	0.4	TN**1604...	1
JTTLNR/L1616X16	16	16	120	17	16	16	0.4	TN**1604...	1

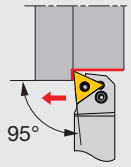
*Torque: Recommended torque (N·m) for clamping **RE: Standard corner radius

SPARE PARTS

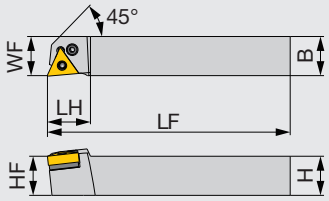
Designation	Clamp	Clamping screw	Wrench
JTTLNR/L...	JCP-3N	JDS-5040	P-2.5F

PTL2NR/L

Lever lock type toolholder without offset with 95° approach angle for negative 60° triangular inserts



Cutting edge style **L2**



Without offset

Right hand (R) shown.

Designation	H	B	LF	LH	HF	WF	RE**	Insert	Torque*
PTL2NR/L2020H16	20	20	100	22	20	20	0.4	TN**1604...	2

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

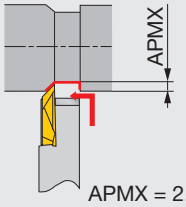
SPARE PARTS

Designation	Shim	Clamping screw	Lever	Spring pin	Wrench
PTL2NR/L...	LST317 D30	LCS3	P-2.5	LSP3	LCL3

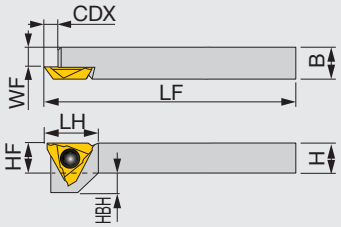
J-SERIES

JSTBR/L

Screw-on toolholder for back turning



APMX = 2.5 mm



Right hand (R) shown.

Designation	H	B	LF	LH	CDX	HF	WF	HBH	Insert	Torque*
JSTBR/L1010X3	10	10	120	15	5	10	6	5	JTBR/L3...	1.2
JSTBL1010K3	10	10	125	15	5	10	6	5	JTBR/L3...	1.2
JSTBR/L1212F3	12	12	85	15	5	12	8	3	JTBR/L3...	1.2
JSTBR/L1212X3	12	12	120	15	5	12	8	3	JTBR/L3...	1.2
JSTBR/L1616X3	16	16	120	15	5	16	12	-	JTBR/L3...	1.2

*Torque: Recommended torque (N·m) for clamping

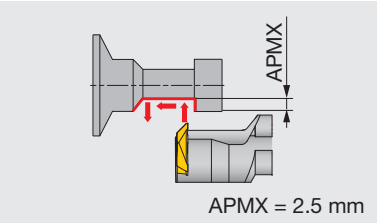
SPARE PARTS

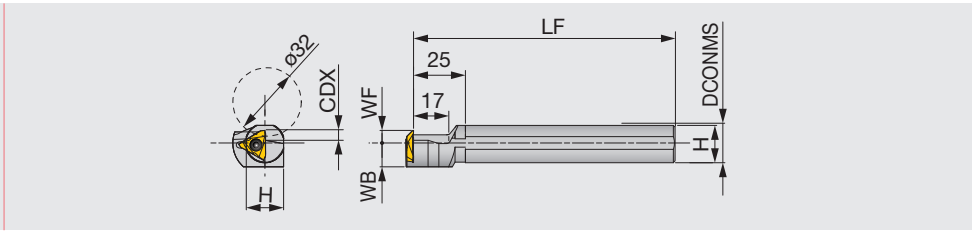
Designation	Clamping screw	Wrench
JSTBR/L...	CSTB-4SD	T-8F

J-SERIES

JS-TBL3

Screw-on toolholder for back turning





Designation	DCONMS	H	LF	CDX	WF	WB	Insert	Torque*
JS19K-TBL3	19.05	18	125	4.5	6	11.5	JTBR3...	3
JS20K-TBL3	20	19	125	4.5	6	11.5	JTBR3...	3
JS22K-TBL3	22	21	125	4.5	6	11.5	JTBR3...	3
JS25K-TBL3	25.4	24	125	4.5	10	12.7	JTBR3...	3

*Torque: Recommended torque (N·m) for clamping

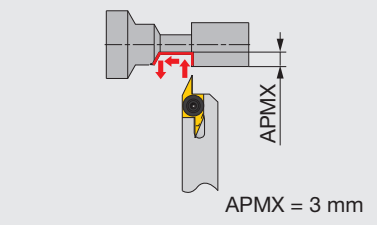
SPARE PARTS

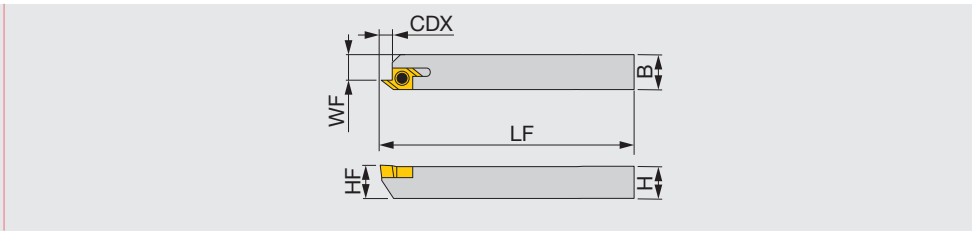
Designation	Clamping screw	Wrench
JS**-TBL3	CSTB-4S	T-15F

J-SERIES

JSEGR/L

Screw-on toolholder for back turning





Designation	H	B	LF	CDX	HF	WF	Insert	Torque*
JSEGR/L1010K10	10	10	125	3.3	10	7.5	J10ER/L...	1.2
JSEGR/L1212K10	12	12	125	3.3	12	9.5	J10ER/L...	1.2
JSEGR/L1616K10	16	16	125	3.3	16	13.5	J10ER/L...	1.2

*Torque: Recommended torque (N·m) for clamping

SPARE PARTS

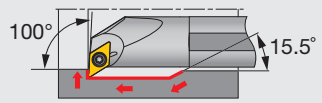
Designation	Clamping screw	Wrench
JSEGR/L...	CSTB-2.5	T-8F

Internal toolholders

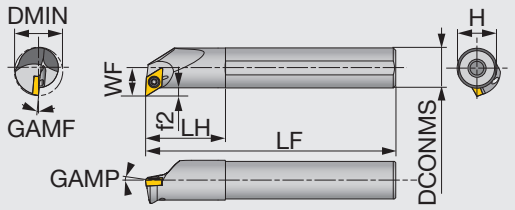
MINIFORCE TURN

A/E-SDXXR/L

For 55° rhombic insert with 4 edges



Cutting edge style **X**



Right hand (R) shown.

Designation	Material	DMIN	DCONMS	WF	LF	LH	H	f2	GAMP	GAMF	RE**	Insert	Torque*
A10K-SDXXR/L07-D130	STEEL	13	10	7.6	125	20	9	2.6	-14	-16	0.4	DXGU0703**L/R...	0.9
A12M-SDXXR/L07-D160	STEEL	16	12	8.6	150	24	11	2.6	-14	-14	0.4	DXGU0703**L/R...	0.9
A16Q-SDXXR/L07-D200	STEEL	20	16	10.6	180	32	15	2.6	-13	-13	0.4	DXGU0703**L/R...	0.9
A20R-SDXXR/L07-D240	STEEL	24	20	12.6	200	36	18	2.6	-13	-12	0.4	DXGU0703**L/R...	0.9
E10M-SDXXR/L07-D130	CARBIDE	13	10	7.6	150	25	9	2.6	-14	-16	0.4	DXGU0703**L/R...	0.9
E12Q-SDXXR/L07-D160	CARBIDE	16	12	8.6	180	27	11	2.6	-14	-14	0.4	DXGU0703**L/R...	0.9
E16R-SDXXR/L07-D200	CARBIDE	20	16	10.6	200	32	15	2.6	-13	-13	0.4	DXGU0703**L/R...	0.9
E20S-SDXXR/L07-D240	CARBIDE	24	20	12.6	250	36	18	2.6	-13	-12	0.4	DXGU0703**L/R...	0.9

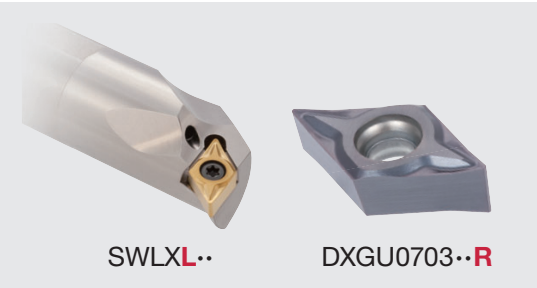
*Torque: Recommended torque (N·m) for clamping **RE: The holder measurements are true with this insert radius
Note: Use the right hand toolholder (R) for the left hand insert (L). Use the left hand toolholder (L) for the right hand insert (R)

SPARE PARTS

Designation	Clamping screw	Wrench
A/E**-SDXXR/L...	SR34-514	T-7F

❶ Use the right hand toolholder (R) for the left hand insert (L)
❷ Use the left hand toolholder (L) for the right hand insert (R)

❶ Right hand toolholder with left hand insert shown

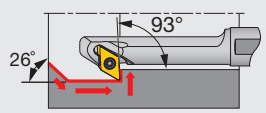


❷ Left hand toolholder with right hand insert shown

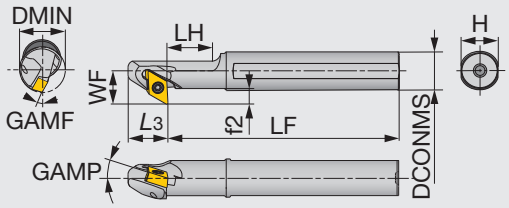
MINIFORCE TURN

A/E-SDZXR/L

For 55° rhombic insert with 4 edges



Cutting edge style **Z**



Right hand (R) shown.

Designation	Material	DMIN	DCONMS	WF	LF	LH	L3	H	f2	GAMP	GAMF	RE**	Insert	Torque*
A12M-SDZXR/L07-D140	STEEL	14	12	10.5	150	30	13	11	4.5	-10	-14	0.4	DXGU0703**R/L...	0.9
A16Q-SDZXR/L07-D160	STEEL	16	16	12.5	180	35	13	15	4.5	-10	-12.5	0.4	DXGU0703**R/L...	0.9
A20R-SDZXR/L07-D200	STEEL	20	20	14.5	200	40	13	18	4.5	-10	-10.5	0.4	DXGU0703**R/L...	0.9
E12Q-SDZXR/L07-D180	CARBIDE	18	12	10.5	180	-	13	11	4.5	-11	-11	0.4	DXGU0703**R/L...	0.9
E16R-SDZXR/L07-D220	CARBIDE	22	16	12.5	200	-	13	15	4.5	-11	-9	0.4	DXGU0703**R/L...	0.9

*Torque: Recommended torque (N·m) for clamping **RE: The holder measurements are true with this insert radius
Note: Use the right hand toolholder (R) for the right hand insert (R). Use the left hand toolholder (L) for the left hand insert (L)

SPARE PARTS

Designation	Clamping screw	Wrench
A/E**-SDZXR/L...	SR34-514	T-7F

❶ Right hand toolholders (R) are used with right hand inserts (R)
❷ Left hand toolholders (L) are used with left hand inserts (L)

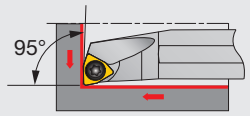
❶ Right hand toolholder with right hand insert shown

❷ Left hand toolholder with left hand insert shown

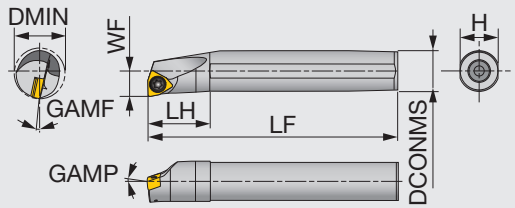
MINIFORCE TURN

A/E-SWLXR/L

For trigon insert with 6 edges



Cutting edge style **L**



Right hand (R) shown.

Designation	Material	DMIN	DCONMS	WF	LF	LH	H	GAMP	GAMF	RE**	Insert	Torque*
A10K-SWLXR/L04-D120	STEEL	12	10	6	125	20	9	-10	-16	0.4	WXGU0403**L/R...	0.9
A12M-SWLXR/L04-D140	STEEL	14	12	7	150	24	11	-10	-14	0.4	WXGU0403**L/R...	0.9
A16Q-SWLXR/L04-D180	STEEL	18	16	9	180	32	15	-10	-11	0.4	WXGU0403**L/R...	0.9
A20R-SWLXR/L04-D220	STEEL	22	20	11	200	36	18	-10	-10	0.4	WXGU0403**L/R...	0.9
E10M-SWLXR/L04-D120	CARBIDE	12	10	6	150	25	9	-10	-16	0.4	WXGU0403**L/R...	0.9
E12Q-SWLXR/L04-D140	CARBIDE	14	12	7	180	27	11	-10	-14	0.4	WXGU0403**L/R...	0.9
E16R-SWLXR/L04-D180	CARBIDE	18	16	9	200	32	15	-10	-11	0.4	WXGU0403**L/R...	0.9
E20S-SWLXR/L04-D220	CARBIDE	22	20	11	250	36	18	-10	-10	0.4	WXGU0403**L/R...	0.9

*Torque: Recommended torque (N·m) for clamping **RE: The holder measurements are true with this insert radius
Note: Use the right hand toolholder (R) for the left hand insert (L). Use the left hand toolholder (L) for the right hand insert (R)

SPARE PARTS

Designation	Clamping screw	Wrench
A/E**-SWLXR/L...	SR34-514	T-7F

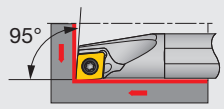
❶ Use the right hand toolholder (R) for the left hand insert (L)
❷ Use the left hand toolholder (L) for the right hand insert (R)

❶ Right hand toolholder with left hand insert shown

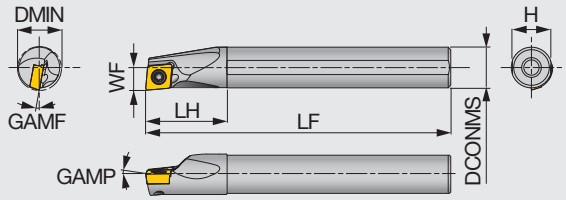
❷ Left hand toolholder with right hand insert shown

STREAMJETBAR
A/E-SCLCR/L

Screw-on boring bars, for positive 80° rhombic inserts



Cutting edge style **L**



Right hand (R) shown.

Designation	Material	DMIN	DCONMS	WF	LF	LH	H	GAMP	GAMF	RE**	Insert	Torque*
A04F-SCLCR/L03-D050	STEEL	5	4	2.5	80	8	3.8	0	-15	0.2	CC**03X1...	0.6
A05F-SCLCR/L03-D060	STEEL	6	5	3	80	9	4.8	0	-13	0.2	CC**03X1...	0.6
A06G-SCLCR/L04-D070	STEEL	7	6	3.5	90	11	5.75	0	-13	0.2	CC**04T1...	0.6
A07G-SCLCR/L04-D080	STEEL	8	7	4	90	12	6.75	0	-11	0.2	CC**04T1...	0.6
E04G-SCLCR/L03-D050	CARBIDE	5	4	2.5	90	9	3.8	0	-15	0.2	CC**03X1...	0.6
E05G-SCLCR/L03-D060	CARBIDE	6	5	3	90	10	4.8	0	-13	0.2	CC**03X1...	0.6
E06H-SCLCR/L04-D070	CARBIDE	7	6	3.5	100	12	5.75	0	-13	0.2	CC**04T1...	0.6
E07H-SCLCR/L04-D080	CARBIDE	8	7	4	100	14	6.75	0	-11	0.2	CC**04T1...	0.6

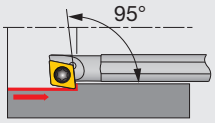
*Torque: Recommended torque (N·m) for clamping **RE: Standard corner radius
Note: When using a right or left hand insert, the right hand insert (R) is used for the left hand toolholders (SCLCL** type), and the left hand insert (L) is used for the right hand toolholders (SCLCR** type).

SPARE PARTS

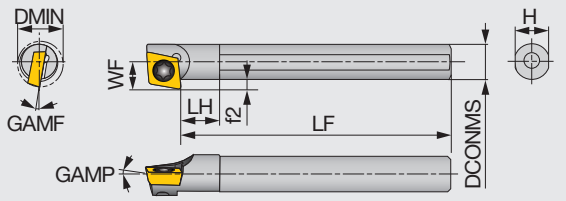
Designation	Clamping screw	Wrench
A**-SCLCR/L03-D...	CSTA-1.6	T-6F
A**-SCLCR/L04-D...	CSTB-2	T-6F
E**-SCLCR/L03-D...	CSTA-1.6	T-6F
E**-SCLCR/L04-D...	CSTB-2	T-6F

STREAMJETBAR
A/E-SEZPR/L

Screw-on boring bars, for positive 75° rhombic inserts



Cutting edge style **Z**



Right hand (R) shown.

Designation	Material	DMIN	DCONMS	WF	LF	LH	H	f2	GAMP	GAMF	RE**	Insert	Torque*
A04F-SEZPR/L03-D055	STEEL	5.5	4	3.2	80	4	3.8	1.2	0	-8	0.2	EP**03X1...	0.6
A05F-SEZPR/L03-D065	STEEL	6.5	5	3.7	80	5	4.8	1.2	0	-6	0.2	EP**03X1...	0.6
E04G-SEZPR/L03-D055	CARBIDE	5.5	4	3.2	90	5	3.8	1.2	0	-8	0.2	EP**03X1...	0.6
E05G-SEZPR/L03-D065	CARBIDE	6.5	5	3.7	90	6	4.8	1.2	0	-6	0.2	EP**03X1...	0.6

*Torque: Recommended torque (N·m) for clamping **RE: Standard corner radius
Note: When using a right or left hand insert, the right hand insert (R) is used for the right hand toolholders (SEZPR ** type), and the left hand insert (L) is used for the left hand toolholders (SEZPL ** type).

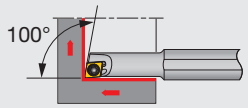
SPARE PARTS

Designation	Clamping screw	Wrench
A**-SEZPR/L03-D...	CSTA-1.6	T-6F
E**-SEZPR/L03-D...	CSTA-1.6	T-6F

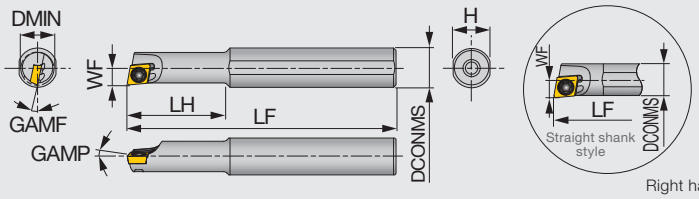
STREAMJETBAR

A/E-SEXPR/L

Screw-on boring bars, for positive 75° rhombic inserts



Cutting edge style **X**



Right hand (R) shown.

Designation	Material	DMIN	DCONMS	WF	LF	LH	H	GAMP	GAMF	RE**	Insert	Torque*
A04F-SEXPR/L03-D045	STEEL	4.5	4	2.3	80	8	3.8	0	-15	0.2	EP**03X1...	0.6
A04F-SEXPR/L03-D050	STEEL	5	4	2.5	80	8	3.8	0	-13	0.2	EP**03X1...	0.6
A05F-SEXPR/L04-D055	STEEL	5.5	5	2.75	80	9	4.8	0	-12	0.4	EP**0401...	0.6
A06G-SEXPR/L04-D070	STEEL	7	6	3.6	90	11	5.75	0	-12	0.4	EP**0401...	0.6
A08H-SEXPR/L04-D055	STEEL	5.5	8	2.75	100	16	7.5	0	-12	0.4	EP**0401...	0.6
A08H-SEXPR/L04-D070	STEEL	7	8	3.6	100	20	7.5	0	-12	0.4	EP**0401...	0.6
E04G-SEXPR/L03-D045	CARBIDE	4.5	4	2.3	90	9	3.8	0	-15	0.2	EP**03X1...	0.6
E04G-SEXPR/L03-D050	CARBIDE	5	4	2.5	90	9	3.8	0	-13	0.2	EP**03X1...	0.6
E05G-SEXPR/L04-D055	CARBIDE	5.5	5	2.75	90	10	4.8	0	-12	0.4	EP**0401...	0.6
E06H-SEXPR/L04-D070	CARBIDE	7	6	3.6	100	12	5.75	0	-12	0.4	EP**0401...	0.6
E08K-SEXPR/L04-D055	CARBIDE	5.5	8	2.75	125	28	7.5	0	-12	0.4	EP**0401...	0.6
E08K-SEXPR/L04-D070	CARBIDE	7	8	3.6	125	40	7.5	0	-12	0.4	EP**0401...	0.6

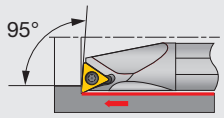
*Torque: Recommended torque (N·m) for clamping **RE: Standard corner radius
Note: When using a right or left hand insert, the right hand insert (R) is used for the left hand toolholders (SEXPL** type), and the left hand insert (L) is used for the right hand toolholders (SEXPR** type).

SPARE PARTS

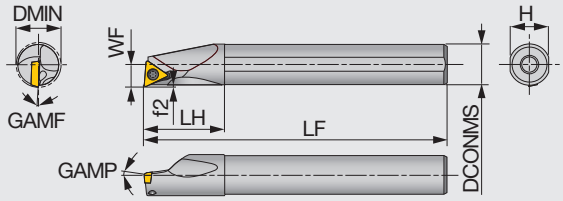
Designation	Clamping screw	Wrench
A**-SEXPR/L03-D...	CSTA-1.6	T-6F
A**-SEXPR/L04-D...	CSTB-2	T-6F
E**-SEXPR/L03-D...	CSTA-1.6	T-6F
E**-SEXPR/L04-D...	CSTB-2	T-6F

STREAMJETBAR
A/E-STUPR/L

Screw-on boring bars, for positive triangle inserts



Cutting edge style **U**



Right hand (R) shown.

Designation	Material	DMIN	DCONMS	WF	LF	LH	H	f2	GAMP	GAMF	RE**	Insert	Torque*
A07G-STUPR/L07-D080	STEEL	8	7	4	90	12	6.75	0.4	5	-10	0.4	TP**0701...	0.9
A08H-STUPR/L07-D080	STEEL	8	8	4	100	19.5	7.5	0.5	5	-10	0.4	TP**0701...	0.9
E07H-STUPR/L07-D080	CARBIDE	8	7	4	100	14	6.75	0.3	5	-10	0.4	TP**0701...	0.9
E08G-STUPR07-D080	CARBIDE	8	8	4	90	44.5	7.5	0.5	5	-10	0.4	TP**0701...	0.9
E08K-STUPR/L07-D080	CARBIDE	8	8	4	125	44.5	7.5	0.5	5	-10	0.4	TP**0701...	0.9

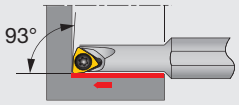
*Torque: Recommended torque (N·m) for clamping **RE: Standard corner radius
Note: When using a right or left hand insert, the right hand insert (R) is used for the left hand toolholders (STUPL ** type), and the left hand insert (L) is used for the right hand toolholders (STUPR ** type).

SPARE PARTS

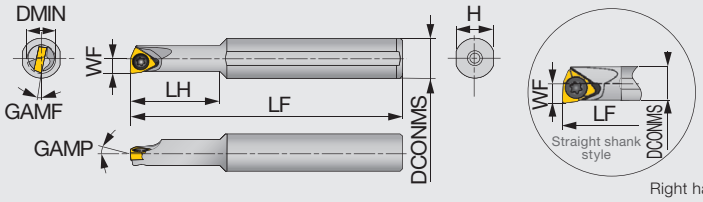
Designation	Clamping screw	Wrench
A07/08-STUPR/L07/09-D...	CSTB-2.2L038	T-7F
E07/08-STUPR/L07/09-D...	CSTB-2.2L038	T-7F

STREAMJETBAR
A/E-SWUBR/L

Screw-on boring bars, for positive trigon inserts



Cutting edge style **U**



Right hand (R) shown.

Designation	Material	DMIN	DCONMS	WF	LF	LH	H	GAMP	GAMF	RE**	Insert	Torque*
A05F-SWUBR/L03-D060	STEEL	6	5	3	80	9	4.8	0	-13	0.4	WB**0301...	0.6
A06G-SWUBR/L03-D070	STEEL	7	6	3.5	90	11	5.75	0	-12	0.4	WB**0301...	0.6
A07G-SWUBR/L03-D080	STEEL	8	7	4	90	12	6.75	0	-11	0.4	WB**0301...	0.6
A08H-SWUBR03-D060	STEEL	6	8	3.1	100	18	7.5	0	-12	0.4	WB**0301...	0.6
A08H-SWUBR03-D070	STEEL	7	8	3.6	100	20	7.5	0	-12	0.4	WB**0301...	0.6
E05G-SWUBR/L03-D060	CARBIDE	6	5	3	90	10	4.8	0	-13	0.4	WB**0301...	0.6
E06H-SWUBR/L03-D070	CARBIDE	7	6	3.5	100	12	5.75	0	-12	0.4	WB**0301...	0.6
E07H-SWUBR/L03-D080	CARBIDE	8	7	4	100	14	6.75	0	-11	0.4	WB**0301...	0.6
E08K-SWUBR03-D060	CARBIDE	6	8	3.1	125	30	7.5	0	-12	0.4	WB**0301...	0.6
E08K-SWUBR03-D070	CARBIDE	7	8	3.6	125	40	7.5	0	-12	0.4	WB**0301...	0.6

*Torque: Recommended torque (N·m) for clamping **RE: Standard corner radius
Note: When using a right or left hand insert, the right hand insert (R) is used for the left hand toolholders (SWUBL** type), and the left hand insert (L) is used for the right hand toolholders (SWUBR** type).

SPARE PARTS

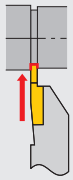
Designation	Clamping screw	Wrench
A/E**-SWUBR/L...	CSTB-2	T-6F

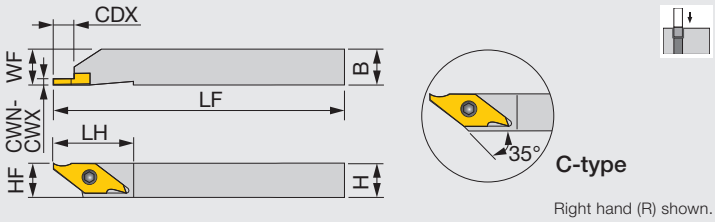
Grooving

J-SERIES

JSVGR/L

External grooving toolholders





Right hand (R) shown.

Designation	CWN	CWX	CDX	H	B	LF	LH	HF	WF	Insert	Torque*
JSVGR/L1010K-C	0.33	2	6.2	10	10	125	23	10	10	JVGR/L...	2.3
JSVGR/L1212K-C	0.33	2	6.2	12	12	125	23	12	12	JVGR/L...	2.3
JSVGR/L1616K	0.33	2	6.2	16	16	125	23	16	16	JVGR/L...	2.3

*Torque: Recommended torque (N·m) for clamping

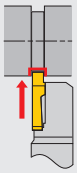
SPARE PARTS

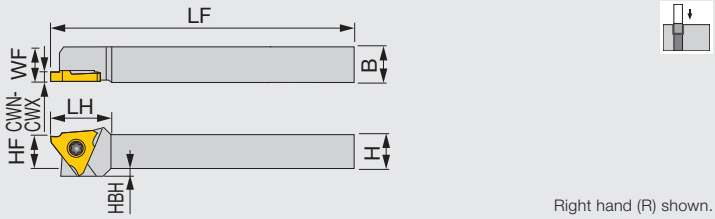
Designation	Clamping screw	Wrench	Wrench 1 (Optional parts)
JSVGR/L	CSTB-3S	T-9F	(T-8L)

J-SERIES

JSTGR/L

External grooving toolholders





Right hand (R) shown.

Designation	CWN	CWX	H	B	LF	LH	HF	WF	HBH	Insert	Torque*
JSTGR/L1010X3	0.33	3	10	10	120	18.5	10	10	2	JTGR/L3...	1.2
JSTGR/L1212F3	0.33	3	12	12	85	18.5	12	12	-	JTGR/L3...	1.2
JSTGR/L1212X3	0.33	3	12	12	120	18.5	12	12	-	JTGR/L3...	1.2
JSTGR/L1616X3	0.33	3	16	16	120	18.5	16	16	-	JTGR/L3...	1.2
JSTGL1616K3	0.33	3	16	16	125	18.5	16	16	-	JTGR/L3...	1.2

*Torque: Recommended torque (N·m) for clamping

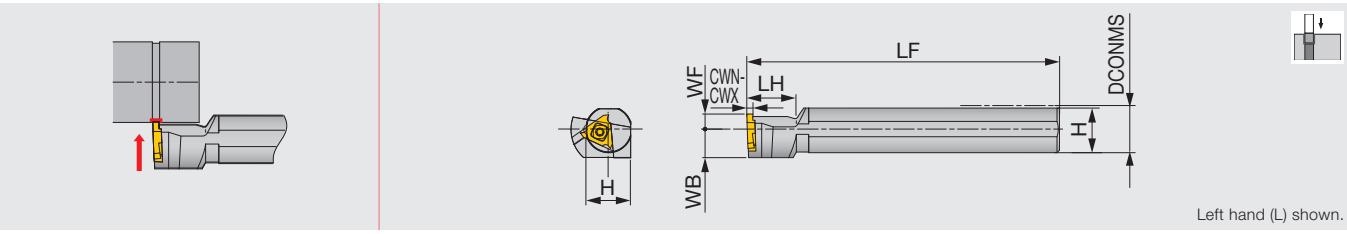
SPARE PARTS

Designation	Clamping screw	Wrench	Wrench 1 (Optional parts)
JSTGR/L...	CSTB-4SD	T-8F	(T-8L)

J-SERIES

JS-TGL3

External grooving toolholders



Designation	CWN	CWX	DCONMS	WF	LF	LH	H	WB	Insert	Torque*
JS19K-TGL3	0.33	3	19.05	6	125	20	18	11.5	JTGR3...	3.0
JS20K-TGL3	0.33	3	20	6	125	20	19	11.5	JTGR3...	3.0
JS22K-TGL3	0.33	3	22	6	125	20	21	11.5	JTGR3...	3.0
JS25K-TGL3	0.33	3	25.4	10	125	20	24	12.7	JTGR3...	3.0

• Left hand toolholders (TGL3) are used with right hand inserts (JTGR3).
*Torque: Recommended torque (N·m) for clamping

SPARE PARTS

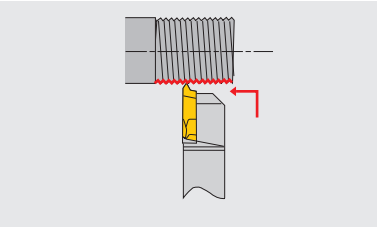
Designation	Clamping screw	Wrench
JS**-TGL3	CSTB-4S	T-15F

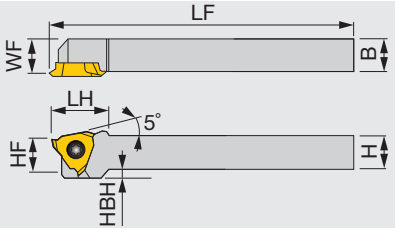
Threading

J-SERIES

JSTTR/L

External threading toolholders





Right hand (R) shown.

Designation	H	B	LF	LH	HF	WF	HBH	Insert
JSTTR/L1010X3	10	10	120	18.5	10	9.5	2	JTTR/L3...
JSTTR/L1212F3	12	12	85	18.5	12	11.5	-	JTTR/L3...
JSTTR/L1212X3	12	12	120	18.5	12	11.5	-	JTTR/L3...
JSTTR/L1616X3	16	16	120	18.5	16	15.5	-	JTTR/L3...

• Recommend clamping torque: 1.2 N·m

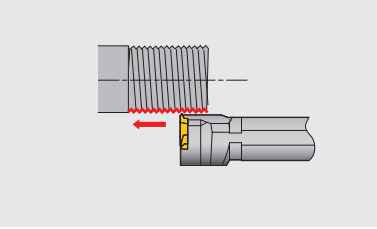
SPARE PARTS

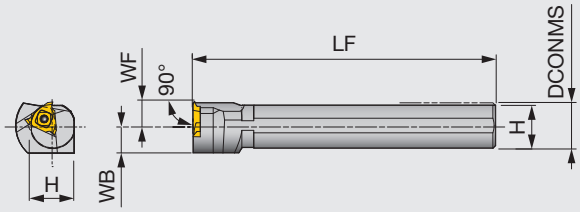
Designation	Clamping screw	Wrench	Wrench 1 (Optional parts)
JSTTR/L...	CSTB-4SD	T-8F	(T-8L)

J-SERIES

JS-TTL3

External threading toolholders





Left hand (L) shown.

Designation	DCONMS	WF	LF	H	WB	Insert
JS19K-TTL3	19.05	10	125	18	11.5	JTTR30...
JS20K-TTL3	20	10	125	19	11.5	JTTR30...
JS22K-TTL3	22	10	125	21	11.5	JTTR30...
JS25K-TTL3	25.4	10	125	24	12.7	JTTR30...

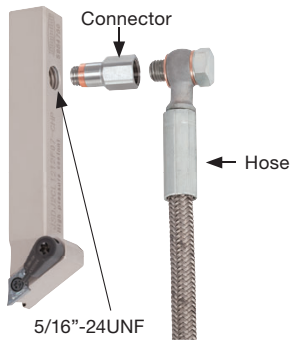
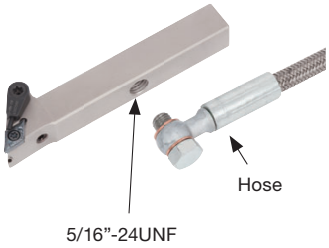
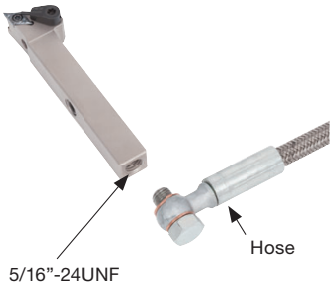
• Recommend clamping torque: 3.5 N·m

SPARE PARTS

Designation	Clamping screw	Wrench
JS**-TTL3	CSTB-4S	T-15F

TUBE CONNECTIONS FOR TungTurn-Jet

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

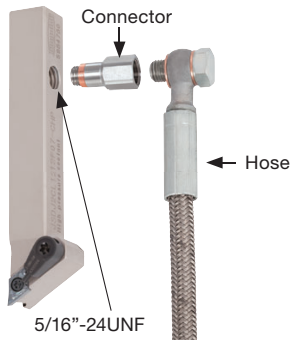
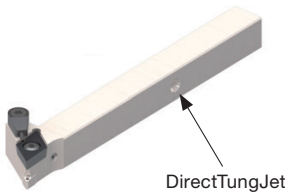
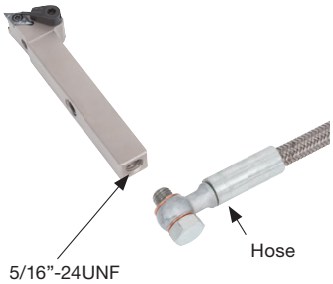
Designation	JSDJ2X... / JSWL2X... / JSVJ2X... / JSDJ2C... / JSVJ2B...		
Shank size	≤ 16 mm		
Connection	Back	Front	Back end
Example of connection			
Connector for toolholder	CHP-CONECTOR5/16-G1/8	-	-
Hose	CHP-HOSE-G1/8-7/16-200BS(1)	CHP-HOSE-5/16-7/16-200BS(1)	CHP-HOSE-5/16-7/16-200BS(1)
	CHP-HOSE-G1/8-7/16-250BS(1)	-	-
	CHP-HOSE-G1/8-G1/8-200BB(2)	-	-
	CHP-HOSE-G1/8-G1/8-250BB(2)	-	-
Connector for machine(3)	CHP-NIPPLE-G1/8-7/16UNF	CHP-NIPPLE-G1/8-7/16UNF	CHP-NIPPLE-G1/8-7/16UNF
Washer for machine(3)	CHP-COPPER-SEAL1/8	CHP-COPPER-SEAL1/8	CHP-COPPER-SEAL1/8

(1): The tube thread type on the machine side is 7/16” -20UNF, female thread.
Therefore, use both Nipple (3) and Washer (3) to connect to the machine G1/8 femail thread.
(2): The thread type on the machine side is G1/8” -28 BSPP, male thread.

DIRECT TUNG JET system

TUBE CONNECTIONS FOR DirectTung-Jet

Requires external coolant subassembly

Designation	Toolholders for Direct Tung Jet		
Shank size	12 - 20 mm		
Connection	Back	Front	Back end
Example of connection			
Connector for toolholder	CHP-CONECTOR5/16-G1/8	-	-
Hose	CHP-HOSE-G1/8-7/16-200BS(1)	-	CHP-HOSE-5/16-7/16-200BS(1)
	CHP-HOSE-G1/8-7/16-250BS(1)	-	-
	CHP-HOSE-G1/8-G1/8-200BB(2)	-	-
	CHP-HOSE-G1/8-G1/8-250BB(2)	-	-
Connector for machine(3)	CHP-NIPPLE-G1/8-7/16UNF	-	CHP-NIPPLE-G1/8-7/16UNF
Washer for machine(3)	CHP-COPPER-SEAL1/8	-	CHP-COPPER-SEAL1/8

(1): The tube thread type on the machine side is 7/16” -20UNF, female thread.
Therefore, use both Nipple (3) and Washer (3) to connect to the machine G1/8 femail thread.
(2): The thread type on the machine side is G1/8” -28 BSPP, male thread.

PARTS FOR COOLANT HOSE

Connecting hose

Fig. 1

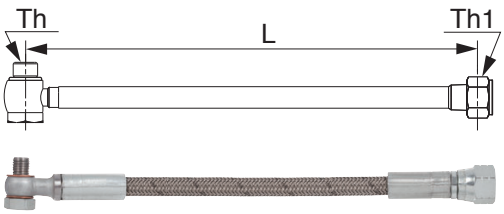
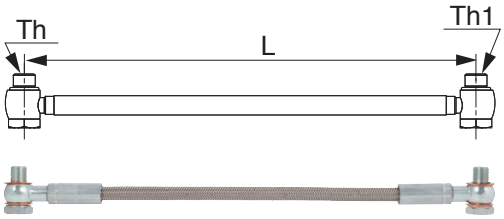
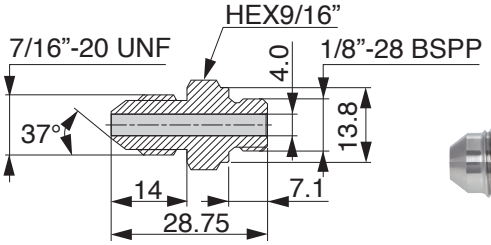


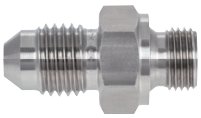
Fig. 2



Designation	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

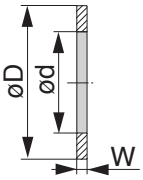
Connector

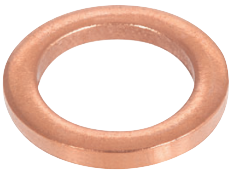




Designation
CHP-NIPPLE-G1/8-7/16UNF

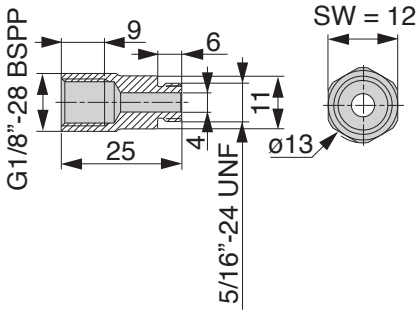
Seal washer

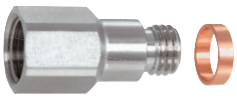




Designation	Dimensions (mm)		
	øD	ød	W
CHP-COPPER-SEAL1/8	15	10	1
CHP-COPPER-SEAL5/16	11	8	1
CHP-COPPER-SEAL5/16-2.5	11	8	2.5

Connector for small lathe with seal washer



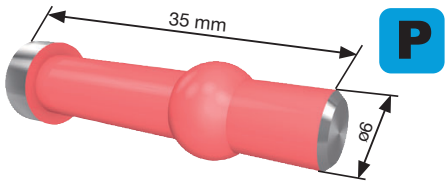
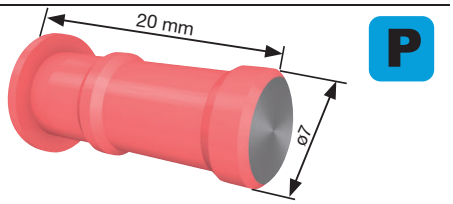
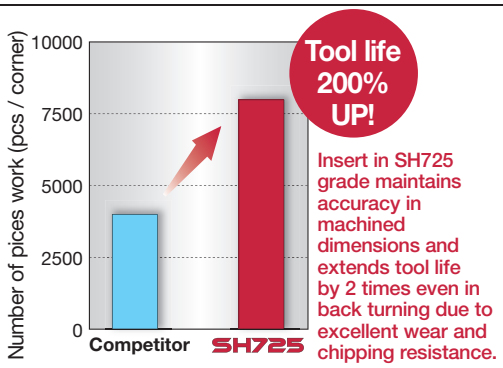
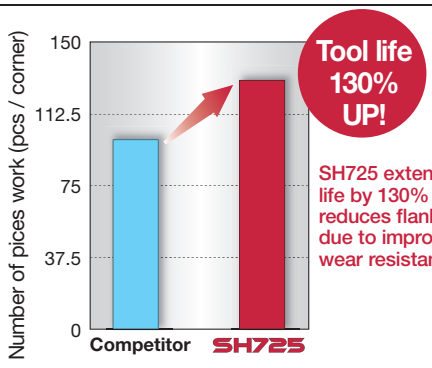


Designation
CHP-CONECTOR/5/16-G1/8

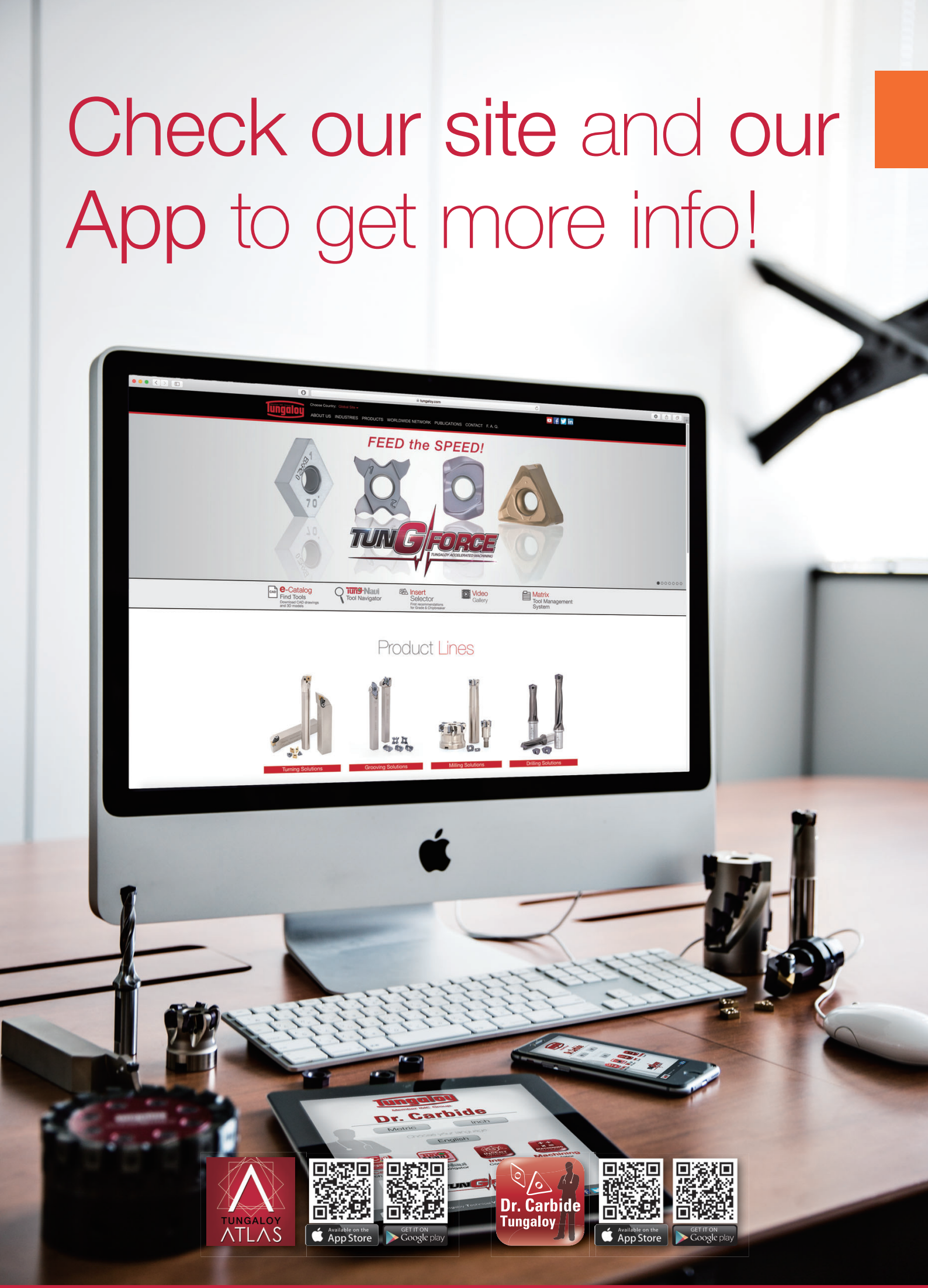
SH725

TUNGALOY

PRACTICAL EXAMPLES

Workpiece type		Shaft	Shaft
Toolholder		JSEGR1212K10	SVLPR1212X-11FF
Insert		J10ER010BF	VPET110301MFR-JRP
Grade		SH725	SH725
Workpiece material		SUM24L / Low-carbon free-cutting steel	SCM415 / 18CrMo4
			
Cutting conditions	Cutting speed : *Vc*(m/min)	100	150
	Feed : *f* (mm/rev)	0.04	0.02
	Depth of cut : *ap* (mm)	1.2	0.5
	Machining	Back Turning	External turning
	Coolant	Wet	Wet
Results		 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.	 SH725 extends tool life by 130% and reduces flank wear due to improved wear resistance.

Check our site and our App to get more info!



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