

Internal Toolholder



Internal Toolholder - Content structure

- Indexable toolholders are listed by cutting edge shape.
- In the same cutting edge shape, the inserts are sorted alphabetically.
The order of the list: CN□□ insert → DN□□ insert → RN□□ insert → SN□□ insert →
TN□□ insert → VN□□ insert → WN□□ insert
- Toolholders in the catalog are our standard stock items.

How to use the page

- Method ① Select the approach angle described at the left end of each page, jump to the page on the left index, and choose a designation you need (④) in the dimension table (③). Applicable inserts are shown in (⑥) and (⑧).
- Method ② Select the approach angle on D003 and check the details on the product page.
- Method ③ Select the series name of a toolholder on D003 and check the details on each page.
- Method ④ Select an item from Quick Guide on D006 - D011.

② **MINIFURN**
A/E-SWLXR/L

Screw-on boring bar, for W&G inserts

① Cutting edge style L

③ Dimension table

Insert	Material	DMIN	DCONS	WF	LF	LH	H	GAMP	GAMP	RE**	Insert	Torque
A06-SWLXR/L2-D08	Steel	0.500	0.375	0.281	5.000	0.750	0.350	-10°	-14°	0.016	WXG0403°/L/L	0.66
A06-SWLXR/L2-D11	Steel	0.688	0.500	0.406	5.000	1.000	0.475	-10°	-10°	0.016	WXG0403°/L/L	0.66
A06-SWLXR/L2-D14	Steel	0.875	0.625	0.531	7.000	1.250	0.600	-10°	-8°	0.016	WXG0403°/L/L	0.66
A12-SWLXR/L2-D16	Steel	1.000	0.750	0.563	7.000	1.438	0.725	-10°	-7°	0.016	WXG0403°/L/L	0.66
A16-SWLXR/L2-D20	Steel	1.250	1.000	0.625	7.000	1.438	0.938	-10°	-7°	0.016	WXG0403°/L/L	0.66
E06-SWLXR/L2-D08	Carbide	0.500	0.375	0.281	5.000	0.750	0.350	-10°	-14°	0.016	WXG0403°/L/L	0.66
E06-SWLXR/L2-D11	Carbide	0.688	0.500	0.406	5.000	1.000	0.475	-10°	-10°	0.016	WXG0403°/L/L	0.66
E12-SWLXR/L2-D14	Carbide	0.875	0.625	0.531	7.000	1.250	0.600	-10°	-8°	0.016	WXG0403°/L/L	0.66
E16-SWLXR/L2-D16	Carbide	1.000	0.750	0.563	7.000	1.438	0.725	-10°	-7°	0.016	WXG0403°/L/L	0.66
E16-SWLXR/L2-D20	Carbide	1.250	1.000	0.625	10.000	1.812	0.938	-10°	-7°	0.016	WXG0403°/L/L	0.66

④ Toolholder designation

⑤ Applicable insert

Reference pages: A/E-SWLXR/L: Insert → B01 - Standard cutting conditions → D105

D034 www.tungaloy.com/us

ISOEFURN
A-PWLNRL/Eco

Lever-lock boring bar, for negative 80° trigon inserts

⑥ Cutting edge style L

⑦ Spare parts

Designation	Clamping screws	Wrench	Lever	Oil supply, anti-chatter	Screw for oil hole
A16M-PWLNRL0604-D030	LCB33	P-2F	LCL33N	-	SHM3-4
A20Q-PWLNRL0604-D250	LCB33	P-2F	LCL33N	EA-20	SHM3-4

⑧ Insert selection

⑨ Reference pages: A-PWLNRL/Eco: Insert → B101 -

Tungaloy D035

- ① : Cutting edge shape
- ② : Series name of indexable boring bars
- ③ : Dimension table
- ④ : Toolholder designation
- e.g. To select right-handed steel shank for minimum machining diameter $\phi 0.750$ "

→ **A12-SCLCR3-D16**

- ⑤ : Applicable insert
- ⑥ : Dimension drawing (conforming to ISO13399)
- ⑦ : Spare parts
- ⑧ : Insert selection
- ⑨ : Reference pages

When ordering

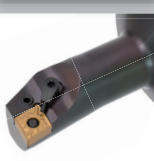
- Please specify the designation and quantity.

e.g. **A12-SCLCR/L3-D16 ... 1** (one boring bar per package)

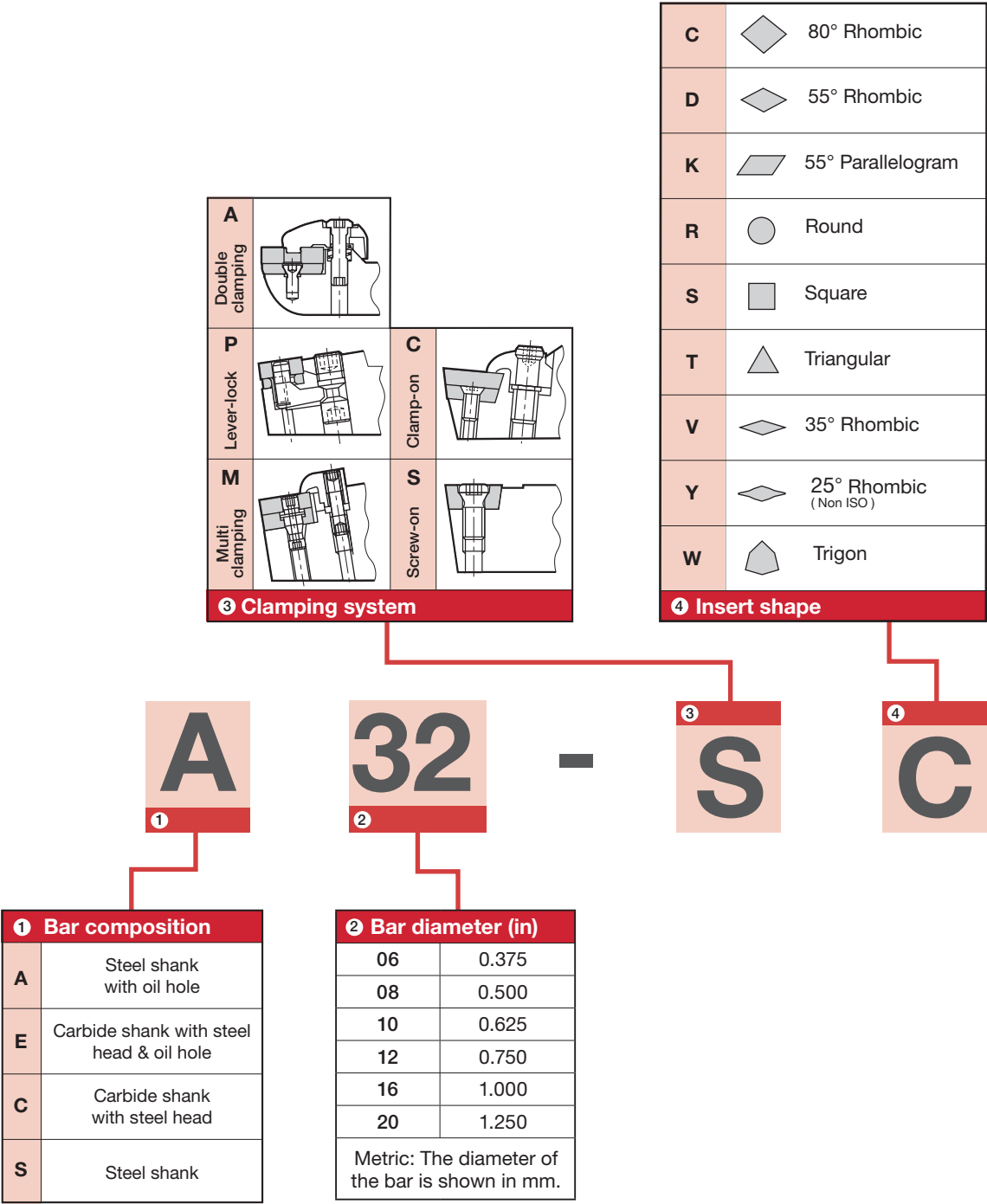
* Inserts are not included. Please order those separately.

Main products

L 95°		D020
X 100°		D040
J 142°		D043
K 75°		D045
F 91°		D049
U 93°		D056
Q 107.5°		D085
Z 93°		D093
OTHERS		D100

			Inch	Metric
	BOREMEISTER Boring head suitable for L/D=10 Shank $\varnothing 0.625"$ - $\varnothing 2.500"$	D018	☒	☐
	MINIFORCE Economical double-sided inserts with excellent sharpness Shank $\varnothing 0.500"$ - $\varnothing 1.250"$ ($\varnothing 10$ mm - 20 mm)	D034, D042, D093	☒	☒
	ISOETURN Small-sized "Eco" insert series for maximized profits Shank $\varnothing 1.000"$ - $\varnothing 1.250"$ ($\varnothing 16$ mm - 32 mm)	D028 D035, D036 D052, D062 D069, D080	☒	☒
	STREAMJETBAR Highly rigid toolholders providing good chip evacuation Shank $\varnothing 0.157"$ - $\varnothing 1.000"$ ($\varnothing 4$ mm - 50 mm)	D019	☒	☒
	Y-PRO SERIES Inserts with 25° corner angle for profiling Shank $\varnothing 0.500"$ - $\varnothing 0.625"$ ($\varnothing 12$ mm - 16 mm)	D084, D092	☒	☒
	TURNINGA Highly rigid clamping system with excellent repeatability Shank $\varnothing 1.000"$ - $\varnothing 2.000"$	D039, D048 D055, D065 D082	☒	☐
	TUNGTURNJET Toolholders for high pressure coolant supply	D031, D065	☒	☒
	Sleeve	D103 - D104	☐	☒

Designation system for Toolholders



ANSI Designation

Symbol	Style	Offset						
A		Without	G		With	S		With
				V			Without	
B		Without	J		With	U		With
				K		75° 	With	X *
C		Without	L		With	Y		With
D		Without		N		Without	Z	
E		Without	P *		Without	Note *mark: Tungaloy standard No mark: ISO standard		
F		With		Q *	45° 			
5 Cutting edge style								

N	0°
B	5°
C	7°
D	15°
E	20°
P	11°

6 Relief angle of insert

5 L 6 C 7 R 8 4 - 9 D14

7 Hand of tool	
R	
L	
N	Neutral

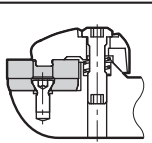
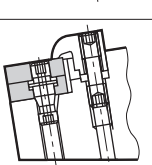
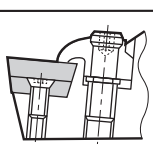
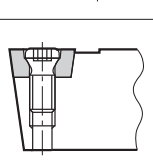
8 Insert size I.C.	
Symbol	Inscribed circle (in)
3	0.375
4	0.500
5	0.625
6	0.750

9 Min. bore diameter (in)	
Stream Jet Bar	
D14	14/16 (ø0.875)

Grade
Insert
Ext. Toolholder
Int. Toolholder
Threading
Grooving
Miniature Tool
Endmill
Drilling Tool
User's Guide Tooling System
Index

A
B
C
D
E
F
G
H
I
J
K
L
M

Designation system for Toolholders

A Double clamping	
P Lever-lock	
M Multi clamping	
C Clamp-on	
S Screw-on	
4 Clamping system	

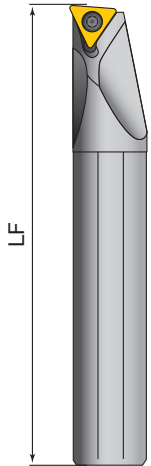
C		80° Rhombic
D		55° Rhombic
K		55° Parallelogram
R		Round
S		Square
T		Triangular
V		35° Rhombic
Y		25° Rhombic (Non ISO)
W		Trigon
5 Insert shape		



1 Bar composition	
A	Steel shank with oil hole
E	Carbide shank with steel head & oil hole
C	Carbide shank with steel head
S	Steel shank
T	Steel shank reinforced with carbide plates ("Tsuppari-Ichiban")
JS	J series Steel shank

2 Bar diameter
Bar diameter is shown in mm.

3 Toolholder length (mm)	
F	80
G	90
H	100
J	110
K	125
L	130
M	150
P	170
Q	180
R	200
S	250
T	300
U	350



ISO Designation

Symbol	Style	Offset						
			G		With	S		With
A		Without					V	
			J		With	U		With
B		Without	K		With	X _*		With
C		Without	L		With	Y		With
D		Without	N		Without	Z		Without
E		Without	P _*		Without	Note *mark: Tungaloy standard No mark: ISO standard		
F		With	Q _*		With			

6 Cutting edge style

6 Cutting edge style

C	
B	
N	
P	
X	Special

7 Relief angle of insert

6 **U** **7** **P** **8** **R** **9** **11** **0** **2** **10** **C** **11** **D140**

8 Hand of tool	
R	
L	

9 Insert size
For M, S, & C types conformed to ISO
"In ISO metric system, a two digit number indicates the edge length (L) of the insert to be used in mm. If the insert thickness is different for the same edge length, add the thickness symbol (S) (two digit number). In above example, TP□□1102□□"

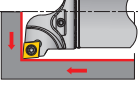
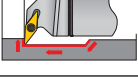
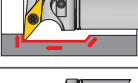
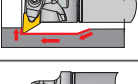
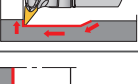
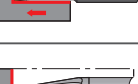
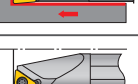
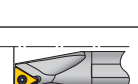
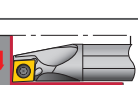
10 Oil hole
Only "Tsuppari-Ichiban" holder

11 Min. bore diameter (mm)			
Stream Jet Bar		Tsuppari-Ichiban	
D140	ø14.0	D14	ø14.0

Internal Toolholder - Quick Guide

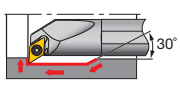
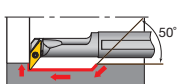
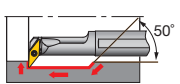
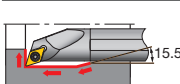
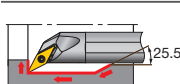
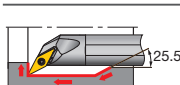
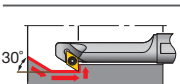
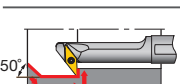
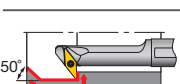
Positive type

Inch

Style	Designation & Application	ISO Insert Y-PRO SERIES	Material	TOOLHOLDER BOREMEISTER STREAMJETBAR MINIFURN	Min. bore diameter DMIN (in)						Page
					0	0.375	0.750	1.125	1.500	2.000	
	S-SCLCR/L-H Boring & internal facing Insert : CC□□	✓	Steel	✓					ø0.787"	ø1.968"	D020
	S-SDUCR/L-H Boring & internal profiling Insert : DC□□	✓	Steel	✓					ø0.787"	ø1.968"	D056
	S-SVUCR/L-H Boring & internal profiling Insert : VC□□	✓	Steel	✓					ø1.063"	ø1.260"	D074
	S-SVLCR/L-H Boring & internal profiling Insert : VC□□	✓	Steel	✓					ø1.260"	ø1.575"	D032
	S-DDUNR/L-H Boring & internal profiling Insert : DN□□	✓	Steel	✓					ø1.575"	ø1.968"	D060
	S-DVUNR/L-H Boring & internal profiling Insert : VN□□	✓	Steel	✓					ø1.575"		D078
	SEXPR/L Boring & internal facing Insert : EP□□	✓	Steel Carbide	✓					ø0.250"	ø0.250"	D040
	SCLCR/L Boring & internal facing Insert : CC□□	✓	Steel Carbide	✓					ø0.500"	ø1.250"	D022
	STUPR/L Boring Insert : TP□□	✓	Steel Carbide	✓					ø0.438"	ø1.250"	D066
	STFPR/L Blind hole boring Insert : TP□□	✓	Carbide	✓					ø0.500"	ø1.000"	D050
	SCLPR/L Boring & internal facing Insert : CP□□	✓	Steel Carbide	✓					ø0.500"	ø0.875"	D025
	STFCR/L Blind hole boring Insert : TC□□	✓	Carbide	✓					ø0.500"	ø1.000"	D049

Positive type

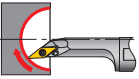
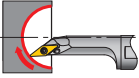
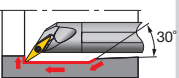
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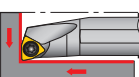
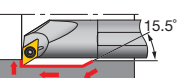
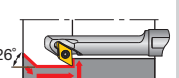
Style	Designation & Application	ISO Insert		Material	Toolholder			Min. bore diameter DMIN (in)						Page
		Insert						0	0.375	0.750	1.125	1.500	2.000	
	SDUCR/L Boring & internal profiling Insert : DC□□	✓		Steel Carbide	✓			ø0.625"				ø1.000"		D058
	SVUCR/L Boring & internal profiling Insert : VC□□	✓		Steel	✓			ø0.625"				ø1.000"		D076
	SVUBR/L Boring & internal profiling Insert : VB□□	✓		Steel	✓							ø1.000"		D072
	SDQCR/L Boring & internal profiling Insert : DC□□	✓		Steel	✓			ø0.625"				ø0.875"		D085
	SVQCR/L Boring & internal profiling Insert : VC□□	✓		Steel	✓			ø0.688"				ø1.000"		D090
	SVQBR/L Boring & internal profiling Insert : VB□□	✓		Steel	✓							ø1.000"		D088
	SDZCR/L Back boring Insert : DC□□	✓		Steel	✓							ø0.875"		D094
	SVZCR/L Back boring Insert : VC□□	✓		Steel	✓			ø0.750"				ø1.000"		D099
	SVZBR/L Back boring Insert : VB□□	✓		Steel	✓							ø1.000"		D098

Internal Toolholder - Quick Guide

Positive type

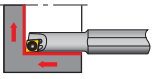
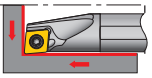
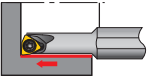
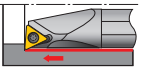
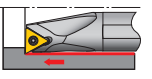
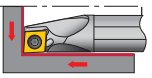
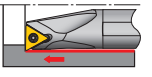
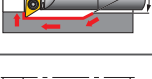
Inch

Style	Designation & Application	ISO Insert		Material	Toolholder			Min. bore diameter DMIN (in)						Page
		Insert						0	0.375	0.750	1.125	1.500	2.000	
	SVJCR/L Internal sphere cutting Insert : VC□□	✓		Steel	✓									D044
	SVJBR/L Internal sphere cutting Insert : VB□□	✓		Steel	✓									D043
	SYQBR/L Boring, undercutting & profiling Insert : YW□□	✓		Steel Carbide	✓			ø0.750"		ø0.875"				D092
	SYUBR/L Boring & internal profiling Insert : YW□□	✓		Steel Carbide	✓							ø0.875"	ø1.000"	D084

Style	Designation & Application	Material	MINIFURN		Min. bore diameter DMIN (in)						Page
			Insert	Toolholder	0	0.375	0.750	1.125	1.500	2.000	
	SWLXR/L Boring & internal facing Insert : WXGU	Steel Carbide		✓	ø0.500"				ø1.250"		D034
	SDXXR/L Boring & internal profiling Insert : DXGU	Steel Carbide		✓	ø0.625"				ø1.250"		D042
	SDZXR/L Back boring Insert : DXGU	Steel		✓	ø0.625"				ø0.875"		D093

Positive type

Metric

Style	Designation & Application	ISO Insert Y-PRO SERIES	Material	Toolholder BOREMEISTER STREAMJETBAR MINIFURN	Min. bore diameter DMIN (mm)						Page
					0	10	20	30	40	50	
	SEXPR/L Boring & internal facing Insert : EP□□	✓	Steel Carbide	✓	ø4.5	ø7					D040 D041
	SCLCR/L Boring & internal facing Insert : CC□□	✓	Steel Carbide Reinforced	✓	ø5	ø27					D023 D024
	SWUBR/L Boring Insert : WB□□	✓	Steel Carbide	✓	ø6	ø8					D083
	STUPR/L Boring Insert : TP□□	✓	Steel Carbide Reinforced	✓	ø8	ø34					D067 D068
	STFPR/L Blind hole boring Insert : TP□□	✓	Steel Carbide	✓	ø10	ø27					D050
	SCLPR/L Boring & internal facing Insert : CP□□	✓	Steel Carbide Reinforced	✓	ø10	ø27					D026 D027
	STFCR/L Blind hole boring Insert : TC□□	✓	Steel Carbide	✓	ø12	ø18					D049
	SSKPR Through boring Insert : SP□□	✓	Steel	✓		ø20	ø31				D045
	SDUCR/L Boring & internal profiling Insert : DC□□	✓	Steel Carbide	✓	ø13	ø32					D058
	SDUPR/L Boring & internal profiling Insert : DPMT□□		Steel Carbide	✓	ø15	ø22					D059

Grade

Insert

Ext. Toolholder

Int. Toolholder

Threading

Grooving

Miniature Tool

Milling Cutter

Endmill

Drilling Tool

User's Guide

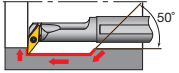
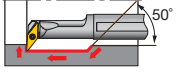
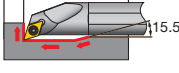
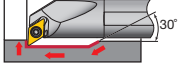
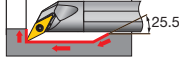
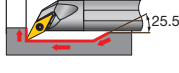
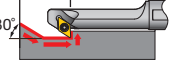
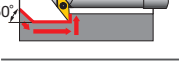
Tooling System

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Internal Toolholder - Quick Guide

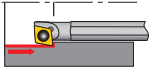
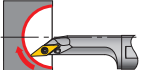
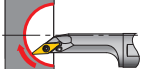
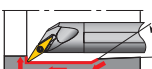
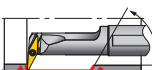
Positive type

Metric

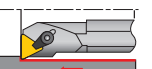
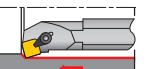
Style	Designation & Application	ISO Insert Y-PRO SERIES	Material	Toolholder BOREMEISTER STREAMJETBAR MINIFURN	Min. bore diameter DMIN (mm)						Page
					0	10	20	30	40	50	
	SVUCR/L Boring & internal profiling Insert : VC□□	✓	Steel Carbide Reinforced	✓			ø16	ø32			D076 D077
	SVUBR/L Boring & internal profiling Insert : VB□□	✓	Steel Carbide Reinforced	✓			ø20	ø32			D072 D073
	SDQCR/L Boring & internal profiling Insert : DC□□	✓	Steel Carbide Reinforced	✓			ø13	ø30			D085 D086
	SDQPR/L Boring & internal profiling Insert : DPMT□□		Steel Carbide	✓			ø15	ø22			D087
	SVQCR/L Boring & internal profiling Insert : VC□□	✓	Steel Carbide Reinforced	✓			ø13.5	ø21.5			D090 D091
	SVQBR/L Boring & internal profiling Insert : VB□□	✓	Steel Carbide Reinforced	✓			ø17	ø30.5			D088 D089
	SDZCR/L Back boring Insert : DC□□	✓	Steel Carbide	✓			ø14	ø25			D094
	SVZCR/L Back boring Insert : VC□□	✓	Steel	✓			ø16				D099
	SVZBR/L Back boring Insert : VB□□	✓	Steel	✓			ø20	ø40			D098

Positive type

Metric

Style	Designation & Application	ISO Insert	Material	Toolholder	Min. bore diameter DMIN (mm)						Page
					0	10	20	30	40	50	
	SEZPR/L Back boring Insert : EP□□	✓	Steel Carbide	✓	05.5	06.5					D097
	SVJCR/L Internal sphere cutting Insert : VC□□	✓	Steel	✓			016	020			D044
	SVJBR/L Internal sphere cutting Insert : VB□□	✓	Steel	✓			025	030			D043
	SYQBR/L Boring, undercutting & profiling Insert : YW□□	✓	Steel Carbide	✓	017	021.5					D092
	SYUBR/L Boring & internal profiling Insert : YW□□	✓	Steel Carbide	✓	020						D084

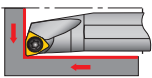
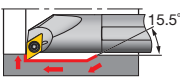
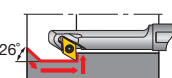
Clamp on

Style	Designation & Application	ISO Insert	Material	Toolholder	Min. bore diameter DMIN (mm)						Page
					0	10	20	30	40	50	
	CTFPR/L Blind hole boring Insert : TP□□ (without hole)	✓	Steel Carbide				016		040		D051
	CSKPR/L Through boring Insert : SP□□ (without hole)	✓	Steel				020		032		D046

Internal Toolholder - Quick Guide

Positive double side

Metric

			MINIFURN	Min. bore diameter DMIN (mm)							Page
Style	Designation & Application	Material	Insert, Toolholder	0	10	20	30	40	50		
	SWLXR/L Boring & internal facing Insert : WXGU	Steel Carbide	✓		ø12		ø22			D034	
	SDXXR/L Boring & internal profiling Insert : DXGU	Steel Carbide	✓		ø13		ø24			D042	
	SDZXR/L Back boring Insert : DXGU	Steel Carbide	✓		ø14		ø20			D093	
					ø18		ø22				

Negative type

Inch

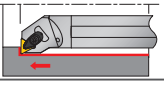
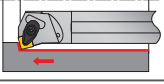
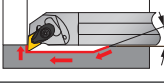
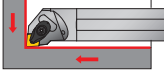
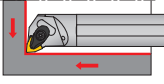
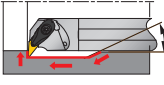
Lever lock

Negative type														
Inch														
Lever lock														
Style	Designation & Application	ISO Insert		Material	Toolholder		Min. bore diameter DMIN (in)						Page	
		Insert	ISO ETURN		STREAMJETBAR	TUNGJET	0	0.375	0.750	1.125	1.500	2.000		
	PVUNR/L Boring & internal profiling Insert : V/YN□□	✓	✓	Steel	✓							ø1.250"	ø1.650"	D080 D081

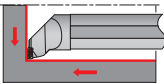
Negative type

Inch

Double clamp

Style	Designation & Application	ISO Insert		Material	STREAMJET BAR TURNING A		Min. bore diameter DMIN (in)						Page
		Insert			Toolholder		0.750	1.125	1.500	2.000	2.500	3.000	
	ATFNR/L Boring Insert : TN□□	✓		Steel		✓	ø1.250"		ø1.560"				D055
	ASKNR/L Boring Insert : SN□□	✓		Steel		✓	ø1.250"		ø1.500"				D048
	ADUNR/L Boring & internal profiling Insert : DN□□	✓	✓	Steel		✓	ø1.250"		ø2.000"				D062 D065
	ACLNR/L Boring & internal facing Insert : CN□□, GN□□	✓	✓	Steel		✓	ø1.250"				ø2.500"		D028 D031
	AVLNR/L Boring & internal facing Insert : WN□□	✓	✓	Steel		✓	ø1.250"				ø2.500"		D036 D039
	AVUNR/L Boring & internal profiling Insert : VN□□	✓		Steel		✓			ø1.560"		ø2.000"		D082

Screw-on

Style	Designation & Application	Material	TURNTEC		Min. bore diameter DMIN (in)						Page
			Insert, Toolholder		0.750	1.125	1.500	2.000	2.500	3.000	
	S-TLANR/L Boring & internal facing Insert : LNMX□□	Steel		✓				ø2.090"		ø3.350"	D100

Grade

Insert

Ext. Toolholder

Int. Toolholder

Threading

Grooving

Miniature Tool

Milling Cutter

Endmill

Drilling Tool

Tooling System

User's Guide

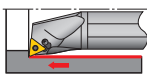
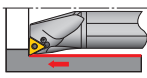
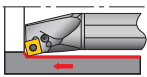
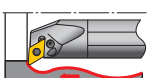
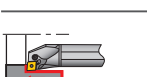
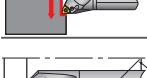
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Internal Toolholder - Quick Guide

Negative type

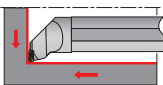
Metric

Lever lock

Style	Designation & Application	ISO Insert		Material	Toolholder		Min. bore diameter DMIN (mm)						Page
		Insert	ISO ETURN		STREAMJETBAR	TUNGJET	20	30	40	50	60	70	
	PTUNR/L Boring Insert : TN□□	✓	✓	Steel Reinforced	✓		ø20		ø40				D069 - D071
	PTFNR/L Boring Insert : TN□□	✓	✓	Steel	✓		ø32				ø63		D052 - D054
	PSKNR/L Through boring Insert : SN□□	✓		Steel	✓				ø40		ø63		D047
	PDUNR/L Boring & internal profiling Insert : DN□□	✓	✓	Steel Reinforced	✓	✓	ø25				ø63		D062 - D064
	PCLNR/L Boring & internal facing Insert : CN□□	✓	✓	Steel Reinforced	✓	✓	ø20				ø63		D028 - D030
	PWLNR/L Boring & internal facing Insert : WN□□	✓	✓	Steel	✓		ø20				ø50		D035 D037 D038
	PVUNR/L Boring & internal profiling Insert : V/YN□□	✓	✓	Steel	✓				ø37		ø50		D080 D081
	PDZNR/L Back boring Insert : DN□□	✓		Steel	✓				ø40		ø63		D095

Negative type
Metric

Screw-on

Style	Designation & Application	Material	TURNTEC	Min. bore diameter DMIN (mm)						Page
				Insert, Toolholder	40	50	60	70	80	
	S-TLANR/L Boring & internal facing Insert : LNMX□□	Steel	✓		ø53				ø85	D100

Grade

Insert

Toolholder

Ext. Toolholder

Int. Toolholder

Threading

Grooving

Miniature Tool

Milling Cutter

Endmill

Drilling Tool

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Unique anti-vibration mechanism in the tool body reduces vibration during deep hole boring with long overhangs of up to **L/D = 10**

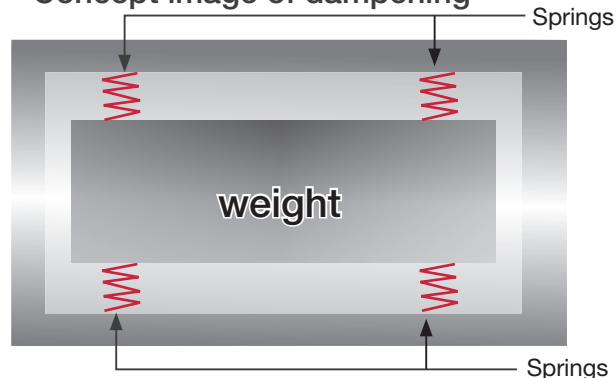
Vibration Dampening Mechanism

When cutting forces create vibration on boring bar set ups with long overhangs, the bar's dampening mechanism counters the tool's motion and cancels the vibration.

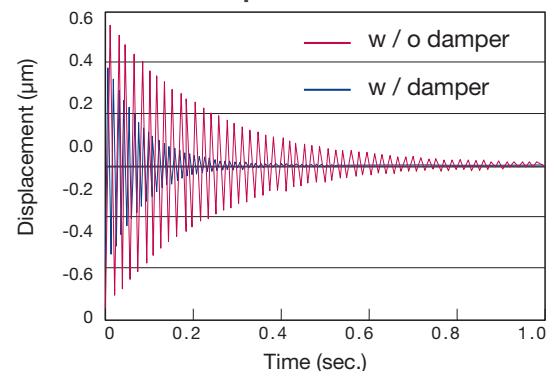
The dampening mechanism consists of a weight supported by spring elements.

The vibrations die out quickly eliminating noise and chatter marks.

- Concept image of dampening



- Tool vibrations with and without vibration damper



Standard Lineup

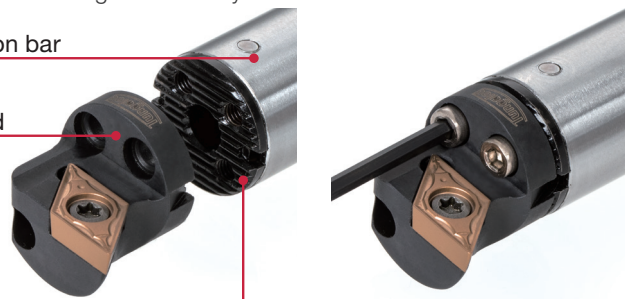
BoreMeister is comprised of the anti-vibration bar and interchangeable boring head, featuring serrated interfaces for high precision indexing. They are connected by screws, allowing the fitting of a wide range of cutting heads for great flexibility.

- Minimum bore diameter : $\varnothing 0.787''$

Anti-vibration bar

Boring head

Serration



Reference pages: **D020 - D021, D032 - D033, D056 - D057, D060 - D061, D074 - D075, D078 - D079**



Engineered for tool strength and optimal chip evacuation

■ Tool body of special alloy steel, designed to reduce chatter!



Chatter

Competitor



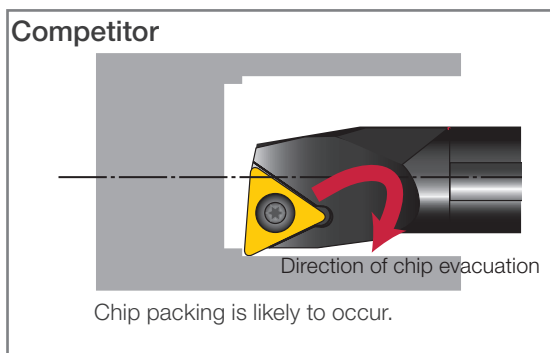
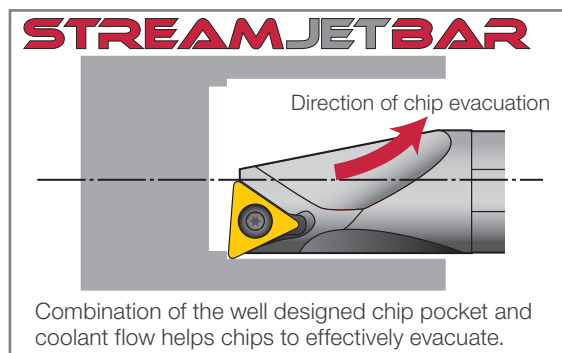
Excellent surface quality
with no chatter

STREAMJETBAR

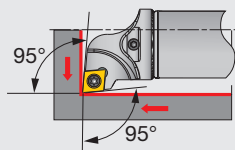
- Minimum bore diameter from $\varnothing 0.177"$ ($\varnothing 4.5$ mm)
- Steel and carbide shank available
- New pocket design for excellent chip evacuation

Cutting performance

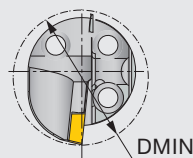
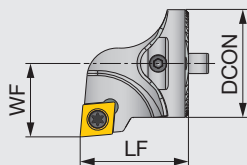
The excellent chip evacuation minimizes tool failure caused by recutting chips and poor chip control. Damage to the work surface from chips is also eliminated.



Reference pages: **D022 - D023, D025 - D026, D029, D037, D040, D043 - D045, D047, D049 - D050, D053, D058 - D059, D063, D066 - D067, D070, D072, D076, D081, D083, D085, D087 - D088, D090, D094 - D095, D097 - D099, D102**



Cutting edge style L



Right hand (R) shown.

Inch	DMIN	DCON	WF	LF	Shank size	Insert
S16-SCLCR/L06-H	0.787	0.630	0.433	0.787	D/G.625	CC**0602...
S20-SCLCR/L09-H	0.984	0.787	0.512	0.787	D/G.750	CC**09T3...
S25-SCLCR/L09-H	1.260	0.984	0.669	0.787	D1.00	CC**09T3...
S32-SCLCR/L09-H	1.575	1.260	0.866	1.260	D1.25	CC**09T3...
S40-SCLCR/L12T-H	1.968	1.575	1.063	1.496	D1.50, D2.00, D2.50	CC**1204...

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	Shim	Shim screw
S16-SCLCR/L06-H	SR14-548	T-7/5	-	-
S20-SCLCR/L09-H	SR16-236	T-15/5	-	-
S25-SCLCR/L09-H	SR16-236	T-15/5	-	-
S32-SCLCR/L09-H	SR16-236	T-15/5	-	-
S40-SCLCR/L12T-H	SR16-212	T-20/5	TCC4-2	SRTC-4

INSERT SELECTION

Application	Precision finishing	Finishing	Finishing to medium cutting	Medium cutting
Grade	NS9530	NS9530	T9215	T9215
Breaker Shape	01	PSS	PS	PM
Cutting conditions	B020			

Application	Finishing to medium cutting
Grade	T515
Breaker Shape	CM
Cutting conditions	B024

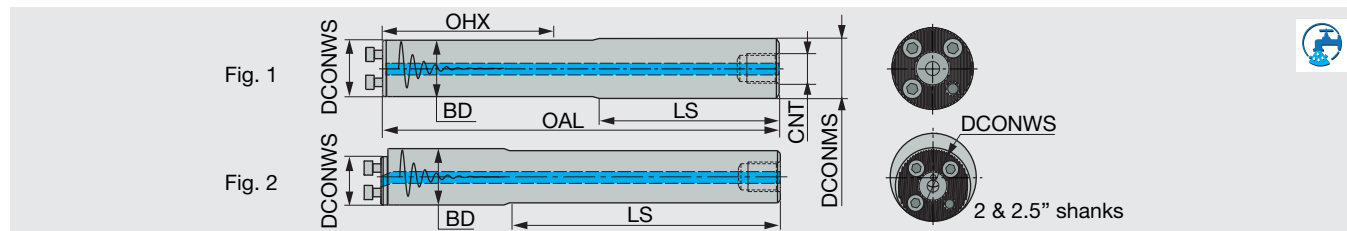
Application	Finishing	Finishing to medium cutting
Grade	AH8015	AH8015
Breaker Shape	PSS	PS
Cutting conditions	B028	

Application	Precision finishing	Finishing	Finishing to medium cutting	Medium cutting
Grade	GH330	AH725	AH630	T6130
Breaker Shape	W**	PSF	PSS	PM
Cutting conditions	B022			

Application	Precision finishing	Finishing	Medium cutting
Grade	DX120	DX140	KS05F
Breaker Shape	T-DIA	with rake T-DIA	AL
Cutting conditions	B026		

Application	Precision finishing	Finishing
Grade	BXM10	BXM20
Breaker Shape	T-CBN	T-CBN
Cutting conditions	B030	

Reference pages: S-SCLCR/L-H: Insert → B111 -, CBN → B182, PCD → B196 -

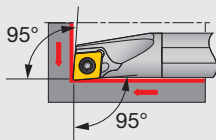


Inch	Material	DCONWS	DCONMS	BD	OAL	LS	OHX	CNT	Fig.
D.625-L6.14-7D-C	Steel	0.630	0.625	0.630	6.140	3.600	3.500	G1/8	1
G.625-L8.03-10D-E	Carbide	0.630	0.625	0.630	8.030	5.220	5.500	-	1
D.750-L7.87-7D-C	Steel	0.787	0.750	0.787	7.870	4.940	4.400	G1/4	1
G.750-L10.24-10D-E	Carbide	0.787	0.750	0.787	10.240	6.770	7.000	-	1
D1.00-L10.2-7D-C	Steel	0.984	1.000	0.984	10.200	6.830	6.200	G1/4	1
D1.00-L13.21-10D-C	Steel	0.984	1.000	0.984	13.210	8.650	9.200	G1/4	1
D1.25-L12.48-7D-C	Steel	1.260	1.250	1.260	12.480	7.370	7.500	G3/8	1
D1.25-L16.24-10D-C	Steel	1.260	1.250	1.260	16.240	9.670	11.200	G3/8	1
D1.50-L15.26-7D-C	Steel	1.575	1.500	1.575	15.260	9.130	9.200	G1/2	1
D1.50-L19.8-10D-C	Steel	1.575	1.500	1.575	19.800	13.350	13.700	G1/2	1
D2.00-L20.74-7D-C	Steel	1.575	2.000	2.000	20.740	-	12.700	G1/2	2
D2.00-L26.73-10D-C	Steel	1.575	2.000	2.000	26.730	-	18.700	G1/2	2
D2.50-L26.2-7D-C	Steel	1.575	2.500	2.500	26.200	-	16.200	G3/4	2
D2.50-L33.72-10D-C	Steel	1.575	2.500	2.500	33.720	-	23.700	G3/4	2

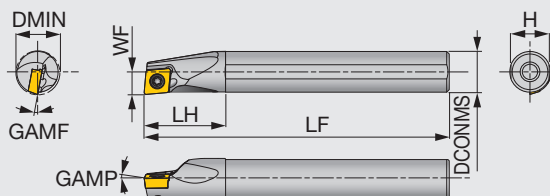
SPARE PARTS



Designation	Clamping screw	Wrench
D.625..., G.625...	SRM3X10DIN912	HW2.5
D.750..., G.750...	SRM3.5X10DIN912	HW2.5
D1.00...	SRM4X12DIN912	HW3.0
D1.25...	SRM5X12DIN912	HW4.0
D1.50..., D2.00... D2.50...	SRM6X16DIN912-12.9	HW5.0



Cutting edge style L



Right hand (R) shown.

Inch	Material	DMIN	DCONMS	WF	LF	LH	H	GAMP	GAMF	RE**	Insert	Torque
A06-SCLCR/L2-D08	Steel	0.500	0.375	0.281	5.000	0.750	0.350	0°	-9°	0.016	CC**21.5...	0.89
A08-SCLCR/L2-D11	Steel	0.687	0.500	0.406	5.000	1.000	0.475	0°	-6°	0.016	CC**21.5...	0.89
A10-SCLCR/L3-D14	Steel	0.875	0.625	0.531	7.000	1.250	0.600	0°	-7°	0.016	CC**32.5...	2.2
A12-SCLCR/L3-D16	Steel	1.000	0.750	0.594	7.000	1.438	0.725	0°	-5°	0.031	CC**32.5...	2.2
A16-SCLCR/L3-D20	Steel	1.250	1.000	0.687	7.000	1.750	0.975	0°	-4°	0.031	CC**32.5...	2.2
E06-SCLCR/L2-D08	Carbide	0.500	0.375	0.281	5.000	0.750	0.350	0°	-9°	0.016	CC**21.5...	0.89
E08-SCLCR/L2-D11	Carbide	0.688	0.500	0.406	5.000	1.000	0.475	0°	-6°	0.016	CC**21.5...	0.89
E10-SCLCR/L2-D14	Carbide	0.875	0.625	0.531	7.000	1.250	0.600	0°	-7°	0.016	CC**21.5...	0.89
E10-SCLCR/L3-D14	Carbide	0.875	0.625	0.531	7.000	1.250	0.600	0°	-7°	0.016	CC**32.5...	2.2
E12-SCLCR/L3-D16	Carbide	1.000	0.750	0.594	7.000	1.438	0.725	0°	-5°	0.031	CC**32.5...	2.2
E16-SCLCR/L3-D20	Carbide	1.250	1.000	0.687	10.000	1.750	0.975	0°	-4°	0.031	CC**32.5...	2.2

Torque: Recommended clamping torque: lbs-ft

**RE: Standard corner radius

Use right-hand toolholders (SCLCR**) with left-hand inserts (L); and left-hand toolholders (SCLCL**) with right-hand inserts (R).

SPARE PARTS

Designation	Clamping screw	Wrench
A**-SCLCR/L2-D...	CSTB-2.5S	T-8F
A**-SCLCR/L3-D...	CSTB-4S	T-15F
E06-SCLCR/L2-D08	CSTB-2.5S	T-8F
E**-SCLCR/L2-D...	CSTB-2.5B	T-8F
E**-SCLCR/L3-D...	CSTB-4S	T-15F

INSERT SELECTION

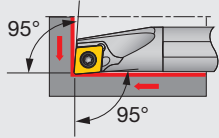
P	Application	Precision finishing	Finishing	Finishing to medium cutting	Medium cutting
	Grade	NS9530	NS9530	T9215	T9215
	Breaker Shape	01 	PSS 	PS 	PM 
	Cutting conditions	B020			
K	Application	Finishing to medium cutting			
	Grade	T515			
	Breaker Shape	CM 			
	Cutting conditions	B024			
S	Application	Finishing	Finishing to medium cutting		
	Grade	AH8015	AH8015		
	Breaker Shape	PSS 	PS 		
	Cutting conditions	B028			

M	Application	Precision finishing	Finishing	Finishing to medium cutting	Medium cutting
	Grade	GH330	AH725	AH630	T6130
	Breaker Shape	W** 	PSF 	PSS 	PM 
	Cutting conditions	B022			

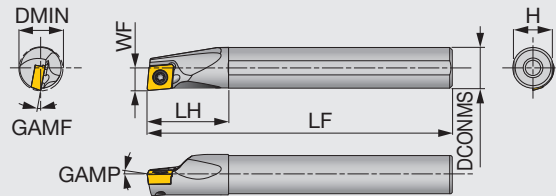
N	Application	Precision finishing	Finishing	Medium cutting
	Grade	DX120	DX140	KS05F
	Breaker Shape	T-DIA 	with rake T-DIA 	AL 
	Cutting conditions	B026		

H	Application	Precision finishing	Finishing
	Grade	BXM10	BXM20
	Breaker Shape	T-CBN 	T-CBN 
	Cutting conditions	B030	

Reference pages: A/E-SCLCR/L: Insert → **B111** -, CBN → **B182**, PCD → **B196** -



Cutting edge style L



Right hand (R) shown.

Metric	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
A08H-SCLCR/L06-D100	Steel	10	8	5.5	100	16	7.5	0°	-13°	0.4	CC**0602...	1.2
A10F-SCLCR06-D120	Steel	12	10	6	80	20	9	0°	-10°	0.4	CC**0602...	1.2
A10K-SCLCR/L06-D120	Steel	12	10	6	125	20	9	0°	-10°	0.4	CC**0602...	1.2
A12H-SCLCR06-D140	Steel	14	12	7	100	24	11	0°	-8°	0.4	CC**0602...	1.2
A12M-SCLCR/L06-D140	Steel	14	12	7	150	24	11	0°	-8°	0.4	CC**0602...	1.2
A12H-SCLCR06-D160	Steel	16	12	9	100	24	11	0°	-7°	0.4	CC**0602...	1.2
A12M-SCLCR/L06-D160	Steel	16	12	9	150	24	11	0°	-7°	0.4	CC**0602...	1.2
A16K-SCLCR09-D180	Steel	18	16	9	125	32	15	0°	-9°	0.8	CC**09T3...	3
A16Q-SCLCR/L09-D180	Steel	18	16	9	180	32	15	0°	-10°	0.8	CC**09T3...	3
A16K-SCLCR09-D200	Steel	20	16	11	125	32	15	0°	-9°	0.8	CC**09T3...	3
A16Q-SCLCR/L09-D200	Steel	20	16	11	180	32	15	0°	-9°	0.8	CC**09T3...	3
A20R-SCLCR/L09-D220	Steel	22	20	11	200	32	18	0°	-8°	0.8	CC**09T3...	3
A25S-SCLCR/L09-D270	Steel	27	25	13.5	250	45	23	0°	-6°	0.8	CC**09T3...	3
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
E08G-SCLCR06-D100	Carbide	10	8	5.5	90	22	7.5	0°	-13°	0.4	CC**0602...	1.2
E08K-SCLCR/L06-D100	Carbide	10	8	5.5	125	22	7.5	0°	-13°	0.4	CC**0602...	1.2
E10F-SCLCR06-D120	Carbide	12	10	6	80	25	9	0°	-10°	0.4	CC**0602...	1.2
E10H-SCLCR06-D120	Carbide	12	10	6	100	25	9	0°	-10°	0.4	CC**0602...	1.2
E10M-SCLCR/L06-D120	Carbide	12	10	6	150	25	9	0°	-10°	0.4	CC**0602...	1.2
E12G-SCLCR06-D140	Carbide	14	12	7	90	27	11	0°	-8°	0.4	CC**0602...	1.2
E12J-SCLCR06-D140	Carbide	14	12	7	110	27	11	0°	-8°	0.4	CC**0602...	1.2
E12Q-SCLCR/L06-D140	Carbide	14	12	7	180	27	11	0°	-8°	0.4	CC**0602...	1.2
E12G-SCLCR06-D160	Carbide	16	12	9	90	27	11	0°	-7°	0.4	CC**0602...	1.2
E12J-SCLCR06-D160	Carbide	16	12	9	110	27	11	0°	-7°	0.4	CC**0602...	1.2
E12Q-SCLCR/L06-D160	Carbide	16	12	9	180	27	11	0°	-7°	0.4	CC**0602...	1.2
E16H-SCLCR09-D180	Carbide	18	16	9	100	32	15	0°	-10°	0.8	CC**09T3...	3
E16L-SCLCR09-D180	Carbide	18	16	9	130	32	15	0°	-10°	0.8	CC**09T3...	3
E16R-SCLCR/L09-D180	Carbide	18	16	9	200	32	15	0°	-10°	0.8	CC**09T3...	3
E16H-SCLCR09-D200	Carbide	20	16	11	100	32	15	0°	-9°	0.8	CC**09T3...	3
E16L-SCLCR09-D200	Carbide	20	16	11	130	32	15	0°	-9°	0.8	CC**09T3...	3
E16R-SCLCR/L09-D200	Carbide	20	16	11	200	32	15	0°	-9°	0.8	CC**09T3...	3
E20S-SCLCR09-D220	Carbide	22	20	11	250	36	18	0°	-8°	0.8	CC**09T3...	3
E25T-SCLCR09-D270	Carbide	27	25	13.5	300	45	23	0°	-6°	0.8	CC**09T3...	3

Torque: Recommended clamping torque: N·m

**RE: Standard corner radius

Use right-hand toolholders (SCLCR**) with left-hand inserts (L); and left-hand toolholders (SCLCL**) with right-hand inserts (R).

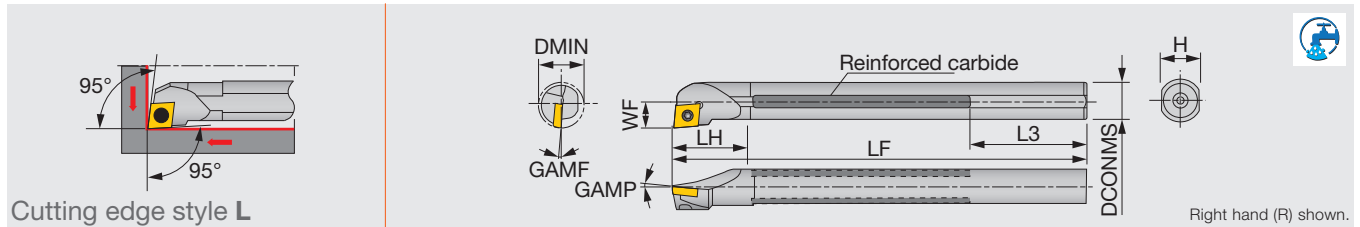
SPARE PARTS



Designation	Clamping screw	Wrench
A/E**-SCLCR/L03-D...	CSTA-1.6	T-6F
A/E**-SCLCR/L04-D...	CSTB-2	T-6F
A/E**-SCLCR/L06-D...	CSTB-2.5S	T-8F
E16*-SCLCR/L09-D...	CSTB-4L060	T-15F
A/E2**-SCLCR/L09-D...	CSTB-4S	T-15F

T-SCLCR/L

Screw-on boring bar, for positive 80° rhombic inserts (Tsuppari-Ichiban)



Metric	Material	DMIN	CNT	DCONMS	WF	LF	LH	L3	H	GAMF	GAMP	RE**	Insert	Torque
T12M-SCLCR/L06	Reinforced	16	—	12	9	150	22	59	11	-10°	0°	0.4	CC**0602...	1.2
T16Q-SCLCR/L09	Reinforced	20	—	16	11	180	27	59	15	-10°	0°	0.8	CC**09T3...	3
T20R-SCLCR/L09C	Reinforced	25	Rc1/4	20	13	200	35	49	18	-8°	0°	0.8	CC**09T3...	3
T25S-SCLCR/L09C	Reinforced	32	Rc1/4	25	17	250	40	64	23	-6°	0°	0.8	CC**09T3...	3

Torque: Recommended clamping torque: N·m

**RE: Standard corner radius

The hole specification of applicable inserts conforms to ISO standard.

Use right-hand toolholders (SCLCR**) with left-hand inserts (L); and left-hand toolholders (SCLCL**) with right-hand inserts (R).

SPARE PARTS

Designation	Clamping screw	Wrench
T12M-SCLCR/L06	CSTB-2.5	T-8F
T16Q-SCLCR/L09	CSTB-4S	T-15F
T20R-SCLCR/L09C	CSTB-4S	T-15F
T25S-SCLCR/L09C	CSTB-4S	T-15F

INSERT SELECTION

P	Application	Precision finishing	Finishing	Finishing to medium cutting	Medium cutting
	Grade	SH725	SH725	T9215	T9215
	Breaker Shape	01	JS	PS	PM
	Cutting conditions	B020			

K	Application	Finishing to medium cutting
	Grade	T515
	Breaker Shape	CM
	Cutting conditions	B024

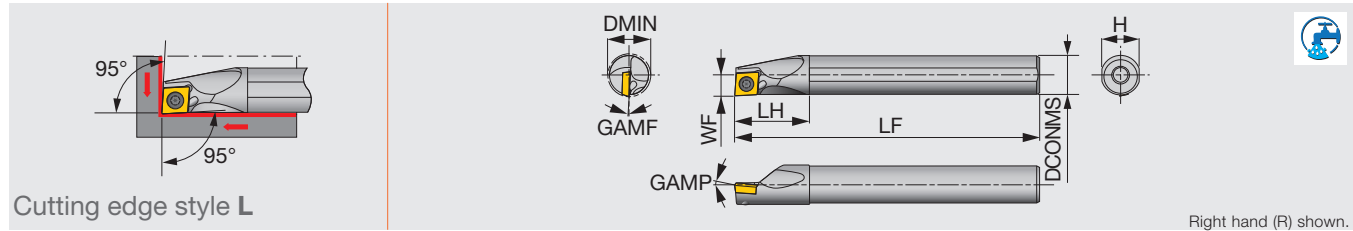
S	Application	Precision finishing	Finishing to medium cutting
	Grade	BX470	AH8005
	Breaker Shape	T-CBN	PS
	Cutting conditions	B028	

M	Application	Precision finishing	Finishing	Finishing to medium cutting	Medium cutting
	Grade	SH725	SH725	T9215	T9215
	Breaker Shape	01	JS	PS	PM
	Cutting conditions	B022			

N	Application	Precision finishing	Finishing	Medium cutting
	Grade	DX120	TH10	KS05F
	Breaker Shape	T-DIA with rake W20	AL	
	Cutting conditions	B026		

H	Application	Precision finishing	Finishing
	Grade	BXM10	BXM20
	Breaker Shape	T-CBN	T-CBN
	Cutting conditions	B030	

Reference pages: T-SCLCR/L: Insert → **B111** -, CBN → **B182**, PCD → **B196** -



Inch	Material	DMIN	DCONMS	WF	LF	LH	H	GAMP	GAMF	RE**	Insert	Torque
A06-SCLPR/L2-D08	Steel	0.500	0.375	0.281	5.000	0.750	0.350	5°	-5°	0.016	CP**21.5...	0.89
A08-SCLPR/L2-D11	Steel	0.687	0.500	0.406	5.000	1.000	0.475	5°	-2°	0.016	CP**21.5...	0.89
A10-SCLPR/L3-D14	Steel	0.875	0.625	0.531	7.000	1.250	0.600	5°	-2°	0.016	CP**32.5...	2.21
E06-SCLPR/L2-D08	Carbide	0.500	0.375	0.281	5.000	0.750	0.350	0°	-9°	0.016	CP**21.5...	0.89
E08-SCLPR/L2-D11	Carbide	0.688	0.500	0.406	5.000	1.000	0.475	0°	-6°	0.016	CP**21.5...	0.89
E10-SCLPR/L3-D14	Carbide	0.875	0.625	0.531	7.000	1.250	0.600	0°	-7°	0.032	CP**32.5...	2.21

Torque: Recommended clamping torque: lbs-ft

**RE: Standard corner radius

When using a right or left hand insert, the right hand insert (R) is used for the left hand toolholders (SCLPL** type), and the left hand insert (L) is used for the right hand toolholders (SCLPR** type).

SPARE PARTS

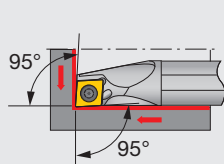
Designation	Clamping screw	Wrench
A06-SCLPR/L2-D08	CSTB-2.5L042	T-8F
A08-SCLPR/L2-D11	CSTB-2.5S	T-8F
A10-SCLPR/L3-D14	CSTB-4L070	T-15F
E06-SCLPR/L2-D08	CSTB-2.5S	T-8F
E08-SCLPR/L2-D11	CSTB-2.5B	T-8F
E10-SCLPR/L3-D14	CSTB-4S	T-15F

INSERT SELECTION

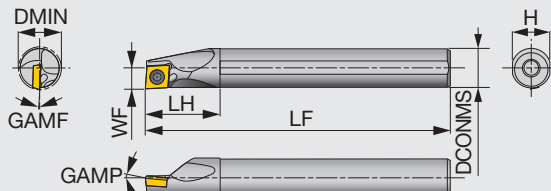
P	Application	Finishing to medium cutting	Medium cutting
	Grade	T9215	T9215
	Breaker Shape	PS	PM
	Cutting conditions	B020	

M	Application	Finishing to medium cutting	Medium cutting
	Grade	T9215	T9215
	Breaker Shape	PS	PM
	Cutting conditions	B022	

K	Application	Finishing to medium cutting
	Grade	T515
	Breaker Shape	CM
	Cutting conditions	B024



Cutting edge style L



Right hand (R) shown.

Metric	Material	DMIN	DCONMS	WF	LF	LH	H	GAMP	GAMF	RE**	Insert	Torque
A08H-SCLPR/L06-D100	Steel	10	8	5.5	100	16	7.5	5°	-8°	0.4	CP**0602...	1.2
A10K-SCLPR/L06-D120	Steel	12	10	6	125	20	9	5°	-5°	0.4	CP**0602...	1.2
A10K-SCLPR/L08-D120	Steel	12	10	6	125	20	9	5°	-5°	0.4	CP**0802...	1.4
A12M-SCLPR/L06-D140	Steel	14	12	7	150	24	11	5°	-4°	0.4	CP**0602...	1.2
A12M-SCLPR/L08-D140	Steel	14	12	7	150	24	11	5°	-4°	0.4	CP**0802...	1.4
A12M-SCLPR/L08-D160	Steel	16	12	9	150	24	11	5°	-3°	0.4	CP**0802...	1.4
A16Q-SCLPR/L09-D180	Steel	18	16	9	180	32	15	5°	-3.5°	0.8	CP**0903...	3
A16Q-SCLPR/L09-D200	Steel	20	16	11	180	32	15	5°	-3°	0.8	CP**0903...	3
A20R-SCLPR/L09-D220	Steel	22	20	11	200	36	18	5°	-2°	0.8	CP**0903...	3
A25S-SCLPR/L09-D270	Steel	27	25	13.5	250	45	23	5°	-1°	0.8	CP**0903...	3
E08K-SCLPR/L06-D100	Carbide	10	8	5.5	125	22	7.5	5°	-8°	0.4	CP**0602...	1.2
E10M-SCLPR/L06-D120	Carbide	12	10	6	150	25	9	5°	-5°	0.4	CP**0602...	1.2
E10H-SCLPR08-D120	Carbide	12	10	6	100	25	9	5°	-5°	0.4	CP**0802...	1.4
E10M-SCLPR/L08-D120	Carbide	12	10	6	150	25	9	5°	-5°	0.4	CP**0802...	1.4
E12Q-SCLPR/L06-D140	Carbide	14	12	7	180	27	11	5°	-4°	0.4	CP**0602...	1.2
E12G-SCLPR08-D140	Carbide	14	12	7	90	27	11	5°	-4°	0.4	CP**0802...	1.4
E12J-SCLPR08-D140	Carbide	14	12	7	110	27	11	5°	-4°	0.4	CP**0802...	1.4
E12Q-SCLPR/L08-D140	Carbide	14	12	7	180	27	11	5°	-4°	0.4	CP**0802...	1.4
E12G-SCLPR08-D160	Carbide	16	12	9	90	27	11	5°	-3°	0.4	CP**0802...	1.4
E12J-SCLPR08-D160	Carbide	16	12	9	110	27	11	5°	-3°	0.4	CP**0802...	1.4
E12Q-SCLPR/L08-D160	Carbide	16	12	9	180	27	11	5°	-3°	0.4	CP**0802...	1.4
E16H-SCLPR09-D180	Carbide	18	16	9	100	32	15	5°	-3.5°	0.8	CP**0903...	3
E16L-SCLPR09-D180	Carbide	18	16	9	130	32	15	5°	-3.5°	0.8	CP**0903...	3
E16R-SCLPL09-D180	Carbide	18	16	9	200	32	15	5°	-3.5°	0.8	CP**0903...	3
E16H-SCLPR09-D200	Carbide	20	16	11	100	32	15	5°	-3°	0.8	CP**0903...	3
E16L-SCLPR09-D200	Carbide	20	16	11	130	32	15	5°	-3°	0.8	CP**0903...	3
E16R-SCLPL09-D200	Carbide	20	16	11	200	32	15	5°	-3°	0.8	CP**0903...	3

Torque: Recommended clamping torque: N·m

**RE: Standard corner radius

Use right-hand toolholders (SCLPR**) with left-hand inserts (L); and left-hand toolholders (SCLPL**) with right-hand inserts (R).

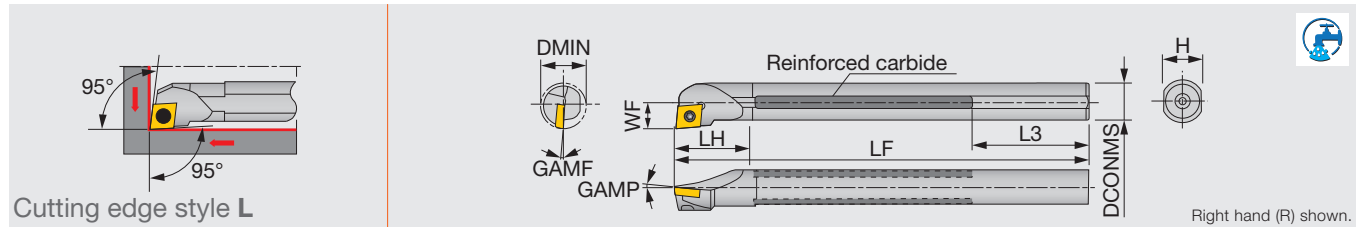
SPARE PARTS



Designation	Clamping screw	Wrench
A**-SCLPR/L06-D...	CSTB-2.5S	T-8F
A10K-SCLPR/L08-D120	CSTB-3L042	T-9F
A12M-SCLPR/L08-D...	CSTB-3L050	T-9F
A**-SCLPR/L09-D...	CSTB-4L060	T-15F
E**-SCLPR/L06-D...	CSTB-2.5S	T-8F
E10*-SCLPR/L08-D...	CSTB-3L042	T-9F
E12*-SCLPR/L08-D...	CSTB-3L050	T-9F
E16*-SCLPR/L09-D...	CSTB-4L060	T-15F

T-SCLPR/L

Screw-on boring bar, for positive 80° rhombic inserts (Tsuppari-Ichiban)



Metric	Material	DMIN	CNT	DCONMS	WF	LF	LH	L3	H	GAMF	GAMP	RE**	Insert	Torque
T12M-SCLPR08-D14	Reinforced	14	-	12	7	150	22	59	11	-4°	5°	0.4	CP**0802...	1.4
T12M-SCLPR/L08	Reinforced	16	-	12	9	150	25	59	11	-3°	5°	0.4	CP**0802...	1.4
T16Q-SCLPR09-D18	Reinforced	18	-	16	9	180	27	59	15	-3.5°	5°	0.8	CP**0903...	3
T16Q-SCLPR/L09	Reinforced	20	-	16	11	180	30	59	15	-4°	5°	0.8	CP**0903...	3
T20R-SCLPR09C-D22	Reinforced	22	Rc1/4	20	11	200	35	49	18	-2°	5°	0.8	CP**0903...	3
T20R-SCLPR/L09	Reinforced	25	-	20	13	200	35	49	18	-2°	5°	0.8	CP**0903...	3
T25S-SCLPR09C-D27	Reinforced	27	Rc1/4	25	13.5	250	40	64	23	-1°	5°	0.8	CP**0903...	3
T25S-SCLPR/L09	Reinforced	32	-	25	17	250	40	64	23	0°	5°	0.8	CP**0903...	3

Torque: Recommended clamping torque: N·m

**RE: Standard corner radius

Use right-hand toolholders (SCLPR**) with left-hand inserts (L); and left-hand toolholders (SCLPL**) with right-hand inserts (R).

SPARE PARTS

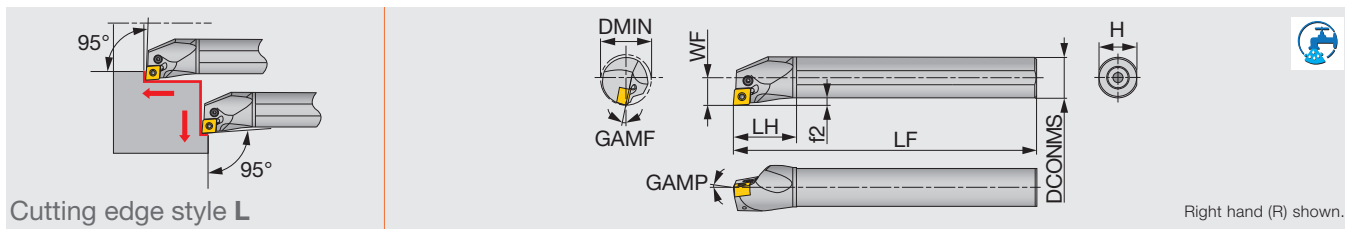
Designation	Clamping screw	Wrench
T12M-SCLPR/L08...	CSTB-3L050	T-9F
T16Q-SCLPR09-D18	CSTB-4L060	T-15F
T16Q-SCLPR/L09	CSTB-4S	T-15F
T20R-SCLPR09C-D22	CSTB-4L060	T-15F
T20R-SCLPR/L09	CSTB-4S	T-15F
T25S-SCLPR09C-D27	CSTB-4L060	T-15F
T25S-SCLPR/L09	CSTB-4S	T-15F

INSERT SELECTION

P	Application	Finishing	Finishing to medium cutting	Medium cutting	M	Application	Finishing	Finishing to medium cutting	Medium cutting
	Grade	NS9530	T9215	T9215		Grade	AH725	AH630	T6130
	Breaker Shape	PSS	PS	PM		Breaker Shape	PSF	PSS	PM
	Cutting conditions	B020				Cutting conditions	B022		
K	Application	Finishing to medium cutting			N	Application	Finishing		
	Grade	T515				Grade	DX140		
	Breaker Shape	CM				Breaker Shape	T-DIA		
	Cutting conditions	B024				Cutting conditions	B026		
S	Application	Finishing	Finishing to medium cutting						
	Grade	AH8015	AH8015						
	Breaker Shape	PSS	PS						
	Cutting conditions	B028							

Reference pages: T-SCLPR/L: Insert → **B118** -

Lever-lock boring bar, for negative 80° rhombic inserts



Metric	Material	DMIN	DCONMS	WF	LF	LH	H	f2	GAMP	GAMF	RE**	Insert	Torque
A16M-PCLNR/L0904-D200	Steel	20	16	11	150	32	15	3	-6°	-16°	0.8	CN**0904...	1.7
A20Q-PCLNR/L0904-D250	Steel	25	20	13	180	36	18	3	-6°	-12°	0.8	CN**0904...	1.7

Torque: Recommended clamping torque: N·m

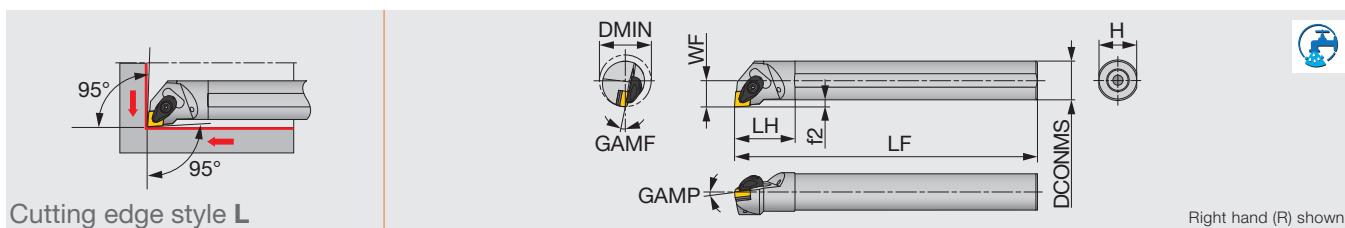
**RE: Standard corner radius

SPARE PARTS

Designation	Clamping screw	Wrench	Lever	Oil supply attachment*	Screw for oil hole*
A16M-PCLNR/L0904-D200	LCS33	P-2F	LCL33N	-	SSHM3-4
A20Q-PCLNR/L0904-D250	LCS33	P-2F	LCL33N	EA-20	SSHM3-4

*Optional

Double-clamp boring bar, for negative 80° rhombic inserts



Inch	Material	DMIN	DCONMS	WF	LF	LH	H	f2	GAMP	GAMF	RE**	Insert	Torque
A16-ACLNR/L33-D20	Steel	1.250	1.000	0.672	12.000	1.750	0.906	0.172	-6°	-13°	0.031	CN**33...	2.21
A20-ACLNR/L33-D25	Steel	1.560	1.250	0.859	14.000	1.938	1.188	0.234	-6°	-10°	0.031	CN**33...	2.21

Torque: Recommended clamping torque: lbs·ft

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

SPARE PARTS

Designation	Clamp	Clamp screw	Spring	Spring pin	Shim	Shim screw	Wrench
A**-ACLNR/L33...	ACP3S-E	ACS-5W	BP-7	SP-2.5	ASC322	CSTB-3.5	T-15F

INSERT SELECTION

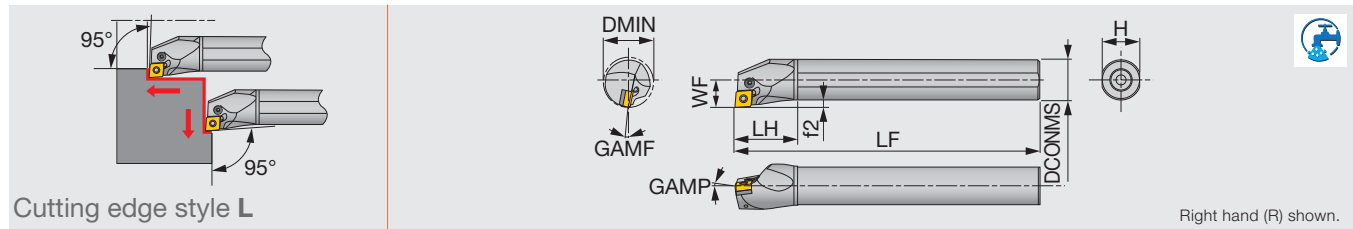
P	Application	Finishing	Medium cutting
	Grade	T9215	T9215
	Breaker Shape	TSF	TM
	Cutting conditions	B020	

K	Application	Medium cutting
	Grade	T515
	Breaker Shape	TM
	Cutting conditions	B024

M	Application	Finishing	Medium cutting
	Grade	T6120	T6130
	Breaker Shape	SS	SM
	Cutting conditions	B022	

S	Application	Medium cutting
	Grade	AH8015
	Breaker Shape	TM
	Cutting conditions	B028

Reference pages: A-PCLNR/L-Eco, A-ACLNR/L-Eco: Insert → **B056** -



Metric	Material	DMIN	DCONMS	WF	LF	LH	H	f2	GAMP	GAMF	RE**	Insert	Torque
A16M-PCLNR/L09-D200	Steel	20	16	11	150	32	15	3	-6°	-14°	0.8	CN**0903...	1.7
A20Q-PCLNR/L09-D250	Steel	25	20	13	180	36	18	3	-6°	-12°	0.8	CN**0903...	1.7
A25R-PCLNR/L09-D320	Steel	32	25	17	200	45	23	4.5	-6°	-11°	0.8	CN**0903...	1.7
A25R-PCLNR/L12-D320	Steel	32	25	17	200	45	23	4.5	-6°	-13°	0.8	CN**1204...	2.7
A32S-PCLNR/L12-D400	Steel	40	32	22	250	50	30	6	-6°	-11°	0.8	CN**1204...	4.8
A40T-PCLNR/L12-D500	Steel	50	40	27	300	60	37	7	-6°	-10°	0.8	CN**1204...	4.8
A50U-PCLNR/L12-D630	Steel	63	50	35	350	65	47	10	-6°	-8°	0.8	CN**1204...	4.8

Torque: Recommended clamping torque: N·m

**RE: Standard corner radius

Use right-hand toolholders (PCLNR**) with left-hand inserts (L); and left-hand toolholders (PCLNR**) with right-hand inserts (R).

SPARE PARTS

Designation	Shim	Clamping screw 1	Clamping screw 2	Wrench 1	Wrench 2	Spring pin	Lever	Oil supply attachment*	Screw for oil hole*
A**-PCLNR/L09-D**0	-	LCS22A	-	P-2F	-	-	LCL32N	EA-25	SSHM5-6
A25R-PCLNR/L12-D320	-	LCS43	-	-	P-2.5	-	LCL43N	EA-32	SSHM5-6
A32S-PCLNR/L12-D400	LSC42BR/L	-	LCS4	-	P-3	LSP4	LCL4	EA-32	SSHM5-6
A40T-PCLNR/L12-D500	LSC42BR/L	-	LCS4	-	P-3	LSP4	LCL4	-	SSHM6-6
A50U-PCLNR/L12-D630	LSC42BR/L	-	LCS4	-	P-3	LSP4	LCL4	-	SSHM6-6

*Optional

INSERT SELECTION

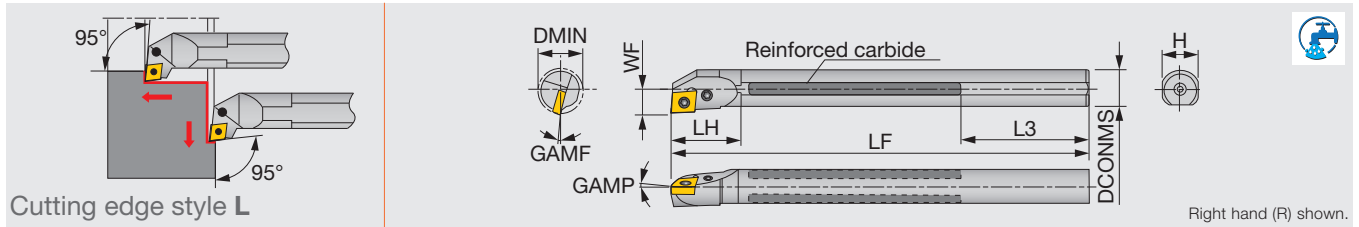
P	Application	Precision finishing	Finishing	Medium cutting	Medium to heavy cutting
	Grade	NS9530	GT9530	T9215	T9215
	Breaker Shape	TF	TSF	TM	TH
	Cutting conditions	B008			
K	Application	Finishing	Medium cutting	Medium to heavy cutting	
	Grade	T515	T515	T515	
	Breaker Shape	All-round	All-round	All-round	
	Cutting conditions	B012			
S	Application	Precision finishing	Finishing	Medium cutting	
	Grade	BX470	AH8005	AH8005	
	Breaker Shape	T-CBN	HRF	HRM	
	Cutting conditions	B016			

M	Application	Finishing	Medium cutting	Medium to heavy cutting
	Grade	T6120	T6130	T6130
	Breaker Shape	SF	SM	SH
	Cutting conditions	B010		
N	Application	Precision finishing	Finishing	Medium cutting
	Grade	DX120	DX140	TH10
	Breaker Shape	T-DIA	with rake T-DIA	P
	Cutting conditions	B014		
H	Application	Precision finishing	Finishing	
	Grade	BXM10	BXM20	
	Breaker Shape	T-CBN	T-CBN	
	Cutting conditions	B018		

Reference pages: A-PCLNR/L: Insert → **B056** -, CBN → **B172** -, PCD → **B194** -

T-PCLNR

Lever-lock boring bar, for negative 80° rhombic inserts (Tsuppari-Ichiban)



Metric	Material	DMIN	CNT	DCONMS	WF	LF	LH	L3	H	GAMP	GAMF	RE**	Insert	Torque
T16Q-PCLNR09	Reinforced	20	-	16	11	180	27	59	15	-6°	-14°	0.8	CN**0903...	1.7
T20R-PCLNR09C	Reinforced	25	Rc1/4	20	13	200	35	49	18	-6°	-12°	0.8	CN**0903...	1.7
T25S-PCLNR09C	Reinforced	32	Rc1/4	25	17	250	40	64	23	-6°	-11°	0.8	CN**0903...	1.7
T32U-PCLNR12C	Reinforced	40	Rc1/2	32	22	350	50	103	30	-6°	-11°	0.8	CN**1204...	4.8
T40V-PCLNR12C	Reinforced	50	Rc1/2	40	27	400	55	88	37	-6°	-10°	0.8	CN**1204...	4.8
T50W-PCLNR12C	Reinforced	63	Rc1/2	50	35	450	65	63	47	-6°	-8°	0.8	CN**1204...	4.8

Torque: Recommended clamping torque: N·m

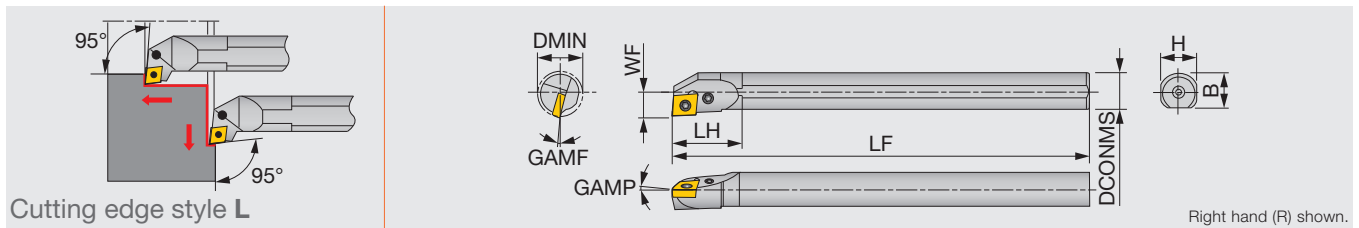
**RE: Standard corner radius

Use right-hand toolholders (R) with left-hand inserts (L); and left-hand toolholders (L) with right-hand inserts (R).

SPARE PARTS	Shim	Clamping screw 1	Clamping screw 2	Wrench 1	Wrench 2	Spring pin	Lever
Designation	Shim	Clamping screw 1	Clamping screw 2	Wrench 1	Wrench 2	Spring pin	Lever
T**-PCLNR09...	-	LCS22A	-	P-2F	-	-	LCL32N
T**-PCLNR12C	LSC42BR	-	LCS4	-	P-3	LSP4	LCL4

S-PCLNR/L

Lever-lock boring bar, for negative 80° rhombic inserts



Metric	Material	DMIN	DCONMS	WF	LF	LH	H	B	GAMP	GAMF	RE**	Insert	Torque
S16M-PCLNR/L09	Steel	20	16	11	150	30	15	15.5	-6°	-14°	0.8	CN**0903...	1.7
S20Q-PCLNR/L09	Steel	25	20	13	180	35	18	19	-6°	-12°	0.8	CN**0903...	1.7
S25R-PCLNR/L09	Steel	32	25	17	200	40	23	24	-6°	-11°	0.8	CN**0903...	1.7
S32S-PCLNR/L12	Steel	40	32	22	250	50	30	29.5	-6°	-11°	0.8	CN**1204...	4.8
S40T-PCLNR/L12	Steel	50	40	27	300	55	37	37.5	-6°	-10°	0.8	CN**1204...	4.8
S50U-PCLNR/L12	Steel	63	50	35	350	65	47	47.5	-6°	-8°	0.8	CN**1204...	4.8

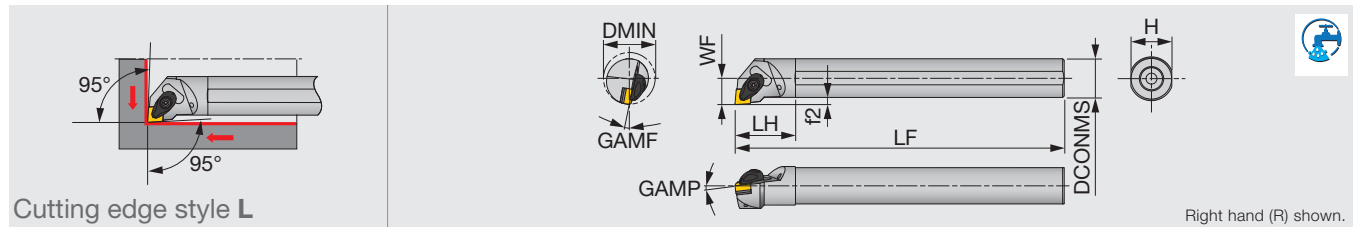
Torque: Recommended clamping torque: N·m

**RE: Standard corner radius

Use right-hand toolholders (R) with left-hand inserts (L); and left-hand toolholders (L) with right-hand inserts (R).

SPARE PARTS	Shim	Clamping screw 1	Clamping screw 2	Wrench 1	Wrench 2	Spring pin	Lever
Designation	Shim	Clamping screw 1	Clamping screw 2	Wrench 1	Wrench 2	Spring pin	Lever
S**-PCLNR/L09	-	LCS22A	-	P-2F	-	-	LCL32N
S**-PCLNR/L12	LSC42BR/L	-	LCS4	-	P-3	LSP4	LCL4

Reference pages: T-PCLNR, S-PCLNR/L: Insert → **B056 -**, CBN → **B172 -**, PCD → **B194 -**



Cutting edge style L

Right hand (R) shown.

Inch	Material	DMIN	DCONMS	WF	LF	LH	H	f2	GAMP	GAMF	RE**	Insert	Torque
A16-ACLNR/L4-D20	Steel	1.250	1.000	0.640	12.000	1.750	0.906	0.177	-6°	-13°	0.031	CN**43...	2.21
A20-ACLNR/L4-D25	Steel	1.560	1.250	0.770	14.000	1.930	1.180	0.236	-6°	-10°	0.031	CN**43...	2.21
A24-ACLNR/L4-D32	Steel	2.000	1.500	0.890	14.000	2.160	1.450	0.275	-6°	-8°	0.031	CN**43...	2.21
A32-ACLNR/L4-D40	Steel	2.500	2.000	1.280	16.000	2.550	1.850	0.393	-6°	-7°	0.031	CN**43...	2.21

Torque: Recommended clamping torque: lbs-ft

**RE: Standard corner radius

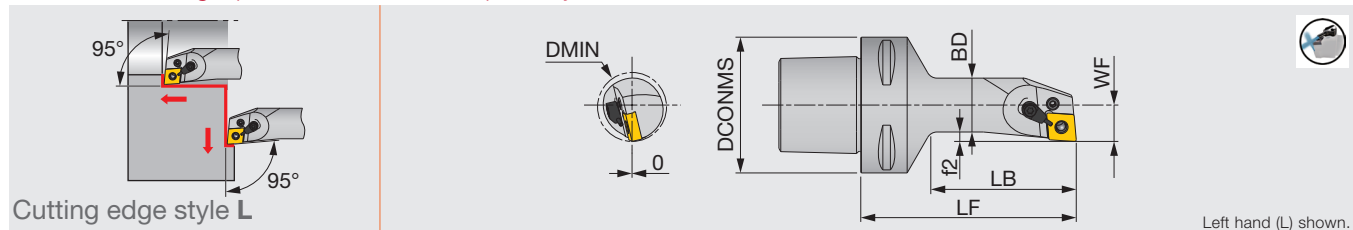
SPARE PARTS

Designation	Clamp	Clamp screw	Spring	Spring pin	Shim	Shim screw	Wrench
A**-ACLNR/L4-D...	ACP4S	ACS-5W	BP-7	SP-2.5	ASC422	CSTB-3.5	T-15F

TUNG T^{URN}JET

C-PCLNL-CHP

Lever-lock boring bar with TungCap connection, with 95° approach angle, for negative 80° rhombic inserts, with high pressure coolant capability



Cutting edge style L

Left hand (L) shown.

Metric	DMIN	DCONMS	BD	LF	LB	WF	f2	RE**	Insert
C6PCLNL17100-12-CHP	32	63	25	100	67.5	17	4.5	0.8	CN**1204...

Applicable for 14 MPa coolant

**RE: Standard corner radius

SPARE PARTS

Designation	Clamping screw	Coolant unit	Wrench	Lever
C6PCLNL17100-12-CHP	LCS43	S-CU-CHP	P-2.5F	LCL43N

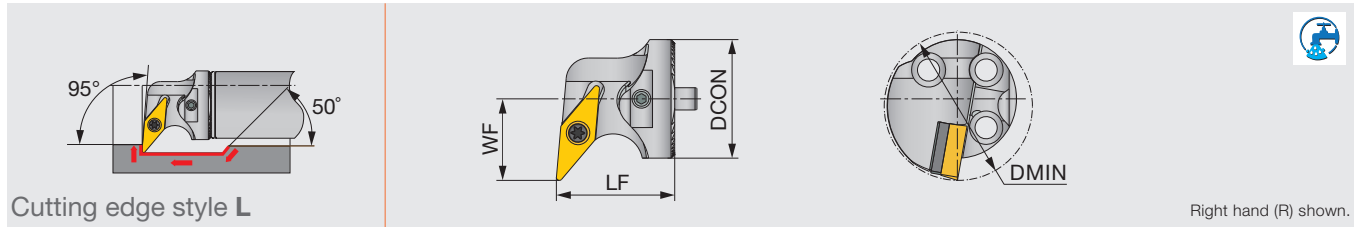
INSERT SELECTION

P	Application	Precision finishing	Finishing	Medium cutting	Medium to heavy cutting
	Grade	NS9530	GT9530	T9215	T9215
	Breaker Shape	TF	TSF	TM	TH
	Cutting conditions	B008			
K	Application	Finishing	Medium cutting	Medium to heavy cutting	
	Grade	T515	T515	T515	
	Breaker Shape	All-round	All-round	All-round	
	Cutting conditions	B012			
S	Application	Precision finishing	Finishing	Medium cutting	
	Grade	BX470	AH8005	AH8005	
	Breaker Shape	T-CBN	HRF	HRM	
	Cutting conditions	B016			

M	Application	Finishing	Medium cutting	Medium to heavy cutting
	Grade	T6120	T6130	T6130
	Breaker Shape	SF	SM	SH
	Cutting conditions	B010		
N	Application	Precision finishing	Finishing	Medium cutting
	Grade	DX120	DX140	TH10
	Breaker Shape	T-DIA	with rake T-DIA	P
	Cutting conditions	B014		
H	Application	Precision finishing	Finishing	
	Grade	BXM10	BXM20	
	Breaker Shape	T-CBN	T-CBN	
	Cutting conditions	B018		

Reference pages: A-ACLNR/L, C-PCLNL-CHP: Insert → **B056** -, CBN → **B172** -, PCD → **B194** -

Screw-on exchangeable boring head, for positive 35° rhombic inserts



Inch	DMIN	DCON	WF	LF	Shank size	Insert
S32-SVLCR/L16T-H	1.575	1.260	0.866	1.260	D1.25	VC**1604...
S40-SVLCR/L16T-H	1.968	1.575	1.063	1.260	D1.50, D2.00, D2.50	VC**1604...

When using a right or left hand insert, the right hand insert (R) is used for the left hand toolholders (SVLCL** type), and the left hand insert (L) is used for the right hand toolholders (SVLCR** type).

SPARE PARTS

Designation	Clamping screw	Wrench	Shim	Shim screw
S**-SVLCR/L16T-H	SR16-236P	T-15/5	TVC 3-1P	SRTC-3P

INSERT SELECTION

P

Application	Finishing	Finishing to medium cutting
Grade	NS9530	T9215
Breaker Shape		
Cutting conditions	B020	

K

Application	Finishing to medium cutting
Grade	T515
Breaker Shape	
Cutting conditions	B024

S

Application	Finishing	Finishing to medium cutting
Grade	AH8015	AH8015
Breaker Shape		
Cutting conditions	B028	

M

Application	Finishing	Finishing to medium cutting	Medium cutting
Grade	AH725	AH630	T6130
Breaker Shape			
Cutting conditions	B022		

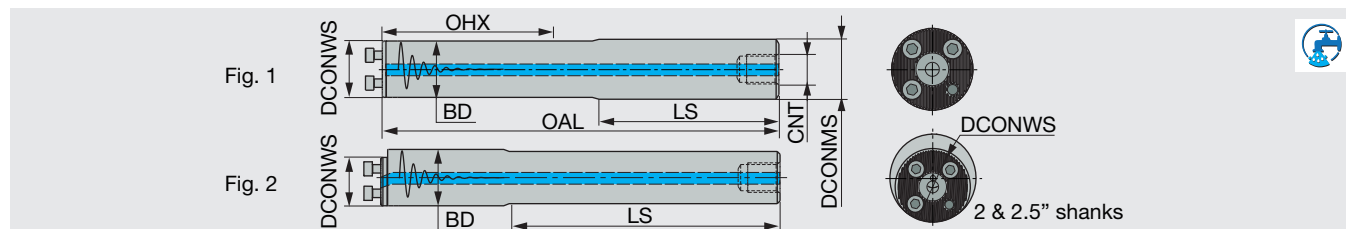
N

Application	Precision finishing	Finishing	Medium cutting
Grade	DX120	DX140	KS05F
Breaker Shape			
Cutting conditions	B026		

H

Application	Precision finishing	Finishing
Grade	BXM10	BXM20
Breaker Shape		
Cutting conditions	B030	

Reference pages: S-SVLCR/L-H: Insert → **B155** -, CBN → **B192**, PCD → **B196** -

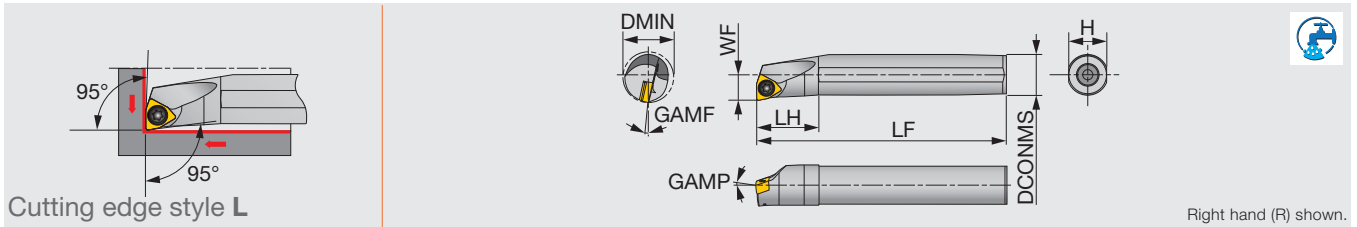


Inch	Material	DCONWS	DCONMS	BD	OAL	LS	OHX	CNT	Fig.
D.625-L6.14-7D-C	Steel	0.630	0.625	0.630	6.140	3.600	3.500	G1/8	1
G.625-L8.03-10D-E	Carbide	0.630	0.625	0.630	8.030	5.220	5.500	-	1
D.750-L7.87-7D-C	Steel	0.787	0.750	0.787	7.870	4.940	4.400	G1/4	1
G.750-L10.24-10D-E	Carbide	0.787	0.750	0.787	10.240	6.770	7.000	-	1
D1.00-L10.2-7D-C	Steel	0.984	1.000	0.984	10.200	6.830	6.200	G1/4	1
D1.00-L13.21-10D-C	Steel	0.984	1.000	0.984	13.210	8.650	9.200	G1/4	1
D1.25-L12.48-7D-C	Steel	1.260	1.250	1.260	12.480	7.370	7.500	G3/8	1
D1.25-L16.24-10D-C	Steel	1.260	1.250	1.260	16.240	9.670	11.200	G3/8	1
D1.50-L15.26-7D-C	Steel	1.575	1.500	1.575	15.260	9.130	9.200	G1/2	1
D1.50-L19.8-10D-C	Steel	1.575	1.500	1.575	19.800	13.350	13.700	G1/2	1
D2.00-L20.74-7D-C	Steel	1.575	2.000	2.000	20.740	-	12.700	G1/2	2
D2.00-L26.73-10D-C	Steel	1.575	2.000	2.000	26.730	-	18.700	G1/2	2
D2.50-L26.2-7D-C	Steel	1.575	2.500	2.500	26.200	-	16.200	G3/4	2
D2.50-L33.72-10D-C	Steel	1.575	2.500	2.500	33.720	-	23.700	G3/4	2

SPARE PARTS



Designation	Clamping screw	Wrench
D.625..., G.625...	SRM3X10DIN912	HW2.5
D.750..., G.750...	SRM3.5X10DIN912	HW2.5
D1.00...	SRM4X12DIN912	HW3.0
D1.25...	SRM5X12DIN912	HW4.0
D1.50..., D2.00... D2.50...	SRM6X16DIN912-12.9	HW5.0



Inch	Material	DMIN	DCONMS	WF	LF	LH	H	GAMP	GAMF	RE**	Insert	Torque
A06-SWLXR/L2-D08	Steel	0.500	0.375	0.281	5.000	0.750	0.350	-10°	-14°	0.016	WXGU0403**L/R...	0.66
A08-SWLXR/L2-D11	Steel	0.688	0.500	0.406	5.000	1.000	0.475	-10°	-10°	0.016	WXGU0403**L/R...	0.66
A10-SWLXR/L2-D14	Steel	0.875	0.625	0.531	7.000	1.250	0.600	-10°	-8°	0.016	WXGU0403**L/R...	0.66
A12-SWLXR/L2-D16	Steel	1.000	0.750	0.593	7.000	1.438	0.725	-10°	-7°	0.016	WXGU0403**L/R...	0.66
A16-SWLXR/L2-D20	Steel	1.250	1.000	0.625	7.000	1.438	0.938	-10°	-7°	0.016	WXGU0403**L/R...	0.66
E06-SWLXR/L2-D08	Carbide	0.500	0.375	0.281	5.000	1.000	0.350	-10°	-14°	0.016	WXGU0403**L/R...	0.66
E08-SWLXR/L2-D11	Carbide	0.688	0.500	0.406	5.000	1.063	0.475	-10°	-10°	0.016	WXGU0403**L/R...	0.66
E10-SWLXR/L2-D14	Carbide	0.875	0.625	0.531	7.000	1.250	0.600	-10°	-8°	0.016	WXGU0403**L/R...	0.66
E12-SWLXR/L2-D16	Carbide	1.000	0.750	0.593	7.000	1.438	0.725	-10°	-7°	0.016	WXGU0403**L/R...	0.66
E16-SWLXR/L2-D20	Carbide	1.250	1.000	0.625	10.000	1.812	0.938	-10°	-7°	0.016	WXGU0403**L/R...	0.66

Metric	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 clamping torque: lbs-ft (*N-m)

**RE: Standard corner radius

Use right-hand toolholders (R) with left-hand inserts (L); and left-hand toolholders (L) with right-hand inserts (R)

SPARE PARTS

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

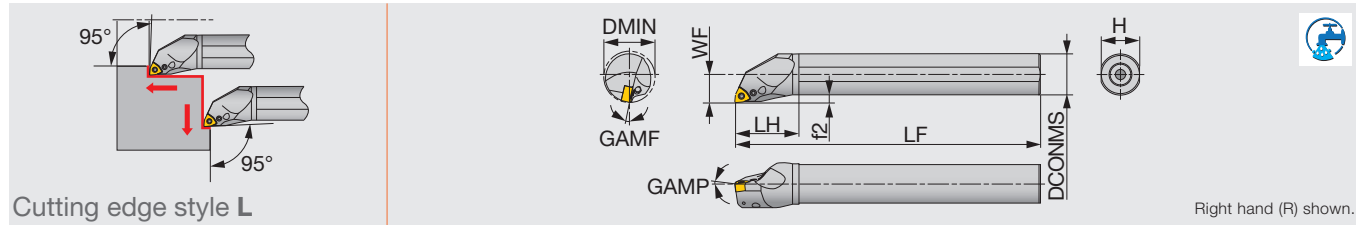
INSERT SELECTION

P	Application	Finishing	Medium cutting
	Grade	NS9530	AH725
	Breaker Shape	SS	TS
	Cutting conditions	D105	
K	Application	Finishing	Medium cutting
	Grade	NS9530	AH725
	Breaker Shape	SS	TS
	Cutting conditions	D105	
M	Application	Finishing	Medium cutting
	Grade	AH8015	AH8015
	Breaker Shape	SS	TS
	Cutting conditions	D105	
N	Application	Finishing	Medium cutting
	Grade	KS05F	KS05F
	Breaker Shape	SS	TS
	Cutting conditions	D105	

Reference pages: A/E-SWLXR/L: Insert → **B161** -

Standard cutting conditions → **D105**

Lever-lock boring bar, for negative 80° trigon inserts



Metric	Material	DMIN	DCONMS	WF	LF	LH	H	f2	GAMP	GAMF	RE**	Insert	Torque
A16M-PWLNR/L0604-D200	Steel	20	16	11	150	32	15	3	-8°	-17°	0.8	WN**0604...	1.7
A20Q-PWLNR/L0604-D250	Steel	25	20	13	180	36	18	3	-6°	-14°	0.8	WN**0604...	1.7

Torque: Recommended clamping torque: N·m

**RE: Standard corner radius

SPARE PARTS

Designation	Clamping screw	Wrench	Lever	Oil supply attachment*	Screw for oil hole*
A16M-PWLNR/L0604-D200	LCS33	P-2F	LCL33N	-	SSHM3-4
A20Q-PWLNR/L0604-D250	LCS33	P-2F	LCL33N	EA-20	SSHM3-4

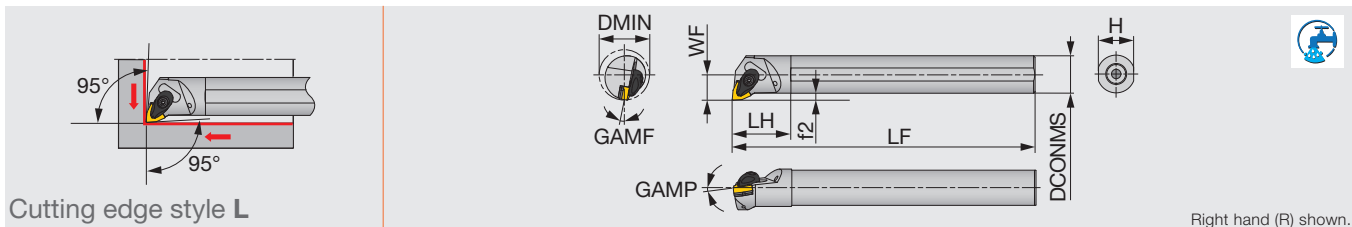
*Optional

INSERT SELECTION

P	Application	Finishing	Medium cutting
	Grade	T9215	T9215
	Breaker Shape	TSF 	TM 
	Cutting conditions	B008	

K	Application	Medium cutting
	Grade	T515
	Breaker Shape	TM 
	Cutting conditions	B012

M	Application	Finishing	Medium cutting
	Grade	T6120	T6130
	Breaker Shape	SS	SM
	Cutting conditions	B010	



Right hand (R) shown.

Inch	Material	DMIN	DCONMS	WF	LF	LH	H	f2	GAMP	GAMF	RE**	Insert	Torque
A16-AWLNR/L33-D20	Steel	1.250	1.000	0.672	12.000	1.750	0.906	0.172	-6°	-13°	0.031	WN**33...	2.21
A20-AWLNR/L33-D25	Steel	1.560	1.250	0.859	14.000	1.938	1.188	0.234	-6°	-10°	0.031	WN**33...	2.21

Torque: Recommended clamping torque: lbs-ft

**RE: Standard corner radius

SPARE PARTS

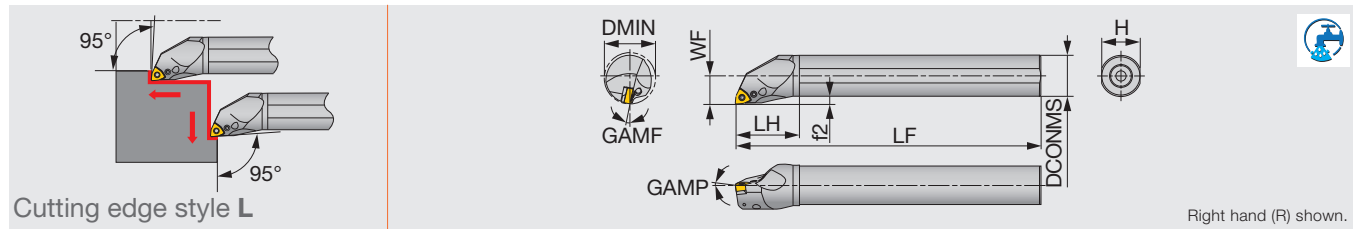
Designation	Clamp	Clamp screw	Spring	Spring pin	Shim	Shim screw	Wrench
A**-AWLNR/L33...	ACP3S-E	ACS-5W	BP-7	SP-2.5	ASW322	CSTB-3.5	T-15F

INSERT SELECTION

P	Application	Finishing	Medium cutting
	Grade	T9215	T9215
	Breaker Shape	TSF	TM
	Cutting conditions	B008	

M	Application	Finishing	Medium cutting
	Grade	T6120	T6130
	Breaker Shape	SS	SM
	Cutting conditions	B010	

K	Application	Medium cutting
	Grade	T515
	Breaker Shape	TM
	Cutting conditions	B012



Metric	Material	DMIN	DCONMS	WF	LF	LH	H	f2	GAMP	GAMP	RE**	Insert	Torque
A16M-PWLNRL/L06-D200	Steel	20	16	11	150	32	15	3	-8°	-17°	0.8	WN**0604...	1.7
A20Q-PWLNRL/L06-D250	Steel	25	20	13	180	36	18	3	-6°	-14°	0.8	WN**0604...	1.7
A25R-PWLNRL/L06-D320	Steel	32	25	17	200	45	23	4.5	-6°	-12°	0.8	WN**0604...	2.7
A32S-PWLNRL/L06-D400	Steel	40	32	22	250	50	30	6	-6°	-11°	0.8	WN**0604...	2.7
A25R-PWLNRL/L08-D320	Steel	32	25	17	200	45	23	4.5	-6°	-13°	0.8	WN**0804...	2.7
A32S-PWLNRL/L08-D400	Steel	40	32	22	250	50	30	6	-6°	-11°	0.8	WN**0804...	4.8
A40T-PWLNRL/L08-D500	Steel	50	40	27	300	60	37	7	-6°	-10°	0.8	WN**0804...	4.8

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

Use right-hand toolholders (PWLNRL**) with left-hand inserts (L); and left-hand toolholders (PWLNRL**) with right-hand inserts (R).

SPARE PARTS									
Designation	Shim	Clamping screw 1	Clamping screw 2	Wrench 1	Wrench 2	Spring pin	Lever	Oil supply attachment*	Screw for oil hole*
A16M-PWLNRL/L06-D200	-	LCS33	-	P-2F	-	-	LCL33N	-	SSHM3-4
A20Q-PWLNRL/L06-D250	-	LCS33	-	P-2F	-	-	LCL33N	EA-20	SSHM3-4
A25R-PWLNRL/L06-D320	LSW312BR/L	-	LCS3B	-	P-2.5	LSP3	LCL3	EA-25	SSHM4-5
A32S-PWLNRL/L06-D400	LSW312BR/L	-	LCS3	-	P-2.5	LSP3	LCL3	EA-32	SSHM4-5
A25R-PWLNRL/L08-D320	-	LCS43	-	-	P-2.5	-	LCL43N	EA-25	SSHM4-5
A32S-PWLNRL/L08-D400	LSW42BR/L	-	LCS4	-	P-3	LSP4	LCL4	EA-32	SSHM4-5
A40T-PWLNRL/L08-D500	LSW42BR/L	-	LCS4	-	P-3	LSP4	LCL4	-	SSHM4-5

*Optional

INSERT SELECTION

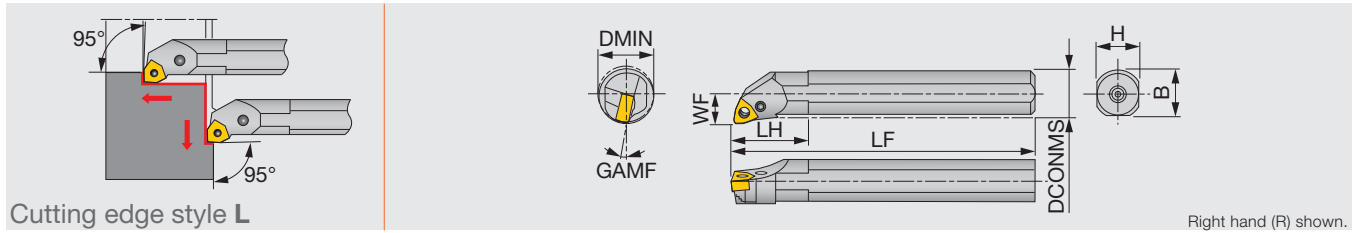
P	Application	Precision finishing	Finishing	Medium cutting	Medium to heavy cutting
	Grade	NS9530	GT9530	T9215	T9215
	Breaker Shape	TF 	TSF 	TM 	TH 
Cutting conditions		B008			
K	Application	Finishing	Medium cutting	Medium to heavy cutting	
	Grade	T515	T515	T515	
	Breaker Shape	All-round 	All-round 	All-round 	
Cutting conditions		B012			
H	Application	Precision finishing	Finishing		
	Grade	BXM10	BXM20		
	Breaker Shape	T-CBN 	T-CBN 		
Cutting conditions		B018			

M	Application	Finishing	Medium cutting	Medium to heavy cutting
	Grade	T6120	T6130	T6130
	Breaker Shape	SF	SM	SH
	Cutting conditions	B010		
S	Application	Precision finishing	Finishing	Medium cutting
	Grade	BX480	AH8005	AH8005
	Breaker Shape	T-CBN	HRF	HRM
	Cutting conditions	B016		

Reference pages: A-PWLNRL: Insert → **B101** -, CBN → **B181**

S-PWLNLR/L

Lever-lock boring bar, for negative 80° trigon inserts



Metric	Material	DMIN	DCONMS	WF	LF	LH	H	B	GAMF	RE**	Insert
S16M-PWLNLR/L06	Steel	20	16	11	150	30	15	15.5	-17°	0.8	WN**0604...
S20Q-PWLNLR/L06	Steel	25	20	13	180	35	18	19	-14°	0.8	WN**0604...
S25R-PWLNLR/L06	Steel	32	25	17	200	40	23	24	-12°	0.8	WN**0604...

**RE : Standard corner radius

Use right-hand toolholders (R) with left-hand inserts (L); and left-hand toolholders (L) with right-hand inserts (R).

SPARE PARTS

Designation	Shim	Clamping screw 1	Clamping screw 2	Wrench 1	Wrench	Spring pin	Lever
S**-PWLNLR/L06	-	LCS33	-	P-2F	-	-	LCL33N
S25R-PWLNLR06	LSW312BR	-	LCS3B	-	P-2.5	LSP3	LCL3
S25R-PWLNLR06	LSW312BL	-	LCS3B	-	P-2.5	LSP3	LCL3

INSERT SELECTION

P	Application	Precision finishing	Finishing	Medium cutting	Medium to heavy cutting
	Grade	NS9530	GT9530	T9215	T9215
	Breaker Shape	TF	TSF	TM	TH
	Cutting conditions	B008			

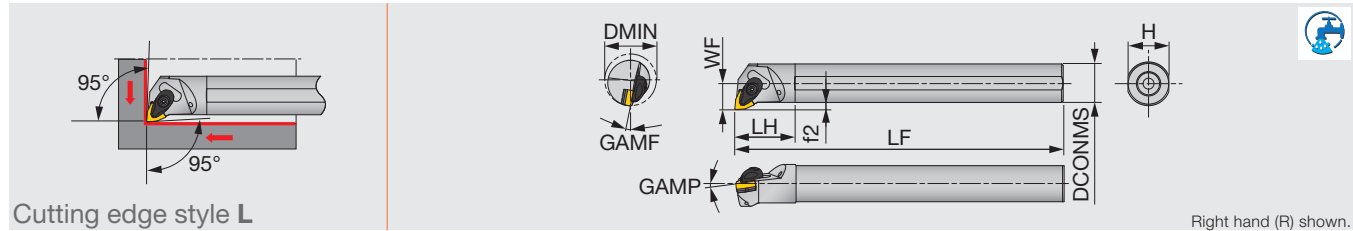
M	Application	Finishing	Medium cutting	Medium to heavy cutting
	Grade	T6120	T6130	T6130
	Breaker Shape	SF	SM	SH
	Cutting conditions	B010		

K	Application	Finishing	Medium cutting	Medium to heavy cutting
	Grade	T515	T515	T515
	Breaker Shape	All-round	All-round	All-round
	Cutting conditions	B012		

S	Application	Precision finishing	Finishing	Medium cutting
	Grade	BX480	AH8005	AH8005
	Breaker Shape	T-CBN	HRF	HRM
	Cutting conditions	B016		

H	Application	Precision finishing	Finishing
	Grade	BXM10	BXM20
	Breaker Shape	T-CBN	T-CBN
	Cutting conditions	B018	

Reference pages: S-PWLNLR/L: Insert → **B101** -, CBN → **B181** -



Inch	Material	DMIN	DCONMS	WF	LF	LH	H	f2	GAMP	GAMF	RE**	Insert	Torque
A16-AWLNR/L3-D20	Steel	1.250	1.000	0.672	12.000	1.770	0.906	0.177	-6°	-13°	0.031	WN**33...	2.21
A20-AWLNR/L3-D25	Steel	1.560	1.250	0.859	14.000	1.960	1.180	0.236	-6°	-10°	0.031	WN**33...	2.21
A16-AWLNR/L4-D20	Steel	1.250	1.000	0.672	12.000	1.770	0.906	0.177	-6°	-13°	0.031	WN**43...	2.21
A20-AWLNR/L4-D25	Steel	1.560	1.250	0.859	14.000	1.960	1.180	0.236	-6°	-10°	0.031	WN**43...	2.21
A24-AWLNR/L4-D32	Steel	2.000	1.500	1.060	14.000	2.160	1.460	0.275	-6°	-8°	0.031	WN**43...	2.21
A32-AWLNR/L4-D40	Steel	2.500	2.000	1.370	16.000	2.550	1.850	0.393	-6°	-7°	0.031	WN**43...	2.21

Torque: Recommended clamping torque: lbs-ft

**RE: Standard corner radius

SPARE PARTS

Designation	Clamp	Clamp screw	Spring	Spring pin	Shim	Shim screw	Wrench
A*-AWLNR/L3-D...	ACP3S	ACS-5W	BP-7	SP-2.5	ASW322	CSTB-3.5	T-15F
A*-AWLNR/L4-D...	ACP4S	ACS-5W	BP-7	SP-2.5	ASW422	CSTB-3.5	T-15F

INSERT SELECTION

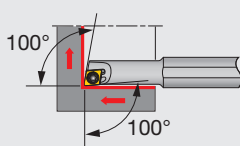
P	Application	Precision finishing	Finishing	Medium cutting	Medium to heavy cutting
	Grade	NS9530	GT9530	T9215	T9215
	Breaker Shape	TF	TSF	TM	TH
	Cutting conditions	B008			

K	Application	Finishing	Medium cutting	Medium to heavy cutting
	Grade	T515	T515	T515
	Breaker Shape	All-round	All-round	All-round
	Cutting conditions	B012		

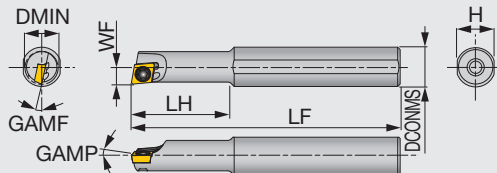
H	Application	Precision finishing	Finishing
	Grade	BXM10	BXM20
	Breaker Shape	T-CBN	T-CBN
	Cutting conditions	B018	

M	Application	Finishing	Medium cutting	Medium to heavy cutting
	Grade	T6120	T6130	T6130
	Breaker Shape	SF	SM	SH
	Cutting conditions	B010		

S	Application	Precision finishing	Finishing	Medium cutting
	Grade	BX480	AH8005	AH8005
	Breaker Shape	T-CBN	HRF	HRM
	Cutting conditions	B016		



Cutting edge style X



Right hand (R) shown.

Inch	Material	DMIN	DCONMS	WF	LF	LH	H	GAMP	GAMF	RE**	Insert	Torque
A05-SEXPR/L04-D04	Steel	0.250	0.313	0.125	5.000	0.812	0.287	0°	-12°	0.016	EPGT52...	0.44
E05-SEXPR04-D04	Carbide	0.250	0.313	0.125	5.000	1.562	0.287	0°	-12°	0.016	EPGT52...	0.44
Metric	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 clamping torque: lbs-ft (*N-m)

**RE : Standard corner radius

Use right-hand toolholders (SEXPR**) with left-hand inserts (L); and left-hand toolholders (SEXPL**) with right-hand inserts (R).

SPARE PARTS

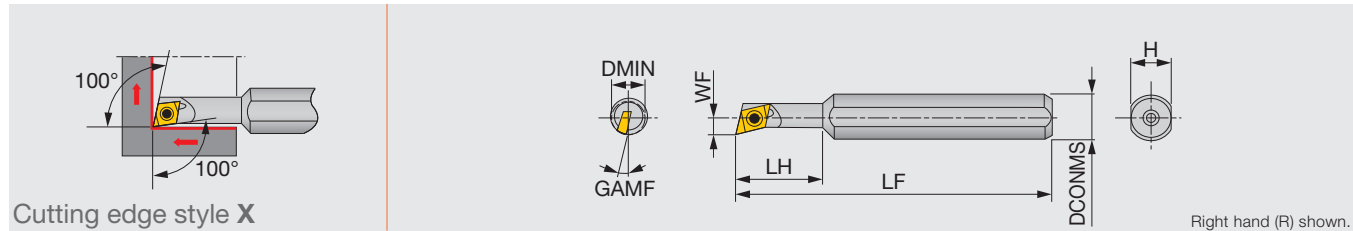


Designation	Clamping screw	Wrench
A**-SEXPR/L03-D...	CSTA-1.6	T-6F
A**-SEXPR/L04-D...	CSTB-2	T-6F
E**-SEXPR/L03-D...	CSTA-1.6	T-6F
E**-SEXPR/L04-D...	CSTB-2	T-6F

INSERT SELECTION

P	Application Grade Breaker Shape Cutting conditions	Finishing SH725 JS B020
M	Application Grade Breaker Shape Cutting conditions	Finishing SH725 JS B022
K	Application Grade Breaker Shape Cutting conditions	Finishing SH725 JS B024
N	Application Grade Breaker Shape Cutting conditions	Precision finishing DX140 W08 B026
H	Application Grade Breaker Shape Cutting conditions	Precision finishing BX310 T-CBN B030

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



Metric	Material	DMIN	DCONMS	WF	LF	LH	H	GAMF	RE**	Insert	Torque
JS08H-SEXPR045	Steel	5.5	8	2.7	100	16	7	12°	0.4	EP**0401...	0.6
JS08H-SEXPR047	Steel	7	8	3.6	100	20	7	12°	0.4	EP**0401...	0.6

SPARE PARTS

Designation	Clamping screw	Wrench
JS08H-SEXPR04...	CSTB-2	T-6F

Torque: Recommended clamping torque: N·m

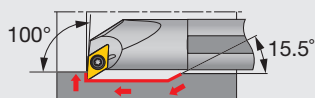
**RE : Standard corner radius

Use right-hand toolholders (SEXPR**) with left-hand inserts (L); and left-hand toolholders (SEXPL**) with right-hand inserts (R).

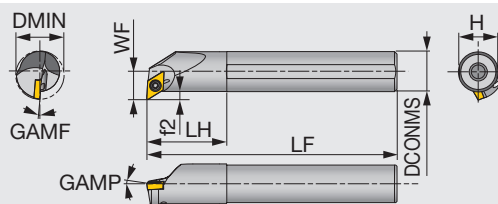
INSERT SELECTION

P	Application	Finishing	M	Application	Finishing	K	Application	Finishing
	Grade	SH725		Grade	SH725		Grade	SH725
	Breaker Shape	JS 		Breaker Shape	JS 		Breaker Shape	JS 
	Cutting conditions			B020	Cutting conditions		B022	Cutting conditions

N	Application	Precision finishing	H	Application	Precision finishing
	Grade	DX140		Grade	BX310
	Breaker Shape	T-DIA  W08 		Breaker Shape	T-CBN 
	Cutting conditions			B026	Cutting conditions



Cutting edge style X



Right hand (R) shown.

Inch	Material	DMIN	DCONMS	WF	LF	LH	H	f2	GAMP	GAMF	RE**	Insert	Torque
A06-SDXXR/L2-D10	Steel	0.625	0.375	0.406	5.000	0.750	0.350	0.213	-14°	-12°	0.016	DXGU0703**/L/R...	0.66
A08-SDXXR/L2-D11	Steel	0.688	0.500	0.406	5.000	1.000	0.475	0.151	-13.5°	-11°	0.016	DXGU0703**/L/R...	0.66
A10-SDXXR/L2-D14	Steel	0.875	0.625	0.531	7.000	1.250	0.600	0.213	-13°	-9°	0.016	DXGU0703**/L/R...	0.66
A12-SDXXR/L2-D16	Steel	1.000	0.750	0.593	7.000	1.438	0.725	0.213	-13°	-8°	0.016	DXGU0703**/L/R...	0.66
A16-SDXXR/L2-D20	Steel	1.250	1.000	0.625	7.000	1.438	0.938	0.120	-13°	-8°	0.016	DXGU0703**/L/R...	0.66
E06-SDXXR/L2-D10	Carbide	0.625	0.375	0.406	5.000	1.000	0.350	0.213	-14°	-12°	0.016	DXGU0703**/L/R...	0.66
E08-SDXXR/L2-D11	Carbide	0.688	0.500	0.406	5.000	1.063	0.475	0.151	-13.5°	-11°	0.016	DXGU0703**/L/R...	0.66
E10-SDXXR/L2-D14	Carbide	0.875	0.625	0.531	7.000	1.250	0.600	0.213	-13°	-9°	0.016	DXGU0703**/L/R...	0.66
E12-SDXXR/L2-D16	Carbide	1.000	0.750	0.593	7.000	1.438	0.725	0.213	-13°	-8°	0.016	DXGU0703**/L/R...	0.66
E16-SDXXR/L2-D20	Carbide	1.250	1.000	0.625	10.000	1.812	0.938	0.120	-13°	-8°	0.016	DXGU0703**/L/R...	0.66

Metric	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 clamping torque: lbs-ft (*N-m) **RE : Standard corner radius

Use right-hand toolholders (R) with left-hand inserts (L); and left-hand toolholders (L) with right-hand inserts (R)

SPARE PARTS



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

INSERT SELECTION

Swiss lathes

P	Application	Finishing	Medium cutting
	Grade	SH725	AH725
	Breaker Shape	JSS	JTS
	Cutting conditions	D105	

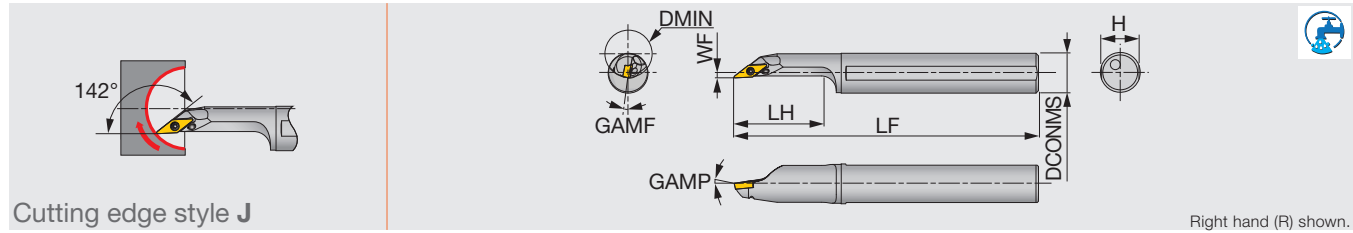
M	Application	Finishing	Medium cutting
	Grade	SH725	AH725
	Breaker Shape	JSS	JTS
	Cutting conditions	D105	

Small CNC lathes

P	Application	Finishing	Medium cutting
	Grade	AH725	AH725
	Breaker Shape	SS	TS
	Cutting conditions	D105	

M	Application	Finishing	Medium cutting
	Grade	AH8015	AH8015
	Breaker Shape	SS	TS
	Cutting conditions	D105	

Reference pages: A/E-SDXXR/L: Insert → **B127** -
Standard cutting conditions → **D105**



Cutting edge style J

Right hand (R) shown.

Inch	Material	DMIN	DCONMS	WF	LF	LH	H	GAMP	GAMF	RE**	Insert	Torque
A10-SVJBR/L2-D16	Steel	1.000	0.625	0.156	7.000	1.250	0.600	-5°	-6°	0.016	VB**22...	0.89
Metric	Material	DMIN	DCONMS	WF	LF	LH	H	GAMP	GAMF	RE**	Insert	Torque*
A20R-SVJBR/L11-D250	Steel	25	20	2	200	40	18	-5°	-5°	0.4	VB**1103...	1.2
A25S-SVJBR/L11-D300	Steel	30	25	3.5	250	50	23	-5°	-5°	0.4	VB**1103...	1.2

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

**RE : Standard corner radius

Use right-hand toolholders (SVJBR**) with left-hand inserts (L); and left-hand toolholders (SVJBL**) with right-hand inserts (R).

SPARE PARTS

Designation	Clamping screw	Wrench
A**-SVJB*11-D...	CSTB-2.5	T-8F

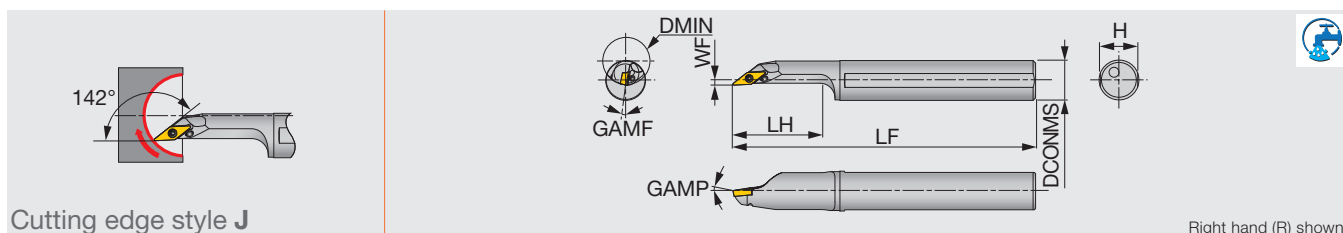
INSERT SELECTION

P	Application	Finishing	Finishing to medium cutting
	Grade	SH725	T9215
	Breaker Shape	JS	PS
	Cutting conditions	B020	

M	Application	Finishing	Finishing to medium cutting
	Grade	SH725	T9215
	Breaker Shape	JS	PS
	Cutting conditions	B022	

K	Application	Finishing to medium cutting
	Grade	T515
	Breaker Shape	CM
	Cutting conditions	B024

H	Application	Precision finishing	Finishing
	Grade	BXM10	BXM20
	Breaker Shape	T-CBN	T-CBN
	Cutting conditions	B030	



Inch	Material	DMIN	DCONMS	WF	LF	LH	H	GAMP	GAMF	RE**	Insert	Torque
A10-SVJCR2-D16	Steel	1.000	0.625	0.156	7.000	1.750	0.600	-5°	-6°	0.016	VC**22..	0.89

Metric	Material	DMIN	DCONMS	WF	LF	LH	H	GAMP	GAMF	RE**	Insert	Torque*
A12M-SVJCR/L08-D160	Steel	16	12	2	150	28	11	-5°	-5°	0.4	VC**0802...	0.6
A16Q-SVJCR/L08-D200	Steel	20	16	2	180	35	15	-5°	-5°	0.4	VC**0802...	0.6

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

**RE : Standard corner radius

Use right-hand toolholders (SVJCR**) with left-hand inserts (L); and left-hand toolholders (SVJCL**) with right-hand inserts (R).

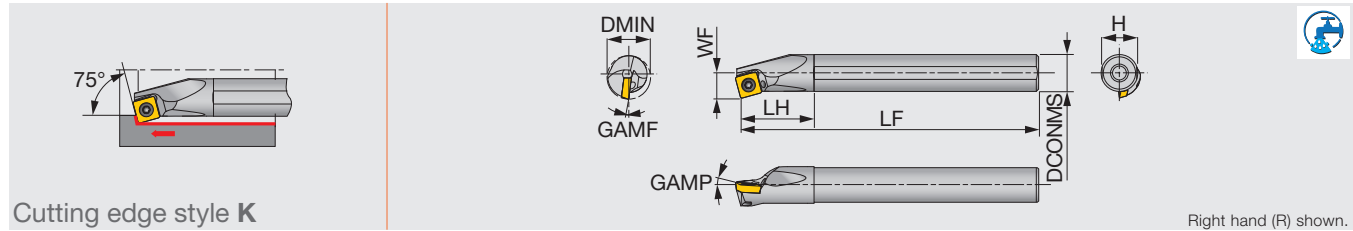
SPARE PARTS

Designation	Clamping screw	Wrench
A**-SVJC*08-D...	CSTB-2L	T-6F

INSERT SELECTION

P	Application	Finishing to medium cutting	M	Application	Finishing to medium cutting
	Grade	T9215		Grade	T9215
	Breaker Shape	PS		Breaker Shape	PS
	Cutting conditions	B020		Cutting conditions	B022
K	Application	Finishing to medium cutting	N	Application	Precision finishing
	Grade	T515		Grade	DX120
	Breaker Shape	CM		Breaker Shape	T-DIA with rake AL
	Cutting conditions	B024		Cutting conditions	B026
S	Application	Finishing to medium cutting	H	Application	Precision finishing
	Grade	AH8005		Grade	BXM10
	Breaker Shape	PS		Breaker Shape	T-CBN
	Cutting conditions	B028		Cutting conditions	B030

Reference pages: A-SVJCR/L: Insert → **B155** -



Metric	Material	DMIN	DCONMS	WF	LF	LH	H	GAMP	GAMF	RE**	Insert	Torque
A16Q-SSKPR09-D200	Steel	20	16	11	180	32	15	5°	-6°	0.8	SP**0903...	3
A20R-SSKPR09-D240	Steel	24	20	13	200	36	18	5°	-2°	0.8	SP**0903...	3
A25S-SSKPR12-D310	Steel	31	25	17	250	45	23	5°	-2°	0.8	SP**1204...	6

Torque: Recommended clamping torque: N·m

**RE : Standard corner radius

Note: Use right-hand toolholders (SSKPR**) with left-hand inserts (L); and left-hand toolholders (SSKPL**) with right-hand inserts (R).

SPARE PARTS

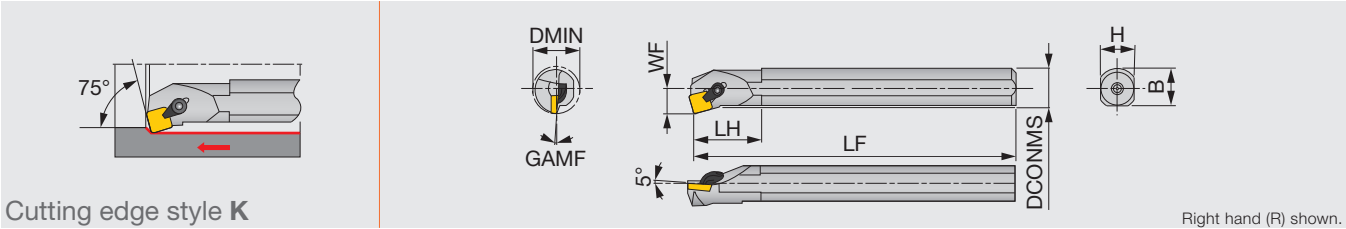
Designation	Clamping screw	Wrench
A**-SSKPR09-D2*0	CSTB-4L060	T-15F
A25S-SSKPR12-D310	CSTB-5S	T-20F

INSERT SELECTION

P	Application	Finishing to medium cutting	M	Application	Finishing to medium cutting
	Grade	T9215		Grade	T9215
	Breaker Shape	PS 		Breaker Shape	PS 
	Cutting conditions	B020		Cutting conditions	B022
K	Application	Finishing to medium cutting		Application	Finishing to medium cutting
	Grade	T515		Grade	T515
	Breaker Shape	CM 		Breaker Shape	CM 
	Cutting conditions	B024		Cutting conditions	B024

S-CSKPR/L

Clamp-on boring bar, for positive square inserts



Metric	Material	DMIN	DCONMS	WF	LF	LH	H	B	GAMF	RE**	Insert
S16Q-CSKPR09	Steel	20	16	11	180	30	15	15	-4°	0.8	SP**0903...
S20R-CSKPR/L09	Steel	25	20	13	200	40	18	18.5	-2°	0.8	SP**0903...
S25S-CSKPR12	Steel	32	25	17	250	45	23	22.5	0°	0.8	SP**1203...

**RE : Standard corner radius
Use right-hand toolholders (R) with left-hand inserts (L); and left-hand toolholders (L) with right-hand inserts (R).

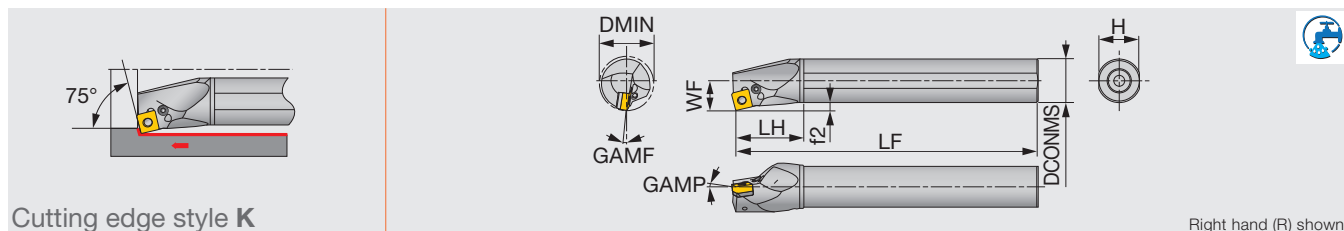
SPARE PARTS

Designation	Clamp set	Wrench
S16Q-CSKPR09	CSG-5S	P-2.5
S20R-CSKPR/L09	CSG-5	P-2.5
S25S-CSKPR12	CSG-6	P-3

INSERT SELECTION

P	Application Finishing to medium cutting	M	Application Medium cutting
Grade T9215		Grade T6130	
Breaker Shape PS		Breaker Shape PM	
Cutting conditions B020		Cutting conditions B022	
K	Application Finishing to medium cutting	N	Application Finishing
Grade T515		Grade DX140	
Breaker Shape CM		Breaker Shape T-DIA	
Cutting conditions B024		Cutting conditions B026	

Reference pages: S-CSKPR/L: Insert → B136 -, CBN → B186, PCD → B197



Metric	Material	DMIN	DCONMS	WF	LF	LH	H	f2	GAMP	GAMF	RE**	Insert	Torque
A32S-PSKNR/L12-D400	Steel	40	32	22	250	50	30	6	-6°	-10°	0.8	SN**1204...	4.8
A40T-PSKNR/L12-D500	Steel	50	40	27	300	60	37	7	-6°	-10°	0.8	SN**1204...	4.8
A50U-PSKNR/L12-D630	Steel	63	50	35	350	65	47	10	-6°	-8°	0.8	SN**1204...	4.8

Torque: Recommended clamping torque: N·m

**RE : Standard corner radius

Use right-hand toolholders (PSKNR**) with left-hand inserts (L); and left-hand toolholders (PSKNL**) with right-hand inserts (R).

SPARE PARTS

Designation	Shim	Screw	Wrench	Spring pin	Lever	Oil supply attachment*	Screw for oil hole*
A32S-PSKNR/L12-D400	LSS42BR/L	LCS4	P-3	LSP4	LCL4	EA-32	SSHM4-5
A40T-PSKNR/L12-D500	LSS42BR/L	LCS4	P-3	LSP4	LCL4	-	SSHM6-6
A50U-PSKNR/L12-D630	LSS42BR/L	LCS4	P-3	LSP4	LCL4	-	SSHM6-6

*Optional

INSERT SELECTION

P	Application	Precision finishing	Finishing	Medium cutting	Medium to heavy cutting
	Grade	NS9530	GT9530	T9215	T9215
	Breaker Shape	TF	TSF	TM	TH
	Cutting conditions	B008			

M	Application	Finishing	Medium cutting	Medium to heavy cutting
	Grade	T6120	T6130	T6130
	Breaker Shape	SF	SM	SH
	Cutting conditions	B010		

K	Application	Finishing	Medium cutting	Medium to heavy cutting
	Grade	T515	T515	T515
	Breaker Shape	All-round	All-round	All-round
	Cutting conditions	B012		

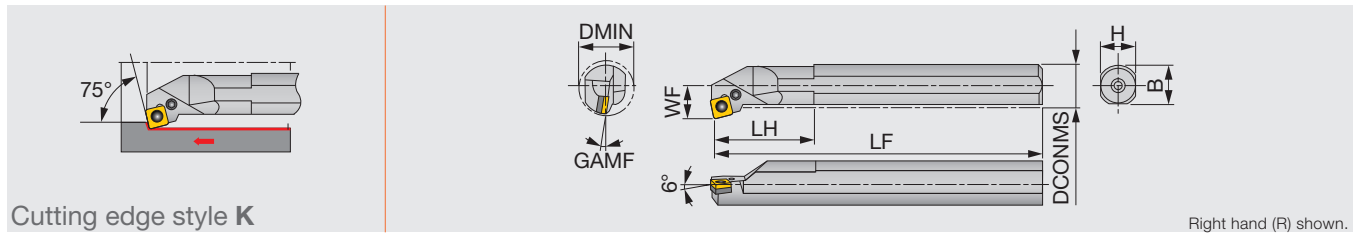
N	Application	Finishing	Medium cutting
	Grade	DX140	TH10
	Breaker Shape	T-DIA	P
	Cutting conditions	B014	

S	Application	Precision finishing	Finishing	Medium cutting
	Grade	BX480	AH8005	AH8005
	Breaker Shape	T-CBN	HRF	HRM
	Cutting conditions	B016		

Reference pages: A-PSKNR/L: Insert → **B077 -**, CBN → **B177**, PCD → **B195**

S-PSKNR

Lever-lock boring bar, for negative square inserts



Metric	Material	DMIN	DCONMS	WF	LF	LH	H	B	GAMF	RE**	Insert
S32S-PSKNR12	Steel	40	32	22	250	50	30	29.5	-10°	0.8	SN**1204...
S40T-PSKNR12	Steel	50	40	27	300	55	37	37.5	-10°	0.8	SN**1204...
S50U-PSKNR12	Steel	63	50	35	350	65	47	47.5	-8°	0.8	SN**1204...

**RE : Standard corner radius

Use right-hand toolholders (R) with left-hand inserts (L); and left-hand toolholders (L) with right-hand inserts (R).

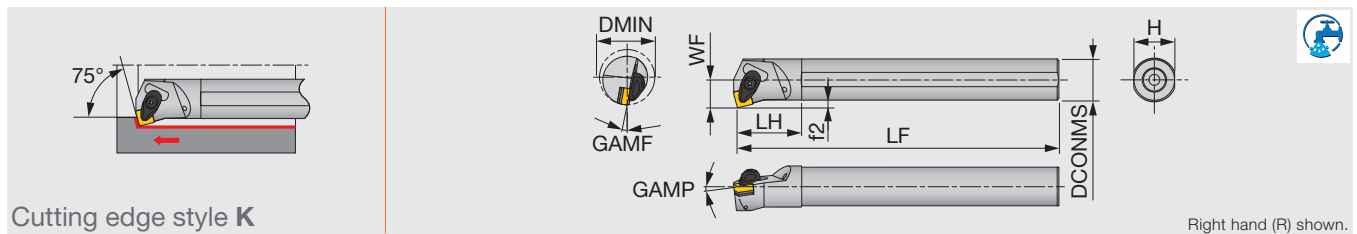
SPARE PARTS

Designation	Shim	Clamping screw	Wrench	Spring pin	Lever
S**-PSKNR12	LSS42BR	LCS4	P-3	LSP4	LCL4

TURNINGA

A-ASKNR/L

Double-clamp boring bar, for negative square inserts



Inch	Material	DMIN	DCONMS	WF	LF	LH	H	f2	GAMP	GAMF	RE**	Insert	Torque
A16-ASKNR/L4-D20	Steel	1.250	1.000	0.672	12.000	1.770	0.906	0.177	-6°	-13°	0.031	SN**43...	2.21
A20-ASKNR/L4-D25	Steel	1.500	1.250	0.859	14.000	1.960	1.180	0.236	-6°	-10°	0.031	SN**43...	2.21

Torque: Recommended clamping torque: lbs-ft

**RE : Standard corner radius

SPARE PARTS

Designation	Clamp	Clamp screw	Spring	Spring pin	Shim	Shim screw	Wrench
A**-ASKNR/L4-D...	ACP4S	ACS-5W	BP-7	SP-2.5	ASS422	CSTB-3.5	T-15F

INSERT SELECTION

P	Application	Precision finishing	Finishing	Medium cutting	Medium to heavy cutting
	Grade	NS9530	GT9530	T9215	T9215
	Breaker Shape	TF	TSF	TM	TH
	Cutting conditions	B008			

M	Application	Finishing	Medium cutting	Medium to heavy cutting
	Grade	T6120	T6130	T6130
	Breaker Shape	SF	SM	SH
	Cutting conditions	B010		

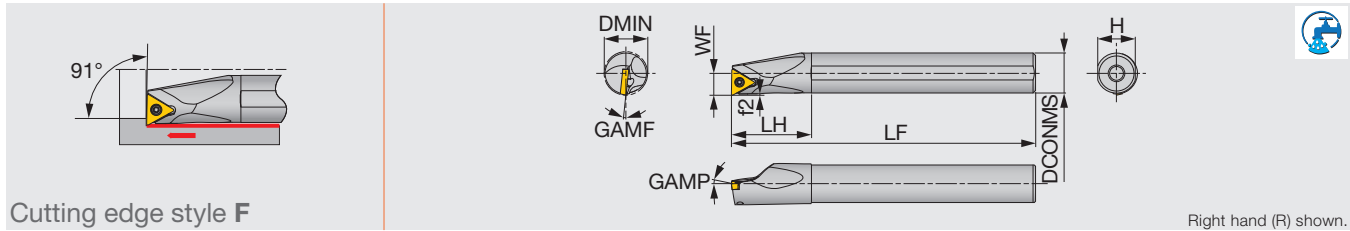
K	Application	Finishing	Medium cutting	Medium to heavy cutting
	Grade	T515	T515	T515
	Breaker Shape	All-round	All-round	All-round
	Cutting conditions	B012		

N	Application	Finishing	Medium cutting
	Grade	DX140	TH10
	Breaker Shape	T-DIA	P
	Cutting conditions	B014	

S	Application	Precision finishing	Finishing	Medium cutting
	Grade	BX480	AH8005	AH8005
	Breaker Shape	T-CBN	HRF	HRM
	Cutting conditions	B016		

Reference pages: S-PSKNR, A-ASKNR/L:

Insert → B077 -, CBN → B177, PCD → B195



Cutting edge style F

Right hand (R) shown.

Inch	Material	DMIN	DCONMS	WF	LF	LH	H	f2	GAMP	GAMF	RE**	Insert	Torque
E06-STFCR/L2-D08	Carbide	0.500	0.375	0.281	5.000	1.000	0.350	-	0°	-9°	0.016	TC**21.5...	0.89
E08-STFCR2-D11	Carbide	0.688	0.500	0.406	5.000	1.062	0.475	-	0°	-6°	0.016	TC**21.5...	0.89
E10-STFCR2-D14	Carbide	0.875	0.625	0.531	7.000	1.250	0.600	-	0°	-5°	0.016	TC**21.5...	0.89
E12-STFCR3-D16	Carbide	1.000	0.750	0.594	7.000	1.438	0.750	-	0°	-5°	0.032	TC**32.5...	2.2
Metric	Material	DMIN	DCONMS	WF	LF	LH	H	f2	GAMP	GAMF	RE**	Insert	Torque*
A10K-STFCR/L1103-D120	Steel	12	10	6.5	125	20	9	0.6	0°	-13°	0.4	TC**1103...	1.2
A12M-STFCR/L1103-D140	Steel	14	12	7	150	24	11	0.5	0°	-10°	0.4	TC**1103...	1.2
A16Q-STFCR/L1103-D180	Steel	18	16	9	180	32	15	0.5	0°	-7°	0.4	TC**1103...	1.2
E10M-STFCR/L1103-D120	Carbide	12	10	6.5	150	25	9	0.7	0°	-13°	0.4	TC**1103...	1.2
E12Q-STFCR/L1103-D140	Carbide	14	12	7	180	27	11	0.5	0°	-10°	0.4	TC**1103...	1.2
E16R-STFCR/L1103-D180	Carbide	18	16	9	200	32	15	0.5	0°	-7°	0.4	TC**1103...	1.2

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

**RE : Standard corner radius

Use right-hand toolholders (STFCR**) with left-hand inserts (L); and left-hand toolholders (STFCL**) with right-hand inserts (R).

SPARE PARTS

Designation	Clamping screw	Wrench
E**-STFCR/L2-D...	CSTB-2.5	T-8F
E12-STFCR3-D16	CSTB-4S	T15-F
A**-STFCR/L1103-D...	CSTB-2.5	T-8F
E**-STFCR/L1103-D...	CSTB-2.5	T-8F

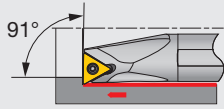
INSERT SELECTION

P	Application	Precision finishing	Finishing	Finishing to medium cutting	Medium cutting
	Grade	SH725	SH725	T9215	T9215
	Breaker Shape	01	JS	PS	PM
	Cutting conditions	B020			

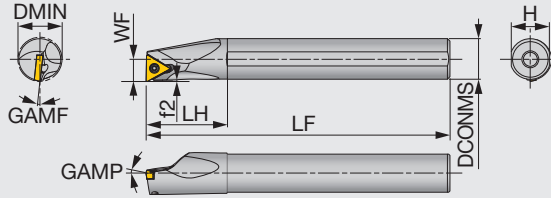
K	Application	Finishing to medium cutting
	Grade	T515
	Breaker Shape	CM
	Cutting conditions	B024

M	Application	Precision finishing	Finishing	Finishing to medium cutting	Medium cutting
	Grade	SH725	SH725	T9215	T9215
	Breaker Shape	01	JS	PS	PM
	Cutting conditions	B022			

N	Application	Precision finishing	Medium cutting
	Grade	DX120	KS05F
	Breaker Shape	T-DIA with rake	AL
	Cutting conditions	B026	



Cutting edge style F



Right hand (R) shown.

Inch	Material	DMIN	DCONMS	WF	LF	LH	H	f2	GAMP	GAMF	RE**	Insert	Torque
E06-STFPR2-D08	Carbide	0.500	0.375	0.281	5.000	1.000	0.350	-	0°	-5°	0.016	TP**21.5...	0.89
E08-STFPR2-D11	Carbide	0.688	0.500	0.406	5.000	1.062	0.475	-	0°	-3°	0.016	TP**21.5...	0.89
E10-STFPR2-D14	Carbide	0.875	0.625	0.531	7.000	1.250	0.605	-	0°	-2°	0.016	TP**21.5...	0.89
E12-STFPR/L3-D16	Carbide	1.000	0.750	0.594	7.000	1.438	0.725	-	0°	-2°	0.032	TP**32.5...	2.2
Metric	Material	DMIN	DCONMS	WF	LF	LH	H	f2	GAMP	GAMF	RE**	Insert	Torque*
A08H-STFPR/L09-D100	Steel	10	8	5.5	100	16	7.5	0.7	5°	-8°	0.4	TP**0902...	0.9
A10K-STFPR/L1102-D120	Steel	12	10	6.5	125	20	9	0.7	5°	-6°	0.4	TP**1102...	1.2
A12M-STFPR/L1102-D140	Steel	14	12	7.0	150	24	11	0.6	5°	-4°	0.4	TP**1102...	1.2
A16Q-STFPR/L13-D180	Steel	18	16	9	180	32	15	0.7	5°	-2°	0.4	TP**1303...	1.4
A20R-STFPR13-D220	Steel	22	20	11	200	36	18	0.8	5°	-2°	0.4	TP**1303...	1.4
A25S-STFPR16-D270	Steel	27	25	13.5	250	45	23	0.6	5°	-1°	0.4	TP**16T3...	3
E08K-STFPR/L09-D100	Carbide	10	8	5.5	125	22	7.5	0.7	5°	-8°	0.4	TP**0902...	0.9
E10M-STFPR/L1102-D120	Carbide	12	10	6.5	150	25	9	0.7	5°	-6°	0.4	TP**1102...	1.2
E12Q-STFPR/L1102-D140	Carbide	14	12	7	180	27	11	0.6	5°	-4°	0.4	TP**1102...	1.2
E16R-STFPR13-D180	Carbide	18	16	9	200	32	15	0.7	5°	-2°	0.4	TP**1303...	1.4
E20S-STFPR13-D220	Carbide	22	20	11	250	36	18	0.8	5°	-2°	0.4	TP**1303...	1.4

Torque: Recommended clamping torque: lbs-ft (*N-m) **RE : Standard corner radius

Use right-hand toolholders (STFPR**) with left-hand inserts (L); and left-hand toolholders (STFPL**) with right-hand inserts (R).

(1) TPGH, TPGM, and TPGA inserts cannot be used.

INCH SPARE PARTS

Designation	Clamping screw	Wrench
E06-STFPR2-D08	CSTB-2.5B	T-8F
E08/10-STFPR2-D1...	CSTB-2.5	T-8F
E12-STFPR/L3-D16	CSTB-4S	T15-F

METRIC SPARE PARTS

Designation	Clamping screw	Wrench
A08H-STFPR/L09-D100	CSTB-2.2S	T-7F
A10K-STFPR/L1102-D120	CSTB-2.5B	T-8F
A12M-STFPR/L1102-D140	CSTB-2.5	T-8F
A16Q-STFPR/L13-D180	CSTB-3S	T-9F
A20R-STFPR13-D220	CSTB-3	T-9F
A25S-STFPR16-D270	CSTB-4M	T-15F
E08K-STFPR/L09-D100	CSTB-2.2S	T-7F
E10M-STFPR/L1102-D120	CSTB-2.5B	T-8F
E12Q-STFPR/L1102-D140	CSTB-2.5	T-8F
E16R-STFPR13-D180	CSTB-3S	T-9F
E20S-STFPR13-D220	CSTB-3	T-9F

INSERT SELECTION

P	Application	Finishing	Finishing to medium cutting	Medium cutting
	Grade	SH725	T9215	T9215
	Breaker Shape	JS	PS	PM
	Cutting conditions	B020		

M	Application	Finishing	Finishing to medium cutting	Medium cutting
	Grade	SH725	T9215	T9215
	Breaker Shape	JS	PS	PM
	Cutting conditions	B022		

K	Application	Finishing to medium cutting
	Grade	T515
	Breaker Shape	CM
	Cutting conditions	B024

N	Application	Precision finishing
	Grade	DX120
	Breaker Shape	T-DIA with rake
	Cutting conditions	B026

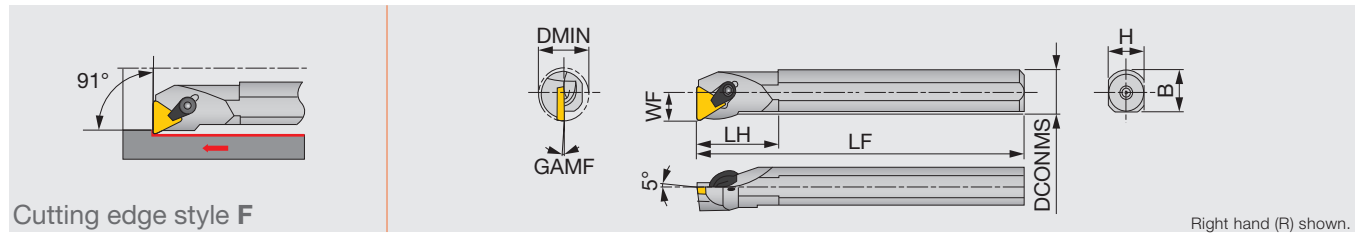
S	Application	Precision finishing
	Grade	BX470
	Breaker Shape	T-CBN
	Cutting conditions	B028

H	Application	Precision finishing	Finishing
	Grade	BXM10	BXM20
	Breaker Shape	T-CBN	T-CBN
	Cutting conditions	B030	

Reference pages: A/E-STFPR/L: Insert → B144 -, CBN → B188 -, PCD → B198

S/C-CTFPR/L

Clamp-on boring bar, for positive 60° triangular inserts



Metric	Material	DMIN	DCONMS	WF	LF	LH	H	B	GAMF	RE**	Insert
S12M-CTFPR/L11	Steel	16	12	9	150	25	11	11.5	-6°	0.4	TP**1103...
S16Q-CTFPR/L11	Steel	20	16	11	180	30	15	15	-4°	0.4	TP**1103...
S20R-CTFPR/L16	Steel	25	20	13	200	40	18	18.5	-2°	0.8	TP**1603...
S25S-CTFPR/L16	Steel	32	25	17	250	45	23	22.5	0°	0.8	TP**1603...
S32T-CTFPR/L16	Steel	40	32	22	300	50	30	29.5	0°	0.8	TP**1603...
C12Q-CTFPR/L11	Carbide	16	12	9	180	-	11	-	-6°	0.4	TP**1103...
C16R-CTFPR/L11	Carbide	20	16	11	200	-	15	-	-4°	0.4	TP**1103...

**RE : Standard corner radius

*The hole specification of applicable inserts conforms to ISO standard.

Use right-hand toolholders (R) with left-hand inserts (L); and left-hand toolholders (L) with right-hand inserts (R).

Designation	Clamp set 1	Clamp set 2	Wrench	Shim	Shim screw
S12M-CTFPR/L11	CSW-00	-	P-2.5	-	-
S16Q-CTFPR/L11	-	CSG-5S	P-2.5	-	-
S20R-CTFPR/L16	-	CSG-6S	P-3	-	-
S25S-CTFPR/L16	-	CSG-6	P-3	-	-
S32T-CTFPR/L16	-	CSG-6	P-3	PAT-32	M3X0.5X6
C12Q-CTFPR/L11	CSW-00	-	P-2.5	-	-
C16R-CTFPR/L11	-	CSG-5S	P-2.5	-	-

INSERT SELECTION

P	Application	Precision finishing	Finishing	Finishing to medium cutting	Medium cutting
	Grade	NS9530	NS9530	T9215	T9215
	Breaker Shape	01	PSS	PS	PM
	Cutting conditions	B020			

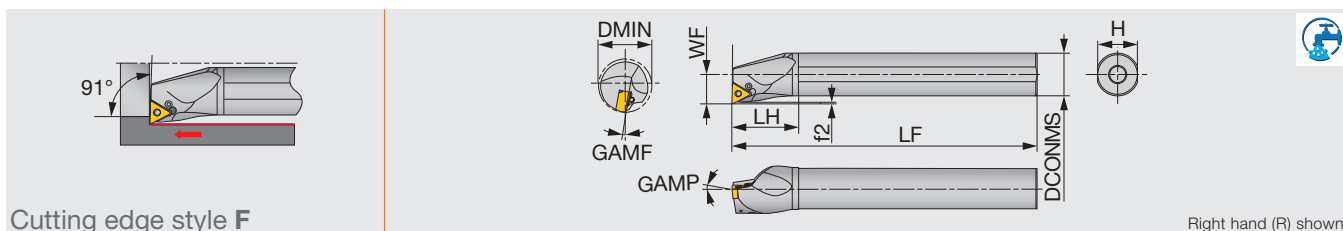
K	Application	Finishing to medium cutting
	Grade	T515
	Breaker Shape	CM
	Cutting conditions	B024

H	Application	Precision finishing	Finishing
	Grade	BXM10	BXM20
	Breaker Shape	T-CBN	T-CBN
	Cutting conditions	B030	

M	Application	Finishing	Finishing to medium cutting	Medium cutting
	Grade	AH725	AH630	T6130
	Breaker Shape	PSF	PSS	PM
	Cutting conditions	B022		

N	Application	Finishing
	Grade	DX140
	Breaker Shape	T-DIA
	Cutting conditions	B026

Reference pages: S/C-CTFPR/L: Insert → **B144** -, CBN → **B188** -, PCD → **B198**



Metric	Material	DMIN	DCONMS	WF	LF	LH	H	f2	GAMP	GAMF	RE**	Insert	Torque
A25R-PTFNR/L1104-D320	Steel	32	25	17	200	45	23	1.31	-6°	-12°	0.8	TN**1104...	2
A32S-PTFNR/L1104-D400	Steel	40	32	22	250	50	30	1.25	-6°	-10°	0.8	TN**1104...	2

Torque: Recommended clamping torque: N·m

**RE: Standard corner radius

SPARE PARTS

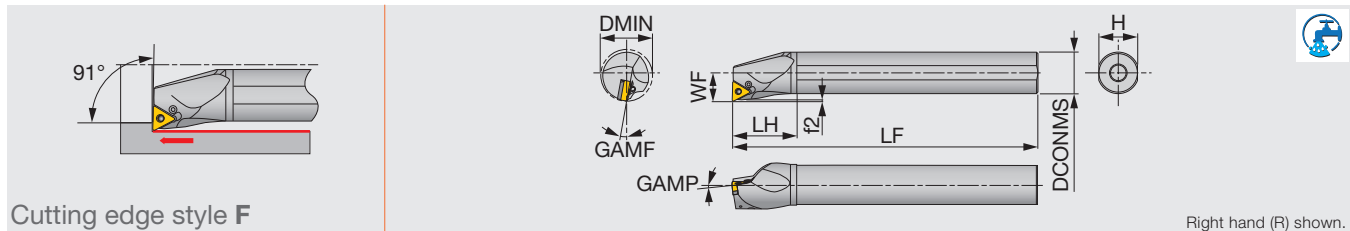
Designation	Clamping screw	Wrench	Lever	Oil supply attachment*	Screw for oil hole*
A25R-PTFNR/L...	LCS23A	P-2.5	LCL23	EA-25	SSHM4-5
A32S-PTFNR/L...	LCS23A	P-2.5	LCL23	EA-32	SSHM4-5

*Optional

INSERT SELECTION

P	Application	Finishing	Medium cutting
	Grade	T9215	T9215
	Breaker Shape	TSF	TM
	Cutting conditions	B008	

M	Application	Finishing	Medium cutting
	Grade	T6120	T6130
	Breaker Shape	SS	SM
	Cutting conditions	B010	



Cutting edge style F

Right hand (R) shown.

Metric	Material	DMIN	DCONMS	WF	LF	LH	H	f2	GAMP	GAMF	RE**	Insert	Torque
A25R-PTFNR/L16-D320	Steel	32	25	17	200	45	23	1.2	-6°	-12°	0.8	TN**1604...	2.7
A32S-PTFNR/L16-D400	Steel	40	32	22	250	50	30	1.1	-6°	-10°	0.8	TN**1604...	2.7
A40T-PTFNR/L16-D500	Steel	50	40	27	300	60	37	1.1	-6°	-10°	0.8	TN**1604...	2.7
A50U-PTFNR/L16-D630	Steel	63	50	35	350	65	47	1.1	-6°	-8°	0.8	TN**1604...	2.7

Torque: Recommended clamping torque: N·m

**RE : Standard corner radius

Note: Use right-hand toolholders (PTFNR**) with left-hand inserts (L); and left-hand toolholders (PTFNL**) with right-hand inserts (R).

SPARE PARTS

Designation	Shim	Clamping screw	Wrench	Spring pin	Lever	Oil supply attachment*	Screw for oil hole*
A25R-PTFNR/L16-D320	ELST317BR/L	LCS3	P-2.5	LSP3	LCL33	EA-25	SSHM4-5
A32S-PTFNR/L16-D400	LST317BR/L	LCS3	P-2.5	LSP3	LCL3	EA-32	SSHM4-5
A40T-PTFNR/L16-D500	LST317BR/L	LCS3	P-2.5	LSP3	LCL3	-	SSHM6-6
A50U-PTFNR/L16-D630	LST317BR/L	LCS3	P-2.5	LSP3	LCL3	-	SSHM6-6

*Optional

INSERT SELECTION

Application	Precision finishing	Finishing	Medium cutting	Medium to heavy cutting
Grade	NS9530	GT9530	T9215	T9215
Breaker Shape	TF	TSF	TM	TH
Cutting conditions	B008			

Application	Finishing	Medium cutting	Medium to heavy cutting
Grade	T515	T515	T515
Breaker Shape	All-round	All-round	All-round
Cutting conditions	B012		

Application	Precision finishing	Finishing	Medium cutting
Grade	BX470	AH8005	AH8005
Breaker Shape	T-CBN	HRF	HRM
Cutting conditions	B016		

Application	Finishing	Medium cutting
Grade	T6120	T6130
Breaker Shape	SF	SM
Cutting conditions	B010	

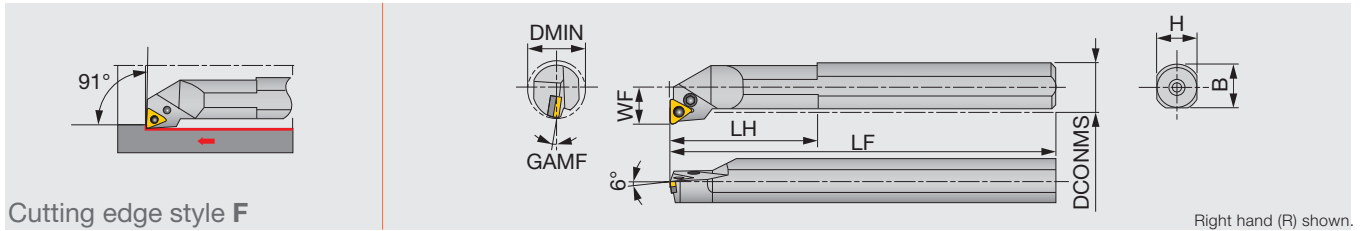
Application	Precision finishing	Finishing	Medium cutting
Grade	DX120	DX140	TH10
Breaker Shape	T-DIA	with rake T-DIA	P
Cutting conditions	B014		

Application	Precision finishing	Finishing
Grade	BXM10	BXM20
Breaker Shape	T-CBN	T-CBN
Cutting conditions	B018	

Reference pages: A-PTFNR/L: Insert → **B086 -**, CBN → **B178 -**, PCD → **B194 -**

S-PTFNR/L

Lever-lock boring bar, for negative 60° triangular inserts



Metric	Material	DMIN	DCONMS	WF	LF	LH	H	B	GAMF	RE**	Insert	Torque
S32S-PTFNR/L16	Steel	40	32	22	250	50	30	29.5	-10°	0.8	TN**1604...	2.7
S40T-PTFNR/L16	Steel	50	40	27	300	55	37	37.5	-10°	0.8	TN**1604...	2.7
S50U-PTFNR16	Steel	63	50	35	350	65	47	47.5	-8°	0.8	TN**1604...	2.7

Torque: Recommended clamping torque: N·m

**RE : Standard corner radius

Use right-hand toolholders (R) with left-hand inserts (L); and left-hand toolholders (L) with right-hand inserts (R).

SPARE PARTS

Designation	Shim	Clamping screw	Wrench	Spring pin	Lever
S32S-PTFNR16	LST317BR	LCS3	P-2.5	LSP3	LCL3
S32S-PTFNL16	LST317BL	LCS3	P-2.5	LSP3	LCL3
S40T-PTFNR16	LST317BR	LCS3	P-2.5	LSP3	LCL3
S40T-PTFNL16	LST317BL	LCS3	P-2.5	LSP3	LCL3
S50U-PTFNR16	LST317BR	LCS3	P-2.5	LSP3	LCL3

INSERT SELECTION

Application	Precision finishing	Finishing	Medium cutting	Medium to heavy cutting
Grade	NS9530	GT9530	T9215	T9215
Breaker Shape	TF	TSF	TM	TH
Cutting conditions	B008			

Application	Finishing	Medium cutting
Grade	T6120	T6130
Breaker Shape	SF	SM
Cutting conditions	B010	

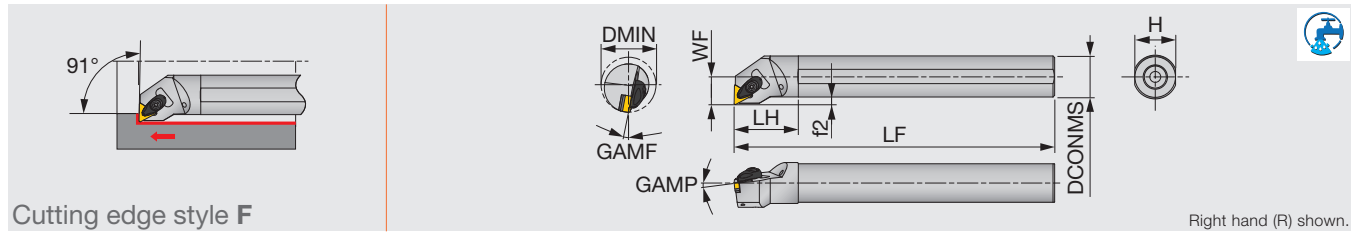
Application	Finishing	Medium cutting	Medium to heavy cutting
Grade	T515	T515	T515
Breaker Shape	All-round	All-round	All-round
Cutting conditions	B012		

Application	Precision finishing	Finishing	Medium cutting
Grade	DX120	DX140	TH10
Breaker Shape	T-DIA	T-DIA	P
Cutting conditions	B014		

Application	Precision finishing	Finishing	Medium cutting
Grade	BX470	AH8005	AH8005
Breaker Shape	T-CBN	HRF	HRM
Cutting conditions	B016		

Application	Precision finishing	Finishing
Grade	BXM10	BXM20
Breaker Shape	T-CBN	T-CBN
Cutting conditions	B018	

Reference pages: S-PTFNR/L: Insert → **B086 -**, CBN → **B178 -**, PCD → **B194 -**



Inch	Material	DMIN	DCONMS	WF	LF	LH	H	f2	GAMP	GAMF	RE**	Insert	Torque
A16-ATFNR/L3-D20	Steel	1.250	1.000	0.672	12.000	1.770	0.906	0.177	-6°	-13°	0.031	TN**33...	2.21
A20-ATFNR/L3-D25	Steel	1.560	1.250	0.859	14.000	1.960	1.180	0.236	-6°	-10°	0.031	TN**33...	2.21

Torque: Recommended clamping torque: lbs-ft

**RE : Standard corner radius

SPARE PARTS

Designation	Clamp	Clamp screw	Spring	Spring pin	Shim	Shim screw	Wrench
A**-ATFNR/L3-D...	ACP3S	ACS-5W	BP-7	SP-2.5	AST322	CSTB-3.5	T-15F

INSERT SELECTION

P	Application	Precision finishing	Finishing	Medium cutting	Medium to heavy cutting
	Grade	NS9530	GT9530	T9215	T9215
	Breaker Shape	TF	TSF	TM	TH
	Cutting conditions	B008			

K	Application	Finishing	Medium cutting	Medium to heavy cutting
	Grade	T515	T515	T515
	Breaker Shape	All-round	All-round	All-round
	Cutting conditions	B012		

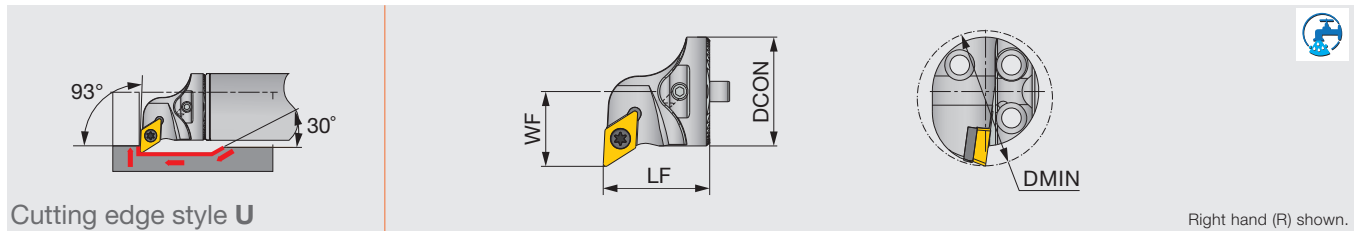
S	Application	Precision finishing	Finishing	Medium cutting
	Grade	BX470	AH8005	AH8005
	Breaker Shape	T-CBN	HRF	HRM
	Cutting conditions	B016		

M	Application	Finishing	Medium cutting
	Grade	T6120	T6130
	Breaker Shape	SF	SM
	Cutting conditions	B010	

N	Application	Precision finishing	Finishing	Medium cutting
	Grade	DX120	DX140	TH10
	Breaker Shape	T-DIA	with rake T-DIA	P
	Cutting conditions	B014		

H	Application	Precision finishing	Finishing
	Grade	BXM10	BXM20
	Breaker Shape	T-CBN	T-CBN
	Cutting conditions	B018	

Reference pages: A-ATFNR/L: Insert → **B086 -**, CBN → **B178 -**, PCD → **B194 -**



Cutting edge style U

Right hand (R) shown.

Inch	DMIN	DCON	WF	LF	Shank size	Insert
S16-SDUCR/L07-H	0.787	0.630	0.433	0.787	D/G.625	DC**0702...
S20-SDUCR/L11-H	0.984	0.787	0.512	0.787	D/G.750	DC**11T3...
S25-SDUCR/L11-H	1.260	0.984	0.669	0.787	D1.00	DC**11T3...
S32-SDUCR/L11T-H	1.575	1.260	0.866	1.260	D1.25	DC**11T3...
S40-SDUCR/L11T-H	1.969	1.575	1.063	1.260	D1.50, D2.00, D2.50	DC**11T3...

When using a right or left hand insert, the right hand insert (R) is used for the left hand toolholders (SDUCL** type), and the left hand insert (L) is used for the right hand toolholders (SDUCR** type).

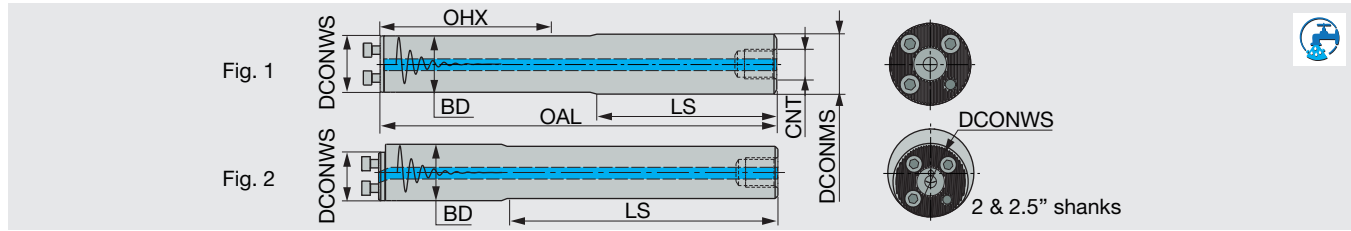
SPARE PARTS

Designation	Clamping screw	Wrench	Shim	Shim screw
S16-SDUCR/L07-H	SR14-548	T-7/5	-	-
S20-SDUCR/L11-H	SR16-236P	T-15/5	-	-
S25-SDUCR/L11-H	SR16-236P	T-15/5	-	-
S32-SDUCR/L11T-H	SR16-236P	T-15/5	TDC3-1P	SRTC-3P
S40-SDUCR/L11T-H	SR16-236P	T-15/5	TDC3-1P	SRTC-3P

INSERT SELECTION

P	Application	Finishing	Finishing to medium cutting	Medium cutting
	Grade	NS9530	T9215	T9215
	Breaker Shape	PSS	PS	PM
	Cutting conditions	B020		
M	Application	Precision finishing	Finishing	Finishing to medium cutting
	Grade	GH330	AH725	AH630
	Breaker Shape	W**	PSF	PSS
	Cutting conditions	B022		
K	Application	Finishing to medium cutting		
	Grade	T515		
	Breaker Shape	CM		
	Cutting conditions	B024		
N	Application	Precision finishing	Finishing	Medium cutting
	Grade	DX120	DX140	KS05F
	Breaker Shape	T-DIA	with rake T-DIA	AL
	Cutting conditions	B026		
S	Application	Finishing	Finishing to medium cutting	
	Grade	AH8015	AH8015	
	Breaker Shape	PSS	PS	
	Cutting conditions	B028		
H	Application	Precision finishing	Finishing	
	Grade	BXM10	BXM20	
	Breaker Shape	T-CBN	T-CBN	
	Cutting conditions	B030		

Reference pages: S-SDUCR/L-H: Insert → **B121** -, CBN → **B184**, PCD → **B196** -

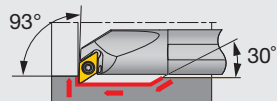


Inch	Material	DCONWS	DCONMS	BD	OAL	LS	OHX	CNT	Fig.
D.625-L6.14-7D-C	Steel	0.630	0.625	0.630	6.140	3.600	3.500	G1/8	1
G.625-L8.03-10D-E	Carbide	0.630	0.625	0.630	8.030	5.220	5.500	-	1
D.750-L7.87-7D-C	Steel	0.787	0.750	0.787	7.870	4.940	4.400	G1/4	1
G.750-L10.24-10D-E	Carbide	0.787	0.750	0.787	10.240	6.770	7.000	-	1
D1.00-L10.2-7D-C	Steel	0.984	1.000	0.984	10.200	6.830	6.200	G1/4	1
D1.00-L13.21-10D-C	Steel	0.984	1.000	0.984	13.210	8.650	9.200	G1/4	1
D1.25-L12.48-7D-C	Steel	1.260	1.250	1.260	12.480	7.370	7.500	G3/8	1
D1.25-L16.24-10D-C	Steel	1.260	1.250	1.260	16.240	9.670	11.200	G3/8	1
D1.50-L15.26-7D-C	Steel	1.575	1.500	1.575	15.260	9.130	9.200	G1/2	1
D1.50-L19.8-10D-C	Steel	1.575	1.500	1.575	19.800	13.350	13.700	G1/2	1
D2.00-L20.74-7D-C	Steel	1.575	2.000	2.000	20.740	-	12.700	G1/2	2
D2.00-L26.73-10D-C	Steel	1.575	2.000	2.000	26.730	-	18.700	G1/2	2
D2.50-L26.2-7D-C	Steel	1.575	2.500	2.500	26.200	-	16.200	G3/4	2
D2.50-L33.72-10D-C	Steel	1.575	2.500	2.500	33.720	-	23.700	G3/4	2

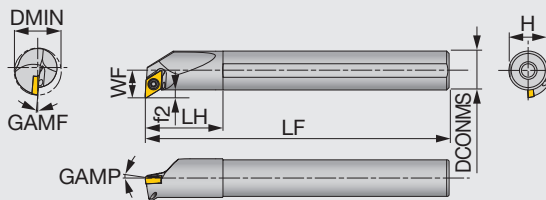
SPARE PARTS



Designation	Clamping screw	Wrench
D.625..., G.625...	SRM3X10DIN912	HW2.5
D.750..., G.750...	SRM3.5X10DIN912	HW2.5
D1.00...	SRM4X12DIN912	HW3.0
D1.25...	SRM5X12DIN912	HW4.0
D1.50..., D2.00... D2.50...	SRM6X16DIN912-12.9	HW5.0



Cutting edge style U



Right hand (R) shown.

Inch	Material	DMIN	DCONMS	WF	LF	LH	H	f2	GAMP	GAMF	RE**	Insert	Torque
A06-SDUCR2-D10	Steel	0.625	0.375	0.406	5.000	0.750	0.350	0.218	0°	-8°	0.016	DC**21.5...	0.89
A08-SDUCR/L2-D11	Steel	0.688	0.500	0.406	5.000	1.000	0.475	0.156	0°	-6°	0.016	DC**21.5...	0.89
A10-SDUCR2-D14	Steel	0.875	0.625	0.531	7.000	1.250	0.600	0.218	0°	-4°	0.016	DC**21.5...	0.89
A12-SDUCR/L3-D16	Steel	1.000	0.750	0.594	10.000	1.500	0.700	0.218	0°	-2°	0.032	DC**32.5...	2.2
E06-SDUCR2-D10	Carbide	0.625	0.375	0.406	5.000	1.000	0.375	0.218	0°	-7°	0.016	DC**21.5...	0.89
E08-SDUCR2-D11	Carbide	0.688	0.500	0.406	5.000	1.062	0.475	0.156	0°	-6°	0.016	DC**21.5...	0.89
E10-SDUCR2-D14	Carbide	0.875	0.625	0.531	7.000	1.250	0.600	0.218	0°	-4°	0.016	DC**21.5...	0.89
E12-SDUCR/L3-D16	Carbide	1.000	0.750	0.594	7.000	1.438	0.750	0.218	0°	-5°	0.032	DC**32.5...	2.2
Metric	Material	DMIN	DCONMS	WF	LF	LH	H	f2	GAMP	GAMF	RE**	Insert	Torque*
A10K-SDUCR/L07-D130	Steel	13	10	7	125	20	9	2	0°	-10°	0.4	DC**0702...	1.2
A12M-SDUCR/L07-D160	Steel	16	12	9.3	150	24	11	3.3	0°	-6°	0.4	DC**0702...	1.2
A16Q-SDUCR/L07-D200	Steel	20	16	11.3	180	32	15	3.3	0°	-5°	0.4	DC**0702...	1.2
A20R-SDUCR/L11-D270	Steel	27	20	16.1	200	36	18	6.1	0°	-5°	0.8	DC**11T3...	3
A25S-SDUCR/L11-D320	Steel	32	25	18.6	250	45	23	6.1	0°	-4°	0.8	DC**11T3...	3
E10H-SDUCR07-D130	Carbide	13	10	7	100	25	9	1.9	5°	-3.5°	0.4	DC**0702...	1.2
E10M-SDUCR/L07-D130	Carbide	13	10	7	150	25	9	2	0°	-10°	0.4	DC**0702...	1.2
E12J-SDUCR07-D160	Carbide	16	12	9.3	110	27	11	3.2	0°	-6°	0.4	DC**0702...	1.2
E12Q-SDUCR/L07-D160	Carbide	16	12	9.3	180	27	11	3.3	0°	-6°	0.4	DC**0702...	1.2
E16L-SDUCR07-D200	Carbide	20	16	11.3	130	32	15	3.2	0°	-5°	0.4	DC**0702...	1.2
E16R-SDUCR/L07-D200	Carbide	20	16	11.3	200	32	15	3.3	0°	-5°	0.4	DC**0702...	1.2
E20S-SDUCR11-D270	Carbide	27	20	16.1	250	36	18	6.1	0°	-5°	0.8	DC**11T3...	3

Torque: Recommended clamping torque: lbs-ft (*N-m) **RE : Standard corner radius

Use right-hand toolholders (SDUCR**) with left-hand inserts (L); and left-hand toolholders (SDUCL**) with right-hand inserts (R).

INCH SPARE PARTS

Designation	Clamping screw	Wrench
A/E06-SDUCR2-D10, A/E10-SDUCR2-D14	CSTB-2.5	T-8F
A08-SDUCR/L2-D11, E08-SDUCR2-D11	CSTB-2.5B	T-8F
A12-SDUCR/L3-D16	CSTB-3.5	T-15F
E12-SDUCR/L3-D16	CSTB-4S	T15-F

METRIC SPARE PARTS

Designation	Clamping screw	Wrench
A1**-SDUCR/L07-D1*0	CSTB-2.5S	T-8F
A16Q-SDUCR/L07-D200	CSTB-2.5	T-8F
A2**-SDUCR/L11-D**0	CSTB-4S	T-15F
E1**-SDUCR/L07-D1*0	CSTB-2.5S	T-8F
E16*-SDUCR/L07-D200	CSTB-2.5	T-8F
E20S-SDUCR11-D270	CSTB-4S	T-15F

INSERT SELECTION

P	Application	Precision finishing	Finishing	Finishing to medium cutting	Medium cutting
	Grade	SH725	SH725	T9215	T9215
	Breaker Shape	01	JS	PS	PM
	Cutting conditions	B020			

M	Application	Precision finishing	Finishing	Finishing to medium cutting	Medium cutting
	Grade	SH725	SH725	T9215	T9215
	Breaker Shape	01	JS	PS	PM
	Cutting conditions	B022			

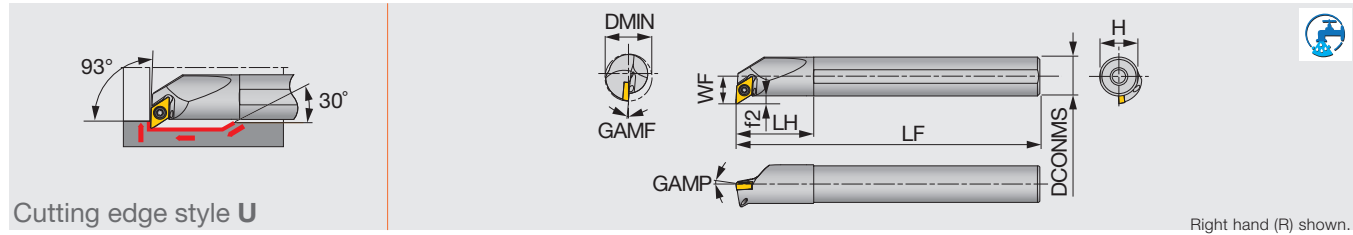
K	Application	Finishing to medium cutting
	Grade	T515
	Breaker Shape	CM
	Cutting conditions	B024

N	Application	Precision finishing	Medium cutting
	Grade	DX120	KS05F
	Breaker Shape	T-DIA with rake	AL
	Cutting conditions	B026	

S	Application	Precision finishing	Finishing to medium cutting
	Grade	BX470	AH8005
	Breaker Shape	T-CBN	PS
	Cutting conditions	B028	

H	Application	Precision finishing	Finishing
	Grade	BXM10	BXM20
	Breaker Shape	T-CBN	T-CBN
	Cutting conditions	B030	

Reference pages: A/E-SDUCR/L: Insert → **B121** -, CBN → **B184**, PCD → **B196** -



Cutting edge style U

Right hand (R) shown.

Metric	Material	DMIN	DCONMS	WF	LF	LH	H	f2	GAMP	GAMF	RE***	Insert	Torque
A12M-SDUPR07-D150-P	Special alloy steel*	15	12	8.3	150	24	11	2.3	5°	0°	0.4	DPMT0702...	1.2
A12M-SDUPL07-D150-P	Special alloy steel*	15	12	8.3	150	24	11	2.3	5°	0°	0.4	DPMT0702...	1.2
A12M-SDUPR07-D180-P	Special alloy steel*	18	12	10.3	150	24	11	4.3	5°	0°	0.4	DPMT0702...	1.2
A12M-SDUPL07-D180-P	Special alloy steel*	18	12	10.3	150	24	11	4.3	5°	0°	0.4	DPMT0702...	1.2
A16Q-SDUPR07-D220-P	Special alloy steel*	22	16	12.3	180	32	15	4.3	5°	0°	0.4	DPMT0702...	1.2
A16Q-SDUPL07-D220-P	Special alloy steel*	22	16	12.3	180	32	15	4.3	5°	0°	0.4	DPMT0702...	1.2
E12Q-SDUPR07-D150	Carbide	15	12	8.3	180	27	11	2.3	5°	0°	0.4	DPMT0702...	1.2
E12Q-SDUPL07-D150	Carbide	15	12	8.3	180	27	11	2.3	5°	0°	0.4	DPMT0702...	1.2
E12Q-SDUPR07-D180	Carbide	18	12	10.3	180	27	11	4.3	5°	0°	0.4	DPMT0702...	1.2
E12Q-SDUPL07-D180	Carbide	18	12	10.3	180	27	11	4.3	5°	0°	0.4	DPMT0702...	1.2
E16R-SDUPR07-D220	Carbide	22	16	12.3	200	32	15	4.3	5°	0°	0.4	DPMT0702...	1.2
E16R-SDUPL07-D220	Carbide	22	16	12.3	200	32	15	4.3	5°	0°	0.4	DPMT0702...	1.2

*Special alloy steel: Exclusively selected material is used to reduce chattering.

Torque: Recommended clamping torque: N·m

***RE : Standard corner radius

Use right-hand toolholders (SCLPR**) with left-hand inserts (L); and left-hand toolholders (SCLPL**) with right-hand inserts (R).

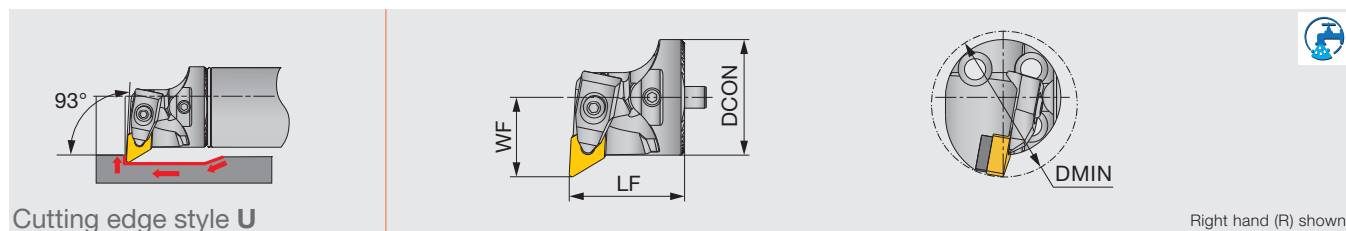
SPARE PARTS

Designation	Clamping screw	Wrench
A**-SDUPR/L07-D**0-P	CSTB-2.5S	T-8F
E**-SDUPR/L07-D**0	CSTB-2.5S	T-8F

INSERT SELECTION

P	Application	Finishing to medium cutting
	Grade	T9225 NS9530
	PS	PS
	Breaker Shape	
	Cutting conditions	B020

S	Application	Finishing to medium cutting
	Grade	AH8015
	PS	
	Breaker Shape	
	Cutting conditions	B028



Inch	DMIN	DCON	WF	LF	Shank size	Insert
S32-DDUNR/L11T-H	1.575	1.260	0.866	1.260	D1.25	DN**33...
S40-DDUNR/L15T-H	1.968	1.575	1.063	1.496	D1.50, D2.00, D2.50	DN**43/44...

When using a right or left hand insert, the right hand insert (R) is used for the left hand toolholders (DDUNL** type), and the left hand insert (L) is used for the right hand toolholders (DDUNR** type).

SPARE PARTS

Designation	Shim	Shim screw	Clamp	Clamping screw	Spring	Wrench
S32-DDUNR/L11T-H	RDT3-2	SR40085I	LCGR-3	SRRC3	KSP3	HW2.5
S40-DDUNR/L15T-H	RDT433	SR14-506	DLM4	DLS4	DSP4	HW3.0
S40-DDUNR/L15T-H	RDT443	SR14-506	DLM4	DLS4	DSP4	HW3.0

INSERT SELECTION

P	Application	Precision finishing	Finishing	Medium cutting	Medium to heavy cutting
	Grade	NS9530	GT9530	T9215	T9215
	Breaker Shape	TF	TSF	TM	TH
	Cutting conditions	B008			

M	Application	Finishing	Medium cutting	Medium to heavy cutting
	Grade	T6120	T6130	T6130
	Breaker Shape	SF	SM	SH
	Cutting conditions	B010		

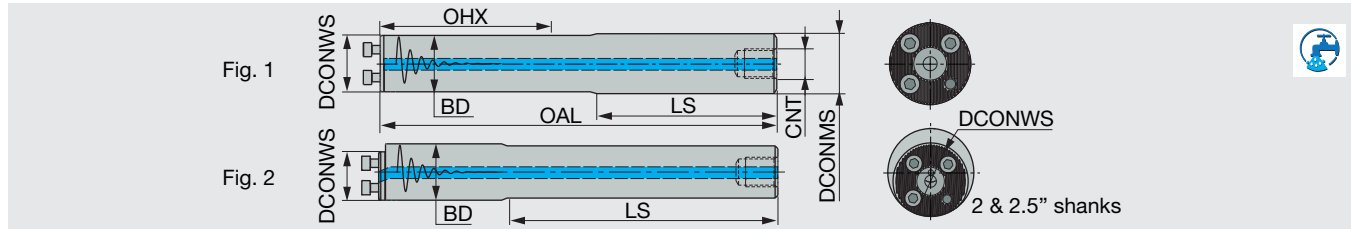
K	Application	Finishing	Medium cutting	Medium to heavy cutting
	Grade	T515	T515	T515
	Breaker Shape	All-round	All-round	All-round
	Cutting conditions	B012		

N	Application	Precision finishing	Finishing	Medium cutting
	Grade	DX120	DX140	TH10
	Breaker Shape	T-DIA	with rake T-DIA	P
	Cutting conditions	B014		

S	Application	Precision finishing	Finishing	Medium cutting
	Grade	BX470	AH8005	AH8005
	Breaker Shape	T-CBN	HRF	HRM
	Cutting conditions	B016		

H	Application	Precision finishing	Finishing
	Grade	BXM10	BXM20
	Breaker Shape	T-CBN	T-CBN
	Cutting conditions	B018	

Reference pages: S-DDUNR/L-H: Insert → **B067** -, CBN → **B174** -, PCD → **B194** -

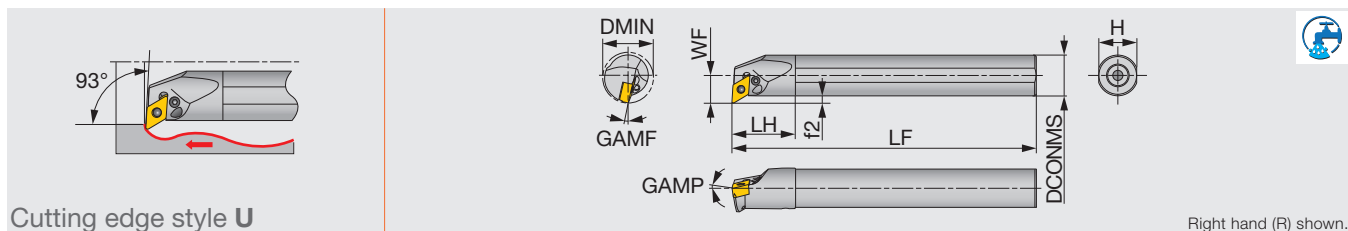


Inch	Material	DCONWS	DCONMS	BD	OAL	LS	OHX	CNT	Fig.
D.625-L6.14-7D-C	Steel	0.630	0.625	0.630	6.140	3.600	3.500	G1/8	1
G.625-L8.03-10D-E	Carbide	0.630	0.625	0.630	8.030	5.220	5.500	-	1
D.750-L7.87-7D-C	Steel	0.787	0.750	0.787	7.870	4.940	4.400	G1/4	1
G.750-L10.24-10D-E	Carbide	0.787	0.750	0.787	10.240	6.770	7.000	-	1
D1.00-L10.2-7D-C	Steel	0.984	1.000	0.984	10.200	6.830	6.200	G1/4	1
D1.00-L13.21-10D-C	Steel	0.984	1.000	0.984	13.210	8.650	9.200	G1/4	1
D1.25-L12.48-7D-C	Steel	1.260	1.250	1.260	12.480	7.370	7.500	G3/8	1
D1.25-L16.24-10D-C	Steel	1.260	1.250	1.260	16.240	9.670	11.200	G3/8	1
D1.50-L15.26-7D-C	Steel	1.575	1.500	1.575	15.260	9.130	9.200	G1/2	1
D1.50-L19.8-10D-C	Steel	1.575	1.500	1.575	19.800	13.350	13.700	G1/2	1
D2.00-L20.74-7D-C	Steel	1.575	2.000	2.000	20.740	-	12.700	G1/2	2
D2.00-L26.73-10D-C	Steel	1.575	2.000	2.000	26.730	-	18.700	G1/2	2
D2.50-L26.2-7D-C	Steel	1.575	2.500	2.500	26.200	-	16.200	G3/4	2
D2.50-L33.72-10D-C	Steel	1.575	2.500	2.500	33.720	-	23.700	G3/4	2

SPARE PARTS



Designation	Clamping screw	Wrench
D.625..., G.625...	SRM3X10DIN912	HW2.5
D.750..., G.750...	SRM3.5X10DIN912	HW2.5
D1.00...	SRM4X12DIN912	HW3.0
D1.25...	SRM5X12DIN912	HW4.0
D1.50..., D2.00... D2.50...	SRM6X16DIN912-12.9	HW5.0



Metric	Material	DMIN	DCONMS	WF	LF	LH	H	f2	GAMP	GAMF	RE**	Insert	Torque
A20Q-PDUNR/L1104-D250	Steel	25	20	13	180	36	18	3	-6°	-14°	0.8	DN**1104...	1.7

Torque: Recommended clamping torque: N·m

**RE : Standard corner radius

Use right-hand toolholders (PDUNR**) with left-hand inserts (L); and left-hand toolholders (PDUNL**) with right-hand inserts (R).

SPARE PARTS

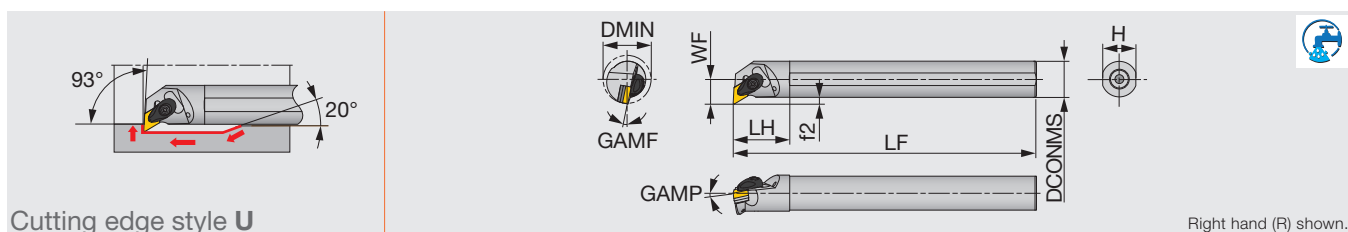
Designation	Clamping screw	Wrench	Lever	Oil supply attachment*	Screw for oil hole*
A20Q-PDUNR/L1104-D250	LCS22A	P-2F	LCL33NL	EA-20	SSHM2.5-3

*Optional

ISO TURN

A-ADUNR/L-Eco

Double-clamp boring bar, for negative 55° rhombic inserts



Inch	Material	DMIN	DCONMS	WF	LF	LH	H	f2	GAMP	GAMF	RE**	Insert	Torque
A16-ADUNR/L33-D20	Steel	1.250	1.000	0.672	12.000	1.750	0.906	0.172	-6°	-13°	0.031	DN**33...	2.21
A20-ADUNR/L33-D25	Steel	1.560	1.250	0.859	14.000	1.938	1.188	0.234	-6°	-11°	0.031	DN**33...	2.21

Torque: Recommended clamping torque: lbs·ft

**RE: Standard corner radius

SPARE PARTS

Designation	Clamp	Clamp screw	Spring	Spring pin	Shim	Shim screw	Wrench
A**-ADUNR/L...	ACP3S-E	ACS-5W	BP-7	SP-2.5	ASD322	CSTB-3.5	T-15F

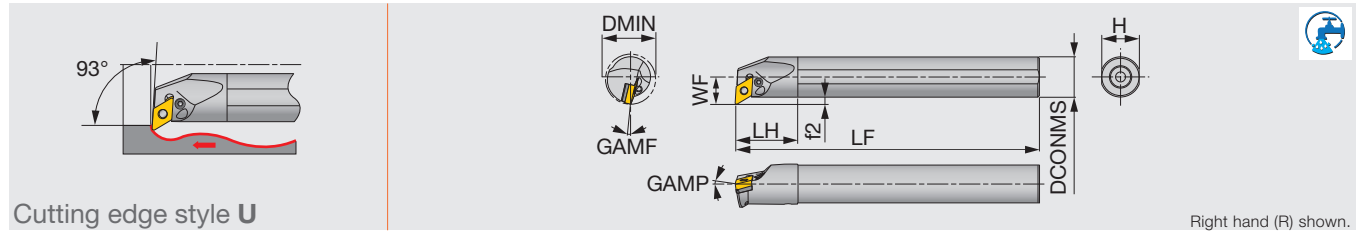
INSERT SELECTION

P	Application	Finishing	Medium cutting
	Grade	T9215	T9215
	Breaker Shape	TSF	TM
	Cutting conditions	B008	

M	Application	Finishing	Medium cutting
	Grade	T6120	T6130
	Breaker Shape	SS	SM
	Cutting conditions	B010	

K	Application	Medium cutting
	Grade	T515
	Breaker Shape	TM
	Cutting conditions	B012

Reference pages: A-PDUNR/L-Eco, A-ADUNR/L-Eco: Insert → **B067** -, CBN → **B174** -, PCD → **B194** -



Metric	Material	DMIN	DCONMS	WF	LF	LH	H	f2	GAMP	GAMF	RE**	Insert	Torque
A20Q-PDUNR/L11-D250	Steel	25	20	13	180	36	18	3	-6°	-14°	0.8	DN**1104...	1.7
A25R-PDUNR/L11-D320	Steel	32	25	17	200	45	23	4.5	-6°	-12°	0.8	DN**1104...	2.7
A32S-PDUNR/L15-D400	Steel	40	32	22	250	50	30	6	-6°	-13°	0.8	DN**1504...	4.8
A40T-PDUNR/L15-D500	Steel	50	40	27	300	60	37	7	-6°	-10°	0.8	DN**1504...	4.8
A50U-PDUNR/L15-D630	Steel	63	50	35	350	65	47	10	-6°	-8°	0.8	DN**1504...	4.8
A32S-PDUNR/L1506-D400	Steel	40	32	22	250	50	30	6	-6°	-13°	0.8	DN**1506...	4.8
A40T-PDUNR/L1506-D500	Steel	50	40	27	300	60	37	7	-6°	-11°	0.8	DN**1506...	4.8
A50U-PDUNR/L1506-D630	Steel	63	50	35	350	65	47	10	-6°	-10°	0.8	DN**1506...	4.8

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

SPARE PARTS

Designation	Shim	Clamping screw 1	Clamping screw 2	Wrench 1	Wrench 2	Spring pin	Lever	Oil supply attachment*	Screw for oil hole*
A20Q-PDUNR/L11-D250	-	LCS22A	-	P-2F	-	-	LCL33NL	EA-20	SSHM2.5-3
A25R-PDUNR/L11-D320	ELSD317BR/L	-	LCS3	-	P-2.5	LSP3	LCL33L	EA-25	SSHM3-4
A32S-PDUNR/L15-D400	LSD42BR/L	-	LCS4	-	P-3	LSP4	LCL4	EA-32	SSHM5-6
A40T-PDUNR/L15-D500	LSD42BR/L	-	LCS4	-	P-3	LSP4	LCL4	-	SSHM6-6
A50U-PDUNR/L15-D630	LSD42BR/L	-	LCS4	-	P-3	LSP4	LCL4	-	SSHM6-6
A32S-PDUNR/L1506-D400	ELSD42	-	ELCS4	-	P-3	LSP4S	LCL44	EA-20	SSHM5-6
A40T-PDUNR/L1506-D500	ELSD42	-	ELCS4	-	P-3	LSP4S	LCL44	-	SSHM6-6
A50U-PDUNR/L1506-D630	ELSD42	-	ELCS4	-	P-3	LSP4S	LCL44	-	SSHM6-6

*Optional

INSERT SELECTION

P	Application	Precision finishing	Finishing	Medium cutting	Medium to heavy cutting
	Grade	NS9530	GT9530	T9215	T9215
	Breaker Shape	TF	TSF	TM	TH
	Cutting conditions	B008			

K	Application	Finishing	Medium cutting	Medium to heavy cutting
	Grade	T515	T515	T515
	Breaker Shape	All-round	All-round	All-round
	Cutting conditions	B012		

S	Application	Precision finishing	Finishing	Medium cutting
	Grade	BX470	AH8005	AH8005
	Breaker Shape	T-CBN	HRF	HRM
	Cutting conditions	B016		

M	Application	Finishing	Medium cutting	Medium to heavy cutting
	Grade	T6120	T6130	T6130
	Breaker Shape	SF	SM	SH
	Cutting conditions	B010		

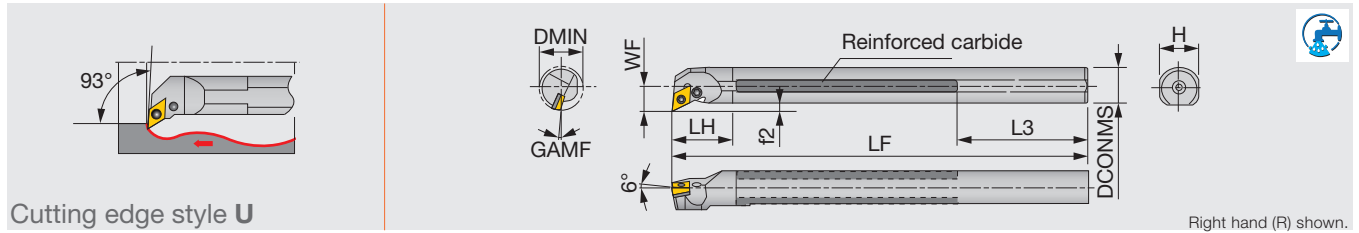
N	Application	Precision finishing	Finishing	Medium cutting
	Grade	DX120	DX140	TH10
	Breaker Shape	T-DIA with rake	T-DIA	P
	Cutting conditions	B014		

H	Application	Precision finishing	Finishing
	Grade	BXM10	BXM20
	Breaker Shape	T-CBN	T-CBN
	Cutting conditions	B018	

Reference pages: A-PDUNR/L: Insert → **B067** -, CBN → **B174** -, PCD → **B194** -

T-PDUNR

Lever-lock boring bar, for negative 55° rhombic inserts (Tsuppari-Ichiban)



Metric	Material	DMIN	CNT	DCONMS	WF	LF	LH	L3	H	f2	GAMF	RE**	Insert
T32U-PDUNR15C	Reinforced	40	Rc1/2	32	22	350	50	103	30	6	-13°	0.8	DN**1504...
T40V-PDUNR15C	Reinforced	50	Rc1/2	40	27	400	55	88	37	7	-10°	0.8	DN**1504...
T50W-PDUNR15C	Reinforced	63	Rc1/2	50	35	450	65	63	47	10	-8°	0.8	DN**1504...

**RE : Standard corner radius

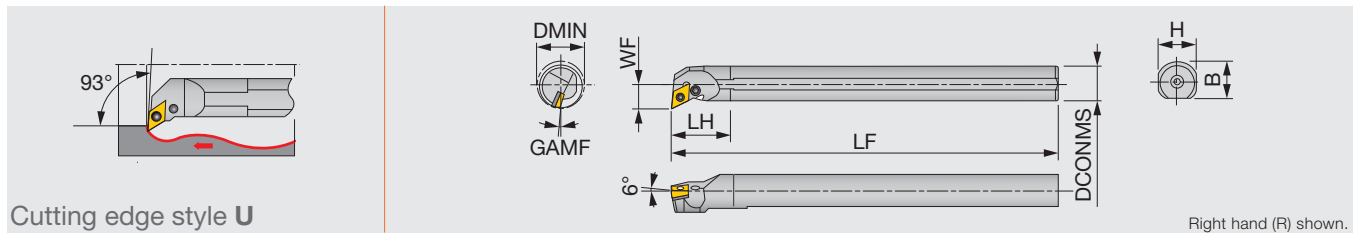
Use right-hand toolholders (R) with left-hand inserts (L); and left-hand toolholders (L) with right-hand inserts (R).

SPARE PARTS

Designation	Shim	Clamping screw	Wrench	Spring pin	Lever
T**-PDUNR15C	LSD42BR	LCS4	P-3	LSP4	LCL4

S-PDUNR/L

Lever-lock boring bar, for negative 55° rhombic inserts



Metric	Material	DMIN	DCONMS	WF	LF	LH	H	B	GAMF	RE**	Insert
S20Q-PDUNR/L11	Steel	25	20	13	180	35	18	19	-14°	0.8	DN**1104...
S25R-PDUNR/L11	Steel	32	25	17	200	40	23	24	-12°	0.8	DN**1104...
S32S-PDUNR/L15	Steel	40	32	22	250	50	30	29.5	-13°	0.8	DN**1504...
S40T-PDUNR/L15	Steel	50	40	27	300	55	37	37.5	-10°	0.8	DN**1504...
S50U-PDUNR/L15	Steel	63	50	35	350	65	47	47.5	-8°	0.8	DN**1504...

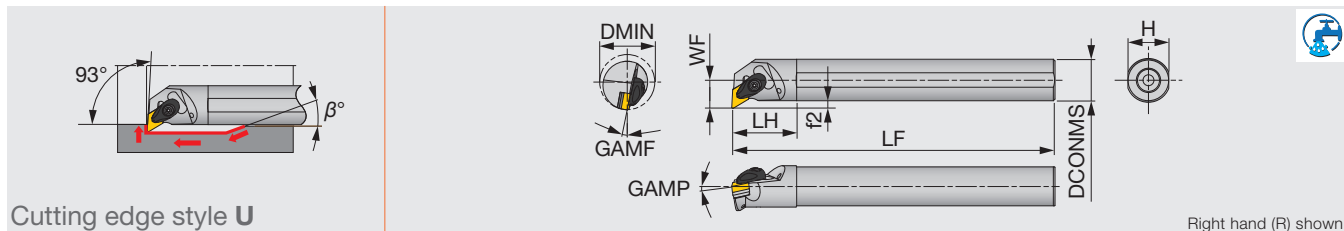
**RE : Standard corner radius

Use right-hand toolholders (R) with left-hand inserts (L); and left-hand toolholders (L) with right-hand inserts (R).

SPARE PARTS

Designation	Shim	Clamping screw 1	Clamping screw 2	Wrench 1	Wrench 2	Spring pin	Lever
S20Q-PDUNR/L11	-	LCS22A	-	P-2F	-	-	LCL33NL
S25R-PDUNR11	ELSD317BR	-	LCS3	-	P-2.5	LSP3	LCL33L
S25R-PDUNL11	ELSD317BL	-	LCS3	-	P-2.5	LSP3	LCL33L
S32S-PDUNR15	LSD42BR	-	LCS4	-	P-3	LSP4	LCL4
S32S-PDUNL15	LSD42BL	-	LCS4	-	P-3	LSP4	LCL4
S40T-PDUNR15	LSD42BR	-	LCS4	-	P-3	LSP4	LCL4
S40T-PDUNL15	LSD42BL	-	LCS4	-	P-3	LSP4	LCL4
S50U-PDUNR15	LSD42BR	-	LCS4	-	P-3	LSP4	LCL4
S50U-PDUNL15	LSD42BL	-	LCS4	-	P-3	LSP4	LCL4

Reference pages: T-PDUNR, S-PDUNR/L: Insert → **B067 -**, CBN → **B174 -**, PCD → **B194 -**



Cutting edge style U

Right hand (R) shown.

Inch	Material	DMIN	DCONMS	WF	LF	LH	H	f2	GAMP	GAMF	β°	RE**	Insert	Torque
A16-ADUNR/L4-D20	Steel	1.250	1.000	0.672	12.000	1.770	0.906	0.177	-6°	-13°	30	0.031	DN**43...	2.21
A20-ADUNR/L4-D25	Steel	1.500	1.250	0.859	14.000	1.960	1.180	0.236	-6°	-11°	20	0.031	DN**43...	2.21
A24-ADUNR/L4-D32	Steel	2.000	1.500	1.063	14.000	2.160	1.450	0.275	-6°	-8°	15	0.031	DN**43...	2.21

Torque: Recommended clamping torque: lbs-ft (*N-m) **RE : Standard corner radius

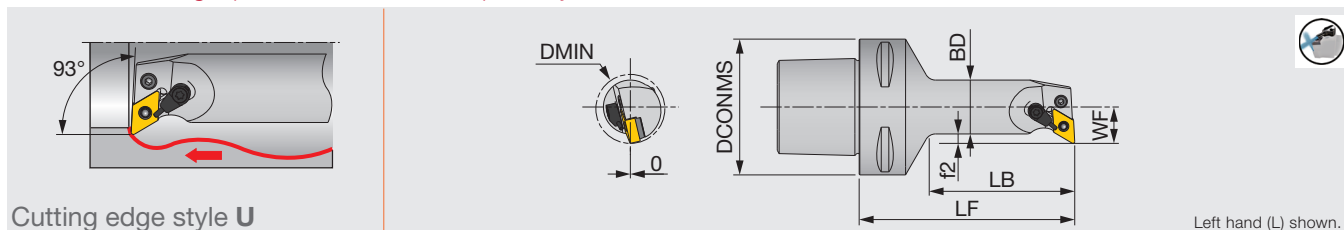
SPARE PARTS

Designation	Clamp	Clamp screw	Spring	Spring pin	Shim	Shim screw	Wrench
A*-ADUNR/L4-D...	ACP4S	ACS-5W	BP-7	SP-2.5	ASD432	CSTB-3.5	T-15F

TUNG TJET

C-PDUNL-CHP

Lever-lock boring bar with TungCap connection, with 93° approach angle, for negative 55° rhombic inserts, with high pressure coolant capability



Cutting edge style U

Left hand (L) shown.

Metric	DMIN	DCONMS	BD	LF	LB	WF	f2	RE**	Insert
C6PDUNL17100-1104-CHP	32	63	25	100	67.5	17	4.5	0.8	DN**1104...

Applicable for 14 MPa coolant

**RE : Standard corner radius

SPARE PARTS

Designation	Shim	Clamping screw	Coolant unit	Wrench	Spring pin	Lever
C6PDUNL17100-1104-CHP	ELSD317BL	LCS43	S-CU-CHP	P-2.5	LSP3	LCL33L

INSERT SELECTION

P	Application	Precision finishing	Finishing	Medium cutting	Medium to heavy cutting
	Grade	NS9530	GT9530	T9215	T9215
	Breaker Shape	TF	TSF	TM	TH
	Cutting conditions	B008			

K	Application	Finishing	Medium cutting	Medium to heavy cutting
	Grade	T515	T515	T515
	Breaker Shape	All-round	All-round	All-round
	Cutting conditions	B012		

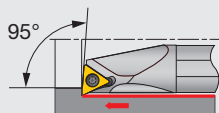
S	Application	Precision finishing	Finishing	Medium cutting
	Grade	BX470	AH8005	AH8005
	Breaker Shape	T-CBN	HRF	HRM
	Cutting conditions	B016		

M	Application	Finishing	Medium cutting	Medium to heavy cutting
	Grade	T6120	T6130	T6130
	Breaker Shape	SF	SM	SH
	Cutting conditions	B010		

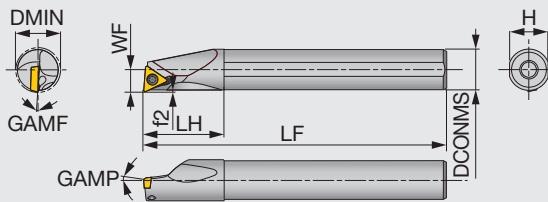
N	Application	Precision finishing	Finishing	Medium cutting
	Grade	DX120	DX140	TH10
	Breaker Shape	T-DIA	with rake T-DIA	P
	Cutting conditions	B014		

H	Application	Precision finishing	Finishing
	Grade	BXM10	BXM20
	Breaker Shape	T-CBN	T-CBN
	Cutting conditions	B018	

Reference pages: A-ADUNR/L, C-PDUNL-CHP Insert → B067 -, CBN → B174 -, PCD → B194 -



Cutting edge style U



Right hand (R) shown.

Inch	Material	DMIN	DCONMS	WF	LF	LH	H	f2	GAMP	GAMF	RE**	Insert	Torque
A05-STUPR/L7-D07	Steel	0.438	0.313	0.250	5.00	0.625	2.880	-	5°	-7°	0.016	TP**73...	0.66
A06-STUPR/L2-D08	Steel	0.500	0.375	0.281	5.00	0.750	0.350	-	5°	-5°	0.016	TP**21.5...	0.89
A08-STUPR/L2-D11	Steel	0.688	0.500	0.406	5.00	1.000	0.475	-	5°	-3°	0.016	TP**21.5...	0.89
A10-STUPR/L2-D14	Steel	0.875	0.625	0.531	7.00	1.250	0.600	-	5°	-2°	0.016	TP**21.5...	1.00
A10-STUPR/L2.5-D14	Steel	0.875	0.625	0.531	7.00	1.250	0.600	-	5°	-2°	0.016	TP**22...	1.00
A12-STUPR/L3-D16	Steel	1.000	0.750	0.594	7.00	1.437	0.725	-	5°	-2°	0.032	TP**32.5...	1.00
A16-STUPR/L3-D20	Steel	1.250	1.000	0.688	7.00	1.750	0.975	-	5°	0°	0.032	TP**32.5...	2.20
E05-STUPR7-D07	Carbide	0.438	0.313	0.250	5.00	0.625	2.880	-	5°	-7°	0.016	TP**73...	0.66
E06-STUPR2-D08	Carbide	0.500	0.375	0.281	5.00	0.750	0.350	-	5°	-5°	0.016	TP**21.5...	0.89
E08-STUPR2-D11	Carbide	0.688	0.500	0.406	5.00	1.000	0.475	-	5°	-3°	0.016	TP**21.5...	0.89
E10-STUPR2.5-D14	Carbide	0.875	0.625	0.531	7.00	1.250	0.600	-	5°	-2°	0.016	TP**22...	1.00

Torque: Recommended clamping torque: lbs-ft

**RE : Standard corner radius

Use right-hand toolholders (STUPR**) with left-hand inserts (L); and left-hand toolholders (STUPL**) with right-hand inserts (R).

SPARE PARTS

Designation	Clamping screw	Wrench
A05-STUPR/L7-D07	CSTB-2.2S	T-7F
A06-STUPR/L2-D08	CSTB-2.5S	T-8F
A08-STUPR/L2-D11	CSTB-2.5B	T-8F
A10-STUPR/L2-D14	CSTB-2.5	T-8F
A10-STUPR/L2.5-D14	CSTB-2.5	T-8F
A12-STUPR/L3-D16	CSTB-4M	T-15F
A16-STUPR/L3-D20	CSTB-4M	T-15F
E05-STUPR7-D07	CSTB-2.2S	T-7F
E06-STUPR2-D08	CSTB-2.5S	T-8F
E08-STUPR2-D11	CSTB-2.5B	T-8F
E10-STUPR2.5-D14	CSTB-3	T-9F

INSERT SELECTION

P	Application	Finishing	Finishing to medium cutting	Medium cutting
	Grade	SH725	T9215	T9215
	Breaker Shape	JS	PS	PM
	Cutting conditions	B020		

M	Application	Finishing	Finishing to medium cutting	Medium cutting
	Grade	SH725	T9215	T9215
	Breaker Shape	JS	PS	PM
	Cutting conditions	B022		

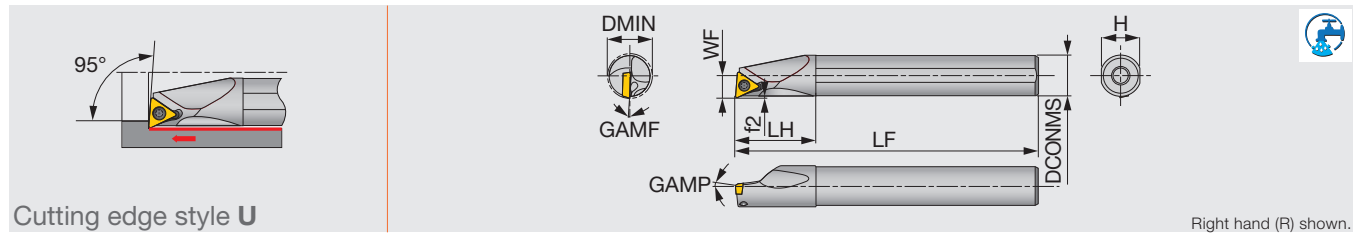
K	Application	Finishing to medium cutting
	Grade	T515
	Breaker Shape	CM
	Cutting conditions	B024

N	Application	Precision finishing
	Grade	DX120
	Breaker Shape	T-DIA with rake
	Cutting conditions	B026

S	Application	Precision finishing
	Grade	BX470
	Breaker Shape	T-CBN
	Cutting conditions	B028

H	Application	Precision finishing	Finishing
	Grade	BXM10	BXM20
	Breaker Shape	T-CBN	T-CBN
	Cutting conditions	B030	

Reference pages: A/E-STUPR/L: Insert → **B144** -, CBN → **B187** -, PCD → **B198**



Metric	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
A08H-STUPR/L09-D100	Steel	10	8	5.5	100	16	7.5	0.6	5°	-8°	0.4	TP**0902... ⁽¹⁾	0.9
A10F-STUPR1102-D120	Steel	12	10	6.5	80	20	9	1.4	5°	-6°	0.4	TP**1102... ⁽¹⁾	1.2
A10K-STUPR/L1102-D120	Steel	12	10	6.5	125	20	9	0.7	5°	-6°	0.4	TP**1102... ⁽¹⁾	1.2
A10K-STUPR/L1103-D120	Steel	12	10	6.5	125	20	9	0.6	5°	-10°	0.4	TP**1103... ⁽¹⁾	1.4
A12H-STUPR1102-D140	Steel	14	12	7	100	24	11	0.8	5°	-4°	0.4	TP**1102... ⁽¹⁾	1.2
A12M-STUPR/L1102-D140	Steel	14	12	7	150	24	11	0.8	5°	-4°	0.4	TP**1102... ⁽¹⁾	1.2
A12M-STUPR/L1103-D140	Steel	14	12	7	150	24	11	0.6	5°	-6°	0.4	TP**1103... ⁽¹⁾	1.4
A12H-STUPR1102-D160	Steel	16	12	9	100	24	11	0.6	5°	-3°	0.4	TP**1102... ⁽¹⁾	1.2
A12M-STUPR/L1102-D160	Steel	16	12	9	150	24	11	0.6	5°	-3°	0.4	TP**1102... ⁽¹⁾	1.2
A16K-STUPR13-D180	Steel	18	16	9	125	32	15	0.8	5°	-3°	0.4	TP**1303... ⁽¹⁾	1.4
A16K-STUPR/L1103-D180	Steel	18	16	9	180	32	15	0.8	5°	-4°	0.4	TP**1103... ⁽¹⁾	1.4
A16Q-STUPR/L13-D180	Steel	18	16	9	180	32	15	0.8	5°	-3°	0.4	TP**1303... ⁽¹⁾	1.4
A16K-STUPR13-D200	Steel	20	16	11	125	32	15	0.6	5°	-3°	0.4	TP**1303... ⁽¹⁾	1.4
A16Q-STUPR/L13-D200	Steel	20	16	11	180	32	15	0.6	5°	-3°	0.4	TP**1303... ⁽¹⁾	1.4
A20R-STUPR/L13-D220	Steel	22	20	11	200	36	18	0.7	5°	-2°	0.4	TP**1303... ⁽¹⁾	1.4
A25S-STUPR/L16-D270	Steel	27	25	13.5	250	45	23	0.5	5°	-1°	0.8	TP**16T3... ⁽¹⁾	3
A32T-STUPR/L16-D340	Steel	34	32	17	300	50	30	0.7	5°	0°	0.8	TP**16T3...	3
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
E08G-STUPR09-D100	Carbide	10	8	5.5	90	22	7	0.6	5°	-8°	0.4	TP**0902... ⁽¹⁾	0.9
E08K-STUPR/L09-D100	Carbide	10	8	5.5	125	22	7	0.6	5°	-8°	0.4	TP**0902... ⁽¹⁾	0.9
E10F-STUPR1102-D120	Carbide	12	10	6.5	80	25	9	0.5	5°	-6°	0.4	TP**1102... ⁽¹⁾	1.2
E10H-STUPR1102-D120	Carbide	12	10	6.5	100	25	9	0.6	5°	-6°	0.4	TP**1102... ⁽¹⁾	1.2
E10M-STUPR/L1102-D120	Carbide	12	10	6.5	150	25	9	0.6	5°	-6°	0.4	TP**1102... ⁽¹⁾	1.2
E10M-STUPR/L1103-D120	Carbide	12	10	6.5	150	25	9	0.7	5°	-10°	0.4	TP**1103... ⁽¹⁾	1.4
E12G-STUPR1102-D140	Carbide	14	12	7	90	27	11	0.8	5°	-4°	0.4	TP**1102... ⁽¹⁾	1.2
E12J-STUPR1102-D140	Carbide	14	12	7	110	27	11	0.8	5°	-4°	0.4	TP**1102... ⁽¹⁾	1.2
E12Q-STUPR/L1102-D140	Carbide	14	12	7	180	27	11	0.8	5°	-4°	0.4	TP**1102... ⁽¹⁾	1.2
E12Q-STUPR/L1103-D140	Carbide	14	12	7	180	27	11	0.7	5°	-6°	0.4	TP**1103... ⁽¹⁾	1.4
E12G-STUPR1102-D160	Carbide	16	12	9	90	27	11	0.6	5°	-3°	0.4	TP**1102... ⁽¹⁾	1.2
E12J-STUPR1102-D160	Carbide	16	12	9	110	27	11	0.6	5°	-3°	0.4	TP**1102... ⁽¹⁾	1.2
E12Q-STUPR/L1102-D160	Carbide	16	12	9	180	27	11	0.6	5°	-3°	0.4	TP**1102... ⁽¹⁾	1.2
E16H-STUPR13-D180	Carbide	18	16	9	100	32	15	0.9	5°	-3°	0.4	TP**1303... ⁽¹⁾	1.4
E16R-STUPR/L1103-D180	Carbide	18	16	9	200	32	15	0.8	5°	-3°	0.4	TP**1103... ⁽¹⁾	1.4
E16L-STUPR13-D180	Carbide	18	16	9	130	32	15	0.6	5°	-3°	0.4	TP**1303... ⁽¹⁾	1.4
E16R-STUPR/L13-D180	Carbide	18	16	9	200	32	15	0.6	5°	-3°	0.4	TP**1303... ⁽¹⁾	1.4
E16H-STUPR13-D200	Carbide	20	16	11	100	32	15	0.6	5°	-3°	0.4	TP**1303... ⁽¹⁾	1.4
E16L-STUPR13-D200	Carbide	20	16	11	130	32	15	0.6	5°	-3°	0.4	TP**1303... ⁽¹⁾	1.4
E16R-STUPR13-D200	Carbide	20	16	11	200	32	15	0.6	5°	-3°	0.4	TP**1303... ⁽¹⁾	1.4
E20S-STUPR1103-D220	Carbide	22	20	11	250	36	18	0.7	5°	-2°	0.4	TP**1103... ⁽¹⁾	1.4
E20S-STUPR13-D220	Carbide	22	20	11	250	36	18	0.6	5°	-2°	0.4	TP**1303... ⁽¹⁾	1.4
E25T-STUPR16-D270	Carbide	27	25	13.5	300	45	23	0.5	5°	-1°	0.8	TP**16T3...	3

SPARE PARTS

Designation	Clamping screw	Wrench
A/E07*-STUPR/L07-...	CSTB-2.2L038	T-7F
A/E08*-STUPR/L07-...	CSTB-2.2L038	T-7F
A/E08*-STUPR/L09-...	CSTB-2.2L038	T-7F
A/E10*-STUPR/L1102-...	CSTB-2.5S	T-8F
A/E10*-STUPR/L1103-...	CSTB-3L050	T-9F
A/E12*-STUPR/L1102-...	CSTB-2.5B	T-8F
A/E12*-STUPR/L1103-...	CSTB-3L050	T-9F
A/E16*-STUPR/L1103-...	CSTB-3S	T-9F
A/E16*-STUPR/L13-...	CSTB-3S	T-9F
A/E20*-STUPR/L1103-...	CSTB-3S	T-9F
A/E20*-STUPR/L13-...	CSTB-3	T-9F
A/E25*-STUPR/L16-...	CSTB-4M	T-15F
A32*-STUPR/L16-...	CSTB-4M	T-15F

Torque: Recommended clamping torque: N·m

**RE : Standard corner radius

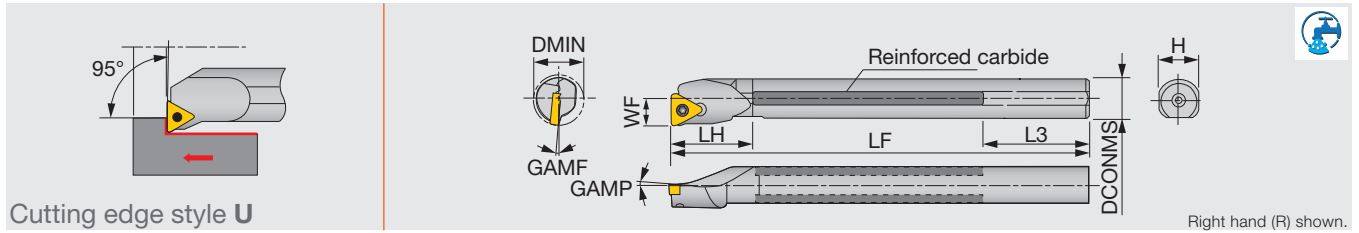
Use right-hand toolholders (STUPR**) with left-hand inserts (L); and left-hand toolholders (STUPL**) with right-hand inserts (R).

(1) TPGH, TPGM, and TPGA inserts cannot be used.

Reference pages: A/E-STUPR/L: Insert → **B144 -**,
CBN → **B187 -**, PCD → **B198**

T-STUPR/L

Screw-on boring bar, for positive 60° triangular inserts (Tsuppari-Ichiban)



Right hand (R) shown.

Metric	Material	DMIN	CNT**	DCONMS	WF	LF	LH	L3	H	GAMP	GAMF	RE**	Insert	Torque
T12M-STUPR11-D14	Reinforced	14	-	12	7	150	24	59	11	5°	-4°	0.4	TP**1102...	1.2
T12M-STUPR/L11	Reinforced	16	-	12	9	150	25	58	11	5°	-4°	0.4	TP**1102...	1.2
T16Q-STUPR13-D18	Reinforced	18	-	16	9	180	30	59	15	5°	-3.5°	0.4	TP**1303...	1.4
T16Q-STUPR/L13	Reinforced	20	-	16	11	180	30	59	15	5°	-3°	0.4	TP**1303...	1.4
T20R-STUPR13C-D22	Reinforced	22	Rc1/4	20	11	200	35	49	18	5°	-2°	0.4	TP**1303...	1.4
T20R-STUPR/L13	Reinforced	24	-	20	13	200	40	49	18	5°	-2°	0.4	TP**1303...	1.4
T25S-STUPR16C-D27	Reinforced	27	Rc1/4	25	13.5	250	40	64	23	5°	-1°	0.8	TP**16T3...	3
T25S-STUPR/L16	Reinforced	31	-	25	17	250	45	64	23	5°	0°	0.8	TP**16T3...	3

Torque: Recommended clamping torque: N·m

**RE : Standard corner radius

***CNT : Threading size at the tail port

Use right-hand toolholders (STUPR**) with left-hand inserts (L); and left-hand toolholders (STUPL**) with right-hand inserts (R).

SPARE PARTS

Designation	Clamping screw	Wrench
T12M-STUPR11-D14	CSTB-2.5B	T-8F
T12M-STUPR/L11	CSTB-2.5	T-8F
T16Q-STUPR13-D18	CSTB-3S	T-9F
T16Q-STUPR/L13	CSTB-3	T-9F
T20R-STUPR13C-D22	CSTB-3S	T-9F
T20R-STUPR/L13	CSTB-3	T-9F
T25S-STUPR/L16...	CSTB-4S	T-15F

INSERT SELECTION

P	Application	Precision finishing	Finishing	Finishing to medium cutting	Medium cutting
	Grade	NS9530	NS9530	T9215	T9215
	Breaker Shape	01	PSS	PS	PM
	Cutting conditions	B020			

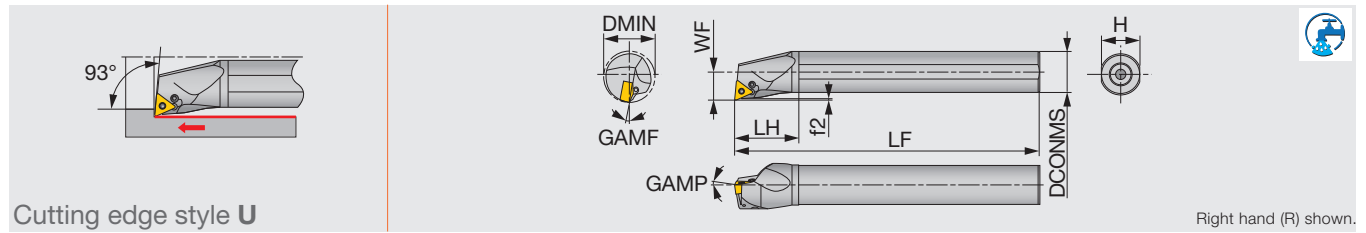
M	Application	Finishing	Finishing to medium cutting	Medium cutting
	Grade	AH725	AH630	T6130
	Breaker Shape	PSF	PSS	PM
	Cutting conditions	B022		

K	Application	Finishing to medium cutting
	Grade	T515
	Breaker Shape	CM
	Cutting conditions	B024

N	Application	Finishing
	Grade	DX140
	Breaker Shape	T-DIA
	Cutting conditions	B026

H	Application	Precision finishing	Finishing
	Grade	BXM10	BXM20
	Breaker Shape	T-CBN	T-CBN
	Cutting conditions	B030	

Reference pages: T-STUPR/L: Insert → B144 -, CBN → B187 -, PCD → B198



Metric	Material	DMIN	DCONMS	WF	LF	LH	H	f2	GAMP	GAMF	RE**	Insert	Torque
A25R-PTUNR/L1104-D320	Steel	32	25	17	200	45	23	1.22	-6°	-12°	0.8	TN**1104...	2
A32S-PTUNR/L1104-D400	Steel	40	32	22	250	50	30	1.16	-6°	-10°	0.8	TN**1104...	2

Torque: Recommended clamping torque: N·m

**RE: Standard corner radius

SPARE PARTS

Designation	Clamping screw	Wrench	Lever	Oil supply attachment*	Screw for oil hole*
A25R-PTUNR/L1104-D320	LCS23A	P-2.5	LCL23	EA-25	SSHM4-5
A32S-PTUNR/L1104-D400	LCS23A	P-2.5	LCL23	EA-32	SSHM4-5

*Optional

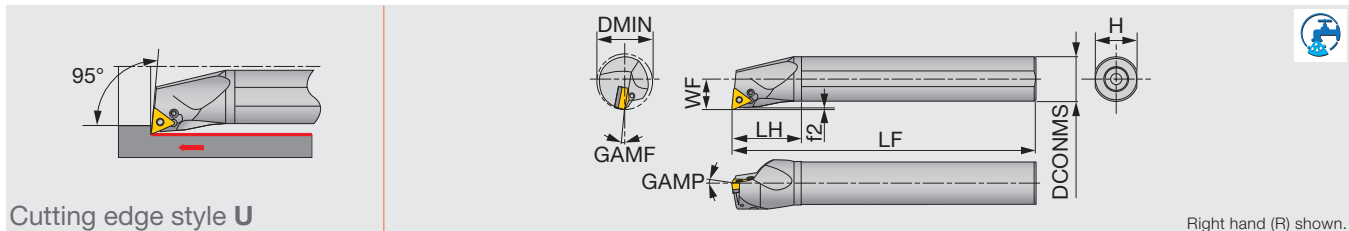
INSERT SELECTION

P	Application	Finishing	Medium cutting
	Grade	T9215	T9215
	Breaker Shape	TSF	TM
	Cutting conditions	B008	

M	Application	Finishing	Medium cutting
	Grade	T6120	T6130
	Breaker Shape	SS	SM
	Cutting conditions	B010	

A-PTUNR/L

Lever-lock boring bar, for negative 60° triangular inserts



Cutting edge style U

Right hand (R) shown.

Metric	Material	DMIN	DCONMS	WF	LF	LH	H	f2	GAMP	GAMF	RE**	Insert	Torque
A16M-PTUNR/L11-D200	Steel	20	16	11	150	32	15	1	-6°	-14°	0.4	TN**1103...	1.7
A20Q-PTUNR/L11-D250	Steel	25	20	13	180	36	18	1	-6°	-12°	0.4	TN**1103...	1.7
A25R-PTUNR/L16-D320	Steel	32	25	17	200	45	23	1.4	-6°	-12°	0.8	TN**1604...	2.7
A32S-PTUNR/L16-D400	Steel	40	32	22	250	50	30	1.3	-6°	-10°	0.8	TN**1604...	2.7

Torque: Recommended clamping torque: N·m

**RE : Standard corner radius

*The hole specification of applicable inserts conforms to ISO standard.

Toolholder length may not conform to ISO standard.

Use right-hand toolholders (PTUNR**) with left-hand inserts (L); and left-hand toolholders (PTUNL**) with right-hand inserts (R).

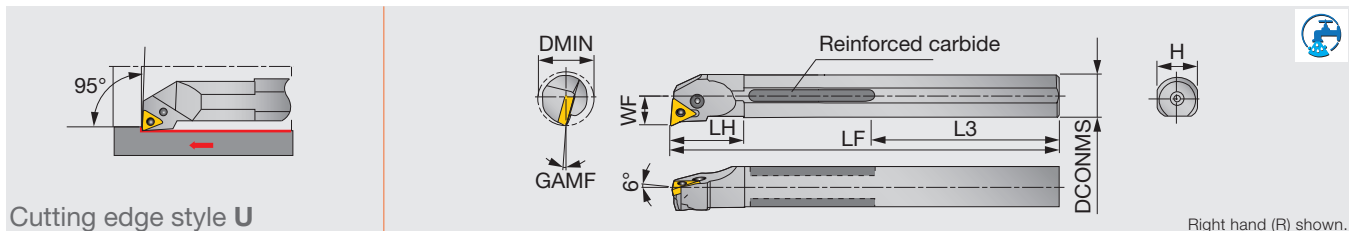
SPARE PARTS

Designation	Shim	Clamping screw 1	Clamping screw 2	Wrench 1	Wrench 2	Spring pin	Lever	Oil supply attachment*	Screw for oil hole*
A16M-PTUNR/L11-D200	-	LCS22A	-	P-2F	-	-	LCL22N	-	SSHM3-4
A20Q-PTUNR/L11-D250	-	LCS22A	-	P-2F	-	-	LCL22N	EA-20	SSHM3-4
A25R-PTUNR/L16-D320	ELST317BR/L	-	LCS3	-	P-2.5	LSP3	LCL33	EA-25	SSHM4-5
A32S-PTUNR/L16-D400	LST317BR/L	-	LCS3	-	P-2.5	LSP3	LCL3	EA-32	SSHM4-5

*Optional

T-PTUNR

Lever-lock boring bar, for negative 60° triangular inserts (Tsuppari-Ichiban)



Cutting edge style U

Right hand (R) shown.

Metric	Material	DMIN	CNT***	DCONMS	WF	LF	LH	L3	H	GAMP	RE**	Insert	Torque
T16Q-PTUNR11	Reinforced	20	-	16	11	180	27	59	15	-14°	0.4	TN**1103...	1.7
T20R-PTUNR11C	Reinforced	25	Rc1/4	20	13	200	35	49	18	-12°	0.4	TN**1103...	1.7
T25S-PTUNR16C	Reinforced	32	Rc1/4	25	17	250	40	64	23	-12°	0.8	TN**1604...	2.7
T32U-PTUNR16C	Reinforced	40	Rc1/2	32	22	350	50	103	30	-10°	0.8	TN**1604...	2.7
T40V-PTUNR16C	Reinforced	50	Rc1/2	40	27	400	55	88	37	-10°	0.8	TN**1604...	2.7
T50W-PTUNR16C	Reinforced	63	Rc1/2	50	35	450	65	63	47	-8°	0.8	TN**1604...	2.7

Torque: Recommended clamping torque: N·m

**RE : Standard corner radius

***CNT : Threading size at the tail port

*The hole specification of applicable inserts conforms to ISO standard.

Toolholder length may not conform to ISO standard.

Use right-hand toolholders (R) with left-hand inserts (L); and left-hand toolholders (L) with right-hand inserts (R).

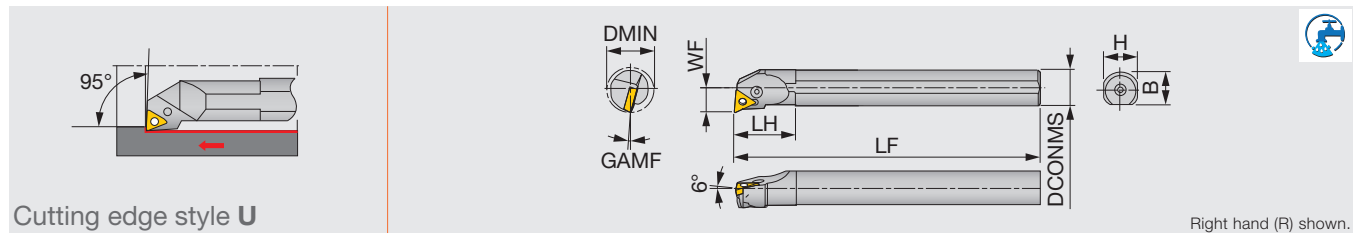
SPARE PARTS

Designation	Shim	Clamping screw 1	Clamping screw 2	Wrench 1	Wrench 2	Spring pin	Lever
T**-PTUNR11...	-	LCS22A	-	P-2F	-	-	LCL22N
T25S-PTUNR16C	ELST317BR	-	LCS3	-	P-2.5	LSP3	LCL33
T**-PTUNR16C	LST317BR	-	LCS3	-	P-2.5	LSP3	LCL3

Reference pages: A-PTUNR/L, T-PTUNR: Insert → **B086 -**, CBN → **B178 -**, PCD → **B194 -**

A/S-PTUNR/L

Lever-lock boring bar, for negative 60° triangular inserts



Cutting edge style U

Right hand (R) shown.

Metric	Material	DMIN	DCONMS	WF	LF	LH	H	B	GAMF	RE**	Insert	Torque
S16M-PTUNR/L11	Steel	20	16	11	150	30	15	15.5	-14°	0.4	TN**1103...	1.7
S20Q-PTUNR/L11	Steel	25	20	13	180	35	18	19	-12°	0.4	TN**1103...	1.7
S25R-PTUNR/L16	Steel	32	25	17	200	40	23	24	-12°	0.8	TN**1604...	2.7
A32S-PTUNR/L16	Steel	40	32	22	250	50	30	29.5	-12°	0.8	TN**1604...	2.7

Torque: Recommended clamping torque: N·m

**RE : Standard corner radius

*The hole specification of applicable inserts conforms to ISO standard.

Toolholder length may not conform to ISO standard.

Use right-hand toolholders (R) with left-hand inserts (L); and left-hand toolholders (L) with right-hand inserts (R).

SPARE PARTS								
Designation	Shim	Clamping screw 1	Clamping screw 2	Wrench 1	Wrench 2	Spring pin	Lever	Oil supply attachment*
S**-PTUNR/L11	-	LCS22A	-	P-2F	-	-	LCL22N	-
S25R-PTUNR16	ELST317BR	-	LCS3	-	P-2.5	LSP3	LCL33	-
S25R-PTUNL16	ELST317BL	-	LCS3	-	P-2.5	LSP3	LCL33	-
A32S-PTUNR16	LST317BR	-	LCS3	-	P-2.5	LSP3	LCL3	EA-32
A32S-PTUNL16	LST317BL	-	LCS3	-	P-2.5	LSP3	LCL3	EA-32

*Optional

INSERT SELECTION

P	Application	Precision finishing	Finishing	Medium cutting	Medium to heavy cutting
	Grade	NS9530	GT9530	T9215	T9215
	Breaker Shape				
	Cutting conditions	B008			

M	Application	Finishing	Medium cutting
	Grade	T6120	T6130
	Breaker Shape		
	Cutting conditions	B010	

K	Application	Finishing	Medium cutting	Medium to heavy cutting
	Grade	T515	T515	T515
	Breaker Shape			
	Cutting conditions	B012		

N	Application	Precision finishing	Finishing	Medium cutting
	Grade	DX120	DX140	TH10
	Breaker Shape			
	Cutting conditions	B014		

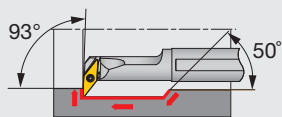
S	Application	Precision finishing	Finishing	Medium cutting
	Grade	BX470	AH8005	AH8005
	Breaker Shape			
	Cutting conditions	B016		

H	Application	Precision finishing	Finishing
	Grade	BXM10	BXM20
	Breaker Shape		
	Cutting conditions	B018	

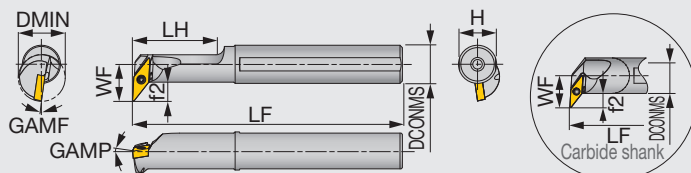
Reference pages: A/S-PTUNR/L: Insert → B086 -, CBN → B178 -, PCD → B194 -

A/E-SVUBR/L

Screw-on boring bar, for positive 35° rhombic inserts



Cutting edge style U



Right hand (R) shown.

Inch	Material	DMIN	DCONMS	WF	LF	LH	H	f2	GAMP	GAMF	RE**	Insert	Torque
A12-SVUBR2-D16	Steel	1.000	0.750	0.594	10.000	1.425	0.725	0.218	-0°	-6°	0.016	VB**22...	0.89

Metric	Material	DMIN	DCONMS	WF	LF	LH	H	f2	GAMP	GAMF	RE**	Insert	Torque*
A16Q-SVUBR/L11-D200	Steel	20	16	15.5	180	35	15	8	0°	-8°	0.4	VB**1103...	1.2
A20R-SVUBR/L11-D250	Steel	25	20	17.5	200	40	19	8	0°	-7°	0.4	VB**1103...	1.2
A25S-SVUBR/L16-D320	Steel	32	25	20.5	250	50	23	8.5	0°	-6°	0.8	VB**1604...	3
E16R-SVUBR/L11-D245	Carbide	24.5	16	16	200	-	15	8	0°	-8°	0.4	VB**1103...	1.2
E20S-SVUBR/L11-D285	Carbide	28.5	20	18	250	-	19	8	0°	-7°	0.4	VB**1103...	1.2
E25T-SVUBR/L16-D340	Carbide	34	25	21	300	-	23	8.5	0°	-6°	0.8	VB**1604...	3

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

**RE : Standard corner radius

Use right-hand toolholders (SVUBR**) with left-hand inserts (L); and left-hand toolholders (SVUBL**) with right-hand inserts (R).

SPARE PARTS

Designation	Clamping screw	Wrench
A12-SVUBR2-D16	CSTB-2.5	T-8F
A**-SVUBR/L11-D2*0	CSTB-2.5	T-8F
A25S-SVUBR/L16-D320	CSTB-3.5	T-15F
E**-SVUBR/L11-D2*5	CSTB-2.5	T-8F
E25T-SVUBR/L16-D340	CSTB-3.5	T-15F

INSERT SELECTION

P	Application	Finishing	Finishing to medium cutting
	Grade	SH725	T9215
	Breaker Shape	JS	PS
	Cutting conditions	B020	

M	Application	Finishing	Finishing to medium cutting
	Grade	SH725	T9215
	Breaker Shape	JS	PS
	Cutting conditions	B022	

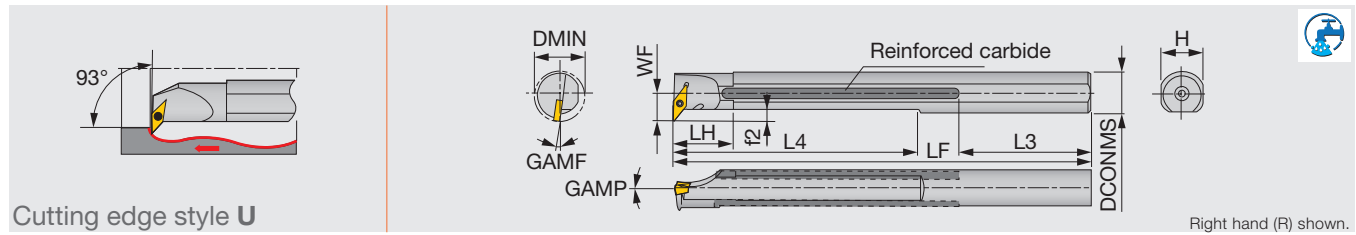
K	Application	Finishing to medium cutting
	Grade	T515
	Breaker Shape	CM
	Cutting conditions	B024

H	Application	Precision finishing	Finishing
	Grade	BXM10	BXM20
	Breaker Shape	T-CBN	T-CBN
	Cutting conditions	B030	

Reference pages: A/E-SVUBR/L: Insert → **B152 -**, CBN → **B191**

T-SVUBR

Screw-on boring bar, for positive 35° rhombic inserts (Tsuppari-Ichiban)



Metric	Material	DMIN	CNT***	DCONMS	WF	LF	LH	L3	L4	H	f2	GAMP	GAMF	RE**	Insert	Torque
T20R-SVUBR11C	Reinforced	25	Rc1/4	20	14	200	30	59	121	18	4	0°	-8°	0.4	VB**1103...	1.2

Torque: Recommended clamping torque: N·m

**RE : Standard corner radius

***CNT : Threading size at the tail port

Use right-hand toolholders (SVUBR**) with left-hand inserts (L).

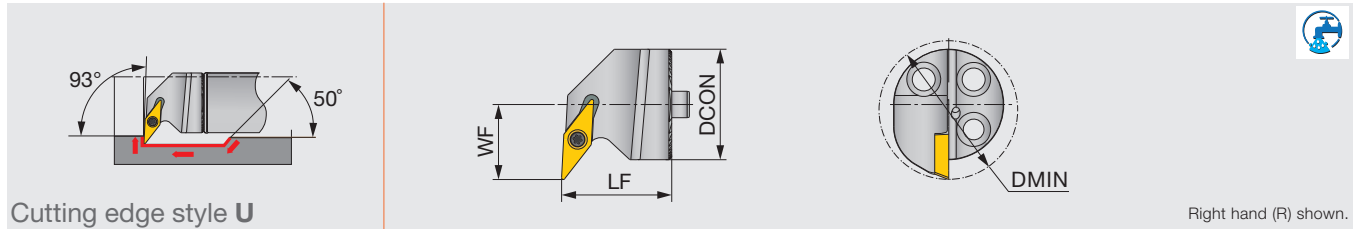
SPARE PARTS

Designation	Clamping screw	Wrench
T20R-SVUBR11C	CSTB-2.5	T-8F

INSERT SELECTION

P	Application	Finishing	Finishing to medium cutting
	Grade	NS9530	T9215
	Breaker Shape	PSS	PS
	Cutting conditions	B020	
M	Application	Finishing	Finishing to medium cutting
	Grade	AH725	AH630
	Breaker Shape	PSF	PSS
	Cutting conditions	B022	
K	Application	Finishing to medium cutting	
	Grade	T515	
	Breaker Shape	CM	
	Cutting conditions	B024	
S	Application	Finishing	Finishing to medium cutting
	Grade	AH8015	AH8015
	Breaker Shape	PSS	PS
	Cutting conditions	B028	
H	Application	Precision finishing	Finishing
	Grade	BXM10	BXM20
	Breaker Shape	T-CBN	T-CBN
	Cutting conditions	B030	

Reference pages: T-SVUBR: Insert → **B152** -, CBN → **B191**



Cutting edge style U

Right hand (R) shown.

Inch	DMIN	DCON	WF	LF	Shank size	Insert
S20-SVUCR/L11-H	1.063	0.787	0.630	0.787	D/G.750	VC**1103...
S25-SVUCR/L11-H	1.260	0.984	0.669	0.984	D1.00	VC**1103...

When using a right or left hand insert, the right hand insert (R) is used for the left hand toolholders (SVUCL** type), and the left hand insert (L) is used for the right hand toolholders (SVUCR** type).

SPARE PARTS

Designation	Clamping screw	Wrench
S**-SVUCR/L11-H	SR14-560	T-8/5

INSERT SELECTION

P	Application	Finishing	Finishing to medium cutting
	Grade	NS9530	T9215
	Breaker Shape	PSS	PS
	Cutting conditions	B020	

M	Application	Finishing	Finishing to medium cutting	Medium cutting
	Grade	AH725	AH630	T6130
	Breaker Shape	PSF	PSS	PM
	Cutting conditions	B022		

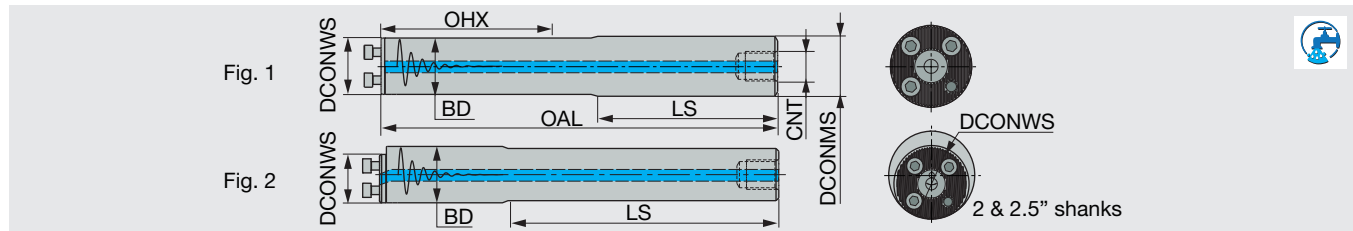
K	Application	Finishing to medium cutting
	Grade	T515
	Breaker Shape	CM
	Cutting conditions	B024

N	Application	Precision finishing	Finishing	Medium cutting
	Grade	DX120	DX140	KS05F
	Breaker Shape	T-DIA with rake	T-DIA	AL
	Cutting conditions	B026		

S	Application	Finishing	Finishing to medium cutting
	Grade	AH8015	AH8015
	Breaker Shape	PSS	PS
	Cutting conditions	B028	

H	Application	Precision finishing	Finishing
	Grade	BXM10	BXM20
	Breaker Shape	T-CBN	T-CBN
	Cutting conditions	B030	

Reference pages: S-SVUCR/L-H: Insert → **B155** -

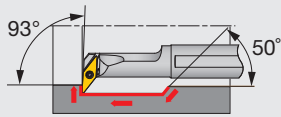


Inch	Material	DCONWS	DCONMS	BD	OAL	LS	OHX	CNT	Fig.
D.625-L6.14-7D-C	Steel	0.630	0.625	0.630	6.140	3.600	3.500	G1/8	1
G.625-L8.03-10D-E	Carbide	0.630	0.625	0.630	8.030	5.220	5.500	-	1
D.750-L7.87-7D-C	Steel	0.787	0.750	0.787	7.870	4.940	4.400	G1/4	1
G.750-L10.24-10D-E	Carbide	0.787	0.750	0.787	10.240	6.770	7.000	-	1
D1.00-L10.2-7D-C	Steel	0.984	1.000	0.984	10.200	6.830	6.200	G1/4	1
D1.00-L13.21-10D-C	Steel	0.984	1.000	0.984	13.210	8.650	9.200	G1/4	1
D1.25-L12.48-7D-C	Steel	1.260	1.250	1.260	12.480	7.370	7.500	G3/8	1
D1.25-L16.24-10D-C	Steel	1.260	1.250	1.260	16.240	9.670	11.200	G3/8	1
D1.50-L15.26-7D-C	Steel	1.575	1.500	1.575	15.260	9.130	9.200	G1/2	1
D1.50-L19.8-10D-C	Steel	1.575	1.500	1.575	19.800	13.350	13.700	G1/2	1
D2.00-L20.74-7D-C	Steel	1.575	2.000	2.000	20.740	-	12.700	G1/2	2
D2.00-L26.73-10D-C	Steel	1.575	2.000	2.000	26.730	-	18.700	G1/2	2
D2.50-L26.2-7D-C	Steel	1.575	2.500	2.500	26.200	-	16.200	G3/4	2
D2.50-L33.72-10D-C	Steel	1.575	2.500	2.500	33.720	-	23.700	G3/4	2

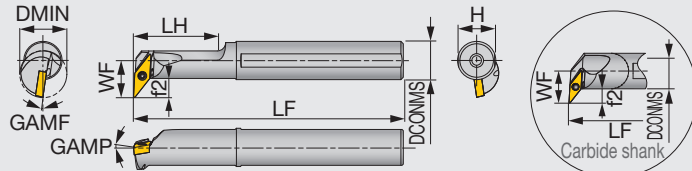
SPARE PARTS



Designation	Clamping screw	Wrench
D.625..., G.625...	SRM3X10DIN912	HW2.5
D.750..., G.750...	SRM3.5X10DIN912	HW2.5
D1.00...	SRM4X12DIN912	HW3.0
D1.25...	SRM5X12DIN912	HW4.0
D1.50..., D2.00... D2.50...	SRM6X16DIN912-12.9	HW5.0



Cutting edge style U



Right hand (R) shown.

Inch	Material	DMIN	DCONMS	WF	LF	LH	H	f2	GAMP	GAMF	RE**	Insert	Torque
A10-SVUCR6-D14	Steel	0.875	0.625	0.531	7.000	1.250	0.600	0.218	0°	-5°	0.016	VC**63...	0.44
A12-SVUCR2-D16	Steel	1.000	0.750	0.594	10.000	1.420	0.725	0.218	0°	-5°	0.016	VC**22...	1.0

Metric	Material	DMIN	DCONMS	WF	LF	LH	H	f2	GAMP	GAMF	RE**	Insert	Torque*
A12M-SVUCR/L08-D160	Steel	16	12	11	150	30	11	5.5	0°	-8°	0.4	VC**0802...	0.6
A25S-SVUCR/L16-D320	Steel	32	25	19	250	45	23	6.5	0°	-5°	0.8	VC**1604...	3
E12Q-SVUCR/L08-D180	Carbide	18	12	11.5	180	-	11	5.5	0°	-8°	0.4	VC**0802...	0.6
E25T-SVUCR/L16-D320	Carbide	32	25	19	300	-	23	6.5	0°	-5°	0.8	VC**1604...	3

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

**RE : Standard corner radius

Use right-hand toolholders (SVUCR**) with left-hand inserts (L); and left-hand toolholders (SVUCL**) with right-hand inserts (R).

SPARE PARTS



Designation	Clamping screw	Wrench
A10-SVUCR6-D14	CSTB-2L	T-6F
A12-SVUCR2-D16	CSTB-2.5	T-8F
A12M-SVUCR/L08-D160	CSTB-2L	T-6F
A25S-SVUCR/L16-D320	CSTB-3.5	T-15F
E12Q-SVUCR/L08-D180	CSTB-2L	T-6F
E25T-SVUCR/L16-D320	CSTB-3.5	T-15F

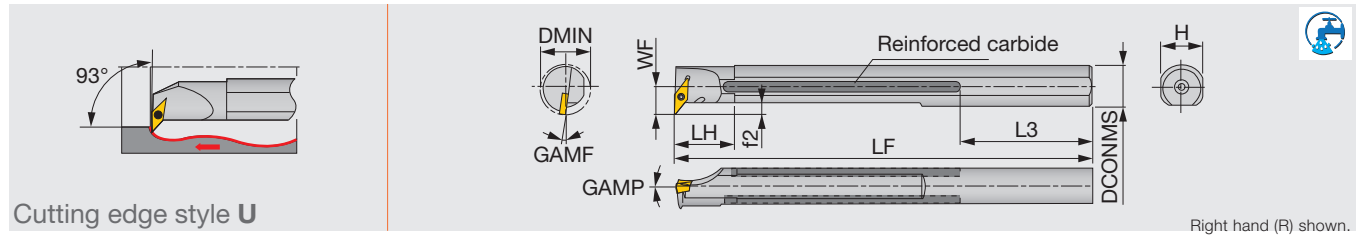
INSERT SELECTION

P	Application	Finishing to medium cutting	M	Application	Finishing to medium cutting
	Grade	T9215		Grade	T9215
	Breaker Shape	PS		Breaker Shape	PS
	Cutting conditions	B020		Cutting conditions	B022
K	Application	Finishing to medium cutting	N	Application	Precision finishing
	Grade	T515		Grade	DX120
	Breaker Shape	CM		Breaker Shape	T-DIA with rake AL
	Cutting conditions	B024		Cutting conditions	B026
S	Application	Finishing to medium cutting	H	Application	Precision finishing
	Grade	AH8005		Grade	BXM10
	Breaker Shape	PS		Breaker Shape	T-CBN
	Cutting conditions	B028		Cutting conditions	B030

Reference pages: A/E-SVUCR/L: Insert → **B155 -**, CBN → **B192**, PCD → **B196 -**

T-SVUCR

Screw-on boring bar, for positive 35° rhombic inserts (Tsuppari-Ichiban)



Metric	Material	DMIN	CNT***	DCONMS	WF	LF	LH	L3	H	f2	GAMP	GAMF	RE**	Insert	Torque
T25S-SVUCR16C	Reinforced	32	Rc1/4	25	19	250	40	64	23	6.5	0°	-5°	0.8	VC**1604...	3

Torque: Recommended clamping torque: N·m

**RE : Standard corner radius

***CNT : Threading size at the tail port

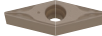
*The hole specification of applicable inserts conforms to ISO standard.

Use right-hand toolholders (SVUCR**) with left-hand inserts (L).

SPARE PARTS

Designation	Clamping screw	Wrench
T25S-SVUCR16C	CSTB-3.5L	T-15F

INSERT SELECTION

P	Application	Finishing	Finishing to medium cutting	
	Grade	NS9530	T9215	
	Breaker Shape	PSS	PS	
				
Cutting conditions		B020		

M	Application	Finishing	Finishing to medium cutting		Medium cutting
	Grade	AH725	AH630		T6130
	Breaker Shape	PSF	PSS		PM
					
Cutting conditions		B022			

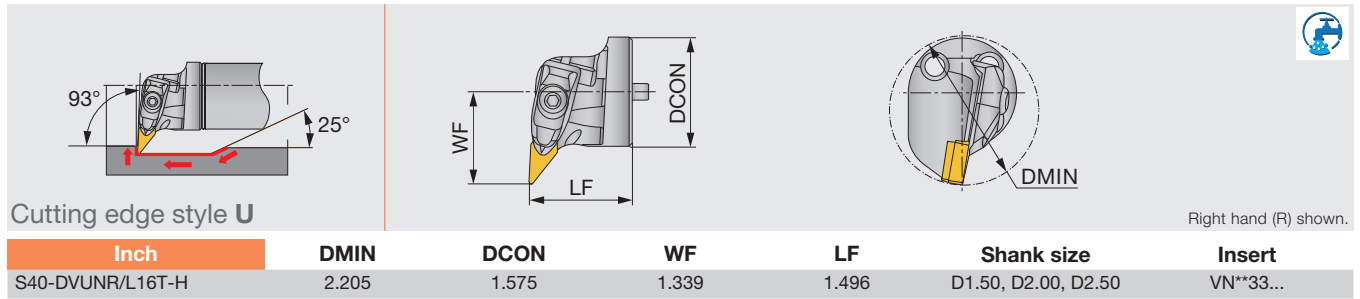
K	Application	Finishing to medium cutting	
	Grade	T515	
	Breaker Shape	CM	
			
Cutting conditions		B024	

N	Application	Precision finishing	Finishing	Medium cutting
	Grade	DX120	DX140	KS05F
	Breaker Shape	T-DIA	with rake T-DIA	AL
				
Cutting conditions		B026		

S	Application	Finishing	Finishing to medium cutting
	Grade	AH8015	AH8015
	Breaker Shape	PSS	PS
			
Cutting conditions		B028	

H	Application	Precision finishing	Finishing
	Grade	BXM10	BXM20
	Breaker Shape	T-CBN	T-CBN
			
Cutting conditions		B030	

Reference pages: T-SVUCR: Insert → **B155** -, CBN → **B192**, PCD → **B196** -



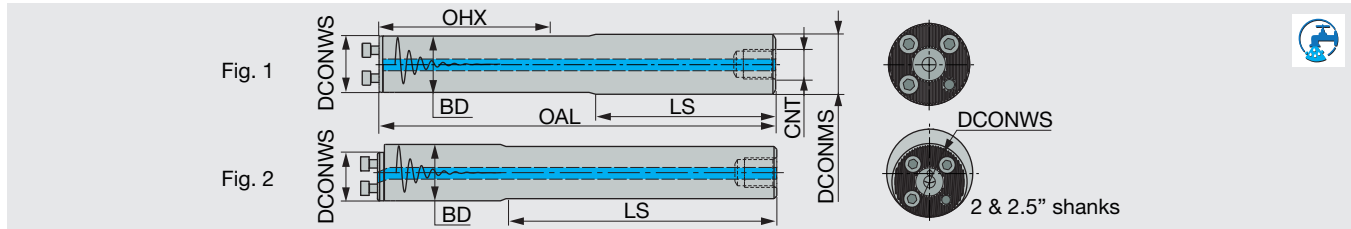
SPARE PARTS

Designation	Shim	Shim screw	Clamp	Clamping screw	Spring	Wrench
S40-DVUNR/L16T-H	ASV322	SR35080I	DLM3V	SR10402267	KSP5	HW4.0

INSERT SELECTION

P	Application	Precision finishing	Finishing	Medium cutting
	Grade	NS9530	GT9530	T9215
	Breaker Shape	TF	TSF	TM
	Cutting conditions	B008		
M	Application	Finishing	Medium cutting	
	Grade	T6120	T6130	
	Breaker Shape	SF	SM	
	Cutting conditions	B010		
K	Application	Finishing	Medium cutting	Medium to heavy cutting
	Grade	T515	T515	T515
	Breaker Shape	All-round	All-round	All-round
	Cutting conditions	B012		
N	Application	Precision finishing		
	Grade	DX120		
	Breaker Shape	T-DIA with rake		
	Cutting conditions	B014		
S	Application	Precision finishing	Finishing	Medium cutting
	Grade	BX470	AH8005	AH8005
	Breaker Shape	T-CBN	HRF	HRM
	Cutting conditions	B016		
H	Application	Precision finishing	Finishing	
	Grade	BXM10	BXM20	
	Breaker Shape	T-CBN	T-CBN	
	Cutting conditions	B018		

Reference pages: S-DVUNR/L-H: Insert → **B096** -, CBN → **B180**, PCD → **B194**

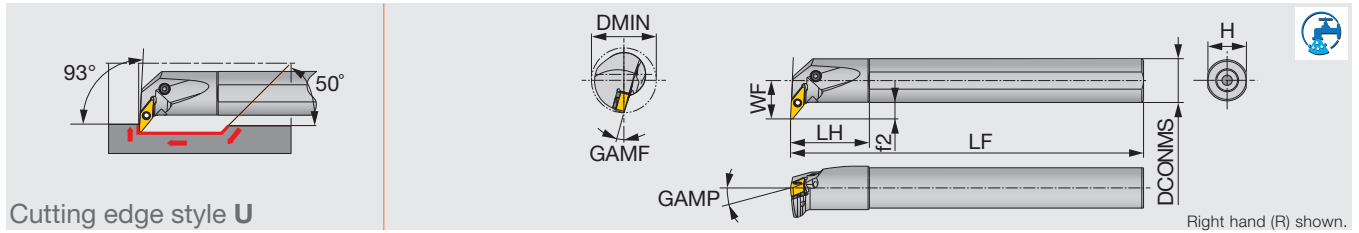


Inch	Material	DCONWS	DCONMS	BD	OAL	LS	OHX	CNT	Fig.
D.625-L6.14-7D-C	Steel	0.630	0.625	0.630	6.140	3.600	3.500	G1/8	1
G.625-L8.03-10D-E	Carbide	0.630	0.625	0.630	8.030	5.220	5.500	-	1
D.750-L7.87-7D-C	Steel	0.787	0.750	0.787	7.870	4.940	4.400	G1/4	1
G.750-L10.24-10D-E	Carbide	0.787	0.750	0.787	10.240	6.770	7.000	-	1
D1.00-L10.2-7D-C	Steel	0.984	1.000	0.984	10.200	6.830	6.200	G1/4	1
D1.00-L13.21-10D-C	Steel	0.984	1.000	0.984	13.210	8.650	9.200	G1/4	1
D1.25-L12.48-7D-C	Steel	1.260	1.250	1.260	12.480	7.370	7.500	G3/8	1
D1.25-L16.24-10D-C	Steel	1.260	1.250	1.260	16.240	9.670	11.200	G3/8	1
D1.50-L15.26-7D-C	Steel	1.575	1.500	1.575	15.260	9.130	9.200	G1/2	1
D1.50-L19.8-10D-C	Steel	1.575	1.500	1.575	19.800	13.350	13.700	G1/2	1
D2.00-L20.74-7D-C	Steel	1.575	2.000	2.000	20.740	-	12.700	G1/2	2
D2.00-L26.73-10D-C	Steel	1.575	2.000	2.000	26.730	-	18.700	G1/2	2
D2.50-L26.2-7D-C	Steel	1.575	2.500	2.500	26.200	-	16.200	G3/4	2
D2.50-L33.72-10D-C	Steel	1.575	2.500	2.500	33.720	-	23.700	G3/4	2

SPARE PARTS



Designation	Clamping screw	Wrench
D.625..., G.625...	SRM3X10DIN912	HW2.5
D.750..., G.750...	SRM3.5X10DIN912	HW2.5
D1.00...	SRM4X12DIN912	HW3.0
D1.25...	SRM5X12DIN912	HW4.0
D1.50..., D2.00... D2.50...	SRM6X16DIN912-12.9	HW5.0



Inch	Material	DMIN	DCONMS	WF	LF	LH	H	f2	GAMP	GAMF	RE**	Insert	Torque
A16-PVUNR/L2.33-D20	Steel	1.250	1.000	0.672	12.000	1.750	0.906	0.197	-6°	-13°	0.031	VN**2.33**E...	2.2
A16-PVUNR/L2.33-D24	Steel	1.500	1.000	0.859	12.000	1.750	0.906	0.315	-6°	-10°	0.031	VN**2.33**E...	2.2
A20-PVUNR/L2.33-D26	Steel	1.650	1.250	0.859	14.000	2.000	1.188	0.217	-6°	-10°	0.031	VN**2.33**E...	2.2

Metric	Material	DMIN	DCONMS	WF	LF	LH	H	f2	GAMP	GAMF	RE**	Insert	Torque*
A25R-PVUNR/L1204-D320	Steel	32	25	18	200	45	23	5.0	-5°	-15°	0.8	VN**1204...	3
A25R-PVUNR/L1204-D370	Steel	37	25	22	200	45	23	8.0	-4°	-15°	0.8	VN**1204...	3
A32S-PVUNR/L1204-D400	Steel	40	32	22	250	50	30	5.5	-6°	-12°	0.8	VN**1204...	3

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

**RE: Standard corner radius

SPARE PARTS

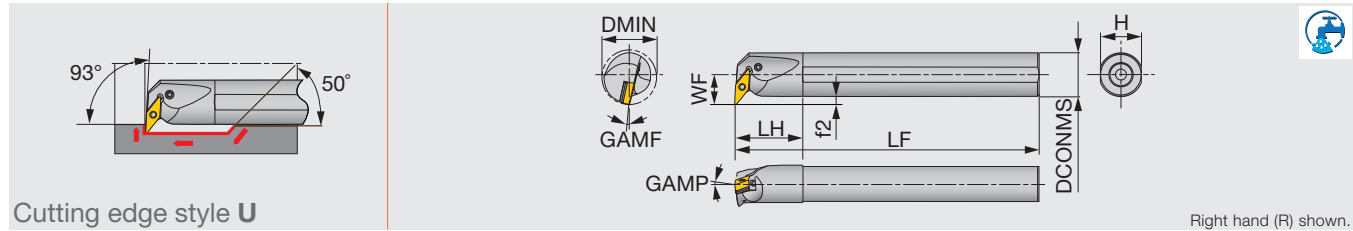
Designation	Clamping screw	Wrench	Lever	Shim	Spring pin	Oil supply attachment*	Screw for oil hole*
A16-PVUNR/L2.33-D... A25R-PVUNR/L1204-D...	LCS3V	P-2.5	LCL3V	LSV212	LSP3	EA-25	SSHM4-5
A20-PVUNR/L2.33-D26, A32S-PVUNR/L1204-D400	LCS3V	P-2.5	LCL3V	LSV212	LSP3	EA-32	SSHM4-5

*Optional

INSERT SELECTION

P	Application	Finishing	Medium cutting
	Grade	T9215	T9215
	Breaker Shape	TSF	TM
	Cutting conditions	B008	

M	Application	Finishing	Medium cutting
	Grade	T6120	T6130
	Breaker Shape	SS	SM
	Cutting conditions	B010	



Cutting edge style U

Right hand (R) shown.

Metric	Material	DMIN	DCONMS	WF	LF	LH	H	f2	GAMP	GAMF	RE**	Insert	Torque
A25R-PVUNR/L16-D370	Steel	37	25	22	200	45	23	9.5	-5°	-14°	0.8	V/YN**1604...	2.7
A32S-PVUNR/L16-D400	Steel	40	32	22	250	50	30	6	-5°	-12°	0.8	V/YN**1604...	2.7
A40T-PVUNR/L16-D500	Steel	50	40	27	300	60	37	7	-5°	-10°	0.8	V/YN**1604...	2.7

Torque: Recommended clamping torque: N·m

**RE: Standard corner radius

SPARE PARTS

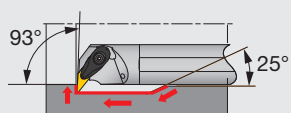
Designation	Shim	Clamping screw	Wrench	Spring pin	Lever	Oil supply attachment*	Screw for oil hole*
A25R-PVUNR/L16-D370	LSV317BR/L	LCS3V	P-2.5	LSP3	LCL3V	EA-25	SSHM4-5
A32S-PVUNR/L16-D400	LSV317BR/L	LCS3V	P-2.5	LSP3	LCL3V	EA-32	SSHM4-5
A40T-PVUNR/L16-D500	LSV317BR/L	LCS3V	P-2.5	LSP3	LCL3V	-	SSHM5-6

*Optional

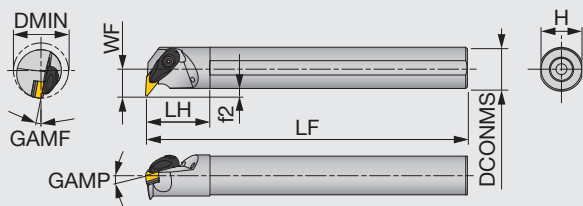
INSERT SELECTION

P	Application	Precision finishing	Finishing	Medium cutting
	Grade	NS9530	GT9530	T9215
	Breaker Shape	TF	TSF	TM
Cutting conditions B008				
K	Application	Finishing	Medium cutting	Medium to heavy cutting
	Grade	T515	T515	T515
	Breaker Shape	All-round	All-round	All-round
Cutting conditions B012				
S	Application	Precision finishing	Finishing	Medium cutting
	Grade	BX470	AH8005	AH8005
	Breaker Shape	T-CBN	HRF	HRM
Cutting conditions B016				
M	Application	Finishing	Medium cutting	
	Grade	T6120	T6130	
	Breaker Shape	SF	SM	
Cutting conditions B010				
N	Application	Precision finishing		
	Grade	DX120		
	Breaker Shape	T-DIA with rake		
Cutting conditions B014				
H	Application	Precision finishing	Finishing	
	Grade	BXM10	BXM20	
	Breaker Shape	T-CBN	T-CBN	
Cutting conditions B018				

Reference pages: A-PVUNR/L: Insert → B096 -, B109, CBN → B180, PCD → B194



Cutting edge style U



Right hand (R) shown.

Inch	Material	DMIN	DCONMS	WF	LF	LH	H	f2	GAMP	GAMPF	RE**	Insert	Torque
A20-AVUNR/L3-D25	Steel	1.560	1.250	0.859	14.000	1.960	1.180	0.236	-6	-10	0.031	V/YN**33...	2.21
A24-AVUNR/L3-D32	Steel	2.000	1.500	1.060	14.000	2.160	1.440	0.275	-6	-8	0.031	V/YN**33...	2.21

Torque: Recommended clamping torque: lbs-ft

**RE : Standard corner radius

SPARE PARTS

Designation	Clamp	Clamp screw	Spring	Spring pin	Shim	Shim screw	Wrench
A*-AVUNR/L3-D...	ACP3L	ACS-5W	BP-7	SP-2.5	ASV322	CSTB-3.5	T-15F

INSERT SELECTION

P	Application	Precision finishing	Finishing	Medium cutting
	Grade	NS9530	GT9530	T9215
	Breaker Shape	TF	TSF	TM
	Cutting conditions	B008		

M	Application	Finishing	Medium cutting
	Grade	T6120	T6130
	Breaker Shape	SF	SM
	Cutting conditions	B010	

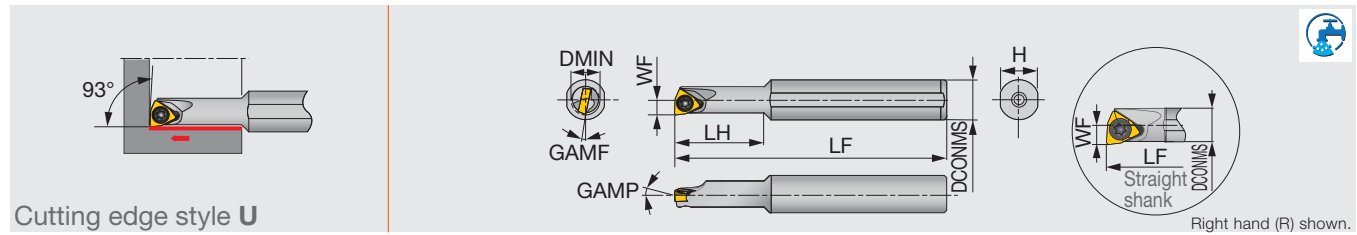
K	Application	Finishing	Medium cutting	Medium to heavy cutting
	Grade	T515	T515	T515
	Breaker Shape	All-round	All-round	All-round
	Cutting conditions	B012		

N	Application	Precision finishing
	Grade	DX120
	Breaker Shape	T-DIA with rake
	Cutting conditions	B014

S	Application	Precision finishing	Finishing	Medium cutting
	Grade	BX470	AH8005	AH8005
	Breaker Shape	T-CBN	HRF	HRM
	Cutting conditions	B016		

H	Application	Precision finishing	Finishing
	Grade	BXM10	BXM20
	Breaker Shape	T-CBN	T-CBN
	Cutting conditions	B018	

Reference pages: A-AVUNR/L: Insert → **B096 -**, **B109**, CBN → **B180**, PCD → **B194**



Metric	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 clamping torque: N·m

**RE : Standard corner radius

Use right-hand toolholders (SVUCR*) with left-hand inserts (L); and left-hand toolholders (SWUBL**) with right-hand inserts (R).

SPARE PARTS

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

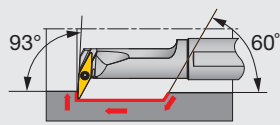
INSERT SELECTION

P	Application Grade Breaker Shape Cutting conditions	Finishing SH725 W08 B008
M	Application Grade Breaker Shape Cutting conditions	Finishing SH725 W08 B010
K	Application Grade Breaker Shape Cutting conditions	Finishing TH10 W08 B012
N	Application Grade Breaker Shape Cutting conditions	Finishing GH110 W08 B014

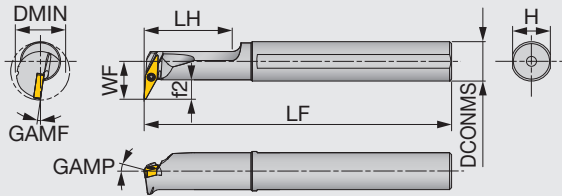
Y-PRO SERIES

A/E-SYUBR/L

Screw-on boring bar, for positive 25° rhombic inserts



Cutting edge style U



Right hand (R) shown.

Inch	Material	DMIN	DCONMS	WF	LF	LH	H	f2	GAMP	GAMF	RE**	Insert	Torque
A10-SYUBR/L2-D16	Steel	1.000	0.625	0.625	7.000	1.250	0.600	0.312	0°	-8°	0.016	YW**11T2...	0.44
E08-SYUBR/L2-D14	Carbide	0.875	0.500	0.563	5.000	1.060	0.475	0.307	0°	-8°	0.016	YW**11T2...	0.44
E10-SYUBR/L2-D16	Carbide	1.000	0.625	0.625	7.000	1.250	0.600	0.307	0°	-8°	0.016	YW**11T2...	0.44

Metric	Material	DMIN	DCONMS	WF	LF	LH	H	f2	GAMP	GAMF	RE**	Insert	Torque*
A16Q-SYUBR/L11-D200	Steel	20	16	15.5	180	35	15	8	0°	-8°	0.4	YW**11T2...	0.6
E12Q-SYUBR/L11-D200	Carbide	20	12	13.5	180	27	11	7.5	0°	-8°	0.4	YW**11T2...	0.6
E16R-SYUBR/L11-D245	Carbide	24.5	16	16	200	32	15	8	0°	-8°	0.4	YW**11T2...	0.6

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

**RE : Standard corner radius

SPARE PARTS



Designation	Clamping screw	Wrench
A10-SYUBR/L2-D16	CSTB-2L	T-6F
E**-SYUBR/L2-D...	CSTB-2L	T-6F
A16Q-SYUBR/L11-D200	CSTB-2L	T-6F
E**-SYUBR/L11-D...	CSTB-2L	T-6F

INSERT SELECTION

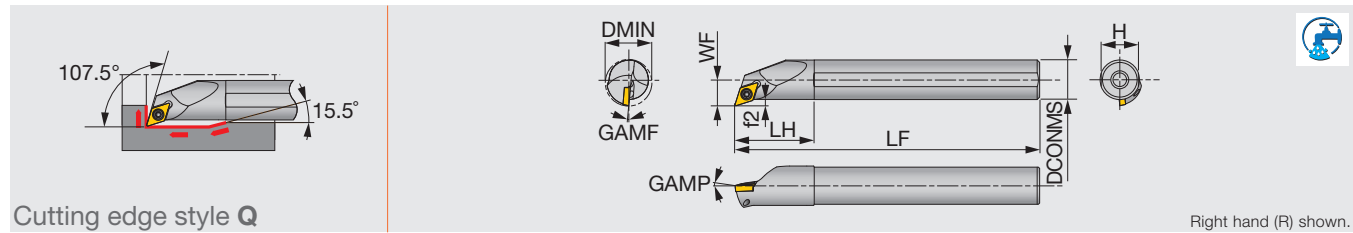


Application	Finishing to medium cutting
Grade	T9225
Breaker Shape	ZM
Cutting conditions	B020



Application	Finishing to medium cutting
Grade	GT9530
Breaker Shape	ZM
Cutting conditions	B024

Reference pages: A/E-SYUBR/L: Insert → **B163**



Inch	Material	DMIN	DCONMS	WF	LF	LH	H	f2	GAMP	GAMF	RE**	Insert	Torque
A06-SDQCR2-D10	Steel	0.625	0.375	0.406	5.000	0.750	0.350	-	0°	-7°	0.016	DC**21.5...	0.89
A08-SDQCR2-D11	Steel	0.688	0.500	0.406	5.000	1.000	0.475	-	0°	-6°	0.016	DC**21.5...	0.89
A10-SDQCR2-D14	Steel	0.875	0.625	0.531	7.000	1.250	0.600	-	0°	-4°	0.016	DC**21.5...	0.89

Metric	Material	DMIN	DCONMS	WF	LF	LH	H	f2	GAMP	GAMF	RE**	Insert	Torque*
A10K-SDQCR/L07-D130	Steel	13	10	7.6	125	20	9	2.6	0°	-8°	0.4	DC**0702...	1.2
A12M-SDQCR/L07-D160	Steel	16	12	8.6	150	24	11	2.6	0°	-6°	0.4	DC**0702...	1.2
A16Q-SDQCR/L07-D200	Steel	20	16	10.6	180	32	15	2.6	0°	-5°	0.4	DC**0702...	1.2
A20R-SDQCR/L11-D250	Steel	25	20	13.7	200	36	18	3.7	0°	-7°	0.8	DC**11T3...	3
A25S-SDQCR/L11-D300	Steel	30	25	16.2	250	45	23	3.7	0°	-4°	0.8	DC**11T3...	3
E10H-SDQCR07-D130	Carbide	13	10	7.6	100	25	9	2.5	0°	-8°	0.4	DC**0702...	1.2
E10M-SDQCR/L07-D130	Carbide	13	10	7.6	150	25	9	2.6	0°	-8°	0.4	DC**0702...	1.2
E12J-SDQCR07-D160	Carbide	16	12	8.6	110	27	11	2.5	0°	-6°	0.4	DC**0702...	1.2
E12Q-SDQCR/L07-D160	Carbide	16	12	8.6	180	27	11	2.6	0°	-6°	0.4	DC**0702...	1.2
E16L-SDQCR07-D200	Carbide	20	16	10.6	130	32	15	2.5	0°	-5°	0.4	DC**0702...	1.2
E16R-SDQCR/L07-D200	Carbide	20	16	10.6	200	32	15	2.6	0°	-5°	0.4	DC**0702...	1.2
E20S-SDQCR/L11-D250	Carbide	25	20	13.7	250	36	18	3.7	0°	-7°	0.8	DC**11T3...	3

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

**RE : Standard corner radius

Use right-hand toolholders (SDQCR**) with left-hand inserts (L); and left-hand toolholders (SDQCL**) with right-hand inserts (R).

SPARE PARTS

Designation	Clamping screw	Wrench
A**-SDQCR2-D...	CSTB-2.5B	T-8F
A1**-SDQCR/L07-D**0	CSTB-2.5S	T-8F
A2**-SDQCR/L11-D**0	CSTB-4S	T-15F
E1**-SDQCR/L07-D**0	CSTB-2.5S	T-8F
E20S-SDQCR/L11-D250	CSTB-4S	T-15F

INSERT SELECTION

P	Application	Precision finishing	Finishing	Finishing to medium cutting	Medium cutting
	Grade	SH725	SH725	T9215	T9215
	Breaker Shape	01	JS	PS	PM
	Cutting conditions	B020			

M	Application	Precision finishing	Finishing	Finishing to medium cutting	Medium cutting
	Grade	SH725	SH725	T9215	T9215
	Breaker Shape	01	JS	PS	PM
	Cutting conditions	B022			

K	Application	Finishing to medium cutting
	Grade	T515
	Breaker Shape	CM
	Cutting conditions	B024

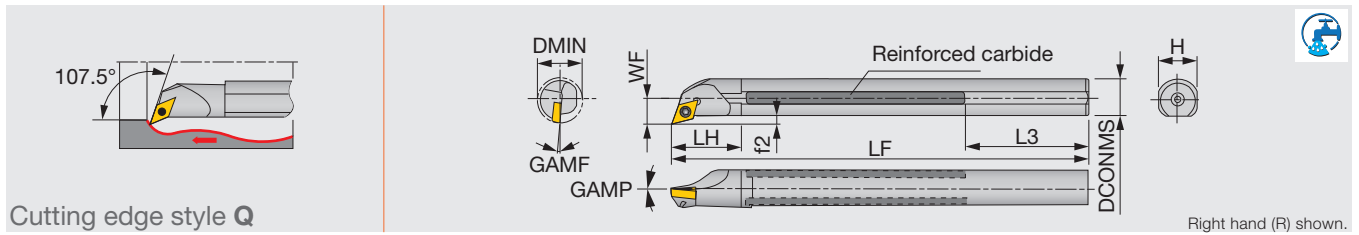
N	Application	Precision finishing	Medium cutting
	Grade	DX120	KS05F
	Breaker Shape	T-DIA with rake	AL
	Cutting conditions	B026	

S	Application	Precision finishing	Finishing to medium cutting
	Grade	BX470	AH8005
	Breaker Shape	T-CBN	PS
	Cutting conditions	B028	

H	Application	Precision finishing	Finishing
	Grade	BXM10	BXM20
	Breaker Shape	T-CBN	T-CBN
	Cutting conditions	B030	

T-SDQCR/L

Screw-on boring bar, for positive 55° rhombic inserts (Tsuppari-Ichiban)



Metric	Material	DMIN	CNT***	DCONMS	WF	LF	LH	L3	H	f2	GAMP	GAMF	RE**	Insert	Torque
T16Q-SDQCR/L07	Reinforced	20	-	16	11	180	27	59	15	3	0°	-6°	0.4	DC**0702...	1.2
T20R-SDQCR/L11C	Reinforced	25	Rc1/4	20	13	200	35	49	18	3	0°	-6°	0.8	DC**11T3...	3
T25S-SDQCR/L11C	Reinforced	32	Rc1/4	25	17	250	40	64	23	4.5	0°	-4°	0.8	DC**11T3...	3

Torque: Recommended clamping torque: N·m

**RE : Standard corner radius

***CNT : Threading size at the tail port

*The hole specification of applicable inserts conforms to ISO standard.

Use right-hand toolholders (SDQCR**) with left-hand inserts (L); and left-hand toolholders (SDQCL**) with right-hand inserts (R).

SPARE PARTS

Designation	Clamping screw	Wrench
T16Q-SDQCR/L07	CSTB-2.5	T-8F
T20R-SDQCR/L11C	CSTB-4M	T-15F
T25S-SDQCR/L11C	CSTB-4	T-15F

INSERT SELECTION

P	Application	Finishing	Finishing to medium cutting	Medium cutting
	Grade	NS9530	T9215	T9215
	Breaker Shape	PSS	PS	PM
	Cutting conditions	B020		

M	Application	Precision finishing	Finishing	Finishing to medium cutting	Medium cutting
	Grade	GH330	AH725	AH630	T6130
	Breaker Shape	W**	PSF	PSS	PM
	Cutting conditions	B022			

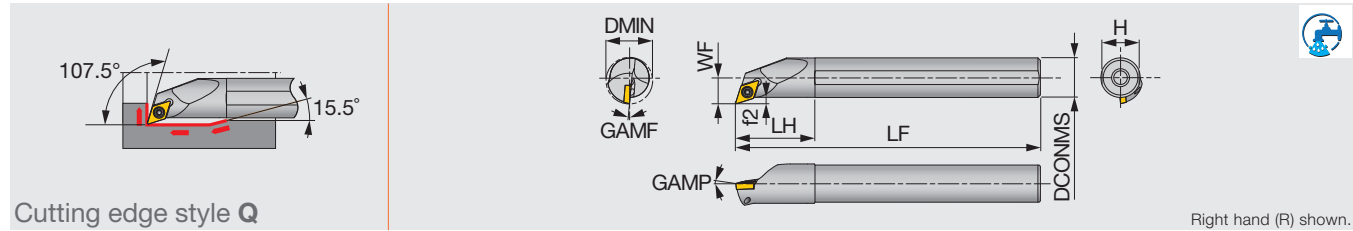
K	Application	Finishing to medium cutting
	Grade	T515
	Breaker Shape	CM
	Cutting conditions	B024

N	Application	Precision finishing	Finishing	Medium cutting
	Grade	DX120	DX140	KS05F
	Breaker Shape	T-DIA	with rake T-DIA	AL
	Cutting conditions	B026		

S	Application	Finishing	Finishing to medium cutting
	Grade	AH8015	AH8015
	Breaker Shape	PSS	PS
	Cutting conditions	B028	

H	Application	Precision finishing	Finishing
	Grade	BXM10	BXM20
	Breaker Shape	T-CBN	T-CBN
	Cutting conditions	B030	

Reference pages: T-SDQCR/L: Insert → **B121 -**, CBN → **B184**, PCD → **B196 -**



Metric	Material	DMIN	DCONMS	WF	LF	LH	H	f2	GAMF	GAMF	RE***	Insert	Torque
A12M-SDQPR07-D150-P	Special alloy steel*	15	12	8.3	150	24	11	2.3	5°	0°	0.40	DPMT0702...	1.2
A12M-SDQPL07-D150-P	Special alloy steel*	15	12	8.3	150	24	11	2.3	5°	0°	0.40	DPMT0702...	1.2
A12M-SDQPR07-D180-P	Special alloy steel*	18	12	9.6	150	24	11	3.6	5°	0°	0.40	DPMT0702...	1.2
A12M-SDQPL07-D180-P	Special alloy steel*	18	12	9.6	150	24	11	3.6	5°	0°	0.40	DPMT0702...	1.2
A16Q-SDQPR07-D220-P	Special alloy steel*	22	16	11.6	180	32	15	3.6	5°	0°	0.40	DPMT0702...	1.2
A16Q-SDQPL07-D220-P	Special alloy steel*	22	16	11.6	180	32	15	3.6	5°	0°	0.40	DPMT0702...	1.2
E12Q-SDQPR07-D150	Carbide	15	12	8.3	180	27	11	2.3	5°	0°	0.40	DPMT0702...	1.2
E12Q-SDQPL07-D150	Carbide	15	12	8.3	180	27	11	2.3	5°	0°	0.40	DPMT0702...	1.2
E12Q-SDQPR07-D180	Carbide	18	12	9.6	180	27	11	3.6	5°	0°	0.40	DPMT0702...	1.2
E12Q-SDQPL07-D180	Carbide	18	12	9.6	180	27	11	3.6	5°	0°	0.40	DPMT0702...	1.2
E16R-SDQPR07-D220	Carbide	22	16	11.6	200	32	15	3.6	5°	0°	0.40	DPMT0702...	1.2
E16R-SDQPL07-D220	Carbide	22	16	11.6	200	32	15	3.6	5°	0°	0.40	DPMT0702...	1.2

*Special alloy steel: Exclusively selected material is used to reduce chattering.

Torque: Recommended clamping torque: N·m

***RE : Standard corner radius

Use right-hand toolholders (SDQCR**) with left-hand inserts (L); and left-hand toolholders (SDQCL**) with right-hand inserts (R).

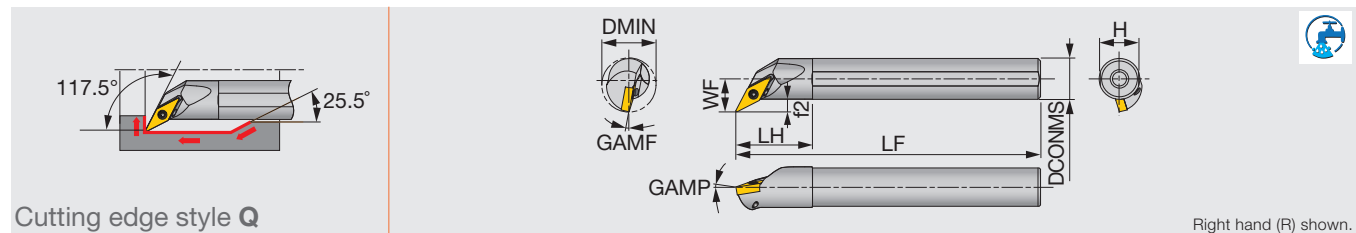
SPARE PARTS

Designation	Clamping screw	Wrench
A**-SDQPR/L07-D**0-P	CSTB-2.5S	T-8F
E**-SDQPR/L07-D**0	CSTB-2.5S	T-8F

INSERT SELECTION

P	Application	Finishing to medium cutting
	Grade	T9225 NS9530
	Breaker Shape	PS PS
	Cutting conditions	B020

S	Application	Finishing to medium cutting
	Grade	AH8015
	Breaker Shape	PS
	Cutting conditions	B028



Inch	Material	DMIN	DCONMS	WF	LF	LH	H	f2	GAMP	GAMF	RE**	Insert	Torque
A10-SVQBR2-D16	Steel	1.000	0.625	0.500	7.000	1.250	0.600	0.188	-5°	-6°	0.016	VB**1103...	0.89
Metric	Material	DMIN	DCONMS	WF	LF	LH	H	f2	GAMP	GAMF	RE**	Insert	Torque*
A12M-SVQBR/L11-D170	Steel	17	12	10.5	150	24	11	4.5	-5°	-10°	0.4	VB**1103...	1.2
A16Q-SVQBR/L11-D215	Steel	21.5	16	13	180	30	15	5	-5°	-8°	0.4	VB**1103...	1.2
A20R-SVQBR/L11-D255	Steel	25.5	20	15	200	36	18	5	-5°	-6°	0.4	VB**1103...	1.2
A25S-SVQBR/L16-D305	Steel	30.5	25	17.5	250	45	23	5	-5°	-8°	0.8	VB**1604...	3
E12Q-SVQBR/L11-D170	Carbide	17	12	10.5	180	27	11	4.5	-5°	-10°	0.4	VB**1103...	1.2
E16R-SVQBR/L11-D215	Carbide	21.5	16	13	200	32	15	5	-5°	-8°	0.4	VB**1103...	1.2
E20S-SVQBR/L11-D255	Carbide	25.5	20	15	250	36	18	5	-5°	-6°	0.4	VB**1103...	1.2
E25T-SVQBR/L16-D305	Carbide	30.5	25	17.5	300	45	23	5	-5°	-8°	0.8	VB**1604...	3

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

**RE : Standard corner radius

Use right-hand toolholders (SVQBR**) with left-hand inserts (L); and left-hand toolholders (SVQBL**) with right-hand inserts (R).

SPARE PARTS

Designation	Clamping screw	Wrench
A10-SVQBR2-D16	CSTB-2.5	T-8F
A**-SVQBR/L11-D...	CSTB-2.5	T-8F
A25S-SVQBR/L16-D305	CSTB-3.5	T-15F
E**-SVQBR/L11-D...	CSTB-2.5	T-8F
E25T-SVQBR/L16-D305	CSTB-3.5	T-15F

INSERT SELECTION

P	Application	Finishing	Finishing to medium cutting
	Grade	SH725	T9215
	Breaker Shape	JS	PS
	Cutting conditions	B020	

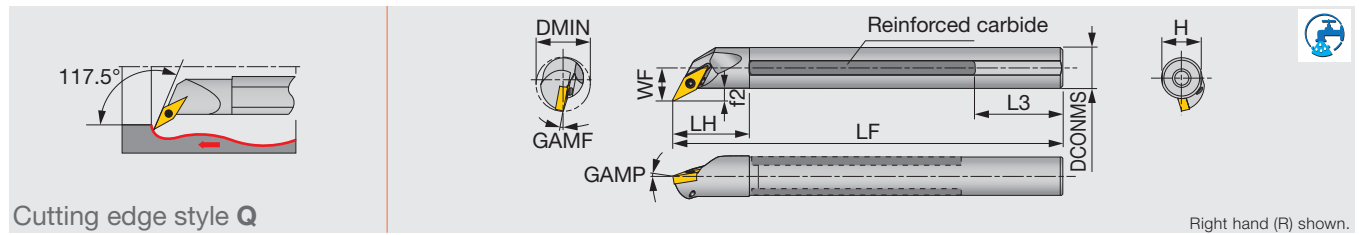
M	Application	Finishing	Finishing to medium cutting
	Grade	SH725	T9215
	Breaker Shape	JS	PS
	Cutting conditions	B022	

K	Application	Finishing to medium cutting
	Grade	T515
	Breaker Shape	CM
	Cutting conditions	B024

H	Application	Precision finishing	Finishing
	Grade	BXM10	BXM20
	Breaker Shape	T-CBN	T-CBN
	Cutting conditions	B030	

T-SVQBR

Screw-on boring bar, for positive 35° rhombic inserts (Tsuppari-Ichiban)



Metric	Material	DMIN	CNT***	DCONMS	WF	LF	LH	L3	H	f2	GAMP	GAMF	RE**	Insert	Torque
T20R-SVQBR11C	Reinforced	25	Rc1/4	20	14	200	30	59	18	4	-5°	-7°	0.4	VB**1103...	1.2

Torque: Recommended clamping torque: N·m

**RE : Standard corner radius

***CNT : Threading size at the tail port

*The hole specification of applicable inserts conforms to ISO standard.

Use right-hand toolholders (R) with left-hand inserts (L); and left-hand toolholders (L) with right-hand inserts (R).

SPARE PARTS

Designation	Clamping screw	Wrench
T20R-SVQBR11C	CSTB-2.5	T-8F

INSERT SELECTION

P	Application	Finishing	Finishing to medium cutting
	Grade	NS9530	T9215
	Breaker Shape	PSS	PS
	Cutting conditions	B020	

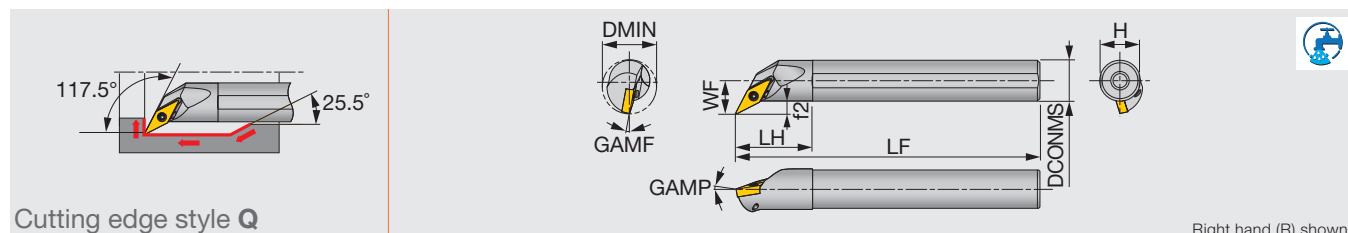
M	Application	Finishing	Finishing to medium cutting
	Grade	AH725	AH630
	Breaker Shape	PSF	PSS
	Cutting conditions	B022	

K	Application	Finishing to medium cutting
	Grade	T515
	Breaker Shape	CM
	Cutting conditions	B024

S	Application	Finishing	Finishing to medium cutting
	Grade	AH8015	AH8015
	Breaker Shape	PSS	PS
	Cutting conditions	B028	

H	Application	Precision finishing	Finishing
	Grade	BXM10	BXM20
	Breaker Shape	T-CBN	T-CBN
	Cutting conditions	B030	

Reference pages: T-SVQBR: Insert → **B152** -, CBN → **B191**



Right hand (R) shown.

Inch	Material	DMIN	DCONMS	WF	LF	LH	H	f2	GAMP	GAMF	RE**	Insert	Torque
A08-SVQCR6-D11	Steel	0.688	0.5	0.375	5.000	1.000	0.475	0.125	-5°	-8°	0.016	VC**0802...	0.44
A10-SVQCR2-D16	Steel	1.000	0.625	0.500	10.000	1.250	0.600	0.188	-5°	-8°	0.016	VC**1103...	0.89
Metric	Material	DMIN	DCONMS	WF	LF	LH	H	f2	GAMP	GAMF	RE**	Insert	Torque*
A10K-SVQCR/L08-D135	Steel	13.5	10	8	125	20	9	3	-5°	-8°	0.4	VC**0802...	0.6
A16Q-SVQCR/L11-D215	Steel	21.5	16	13	180	30	15	4.9	-5°	-8°	0.4	VC**1103...	1.2
E10M-SVQCR/L08-D135	Carbide	13.5	10	8	150	25	9	3	-5°	-8°	0.4	VC**0802...	0.6
E16R-SVQCR/L11-D215	Carbide	21.5	16	13	200	32	15	4.9	-5°	-8°	0.4	VC**1103...	1.2

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

**RE : Standard corner radius

Use right-hand toolholders (SVQCR**) with left-hand inserts (L); and left-hand toolholders (SVQCL**) with right-hand inserts (R).

SPARE PARTS

Designation	Clamping screw	Wrench
A08-SVQCR6-D11	CSTB-2L	T-6F
A10-SVQCR2-D16	CSTB-2.5	T-8F
A10K-SVQCR/L08-D135	CSTB-2L	T-6F
A16Q-SVQCR/L11-D215	CSTB-2.5	T-8F
E10M-SVQCR/L08-D135	CSTB-2L	T-6F
E16R-SVQCR/L11-D215	CSTB-2.5	T-8F

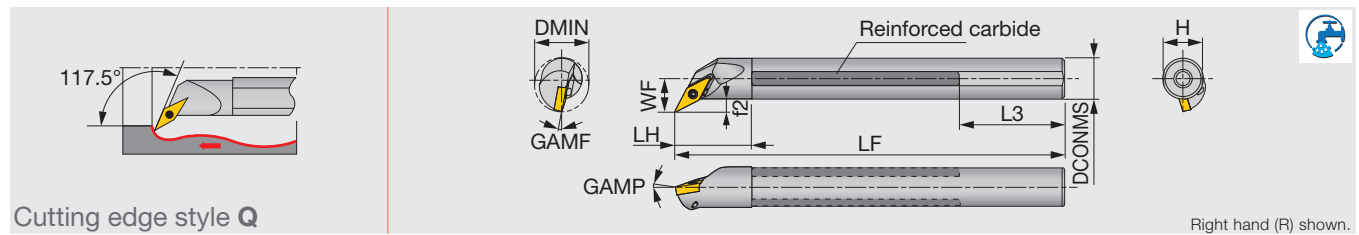
INSERT SELECTION

P	Application	Finishing to medium cutting	M	Application	Finishing to medium cutting
	Grade	T9215		Grade	T9215
	Breaker Shape	PS		Breaker Shape	PS
	Cutting conditions	B020		Cutting conditions	B022
K	Application	Finishing to medium cutting	N	Application	Precision finishing
	Grade	T515		Grade	DX120
	Breaker Shape	CM		Breaker Shape	T-DIA with rake AL
	Cutting conditions	B024		Cutting conditions	B026
S	Application	Finishing to medium cutting	H	Application	Precision finishing
	Grade	AH8005		Grade	BXM10
	Breaker Shape	PS		Breaker Shape	T-CBN
	Cutting conditions	B028		Cutting conditions	B030

Reference pages: A/E-SVQCR/L: Insert → **B155 -**

T-SVQCR

Screw-on boring bar, for positive 35° rhombic inserts (Tsuppari-Ichiban)



Metric	Material	DMIN	CNT***	DCONMS	WF	LF	LH	L3	H	f2	GAMP	GAMF	RE**	Insert	Torque
T25S-SVQCR16C	Reinforced	32	Rc1/4	25	17	250	40	64	23	8	0°	-5°	0.8	VC**1604...	3

Torque: Recommended clamping torque: N·m

**RE : Standard corner radius

***CNT : Threading size at the tail port

*The hole specification of applicable inserts conforms to ISO standard.

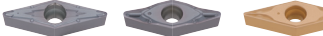
Use right-hand toolholders (R) with left-hand inserts (L); and left-hand toolholders (L) with right-hand inserts (R).

SPARE PARTS

Designation	Clamping screw	Wrench
T25S-SVQCR16C	CSTB-3.5L	T-15F

INSERT SELECTION

P	Application	Finishing	Finishing to medium cutting	
	Grade	NS9530	T9215	
	Breaker Shape	PSS	PS	
				
Cutting conditions B020				

M	Application	Finishing	Finishing to medium cutting	Medium cutting
	Grade	AH725	AH630	T6130
	Breaker Shape	PSF	PSS	PM
				
Cutting conditions B022				

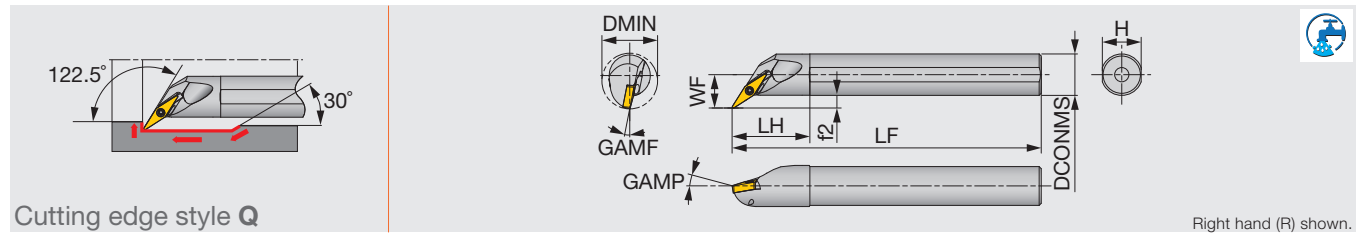
K	Application	Finishing to medium cutting
	Grade	T515
	Breaker Shape	CM
		
Cutting conditions B024		

N	Application	Precision finishing	Finishing	Medium cutting
	Grade	DX120	DX140	KS05F
	Breaker Shape	T-DIA	with rake T-DIA	AL
				
Cutting conditions B026				

S	Application	Finishing	Finishing to medium cutting
	Grade	AH8015	AH8015
	Breaker Shape	PSS	PS
			
Cutting conditions B028			

H	Application	Precision finishing	Finishing
	Grade	BXM10	BXM20
	Breaker Shape	T-CBN	T-CBN
			
Cutting conditions B030			

Reference pages: T-SVQCR: Insert → **B155** -, CBN → **B192**, PCD → **B196** -



Inch	Material	DMIN	DCONMS	WF	LF	LH	H	f2	GAMP	GAMF	RE**	Insert	Torque
A08-SYQBR2-D12	Steel	0.750	0.500	0.438	5.000	1.000	0.475	0.188	-5°	-10°	0.016	YW**11T2...	0.44
A10-SYQBR2-D14	Steel	0.875	0.625	0.500	7.000	1.250	0.600	0.188	-5°	-8°	0.016	YW**11T2...	0.44
E08-SYQBR2-D12	Carbide	0.750	0.500	0.438	5.000	1.000	0.475	0.188	-5°	-10°	0.016	YW**11T2...	0.44
E10-SYQBR2-D14	Carbide	0.875	0.625	0.500	7.000	1.250	0.600	0.188	-5°	-8°	0.016	YW**11T2...	0.44

Metric	Material	DMIN	DCONMS	WF	LF	LH	H	f2	GAMP	GAMF	RE**	Insert	Torque*
A12M-SYQBR/L11-D170	Steel	17	12	10.5	150	24	11	4.5	-5°	-10°	0.4	YW**11T2...	0.6
A16Q-SYQBR/L11-D215	Steel	21.5	16	13	180	30	15	5	-5°	-8°	0.4	YW**11T2...	0.6
E12Q-SYQBR/L11-D170	Carbide	17	12	10.5	180	27	11	4.5	-5°	-10°	0.4	YW**11T2...	0.6
E16R-SYQBR/L11-D215	Carbide	21.5	16	13	200	32	15	5	-5°	-8°	0.4	YW**11T2...	0.6

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

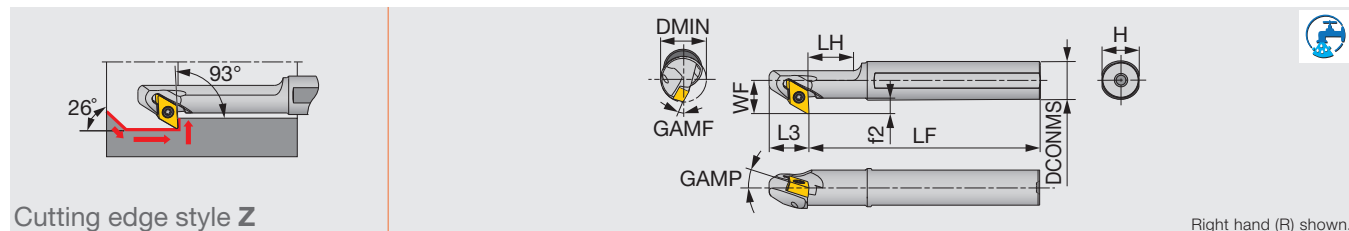
**RE : Standard corner radius

SPARE PARTS

Designation	Clamping screw	Wrench
A/E**-SYQBR/L2-D...	CSTB-2L	T-6F
A/E**-SYQBR/L11-D...	CSTB-2L	T-6F

INSERT SELECTION

P	Application	Finishing to medium cutting	K	Application	Finishing to medium cutting
	Grade	T9225		Grade	GT9530
	Breaker Shape	ZM		Breaker Shape	ZM
	Cutting conditions	B020		Cutting conditions	B024



Inch	Material	DMIN	DCONMS	WF	LF	LH	L3	H	f2	GAMP	GAMF	RE**	Insert	Torque
A08-SDZXR/L2-D10	Steel	0.625	0.500	0.438	5.000	1.125	0.500	0.475	0.188	-10°	-14°	0.016	DXGU0703**R/L...	0.66
A10-SDZXR/L2-D11	Steel	0.688	0.625	0.500	7.000	1.250	0.500	0.600	0.188	-10°	-12.5°	0.016	DXGU0703**R/L...	0.66
A12-SDZXR/L2-D14	Steel	0.875	0.750	0.563	7.000	1.375	0.500	0.725	0.188	-10°	-10.5°	0.016	DXGU0703**R/L...	0.66
Metric	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 clamping torque: lbs-ft (*N-m) **RE : Standard corner radius

Use right-hand toolholders (R) with right-hand inserts (R); and left-hand toolholders (L) with left-hand inserts (L).

SPARE PARTS

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

INSERT SELECTION

P

Application	Finishing	Medium cutting
Grade	NS9530	AH725
Breaker Shape	SS 	TS 
Cutting conditions	D105	

M

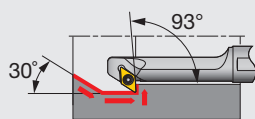
Application	Finishing	Medium cutting
Grade	AH8015	AH8015
Breaker Shape	SS 	TS 
Cutting conditions	D105	

K

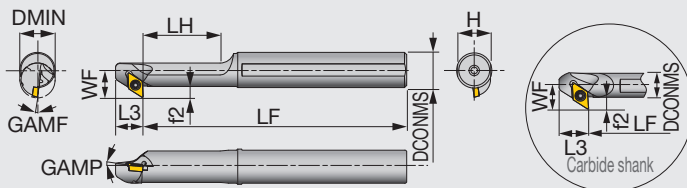
Application	Finishing	Medium cutting
Grade	NS9530	AH725
Breaker Shape	SS 	TS 
Cutting conditions	D105	

N

Application	Finishing	Medium cutting
Grade	KS05F	KS05F
Breaker Shape	SS 	TS 
Cutting conditions	D105	



Cutting edge style Z



Right hand (R) shown.

Inch	Material	DMIN	DCONMS	WF	LF	LH	L3	H	f2	GAMP	GAMF	RE**	Insert	Torque
A10-SDZCR2-D14	Steel	0.875	0.625	0.531	7.000	1.250	0.500	0.600	0.219	0°	-4°	0.016	DC**0702...	0.89
Metric	Material	DMIN	DCONMS	WF	LF	LH	L3	H	f2	GAMP	GAMF	RE**	Insert	Torque*
A12M-SDZCR/L07-D140	Steel	14	12	10.5	150	30	12.5	11	4.5	0°	-9°	0.4	DC**0702...	1.2
A16Q-SDZCR/L07-D160	Steel	16	16	12.5	180	35	12.5	15	4.5	0°	-8°	0.4	DC**0702...	1.2
A20R-SDZCR/L11-D200	Steel	20	20	15.5	200	40	15.0	18	5.5	0°	-8°	0.8	DC**11T3...	3
A25S-SDZCR/L11-D250	Steel	25	25	18	250	50	15	23	5.5	0°	-6°	0.8	DC**11T3...	3
E12Q-SDZCR/L07-D180	Carbide	18	12	10.5	180	-	12.5	11	4.5	0°	-8°	0.4	DC**0702...	1.2
E16R-SDZCR/L07-D220	Carbide	22	16	12.5	200	-	12.5	15	4.5	0°	-6°	0.4	DC**0702...	1.2

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

**RE : Standard corner radius

Use right-hand toolholders (SDZCR**) with right-hand inserts (R); and left-hand toolholders (SDZCL**) with left-hand inserts (L).

SPARE PARTS

Designation	Clamping screw	Wrench
A10-SDZCR2-D14	CSTB-2.5	T-8F
A1**-SDZCR/L07-D1*0	CSTB-2.5	T-8F
A2**-SDZCR/L11-D2*0	CSTB-4S	T-15F
E1**-SDZCR/L07-D**0	CSTB-2.5	T-8F

INSERT SELECTION

P	Application	Precision finishing	Finishing	Finishing to medium cutting	Medium cutting
	Grade	SH725	SH725	T9215	T9215
	Breaker Shape	01	JS	PS	PM
	Cutting conditions	B020			

K	Application	Finishing to medium cutting
	Grade	T515
	Breaker Shape	CM
	Cutting conditions	B024

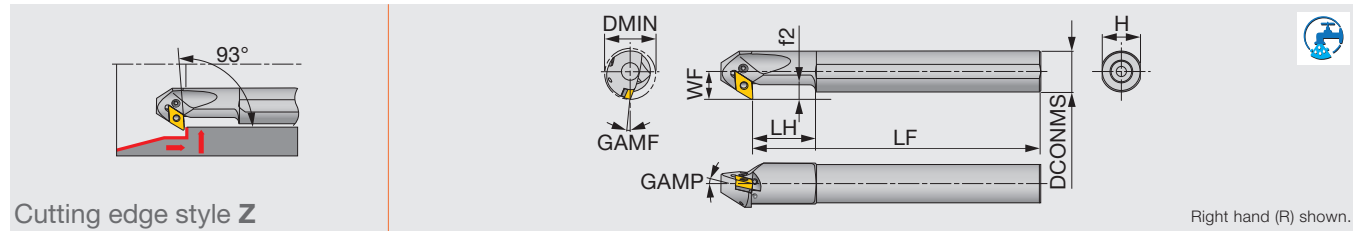
S	Application	Precision finishing	Finishing to medium cutting
	Grade	BX470	AH8005
	Breaker Shape	T-CBN	PS
	Cutting conditions	B028	

M	Application	Precision finishing	Finishing	Finishing to medium cutting	Medium cutting
	Grade	SH725	SH725	T9215	T9215
	Breaker Shape	01	JS	PS	PM
	Cutting conditions	B022			

N	Application	Precision finishing	Medium cutting
	Grade	DX120	KS05F
	Breaker Shape	T-DIA	AL
	Cutting conditions	B026	

H	Application	Precision finishing	Finishing
	Grade	BXM10	BXM20
	Breaker Shape	T-CBN	T-CBN
	Cutting conditions	B030	

Reference pages: A/E-SDZCR/L: Insert → B121 -, CBN → B184, PCD → B196 -



Metric	Material	DMIN	DCONMS	WF	LF	LH	H	f2	GAMP	GAMF	RE**	Insert	Torque
A32S-PDZNR/L15-D400	Steel	40	32	22	250	50	30	11.5	-6°	-13°	0.8	DN**1504...	4.8
A40T-PDZNR/L15-D500	Steel	50	40	27	300	60	37	14.5	-6°	-10°	0.8	DN**1504...	4.8
A50U-PDZNR/L15-D630	Steel	63	50	35	350	65	47	14.5	-6°	-8°	0.8	DN**1504...	4.8

Torque: Recommended clamping torque: N·m

**RE : Standard corner radius

Use right-hand toolholders (PDZNR**) with right-hand inserts (R); and left-hand toolholders (PDZNL**) with left-hand inserts (L).

SPARE PARTS

Designation	Shim	Clamping screw	Wrench	Spring pin	Lever	Oil supply attachment*	Screw for oil hole*
A32S-PDZNR15-D400	LSZ42BR	LCS4	P-3	LSP4	LCL4	EA-32	SSHM4-5
A32S-PDZNL15-D400	LSZ42BL	LCS4	P-3	LSP4	LCL4	EA-32	SSHM4-5
A40T-PDZNR15-D500	LSZ42BR	LCS4	P-3	LSP4	LCL4	-	SSHM5-6
A40T-PDZNL15-D500	LSZ42BL	LCS4	P-3	LSP4	LCL4	-	SSHM5-6
A50U-PDZNR15-D630	LSZ42BR	LCS4	P-3	LSP4	LCL4	-	SSHM6-6
A50U-PDZNL15-D630	LSZ42BL	LCS4	P-3	LSP4	LCL4	-	SSHM6-6

*Optional

INSERT SELECTION

P	Application	Precision finishing	Finishing	Medium cutting	Medium to heavy cutting
	Grade	NS9530	GT9530	T9215	T9215
	Breaker Shape	TF	TSF	TM	TH
	Cutting conditions	B008			

K	Application	Finishing	Medium cutting	Medium to heavy cutting
	Grade	T515	T515	T515
	Breaker Shape	All-round	All-round	All-round
	Cutting conditions	B012		

S	Application	Precision finishing	Finishing	Medium cutting
	Grade	BX470	AH8005	AH8005
	Breaker Shape	T-CBN	HRF	HRM
	Cutting conditions	B016		

M	Application	Finishing	Medium cutting	Medium to heavy cutting
	Grade	T6120	T6130	T6130
	Breaker Shape	SF	SM	SH
	Cutting conditions	B010		

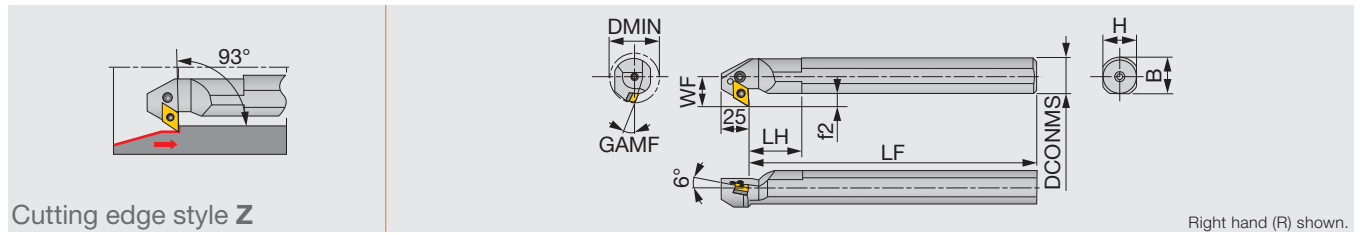
N	Application	Precision finishing	Finishing	Medium cutting
	Grade	DX120	DX140	TH10
	Breaker Shape	T-DIA	with rake T-DIA	P
	Cutting conditions	B014		

H	Application	Precision finishing	Finishing
	Grade	BXM10	BXM20
	Breaker Shape	T-CBN	T-CBN
	Cutting conditions	B018	

Reference pages: A-PDZNR/L: Insert → **B067 -**, CBN → **B174 -**, PCD → **B194 -**

S-PDZNR/L

Lever-lock boring bar, for negative 55° rhombic inserts



Metric	Material	DMIN	DCONMS	WF	LF	LH	H	f2	B	GAMF	RE**	Insert
S32S-PDZNR/L15	Steel	40	32	22	250	30	30	6	29.5	-13°	0.8	DN**1504...
S40T-PDZNR15	Steel	50	40	27	300	35	37	7	37.5	-10°	0.8	DN**1504...
S50U-PDZNR15	Steel	60	50	35	350	40	47	10	47.5	-8°	0.8	DN**1504...

SPARE PARTS

Designation	Shim	Clamping screw	Wrench	Spring pin	Lever
S32S-PDZNR15	LSZ42BR	LCS4	P-3	LSP4	LCL4
S32S-PDZNL15	LSZ42BL	LCS4	P-3	LSP4	LCL4
S*0*-PDZNR15	LSZ42BR	LCS4	P-3	LSP4	LCL4

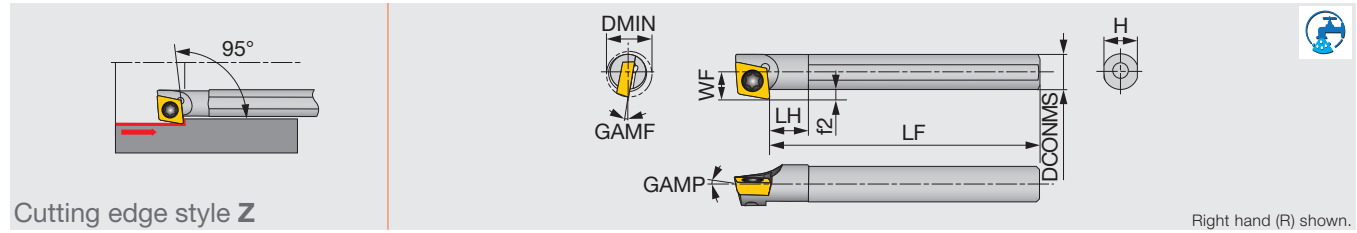
**RE : Standard corner radius

Use right-hand toolholders (R) with right-hand inserts (R); and left-hand toolholders (L) with left-hand inserts (L)

INSERT SELECTION

P	Application	Precision finishing	Finishing	Medium cutting	Medium to heavy cutting
	Grade	NS9530	GT9530	T9215	T9215
	Breaker Shape	TF	TSF	TM	TH
	Cutting conditions	B008			
K	Application	Finishing	Medium cutting	Medium to heavy cutting	
	Grade	T515	T515	T515	
	Breaker Shape	All-round	All-round	All-round	
	Cutting conditions	B012			
S	Application	Precision finishing	Finishing	Medium cutting	
	Grade	BX470	AH8005	AH8005	
	Breaker Shape	T-CBN	HRF	HRM	
	Cutting conditions	B016			
M	Application	Finishing	Medium cutting	Medium to heavy cutting	
	Grade	T6120	T6130	T6130	
	Breaker Shape	SF	SM	SH	
	Cutting conditions	B010			
N	Application	Precision finishing	Finishing	Medium cutting	
	Grade	DX120	DX140	TH10	
	Breaker Shape	T-DIA	T-DIA	P	
	Cutting conditions	B014			
H	Application	Precision finishing	Finishing		
	Grade	BXM10	BXM20		
	Breaker Shape	T-CBN	T-CBN		
	Cutting conditions	B018			

Reference pages: S-PDZNR/L: Insert → **B067 -**, CBN → **B174 -**, PCD → **B194 -**



Metric	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 clamping torque: N·m

**RE : Standard corner radius

Use right-hand toolholders (SEZPR**) with right-hand inserts (R); and left-hand toolholders (SEZPL**) with left-hand inserts (L).

SPARE PARTS

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

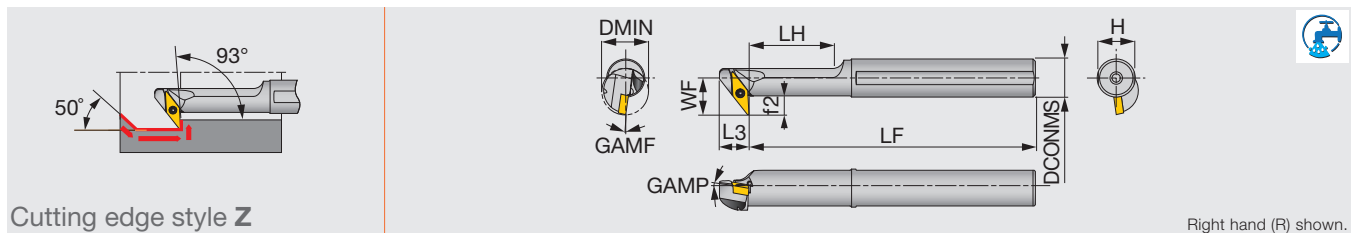
INSERT SELECTION

P	Application	Finishing	M	Application	Finishing	K	Application	Finishing
	Grade	SH725		Grade	SH725		Grade	SH725
	JS			JS			JS	
	Breaker Shape			Breaker Shape			Breaker Shape	
Cutting conditions		B008	Cutting conditions		B010	Cutting conditions		B012

N	Application	Precision finishing	Finishing	H	Application	Precision finishing
	Grade	DX140	GH110		Grade	BX310
	T-DIA	W08	T-CBN			
	Breaker Shape				Breaker Shape	
Cutting conditions		B014		Cutting conditions		B018

A-SVZBR/L

Screw-on boring bar, for positive 35° rhombic inserts



Cutting edge style Z

Right hand (R) shown.

Inch	Material	DMIN	DCONMS	WF	LF	LH	L3	H	f2	GAMP	GAMF	RE**	Insert	Torque
A12-SVZBR2-D16	Steel	1.000	0.750	0.594	10.000	1.425	0.500	0.725	0.219	0°	-5°	0.016	VB**1103...	0.89
Metric	Material	DMIN	DCONMS	WF	LF	LH	L3	H	f2	GAMP	GAMF	RE**	Insert	Torque*
A16Q-SVZBR/L11-D200	Steel	20	16	15.5	180	35	12.5	15	8	0°	-8°	0.4	VB**1103...	1.2
A20R-SVZBR/L11-D250	Steel	25	20	17.5	200	40	12.5	18	8	0°	-7°	0.4	VB**1103...	1.2
A25S-SVZBR/L16-D320	Steel	32	25	24	250	50	17.5	23	12	0°	-6°	0.8	VB**1604...	3
A32T-SVZBR/L16-D400	Steel	40	32	27.5	300	72	17.5	30	12	0°	-5°	0.8	VB**1604...	3

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

**RE : Standard corner radius

Use right-hand toolholders (SVZBR**) with right-hand inserts (R); and left-hand toolholders (SVZBL**) with left-hand inserts (L).

SPARE PARTS

Designation	Clamping screw	Wrench
A12-SVZBR2-D16	CSTB-2.5	T-8F
A**-SVZBR/L11-D2*0	CSTB-2.5	T-8F
A25S-SVZBR/L16-D320	CSTB-3.5	T-15F
A32T-SVZBR/L16-D400	CSTB-3.5L	T-15F

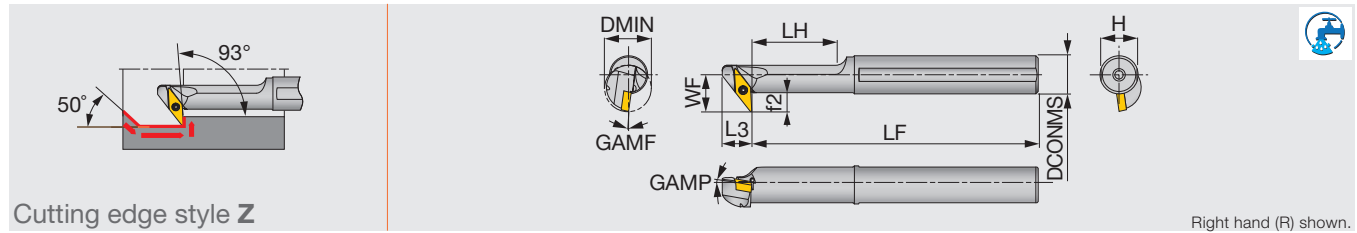
INSERT SELECTION

P	Application	Finishing	Finishing to medium cutting
	Grade	SH725	T9215
	Breaker Shape	JS	PS
	Cutting conditions	B020	
M	Application	Finishing	Finishing to medium cutting
	Grade	SH725	T9215
	Breaker Shape	JS	PS
	Cutting conditions	B022	
K	Application	Finishing to medium cutting	
	Grade	T515	
	Breaker Shape	CM	
	Cutting conditions	B024	
H	Application	Precision finishing	Finishing
	Grade	BXM10	BXM20
	Breaker Shape	T-CBN	T-CBN
	Cutting conditions	B030	

Reference pages: A-SVZBR/L: Insert → **B152 -**, CBN → **B191**

A-SVZCR/L

Screw-on boring bar, for positive 35° rhombic inserts



Inch	Material	DMIN	DCONMS	WF	LF	LH	L3	H	f2	GAMP	GAMF	RE**	Insert	Torque
A08-SVZCR6-D12	Steel	0.750	0.500	0.438	5.000	1.000	0.395	0.475	0.188	0°	-6°	0.016	VC**63...	0.44
A12-SVZCR2-D16	Steel	1.000	0.750	0.593	10.000	1.425	0.500	0.725	0.218	0°	-7°	0.016	VC**22...	0.44
Metric	Material	DMIN	DCONMS	WF	LF	LH	L3	H	f2	GAMP	GAMF	RE**	Insert	Torque*
A12M-SVZCR/L08-D160	Steel	16	12	11	150	30	10	11	5.5	0°	-8°	0.4	VC**0802...	0.6

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

**RE : Standard corner radius

Use right-hand toolholders (SVZCR**) with right-hand inserts (R); and left-hand toolholders (SVZCL**) with left-hand inserts (L).

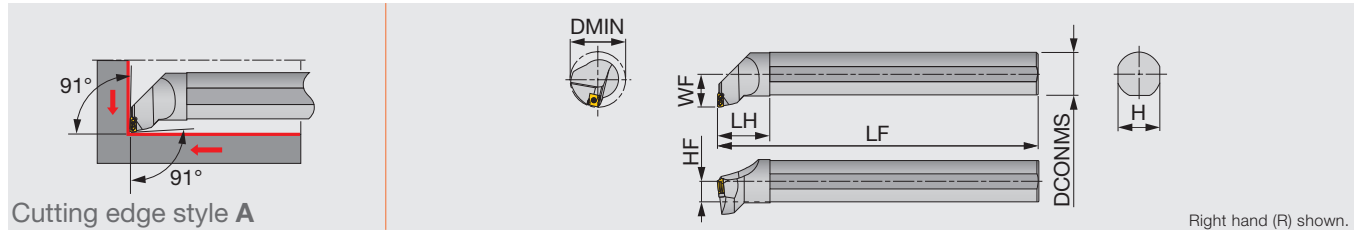
SPARE PARTS

Designation	Clamping screw	Wrench
A08-SVZCR6-D12	CSTB-2L	T-6F
A12-SVZCR2-D16	CSTB-2.5	T-8F
A12M-SVZCR/L08-D160	CSTB-2L	T-6F

INSERT SELECTION

P	Application	Finishing to medium cutting	M	Application	Finishing to medium cutting
	Grade	T9215		Grade	T9215
	Breaker Shape	PS		Breaker Shape	PS
	Cutting conditions	B020		Cutting conditions	B022
K	Application	Finishing to medium cutting	N	Application	Precision finishing
	Grade	T515		Grade	DX120 with rake AL KS05F
	Breaker Shape	CM		Breaker Shape	T-DIA
	Cutting conditions	B024		Cutting conditions	B026
S	Application	Finishing to medium cutting	H	Application	Precision finishing
	Grade	AH8005		Grade	BXM10 T-CBN
	Breaker Shape	PS		Breaker Shape	BXM20 T-CBN
	Cutting conditions	B028		Cutting conditions	B030

Reference pages: A-SVZCR/L: Insert → **B155 -**

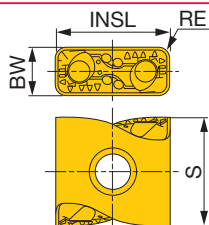


Inch	Material	DMIN	DCONMS	WF	LF	LH	H	HF	Insert
S16-TLANR/L12-D34	Steel	2.090	1.000	0.670	12.000	1.500	0.920	0.460	LNMX1204**L/R...
S20-TLANR/L12-D34	Steel	2.090	1.250	0.870	14.000	1.750	1.140	0.570	LNMX1204**L/R...
S24-TLANR/L12-D34	Steel	2.090	1.500	1.060	16.000	2.000	1.340	0.670	LNMX1204**L/R...
S32-TLANR/L16-D54	Steel	3.350	2.000	1.460	16.000	2.360	1.810	0.905	LNMX1606**L/R...

Use right-hand toolholders (TLANR**) with left-hand inserts (L); and left-hand toolholders (TLANL**) with right-hand inserts (R).

SPARE PARTS

Designation	Clamping screw	Shim screw	Shim	Spring pin	Wrench 1	Wrench 2
S**-TLANR/L12-D34	CSTB-3.5L115-S	CSTF-2L055-S	TSL12L/RI	-	KEYV-T10	T-6F-S
S32-TLANR16-D54	CSTB-4L115-S	-	TSL16LI	PSP-16	KEYV-T15	-
S32-TLANL16-D54	CSTB-4L115-S	-	TSL16RI	PSP-16	KEYV-T15	-



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

★ : First choice

★ : First choice
☆ : Second choice

Designation	HAND	RE (in)	Coated										BW (in)	INSL (in)	S (in)
			T9115	T9125	AH725										
LNMX120408R-TDR	R	0.031	●	●									0.189	0.472	0.457
LNMX120408L-TDR	L	0.031	●	●									0.189	0.472	0.457
LNMX120412R-TDR	R	0.047	●	●									0.189	0.472	0.457
LNMX120412L-TDR	L	0.047	●	●									0.189	0.472	0.457
LNMX160608R-TDR	R	0.031	●	●									0.252	0.638	0.531
LNMX160608L-TDR	L	0.031	●	●									0.252	0.638	0.531
LNMX160612R-TDR	R	0.047	●	●									0.252	0.638	0.531
LNMX160612L-TDR	L	0.047	●	●									0.252	0.638	0.531
LNMX160616R-TDR	R	0.063	●	●									0.252	0.638	0.531
LNMX160616L-TDR	L	0.063	●	●									0.252	0.638	0.531
LNMX241016R-TDR	R	0.063	●	●									0.370	0.945	0.807
LNMX241016L-TDR	L	0.063	●	●									0.370	0.945	0.807
LNMX241024R-TDR	R	0.094	●	●									0.370	0.945	0.807
LNMX241024L-TDR	L	0.094	●	●									0.370	0.945	0.807
LNMX160608R-MDR	R	0.031	●		●								0.252	0.638	0.531
LNMX160608L-MDR	L	0.031	●		●								0.252	0.638	0.531
LNMX160612R-MDR	R	0.047	●		●								0.252	0.638	0.531
LNMX160612L-MDR	L	0.047	●		●								0.252	0.638	0.531
LNMX160608R-TWR	R	0.031	●	●									0.252	0.638	0.531
LNMX160608L-TWR	L	0.031	●	●									0.252	0.638	0.531
LNMX160612R-TWR	R	0.047	●	●									0.252	0.638	0.531
LNMX160612L-TWR	L	0.047	●	●									0.252	0.638	0.531

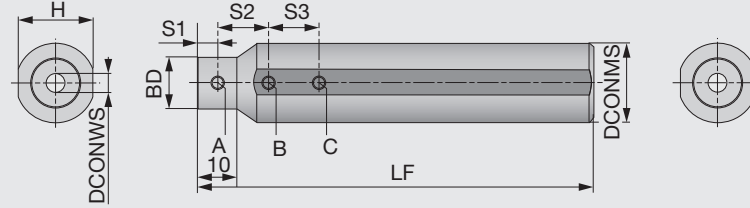
● : Line up

Technical Guide

STREAMJETBAR

BLM sleeve

Round shank sleeve for StreamJetBar-Mini series



Metric	DCONMS	DCONWS	BD	LF	H	S1	S2	S3
BLM159-04	15.875 (0.625")	4	15	100	15	5	15	15
BLM159-05	15.875 (0.625")	5	15	100	15	5	15	15
BLM159-06	15.875 (0.625")	6	15	100	15	5	20	20
BLM159-07	15.875 (0.625")	7	15	100	15	5	20	20
BLM16-04	16	4	15	100	15	5	15	15
BLM16-05	16	5	15	100	15	5	15	15
BLM16-06	16	6	15	100	15	5	20	20
BLM16-07	16	7	15	100	15	5	20	20
BLM19-04	19.05 (0.750")	4	18	100	18	5	15	15
BLM19-05	19.05 (0.750")	5	18	100	18	5	15	15
BLM19-06	19.05 (0.750")	6	18	100	18	5	20	20
BLM19-07	19.05 (0.750")	7	18	100	18	5	20	20
BLM20-04	20	4	13	100	19	5	15	15
BLM20-05	20	5	14	100	19	5	15	15
BLM20-06	20	6	15	100	19	5	20	20
BLM20-07	20	7	16	100	19	5	20	20
BLM22-04	22	4	13	125	21	5	15	15
BLM22-05	22	5	14	125	21	5	15	15
BLM22-06	22	6	15	125	21	5	20	20
BLM22-07	22	7	16	125	21	5	20	20
BLM25-04	25	4	13	125	24	5	15	15
BLM25-05	25	5	14	125	24	5	15	15
BLM25-06	25	6	15	125	24	5	20	20
BLM25-07	25	7	16	125	24	5	20	20
BLM254-04	25.4 (1.000")	4	13	125	24	5	15	15
BLM254-05	25.4 (1.000")	5	14	125	24	5	15	15
BLM254-06	25.4 (1.000")	6	15	125	24	5	20	20
BLM254-07	25.4 (1.000")	7	16	125	24	5	20	20

SPARE PARTS

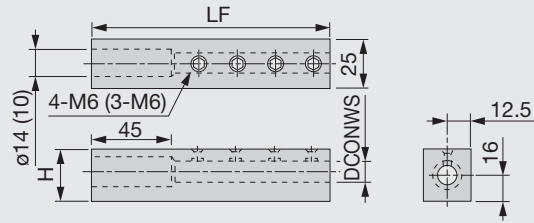


Designation	Clamping screw A	Clamping screw B, C	Wrench	Seal cap* (inner screw)
BLM159, 16...	SSHM4-4	SSHM4-4	P-2	CA-16(M6)
BLM19-04	SSHM4-4	SSHM4-6	P-2	CA-16(M6)
BLM19-05, 06, 07	SSHM4-4	SSHM4-4	P-2	CA-16(M6)
BLM20-04, 05	SSHM4-4	SSHM4-6	P-2	CA-16(M6)
BLM20-06, 07	SSHM4-4	SSHM4-4	P-2	CA-16(M6)
BLM22-...	SSHM4-4	SSHM4-6	P-2	CA-16(M6)
BLM25-04, 05	SSHM4-4	SSHM4-8	P-2	CA-16(M6)
BLM25-06	SSHM4-4	SSHM4-8	P-2	CA-16(M6)
BLM25-07	SSHM4-4	SSHM4-6	P-2	CA-16(M6)
BLM254-04, 05, 06	SSHM4-4	SSHM4-8	P-2	CA-16(M6)
BLM254-07	SSHM4-4	SSHM4-6	P-2	CA-16(M6)

*Optional

BLS sleeve

Square shank sleeve for boring bars (regular length)



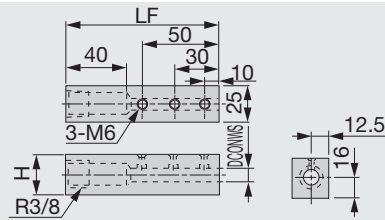
Metric	DCONWS	LF	H
BLS16-08	8	125	28
BLS16-10	10	125	28
BLS16-12	12	125	28

SPARE PARTS

Designation	Wrench
BLS16-...	P-3

BLS-C sleeve

Square shank sleeve for boring bars (short type)



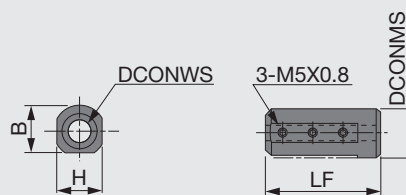
Metric	DCONWS	LF	H
BLS16-08C	8	100	28
BLS16-10C	10	100	28
BLS16-12C	12	100	28

SPARE PARTS

Designation	Wrench
BLS16-**C	P-3

BLM sleeve

Round shank sleeve for boring bars



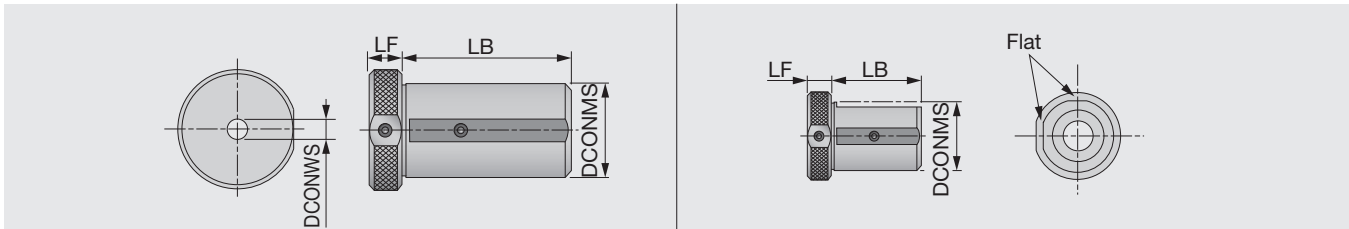
Metric	DCONWS	DCONMS	LF	H	B
BLM19-08	8	19.05	100	18	18
BLM20-08	8	20	100	18	19
BLM22-08	8	22	125	21	21
BLM254-08	8	25.4	125	24	24
BLM25-08C	8	25	55	23	24
BLM25-10C	10	25	55	23	24
BLM25-12C	12	25	55	23	24

SPARE PARTS

Designation	Wrench
BLM...	P-2.5

BLC sleeve

Round shank sleeve for boring bars



Metric	DCONWS	LB	LF	DCONMS
BLC40-8	8	73	13	40
BLC40-10	10	73	13	40
BLC40-12	12	73	13	40
BLC40-16	16	73	13	40
BLC32-8C	8	45	20	32
BLC32-10C	10	45	20	32
BLC32-12C	12	45	20	32
BLC40-8C	8	55	13	40
BLC40-10C	10	55	13	40
BLC40-12C	12	55	13	40
BLC40-16C	16	55	13	40

SPARE PARTS



Designation	Wrench
BLC40-8	P-3
BLC40-1...	P-4
BLC32-8C	P-3
BLC32-1*C	P-4
BLC40-8C	P-3
BLC40-1*C	P-4

MINIFORCE

STANDARD CUTTING CONDITIONS

Internal turning

ISO	Workpiece material	Grade			Cutting speed Vc (sfm)	Depth of cut ap (in)	Feed f (ipr)
		First Choice	For surface finish	For wear resistance (High speed)			
P	Low carbon steel 1025, etc.	AH725	-	-	164 - 180	0.012 - 0.079	0.003 - 0.012
		-	-	AH8015	164 - 656	0.012 - 0.079	0.003 - 0.012
		-	NS9530	-	262 - 820	0.012 - 0.079	0.003 - 0.012
		-	GT9530	-	262 - 984	0.012 - 0.079	0.003 - 0.012
	Carbon steel 1045, 1055, etc.	AH725	-	-	164 - 591	0.012 - 0.079	0.003 - 0.012
		-	-	AH8015	164 - 656	0.012 - 0.079	0.003 - 0.012
		-	NS9530	-	262 - 820	0.012 - 0.079	0.003 - 0.012
		-	GT9530	-	262 - 984	0.012 - 0.079	0.003 - 0.012
	Low alloy steel 4140, etc.	AH725	-	-	164 - 591	0.012 - 0.079	0.003 - 0.012
		-	-	AH8015	164 - 656	0.012 - 0.079	0.003 - 0.012
		-	NS9530	-	262 - 820	0.012 - 0.079	0.003 - 0.012
		-	GT9530	-	262 - 984	0.012 - 0.079	0.003 - 0.012
	Alloy steel 5120, etc.	AH725	-	-	164 - 591	0.012 - 0.079	0.003 - 0.012
		-	-	AH8015	164 - 656	0.012 - 0.079	0.003 - 0.012
		-	NS9530	-	262 - 820	0.012 - 0.079	0.003 - 0.012
		-	GT9530	-	262 - 984	0.012 - 0.079	0.003 - 0.012
M	Stainless steel (Austenitic) 304, etc.	AH8015	-	-	164 - 492	0.012 - 0.079	0.003 - 0.012
	Stainless steel (Martensitic and ferritic) 430, etc.	AH8015	-	-	164 - 492	0.012 - 0.079	0.003 - 0.012
	Stainless steel (Precipitation hardening) 174, etc.	AH8015	-	-	164 - 492	0.012 - 0.079	0.003 - 0.012
K	Gray cast iron No.250B, etc.	AH725	-	-	164 - 591	0.012 - 0.079	0.003 - 0.012
		-	-	AH8015	164 - 656	0.012 - 0.079	0.003 - 0.012
		-	NS9530	-	262 - 820	0.012 - 0.079	0.003 - 0.012
		-	GT9530	-	262 - 984	0.012 - 0.079	0.003 - 0.012
	Ductile cast iron 80-55-60, etc.	AH725	-	-	164 - 591	0.012 - 0.079	0.003 - 0.012
		-	-	AH8015	164 - 656	0.012 - 0.079	0.003 - 0.012
		-	NS9530	-	262 - 820	0.012 - 0.079	0.003 - 0.012
		-	GT9530	-	262 - 984	0.012 - 0.079	0.003 - 0.012
N	Non ferrous Metal Aluminum alloy, etc.	KS05F	-	-	328 - 984	0.012 - 0.079	0.003 - 0.012
	Non ferrous Metal Cu Alloy, etc.	KS05F	-	-	328 - 984	0.012 - 0.079	0.003 - 0.012
S	Heat-resistant alloys Titanium alloys, etc.	AH8015	-	-	66 - 262	0.012 - 0.079	0.003 - 0.012
	Heat-resistant alloys Nickel-base alloys	AH8015	-	-	66 - 262	0.012 - 0.079	0.003 - 0.012

Reference pages: A/E-SWLXR/L → **D034**, A/E-SDXXR/L → **D042**
A/E-SDZXR/L → **D093**

Technical Guide

TURNTEC

STANDARD CUTTING CONDITIONS

LNMX1204

*Values in red are for facing.

ISO	Workpiece material	Chip breaker	Grade	Cutting speed Vc (sfm)	Depth of cut: ap (in)		Feed: f (ipr)	
					RE : 0.031	RE : 0.047	RE : 0.031	RE : 0.047
P	Steels 1045, 4130, etc.	TDR	T9115	390 - 820	0.020 - 0.195 0.020 - 0.086	0.031 - 0.195 0.031 - 0.086	0.006 - 0.024	0.010 - 0.031
		TDR	T9125	260 - 590	0.020 - 0.195 0.020 - 0.086	0.031 - 0.195 0.031 - 0.086	0.006 - 0.024	0.010 - 0.031
M	Stainless steels 304, 316, etc.	TDR	T9115	330 - 590	0.020 - 0.195 0.020 - .086	0.031 - 0.195 0.031 - 0.086	0.006 - 0.024	0.010 - 0.031
		TDR	T9125	260 - 590	0.020 - 0.195 0.020 - 0.086	0.031 - 0.195 0.031 - 0.086	0.006 - 0.024	0.010 - 0.031

LNMX1606

ISO	Workpiece material	Chip breaker	Grade	Cutting speed Vc (sfm)	Depth of cut: ap (in)			Feed: f (ipr)		
					RE : 0.031	RE : 0.047	RE : 0.063	RE : 0.031	RE : 0.047	RE : 0.063
P	Steels 1045, 4130, etc.	TDR	T9115	390 - 820	0.020 - 0.197 0.020 - .126	0.031 - 0.236 .031 - .126	0.039 - 0.315 0.039 - 0.126	0.006 - 0.024	0.010 - 0.031	0.012 - 0.039
		TDR	T9125	260 - 590	0.020 - 0.197 0.020 - .126	0.031 - 0.236 .031 - .126	0.039 - 0.315 0.039 - 0.126	0.006 - 0.024	0.010 - 0.031	0.012 - 0.039
		TWR	T9115	390 - 820	0.020 - 0.197 0.020 - 0.126	0.031 - 0.236 0.031 - 0.126	-	0.006 - 0.024	0.010 - 0.031	-
		TWR	T9125	260 - 590	0.020 - 0.197 0.020 - 0.126	0.031 - 0.236 0.031 - 0.126	-	0.006 - 0.024	0.010 - 0.031	-
M	Stainless steels 304, 316, etc.	TDR	T9115	330 - 590	0.020 - 0.197 0.020 - 0.126	0.031 - 0.236 0.031 - 0.126	0.039 - 0.315 0.039 - 0.126	0.006 - 0.024	0.010 - 0.031	0.012 - 0.039
		TDR	T9125	260 - 590	0.020 - 0.197 0.020 - 0.126	0.031 - 0.236 0.031 - 0.126	0.039 - 0.315 0.039 - 0.126	0.006 - 0.024	0.010 - 0.031	0.012 - 0.039
		MDR	T9115	330 - 490	0.059 - 0.236 0.020 - 0.126	0.059 - 0.276 0.031 - 0.126	-	0.004 - 0.020	0.006 - 0.028	-
		MDR	AH725	160 - 490	0.059 - 0.236 0.020 - 0.126	0.059 - 0.276 0.031 - 0.126	-	0.004 - 0.020	0.006 - 0.028	-
		TWR	T9115	330 - 590	0.020 - 0.197 0.020 - 0.126	0.031 - 0.236 0.031 - 0.126	-	0.006 - 0.024	0.010 - 0.031	-
		TWR	T9125	260 - 590	0.020 - 0.197 0.020 - 0.126	0.031 - 0.236 0.031 - 0.126	-	0.006 - 0.024	0.010 - 0.031	-

LNMX2410

ISO	Workpiece material	Chip breaker	Grade	Cutting speed Vc (sfm)	Depth of cut: ap (in)		Feed: f (ipr)	
					RE : 0.063	RE : 0.094	RE : 0.063	RE : 0.094
P	Steels 1045, 4130, etc.	TDR	T9115	390 - 820	0.156 - 0.585 0.039 - 0.176	0.195 - 0.585 0.039 - 0.176	0.012 - 0.039	0.012 - 0.043
		TDR	T9125	260 - 490	0.156 - 0.585 0.039 - 0.176	0.195 - 0.585 0.039 - 0.176	0.012 - 0.039	0.012 - 0.043
M	Stainless steels 304, 316, etc.	TDR	T9115	330 - 590	0.156 - 0.585 0.039 - 0.176	0.195 - 0.585 0.039 - 0.176	0.012 - 0.039	0.012 - 0.043
		TDR	T9125	260 - 490	0.156 - 0.585 0.039 - 0.176	0.195 - 0.585 0.039 - 0.176	0.012 - 0.039	0.012 - 0.043

Reference pages: S-TLANR/L → **D100**