Internal Toolholder

Internal Toolholder - Content structure

- Indexable toolholders are listed by cutting edge shape.
- Toolholders in the catalog are our standard items.

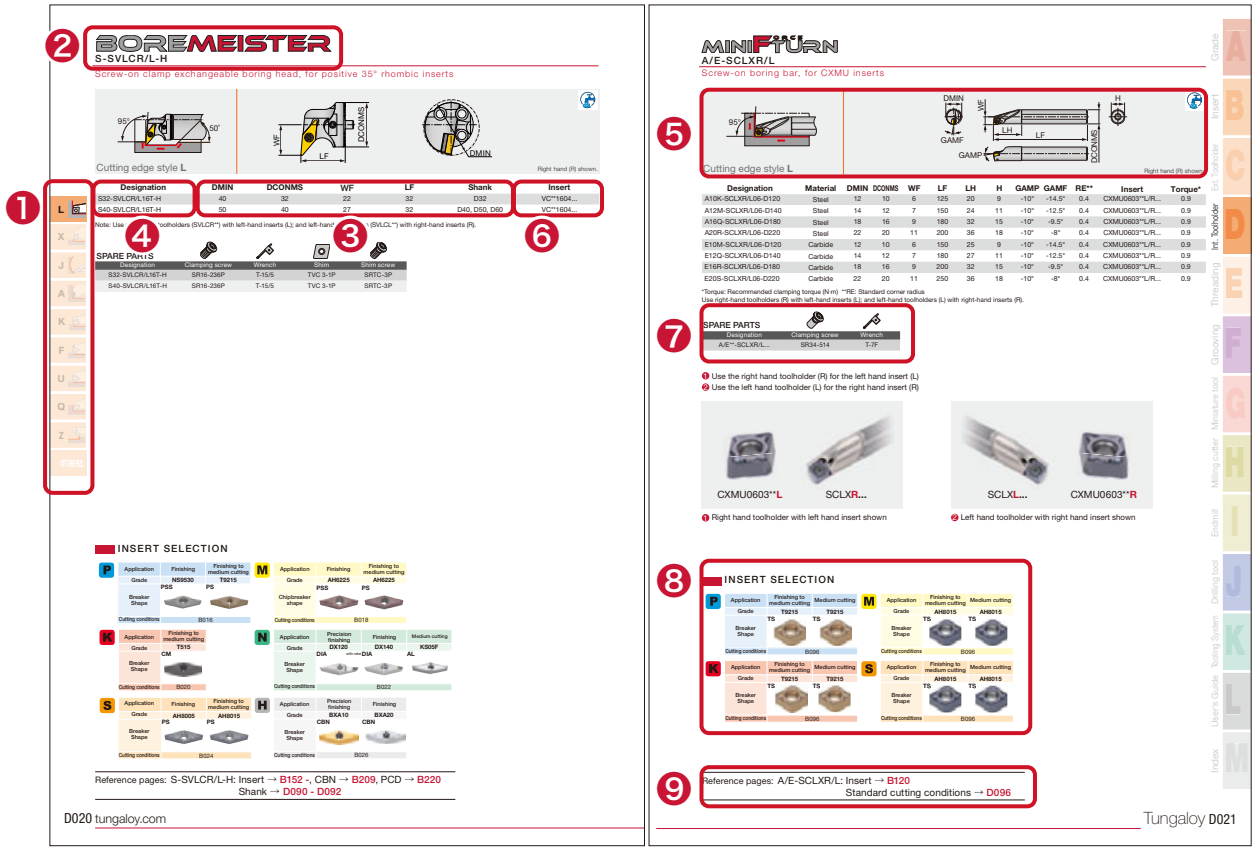
How to use the page

Method ① Select the cutting edge shape described at the left end of each page, jump to the page on the left index, and choose a designation you need (❹) in the dimension table (❸). Applicable inserts are shown in (❻) and (❽).

Method ② Select the cutting edge 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 D004 - D009.



❶ : Cutting edge shape
❷ : Series name of indexable boring bars
❸ : Dimension table
❹ : Toolholder designation
e.g. To select right-handed steel shank with minimum machining diameter ø13

→ **A10K-SDXXR07-D130**

❺ : Dimension drawing (conforming to ISO13399)
❻ : Applicable insert
❼ : Spare parts
❽ : Insert selection
❾ : Reference pages

When ordering
- Please specify the designation and quantity.
  e.g. **A12M-SDZXR/L07-D140 ...** 1 (one boring bar per package)
  * Inserts are not included. Please order those separately.

Main products

L 95° D014
X 100° D034
J 142° D038
A 91° D040
K 75° D041
F 91° D045
U 93° D052
Q 107.5° D076
Z 93° D084
OTHERS D090

BOREMEISTER

Boring head suitable for L/D=10

Shank **ø16 - 60 mm**

D010

MINIFORCETURN

Economical double-sided inserts with excellent sharpness

Shank **ø10 - 20 mm**

D013

ISOECOTURN

Small-sized "Eco" insert series for maximized profits

Shank **ø16 - 32 mm**

D025 -, D031 -
D049 -, D067
D069 -, D074

STREAMJETBAR

Highly rigid toolholders providing good chip evacuation

Shank **ø4 - 50 mm**

D011

Y-PRO SERIES

Inserts with 25° corner angle for profiling

Shank **ø12 - 16 mm**

D064, D083

TURNINGA

Highly rigid clamping system with excellent repeatability

Shank **ø25 - 50 mm**

D030, D033, D044
D051, D072, D075

TUNGTURNJET

Toolholders for high pressure coolant supply

D026, D071

TUNGBOREMINI

Multifunctional tool for drilling, external turning and internal turning

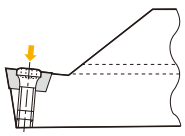
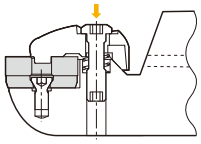
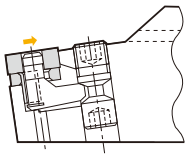
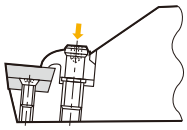
Shank **ø8 - 12 mm**

D012

Sleeve

D092 -

Internal Toolholder - Quick Guide

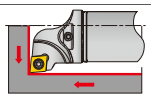
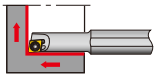
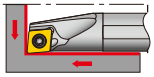
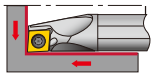
Screw-on	Double clamping	Lever-lock	Clamp-on
 STREAMJETBAR MINIFTURN	 TURNINGA	 ISOETURN	
• Simple clamping mechanism. • Smart shape without overhang area. • Minimum bore diameter: ø4.5 mm. • Good cutting action by using positive inserts. • Carbide shanks that have excellent resistance to chatter. • "Tsuppari-Ichiban" shanks (reinforced with carbide plates) are also stocked.	• Increased clamping rigidity contributes to superior cutting edge positioning accuracy & longer tool life. • Enlarged insert holding area of the clamp allows more accurate cutting edge positioning. It delivers high performance even when using VNMG type (35° corner angle) inserts, which tend to destabilize cutting edge positioning. • Simple structure keeps cost low. Easy clamping with only one wrench.	• Negative rake, lever-lock type, round shank boring bars. • The insert is positively held into a two wall pocket, excelling in indexing accuracy. • Minimum bore diameter: ø20 mm. • "Tsuppari-Ichiban" shanks that are reinforced with carbide plates are also stocked.	• Clamp-on type insert locking mechanism assures secure holding & accurate indexing. • For inserts without a hole, it provides stronger cutting edge strength than S-type tools & can withstand heavier cutting conditions. • Minimum bore diameter: ø16 mm

Tool selection according to the ratio of length to tool diameter (L/D) for different shank materials

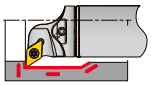
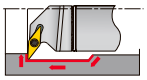
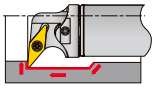
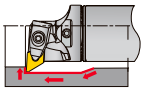
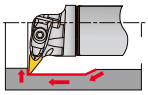
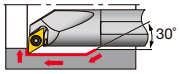
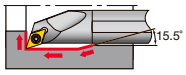
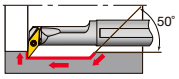
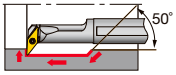
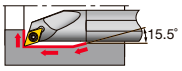
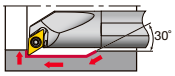
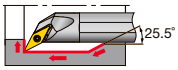
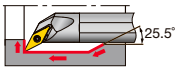
Steel shank	Carbide reinforced	Carbide shank	BoreMeister
L/D ≤ 3	L/D ≤ 4	L/D ≤ 5	L/D ≤ 10

For custom tooling inquiries, contact Tungaloy

Positive type

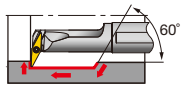
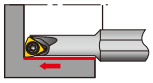
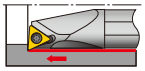
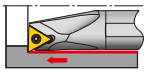
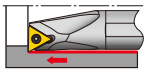
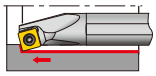
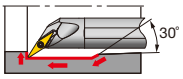
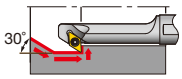
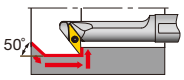
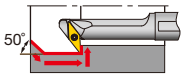
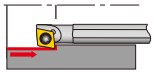
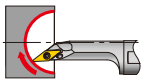
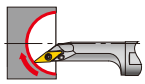
Application	Style	Designation	Insert	Material	Through coolant	ISO Insert	BOREMEISTER	STREAMJETBAR	Min. bore diameter DMIN (mm) (0 10 20 30 40 50)	Page
Boring & internal facing		S-SCLCR/L-H	CC...	Steel Carbide	○	✓	✓		ø20 – ø50	D017
		SEXPR/L	EP...	Steel Carbide	○	✓		✓	ø4.5 – ø7 ø4.5 – ø7	D034 D035
		SCLCR/L	CC...	Steel Carbide Reinforced	○	✓		✓	ø5 – ø27 ø5 – ø27 ø16 – ø32	D014 - D016
		SCLPR/L	CP...	Steel Carbide Reinforced	○	✓		✓	ø10 – ø27 ø10 – ø20 ø14 – ø32	D018 D019

Positive type

Application	Style	Designation	Insert	Material	Through coolant	ISO Insert	BOREMEISTER	STREAMJETBAR	Min. bore diameter DMIN (mm) (0 10 20 30 40 50)	Page
Boring & internal profiling		**S-SDUCR/L-H**	DC...	Steel Carbide	○	✓	✓		ø20 – ø50	D057
		**S-SVUCR/L-H**	VC...	Steel Carbide	○	✓	✓		ø27 – ø31	D063
		**S-SVLCR/L-H**	VC...	Steel Carbide	○	✓	✓		ø40 – ø50	D020
		**S-DDUNR/L-H**	DN...	Steel Carbide	○	✓	✓		ø40 – ø50	D073
		**S-DVUNR/L-H**	VN...	Steel Carbide	○	✓	✓		ø56	D075
		**SDUCR/L**	DC...	Steel Carbide	○	✓		✓	ø13 – ø32 ø13 – ø27	D056
		**SDUPR/L**	DP...	Steel Carbide	○			✓	ø15 – ø22 ø15 – ø22	D058
		**SVUCR/L**	VC...	Steel Carbide Reinforced	○	✓		✓	ø16 – ø32 ø18 – ø32 ø32	D061
		**SVUBR/L**	VB...	Steel Carbide Reinforced	○	✓		✓	ø20 – ø32 ø24.5 – ø34 ø25	D059
		**SDQCR/L**	DC...	Steel Carbide Reinforced	○	✓		✓	ø13 – ø30 ø13 – ø25 ø20 – ø32	D076 D077
		**SDQPR/L**	DP...	Steel Carbide	○			✓	ø15 – ø22 ø15 – ø22	D078
		**SVQCR/L**	VC...	Steel Carbide Reinforced	○	✓		✓	ø13.5 – ø21.5 ø13.5 – ø21.5 ø32	D081
		**SVQBR/L**	VB...	Steel Carbide Reinforced	○	✓		✓	ø17 – ø30.5 ø17 – ø30.5 ø25	D079

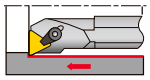
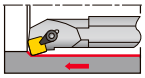
Internal Toolholder - Quick Guide

Positive type

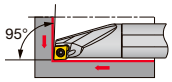
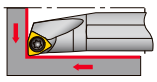
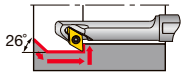
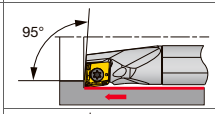
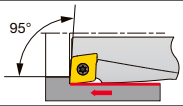
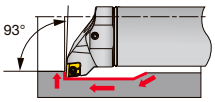
Application	Style	Designation	Insert	Material	Through coolant	ISO Insert	STREAMJETBAR	Min. bore diameter DMIN (mm) (0 10 20 30 40 50)	Page
Boring & internal profiling		**SYUBR/L**	YW...	Steel Carbide	○		✓	ø20 ø20 ø24.5	D064
Boring		**SWUBR/L**	WB...	Steel Carbide	○	✓	✓	ø6 ø8 ø6 ø8	D052
Boring		**STUPR/L**	TP...	Steel Carbide Reinforced	○	✓	✓	ø8 ø34 ø8 ø27 ø14 ø31	D053 - D055
Blind hole boring		**STFPR/L**	TP...	Steel Carbide	○	✓	✓	ø10 ø27 ø10 ø22	D046
Blind hole boring		**STFCR/L**	TC...	Steel Carbide	○	✓	✓	ø12 ø18 ø12 ø18	D045
Through boring		**SSKPR**	SP...	Steel	○	✓	✓	ø20 ø31	D041
Boring, undercutting & profiling		**SYQBR/L**	YW...	Steel Carbide	○		✓	ø17 ø21.5 ø17 ø21.5	D083
Back boring		**SDZCR/L**	DC...	Steel Carbide	○	✓	✓	ø14 ø25 ø18 ø22	D085
Back boring		**SVZCR/L**	VC...	Steel	○	✓	✓	ø16	D088
Back boring		**SVZBR/L**	VB...	Steel	○	✓	✓	ø20 ø40	D087
Back boring		**SEZPR/L**	EP...	Steel Carbide	○	✓	✓	ø5.5 ø6.5 ø5.5 ø6.5	D084
Internal sphere cutting		**SVJCR/L**	VC...	Steel	○	✓	✓	ø16 ø20	D039
Internal sphere cutting		**SVJBR/L**	VB...	Steel	○	✓	✓	ø25 ø30	D038

Positive type

Clamp on

Application	Style	Designation	Insert	Material	Through coolant	ISO Insert	Min. bore diameter DMIN (mm) (0 10 20 30 40 50)	Page
Blind hole boring		**CTFPR/L**	TP... Without hole	Steel Carbide		✓	ø16 – ø40 ø16 – ø20	D047
Through boring		**CSKPR/L**	SP... Without hole	Steel		✓	ø20 – ø32	D042

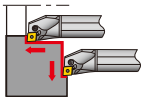
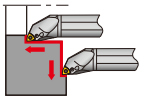
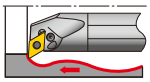
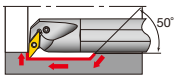
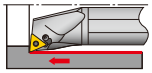
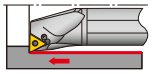
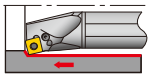
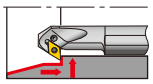
Positive double side

Application	Style	Designation	Insert	Material	Through coolant	TUNGBÖRINI	BOREMEISTER	MINIFÜRN	Min. bore diameter DMIN (mm) (0 10 20 30 40 50)	Page
Boring & internal facing		**SCLXR/L**	CX...	Steel Carbide	○			✓	ø12 – ø22 ø12 – ø22	D021
		**SWLXR/L**	WX...	Steel Carbide	○			✓	ø12 – ø22 ø12 – ø22	D023
Boring & internal profiling		**SDXXR/L**	DX...	Steel Carbide	○			✓	ø13 – ø24 ø13 – ø24	D036
Back boring		**SDZXR/L**	DX...	Steel Carbide	○			✓	ø14 – ø20 ø18 – ø22	D086
Boring		**A/E-SXUOR/L**	XOMU	Steel Carbide	○	✓			ø10 – ø14 ø10 – ø14	D065
		**TBM**	XOMU	Steel	○	✓			ø10 – ø16	D065
Boring & internal profiling		**S-SXUOR05-H**	XOMU	Steel Carbide	○	✓	✓		ø25 – ø32	D066

Internal Toolholder - Quick Guide

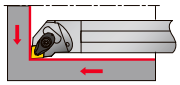
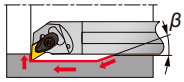
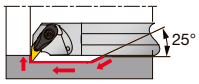
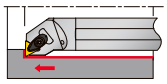
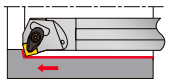
Negative type

Lever lock

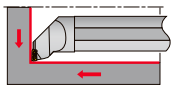
Application	Style	Designation	Insert	Material	Through coolant	ISO Insert	ISOEFURN	STREAMJETBAR	TUNGTJET	Min. bore diameter DMIN (mm) (20 30 40 50 60 70)	Page
Boring & internal facing		**PCLNR/L**	CN..., GN...	Steel Reinforced	○	✓	✓	✓	✓	ø20 – ø63 ø20 – ø63	D025 - D028
Boring & internal facing		**PWLNR/L**	WN...	Steel	○	✓	✓	✓		ø20 – ø50	D031 D032
Boring & internal profiling		**PDUNR/L**	DN..., FN...	Steel Reinforced	○	✓	✓	✓	✓	ø25 – ø63 ø40 – ø63	D069 D070
Boring & internal profiling		**PVUNR/L**	VN..., YN...	Steel	○	✓	✓	✓		ø37 – ø50	D074
Boring		**PTUNR/L**	TN...	Steel Reinforced	○	✓	✓	✓		ø20 – ø40 ø20 – ø63	D067
Boring		**PTFNR/L**	TN...	Steel	○	✓	✓	✓		ø32 – ø63	D049 D050
Through boring		**PSKNR/L**	SN...	Steel	○	✓		✓		ø40 – ø63	D043
Back boring		**PDZNR/L**	DN...	Steel	○	✓		✓		ø40 – ø63	D088 D089

Negative type

Double clamp

Application	Style	Designation	Insert	Material	Through coolant	ISO Insert	ISOFIT	TURNING	Min. bore diameter DMIN (mm) (20 30 40 50 60 70)	Page
Boring & internal facing		**ACLNR/L**	CN..., GN...	Steel	○	✓	✓	✓	ø32 – ø63	D030
Boring & internal facing		**AWLNR/L**	WN...	Steel	○	✓	✓	✓	ø32 – ø63	D033
Boring & internal profiling		**ADUNR/L**	DN..., FN...	Steel	○	✓	✓	✓	ø32 – ø63	D072
Boring & internal profiling		**AVUNR/L**	VN..., YN...	Steel	○	✓		✓	ø40 – ø50	D075
Boring		**ATFNR/L**	TN...	Steel	○	✓		✓	ø32 – ø40	D051
Boring		**ASKNR/L**	SN...	Steel	○	✓		✓	ø32 – ø40	D044

Screw-on

Application	Style	Designation	Insert	Material	Through coolant	TURNTEC	Min. bore diameter DMIN (mm) (40 50 60 70 80 90)	Page
Boring & internal facing		**S-TLANR/L**	LNMX	Steel		✓	ø53 – ø85	D040

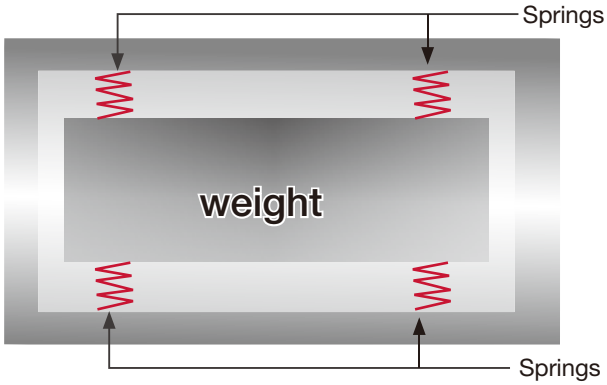
BOREMEISTER

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

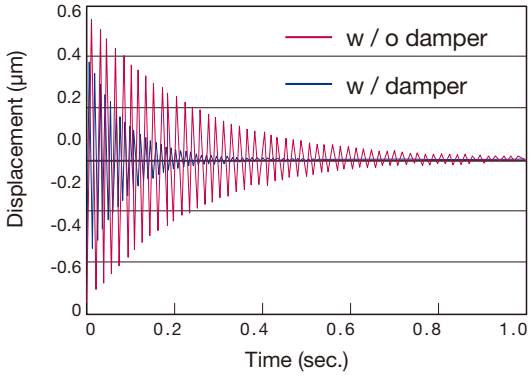
Vibration Dampening Mechanism

When cutting forces create vibration on boring bar set up 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

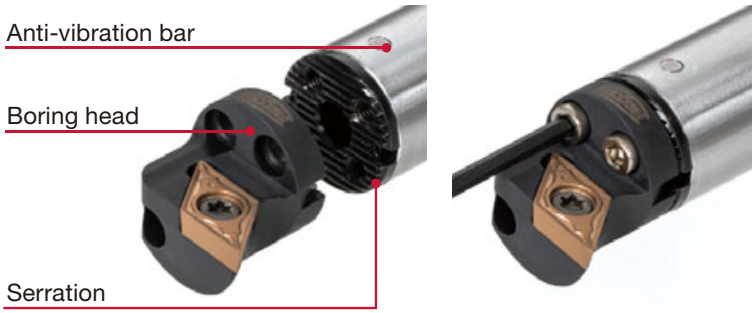


- Tool vibrations with and without vibration damper



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 : ø20 mm

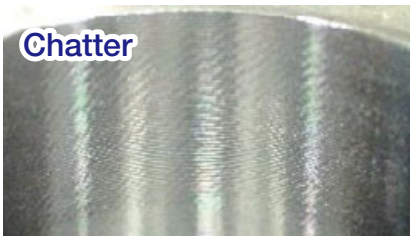


Reference pages: D017, D020, D029, D048, D050, D057, D063, D066, D073, D075, D090 - D092

STREAMJETBAR

Engineered for tool strength and optimal chip evacuation

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



Competitor

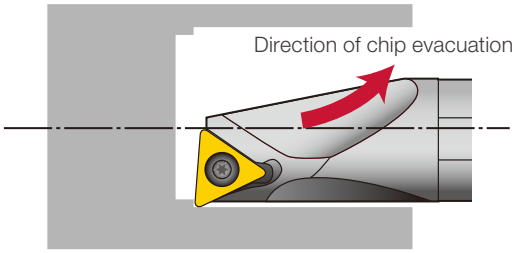
STREAMJETBAR

- **Minimum bore diameter from ø4.5 mm**
- **Steel and carbide shank available**
- **New pocket design for excellent chip evacuation**

Cutting performance

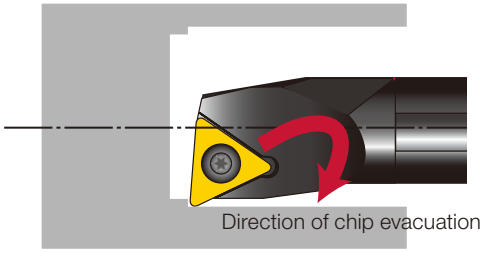
The excellent chip evacuation minimizes tool failure caused by recutting chips and poor chip control. Damage to the work surface from chips is also eliminated.

STREAMJETBAR



Combination of the well designed chip pocket and coolant flow helps chips to effectively evacuate.

Competitor



Chip packing is likely to occur.

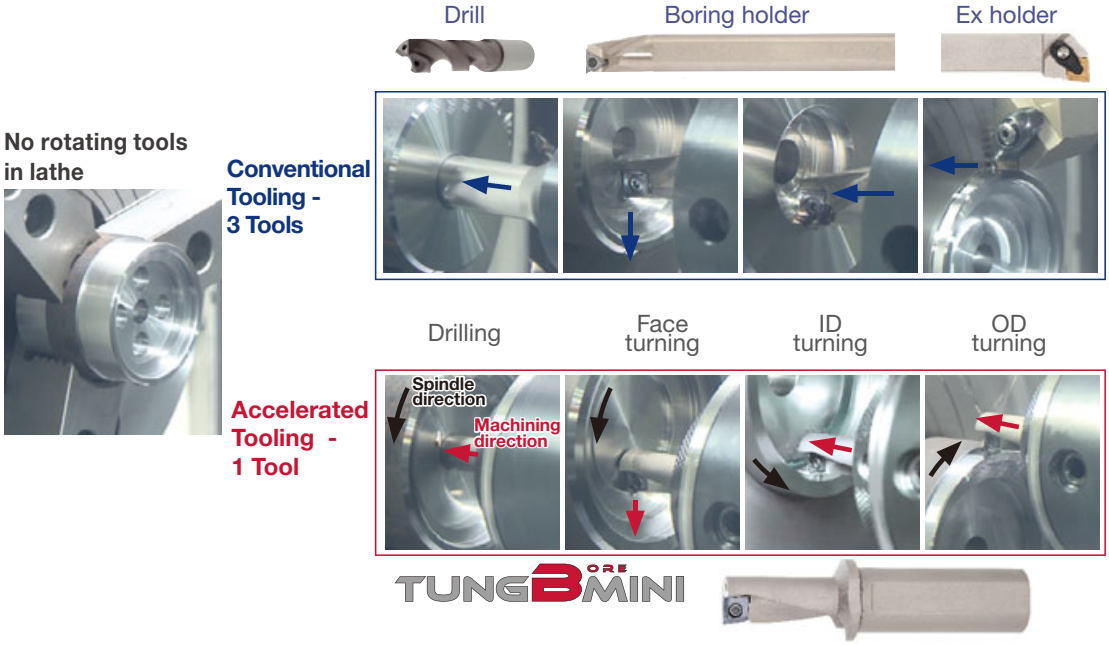
Reference pages: D014, D018, D025, D031, D034, D036, D038, D041, D043, D045, D046, D049 D052, D053, D056, D058, D059, D061, D067, D069, D074, D076, D078, D079 D081, D084, D085, D087 - D089, D093 - D095

TUNGBORE MINI

Reduced machine downtime thanks to eliminating the need for tool changes. Multifunctional Tool for Drilling and Turning.

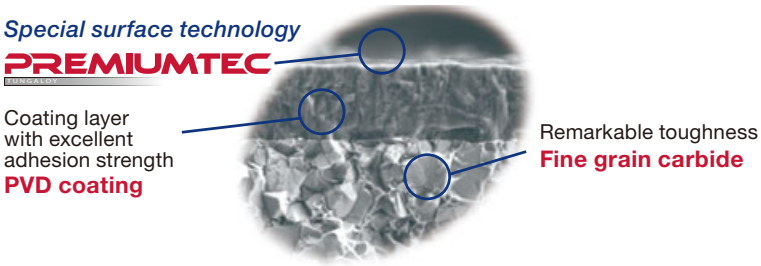
Minimum number of tools for maximum productivity

- A single TungBoreMini tool can handle multiple operations such as ID turning after drilling without exchanging the tools
- Allows drilling and hole enlargement on various materials, instead of using a drill and turning tool
- Can be used just like a standard ISO turning tool for ID, OD, and/or face turning applications



PVD grade: AH725

AH725 features a super tough substrate with a new PVD coating layer.



Reference pages: D065

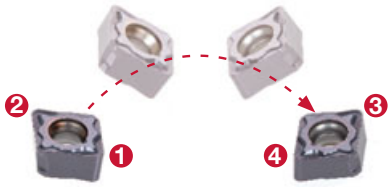
MINIFORCE TURN

Economical double-sided positive insert

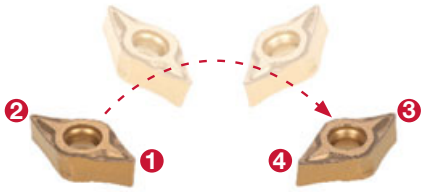
Innovative geometry and seat interface ensures stability and high performance.

Insert

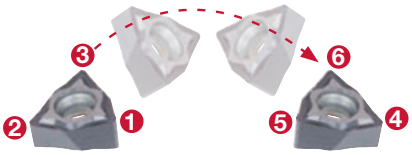
CXMU0603... 4 edges, rhombic 80°



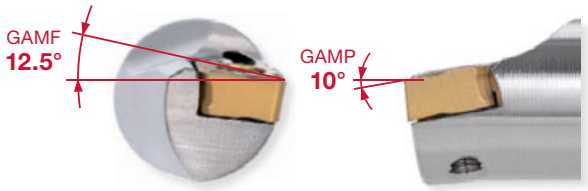
DXM/GU0703... 4 edges, rhombic 55°



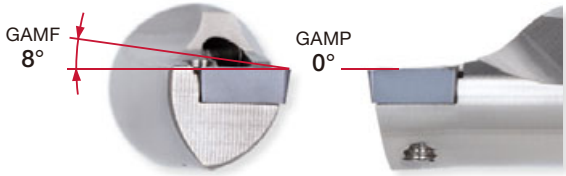
WXGU0403... 6 positive cutting edges



Low cutting force machining with high rake angle



MINIFORCE TURN
A12M-SCLXR06-D140



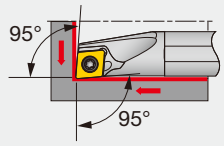
Conventional
A12M-SCLCR06-D140

Reference pages: D021 - D024, D036

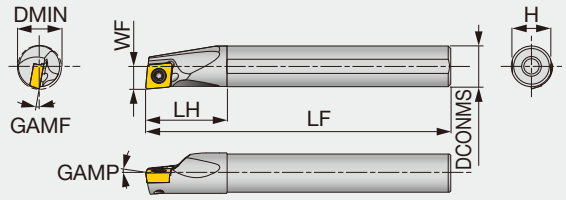
STREAMJETBAR

A/E-SCLCR/L

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



Cutting edge style **L**



Right hand (R) shown.

Designation	Material	DMIN	DCONMS	WF	LF	LH	H	GAMP	GAMF	RE**	Insert	Torque*
A04F-SCLCR/L03-D050	Steel	5	4	2.5	80	8	3.8	0°	-15°	0.2	CC**03X1...	0.6
A05F-SCLCR/L03-D060	Steel	6	5	3	80	9	4.8	0°	-13°	0.2	CC**03X1...	0.6
A06G-SCLCR/L04-D070	Steel	7	6	3.5	90	11	5.75	0°	-13°	0.2	CC**04T1...	0.6
A07G-SCLCR/L04-D080	Steel	8	7	4	90	12	6.75	0°	-11°	0.2	CC**04T1...	0.6
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
Note: Use right-hand toolholders (SCLCR**) with left-hand inserts (L); and left-hand toolholders (SCLCL**) with right-hand inserts (R).

Reference pages: A/E-SCLCR/L: Insert → B112 -, CBN → B189 -, PCD → B213

SPARE PARTS

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

INSERT SELECTION

P

Application	Precision finishing	Finishing		Finishing to medium cutting
Grade	SH725	NS9530	SH725	T9215
Breaker Shape	JP	PSS	JS	PS
Cutting conditions	B016			

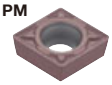
M

Application	Precision finishing	Finishing		Finishing to medium cutting
Grade	SH725	AH6225	SH725	AH6225
Chipbreaker shape	JP	PSS	JS	PS
Cutting conditions	B018			

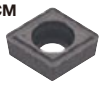
P

Application	Medium cutting
Grade	T9215
Breaker Shape	PM
Cutting conditions	B016

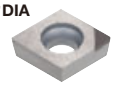
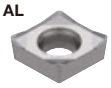
M

Application	Medium cutting
Grade	AH6225
Chipbreaker shape	PM 
Cutting conditions	B018

K

Application	Finishing to medium cutting
Grade	T515
Breaker Shape	CM 
Cutting conditions	B020

N

Application	Precision finishing	Finishing	Medium cutting
Grade	DX120	DX140	KS05F
Breaker Shape	DIA with rake	DIA 	AL 
Cutting conditions	B022		

S

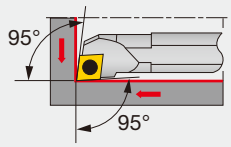
Application	Precision finishing	Finishing	Finishing to medium cutting
Grade	BX470	AH8005	AH8015
Breaker Shape	CBN	PS	PS
Cutting conditions	B024		

H

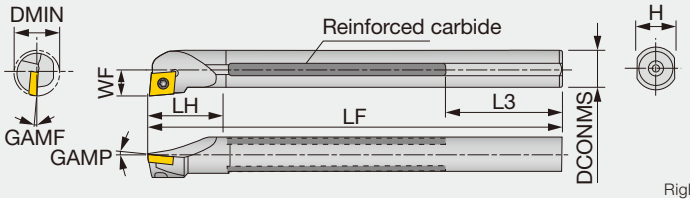
Application	Precision finishing	Finishing
Grade	BXA10	BXA20
Breaker Shape	HP	HS
Cutting conditions	B026	

T-SCLCR/L

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



Cutting edge style **L**



Right hand (R) shown.

Designation	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.
Note: 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
Grade	SH725	NS9530	SH725	T9215
Breaker Shape	JP	PSS	JS	PS
Cutting conditions	B016			

M

Application	Precision finishing	Finishing		Finishing to medium cutting
Grade	SH725	AH6225	SH725	AH6225
Chipbreaker shape	JP	PSS	JS	PS
Cutting conditions	B018			

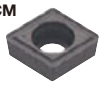
P

Application	Medium cutting
Grade	T9215
Breaker Shape	PM
Cutting conditions	B016

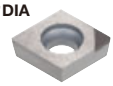
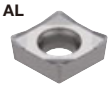
M

Application	Medium cutting
Grade	AH6225
Chipbreaker shape	PM
Cutting conditions	B018

K

Application	Finishing to medium cutting
Grade	T515
Breaker Shape	CM 
Cutting conditions	B020

N

Application	Precision finishing	Finishing	Medium cutting
Grade	DX120	DX140	KS05F
Breaker Shape	DIA with rake	DIA 	AL 
Cutting conditions	B022		

S

Application	Precision finishing	Finishing	Finishing to medium cutting
Grade	BX470	AH8005	AH8015
Breaker Shape	CBN	PS	PS
Cutting conditions	B024		

H

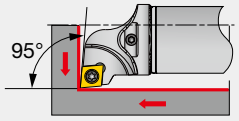
Application	Precision finishing	Finishing
Grade	BXA10	BXA20
Breaker Shape	HP	HS
Cutting conditions	B026	

Reference pages: T-SCLCR/L: Insert → B112 -, CBN → B189 -, PCD → B213

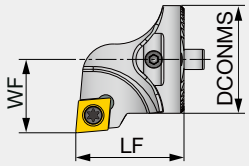
BOREMEISTER

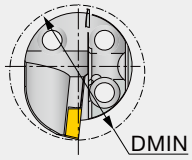
S-SCLCR/L-H

Screw-on clamp exchangeable boring head, for positive 80° rhombic inserts



Cutting edge style **L**





Right hand (R) shown.

Designation	DMIN	DCONMS	WF	LF	Shank	Insert
S16-SCLCR/L06-H	20	16	11	20	D/G16	CC**0602...
S20-SCLCR/L09-H	25	20	13	20	D/G20	CC**09T3...
S25-SCLCR/L09-H	32	25	17	20	D25	CC**09T3...
S32-SCLCR/L09-H	40	32	22	32	D32	CC**09T3...
S40-SCLCR/L12T-H	50	40	27	38	D40, D50, D60	CC**1204...

Note: 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	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

P

Application	Precision finishing	Finishing		Finishing to medium cutting
Grade	SH725	NS9530	SH725	T9215
Breaker Shape	JP	PSS	JS	PS
Cutting conditions	B016			

M

Application	Precision finishing	Finishing		Finishing to medium cutting
Grade	SH725	AH6225	SH725	AH6225
Chipbreaker shape	JP	PSS	JS	PS
Cutting conditions	B018			

P

Application	Medium cutting
Grade	T9215
Breaker Shape	PM
Cutting conditions	B016

M

Application	Medium cutting
Grade	AH6225
Chipbreaker shape	PM
Cutting conditions	B018

K

Application	Finishing to medium cutting
Grade	T515
Breaker Shape	CM
Cutting conditions	B020

N

Application	Precision finishing	Finishing	Medium cutting
Grade	DX120	DX140	KS05F
Breaker Shape	DIA (with rake)	DIA	AL
Cutting conditions	B022		

S

Application	Precision finishing	Finishing	Finishing to medium cutting
Grade	BX470	AH8005	AH8015
Breaker Shape	CBN	PS	PS
Cutting conditions	B024		

H

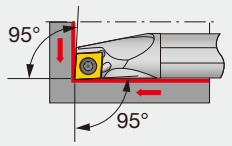
Application	Precision finishing	Finishing
Grade	BXA10	BXA20
Breaker Shape	HP	HS
Cutting conditions	B026	

Reference pages: S-SCLCR/L-H: Insert → B112 -, CBN → B189 -, PCD → B213
Shank → D090 - D092

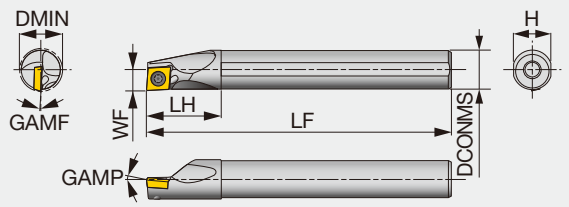
STREAMJETBAR

A/E-SCLPR/L

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



Cutting edge style **L**



Right hand (R) shown.

Designation	Material	DMIN	DCONMS	WF	LF	LH	H	GAMP	GAMF	RE**	Insert	Torque*
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
Note: Use right-hand toolholders (SCLPR**) with left-hand inserts (L); and left-hand toolholders (SCLPL**) with right-hand inserts (R).

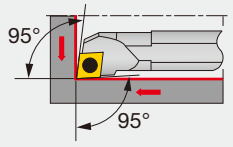
SPARE PARTS

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

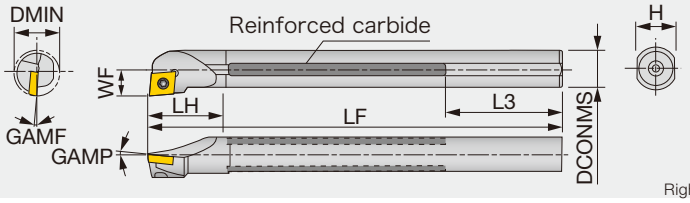
Reference pages: A/E-SCLPR/L: Insert → B118 -, CBN → B192

T-SCLPR/L

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



Cutting edge style **L**



Right hand (R) shown.

Designation	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
Note: 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
Grade	NS9530	T9215	T9215
Breaker Shape	PSS	PS	PM
Cutting conditions	B016		

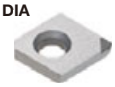
M

Application	Finishing	Finishing to medium cutting	Medium cutting
Grade	AH6225	AH6225	AH6225
Chipbreaker shape	PSS	PS	PM
Cutting conditions	B018		

K

Application	Finishing to medium cutting
Grade	T515
Breaker Shape	CM
Cutting conditions	B020

N

Application	Finishing
Grade	DX140
Breaker Shape	DIA 
Cutting conditions	B022

S

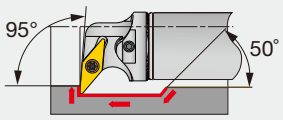
Application	Finishing	Finishing to medium cutting
Grade	AH8005	AH8015
Breaker Shape	PSS	PS
Cutting conditions	B024	

Reference pages: T-SCLPR/L: Insert → B118 -, CBN → B192

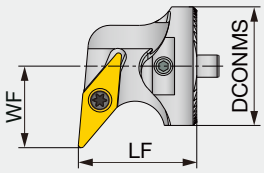
BOREMEISTER

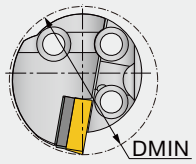
S-SVLCR/L-H

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



Cutting edge style **L**





Right hand (R) shown.

Designation	DMIN	DCONMS	WF	LF	Shank	Insert
S32-SVLCR/L16T-H	40	32	22	32	D32	VC**1604...
S40-SVLCR/L16T-H	50	40	27	32	D40, D50, D60	VC**1604...

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

SPARE PARTS

Designation	Clamping screw	Wrench	Shim	Shim screw
S32-SVLCR/L16T-H	SR16-236P	T-15/5	TVC 3-1P	SRTC-3P
S40-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	PSS	PS
Cutting conditions	B016	

M

Application	Finishing	Finishing to medium cutting
Grade	AH6225	AH6225
Chipbreaker shape	PSS	PS
Cutting conditions	B018	

K

Application	Finishing to medium cutting
Grade	T515
Breaker Shape	CM
Cutting conditions	B020

N

Application	Precision finishing	Finishing	Medium cutting
Grade	DX120	DX140	KS05F
Breaker Shape	DIA with rake	DIA	AL
Cutting conditions	B022		

S

Application	Finishing	Finishing to medium cutting
Grade	AH8005	AH8015
Breaker Shape	PS	PS
Cutting conditions	B024	

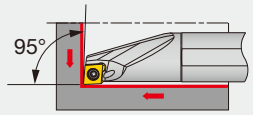
H

Application	Precision finishing	Finishing
Grade	BXA10	BXA20
Breaker Shape	CBN	CBN
Cutting conditions	B026	

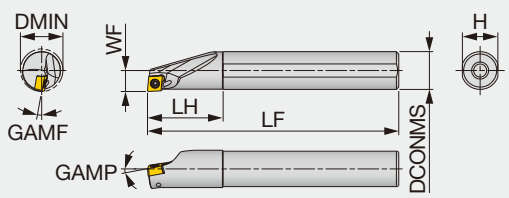
Reference pages: S-SVLCR/L-H: Insert → B152 -, CBN → B209, PCD → B220
Shank → D090 - D092

A/E-SCLXR/L

Screw-on boring bar, for CXMU inserts



Cutting edge style **L**



Right hand (R) shown.

Designation	Material	DMIN	DCONMS	WF	LF	LH	H	GAMP	GAMF	RE**	Insert	Torque*
A10K-SCLXR/L06-D120	Steel	12	10	6	125	20	9	-10°	-14.5°	0.4	CXMU0603**L/R...	0.9
A12M-SCLXR/L06-D140	Steel	14	12	7	150	24	11	-10°	-12.5°	0.4	CXMU0603**L/R...	0.9
A16Q-SCLXR/L06-D180	Steel	18	16	9	180	32	15	-10°	-9.5°	0.4	CXMU0603**L/R...	0.9
A20R-SCLXR/L06-D220	Steel	22	20	11	200	36	18	-10°	-8°	0.4	CXMU0603**L/R...	0.9
E10M-SCLXR/L06-D120	Carbide	12	10	6	150	25	9	-10°	-14.5°	0.4	CXMU0603**L/R...	0.9
E12Q-SCLXR/L06-D140	Carbide	14	12	7	180	27	11	-10°	-12.5°	0.4	CXMU0603**L/R...	0.9
E16R-SCLXR/L06-D180	Carbide	18	16	9	200	32	15	-10°	-9.5°	0.4	CXMU0603**L/R...	0.9
E20S-SCLXR/L06-D220	Carbide	22	20	11	250	36	18	-10°	-8°	0.4	CXMU0603**L/R...	0.9

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

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

❶ Right hand toolholder with left hand insert shown

❷ Left hand toolholder with right hand insert shown

INSERT SELECTION

P

Application	Finishing to medium cutting	Medium cutting
Grade	T9215	T9215
Breaker Shape	TS	TS
Cutting conditions	B096	

M

Application	Finishing to medium cutting	Medium cutting
Grade	AH8015	AH8015
Breaker Shape	TS	TS
Cutting conditions	B096	

K

Application	Finishing to medium cutting	Medium cutting
Grade	T9215	T9215
Breaker Shape	TS	TS
Cutting conditions	B096	

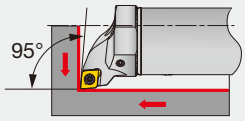
S

Application	Finishing to medium cutting	Medium cutting
Grade	AH8015	AH8015
Breaker Shape	TS	TS
Cutting conditions	B096	

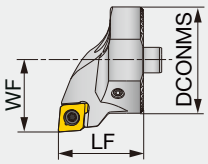
Reference pages: A/E-SCLXR/L: Insert → B120
Standard cutting conditions → D096

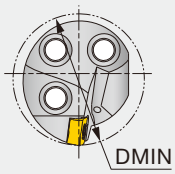
S-SCLXR/L-H

Screw-on clamp exchangeable boring head, for CXMU inserts



Cutting edge style **L**





Right hand (R) shown.

Designation	DMIN	DCONMS	WF	LF	Shank	Insert
S25-SCLXR/L06-H	32	25	17	20	D25	CXMU0603**L/R...
S32-SCLXR/L06-H	40	32	22	32	D32	CXMU0603**L/R...
S40-SCLXR/L06-H	50	40	27	32	D40, D50, D60	CXMU0603**L/R...

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

SPARE PARTS

Designation	Clamping screw	Wrench
S**-SCLXR/L06-H	SR34-514	T-7F

INSERT SELECTION

P

Application	Finishing to medium cutting	Medium cutting
Grade	T9215	T9215
Breaker Shape	TS	TS
Cutting conditions	B096	

M

Application	Finishing to medium cutting	Medium cutting
Grade	AH8015	AH8015
Breaker Shape	TS	TS
Cutting conditions	B096	

K

Application	Finishing to medium cutting	Medium cutting
Grade	T9215	T9215
Breaker Shape	TS	TS
Cutting conditions	B096	

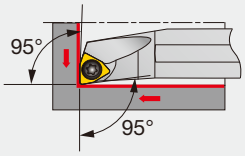
S

Application	Finishing to medium cutting	Medium cutting
Grade	AH8015	AH8015
Breaker Shape	TS	TS
Cutting conditions	B096	

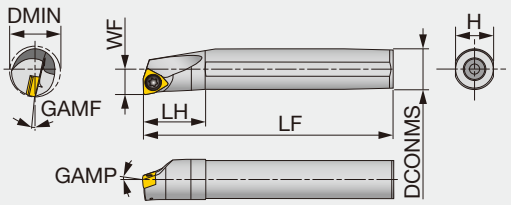
Reference pages: S-SCLXR/L-H: Insert → B120, Shank → D090 - D092
Standard cutting conditions → D096

A/E-SWLXR/L

Screw-on boring bar, for WXGU inserts



Cutting edge style **L**



Right hand (R) shown.

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

*Torque: Recommended clamping torque (N·m) **RE: Standard corner radius
Note: 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	Precision finishing	Finishing		Finishing to medium cutting
Grade	SH725	SH725	NS9530	AH8015
Breaker Shape	JS	JTS	SS	TS
Cutting conditions	B096			

M

Application	Precision finishing	Finishing		Finishing to medium cutting
Grade	SH725	SH725	AH8015	AH8015
Chipbreaker shape	JS	JTS	SS	TS
Cutting conditions	B096			

P

Application	Medium cutting
Grade	AH8015
Breaker Shape	TS
Cutting conditions	B096

M

Application	Medium cutting
Grade	AH8015
Chipbreaker shape	TS
Cutting conditions	B096

K

Application	Precision finishing	Finishing		Finishing to medium cutting
Grade	SH725	SH725	NS9530	AH8015
Breaker Shape	JS	JTS	SS	TS
Cutting conditions	B096			

N

Application	Finishing	Finishing to medium cutting	Medium cutting
Grade	KS05F	KS05F	KS05F
Breaker Shape	SS	TS	TS
Cutting conditions	B096		

K

Application	Medium cutting
Grade	AH8015
Breaker Shape	TS
Cutting conditions	B096

S

Application	Precision finishing	Finishing		Finishing to medium cutting
Grade	SH725	SH725	AH8015	AH8015
Breaker Shape	JS	JTS	SS	TS
Cutting conditions	B096			

H

Application	Finishing	Finishing to medium cutting	Medium cutting
Grade	BXA10	BXA20	BXA20
Breaker Shape	HP		
Cutting conditions	B096		

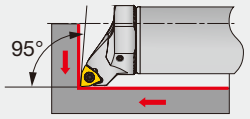
S

Application	Medium cutting
Grade	AH8015
Breaker Shape	TS
Cutting conditions	B096

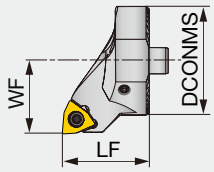
Reference pages: A/E-SWLXR/L: Insert → B157 -
Standard cutting conditions → D096

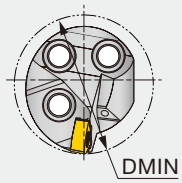
S-SWLXR/L-H

Screw-on clamp exchangeable boring head, for WXGU inserts



Cutting edge style **L**





Right hand (R) shown.

Designation	DMIN	DCONMS	WF	LF	Shank	Insert
S25-SWLXR/L04-H	32	25	17	20	D25	WXGU…
S32-SWLXR/L04-H	40	32	22	32	D32	WXGU…
S40-SWLXR/L04-H	50	40	27	32	D40, D50, D60	WXGU…

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

SPARE PARTS

Designation	Clamping screw	Wrench
S**-SWLXR/L04-H	SR34-514	T-7F

INSERT SELECTION

P

Application	Precision finishing	Finishing		Finishing to medium cutting
Grade	SH725	SH725	NS9530	AH8015
Breaker Shape	JS	JTS	SS	TS
Cutting conditions	B096			

P

Application	Medium cutting
Grade	AH8015
Breaker Shape	TS
Cutting conditions	B096

K

Application	Precision finishing	Finishing		Finishing to medium cutting
Grade	SH725	SH725	NS9530	AH8015
Breaker Shape	JS	JTS	SS	TS
Cutting conditions	B096			

K

Application	Medium cutting
Grade	AH8015
Breaker Shape	TS
Cutting conditions	B096

H

Application	Finishing	Finishing to medium cutting	Medium cutting
Grade	BXA10	BXA20	BXA20
Breaker Shape	HP	CBN	CBN
Cutting conditions	B096		

M

Application	Precision finishing	Finishing		Finishing to medium cutting
Grade	SH725	SH725	AH8015	AH8015
Chipbreaker shape	JS	JTS	SS	TS
Cutting conditions	B096			

M

Application	Medium cutting
Grade	AH8015
Chipbreaker shape	TS
Cutting conditions	B096

N

Application	Finishing	Finishing to medium cutting	Medium cutting
Grade	KS05F	KS05F	KS05F
Breaker Shape	SS	TS	TS
Cutting conditions	B096		

S

Application	Precision finishing	Finishing		Finishing to medium cutting
Grade	SH725	SH725	AH8015	AH8015
Breaker Shape	JS	JTS	SS	TS
Cutting conditions	B096			

S

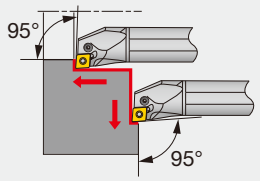
Application	Medium cutting
Grade	AH8015
Breaker Shape	TS
Cutting conditions	B096

Reference pages: S-SWLXR/L-H: Insert → B157 -, Shank → D090 - D092
Standard cutting conditions → D096

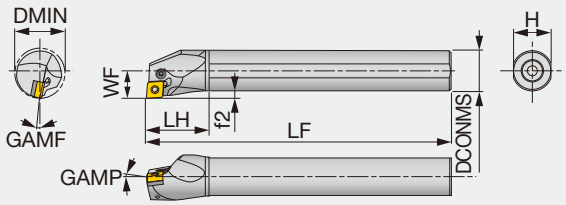
STREAMJETBAR

A-PCLNR/L

Lever-lock boring bar, for negative 80°/70° rhombic inserts



Cutting edge style **L**



Right hand (R) shown.

Designation	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**/GNMG0904...	1.7
A20Q-PCLNR/L0904-D250	Steel	25	20	13	180	36	18	3	-6°	-12°	0.8	CN**/GNMG0904...	1.7
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**/GNGA1204...	2.7
A32S-PCLNR/L12-D400	Steel	40	32	22	250	50	30	6	-6°	-11°	0.8	CN**/GNGA1204...	4.8
A40T-PCLNR/L12-D500	Steel	50	40	27	300	60	37	7	-6°	-10°	0.8	CN**/GNGA1204...	4.8
A50U-PCLNR/L12-D630	Steel	63	50	35	350	65	47	10	-6°	-8°	0.8	CN**/GNGA1204...	4.8

*Torque: Recommended clamping torque (N·m)
**RE: Standard corner radius
Note: Use right-hand toolholders (PCLNR**) with left-hand inserts (L); and left-hand toolholders (PCLNL**) with right-hand inserts (R).

SPARE PARTS

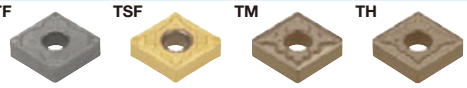
Designation	Shim	Clamping screw 1	Clamping screw 2	Wrench 1	Wrench 2	Spring pin	Lever	Oil supply attachment*	Screw for oil hole*
A16M-PCLNR/L0904-D200	-	-	LCS33	P-2F	-	-	LCL33N	-	SSHM3-4
A20Q-PCLNR/L0904-D250	-	-	LCS33	P-2F	-	-	LCL33N	EA-20	SSHM3-4
A**-PCLNR/L09-D**0	-	LCS22A	-	P-2F	-	-	LCL32N	EA-25	SSHM5-6
A25R-PCLNR/L12-D320	-	LCS43	-	-	P-2.5	-	LCL43N	EA-25	SSHM5-6
A32S-PCLNR12-D400	LSC42BR	-	LCS4	-	P-3	LSP4	LCL4	EA-32	SSHM5-6
A32S-PCLNL12-D400	LSC42BL	-	LCS4	-	P-3	LSP4	LCL4	-	SSHM6-6
A40T-PCLNR12-D500	LSC42BR	-	LCS4	-	P-3	LSP4	LCL4	-	SSHM6-6
A40T-PCLNL12-D500	LSC42BL	-	LCS4	-	P-3	LSP4	LCL4	-	SSHM6-6
A50U-PCLNR12-D630	LSC42BR	-	LCS4	-	P-3	LSP4	LCL4	-	SSHM6-6
A50U-PCLNL12-D630	LSC42BL	-	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	B004			

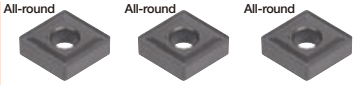


M

Application	Finishing	Medium cutting	Medium to heavy cutting
Grade	T6215	AH6225	AH6225
Chipbreaker shape	SF	SM	SH
Cutting conditions	B006		

K

Application	Finishing	Medium cutting	Medium to heavy cutting
Grade	T515	T515	T515
Breaker Shape	All-round	All-round	All-round
Cutting conditions	B008		



N

Application	Precision finishing	Finishing	Medium cutting
Grade	DX120	DX140	TH10
Breaker Shape	DIA with rake	DIA	P
Cutting conditions	B010		

S

Application	Precision finishing	Finishing	Medium cutting
Grade	BX815	AH8005	AH8005
Breaker Shape	CBN	HRF	HRM
Cutting conditions	B012		

H

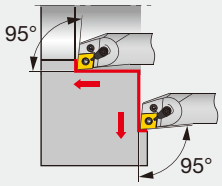
Application	Precision finishing	Finishing
Grade	BXA10	BXA20
Breaker Shape	HP	HS
Cutting conditions	B014	

Reference pages: A-PCLNR/L: Insert → B054 -, B075, CBN → B168 -, PCD → B211

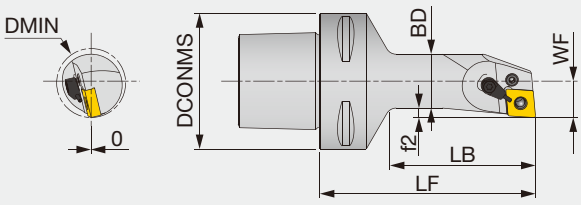
TUNGCAP

C-PCLNL-CHP

Lever-lock boring bar with TungCap connection, with 95° approach angle, for negative 80°/70° rhombic inserts, with high pressure coolant capability



Cutting edge style **L**



Left hand (L) shown.

Designation	DMIN	DCONMS	BD	LF	LB	WF	f2	RE**	Insert
C6PCLNL17100-12-CHP	32	63	25	100	67.5	17	4.5	0.8	CN**/GNGA1204...

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	B004			

M

Application	Finishing	Medium cutting	Medium to heavy cutting
Grade	T6215	AH6225	AH6225
Chipbreaker shape	SF	SM	SH
Cutting conditions	B006		

K

Application	Finishing	Medium cutting	Medium to heavy cutting
Grade	T515	T515	T515
Breaker Shape	All-round	All-round	All-round
Cutting conditions	B008		

N

Application	Precision finishing	Finishing	Medium cutting
Grade	DX120	DX140	TH10
Breaker Shape	DIA with rake	DIA	P
Cutting conditions	B010		

S

Application	Precision finishing	Finishing	Medium cutting
Grade	BX815	AH8005	AH8005
Breaker Shape	CBN	HRF	HRM
Cutting conditions	B012		

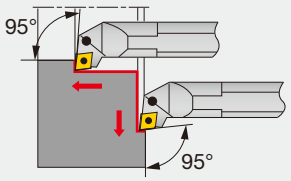
H

Application	Precision finishing	Finishing
Grade	BXA10	BXA20
Breaker Shape	HP	HS
Cutting conditions	B014	

Reference pages: C-PCLNL-CHP: Insert → B054 -, CBN → B168 -, PCD → B211

S-PCLNR/L

Lever-lock boring bar, for negative 80°/70° rhombic inserts



Cutting edge style **L**

Right hand (R) shown.

Designation	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**/GNGA1204...	4.8
S40T-PCLNR/L12	Steel	50	40	27	300	55	37	37.5	-6°	-10°	0.8	CN**/GNGA1204...	4.8
S50U-PCLNR/L12	Steel	63	50	35	350	65	47	47.5	-6°	-8°	0.8	CN**/GNGA1204...	4.8

*Torque: Recommended clamping torque (N·m)
**RE: Standard corner radius
Note: 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
S**-PCLNR/L09	-	LCS22A	-	P-2F	-	-	LCL32N
S32S-PCLNR/L12	LSC42BR/L	-	LCS4	-	P-3	LSP4	LCL4
S40T-PCLNR/L12	LSC42BR/L	-	LCS4	-	P-3	LSP4	LCL4
S50U-PCLNR/L12	LSC42BR/L	-	LCS4	-	P-3	LSP4	LCL4

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	B004			

M

Application	Finishing	Medium cutting	Medium to heavy cutting
Grade	T6215	AH6225	AH6225
Chipbreaker shape	SF	SM	SH
Cutting conditions	B006		

K

Application	Finishing	Medium cutting	Medium to heavy cutting
Grade	T515	T515	T515
Breaker Shape	All-round	All-round	All-round
Cutting conditions	B008		

N

Application	Precision finishing	Finishing	Medium cutting
Grade	DX120	DX140	TH10
Breaker Shape	DIA with rake	DIA	P
Cutting conditions	B010		

S

Application	Precision finishing	Finishing	Medium cutting
Grade	BX815	AH8005	AH8005
Breaker Shape	CBN	HRF	HRM
Cutting conditions	B012		

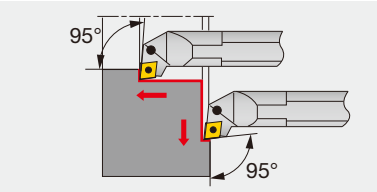
H

Application	Precision finishing	Finishing
Grade	BXA10	BXA20
Breaker Shape	HP	HS
Cutting conditions	B014	

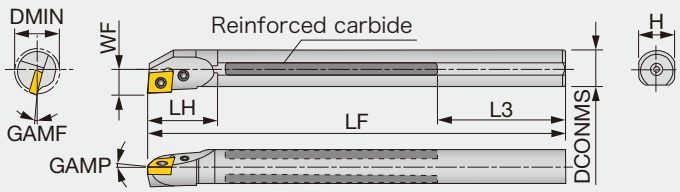
Reference pages: S-PCLNR/L: Insert → B054 -, CBN → B168 -, PCD → B211

T-PCLNR

Lever-lock boring bar, for negative 80°/70° rhombic inserts (Tsuppari-Ichiban)



Cutting edge style **L**



Right hand (R) shown.

Designation	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**/GNGA1204...	4.8
T40V-PCLNR12C	Reinforced	50	Rc1/2	40	27	400	55	88	37	-6°	-10°	0.8	CN**/GNGA1204...	4.8
T50W-PCLNR12C	Reinforced	63	Rc1/2	50	35	450	65	63	47	-6°	-8°	0.8	CN**/GNGA1204...	4.8

*Torque: Recommended clamping torque (N·m)
**RE: Standard corner radius
Note: Use right-hand toolholders (R) with left-hand inserts (L); and left-hand toolholders (L) with right-hand inserts (R).

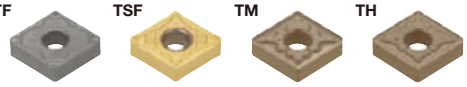
SPARE PARTS

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

INSERT SELECTION

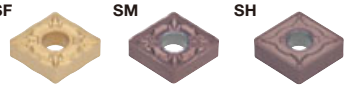
P

Application	Precision finishing	Finishing	Medium cutting	Medium to heavy cutting
Grade	NS9530	GT9530	T9215	T9215
Breaker Shape	TF	TSF	TM	TH
Cutting conditions	B004			



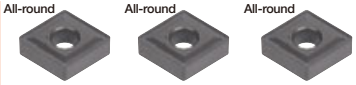
M

Application	Finishing	Medium cutting	Medium to heavy cutting
Grade	T6215	AH6225	AH6225
Chipbreaker shape	SF	SM	SH
Cutting conditions	B006		



K

Application	Finishing	Medium cutting	Medium to heavy cutting
Grade	T515	T515	T515
Breaker Shape	All-round	All-round	All-round
Cutting conditions	B008		



N

Application	Precision finishing	Finishing	Medium cutting
Grade	DX120	DX140	TH10
Breaker Shape	DIA with rake	DIA	P
Cutting conditions	B010		

S

Application	Precision finishing	Finishing	Medium cutting
Grade	BX815	AH8005	AH8005
Breaker Shape	CBN	HRF	HRM
Cutting conditions	B012		

H

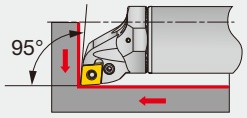
Application	Precision finishing	Finishing
Grade	BXA10	BXA20
Breaker Shape	HP	HS
Cutting conditions	B014	

Reference pages: T-PCLNR: Insert → B054 -, CBN → B168 -, PCD → B211

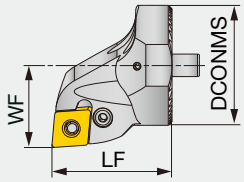
BOREMEISTER

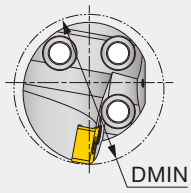
S-PCLNR/L-H

Lever-lock clamp exchangeable boring head, for negative 80°/70° rhombic inserts



Cutting edge style **L**





Right hand (R) shown.

Designation	DMIN	DCONMS	WF	LF	Shank	Insert
S32-PCLNR/L09-H	40	32	22	32	D32	CN**/GNMG0904...
S40-PCLNR/L09-H	50	40	27	32	D40, D50, D60	CN**/GNMG0904...

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

SPARE PARTS

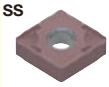
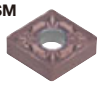
Designation	Lever	Clamping screw	Shim	Spring pin	Wrench
S32-PCLNR/L09-H	LCL33N	LCS33	-	-	P-2F
S40-PCLNR/L09-H	LCL33	LCS3	LSC317	LSP3	P-2.5

INSERT SELECTION

P

Application	Finishing	Medium cutting
Grade	T9215	T9215
Chipbreaker shape	TSF	TM
Cutting conditions	B004	

M

Application	Finishing	Medium cutting
Grade	AH6225	AH6225
Chipbreaker shape	SS 	SM 
Cutting conditions	B006	

K

Application	Medium cutting
Grade	T515
Chipbreaker shape	TM
Cutting conditions	B008

S

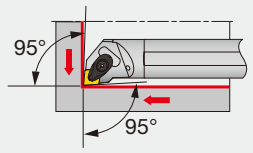
Application	Medium cutting
Grade	AH8015
Chipbreaker shape	TM
Cutting conditions	B012

Reference pages: S-PCLNR/L-H: Insert → B054 -, B075, CBN → B168 -, PCD → B211
Shank → D090 - D092

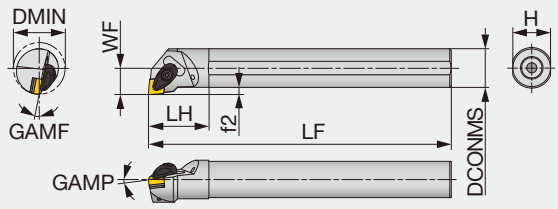
TURNINGA

A-ACLNR/L

Double-clamp boring bar, for negative 80°/70° rhombic inserts



Cutting edge style **L**



Right hand (R) shown.

Designation	Material	DMIN	DCONMS	WF	LF	LH	H	f2	GAMP	GAMF	RE**	Insert	Torque*
A25R-ACLNR/L0904-D320	Steel	32	25	17	200	45	23	4.5	-6°	-13°	0.8	CN**/GNMG0904...	3
A32S-ACLNR/L0904-D400	Steel	40	32	22	250	50	30	6	-6°	-10°	0.8	CN**/GNMG0904...	3
A25R-ACLNR/L12-D320	Steel	32	25	17	200	45	23	4.5	-6°	-13°	0.8	CN**/GNGA1204...	3
A32S-ACLNR/L12-D400	Steel	40	32	22	250	50	30	6	-6°	-10°	0.8	CN**/GNGA1204...	3
A40T-ACLNR/L12-D500	Steel	50	40	27	300	55	37	7	-6°	-8°	0.8	CN**/GNGA1204...	3
A50U-ACLNR12-D630	Steel	63	50	35	350	65	47	10	-6°	-7°	0.8	CN**/GNGA1204...	3

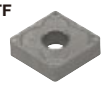
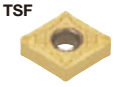
*Torque: Recommended clamping torque (N·m)
**RE: Standard corner radius

SPARE PARTS

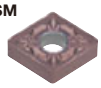
Designation	Clamp	Clamp screw	Spring	Spring pin	Shim	Shim screw	Wrench
A**-ACLNR/L0904-D...	ACP3S-E	ACS-5W	BP-7	SP-2.5	ASC322	CSTB-3.5	T-15F
A**-ACLNR/L12-D...	ACP4S	ACS-5W	BP-7	SP-2.5	ASC422	CSTB-3.5	T-15F

INSERT SELECTION

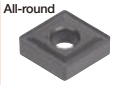
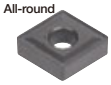
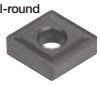
P

Application	Precision finishing	Finishing	Medium cutting	Medium to heavy cutting
Grade	NS9530	GT9530	T9215	T9215
Breaker Shape	TF 	TSF 	TM	TH
Cutting conditions	B004			

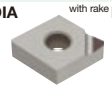
M

Application	Finishing	Medium cutting	Medium to heavy cutting
Grade	T6215	AH6225	AH6225
Chipbreaker shape	SF	SM 	SH
Cutting conditions	B006		

K

Application	Finishing	Medium cutting	Medium to heavy cutting
Grade	T515	T515	T515
Breaker Shape	All-round 	All-round 	All-round 
Cutting conditions	B008		

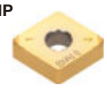
N

Application	Precision finishing	Finishing	Medium cutting
Grade	DX120	DX140	TH10
Breaker Shape	DIA with rake 	DIA	P
Cutting conditions	B010		

S

Application	Precision finishing	Finishing	Medium cutting
Grade	BX815	AH8005	AH8005
Breaker Shape	CBN	HRF	HRM
Cutting conditions	B012		

H

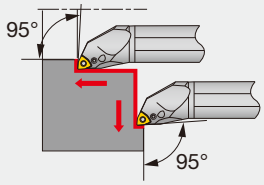
Application	Precision finishing	Finishing
Grade	BXA10	BXA20
Breaker Shape	HP 	HS
Cutting conditions	B014	

Reference pages: A-ACLNR/L: Insert → B054 -, B075, CBN → B168 -, PCD → B211

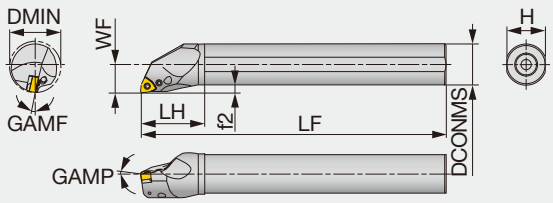
STREAMJETBAR

A-PWLNR/L

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



Cutting edge style **L**



Right hand (R) shown.

Designation	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
A16M-PWLNR/L06-D200	Steel	20	16	11	150	32	15	3	-8°	-17°	0.8	WN**0604...	1.7
A20Q-PWLNR/L06-D250	Steel	25	20	13	180	36	18	3	-6°	-14°	0.8	WN**0604...	1.7
A25R-PWLNR/L06-D320	Steel	32	25	17	200	45	23	4.5	-6°	-12°	0.8	WN**0604...	2.7
A32S-PWLNR/L06-D400	Steel	40	32	22	250	50	30	6	-6°	-11°	0.8	WN**0604...	2.7
A25R-PWLNR/L08-D320	Steel	32	25	17	200	45	23	4.5	-6°	-13°	0.8	WN**0804...	2.7
A32S-PWLNR/L08-D400	Steel	40	32	22	250	50	30	6	-6°	-11°	0.8	WN**0804...	4.8
A40T-PWLNR/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

Note: Use right-hand toolholders (PWLNR**) with left-hand inserts (L); and left-hand toolholders (PWLNL**) 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-PWLNR/L0604-D200	-	-	LCS33	P-2F	-	-	LCL33N	-	SSHM3-4
A20Q-PWLNR/L0604-D250	-	-	LCS33	P-2F	-	-	LCL33N	EA-20	SSHM3-4
A16M-PWLNR/L06-D200	-	LCS33	-	P-2F	-	-	LCL33N	-	SSHM3-4
A20Q-PWLNR/L06-D250	-	LCS33	-	P-2F	-	-	LCL33N	EA-20	SSHM3-4
A25R-PWLNR/L06-D320	LSW312BR/L	-	LCS3B	-	P-2.5	LSP3	LCL3	EA-25	SSHM4-5
A32S-PWLNR/L06-D400	LSW312BR/L	-	LCS3	-	P-2.5	LSP3	LCL3	EA-32	SSHM4-5
A25R-PWLNR/L08-D320	-	LCS43	-	-	P-2.5	-	LCL43N	EA-25	SSHM4-5
A32S-PWLNR/L08-D400	LSW42BR/L	-	LCS4	-	P-3	LSP4	LCL4	EA-32	SSHM4-5
A40T-PWLNR/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	B004			

M

Application	Finishing	Medium cutting	Medium to heavy cutting
Grade	T6215	AH6225	AH6225
Breaker Shape	SF	SM	SH
Cutting conditions	B006		

K

Application	Finishing	Medium cutting	Medium to heavy cutting
Grade	T515	T515	T515
Breaker Shape	All-round	All-round	All-round
Cutting conditions	B008		

S

Application	Precision finishing	Finishing	Medium cutting
Grade	BX480	AH8005	AH8005
Breaker Shape	CBN	HRF	HRM
Cutting conditions	B012		

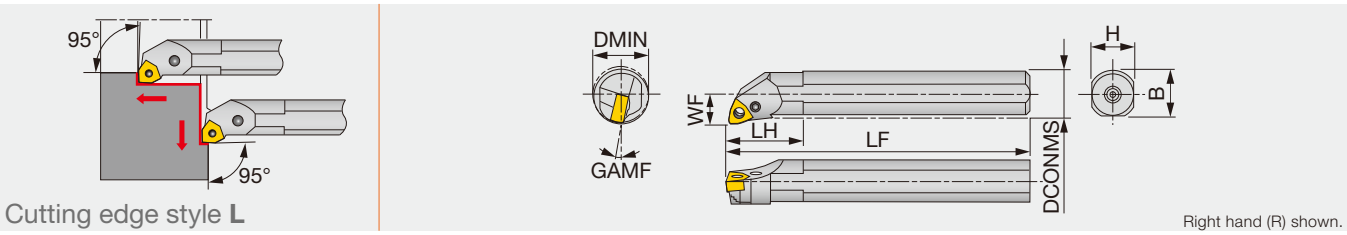
H

Application	Precision finishing	Finishing
Grade	BXM10	BXM20
Breaker Shape	CBN	CBN
Cutting conditions	B014	

Reference pages: A-PWLNR/L: Insert → B102 -, CBN → B187

S-PWLNR/L

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



Cutting edge style **L**

Right hand (R) shown.

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

**RE : Standard corner radius

Note: 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**-PWLNR/L06	-	LCS33	-	P-2F	-	-	LCL33N
S25R-PWLNR06	LSW312BR	-	LCS3B	-	P-2.5	LSP3	LCL3
S25R-PWLNL06	LSW312BL	-	LCS3B	-	P-2.5	LSP3	LCL3

INSERT SELECTION

P

Application	Finishing	Medium cutting
Grade	T9215	T9215
Breaker Shape	TSF	TM
Cutting conditions	B004	

M

Application	Finishing	Medium cutting
Grade	AH6225	AH6225
Chipbreaker shape	SS	SM
Cutting conditions	B006	

K

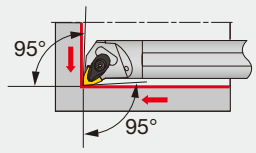
Application	Medium cutting
Grade	T515
Breaker Shape	TM
Cutting conditions	B008

Reference pages: A-PWLNR/L: Insert → B102 -, CBN → B187

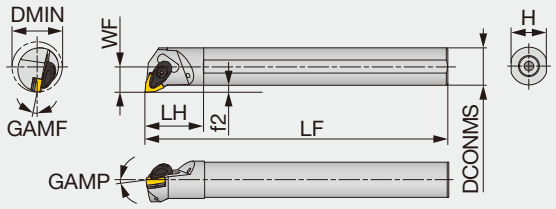
TURNINGA

A-AWLNR/L

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



Cutting edge style **L**



Right hand (R) shown.

Designation	Material	DMIN	DCONMS	WF	LF	LH	H	f2	GAMP	GAMF	RE**	Insert	Torque*
A25R-AWLNR/L0604-D320	Steel	32	25	17	200	45	23	4.5	-6°	-13°	0.8	WN**0604...	3
A32S-AWLNR/L0604-D400	Steel	40	32	22	250	50	30	6	-6°	-10°	0.8	WN**0604...	3
A25R-AWLNR/L06-D320	Steel	32	25	17	200	45	23	4.5	-6°	-13°	0.8	WN**0604...	3
A32S-AWLNR/L06-D400	Steel	40	32	22	250	50	30	6	-6°	-10°	0.8	WN**0604...	3
A25R-AWLNR/L08-D320	Steel	32	25	17	200	45	23	4.5	-6°	-13°	0.8	WN**0804...	3
A32S-AWLNR/L08-D400	Steel	40	32	22	250	50	30	6	-6°	-10°	0.8	WN**0804...	3
A40T-AWLNR/L08-D500	Steel	50	40	27	300	55	37	7	-6°	-8°	0.8	WN**0804...	3
A50U-AWLNR/L08-D630	Steel	63	50	35	350	65	47	10	-6°	-7°	0.8	WN**0804...	3

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

SPARE PARTS

Designation	Clamp	Clamp screw	Spring	Spring pin	Shim	Shim screw	Wrench
A**-AWLNR/L0604-D...	ACP3S-E	ACS-5W	BP-7	SP-2.5	ASW322	CSTB-3.5	T-15F
A**-AWLNR/L06-D...	ACP3S	ACS-5W	BP-7	SP-2.5	ASW322	CSTB-3.5	T-15F
A**-AWLNR/L08-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	B004			

M

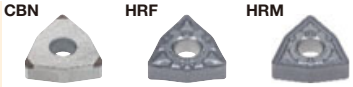
Application	Finishing	Medium cutting	Medium to heavy cutting
Grade	T6215	AH6225	AH6225
Breaker Shape	SF	SM	SH
Cutting conditions	B006		

K

Application	Finishing	Medium cutting	Medium to heavy cutting
Grade	T515	T515	T515
Breaker Shape	All-round	All-round	All-round
Cutting conditions	B008		

S

Application	Precision finishing	Finishing	Medium cutting
Grade	BX480	AH8005	AH8005
Breaker Shape	CBN	HRF	HRM
Cutting conditions	B012		



H

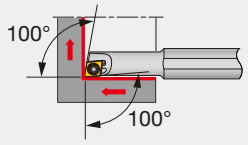
Application	Precision finishing	Finishing
Grade	BXM10	BXM20
Breaker Shape	CBN	CBN
Cutting conditions	B014	

Reference pages: A-AWLNR/L: Insert → B102 -, CBN → B187

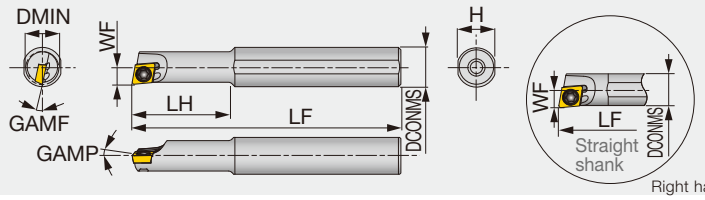
STREAMJETBAR

A/E-SEXPR/L

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



Cutting edge style **X**



Right hand (R) shown.

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

*Torque: Recommended clamping torque (N·m)
**RE : Standard corner radius
Note: 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	Finishing
Grade	SH725
Breaker Shape	JS
Cutting conditions	B016

M

Application	Finishing
Grade	SH725
Breaker Shape	JS
Cutting conditions	B018

K

Application	Finishing
Grade	SH725
Breaker Shape	JS
Cutting conditions	B020

S

Application	Finishing
Grade	SH725
Breaker Shape	JS
Cutting conditions	B024

N

Application	Precision finishing	Finishing
Grade	DX140	SH725
Breaker Shape	DIA	JS
Cutting conditions	B022	

H

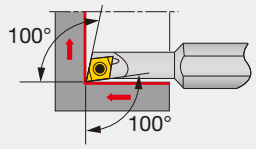
Application	Precision finishing
Grade	BX310
Breaker Shape	CBN
Cutting conditions	B026

Reference pages: A/E-SEXPR/L: Insert → B128 -, CBN → B195, PCD → B214

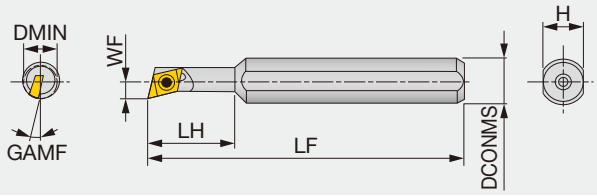
J-SERIES

JS-SEXPR/L

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



Cutting edge style **X**



Right hand (R) shown.

Designation	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
Note: 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
Grade	SH725
Breaker Shape	JS
Cutting conditions	B016

M

Application	Finishing
Grade	SH725
Breaker Shape	JS
Cutting conditions	B018

K

Application	Finishing
Grade	SH725
Breaker Shape	JS
Cutting conditions	B020

S

Application	Finishing
Grade	SH725
Breaker Shape	JS
Cutting conditions	B024

N

Application	Precision finishing	Finishing
Grade	DX140	SH725
Breaker Shape	DIA	JS
Cutting conditions	B022	

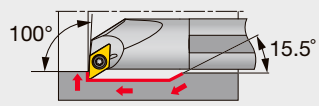
H

Application	Precision finishing
Grade	BX310
Breaker Shape	CBN
Cutting conditions	B026

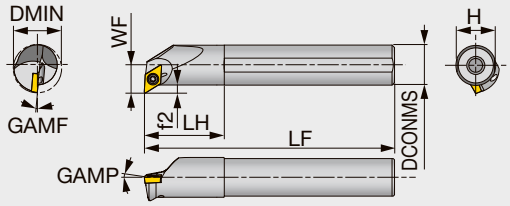
Reference pages: JS-SEXPR/L: Insert → B128 -, CBN → B195, PCD → B214

A/E-SDXXR/L

Screw-on boring bar, for DXG/MU inserts



Cutting edge style **X**



Right hand (R) shown.

Designation	Material	DMIN	DCONMS	WF	LF	LH	H	f2	GAMP	GAMF	RE**	Insert	Torque*
A10K-SDXXR/L07-D130	Steel	13	10	7.6	125	20	9	2.6	-14°	-16°	0.4	DXG/MU0703**L/R...	0.9
A12M-SDXXR/L07-D160	Steel	16	12	8.6	150	24	11	2.6	-14°	-14°	0.4	DXG/MU0703**L/R...	0.9
A16Q-SDXXR/L07-D200	Steel	20	16	10.6	180	32	15	2.6	-13°	-13°	0.4	DXG/MU0703**L/R...	0.9
A20R-SDXXR/L07-D240	Steel	24	20	12.6	200	36	18	2.6	-13°	-12°	0.4	DXG/MU0703**L/R...	0.9
E10M-SDXXR/L07-D130	Carbide	13	10	7.6	150	25	9	2.6	-14°	-16°	0.4	DXG/MU0703**L/R...	0.9
E12Q-SDXXR/L07-D160	Carbide	16	12	8.6	180	27	11	2.6	-14°	-14°	0.4	DXG/MU0703**L/R...	0.9
E16R-SDXXR/L07-D200	Carbide	20	16	10.6	200	32	15	2.6	-13°	-13°	0.4	DXG/MU0703**L/R...	0.9
E20S-SDXXR/L07-D240	Carbide	24	20	12.6	250	36	18	2.6	-13°	-12°	0.4	DXG/MU0703**L/R...	0.9

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

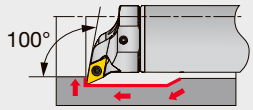
Note: Use right-hand toolholders (R) with left-hand inserts (L); and left-hand toolholders (L) with right-hand inserts (R)

SPARE PARTS

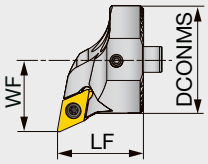
Designation	Clamping screw	Wrench
A/E**-SDXXR/L...	SR34-514	T-7F

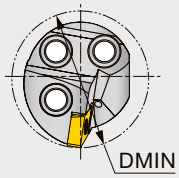
S-SDXXR/L-H

Screw-on clamp exchangeable boring head, for DXG/MU inserts



Cutting edge style **X**





Right hand (R) shown.

Designation	DMIN	DCONMS	WF	LF	Shank	Insert
S25-SDXXR/L07-H	32	25	17	20	D25	DXG/MU0703**L/R...
S32-SDXXR/L07-H	40	32	22	32	D32	DXG/MU0703**L/R...
S40-SDXXR/L07-H	50	40	27	32	D40, D50, D60	DXG/MU0703**L/R...

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

SPARE PARTS

Designation	Clamping screw	Wrench
S**-SDXXR/L07-H	SR34-514	T-7F

Reference pages: A/E-SDXXR/L, S-SDXXR/L-H: Insert → B126 -, Shank → D090 - D092
Standard cutting conditions → D096

INSERT SELECTION

P

Application	Precision finishing	Finishing		Finishing to medium cutting
Grade	SH725	SH725	NS9530	T9215
Breaker Shape	JS	JTS	SS	TS
Cutting conditions	B096			

P

Application	Medium cutting
Grade	T9215
Breaker Shape	TS
Cutting conditions	B096

K

Application	Precision finishing	Finishing		Finishing to medium cutting
Grade	SH725	SH725	NS9530	T9215
Breaker Shape	JS	JTS	SS	TS
Cutting conditions	B096			

K

Application	Medium cutting
Grade	T9215
Breaker Shape	TS
Cutting conditions	B096

S

Application	Precision finishing	Finishing		Finishing to medium cutting
Grade	SH725	SH725	AH8015	AH8015
Breaker Shape	JS	JTS	SS	TS
Cutting conditions	B096			

S

Application	Medium cutting
Grade	AH8015
Breaker Shape	TS
Cutting conditions	B096

M

Application	Precision finishing	Finishing		Finishing to medium cutting
Grade	SH725	SH725	AH8015	AH8015
Chipbreaker shape	JS	JTS	SS	TS
Cutting conditions	B096			

M

Application	Medium cutting
Grade	AH8015
Chipbreaker shape	TS
Cutting conditions	B096

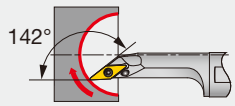
N

Application	Finishing	Finishing to medium cutting	Medium cutting
Grade	KS05F	KS05F	KS05F
Breaker Shape	SS	TS	TS
Cutting conditions	B096		

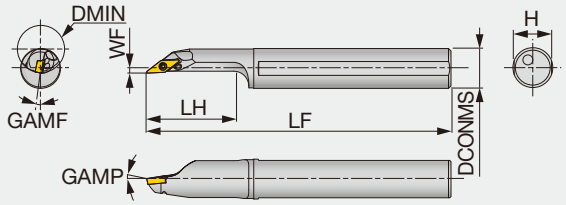
STREAMJETBAR

A-SVJBR/L

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



Cutting edge style **J**



Right hand (R) shown.

Designation	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 (N·m)
**RE : Standard corner radius
Note: 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	Precision finishing	Finishing		Finishing to medium cutting
Grade	SH725	SH725	NS9530	T9215
Breaker Shape	JP	JS	PSS	PS
Cutting conditions	B014			

M

Application	Precision finishing	Finishing		Finishing to medium cutting
Grade	SH725	SH725	AH6225	AH6225
Chipbreaker shape	JP	JS	PSS	PS
Cutting conditions	B016			

P

Application	Medium cutting
Grade	T9215
Breaker Shape	PS
Cutting conditions	B014

M

Application	Medium cutting
Grade	AH6225
Chipbreaker shape	PS
Cutting conditions	B016

K

Application	Finishing to medium cutting
Grade	T515
Breaker Shape	CM
Cutting conditions	B020

S

Application	Finishing	Finishing to medium cutting
Grade	AH8005	AH8015
Breaker Shape	PS	PS
Cutting conditions	B024	

H

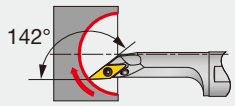
Application	Precision finishing	Finishing
Grade	BXA10	BXA20
Breaker Shape	HP	HS
Cutting conditions	B026	

Reference pages: A-SVJBR/L: Insert → B150 -, CBN → B207 -

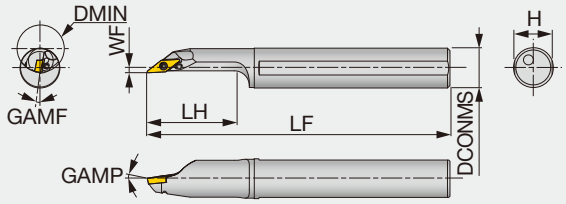
STREAMJETBAR

A-SVJCR/L

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



Cutting edge style **J**



Right hand (R) shown.

Designation	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 (N·m)
**RE : Standard corner radius
Note: 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	Finishing to medium cutting
Grade	NS9530	T9215
Breaker Shape	PSS	PS
Cutting conditions	B014	

M

Application	Finishing	Finishing to medium cutting
Grade	AH6225	AH6225
Chipbreaker shape	PSS	PS
Cutting conditions	B016	

K

Application	Finishing to medium cutting
Grade	T515
Breaker Shape	CM
Cutting conditions	B020

N

Application	Precision finishing	Finishing	Medium cutting
Grade	DX120	DX140	KS05F
Breaker Shape	DIA with rake	DIA	AL
Cutting conditions	B022		

S

Application	Finishing	Finishing to medium cutting
Grade	AH8005	AH8015
Breaker Shape	PS	PS
Cutting conditions	B024	

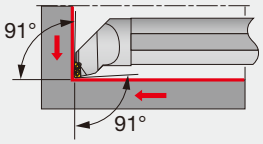
H

Application	Precision finishing	Finishing
Grade	BXA10	BXA20
Breaker Shape	CBN	CBN
Cutting conditions	B026	

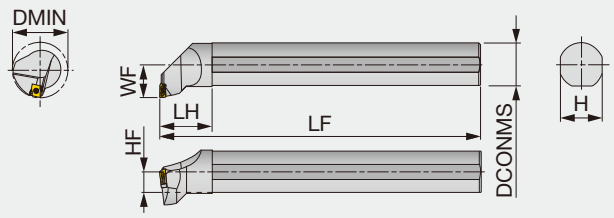
Reference pages: A-SVJCR/L: Insert → B152 -

S-TLANR/L

Screw-on boring bar for roughing, for negative tangential inserts



Cutting edge style **A**



Right hand (R) shown.

Designation	Material	DMIN	DCONMS	WF	LF	LH	H	HF	Insert
S25T-TLANR/L12-D530	Steel	53	25	17	300	40	23	11.5	LNMX1204**L/R...
S32U-TLANR/L12-D530	Steel	53	32	22	350	45	30	15	LNMX1204**L/R...
S40V-TLANR/L12-D530	Steel	53	40	27	400	53	37	18.5	LNMX1204**L/R...
S50U-TLANR/L16-D850	Steel	85	50	37	350	63	47	23.5	LNMX1606**L/R...

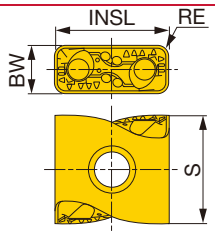
Note: Use right-hand toolholders (TLANR**) with left-hand inserts (L); and left-hand toolholders (TLANL**) with right-hand inserts (R).

SPARE PARTS

Designation	Clamping screw	Shim screw	Shim	Spring pin	Wrench 1	Wrench 2
S**-TLANR/L12-D530	CSTB-3.5L115-S	CSTF-2L055-S	TSL12L/RI	-	KEYV-T10	T-6F-S
S50U-TLANR16-D850	CSTB-4L115-S	-	TSL16LI	PSP-16	KEYV-T15	-
S50U-TLANL16-D850	CSTB-4L115-S	-	TSL16RI	PSP-16	KEYV-T15	-

INSERT

LNMX12/16/24



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

★ : First choice
☆ : Second choice

Designation	HAND	RE	Coated														BW	INSL	S
			T9115	T9125	AH725														
LNMX120408R-TDR	R	0.8	●	●													4.8	12	11.6
LNMX120408L-TDR	L	0.8	●	●													4.8	12	11.6
LNMX120412R-TDR	R	1.2	●	●													4.8	12	11.6
LNMX120412L-TDR	L	1.2	●	●													4.8	12	11.6
LNMX160608R-TDR	R	0.8	●	●													6.4	16.2	13.5
LNMX160608L-TDR	L	0.8	●	●													6.4	16.2	13.5
LNMX160612R-TDR	R	1.2	●	●													6.4	16.2	13.5
LNMX160612L-TDR	L	1.2	●	●													6.4	16.2	13.5
LNMX160616R-TDR	R	1.6	●	●													6.4	16.2	13.5
LNMX160616L-TDR	L	1.6	●	●													6.4	16.2	13.5
LNMX241016R-TDR	R	1.6	●	●													9.4	24	20.5
LNMX241016L-TDR	L	1.6	●	●													9.4	24	20.5
LNMX241024R-TDR	R	2.4	●	●													9.4	24	20.5
LNMX241024L-TDR	L	2.4	●	●													9.4	24	20.5
LNMX160608R-MDR	R	0.8	●		●												6.4	16.2	13.5
LNMX160608L-MDR	L	0.8	●		●												6.4	16.2	13.5
LNMX160612R-MDR	R	1.2	●		●												6.4	16.2	13.5
LNMX160612L-MDR	L	1.2	●		●												6.4	16.2	13.5
LNMX160608R-TWR	R	0.8	●														6.4	16.2	13.5
LNMX160608L-TWR	L	0.8	●	●													6.4	16.2	13.5
LNMX160612R-TWR	R	1.2	●	●													6.4	16.2	13.5
LNMX160612L-TWR	L	1.2	●	●													6.4	16.2	13.5

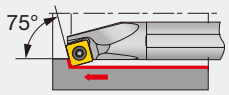
●: Line up

Reference pages: Standard cutting conditions → D097

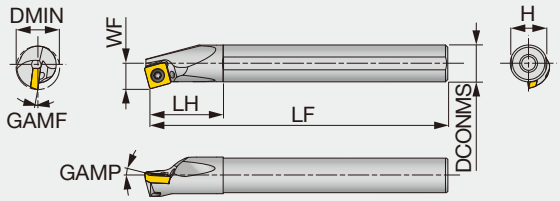
STREAMJETBAR

A-SSKPR

Screw-on boring bar, for positive square inserts



Cutting edge style **K**



Right hand (R) shown.

Designation	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
Grade	T9215
Breaker Shape	PS
Cutting conditions	B016

M

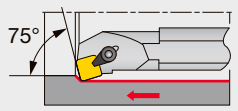
Application	Finishing to medium cutting
Grade	AH6225
Breaker Shape	PS
Cutting conditions	B018

K

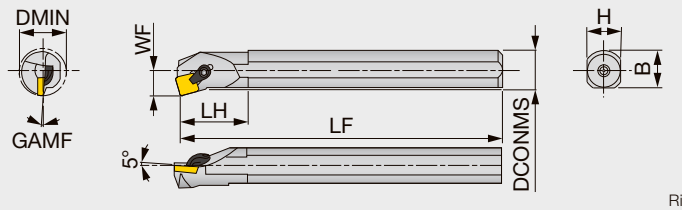
Application	Finishing to medium cutting
Grade	T515
Breaker Shape	CM
Cutting conditions	B020

Reference pages: A-SSKPR: Insert → B135 -, CBN → B195 -

Clamp-on boring bar, for positive square inserts



Cutting edge style **K**



Right hand (R) shown.

Designation	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

Note: 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

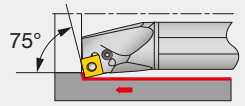
L
X
J
A
K
F
U
Q
Z
OTHERS

Reference pages: S/C-CSKPR/L: Insert → B135 -, CBN → B195 -, PCD → B215

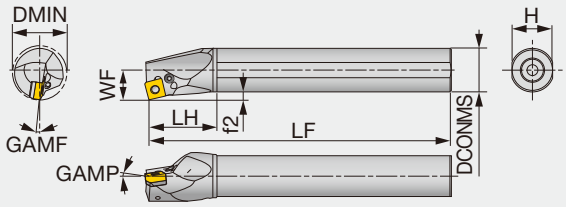
STREAMJETBAR

A-PSKNR/L

Lever-lock boring bar, for negative square inserts



Cutting edge style **K**



Right hand (R) shown.

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

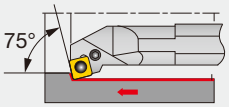
SPARE PARTS

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

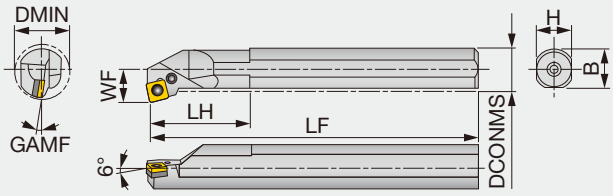
*Optional

S-PSKNR

Lever-lock boring bar, for negative square inserts



Cutting edge style **K**



Right hand (R) shown.

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

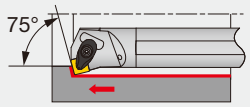
SPARE PARTS

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

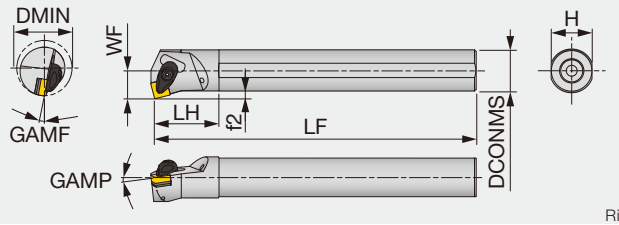
Reference pages: A-PSKNR/L, S-PSKNR: Insert → B077 -, CBN → B180, PCD → B211

A-ASKNR/L

Double-clamp boring bar, for negative square inserts



Cutting edge style **K**



Right hand (R) shown.

Designation	Material	DMIN	DCONMS	WF	LF	LH	H	f2	GAMP	GAMF	RE**	Insert	Torque*
A25R-ASKNR/L12-D320	Steel	32	25	17	200	45	23	4.5	-6°	-13°	0.8	SN**1204...	3
A32S-ASKNR/L12-D400	Steel	40	32	22	250	50	30	6	-6°	-10°	0.8	SN**1204...	3

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

SPARE PARTS

Designation	Clamp	Clamp screw	Spring	Spring pin	Shim	Shim screw	Wrench
A**-ASKN*12-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	B004			

M

Application	Finishing	Medium cutting	Medium to heavy cutting
Grade	T6215	AH6225	AH6225
Chipbreaker Shape	SF	SM	SH
Cutting conditions	B006		

K

Application	Finishing	Medium cutting	Medium to heavy cutting
Grade	T515	T515	T515
Breaker Shape	All-round	All-round	All-round
Cutting conditions	B008		

N

Application	Finishing	Medium cutting
Grade	DX140	TH10
Breaker Shape	T-DIA	P
Cutting conditions	B010	

S

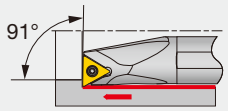
Application	Precision finishing	Finishing	Medium cutting
Grade	BX480	AH8005	AH8005
Breaker Shape	T-CBN	HRF	HRM
Cutting conditions	B012		

Reference pages: A-ASKNR/L: Insert → B077 -, CBN → B180, PCD → B211

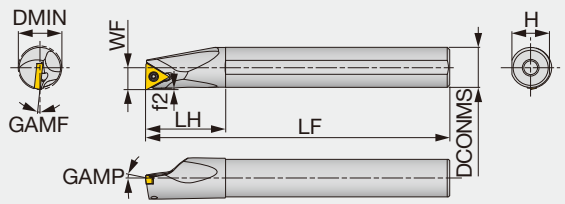
STREAMJETBAR

A/E-STFCR/L

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



Cutting edge style **F**



Right hand (R) shown.

Designation	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 (N·m)
**RE : Standard corner radius
Note: 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
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	JP	JS	PS	PM
Cutting conditions	B016			

M

Application	Precision finishing	Finishing	Finishing to medium cutting	Medium cutting
Grade	SH725	SH725	AH6225	AH6225
Breaker Shape	JP	JS	PS	PM
Cutting conditions	B018			

K

Application	Finishing to medium cutting
Grade	T515
Breaker Shape	CM
Cutting conditions	B020

N

Application	Precision finishing	Finishing to medium cutting
Grade	DX120	KS05F
Breaker Shape	DIA with rake	AL
Cutting conditions	B022	

S

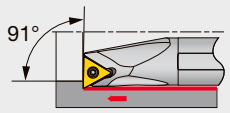
Application	Precision finishing	Finishing	Finishing to medium cutting	Medium cutting
Grade	SH725	SH725	AH6225	AH6225
Breaker Shape	JP	JS	PS	PM
Cutting conditions	B024			

Reference pages: A/E-STFCR/L: Insert → B138 -, PCD → B216

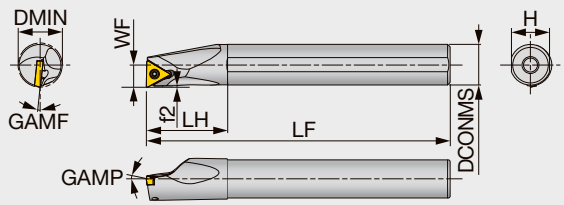
STREAMJETBAR

A/E-STFPR/L

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



Cutting edge style **F**



Right hand (R) shown.

Designation	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 (N·m)
**RE : Standard corner radius
Note: Use right-hand toolholders (STFPR**) with left-hand inserts (L); and left-hand toolholders (STFPL**) with right-hand inserts (R).
TPGH, TPGM, and TPGA inserts cannot be used.

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	NS9530	T9215	T9215
Breaker Shape	PSS	PS	PM
Cutting conditions	B016		

M

Application	Finishing	Finishing to medium cutting	Medium cutting
Grade	AH6225	AH6225	AH6225
Breaker Shape	PSS	PS	PM
Cutting conditions	B018		

K

Application	Finishing to medium cutting
Grade	T515
Breaker Shape	CM
Cutting conditions	B020

N

Application	Precision finishing
Grade	DX140 with rake
Breaker Shape	DIA
Cutting conditions	B022

S

Application	Precision finishing
Grade	BX470
Breaker Shape	CBN
Cutting conditions	B024

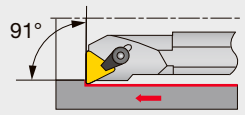
H

Application	Precision finishing	Finishing
Grade	BXA10	BXA20
Breaker Shape	HP	HS
Cutting conditions	B026	

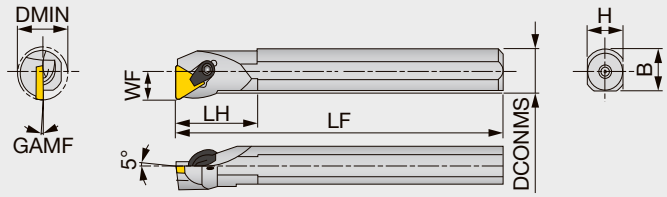
Reference pages: A/E-STFPR/L: Insert → B142 -, CBN → B199 -, PCD → B216 -

S/C-CTFPR/L

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



Cutting edge style **F**



Right hand (R) shown.

Designation	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

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

SPARE PARTS

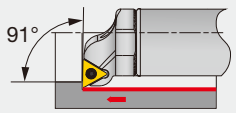
Designation	Clamp set 1	Clamp set 2	Wrench	Shim	Shim screw
S12M-CTFPR/L11	CSW-00	-	P-2.5	-	-
S16Q-CTFPR/L11	-	CSG-5S	P-2.5	-	-
S20R-CTFPR/L16	-	CSG-6S	P-3	-	-
S25S-CTFPR/L16	-	CSG-6	P-3	-	-
S32T-CTFPR/L16	-	CSG-6	P-3	PAT-32	M3X0.5X6
C12Q-CTFPR/L11	CSW-00	-	P-2.5	-	-
C16R-CTFPR/L11	-	CSG-5S	P-2.5	-	-

Reference pages: S/C-CTFPR/L: Insert → B142 -, CBN → B199 -, PCD → B217 -

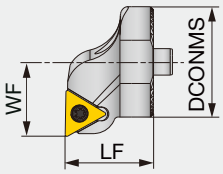
BOREMEISTER

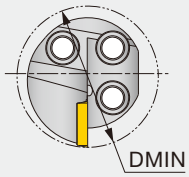
S-STFPR/L-H

Screw-on clamp exchangeable boring head, for positive 60° triangular inserts



Cutting edge style **F**





Right hand (R) shown.

Designation	DMIN	DCONMS	WF	LF	Shank	Insert
S16-STFPR/L09-H	20	16	11	20	D16	TP**0902...
S16-STFPR/L11-H	20	16	11	20	D16	TP**1102...
S20-STFPR/L11-H	25	20	13	20	D20	TP**1102...
S25-STFPR/L11-H	32	25	17	20	D25	TP**1102...
S32-STFPR/L16-H	40	32	22	32	D32	TP**16T3...
S40-STFPR/L16-H	50	40	27	32	D40, D50, D60	TP**16T3...

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

SPARE PARTS

Designation	Clamping screw	Wrench
S16-STFPR/L09-H	CSTB-2.2S	T-7F
S16-STFPR/L11-H	CSTB-2.5	T-8F
S20-STFPR/L11-H	CSTB-2.5	T-8F
S25-STFPR/L11-H	CSTB-2.5	T-8F
S32-STFPR/L16-H	CSTB-4M	T-15F
S40-STFPR/L16-H	CSTB-4M	T-15F

INSERT SELECTION

P

Application	Finishing	Finishing to medium cutting	Medium cutting
Grade	NS9530	T9215	T9215
Breaker Shape	PSS	PS	PM
Cutting conditions	B016		

M

Application	Finishing	Finishing to medium cutting	Medium cutting
Grade	AH6225	AH6225	AH6225
Breaker Shape	PSS	PS	PM
Cutting conditions	B018		

K

Application	Finishing to medium cutting
Grade	T515
Breaker Shape	CM
Cutting conditions	B020

N

Application	Precision finishing
Grade	DX140
Breaker Shape	DIA with rake
Cutting conditions	B022

S

Application	Precision finishing
Grade	BX470
Breaker Shape	CBN
Cutting conditions	B024

H

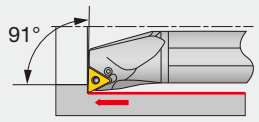
Application	Precision finishing	Finishing
Grade	BXA10	BXA20
Breaker Shape	HP	HS
Cutting conditions	B026	

Reference pages: S-STFPR/L-H: Insert → B142 -, CBN → B199 -, PCD → B216 -
Shank → D090 - D092

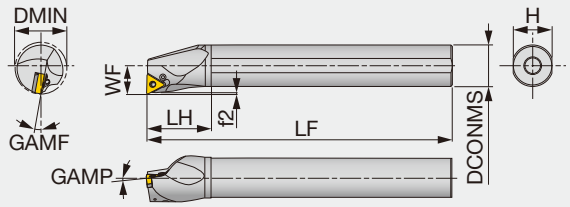
STREAMJETBAR

A-PTFNR/L

Lever-lock boring bar, for negative triangular inserts



Cutting edge style **F**



Right hand (R) shown.

Designation	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
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).

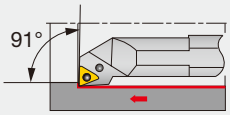
SPARE PARTS

Designation	Shim	Clamping screw 1	Clamping screw 2	Wrench	Spring pin	Lever	Oil supply attachment*	Screw for oil hole*
A25R-PTFNR/L1104-D320	-	LCS23A	-	P-2.5	-	LCL23	EA-25	SSHM4-5
A32S-PTFNR/L1104-D400	-	LCS23A	-	P-2.5	-	LCL23	EA-32	SSHM4-5
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

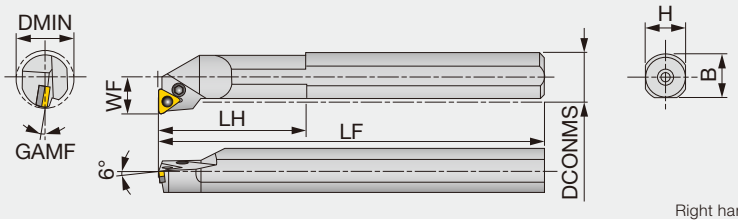
*Optional

S-PTFNR/L

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



Cutting edge style **F**



Right hand (R) shown.

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

SPARE PARTS

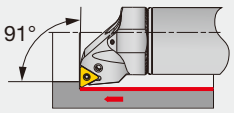
Designation	Shim	Clamping screw	Wrench	Spring pin	Lever
S32S-PTFNR16	LST317BR	LCS3	P-2.5	LSP3	LCL3
S32S-PTFNL16	LST317BL	LCS3	P-2.5	LSP3	LCL3
S40T-PTFNR16	LST317BR	LCS3	P-2.5	LSP3	LCL3
S40T-PTFNL16	LST317BL	LCS3	P-2.5	LSP3	LCL3
S50U-PTFNR16	LST317BR	LCS3	P-2.5	LSP3	LCL3

Reference pages: A-PTFNR/L, S-PTFNR/L: Insert → B087 -, CBN → B182 -, PCD → B212

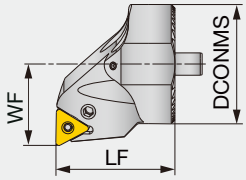
BOREMEISTER

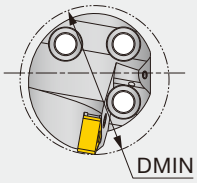
S-PTFNR/L-H

Lever-lock clamp exchangeable boring head, for negative 60° triangular inserts



Cutting edge style **F**





Right hand (R) shown.

Designation	DMIN	DCONMS	WF	LF	Shank	Insert
S32-PTFNR/L11-H	40	32	22	32	D32	TN**1104...
S40-PTFNR/L11-H	50	40	27	32	D40, D50, D60	TN**1104...

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

SPARE PARTS

Designation	Lever	Clamping screw	Wrench
S**-PTFNR/L11-H	LCL23	LCS23A	P-2.5

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	B004			

M

Application	Finishing	Medium cutting
Grade	T6215	AH6225
Breaker Shape	SF	SM
Cutting conditions	B006	

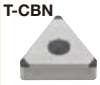
K

Application	Finishing	Medium cutting	Medium to heavy cutting
Grade	T515	T515	T515
Breaker Shape	All-round	All-round	All-round
Cutting conditions	B008			

N

Application	Precision finishing	Finishing	Medium cutting
Grade	DX120	DX140	TH10
Breaker Shape	DIA with rake	DIA	P
Cutting conditions	B010		

S

Application	Precision finishing	Finishing	Medium cutting
Grade	BX470	AH8005	AH8005
Breaker Shape	T-CBN 	HRF	HRM
Cutting conditions	B012		

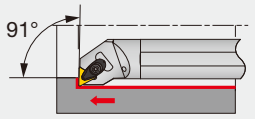
H

Application	Precision finishing	Finishing
Grade	BXA10	BXA20
Breaker Shape	HP	HS
Cutting conditions	B014	

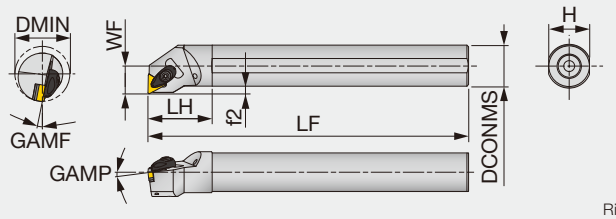
Reference pages: S-PTFNR/L-H: Insert → B087 -, CBN → B184
Shank → D090 - D092

A-ATFNR/L

Double-clamp boring bar, for negative 60° triangular inserts



Cutting edge style **F**



Right hand (R) shown.

Designation	Material	DMIN	DCONMS	WF	LF	LH	H	f2	GAMP	GAMF	RE**	Insert	Torque*
A25R-ATFNR/L16-D320	Steel	32	25	17	200	45	23	4.5	-6°	-13°	0.8	TN**1604...	3
A32S-ATFNR/L16-D400	Steel	40	32	22	250	50	30	6	-6°	-10°	0.8	TN**1604...	3

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

SPARE PARTS

Designation	Clamp	Clamp screw	Spring	Spring pin	Shim	Shim screw	Wrench
A**-ATFNR/L16-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	B004			

M

Application	Finishing	Medium cutting
Grade	T6215	AH6225
Breaker Shape	SF	SM
Cutting conditions	B006	

K

Application	Finishing	Medium cutting	Medium to heavy cutting
Grade	T515	T515	T515
Breaker Shape	All-round	All-round	All-round
Cutting conditions	B008		

N

Application	Precision finishing	Finishing	Medium cutting
Grade	DX120	DX140	TH10
Breaker Shape	DIA with rake	DIA	P
Cutting conditions	B010		

S

Application	Precision finishing	Finishing	Medium cutting
Grade	BX470	AH8005	AH8005
Breaker Shape	CBN	HRF	HRM
Cutting conditions	B012		

H

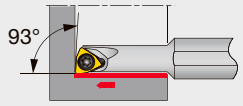
Application	Precision finishing	Finishing
Grade	BXA10	BXA20
Breaker Shape	HP	HS
Cutting conditions	B014	

Reference pages: A-ATFNR/L: Insert → B087 -, CBN → B182 -, PCD → B212

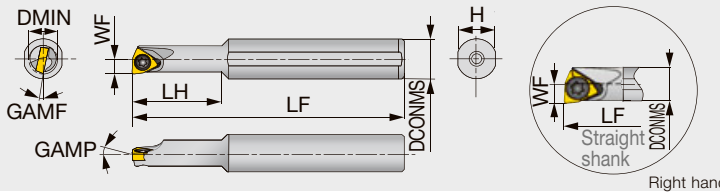
STREAMJETBAR

A/E-SWUBR/L

Screw-on boring bar, for positive 80° trigon inserts



Cutting edge style **U**



Right hand (R) shown.

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

*Torque: Recommended clamping torque (N·m)
**RE : Standard corner radius
Note: Use right-hand toolholders (SWUBR**) 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	Finishing
Grade	SH725
Breaker Shape	JS
Cutting conditions	B016

M

Application	Finishing
Grade	SH725
Breaker Shape	JS
Cutting conditions	B018

K

Application	Finishing
Grade	SH725
Breaker Shape	JS
Cutting conditions	B020

N

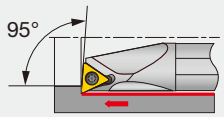
Application	Finishing
Grade	SH725
Breaker Shape	JS
Cutting conditions	B022

Reference pages: A/E-SWUBR/L: Insert → B156 -

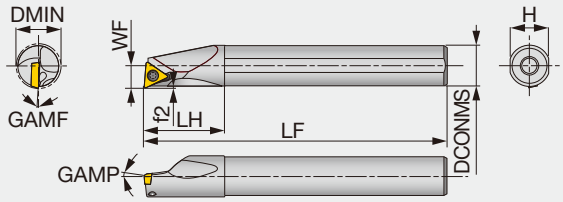
STREAMJETBAR

A/E-STUPR/L

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



Cutting edge style **U**



Right hand (R) shown.

Designation	Material	DMIN	DCONMS	WF	LF	LH	H	f2	GAMP	GAMF	RE**	Insert	Torque*
A07G-STUPR/L07-D080	Steel	8	7	4	90	12	6.75	0.4	5°	-10°	0.4	TP**0701...	0.9
A08H-STUPR/L07-D080	Steel	8	8	4	100	19.5	7.5	0.5	5°	-10°	0.4	TP**0701...	0.9
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
A16Q-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/L1103-D220	Steel	22	20	11	200	36	18	0.7	5°	-2°	0.4	TP**1103...(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-STUPR/L13-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

*Torque: Recommended clamping torque (N·m)
**RE : Standard corner radius
Note: 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 → B142 -, CBN → B199 -, PCD → B216 -

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

INSERT SELECTION

P

Application	Finishing	Finishing to medium cutting	Medium cutting
Grade	NS9530	T9215	T9215
Breaker Shape	PSS	PS	PM
Cutting conditions	B016		

M

Application	Finishing	Finishing to medium cutting	Medium cutting
Grade	AH6225	AH6225	AH6225
Breaker Shape	PSS	PS	PM
Cutting conditions	B018		

K

Application	Finishing to medium cutting
Grade	T515
Breaker Shape	CM
Cutting conditions	B020

N

Application	Precision finishing
Grade	DX140
Breaker Shape	DIA with rake
Cutting conditions	B022

S

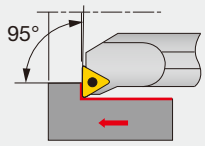
Application	Precision finishing
Grade	BX470
Breaker Shape	CBN
Cutting conditions	B024

H

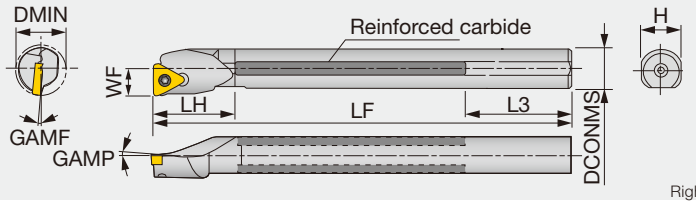
Application	Precision finishing	Finishing
Grade	BXA10	BXA20
Breaker Shape	HP	HS
Cutting conditions	B026	

T-STUPR/L

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



Cutting edge style **U**



Right hand (R) shown.

Designation	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	24	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
Note: 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	Finishing	Finishing to medium cutting	Medium cutting
Grade	NS9530	T9215	T9215
Breaker Shape	PSS	PS	PM
Cutting conditions	B016		

M

Application	Finishing	Finishing to medium cutting	Medium cutting
Grade	AH6225	AH6225	AH6225
Breaker Shape	PSS	PS	PM
Cutting conditions	B018		

K

Application	Finishing to medium cutting
Grade	T515
Breaker Shape	CM
Cutting conditions	B020

N

Application	Precision finishing
Grade	DX140
Breaker Shape	DIA with rake
Cutting conditions	B022

S

Application	Precision finishing
Grade	BX470
Breaker Shape	CBN
Cutting conditions	B024

H

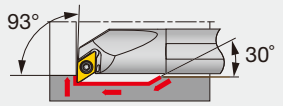
Application	Precision finishing	Finishing
Grade	BXA10	BXA20
Breaker Shape	HP	HS
Cutting conditions	B026	

Reference pages: T-STUPR/L: Insert → B142 -, CBN → B199 -, PCD → B216 -

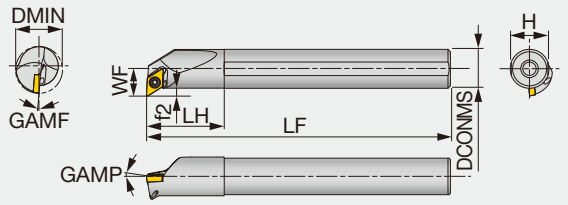
STREAMJETBAR

A/E-SDUCR/L

Screw-on boring bar, for positive 55° rhombic inserts



Cutting edge style **U**



Right hand (R) shown.

Designation	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 (N·m)
**RE : Standard corner radius
Note: Use right-hand toolholders (SDUCR**) with left-hand inserts (L); and left-hand toolholders (SDUCL**) with right-hand inserts (R).

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

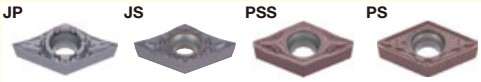
INSERT SELECTION

P

Application	Precision finishing	Finishing		Finishing to medium cutting
Grade	SH725	SH725	NS9530	T9215
Breaker Shape	JP	JS	PSS	PS
Cutting conditions	B016			

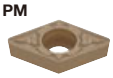
M

Application	Precision finishing	Finishing		Finishing to medium cutting
Grade	SH725	SH725	AH6225	AH6225
Breaker Shape	JP	JS	PSS	PS
Cutting conditions	B018			



P

Application	Medium cutting
Grade	T9215
Breaker Shape	PM
Cutting conditions	B016



M

Application	Medium cutting
Grade	AH6225
Breaker Shape	PM
Cutting conditions	B018

K

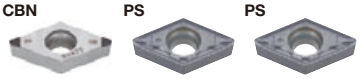
Application	Finishing to medium cutting
Grade	T515
Breaker Shape	CM
Cutting conditions	B020

N

Application	Precision finishing	Finishing	Finishing to medium cutting
Grade	DX120	DX140	KS05F
Breaker Shape	DIA with rake		AL
Cutting conditions	B022		

S

Application	Precision finishing	Finishing	Finishing to medium cutting
Grade	BX470	AH8005	AH8015
Breaker Shape	CBN	PS	PS
Cutting conditions	B024		



H

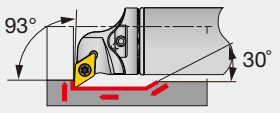
Application	Precision finishing	Finishing
Grade	BXA10	BXA20
Breaker Shape	HP	HS
Cutting conditions	B026	

Reference pages: A/E-SDUCR/L: Insert → B119 -, CBN → B182, PCD → B194 -

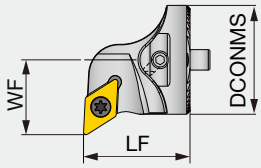
BOREMEISTER

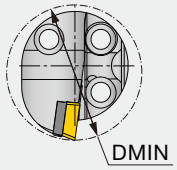
S-SDUCR/L-H

Screw-on clamp exchangeable boring head, for positive 55° rhombic inserts



Cutting edge style **U**





Right hand (R) shown.

Designation	DMIN	DCONMS	WF	LF	Shank	Insert
S16-SDUCR/L07-H	20	16	11	20	D/G16	DC**0702...
S20-SDUCR/L11-H	25	20	13	20	D/G20	DC**11T3...
S25-SDUCR/L11-H	32	25	17	20	D25	DC**11T3...
S32-SDUCR/L11T-H	40	32	22	32	D32	DC**11T3...
S40-SDUCR/L11T-H	50	40	27	32	D40, D50, D60	DC**11T3...

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

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	Precision finishing	Finishing		Finishing to medium cutting
Grade	SH725	SH725	NS9530	T9215
Breaker Shape	JP	JS	PSS	PS
Cutting conditions	B016			

M

Application	Precision finishing	Finishing		Finishing to medium cutting
Grade	SH725	SH725	AH6225	AH6225
Breaker Shape	JP	JS	PSS	PS
Cutting conditions	B018			

P

Application	Medium cutting
Grade	T9215
Breaker Shape	PM
Cutting conditions	B016

M

Application	Medium cutting
Grade	AH6225
Breaker Shape	PM
Cutting conditions	B018

K

Application	Finishing to medium cutting
Grade	T515
Breaker Shape	CM
Cutting conditions	B020

N

Application	Precision finishing	Finishing	Finishing to medium cutting
Grade	DX120	DX140	KS05F
Breaker Shape	DIA with rake		AL
Cutting conditions	B022		

S

Application	Precision finishing	Finishing	Finishing to medium cutting
Grade	BX470	AH8005	AH8015
Breaker Shape	CBN	PS	PS
Cutting conditions	B024		

H

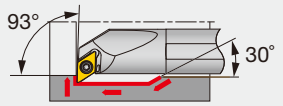
Application	Precision finishing	Finishing
Grade	BXA10	BXA20
Breaker Shape	HP	HS
Cutting conditions	B026	

Reference pages: S-SDUCR/L-H: Insert → B121 -, CBN → B193 -, PCD → B214
Shank → D090 - D092

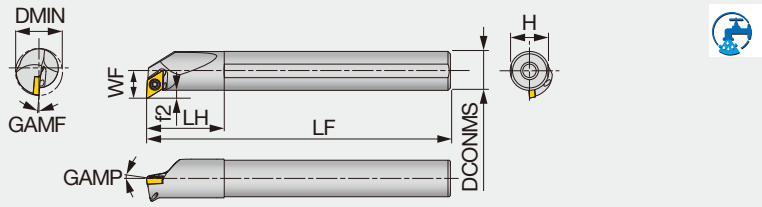
STREAMJETBAR

A/E-SDUPR/L

Screw-on boring bar, for positive 55° rhombic inserts



Cutting edge style **U**



Right hand (R) shown.

Designation	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

*Torque: Recommended clamping torque (N·m)
**RE : Standard corner radius
Note: 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	Finishing to medium cutting
Grade	NS9530	T9215
Breaker Shape	PS	PS
Cutting conditions	B016	

M

Application	Finishing	Finishing to medium cutting
Grade	AH6225	AH6225
Chipbreaker shape	PS	PS
Cutting conditions	B018	

K

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

S

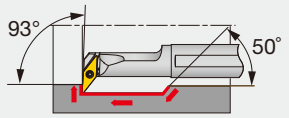
Application	Finishing	Finishing to medium cutting
Grade	AH8015	AH8015
Breaker Shape	PS	PS
Cutting conditions	B024	

Reference pages: A/E-SDUPR/L: Insert → B126

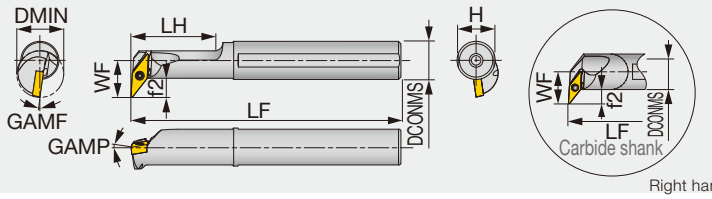
STREAMJETBAR

A/E-SVUBR/L

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



Cutting edge style **U**



Right hand (R) shown.

Designation	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 (N·m)
**RE : Standard corner radius
Note: 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
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	Precision finishing	Finishing		Finishing to medium cutting
Grade	SH725	SH725	NS9530	T9215
Breaker Shape	JP	JS	PSS	PS
Cutting conditions	B014			

M

Application	Precision finishing	Finishing		Finishing to medium cutting
Grade	SH725	SH725	AH6225	AH6225
Chipbreaker shape	JP	JS	PSS	PS
Cutting conditions	B016			

P

Application	Medium cutting
Grade	T9215
Breaker Shape	PS
Cutting conditions	B014

M

Application	Medium cutting
Grade	AH6225
Chipbreaker shape	PS
Cutting conditions	B016

K

Application	Finishing to medium cutting
Grade	T515
Breaker Shape	CM
Cutting conditions	B020

S

Application	Finishing	Finishing to medium cutting
Grade	AH8005	AH8015
Breaker Shape	PS	PS
Cutting conditions	B024	

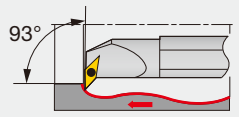
H

Application	Precision finishing	Finishing
Grade	BXA10	BXA20
Breaker Shape	HP	HS
Cutting conditions	B026	

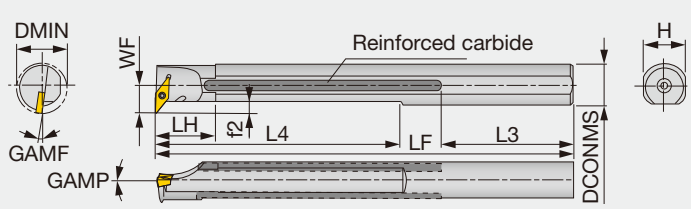
Reference pages: A/E-SVUBR/L: Insert → B150 -, CBN → B207 -

T-SVUBR

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



Cutting edge style **U**



Right hand (R) shown.

Designation	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
Note: 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	Precision finishing	Finishing		Finishing to medium cutting
Grade	SH725	SH725	NS9530	T9215
Breaker Shape	JP	JS	PSS	PS
Cutting conditions	B014			

M

Application	Precision finishing	Finishing		Finishing to medium cutting
Grade	SH725	SH725	AH6225	AH6225
Chipbreaker shape	JP	JS	PSS	PS
Cutting conditions	B016			

P

Application	Medium cutting
Grade	T9215
Breaker Shape	PS
Cutting conditions	B014

M

Application	Medium cutting
Grade	AH6225
Chipbreaker shape	PS
Cutting conditions	B016

K

Application	Finishing to medium cutting
Grade	T515
Breaker Shape	CM
Cutting conditions	B020

S

Application	Finishing	Finishing to medium cutting
Grade	AH8005	AH8015
Breaker Shape	PS	PS
Cutting conditions	B024	

H

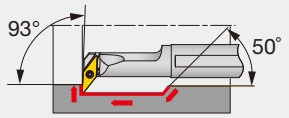
Application	Precision finishing	Finishing
Grade	BXA10	BXA20
Breaker Shape	HP	HS
Cutting conditions	B026	

Reference pages: T-SVUBR: Insert → B150 -, CBN → B207 -

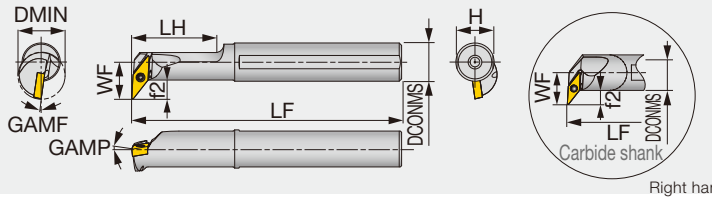
STREAMJETBAR

A/E-SVUCR/L

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



Cutting edge style **U**



Right hand (R) shown.

Designation	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 (N·m)
**RE : Standard corner radius
Note: 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
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	Finishing to medium cutting
Grade	NS9530	T9215
Breaker Shape	PSS	PS
Cutting conditions	B016	

M

Application	Finishing	Finishing to medium cutting
Grade	AH6225	AH6225
Chipbreaker shape	PSS	PS
Cutting conditions	B018	

K

Application	Finishing to medium cutting
Grade	T515
Breaker Shape	CM
Cutting conditions	B020

N

Application	Precision finishing	Finishing	Medium cutting
Grade	DX120	DX140	KS05F
Breaker Shape	DIA with rake	DIA	AL
Cutting conditions	B022		

S

Application	Finishing	Finishing to medium cutting
Grade	AH8005	AH8015
Breaker Shape	PS	PS
Cutting conditions	B024	

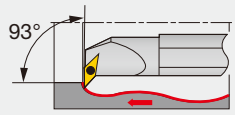
H

Application	Precision finishing	Finishing
Grade	BXA10	BXA20
Breaker Shape	CBN	CBN
Cutting conditions	B026	

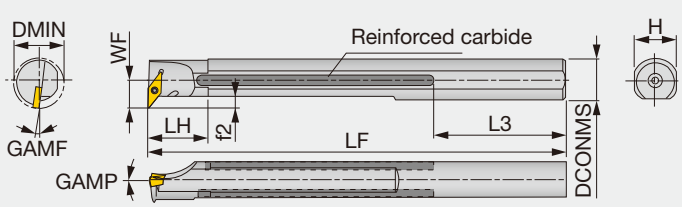
Reference pages: A/E-SVUCR/L: Insert → B152 -, CBN → B209, PCD → B220

T-SVUCR

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



Cutting edge style **U**



Right hand (R) shown.

Designation	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
*The hole specification of applicable inserts conforms to ISO standard.
Note: 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	B016	

M

Application	Finishing	Finishing to medium cutting
Grade	AH6225	AH6225
Chipbreaker shape	PSS	PS
Cutting conditions	B018	

K

Application	Finishing to medium cutting
Grade	T515
Breaker Shape	CM
Cutting conditions	B020

N

Application	Precision finishing	Finishing	Medium cutting
Grade	DX120	DX140	KS05F
Breaker Shape	DIA with rake	DIA	AL
Cutting conditions	B022		

S

Application	Finishing	Finishing to medium cutting
Grade	AH8005	AH8015
Breaker Shape	PS	PS
	B024	

H

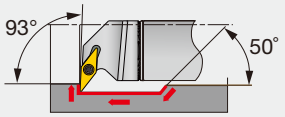
Application	Precision finishing	Finishing
Grade	BXA10	BXA20
Breaker Shape	CBN	CBN
	B026	

Reference pages: T-SVUCR: Insert → B152 -, CBN → B209, PCD → B220

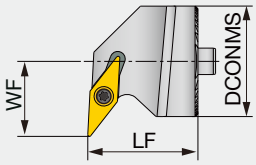
BOREMEISTER

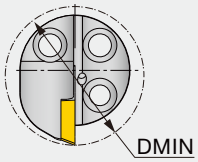
S-SVUCR/L-H

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



Cutting edge style **U**





Right hand (R) shown.

Designation	DMIN	DCONMS	WF	LF	Shank	Insert
S20-SVUCR/L11-H	27	20	16	20	D/G20	VC**1103...
S25-SVUCR/L11-H	31	25	17	25	D25	VC**1103...

Note: 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
S20-SVUCR/L11-H	SR14-560	T-8/5
S25-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	B016	

M

Application	Finishing	Finishing to medium cutting
Grade	AH6225	AH6225
Chipbreaker shape	PSS	PS
Cutting conditions	B018	

K

Application	Finishing to medium cutting
Grade	T515
Breaker Shape	CM
Cutting conditions	B020

N

Application	Precision finishing	Finishing	Medium cutting
Grade	DX120	DX140	KS05F
Breaker Shape	DIA with rake	DIA	AL
Cutting conditions	B022		

S

Application	Finishing	Finishing to medium cutting
Grade	AH8005	AH8015
Breaker Shape	PS	PS
Cutting conditions	B024	

H

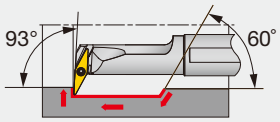
Application	Precision finishing	Finishing
Grade	BXA10	BXA20
Breaker Shape	CBN	CBN
Cutting conditions	B026	

Reference pages: S-SVUCR/L-H: Insert → B152 -, CBN → B209, PCD → B220
Shank → D090 - D092

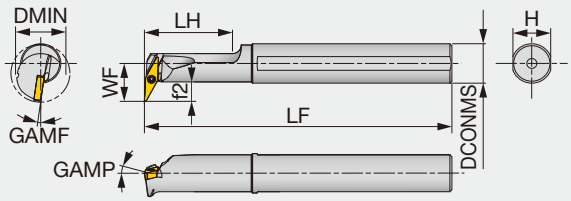
Y-PRO SERIES

A/E-SYUBR/L

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



Cutting edge style **U**



Right hand (R) shown.

Designation	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

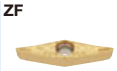
*Torque: Recommended clamping torque (N·m)
**RE : Standard corner radius

SPARE PARTS

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

INSERT SELECTION

P

Application	Finishing	Finishing to medium cutting	Medium cutting
Grade	GT9215	T9215	T9215
Breaker Shape	ZF 	ZF	ZM
Cutting conditions	B016		

M

Application	Finishing	Finishing to medium cutting	Medium cutting
Grade	AH8015	AH8015	AH8015
Breaker Shape	ZF	ZF	ZM
Cutting conditions	B018		

K

Application	Finishing	Finishing to medium cutting	Medium cutting
Grade	GT9530	T9215	T9215
Breaker Shape	ZF	ZF	ZM
Cutting conditions	B020		

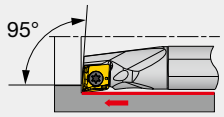
S

Application	Finishing	Finishing to medium cutting	Medium cutting
Grade	AH8015	AH8015	AH8015
Breaker Shape	ZF	ZF	ZM
Cutting conditions	B024		

Reference pages: A/E-SYUBR/L: Insert → B159

A/E-SXUOR/L

Screw-on boring bar, for XOMU rhombic inserts



Cutting edge style **U**

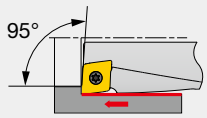
Designation	DMIN	DCONMS	WF	LF	LH	H	GAMP	GAMF	Insert
A08H-SXUOR/L05-D100	10	8	5	100	16	7.5	-7°	-0.8°	XOMU05X204-PS
A12M-SXUOR/L07-D140	14	12	7	150	24	11	-7.2°	3.2°	XOMU07H304-PS
E08K-SXUOR/L05-D100	10	8	5	125	22	7.5	-7°	-0.8°	XOMU05X204-PS
E12Q-SXUOR/L07-D140	14	12	7	180	27	11	-7.2°	3.2°	XOMU07H304-PS

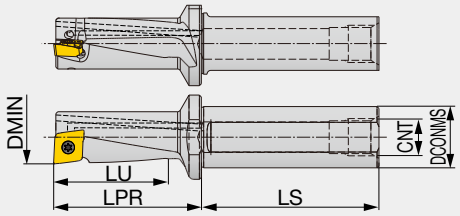
SPARE PARTS

Designation	Clamping screw	Wrench
A08H-SXUOR/L05-D100	CSTB-2L040	T-6F
A12M-SXUOR/L07-D140	CSPB-2.5	IP-8D
E08K-SXUOR/L05-D100	CSTB-2L040	T-6F
E12Q-SXUOR/L07-D140	CSPB-2.5	IP-8D

TBM

Maximum hole depth for LH/DC = 2.25





Designation	DMIN	DCONMS	LU	LS	LPR	CNT	Insert
TBM10R/LF12-2.25	10	12	22.5	41.5	28.45	UNF 5/16-24	XOMU05X204-PS
TBM12R/LF16-2.25	12	16	27	43.9	33.53	G1/8	XOMU06H204-PS
TBM14R/LF16-2.25	14	16	31.5	46.4	38.57	G1/8	XOMU07H304-PS
TBM16R/LF20-2.25	16	20	36	57.1	42.9	G1/8	XOMU08T304-PS

SPARE PARTS

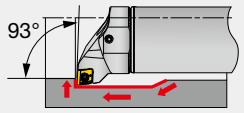
Designation	Clamping screw	Wrench
TBM10R/LF12-2.25	CSTB-2L040	T-6D
TBM12R/LF16-2.25	CSPB-2.2	IP-7D
TBM14R/LF16-2.25	CSPB-2.5	IP-8D
TBM16R/LF20-2.25	CSTB-3	T-9D

Reference pages: Insert → D066
Standard cutting conditions → D098

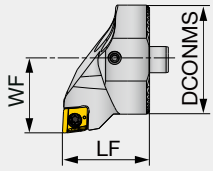
BOREMEISTER

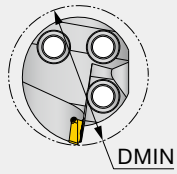
S-SXUOR05-H

Screw-on clamp exchangeable boring head, for XOMU inserts



Cutting edge style **U**





Right hand (R) shown.

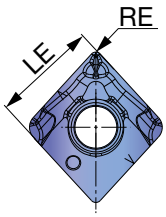
Designation	DMIN	DCONMS	WF	LF	Shank	Insert
S20-SXUOR05-H	25	20	13	20	D20	XOMU05X204-PS
S25-SXUOR05-H	32	25	17	20	D25	XOMU05X204-PS

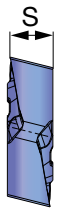
SPARE PARTS

Designation	Clamping screw	Wrench
S**-SXUOR05-H	CSTB-2L040	T-6F

INSERT

XOMU-PS





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

★ : First choice
☆ : Second choice

Designation	RE	Coated	S	LE
		AH725		
XOMU05X204-PS	0.4	●	2.3	5.56
XOMU06H204-PS	0.4	●	2.7	6.3
XOMU07H304-PS	0.4	●	3.3	7.3
XOMU08T304-PS	0.4	●	4	8.3

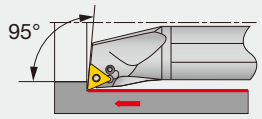
●: Line up

Reference pages: Shank → D090 - D092
Standard cutting conditions → D098

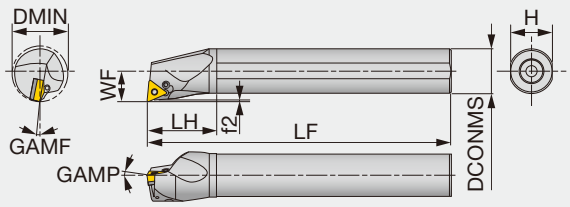
STREAMJETBAR

A-PTUNR/L

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



Cutting edge style **U**



Right hand (R) shown.

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

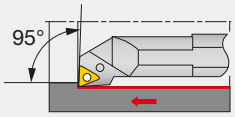
SPARE PARTS

Designation	Shim	Clamping screw 1	Clamping screw 2	Wrench 1	Wrench 2	Spring pin	Lever	Oil supply attachment*	Screw for oil hole*
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
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

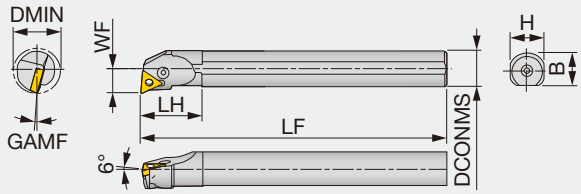
*Optional

A/S-PTUNR/L

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



Cutting edge style **U**



Right hand (R) shown.

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

SPARE PARTS

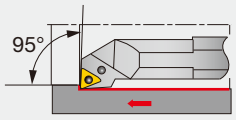
Designation	Shim	Clamping screw 1	Clamping screw 2	Wrench 1	Wrench 2	Spring pin	Lever	Oil supply attachment*
S**-PTUNR/L11	-	LCS22A	-	P-2F	-	-	LCL22N	-
S25R-PTUNR16	ELST317BR	-	LCS3	-	P-2.5	LSP3	LCL33	-
S25R-PTUNL16	ELST317BL	-	LCS3	-	P-2.5	LSP3	LCL33	-
A32S-PTUNR16	LST317BR	-	LCS3	-	P-2.5	LSP3	LCL3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

*Optional

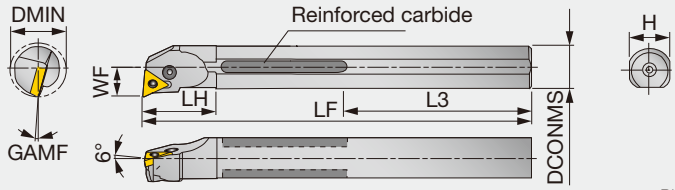
Reference pages: A-PTUNR/L, A/S-PTUNR/L: Insert → B087 -, CBN → B182 -, PCD → B212

T-PTUNR

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



Cutting edge style **U**



Right hand (R) shown.

Designation	Material	DMIN	CNT	DCONMS	WF	LF	LH	L3	H	GAMF	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
*The hole specification of applicable inserts conforms to ISO standard.
Toolholder length may not conform to ISO standard.
Note: 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

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	B004			

M

Application	Finishing	Medium cutting
Grade	T6215	AH6225
Breaker Shape	SF	SM
Cutting conditions	B006	

K

Application	Finishing	Medium cutting	Medium to heavy cutting
Grade	T515	T515	T515
Breaker Shape	All-round	All-round	All-round
Cutting conditions	B008			

N

Application	Precision finishing	Finishing	Medium cutting
Grade	DX120	DX140	TH10
Breaker Shape	DIA with rake T-DIA	P	
Cutting conditions	B010		

S

Application	Precision finishing	Finishing	Medium cutting
Grade	BX470	AH8005	AH8005
Breaker Shape	CBN	HRF	HRM
Cutting conditions	B012		

H

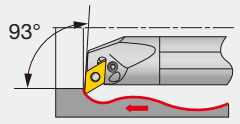
Application	Precision finishing	Finishing
Grade	BXA10	BXA20
Breaker Shape	HP	HS
Cutting conditions	B014	

Reference pages: T-PTUNR: Insert → B087 -, CBN → B182 -, PCD → B212

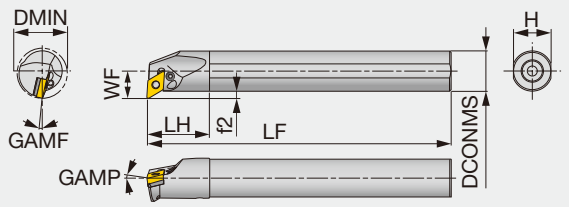
STREAMJETBAR

A-PDUNR/L

Lever-lock boring bar, for negative 55°/45° rhombic inserts



Cutting edge style **U**



Right hand (R) shown.

Designation	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**/FNMG1104...	1.7
A20Q-PDUNR/L11-D250	Steel	25	20	13	180	36	18	3	-6°	-14°	0.8	DN**/FNMG1104...	1.7
A25R-PDUNR/L11-D320	Steel	32	25	17	200	45	23	4.5	-6°	-12°	0.8	DN**/FNMG1104...	2.7
A32S-PDUNR/L15-D400	Steel	40	32	22	250	50	30	6	-6°	-13°	0.8	DN**/FNGA1504...	4.8
A40T-PDUNR/L15-D500	Steel	50	40	27	300	60	37	7	-6°	-10°	0.8	DN**/FNGA1504...	4.8
A50U-PDUNR/L15-D630	Steel	63	50	35	350	65	47	10	-6°	-8°	0.8	DN**/FNGA1504...	4.8
A32S-PDUNR/L1506-D400	Steel	40	32	22	250	50	30	6	-6°	-13°	0.8	DN**/FNGA1506...	4.8
A40T-PDUNR/L1506-D500	Steel	50	40	27	300	60	37	7	-6°	-11°	0.8	DN**/FNGA1506...	4.8
A50U-PDUNR/L1506-D630	Steel	63	50	35	350	65	47	10	-6°	-10°	0.8	DN**/FNGA1506...	4.8

*Torque: Recommended clamping torque (N·m)
**RE : Standard corner radius
Note: Use right-hand toolholders (PDUNR**) with left-hand inserts (L); and left-hand toolholders (PDUNL**) 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*
A20Q-PDUNR/L1104-D250	-	LCS22A	-	P-2F	-	-	LCL33NL	EA-20	SSHM2.5-3
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	B004			

M

Application	Finishing	Medium cutting	Medium to heavy cutting
Grade	T6215	AH6225	AH6225
Chipbreaker shape	SF	SM	SH
Cutting conditions	B006		

K

Application	Finishing	Medium cutting	Medium to heavy cutting
Grade	T515	T515	T515
Breaker Shape	All-round	All-round	All-round
Cutting conditions	B008		

N

Application	Precision finishing	Finishing	Medium cutting
Grade	DX120	DX140	TH10
Breaker Shape	DIA	with rake T-DIA	P
Cutting conditions	B010		

S

Application	Precision finishing	Finishing	Medium cutting
Grade	BX470	AH8005	AH8005
Breaker Shape	CBN	HRF	HRM
Cutting conditions	B012		

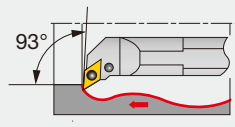
H

Application	Precision finishing	Finishing
Grade	BXA10	BXA20
Breaker Shape	HP	HS
Cutting conditions	B014	

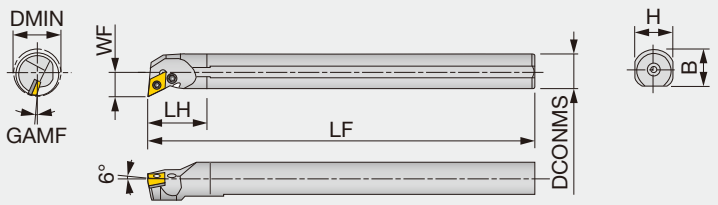
Reference pages: A-PDUNR/L: Insert → B066 -, B075, CBN → B172 -, PCD → B211

S-PDUNR/L

Lever-lock boring bar, for negative 55°/45° rhombic inserts



Cutting edge style **U**



Right hand (R) shown.

Designation	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**/FNMG1104...
S25R-PDUNR/L11	Steel	32	25	17	200	40	23	24	-12°	0.8	DN**/FNMG1104...
S32S-PDUNR/L15	Steel	40	32	22	250	50	30	29.5	-13°	0.8	DN**/FNGA1504...
S40T-PDUNR/L15	Steel	50	40	27	300	55	37	37.5	-10°	0.8	DN**/FNGA1504...
S50U-PDUNR/L15	Steel	63	50	35	350	65	47	47.5	-8°	0.8	DN**/FNGA1504...

**RE : Standard corner radius

Note: 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

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	B004			

M

Application	Finishing	Medium cutting	Medium to heavy cutting
Grade	T6215	AH6225	AH6225
Chipbreaker shape	SF	SM	SH
Cutting conditions	B006		

K

Application	Finishing	Medium cutting	Medium to heavy cutting
Grade	T515	T515	T515
Breaker Shape	All-round	All-round	All-round
Cutting conditions	B008		

N

Application	Precision finishing	Finishing	Medium cutting
Grade	DX120	DX140	TH10
Breaker Shape	DIA with rake	DIA	P
Cutting conditions	B010		

S

Application	Precision finishing	Finishing	Medium cutting
Grade	BX470	AH8005	AH8005
Breaker Shape	CBN	HRF	HRM
Cutting conditions	B012		

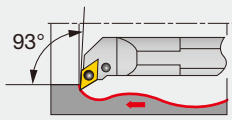
H

Application	Precision finishing	Finishing
Grade	BXA10	BXA20
Breaker Shape	HP	HS
Cutting conditions	B014	

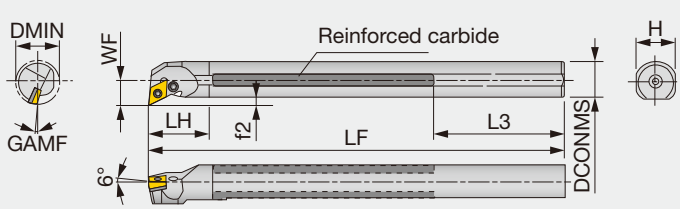
Reference pages: S-PDUNR/L: Insert → B066 -, B075, CBN → B172 -, PCD → B211

T-PDUNR

Lever-lock boring bar, for negative 55°/45° rhombic inserts (Tsuppari-Ichiban)



Cutting edge style **U**



Right hand (R) shown.

Designation	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**/FNGA1504...
T40V-PDUNR15C	Reinforced	50	Rc1/2	40	27	400	55	88	37	7	-10°	0.8	DN**/FNGA1504...
T50W-PDUNR15C	Reinforced	63	Rc1/2	50	35	450	65	63	47	10	-8°	0.8	DN**/FNGA1504...

**RE : Standard corner radius

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

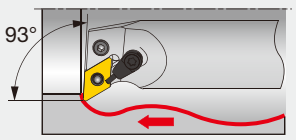
SPARE PARTS

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

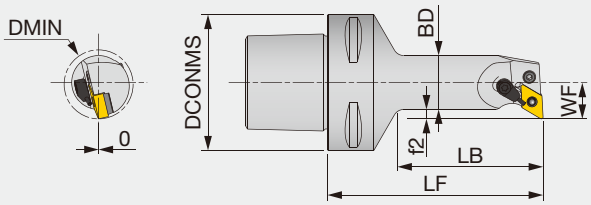
TUNGCAP

C-PDUNL-CHP

Lever-lock boring bar with TungCap connection, with 93° approach angle, for negative 55°/45° rhombic inserts, with high pressure coolant capability



Cutting edge style **U**



Left hand (L) shown.

Designation	DMIN	DCONMS	BD	LF	LB	WF	f2	RE**	Insert
C6PDUNL17100-1104-CHP	32	63	25	100	67.5	17	4.5	0.8	DN**/FNMG1104...

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	B004			

M

Application	Finishing	Medium cutting	Medium to heavy cutting
Grade	T6215	AH6225	AH6225
Chipbreaker shape	SF	SM	SH
Cutting conditions	B006		

K

Application	Finishing	Medium cutting	Medium to heavy cutting
Grade	T515	T515	T515
Breaker Shape	All-round	All-round	All-round
Cutting conditions	B008		

N

Application	Precision finishing	Finishing	Medium cutting
Grade	DX120	DX140	TH10
Breaker Shape	DIA with rake	DIA	P
Cutting conditions	B010		

S

Application	Precision finishing	Finishing	Medium cutting
Grade	BX470	AH8005	AH8005
Breaker Shape	CBN	HRF	HRM
Cutting conditions	B012		

H

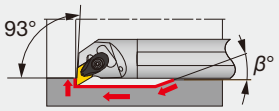
Application	Precision finishing	Finishing
Grade	BXA10	BXA20
Breaker Shape	HP	HS
Cutting conditions	B014	

Reference pages: T-PDUNR, C-PDUNL-CHP: Insert → B066 -, B075, CBN → B172 -, PCD → B211

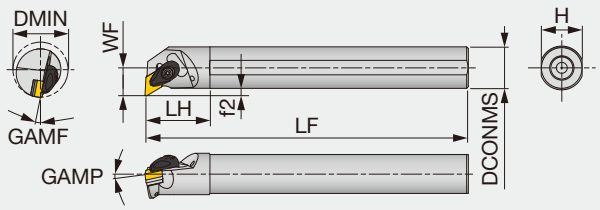
TURNINGA

A-ADUNR/L

Double-clamp boring bar, for negative 55°/45° rhombic inserts



Cutting edge style **U**



Right hand (R) shown.

Designation	Material	DMIN	DCONMS	WF	LF	LH	H	f2	GAMP	GAMF	β°	RE**	Insert	Torque*
A25R-ADUNR/L1104-D320	Steel	32	25	17	200	45	23	4.5	-6°	-13°	20	0.8	DN**/FNMG1104...	3
A32S-ADUNR/L1104-D400	Steel	40	32	22	250	50	30	6	-6°	-11°	20	0.8	DN**/FNMG1104...	3
A25R-ADUNR/L15-D320	Steel	32	25	17	200	45	23	4.5	-6°	-13°	30	0.8	DN**/FNGA1504...	3
A32S-ADUNR/L15-D400	Steel	40	32	22	250	50	30	6	-6°	-11°	20	0.8	DN**/FNGA1504...	3
A40T-ADUNR15-D500	Steel	50	40	27	300	55	37	7	-6°	-8°	15	0.8	DN**/FNGA1504...	3
A50U-ADUNR15-D630	Steel	63	50	35	350	65	47	10	-6°	-7°	15	0.8	DN**/FNGA1504...	3
A25R-ADUNR/L1506-D320	Steel	32	25	17	200	45	23	4.5	-6°	-13°	15	0.8	DN**/FNGA1506...	3
A32S-ADUNR/L1506-D400	Steel	40	32	22	250	50	30	6	-6°	-11°	20	0.8	DN**/FNGA1506...	3

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

SPARE PARTS

Designation	Clamp	Clamp screw	Spring	Spring pin	Shim	Shim screw	Wrench
A**-ADUNR/L1104-D...	ACP3S-E	ACS-5W	BP-7	SP-2.5	ASD322	CSTB-3.5	T-15F
A**-ADUNR/L15-D...	ACP4S	ACS-5W	BP-7	SP-2.5	ASD432	CSTB-3.5	T-15F
A**-ADUNR/L1506-D...	ACP4S	ACS-5W	BP-7	SP-2.5	ASD423	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	B004			

M

Application	Finishing	Medium cutting	Medium to heavy cutting
Grade	T6215	AH6225	AH6225
Chipbreaker shape	SF	SM	SH
Cutting conditions	B006		

K

Application	Finishing	Medium cutting	Medium to heavy cutting
Grade	T515	T515	T515
Breaker Shape	All-round	All-round	All-round
Cutting conditions	B008		

N

Application	Precision finishing	Finishing	Medium cutting
Grade	DX120	DX140	TH10
Breaker Shape	DIA with rake	DIA	P
Cutting conditions	B010		

S

Application	Precision finishing	Finishing	Medium cutting
Grade	BX470	AH8005	AH8005
Breaker Shape	CBN	HRF	HRM
Cutting conditions	B012		

H

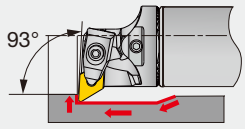
Application	Precision finishing	Finishing
Grade	BXA10	BXA20
Breaker Shape	HP	HS
Cutting conditions	B014	

Reference pages: A-ADUNR/L: Insert → B066 -, B075, CBN → B172 -, PCD → B211

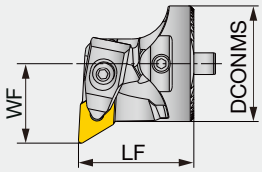
BOREMEISTER

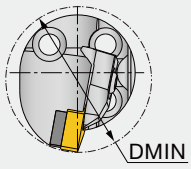
S-DDUNR/L-H

Double-clamp exchangeable boring head, for negative 55°/45° rhombic inserts



Cutting edge style **U**





Right hand (R) shown.

Designation	DMIN	DCONMS	WF	LF	Shank size	Insert
S32-DDUNR/L11T-H	40	32	22	32	D32	DN**/FNMG1104...
S40-DDUNR/L15T-H(1)	50	40	27	38	D40, D50, D60	DN**/FNGA1506(04)...

Note: 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).
(1) DN**/FNGA1504... inserts require a separate shim (# RDT443).

SPARE PARTS

Designation	Shim 1	Shim 2 (Optional)	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	(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	B004			

M

Application	Finishing	Medium cutting	Medium to heavy cutting
Grade	T6215	AH6225	AH6225
Chipbreaker shape	SF	SM	SH
Cutting conditions	B006		

K

Application	Finishing	Medium cutting	Medium to heavy cutting
Grade	T515	T515	T515
Breaker Shape	All-round	All-round	All-round
Cutting conditions	B008		

N

Application	Precision finishing	Finishing	Medium cutting
Grade	DX120	DX140	TH10
Breaker Shape	T-DIA	with rake T-DIA	P
Cutting conditions	B010		

S

Application	Precision finishing	Finishing	Medium cutting
Grade	BX470	AH8005	AH8005
Breaker Shape	CBN	HRF	HRM
Cutting conditions	B012		

H

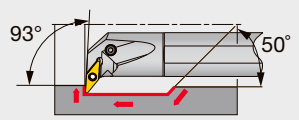
Application	Precision finishing	Finishing
Grade	BXA10	BXA20
Breaker Shape	HP	HS
Cutting conditions	B014	

Reference pages: S-DDUNR/L-H: Insert → B066 -, B075, CBN → B172 -, PCD → B211
Shank → D090 - D092

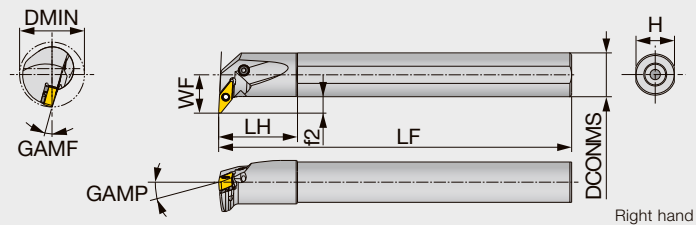
STREAMJETBAR

A-PVUNR/L

Lever-lock boring bar, for negative 35°/25° rhombic inserts



Cutting edge style **U**



Right hand (R) shown.

Designation	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
A25R-PVUNR/L16-D370	Steel	37	25	22	200	45	23	9.5	-5°	-14°	0.8	VN**/YN**1604...	2.7
A32S-PVUNR/L16-D400	Steel	40	32	22	250	50	30	6	-5°	-12°	0.8	VN**/YN**1604...	2.7
A40T-PVUNR/L16-D500	Steel	50	40	27	300	60	37	7	-5°	-10°	0.8	VN**/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/L1204-D...	LSV212	LCS3V	P-2.5	LSP3	LCL3V	EA-25	SSHM4-5
A32S-PVUNR/L1204-D400	LSV212	LCS3V	P-2.5	LSP3	LCL3V	EA-32	SSHM4-5
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	B004		

M

Application	Finishing	Medium cutting
Grade	T6215	AH6225
Chipbreaker shape	SF	SM
Cutting conditions	B006	

K

Application	Finishing	Medium cutting	Medium to heavy cutting
Grade	T515	T515	T515
Breaker Shape	All-round	All-round	All-round
Cutting conditions	B008		

N

Application	Precision finishing
Grade	DX120
Breaker Shape	DIA with rake
Cutting conditions	B010

S

Application	Precision finishing	Finishing	Medium cutting
Grade	BX470	AH8005	AH8005
Breaker Shape	CBN	HRF	HRM
Cutting conditions	B012		

H

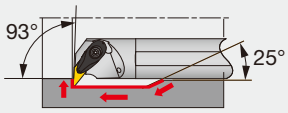
Application	Precision finishing	Finishing
Grade	BXA10	BXA20
Breaker Shape	HP	HS
Cutting conditions	B014	

Reference pages: A-PVUNR/L: Insert → B098 -, B110, CBN → B186 -, PCD → B188

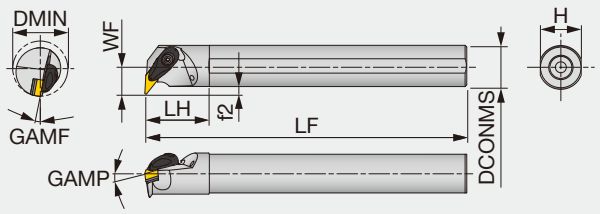
TURNING A

A-AVUNR/L

Double-clamp boring bar, for negative 35°/25° rhombic inserts



Cutting edge style **U**



Right hand (R) shown.

Designation	Material	DMIN	DCONMS	WF	LF	LH	H	f2	GAMP	GAMF	RE**	Insert	Torque*
A32S-AVUNR/L16-D400	Steel	40	32	22	250	50	30	6	-6°	-10°	0.8	VN**/YN**1604...	3
A40T-AVUNR/L16-D500	Steel	50	40	27	300	55	37	7	-6°	-8°	0.8	VN**/YN**1604...	3

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

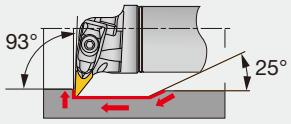
SPARE PARTS

Designation	Clamp	Clamp screw	Spring	Spring pin	Shim	Shim screw	Wrench
A**-AVUNR/L16-D...	ACP3L	ACS-5W	BP-7	SP-2.5	ASV322	CSTB-3.5	T-15F

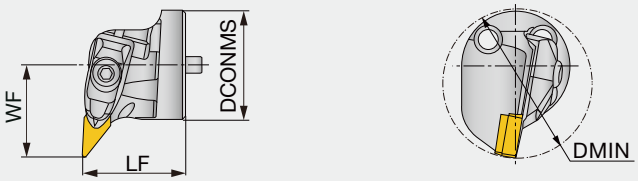
BOREMEISTER

S-DVUNR/L-H

Double-clamp exchangeable boring head, for negative 35° rhombic inserts



Cutting edge style **U**



Right hand (R) shown.

Designation	DMIN	DCONMS	WF	LF	Shank	Insert
S40-DVUNR/L16T-H	56	40	34	38	D40, D50, D60	VN**1604...

SPARE PARTS

Designation	Shim	Shim screw	Clamp	Clamp 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	B004		

M

Application	Finishing	Medium cutting
Grade	T6215	AH6225
Chipbreaker shape	SF	SM
Cutting conditions	B006	

K

Application	Finishing	Medium cutting	Medium to heavy cutting
Grade	T515	T515	T515
Breaker Shape	All-round	All-round	All-round
Cutting conditions	B008		

N

Application	Precision finishing
Grade	DX120
Breaker Shape	DIA with rake
Cutting conditions	B010

S

Application	Precision finishing	Finishing	Medium cutting
Grade	BX470	AH8005	AH8005
Breaker Shape	CBN	HRF	HRM
Cutting conditions	B012		

H

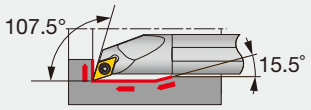
Application	Precision finishing	Finishing
Grade	BXA10	BXA20
Breaker Shape	HP	HS
Cutting conditions	B014	

Reference pages: A-AVUNR/L, S-DVUNR/L-H: Insert → B098 -, B110, CBN → B186 -, PCD → B192
Shank → D090 - D092

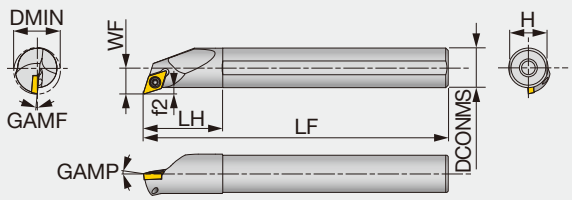
STREAMJETBAR

A/E-SDQCR/L

Screw-on boring bar, for positive 55° rhombic inserts



Cutting edge style **Q**



Right hand (R) shown.

Designation	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 (N·m)
**RE : Standard corner radius
Note: 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
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
Grade	SH725	SH725	NS9530	T9215
Breaker Shape	JP	JS	PSS	PS
Cutting conditions	B016			

M

Application	Precision finishing	Finishing		Finishing to medium cutting
Grade	SH725	SH725	AH6225	AH6225
Breaker Shape	JP	JS	PSS	PS
Cutting conditions	B018			

P

Application	Medium cutting
Grade	T9215
Breaker Shape	PM
Cutting conditions	B016

M

Application	Medium cutting
Grade	AH6225
Breaker Shape	PM
Cutting conditions	B018

K

Application	Finishing to medium cutting
Grade	T515
Breaker Shape	CM
Cutting conditions	B020

N

Application	Precision finishing	Finishing	Finishing to medium cutting
Grade	DX120	DX140	KS05F
Breaker Shape	DIA with rake		AL
Cutting conditions	B022		

S

Application	Precision finishing	Finishing	Finishing to medium cutting
Grade	BX470	AH8005	AH8015
Breaker Shape	CBN	PS	PS
Cutting conditions	B024		

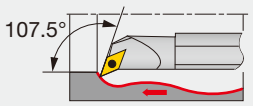
H

Application	Precision finishing	Finishing
Grade	BXA10	BXA20
Breaker Shape	HP	HS
Cutting conditions	B026	

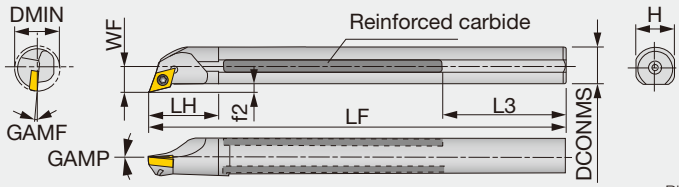
Reference pages: A/E-SDQCR/L: Insert → B121, CBN → B193 -, PCD → B214

T-SDQCR/L

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



Cutting edge style **Q**



Right hand (R) shown.

Designation	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
*The hole specification of applicable inserts conforms to ISO standard.
Note: 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	Precision finishing	Finishing		Finishing to medium cutting
Grade	SH725	SH725	NS9530	T9215
Breaker Shape	JP	JS	PSS	PS
Cutting conditions	B016			

M

Application	Precision finishing	Finishing		Finishing to medium cutting
Grade	SH725	SH725	AH6225	AH6225
Breaker Shape	JP	JS	PSS	PS
Cutting conditions	B018			

P

Application	Medium cutting
Grade	T9215
Breaker Shape	PM
Cutting conditions	B016

M

Application	Medium cutting
Grade	AH6225
Breaker Shape	PM
Cutting conditions	B018

K

Application	Finishing to medium cutting
Grade	T515
Breaker Shape	CM
Cutting conditions	B020

N

Application	Precision finishing	Finishing	Finishing to medium cutting
Grade	DX120	DX140	KS05F
Breaker Shape	DIA with rake		AL
Cutting conditions	B022		

S

Application	Precision finishing	Finishing	Finishing to medium cutting
Grade	BX470	AH8005	AH8015
Breaker Shape	CBN	PS	PS
Cutting conditions	B024		

H

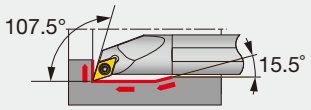
Application	Precision finishing	Finishing
Grade	BXA10	BXA20
Breaker Shape	HP	HS
Cutting conditions	B026	

Reference pages: T-SDQCR/L: Insert → B121, CBN → B193 -, PCD → B214

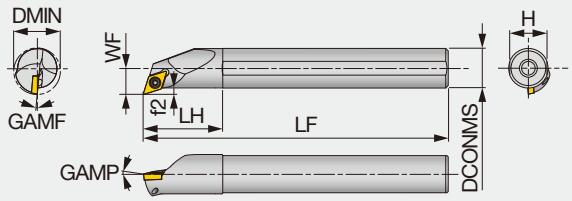
STREAMJETBAR

A/E-SDQPR/L

Screw-on boring bar, for positive 55° rhombic inserts



Cutting edge style **Q**



Right hand (R) shown.

Designation	Material	DMIN	DCONMS	WF	LF	LH	H	f2	GAMP	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

*Torque: Recommended clamping torque (N·m)
**RE : Standard corner radius
Note: 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	Finishing to medium cutting
Grade	NS9530	T9215
Breaker Shape	PS	PS
Cutting conditions	B016	

M

Application	Finishing	Finishing to medium cutting
Grade	AH6225	AH6225
Chipbreaker shape	PS	PS
Cutting conditions	B018	

K

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

S

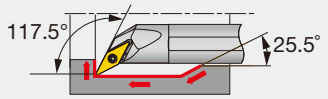
Application	Finishing	Finishing to medium cutting
Grade	AH8015	AH8015
Breaker Shape	PS	PS
Cutting conditions	B024	

Reference pages: A/E-SDQPR/L: Insert → B126

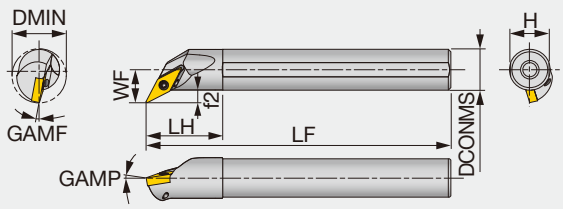
STREAMJETBAR

A/E-SVQBR/L

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



Cutting edge style **Q**



Right hand (R) shown.

Designation	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 (N·m)
**RE : Standard corner radius
Note: 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
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	Precision finishing	Finishing		Finishing to medium cutting
Grade	SH725	SH725	NS9530	T9215
Breaker Shape	JP	JS	PSS	PS
Cutting conditions	B014			

M

Application	Precision finishing	Finishing		Finishing to medium cutting
Grade	SH725	SH725	AH6225	AH6225
Chipbreaker shape	JP	JS	PSS	PS
Cutting conditions	B016			

P

Application	Medium cutting
Grade	T9215
Breaker Shape	PS
Cutting conditions	B014

M

Application	Medium cutting
Grade	AH6225
Chipbreaker shape	PS
Cutting conditions	B016

K

Application	Finishing to medium cutting
Grade	T515
Breaker Shape	CM
Cutting conditions	B020

S

Application	Finishing	Finishing to medium cutting
Grade	AH8005	AH8015
Breaker Shape	PS	PS
Cutting conditions	B024	

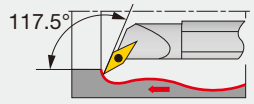
H

Application	Precision finishing	Finishing
Grade	BXA10	BXA20
Breaker Shape	HP	HS
Cutting conditions	B026	

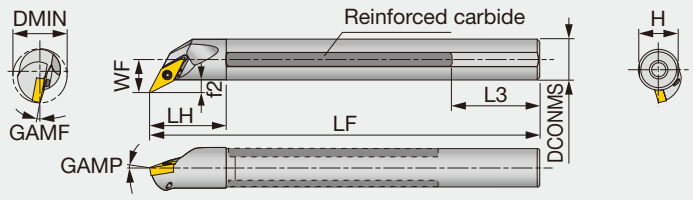
Reference pages: A/E-SVQBR/L: Insert → B150 -, CBN → B207 -

T-SVQBR

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



Cutting edge style **Q**



Right hand (R) shown.

Designation	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
*The hole specification of applicable inserts conforms to ISO standard.
Note: 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	Precision finishing	Finishing		Finishing to medium cutting
Grade	SH725	SH725	NS9530	T9215
Breaker Shape	JP	JS	PSS	PS
Cutting conditions	B014			

M

Application	Precision finishing	Finishing		Finishing to medium cutting
Grade	SH725	SH725	AH6225	AH6225
Chipbreaker shape	JP	JS	PSS	PS
Cutting conditions	B016			

P

Application	Medium cutting
Grade	T9215
Breaker Shape	PS
Cutting conditions	B014

M

Application	Medium cutting
Grade	AH6225
Chipbreaker shape	PS
Cutting conditions	B016

K

Application	Finishing to medium cutting
Grade	T515
Breaker Shape	CM
Cutting conditions	B020

S

Application	Finishing	Finishing to medium cutting
Grade	AH8005	AH8015
Breaker Shape	PS	PS
Cutting conditions	B024	

H

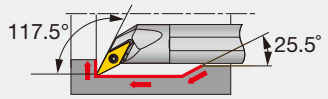
Application	Precision finishing	Finishing
Grade	BXA10	BXA20
Breaker Shape	HP	HS
Cutting conditions	B026	

Reference pages: T-SVQBR: Insert → B150 -, CBN → B207 -

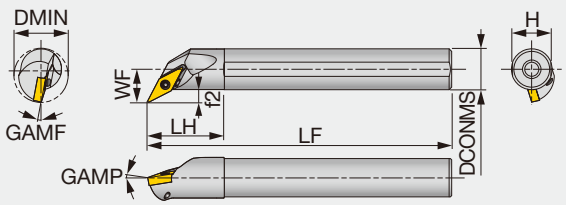
STREAMJETBAR

A/E-SVQCR/L

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



Cutting edge style **Q**



Right hand (R) shown.

Designation	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 (N·m)
**RE : Standard corner radius
Note: 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
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	Finishing to medium cutting
Grade	NS9530	T9215
Breaker Shape	PSS	PS
Cutting conditions	B016	

M

Application	Finishing	Finishing to medium cutting
Grade	AH6225	AH6225
Chipbreaker shape	PSS	PS
Cutting conditions	B018	

K

Application	Finishing to medium cutting
Grade	T515
Breaker Shape	CM
Cutting conditions	B020

N

Application	Precision finishing	Finishing	Medium cutting
Grade	DX120	DX140	KS05F
Breaker Shape	DIA with rake	DIA	AL
Cutting conditions	B022		

S

Application	Finishing	Finishing to medium cutting
Grade	AH8005	AH8015
Breaker Shape	PS	PS
Cutting conditions	B024	

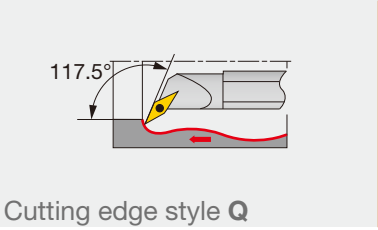
H

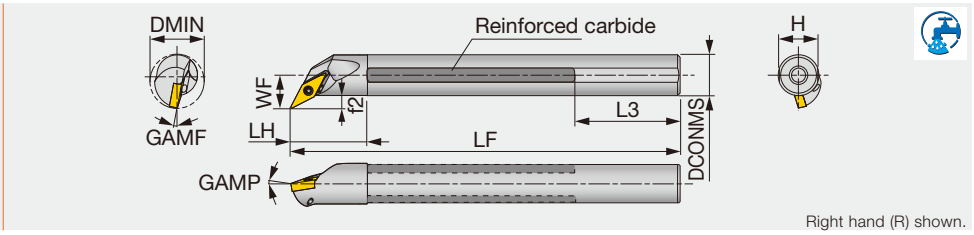
Application	Precision finishing	Finishing
Grade	BXA10	BXA20
Breaker Shape	CBN	CBN
Cutting conditions	B026	

Reference pages: A/E-SVQCR/L: Insert → B152 -, CBN → B209, PCD → B220

T-SVQCR

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





Designation	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	4.5	0°	-5°	0.8	VC**1604...	3

*Torque: Recommended clamping torque (N·m)
**RE : Standard corner radius
*The hole specification of applicable inserts conforms to ISO standard.
Note: 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	B016	

M

Application	Finishing	Finishing to medium cutting
Grade	AH6225	AH6225
Chipbreaker shape	PSS	PS
Cutting conditions	B018	

K

Application	Finishing to medium cutting
Grade	T515
Breaker Shape	CM
Cutting conditions	B020

N

Application	Precision finishing	Finishing	Medium cutting
Grade	DX120	DX140	KS05F
Breaker Shape	DIA with rake	DIA	AL
Cutting conditions	B022		

S

Application	Finishing	Finishing to medium cutting
Grade	AH8005	AH8015
Breaker Shape	PS	PS
Cutting conditions	B024	

H

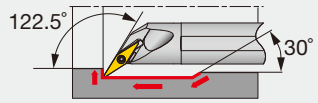
Application	Precision finishing	Finishing
Grade	BXA10	BXA20
Breaker Shape	CBN	CBN
Cutting conditions	B026	

Reference pages: T-SVQCR: Insert → B152 -, CBN → B209, PCD → B220

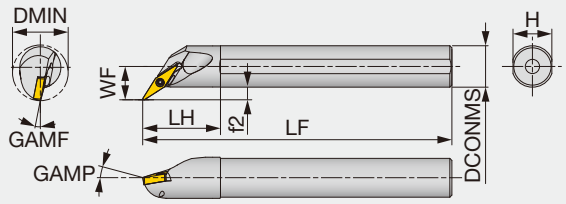
Y-PRO SERIES

A/E-SYQBR/L

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



Cutting edge style **Q**



Right hand (R) shown.

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

SPARE PARTS

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

INSERT SELECTION

P

Application	Finishing	Finishing to medium cutting	Medium cutting
Grade	GT9215	T9215	T9215
Breaker Shape	ZF	ZF	ZM
Cutting conditions	B016		

M

Application	Finishing	Finishing to medium cutting	Medium cutting
Grade	AH8015	AH8015	AH8015
Breaker Shape	ZF	ZF	ZM
Cutting conditions	B018		

K

Application	Finishing	Finishing to medium cutting	Medium cutting
Grade	GT9530	T9215	T9215
Breaker Shape	ZF	ZF	ZM
Cutting conditions	B020		

S

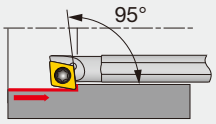
Application	Finishing	Finishing to medium cutting	Medium cutting
Grade	AH8015	AH8015	AH8015
Breaker Shape	ZF	ZF	ZM
Cutting conditions	B024		

Reference pages: A/E-SYQBR/L: Insert → B159

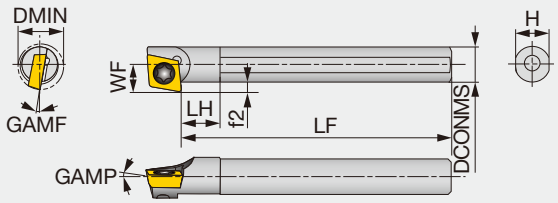
STREAMJETBAR

A/E-SEZPR/L

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



Cutting edge style **Z**



Right hand (R) shown.

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

*Torque: Recommended clamping torque (N·m)
**RE : Standard corner radius
Note: 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
Grade	SH725
Breaker Shape	JS
Cutting conditions	B016

M

Application	Finishing
Grade	SH725
Breaker Shape	JS
Cutting conditions	B018

K

Application	Finishing
Grade	SH725
Breaker Shape	JS
Cutting conditions	B020

S

Application	Finishing
Grade	SH725
Breaker Shape	JS
Cutting conditions	B024

N

Application	Precision finishing	Finishing
Grade	DX140	SH725
Breaker Shape	DIA	JS
Cutting conditions	B022	

H

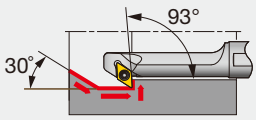
Application	Precision finishing
Grade	BX310
Breaker Shape	CBN
Cutting conditions	B026

Reference pages: A/E-SEZPR/L: Insert → B128 -, CBN → B195, PCD → B214

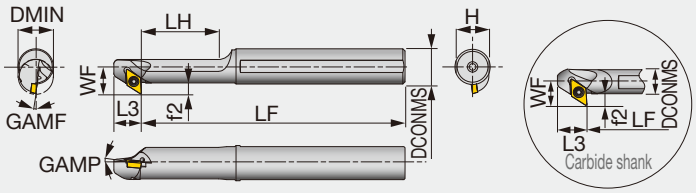
STREAMJETBAR

A/E-SDZCR/L

Screw-on boring bar, for positive 55° rhombic inserts



Cutting edge style **Z**



Right hand (R) shown.

Designation	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 (N·m)
**RE : Standard corner radius
Note: 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
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
Grade	SH725	SH725	NS9530	T9215
Breaker Shape	JP	JS	PSS	PS
Cutting conditions	B016			

M

Application	Precision finishing	Finishing		Finishing to medium cutting
Grade	SH725	SH725	AH6225	AH6225
Breaker Shape	JP	JS	PSS	PS
Cutting conditions	B018			

P

Application	Medium cutting
Grade	T9215
Breaker Shape	PM
Cutting conditions	B016

M

Application	Medium cutting
Grade	AH6225
Breaker Shape	PM
Cutting conditions	B018

K

Application	Finishing to medium cutting
Grade	T515
Breaker Shape	CM
Cutting conditions	B020

N

Application	Precision finishing	Finishing	Finishing to medium cutting
Grade	DX120	DX140	KS05F
Breaker Shape	DIA with rake		AL
Cutting conditions	B022		

S

Application	Precision finishing	Finishing	Finishing to medium cutting
Grade	BX470	AH8005	AH8015
Breaker Shape	CBN	PS	PS
Cutting conditions	B024		

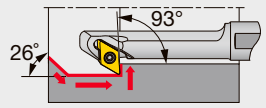
H

Application	Precision finishing	Finishing
Grade	BXA10	BXA20
Breaker Shape	HP	HS
Cutting conditions	B026	

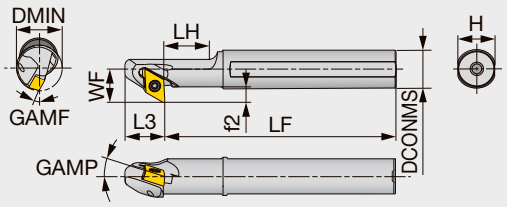
Reference pages: A/E-SDZCR/L: Insert → B121, CBN → B193 -, PCD → B214

A/E-SDZXR/L

Screw-on boring bar, for DXG/MU inserts



Cutting edge style **Z**



Right hand (R) shown.

Designation	Material	DMIN	DCONMS	WF	LF	LH	L3	H	f2	GAMP	GAMF	RE**	Insert	Torque*
A12M-SDZXR/L07-D140	Steel	14	12	10.5	150	30	13	11	4.5	-10°	-14°	0.4	DXG/MU0703**R/L...	0.9
A16Q-SDZXR/L07-D160	Steel	16	16	12.5	180	35	13	15	4.5	-10°	-12.5°	0.4	DXG/MU0703**R/L...	0.9
A20R-SDZXR/L07-D200	Steel	20	20	14.5	200	40	13	18	4.5	-10°	-10.5°	0.4	DXG/MU0703**R/L...	0.9
E12Q-SDZXR/L07-D180	Carbide	18	12	10.5	180	-	13	11	4.5	-11°	-11°	0.4	DXG/MU0703**R/L...	0.9
E16R-SDZXR/L07-D220	Carbide	22	16	12.5	200	-	13	15	4.5	-11°	-9°	0.4	DXG/MU0703**R/L...	0.9

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

Note: 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	Precision finishing	Finishing		Finishing to medium cutting
Grade	SH725	SH725	NS9530	T9215
Breaker Shape	JS	JTS	SS	TS
Cutting conditions	D096			

P

Application	Medium cutting
Grade	T9215
Breaker Shape	TS
Cutting conditions	D096

K

Application	Precision finishing	Finishing		Finishing to medium cutting
Grade	SH725	SH725	NS9530	T9215
Breaker Shape	JS	JTS	SS	TS
Cutting conditions	D096			

K

Application	Medium cutting
Grade	T9215
Breaker Shape	TS
Cutting conditions	D096

S

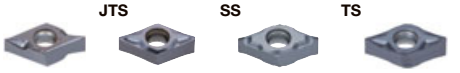
Application	Precision finishing	Finishing		Finishing to medium cutting
Grade	SH725	SH725	AH8015	AH8015
Breaker Shape	JS	JTS	SS	TS
Cutting conditions	D096			

S

Application	Medium cutting
Grade	AH8015
Breaker Shape	TS
Cutting conditions	D096

M

Application	Precision finishing	Finishing		Finishing to medium cutting
Grade	SH725	SH725	AH8015	AH8015
Chipbreaker shape	JS	JTS	SS	TS
Cutting conditions	D096			



M

Application	Medium cutting
Grade	AH8015
Chipbreaker shape	TS
Cutting conditions	D096

N

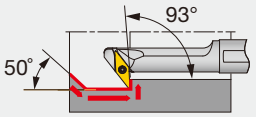
Application	Finishing	Finishing to medium cutting	Medium cutting
Grade	KS05F	KS05F	KS05F
Breaker Shape	SS	TS	TS
Cutting conditions	D096		

Reference pages: A/E-SDZXR/L: Insert → B126 -
Standard cutting conditions → D096

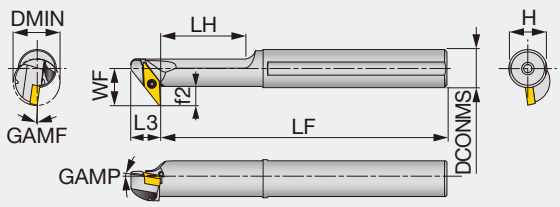
STREAMJETBAR

A-SVZBR/L

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



Cutting edge style **Z**



Right hand (R) shown.

Designation	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 (N·m)
**RE : Standard corner radius
Note: 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
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	Precision finishing	Finishing		Finishing to medium cutting
Grade	SH725	SH725	NS9530	T9215
Breaker Shape	JP	JS	PSS	PS
Cutting conditions	B014			

M

Application	Precision finishing	Finishing		Finishing to medium cutting
Grade	SH725	SH725	AH6225	AH6225
Chipbreaker shape	JP	JS	PSS	PS
Cutting conditions	B016			

P

Application	Medium cutting
Grade	T9215
Breaker Shape	PS
Cutting conditions	B014

M

Application	Medium cutting
Grade	AH6225
Chipbreaker shape	PS
Cutting conditions	B016

K

Application	Finishing to medium cutting
Grade	T515
Breaker Shape	CM
Cutting conditions	B020

S

Application	Finishing	Finishing to medium cutting
Grade	AH8005	AH8015
Breaker Shape	PS	PS
Cutting conditions	B024	

H

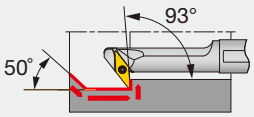
Application	Precision finishing	Finishing
Grade	BXA10	BXA20
Breaker Shape	HP	HS
Cutting conditions	B026	

Reference pages: A-SVZBR/L: Insert → B150 -, CBN → B207 -

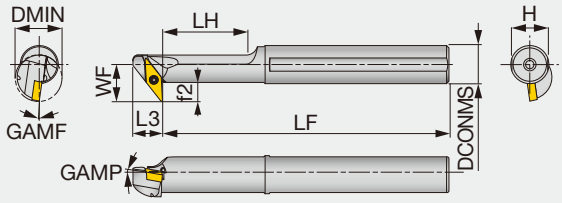
STREAMJETBAR

A-SVZCR/L

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



Cutting edge style **Z**



Right hand (R) shown.

Designation	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 (N·m)
**RE : Standard corner radius
Note: 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
A12M-SVZCR/L08-D160	CSTB-2L	T-6F

INSERT SELECTION

P

Application	Finishing	Finishing to medium cutting
Grade	NS9530	T9215
Breaker Shape	PSS	PS
Cutting conditions	B014	

M

Application	Finishing	Finishing to medium cutting
Grade	AH6225	AH6225
Chipbreaker shape	PSS	PS
Cutting conditions	B016	

K

Application	Finishing to medium cutting
Grade	T515
Breaker Shape	CM
Cutting conditions	B020

N

Application	Precision finishing	Finishing	Medium cutting
Grade	DX120	DX140	KS05F
Breaker Shape	DIA	with rake DIA	AL
Cutting conditions	B022		

S

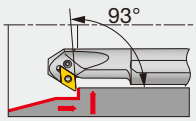
Application	Finishing	Finishing to medium cutting
Grade	AH8005	AH8015
Breaker Shape	PS	PS
Cutting conditions	B024	

H

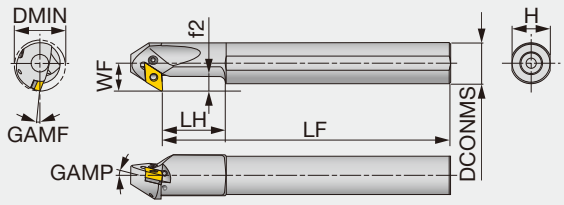
Application	Precision finishing	Finishing
Grade	BXA10	BXA20
Breaker Shape	CBN	CBN
Cutting conditions	B026	

A-PDZNR/L

Lever-lock boring bar, for negative 55°/45° rhombic inserts



Cutting edge style **Z**



Right hand (R) shown.

Designation	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**/FNGA1504...	4.8
A40T-PDZNR/L15-D500	Steel	50	40	27	300	60	37	14.5	-6°	-10°	0.8	DN**/FNGA1504...	4.8
A50U-PDZNR/L15-D630	Steel	63	50	35	350	65	47	14.5	-6°	-8°	0.8	DN**/FNGA1504...	4.8

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

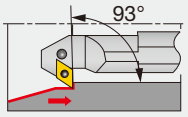
*Optional

Reference pages: A-SVZCR/L: Insert → B152 -, CBN → B209, PCD → B220
A-PDZNR/L,: Insert → B066 -, B075, CBN → B172 -, PCD → B211

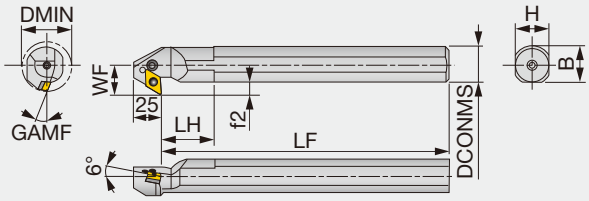
STREAMJETBAR

S-PDZNR/L

Lever-lock boring bar, for negative 55°/45° rhombic inserts



Cutting edge style **Z**



Right hand (R) shown.

Designation	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**/FNGA1504...
S40T-PDZNR15	Steel	50	40	27	300	35	37	7	37.5	-10°	0.8	DN**/FNGA1504...
S50U-PDZNR15	Steel	60	50	35	350	40	47	10	47.5	-8°	0.8	DN**/FNGA1504...

**RE : Standard corner radius

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

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

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	B004			

M

Application	Finishing	Medium cutting	Medium to heavy cutting
Grade	T6215	AH6225	AH6225
Chipbreaker shape	SF	SM	SH
Cutting conditions	B006		

K

Application	Finishing	Medium cutting	Medium to heavy cutting
Grade	T515	T515	T515
Breaker Shape	All-round	All-round	All-round
Cutting conditions	B008		

N

Application	Precision finishing	Finishing	Medium cutting
Grade	DX120	DX140	TH10
Breaker Shape	DIA with rake	DIA	P
Cutting conditions	B010		

S

Application	Precision finishing	Finishing	Medium cutting
Grade	BX470	AH8005	AH8005
Breaker Shape	CBN	HRF	HRM
Cutting conditions	B012		

H

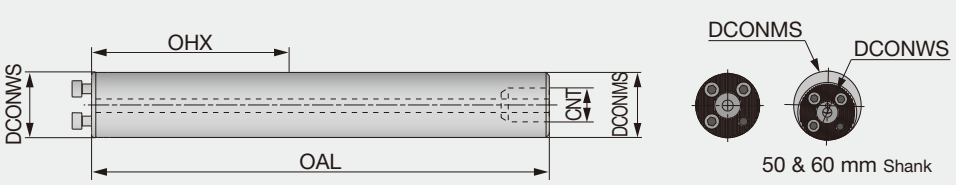
Application	Precision finishing	Finishing
Grade	BXA10	BXA20
Breaker Shape	HP	HS
Cutting conditions	B014	

Reference pages: S-PDZNR/L: Insert → B066 -, B075, CBN → B172 -, PCD → B211

BOREMEISTER

Anti-vibration bar

Anti-vibration bar for exchangeable turning heads, with through coolant



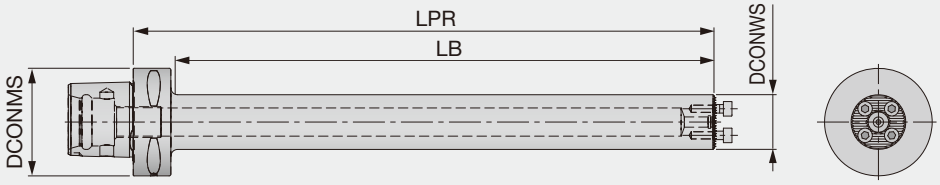
Designation	Material	DCONWS	DCONMS	OAL	OHX	CNT
D16-L156-7D-C	Steel	16	16	156.3	92	G1/8
G16-L204-10D-E	Carbide	16	16	204.3	140	-
D20-L200-7D-C	Steel	20	20	200.3	120	G1/4
G20-L260-10D-E	Carbide	20	20	260.3	180	-
D25-L255-7D-C	Steel	25	25	257.5	155	G1/4
D25-L330-10D-C	Steel	25	25	332.5	230	G1/4
D32-L320-7D-C	Steel	32	32	323	192	G3/8
D32-L416-10D-C	Steel	32	32	419	288	G3/8
D40-L408-7D-C	Steel	40	40	411	248	G1/2
D40-L528-10D-C	Steel	40	40	531	368	G1/2
D50-L518-7D-C	Steel	40	50	523	318	G1/2
D50-L668-10D-C	Steel	40	50	673	468	G1/2
D60-L628-7D-C	Steel	40	60	633	388	G3/4
D60-L808-10D-C	Steel	40	60	813	568	G3/4

SPARE PARTS

Designation	Clamping screw	Wrench
D16-L..., G16-L...	SRM3X10DIN912	HW2.5
D20-L..., G20-L...	SR55-2M3.5X10	HW2.5
D25-L...	SRM4X12DIN912	HW3.0
D32-L...	SRM5X12DIN912	HW4.0
D40-L..., D50-L... D60-L...	SRM6X16DIN912-12.9	HW5.0

C6-9D-C

PSC adapter with anti vibration, L/D = 9



Designation	Material	DCONWS	DCONMS	LPR	LB	WT (kg)
C6-D25-L230-9D-C	Steel	25	63	230.5	200.1	1.65
C6-D32-L288-9D-C	Steel	32	63	288.5	259.5	2.73
C6-D40-L368-9D-C	Steel	40	63	368.5	339	4.45

SPARE PARTS

Designation	Clamping screw	Wrench
C6-D25...	SRM4X12DIN912	HW3.0
C6-D32...	SRM5X12DIN912	HW4.0
C6-D40...	SRM6X16DIN912-12.9	HW5.0

BOREMEISTER

C#-SH-CHP / C#-SH-E-CHP

PSC compatible adapter with steel or carbide core

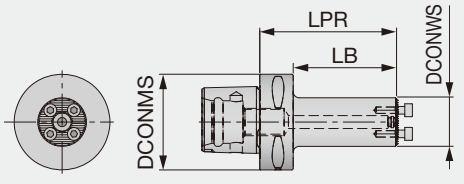


Fig. 1

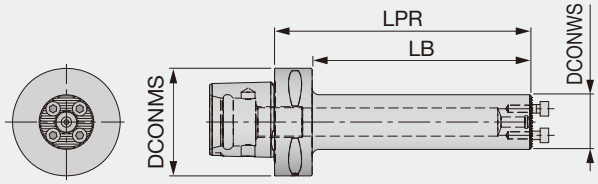


Fig. 2

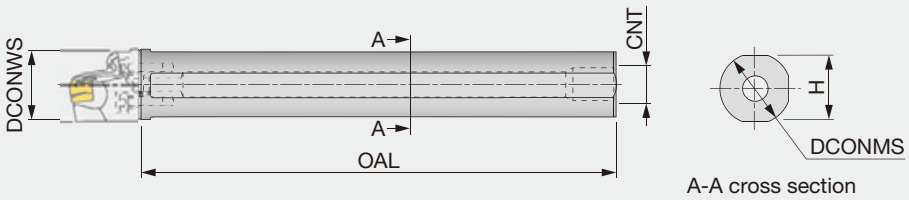
Designation	Material	DCONWS	DCONMS	LPR	LB	Fig
C4-SH-D16-2.5D-CHP	Steel	16	40	40	20	1
C4-SH-D20-2.5D-CHP	Steel	20	40	50	30	1
C4-SH-D25-2.5D-CHP	Steel	25	40	55	35	1
C4-SH-D32-2.5D-CHP	Steel	32	40	75	55	1
C4-SH-D40-3D-CHP	Steel	40	40	80	80	1
C6-SH-D20-5D-E-CHP	Carbide	20	63	100	78	2
C6-SH-D25-5D-E-CHP	Carbide	25	63	115	93	2
C6-SH-D32-5D-E-CHP	Carbide	32	63	150	128	2
C6-SH-D40-5D-E-CHP	Carbide	40	63	185	163	2

SPARE PARTS

Designation	Clamping screw	Wrench
C4**D16...	SRM3X10DIN912	HW2.5
C4/C6**D20...	SR55-2M3.5X10	HW2.5
C4/C6**D25...	SRM4X12DIN912	HW3.0
C4/C6**D32...	SRM5X12DIN912	HW4.0
C4/C6**D40...	SRM6X16DIN912-12.9	HW5.0

D#4D-SH

Steel shank for internal turning, with through coolant



Designation	Material	DCONWS	DCONMS	OAL	CNT	H
D16-L105-4D-SH	Steel	16	16	105	UNC-2B 3/8"-16	15
D20-L140-4D-SH	Steel	20	20	140	UNFC-2B 3/8"-24	18
D25-L200-4D-SH	Steel	25	25	200	UNF-2B 1/2"-20	23
D32-L218-4D-SH	Steel	32	32	218	UNF-2B 1/2"-20	29
D40-L283-4D-SH	Steel	40	40	283	UNF-2B 1/2"-20	36

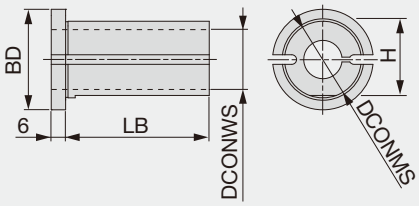
SPARE PARTS

Designation	Clamping screw	Wrench
D16**4D-SH	SRM3X10DIN912	HW2.5
D20**4D-SH	SR55-2M3.5X10	HW2.5
D25**4D-SH	SRM4X12DIN912	HW3.0
D32**4D-SH	SRM5X12DIN912	HW4.0
D40**4D-SH	SRM6X16DIN912-12.9	HW5.0

BOREMEISTER

RSL sleeve

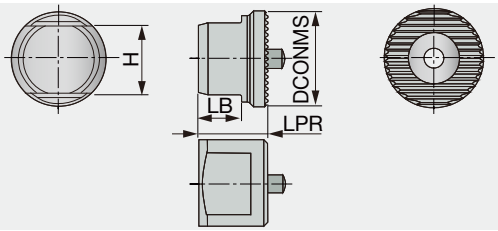
Split sleeve for anti-vibration bar



Designation	DCONWS	DCONMS	BD	LB	H
RSL-32-16-L66	16	32	42	60	31
RSL-32-20-L66	20	32	42	60	31
RSL-32-25-L66	25	32	42	60	31
RSL-40-16-L76	16	40	50	70	38.5
RSL-40-20-L76	20	40	50	70	38.5
RSL-40-25-L76	25	40	50	70	38.5

AVC-SET

Center height set up device

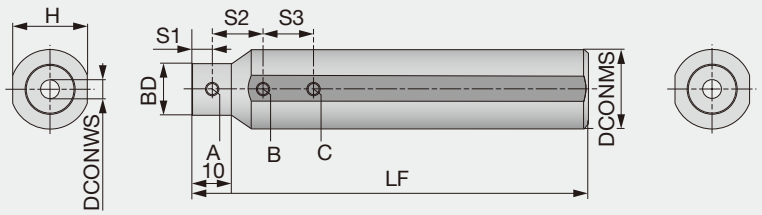


Designation	DCONMS	H	LPR	LB	Applicable shank
AVC-SET 16-25	20	15	14.5	8.9	16, 20, 25
AVC-SET 32-60	29	16	17.5	11.43	32, 40, 50, 60

STREAMJETBAR

BLM sleeve

Round shank sleeve for StreamJetBar-Mini series



Designation	DCONMS	DCONWS	BD	LF	H	S1	S2	S3
BLM159-04	15.875	4	15	100	15	5	15	15
BLM159-05	15.875	5	15	100	15	5	15	15
BLM159-06	15.875	6	15	100	15	5	20	20
BLM159-07	15.875	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	4	18	100	18	5	15	15
BLM19-05	19.05	5	18	100	18	5	15	15
BLM19-06	19.05	6	18	100	18	5	20	20
BLM19-07	19.05	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	4	13	125	24	5	15	15
BLM254-05	25.4	5	14	125	24	5	15	15
BLM254-06	25.4	6	15	125	24	5	20	20
BLM254-07	25.4	7	16	125	24	5	20	20

SPARE PARTS

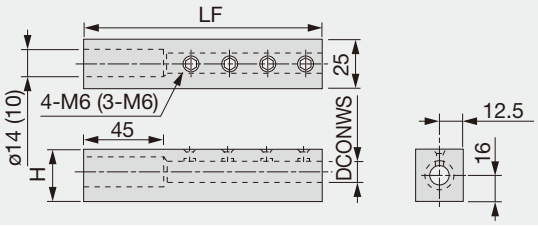
Designation	Clamping screw A	Clamping screw B, C	Wrench	Seal cap* (inner screw)
BLM159, 16...	SSHM4-4	SSHM4-4	P-2	CA-16(M6)
BLM19-04	SSHM4-4	SSHM4-6	P-2	CA-16(M6)
BLM19-05, 06, 07	SSHM4-4	SSHM4-4	P-2	CA-16(M6)
BLM20-04, 05	SSHM4-4	SSHM4-6	P-2	CA-16(M6)
BLM20-06, 07	SSHM4-4	SSHM4-4	P-2	CA-16(M6)
BLM22-...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

STREAMJETBAR

BLS sleeve

Square shank sleeve for boring bars (regular length)



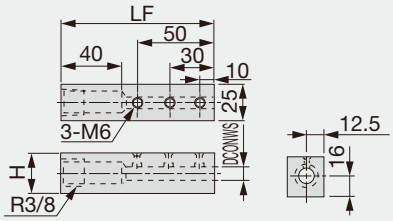
Designation	DCONWS	LF	H
BLS16-08	8	125	28
BLS16-10	10	125	28
BLS16-12	12	125	28

SPARE PARTS

Designation	Wrench
BLS16-...	P-3

BLS-C sleeve

Square shank sleeve for boring bars (short type)



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

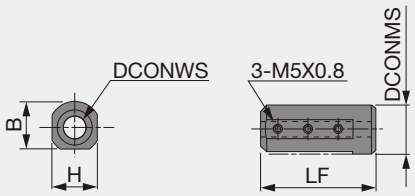
SPARE PARTS

Designation	Wrench
BLS16-**C	P-3

STREAMJETBAR

BLM sleeve

Round shank sleeve for boring bars



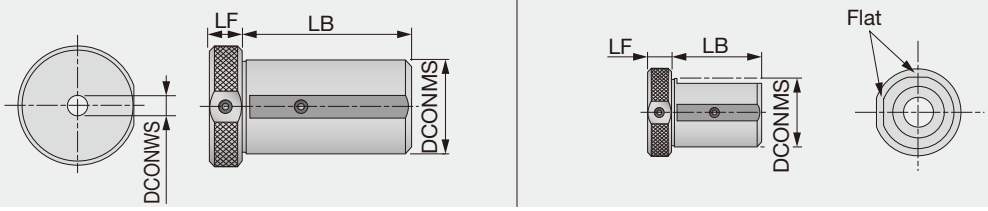
Designation	DCONWS	DCONMS	LF	H	B
BLM19-08	8	19.05	100	18	18
BLM20-08	8	20	100	18	19
BLM22-08	8	22	125	21	21
BLM254-08	8	25.4	125	24	24
BLM25-08C	8	25	55	23	24
BLM25-10C	10	25	55	23	24
BLM25-12C	12	25	55	23	24

SPARE PARTS

Designation	Wrench
BLM...	P-2.5

BLC sleeve

Round shank sleeve for boring bars



Designation	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 TURN

STANDARD CUTTING CONDITIONS

FOR INTERNAL TURNING

ISO	Workpiece material	Grade		Cutting speed *Vc* (m/min)	Depth of cut *ap* (mm)	Feed *f* (mm/rev)
		First choice	Second choice			
P	Low carbon steel / Low alloy steel	T9215	-	120 - 350	0.3 - 2	0.08 - 0.3
		T9225	-	100 - 300	0.3 - 2	0.08 - 0.3
		AH8015	-	50 - 200	0.3 - 2	0.08 - 0.3
		-	AH725	50 - 180	0.3 - 2	0.08 - 0.3
		-	NS9530	80 - 250	0.3 - 2	0.08 - 0.3
		-	GT9530	80 - 300	0.3 - 2	0.08 - 0.3
	Carbon steel / Alloy steel	T9215	-	80 - 350	0.3 - 2	0.08 - 0.3
		T9225	-	80 - 300	0.3 - 2	0.08 - 0.3
		AH8015	-	50 - 200	0.3 - 2	0.08 - 0.3
		-	AH725	50 - 180	0.3 - 2	0.08 - 0.3
		-	NS9530	80 - 250	0.3 - 2	0.08 - 0.3
		-	GT9530	80 - 300	0.3 - 2	0.08 - 0.3
M	Stainless steel (Austenitic)	AH8015	-	50 - 150	0.3 - 2	0.08 - 0.3
		-	AH725	50 - 150	0.3 - 2	0.08 - 0.3
		-	T9215	50 - 200	0.3 - 2	0.08 - 0.3
	Stainless steel (Martensitic and ferritic)	AH8015	-	50 - 150	0.3 - 2	0.08 - 0.3
		-	AH725	50 - 150	0.3 - 2	0.08 - 0.3
		-	T9215	50 - 200	0.3 - 2	0.08 - 0.3
	Stainless steel (Precipitation hardening)	AH8015	-	50 - 150	0.3 - 2	0.08 - 0.3
		-	AH725	50 - 150	0.3 - 2	0.08 - 0.3
		-	T9215	50 - 200	0.3 - 2	0.08 - 0.3
K	Grey cast iron	T9215	-	100 - 350	0.3 - 2	0.08 - 0.3
		T9225	-	100 - 350	0.3 - 2	0.08 - 0.3
		-	AH8015	50 - 200	0.3 - 2	0.08 - 0.3
		-	AH725	50 - 180	0.3 - 2	0.08 - 0.3
		-	NS9530	80 - 250	0.3 - 2	0.08 - 0.3
		-	GT9530	80 - 300	0.3 - 2	0.08 - 0.3
	Ductile cast iron	T9215	-	100 - 350	0.3 - 2	0.08 - 0.3
		T9225	-	100 - 350	0.3 - 2	0.08 - 0.3
		-	AH8015	50 - 200	0.3 - 2	0.08 - 0.3
		-	AH725	50 - 180	0.3 - 2	0.08 - 0.3
		-	NS9530	80 - 250	0.3 - 2	0.08 - 0.3
		-	GT9530	80 - 300	0.3 - 2	0.08 - 0.3
N	Aluminum alloys	KS05F	-	100 - 300	0.3 - 2	0.08 - 0.3
	Copper alloys	KS05F	-	100 - 300	0.3 - 2	0.08 - 0.3
S	Titanium alloys	AH8015	-	20 - 80	0.3 - 2	0.08 - 0.3
	Nickel-based alloys	AH8015	-	20 - 80	0.3 - 2	0.08 - 0.3
H	Hardened steel	BXA20	-	50 - 220	0.12 - 0.8	0.1 - 0.3
		-	BXA10	50 - 220	0.12 - 0.8	0.1 - 0.3

Reference pages: A/E-SCLXR/L → D021, S-SCLXR/L-H → D022
A/E-SWLXR/L → D023, S-SWLXR/L-H → D024
A/E-SDXXR/L → D036

TURNTEC

STANDARD CUTTING CONDITIONS

*Values in red are for facing.

LNMX1204

ISO	Workpiece material	Chip breaker	Grade	Cutting speed *Vc* (m/min)	Depth of cut: *ap* (mm) RE : 0.8	Depth of cut: *ap* (mm) RE : 1.2	Feed: *f* (mm/rev) RE : 0.8	Feed: *f* (mm/rev) RE : 1.2
P	Steels S45C, SCM415, etc. C45, 18CrMo4, etc.	TDR	T9115	120 - 250	0.5 - 5 0.5 - 2.2	0.8 - 5 0.8 - 2.2	0.15 - 0.6	0.25 - 0.8
		TDR	T9125	80 - 180	0.5 - 5 0.5 - 2.2	0.8 - 5 0.8 - 2.2	0.15 - 0.6	0.25 - 0.8
M	Stainless steels SUS304, SUS316, etc. X5CrNi18-9, X5CrNiMo17-12-2, etc.	TDR	T9115	100 - 180	0.5 - 5 0.5 - 2.2	0.8 - 5 0.8 - 2.2	0.15 - 0.6	0.25 - 0.8
		TDR	T9125	80 - 180	0.5 - 5 0.5 - 2.2	0.8 - 5 0.8 - 2.2	0.15 - 0.6	0.25 - 0.8

LNMX1606

ISO	Workpiece material	Chip breaker	Grade	Cutting speed *Vc* (m/min)	Depth of cut: *ap* (mm) RE : 0.8	Depth of cut: *ap* (mm) RE : 1.2	Depth of cut: *ap* (mm) RE : 1.6	Feed: *f* (mm/rev) RE : 0.8	Feed: *f* (mm/rev) RE : 1.2	Feed: *f* (mm/rev) RE : 1.6
P	Steels S45C, SCM415, etc. C45, 18CrMo4, etc.	TDR	T9115	120 - 250	0.5 - 5 0.5 - 3.2	0.8 - 6 0.8 - 3.2	1 - 8 1 - 3.2	0.15 - 0.6	0.25 - 0.8	0.3 - 1
		TDR	T9125	80 - 180	0.5 - 5 0.5 - 3.2	0.8 - 6 0.8 - 3.2	1 - 8 1 - 3.2	0.15 - 0.6	0.25 - 0.8	0.3 - 1
		TWR	T9115	120 - 250	1 - 8 1 - 3.2	0.8 - 6 0.8 - 3.2	-	0.15 - 0.6	0.25 - 0.8	-
		TWR	T9125	80 - 180	1 - 8 1 - 3.2	0.8 - 6 0.8 - 3.2	-	0.15 - 0.6	0.25 - 0.8	-
M	Stainless steels SUS304, SUS316, etc. X5CrNi18-9, X5CrNiMo17-12-2, etc.	TDR	T9115	100 - 180	0.5 - 5 0.5 - 3.2	0.8 - 6 0.8 - 3.2	1 - 8 1 - 3.2	0.15 - 0.6	0.25 - 0.8	0.3 - 1
		TDR	T9125	80 - 180	0.5 - 5 0.5 - 3.2	0.8 - 6 0.8 - 3.2	1 - 8 1 - 3.2	0.15 - 0.6	0.25 - 0.8	0.3 - 1
		MDR	T9115	100 - 150	1.5 - 6 0.5 - 3.2	1.5 - 7 0.8 - 3.2	-	0.1 - 0.5	0.15 - 0.7	-
		MDR	AH725	50 - 150	1.5 - 6 0.5 - 3.2	1.5 - 7 0.8 - 3.2	-	0.1 - 0.5	0.15 - 0.7	-
		TWR	T9115	100 - 180	0.5 - 5 0.5 - 3.2	0.8 - 6 0.8 - 3.2	-	0.15 - 0.6	0.25 - 0.8	-
		TWR	T9125	80 - 180	0.5 - 5 0.5 - 3.2	0.8 - 6 0.8 - 3.2	-	0.15 - 0.6	0.25 - 0.8	-

LNMX2410

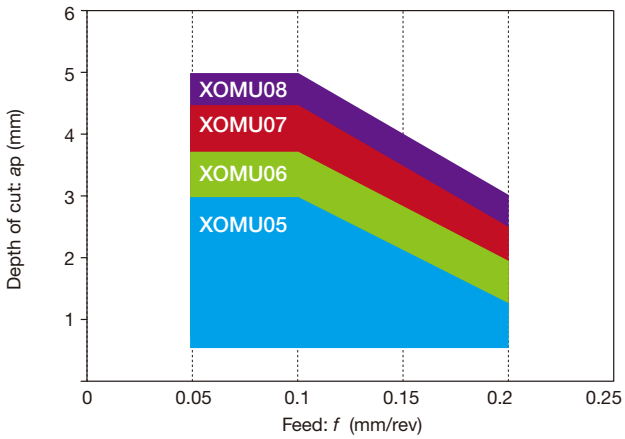
ISO	Workpiece material	Chip breaker	Grade	Cutting speed *Vc* (m/min)	Depth of cut: *ap* (mm) RE : 1.6	Depth of cut: *ap* (mm) RE : 2.4	Feed: *f* (mm/rev) RE : 1.6	Feed: *f* (mm/rev) RE : 2.4
P	Steels S45C, SCM415, etc. C45, 18CrMo4, etc.	TDR	T9115	120 - 250	4 - 15 1 - 4.5	5 - 15 1 - 4.5	0.3 - 1	0.3 - 1.1
		TDR	T9125	80 - 150	4 - 15 1 - 4.5	5 - 15 1 - 4.5	0.3 - 1	0.3 - 1.1
M	Stainless steels SUS304, SUS316, etc. X5CrNi18-9, X5CrNiMo17-12-2, etc.	TDR	T9115	100 - 180	4 - 15 1 - 4.5	5 - 15 1 - 4.5	0.3 - 1	0.3 - 1.1
		TDR	T9125	80 - 150	4 - 15 1 - 4.5	5 - 15 1 - 4.5	0.3 - 1	0.3 - 1.1

Reference pages: S-TLANR/L → D040

TUNGBORE MINI

STANDARD CUTTING CONDITIONS

DMIN	Description	Depth of cut ap (mm)	Feed f (mm/rev)	Cutting speed: Vc (m/min)	
	Insert			Carbon steel, Alloy steel	Stainless steel
ø10	XOMU05X204-PS	0.5 - 3	0.05 - 0.2	50 - 180 m/min	50 - 160 m/min
ø12	XOMU06H204-PS	0.5 - 3.5			
ø14	XOMU07H304-PS	0.5 - 4.5			
ø16	XOMU08T304-PS	0.5 - 5			



Reference pages: A/E-SXUOR/L → D065