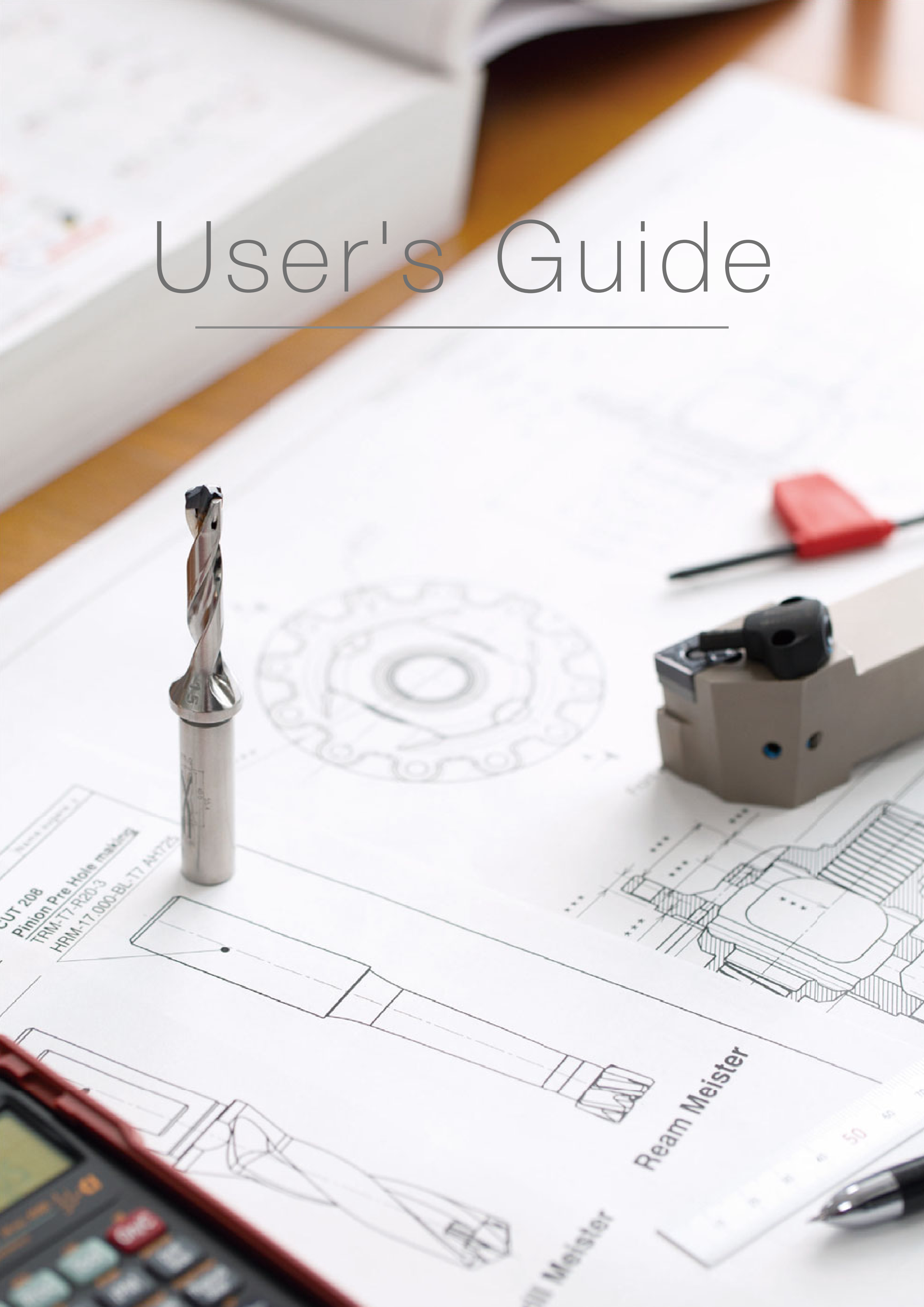
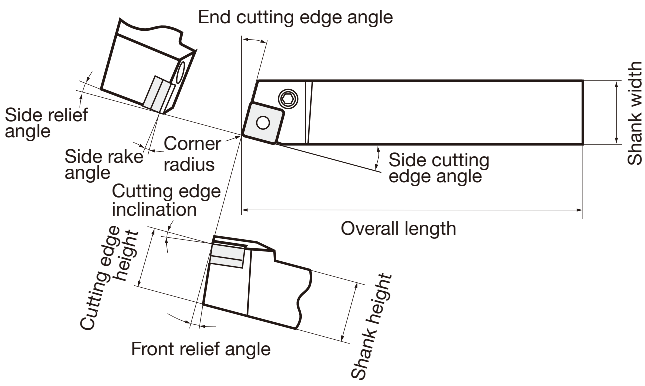
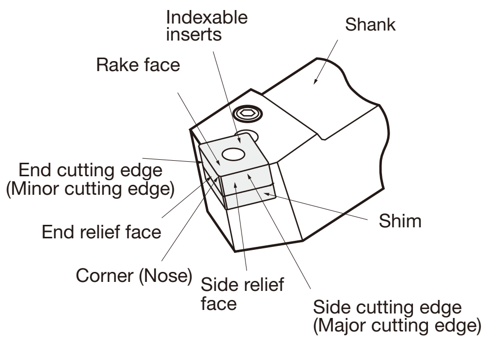
User's Guide

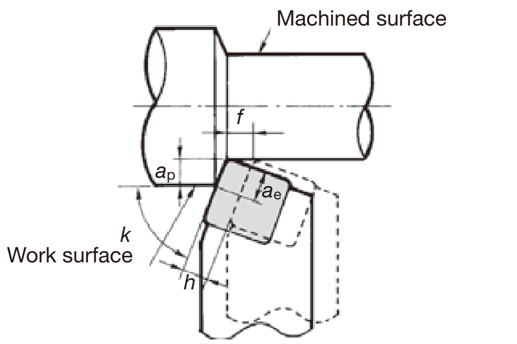

CUT 208
Pinion Pre Hole making
TRM-T17-R20-3
HRM-17.000-BL-T17 AH725
Ream Meister

Name of tools parts





Relating angles between tool and workpiece



a_p … Depth of cut (Distance between work surface and machined surface)

a_e … Length of cutting edge engaging in cutting.

k … Cutting edge angle (Angle to be made by cutting edge and work surface)

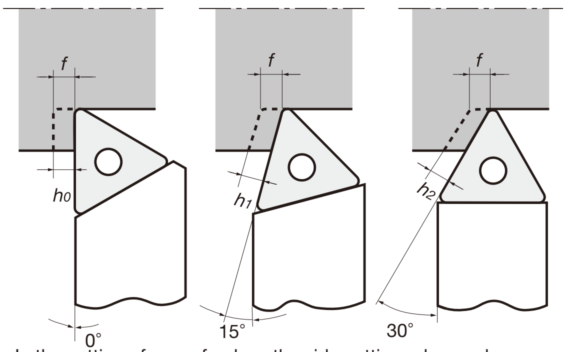
f … Feed per revolution

h … Thickness to be cut per revolution

Machined surface … Workpiece surface after having machined.

Work surface … Workpiece surface to be cut.

● Effect of side cutting edge angle



In the cutting of same feed, as the side cutting edge angle increases, the chip thickness decreases.

$h_0 > h_1 > h_2$

● Honing

TAC indexable inserts of steel cutting grades are honed. Honing specifications are shown in the following table.

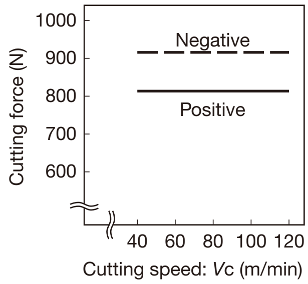
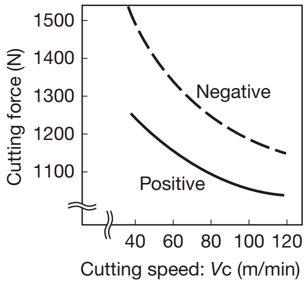
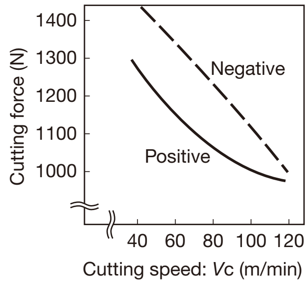
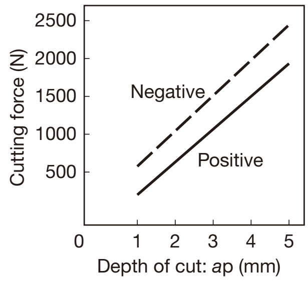
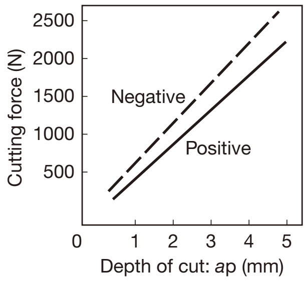
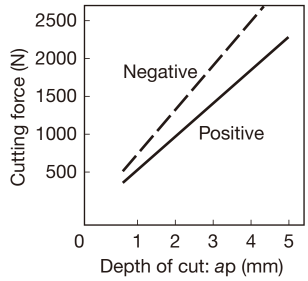
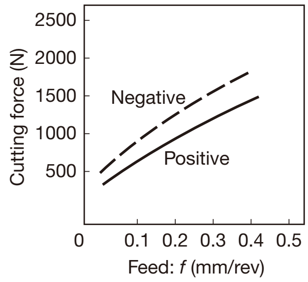
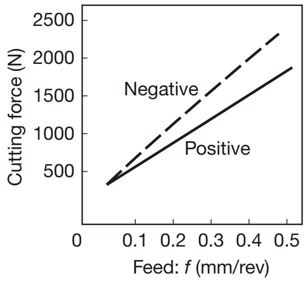
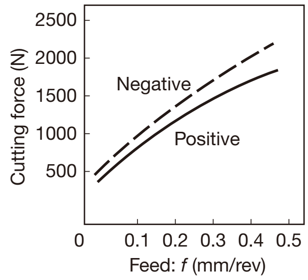
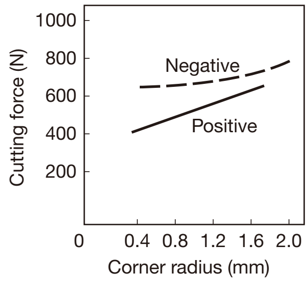
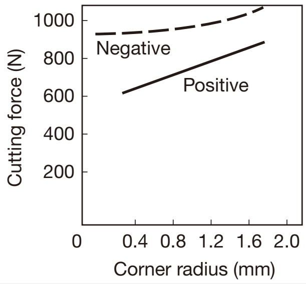
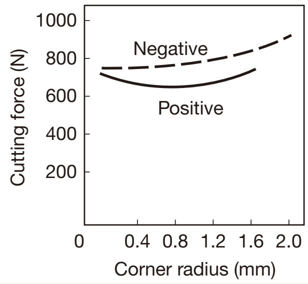
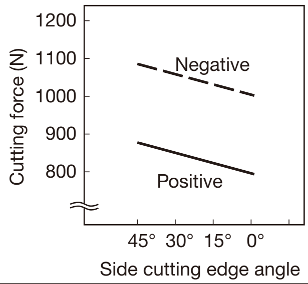
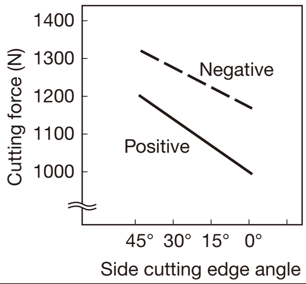
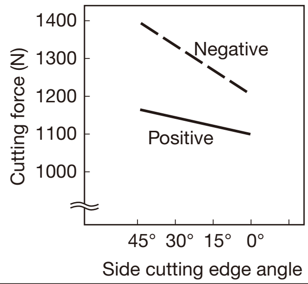
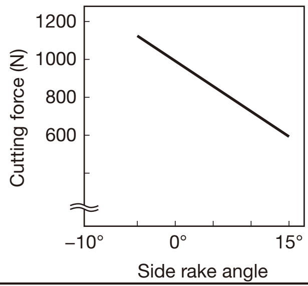
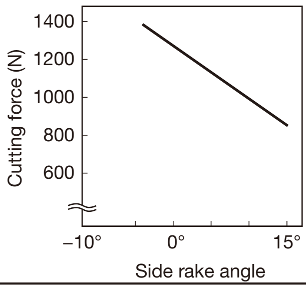
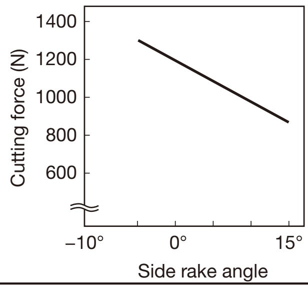
Edge condition	Shape
Sharp edge	
Round honing	
Chamfered honing	

● Effects of tool geometry on cutting phenomena

Phenomena / Increasing	Flank wear	Crater wear	Edge strength	Cutting force	Surface finish	Chattering	Cutting edge temperature	Chip shape and flow
Cutting edge inclination	–	Decrease	Lower	Radial force decrease	–	Less tendency	Lower	Effect on flow direction
Side rake angle	–	Decrease	Lower	Decrease	–	–	Lower	Effect on shape
Relief angle	Decrease	–	Lower	Decrease	–	Likely to occur	Lower	–
End cutting edge angle	Decrease	–	Lower	Radial force decrease	Roughen	Less tendency	Lower	–
Side cutting edge angle	Decrease	Decrease	Increase	Radial force decrease	–	Likely to occur	Increase	Decrease thickness
Nose radius	Decrease to some level		Increase	Increase	Improve	Likely to occur	Increase	Effect on flow direction
Honing width	Increase	–	Increase	Increase	–	Likely to occur	Increase	–

Turning Tools

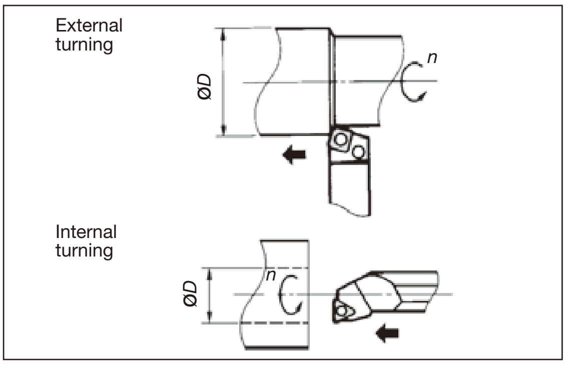
Relations between cutting force and cutting conditions or cutting phenomena

Condition	Grey cast iron (HB130)	Stainless steel (HB145)	Carbon steel (HB230)
Cutting speed and cutting force *f* = 0.2 mm/rev a_p = 2 mm Side cutting edge angle 0° Corner radius RE 0.4			
Depth of cut and cutting force V_c = 100 m/min *f* = 0.2 mm/rev Side cutting edge angle 0° Corner radius RE 0.4			
Feed and cutting force V_c = 100 m/min a_p = 2 mm Side cutting edge angle 0° Corner radius RE 0.4			
Corner radius and cutting force V_c = 100 m/min *f* = 0.2 mm/rev a_p = 1.2 mm Side cutting edge angle 0°			
Side cutting edge angle and cutting force V_c = 100 m/min *f* = 0.2 mm/rev a_p = 2 mm Corner radius RE 0.4			
Side rake angle and cutting force V_c = 100 m/min *f* = 0.2 mm/rev a_p = 2 mm Side cutting edge angle 0° Corner radius RE 0.2			

* 9.8N = 1kgf

Calculation formulas for turning

● Cutting speed



When calculating cutting speed from number of revolutions:

$$Vc = \frac{\pi \times øD \times n}{1000}$$

V_c : Cutting speed (m/min)
n : Number of revolution (min^{-1})
$øD$: Diameter of workpiece (mm)
$\pi \approx 3.14$

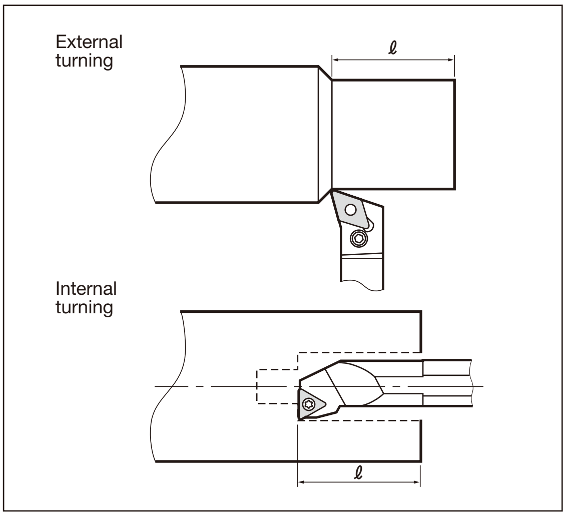
When calculating required number of revolutions from cutting speed:

$$n = \frac{Vc \times 1000}{\pi \times øD}$$

Example : Calculating the cutting speed when turning a ø150 mm-diameter workpiece at 250 min^{-1}

$$V_c = \frac{3.14 \times 150 \times 250}{1000} = 117 \text{ m/min}$$

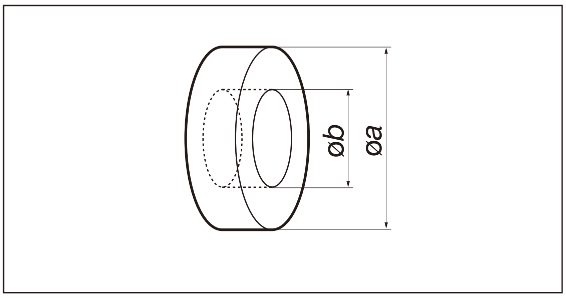
● Cutting time on external and internal turning



$$\underset{(min)}{T} = \frac{\ell}{f \times n}$$

T : Cutting time (min)
ℓ : Cutting length (mm)
f : Feed (mm/rev)
n : Number of revolution (min^{-1})

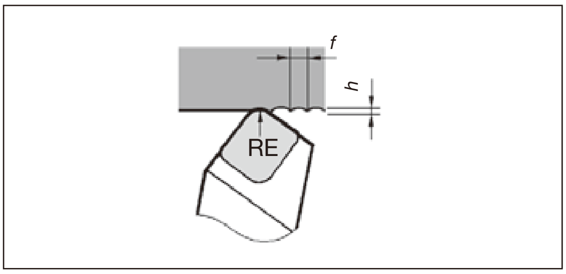
● Cutting time on face turning



$$\underset{(min)}{T} = \frac{\pi \times (øa^2 - øb^2)}{4000 \times v_c \times f}$$

V_c : Cutting speed (m/min)
f : Feed (mm/rev)
T : Cutting Time (min)

● Theoretical surface roughness



$$\underset{(\mu m)}{h} = \frac{f^2}{8 \times r} \times 1000$$

h : Surface roughness (µm)
f : Feed (mm/rev)
r : Nose radius (mm) 〔RE〕

〔 〕 The notation in the brackets is the one used in the catalog (ISO compliant)

● Power consumption

$$\underset{(kW)}{P_c} = \frac{F \times Vc}{60000}$$

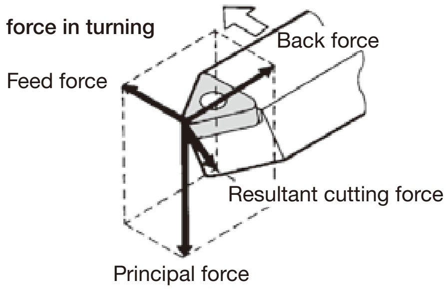
P_c : Power requirement (kW)
F : Cutting force (N)
V_c : Cutting speed (m/min)

Turning Tools

Cutting forces

(1) Finding from the diagram based on experimental data.
(2) In case determining by simplified equation:

Cutting force in turning



$$F = k_c \times a_p \times f$$
(N)

F : Cutting force (N)
k_c : Specific cutting force (N/mm^2) [Refer to the Table below]
a_p : Depth of cut (mm)
f : Feed (mm/rev)

Example :
Calculating the cutting force when cutting a high carbon steel (ISO C55) at f = 0.2 mm/rev and ap = 3 mm.
F = 3430 × 3 × 0.2 = 2058N

● Calculating power requirement

$$P_c = \frac{k_c \times a_p \times v_c \times f}{60 \times 1000}$$
(kW)

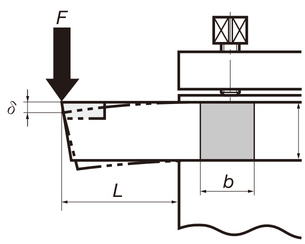
P_c : Net power requirement (kW)
k_c : Specific cutting force (N/mm^2) [Refer to the Table below]
v_c : Cutting speed (m/min)
a_p : Depth of cutting (mm)
f : Feed (mm/rev)

Value of specific cutting force (k_c)

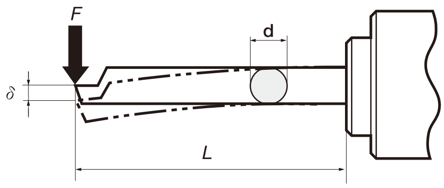
Workpiece material (JIS)	Tensile strength (MPa)	Hardness (HB)	Value of specific cutting force on feed k_c (N/mm²)				
			0.04 (mm/rev)	0.1 (mm/rev)	0.2 (mm/rev)	0.4 (mm/rev)	1.0 (mm/rev)
SS400, S15C	390	100	3430	2840	2450	2080	1700
S35C, S40C	590	170	4220	3490	2940	2500	2080
S50C, SCr430	785	230	4900	4020	3430	2940	2400
SCM440, SNCM439	980	300	5390	4410	3780	3240	2650
SDK	1765 (56HRC)	56HRC	8390	6870	5880	5000	4120
FC200	(160HB)	160	2550	1960	1630	1340	1030
FCD600	(200HB)	200	3330	2550	2110	1750	1340
Aluminium alloy	(89HB)	89	1350	1130	950	810	670
Aluminium			1050	870	740	640	520
Magnesium alloy			390	390	390	390	390
Brass			1080	1080	1080	1080	1080

● Bending stress and tool deflection

Square shank



Round shank



Bending stress

(1) Square shank

$$S = \frac{6 \times F \times L}{b \times h^2}$$
(MPa)

(2) Round shank

$$S = \frac{32 \times F \times L}{\pi \times d^3}$$
(MPa)

Tool deflection (mm)

(1) Square shank

$$\delta = \frac{4 \times F \times L^3}{E \times b \times h^3}$$
(mm)

(2) Round shank

$$\delta = \frac{64 \times F \times L^3}{3 \times \pi \times E \times d^4}$$
(mm)

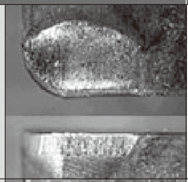
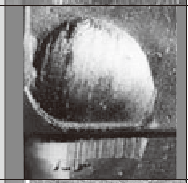
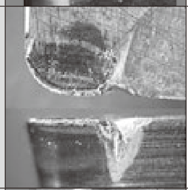
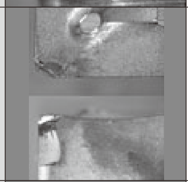
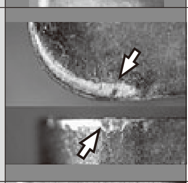
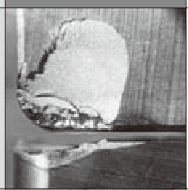
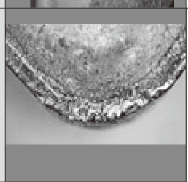
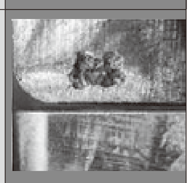
S : Bending stress in shank (MPa)
F : Cutting force (N)
L : Overhang length of tool (mm)
b : Shank width (mm): 〔B〕
h : Shank height (mm): 〔H〕
d : Shank diameter (mm): 〔DCONMS〕
E : Modulus of elasticity of shank material (MPa)

〔 〕 The notation in the brackets is the one used in the catalog (ISO compliant)

(Ref.) Values of E

Material	MPa (N/mm^2)	{kgf/mm^2}
Steel	210,000	21,000
Cemented Carbide	560,000~620,000	56,000~62,000

Troubleshooting in turning

Typical tool failure		Countermeasure		
		Tool grade	Cutting conditions	
Flank wear		• Change to more wear resistant grades **P, M, K30 → 20 → 10**	• Reduce cutting speed • Change to appropriate feed • Change to wet cutting	• Decrease honing width • Increase relief angle • Increase end cutting edge angle • Increase corner radius • Select free-cutting chipbreaker • Increase rake angle
Crater wear		• Change to more wear resistant grades **P, M, K30 → 20 → 10**	• Reduce cutting speed • Reduce feed • Reduce depth of cut • Change to wet cutting	• Increase rake angle • Select an appropriate chipbreaker • Increase side cutting edge angle • Increase corner radius
Notch wear		• Change to more wear resistant grades **P, M, K30 → 20 → 10**	• Reduce cutting speed • Reduce feed	• Increase rake angle • Increase side cutting edge angle
Fracture		• Change to tougher grades • Change to thermal-shock resistant grades **P, M, K10 → 20 → 30**	• Reduce feed • Reduce depth of cut • Improve holding rigidity of work and tool • Reduce overhang length of toolholder • Improve looseness in machine	• Reduce rake angle • Select a chipbreaker with high edge strength • Increase honing width • Increase side cutting edge angle • Select larger shank size • Increase corner radius
Chipping		• Change to tougher grades **P, M, K10 → 20 → 30**	• Reduce cutting speed • Reduce feed • Reduce depth of cut • Improve holding rigidity of work and tool • Reduce overhang length of toolholder • Improve looseness in machine	• Reduce rake angle • Select a chipbreaker with high edge strength • Increase honing width • Increase side cutting edge angle • Select larger shank size
Flaking		• Change to tougher grades **P, M, K10 → 20 → 30**	• Reduce cutting speed • Reduce feed	• Reduce rake angle • Increase corner radius • Increase honing width
Plastic deformation		• Change to more wear resistant grade **P, M, K30 → 20 → 10**	• Reduce cutting speed • Change to appropriate feed • Reduce depth of cut • Supply cutting fluid in adequate volume	• Increase relief angle • Increase rake angle • Reduce corner radius • Reduce side cutting edge angle • Select a free-cutting chipbreaker
Chip welding Built-up edge	 	• Use a grade which has a low tendency to adhere to workpiece material **Cemented carbide → Coated carbide or cermet**	• Increase cutting speed • Increase feed • Change to water-insoluble cutting fluid • Change to wet cutting	• Increase rake angle • Select a free-cutting chipbreaker • Decrease honing width
Thermal cracking		• Change to tougher grades • Change to thermal-shock resistant grades **P, M, K10 → 20 → 30**	• Reduce cutting speed • Reduce feed • Change to dry cutting • Supply cutting fluid in adequate volume • Reduce depth of cut • Change to water-insoluble cutting fluid	• Increase rake angle • Select a free-cutting chipbreaker • Decrease honing width

Turning Tools

Troubleshooting in turning

Problem	Cause	Countermeasure: Tool	Countermeasure: Cutting conditions and others
Deteriorated surface roughness	• Increased tool wear	• Select a more wear resistant grade • Use an insert with a larger rake angle • Select a freer-cutting chipbreaker type • Use an insert with a larger nose radius • Use a more lightly honed insert • Use an insert of closer tolerance (from M class to G class)	• Select a proper feed • Decrease the cutting speed • Use a cutting fluid
	• Edge chipping	• Use a tougher grade • Select a chipbreaker with strong cutting edges • Use a largely honed insert • Increase the side cutting edge angle • Use a larger shank size	• Decrease the depth of cut • Decrease the feed • Use a more rigid machine • Improve the holding rigidity of the tool and workpiece • Shorten the overhang of the toolholder • Improve the machine looseness
	• Chip welding • Built-up-edge	• Select a grade with less affinity with the Work-piece material • Use an insert with a larger rake angle • Select a freer-cutting chipbreaker type • Use a more lightly honed insert • Use an insert of closer tolerance (from M class to G class)	• Increase the cutting speed • Increase the feed • Use a water-insoluble cutting fluid • Use a cutting fluid
	• Vibration and chatter	• Use a tougher grade • Use an insert with a larger rake angle • Select a freer-cutting chipbreaker type • Use an insert with a smaller nose radius • Decrease the side cutting edge angle • Use a more lightly honed insert • Use a larger shank size	• Use a proper cutting speed • Decrease the feed • Decrease the depth of cut • Improve the holding rigidity of the tool and workpiece • Shorten the overhang of the toolholder • Improve the machine looseness
Deteriorated dimensional accuracy	• Improper insert accuracy	• Use an insert of closer tolerance (from M class to G class)	
	• Incomplete engagement of tool and workpiece	• Use an insert with a larger rake angle • Select a freer-cutting chipbreaker type • Use an insert with a smaller nose radius • Use a more lightly honed insert	• Improve the holding rigidity of the tool and workpiece • Shorten the overhang of the toolholder • Improve the machine looseness
Burr occurrence	• Unsuitable cutting speed		• Decrease the cutting speed • Increase the feed • Use a cutting fluid
	• Worn tool or improper cutting edge geometry	• Use a harder grade • Use an insert with a larger rake angle • Select a freer-cutting chipbreaker type • Increase the relief angle • Use an insert with a smaller nose radius • Decrease the side cutting edge angle • Use a more lightly honed insert	
Edge breakout	• Improper cutting speed		• Decrease the feed • Decrease the depth of cut
	• Worn tool or improper cutting edge geometry	• Use a harder grade • Use an insert with a larger rake angle • Select a freer-cutting chipbreaker type • Increase the side cutting edge angle • Use an insert with a larger nose radius • Use a more lightly honed insert • Use a larger shank size	• Improve the holding rigidity of the tool and workpiece • Shorten the overhang of the toolholder • Improve the machine looseness
Fuzzy surface finish	• Improper cutting conditions		• Increase the cutting speed • Select a proper feed • Use a water-insoluble cutting fluid • Use a cutting fluid
	• Worn tool or improper cutting edge geometry	• Use a harder grade. • Select a grade with less affinity with the Workpiece material • Use an insert with a larger rake angle • Select a freer-cutting chipbreaker type • Use a more lightly honed insert	

Chipbreakers

Chip controllability

Necessity of chip control

①Why is chip control needed?
②Effect of improper chip control

Necessity of chip control (Problems and effects)

Problems	Effects
1. Scattering of chips and coolant. 2. Wrapping around the workpiece and the tool. 3. Accumulation on the tool, jig, and machining facilities.	1. Disturbs unmanned and automated machining. 2. Disturbs high-speed and high-efficiency machining. 3. Degrades finished surface. 4. Threatens operator's safety. 5. Reduced operation rate.

Additional problems when chips are not properly controlled

①Why is chip control needed?

What is chip?

For making a product from a workpiece, removed objects produced by a tool which is set to cut to a specified depth with the relative motion of the tool and the workpiece.

Problems when chips are not properly controlled

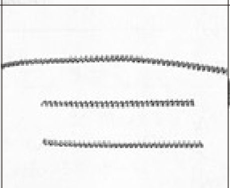
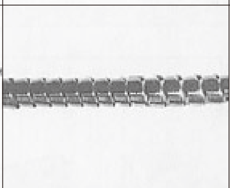
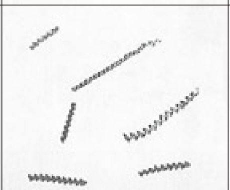
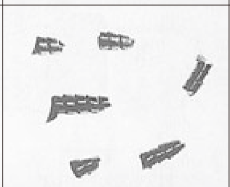
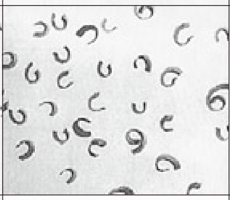
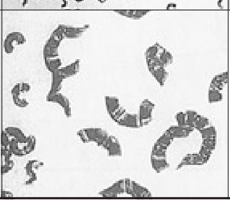
②Effect of improper chip control

Effects on quality
- Defective work.
- Defective surface finish
- Chip entangling

Effects on operation
- Increased number of man-hours for handling.
- Increased tool costs.
- Troublesome chip handling.
- Machine stoppage and reduced operation rate.

Effect on safety and health.
- Stain and damage on machine caused from improper carrying-out of chips.
- Dangerous effects on the human body. (Injury and burns on hand, etc.)

Effective measures → **"Chipbreaker"**

Classi-fication	Chip shape: Depth of cut: small	Chip shape: Depth of cut: large	Description of chip shape	Acceptability	Effect
Shape A			Chips irregularly entangled	Not acceptable	• Wrapping around the tool or workpiece or accumulation around the cutting point, hindering cutting • Possible damage to the machined surface
Shape B			Long continuous spiral chips $\ell > 50$ mm		• Bulky during transport in the automatic line • May be preferred when one operator handles one machine
Shape C			Short spiral chips $\ell < 50$ mm	Acceptable	• Smooth chip flow • Difficult to scatter • Favorable shape
Shape D			"C" or "9" shaped chips (Around one coiling)		• Favorable shape if not scattering • Not bulky and easy to transport
Shape E			Excessively broken chips. Thin pieces or connected in a form of wave as shown in the figure left	Not acceptable	• Readily scattering. If scattering is the only trouble, it may be acceptable because the chip cover, etc. may be used. • Tend to cause chatter, causing harm on the finished surface roughness or tool life.

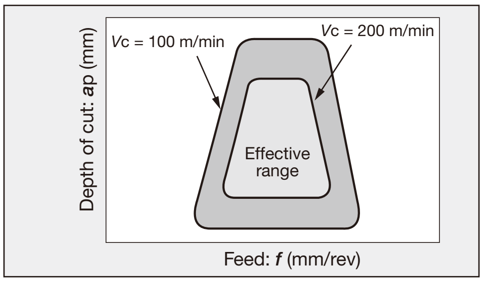
Chipbreakers

Factors affecting chip control

(1) Cutting conditions
1 Feed
2 Depth of cut
3 Cutting speed

- Of these, feed has the greatest effect followed by depth of cut and cutting speed in order listed.
- Feed is proportionate to the thickness of chips.
- Depth of cut is proportionate to the width of chips.
- There are optimum values (effective range) in feed and depth of cut.
- Cutting speed is in inverse proportion to chip thickness. Effective range becomes narrow at high speed.

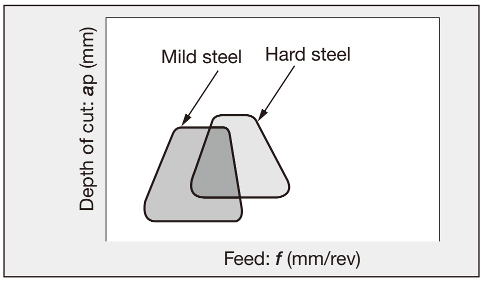
● Effect of cutting speed on chipbreaker effective range



(2) Workpiece material
1 Alloy element
2 Hardness
3 Heat treatment condition

- These are related to thickness of chips and ease of curling.
- Mild steel chips are thicker than those of hard steel.
- Hard steel chips are liable to curl more than those of mild steel.
- Chips that do not curl are thin. As an exception, in case of mild steel even if thick, may not curl.

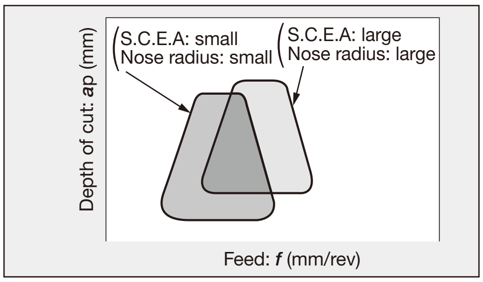
● Effect of material type on chipbreaker effective range



(3) Tool geometry
1 Side cutting edge angle
2 Nose radius

- Side cutting edge angle is relative to chip thickness and width
- Side cutting edge angle is preferably small.
- Nose radius is relative to thickness and width and the direction of flowing out.
- In finishing, small nose radius, whilst for rough cutting, large nose radius is better.

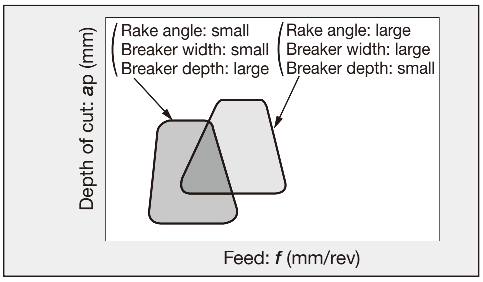
● Effect of tool geometry on chipbreaker effective range



(4) Shape of chipbreaker
1 Rake angle
2 Chipbreaker width
3 Chipbreaker depth

- Rake angle is in inverse proportion to chip thickness.
- Depending on the Workpiece material, there is an optimum value.
- Chipbreaker width is selected proportionately to feed.
- Narrow at low feed and wide at high feed.
- Chipbreaker depth is to be selected so as to be inversely proportionate to feed.
- Deep at low feed and shallow at high feed.

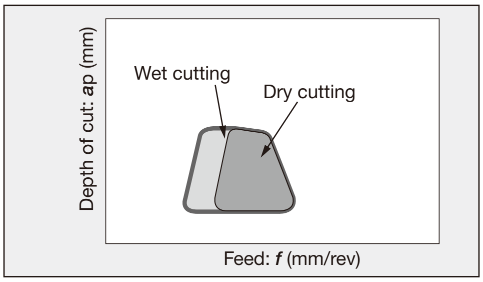
● Effect of chipbreaker shape on chipbreaker effective range



(5) Coolant

- Effective range is wider with wet cutting.
- Especially at low feed range is liable to curl.

● Effect of with/without of coolant on chipbreaker effective range



(6) Machine
1 Rigidity
2 Power limit

- The machine has enough power and mechanical strength.
- Select the machine consistent with the size of Workpiece material to be used.

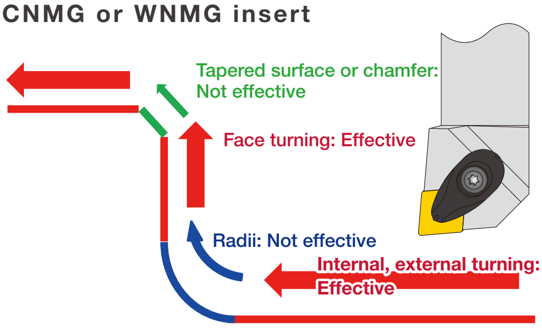
Wiper Insert

Machining program compensation for wiper -SW / -FW insert

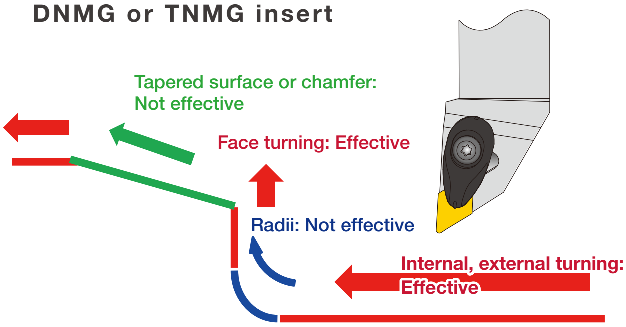
The nose radius on a wiper insert has a different configuration from that on standard ISO insert's. Machining program adjustments are, therefore, required to generate a correct offset for the wiper insert to machine the correct workpiece dimension. No compensation is needed, however, for the positive, CCMT-SW wiper insert.

● Wiper effectiveness (surface finish quality improvement) by applications

CNMG or WNMG insert

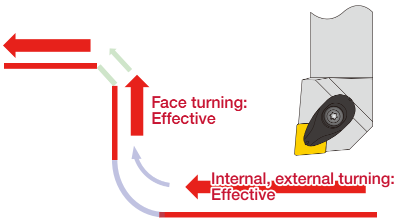
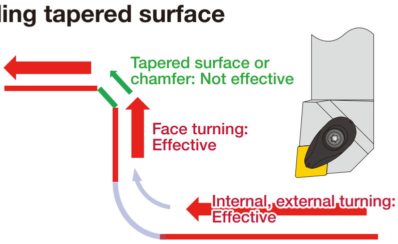
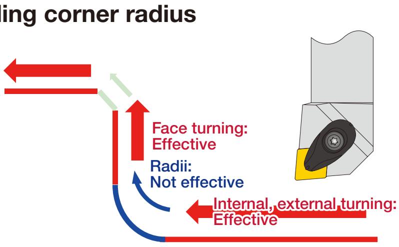
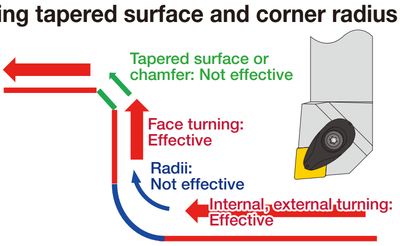


DNMG or TNMG insert



Program compensations by insert shapes and applications

Match your insert shape and application to find the proper compensation method.

Insert shape / Application	CNMG/WNMG -SW/FW	DNMG/TNMG -SW/FW	CCMT-SW
	Type **L**	Type **J, G, F**	Type **L**
Internal, External and Face turning 	Proceed to Compensation ① (See Page L012)	Proceed to Compensation ④ (See Page L013)	No compensation needed
Including tapered surface 	Proceed to Compensation ①, ② (See Page L012)	Proceed to Compensation ④, ⑤ (See Page L013 - L014)	↑
Including corner radius 	Proceed to Compensation ①, ③ (See Page L012)	Proceed to Compensation ④ (See Page L013) Proceed to Compensation ⑥ (See Page L014)	↑
Including tapered surface and corner radius 	Proceed to Compensation ①, ②, ③ (See Page L012)	Proceed to Compensation ④, ⑤, ⑥ (See Page L013 - L014)	↑

Wiper Insert

Compensations for CNMG / WNMG -SW / -FW

● Compensations ① Tool offsets (Compensations for X- and Z-axis)

Match the insert approach angle and the insert style to find the value and compensate the machining program for the insert radius. (mm)
*This compensation procedure will not be necessary if the insert is compensated with the built-in tool presetter after insert replacement.

CNMG/WNMG-SW/-FW(Type L)

Nose Radius	X-axis direction	Z-axis direction
R0.4	0.03	0.03
R0.8	0.05	0.05
R1.2	0.05	0.05

● Compensations ② Program compensations for tapered surface (proceed after ①) (mm)

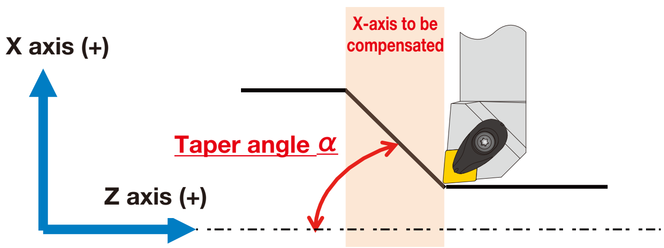
To machine tapered surfaces, compensate the nose radius position in the x-axis position to obtain the correct workpiece dimension.

Compensations for x-axis when using CNMG or WNMG-SW/-FW (Tool approach angle: L) insert

Match the insert nose radius and the angle of the surface taper to find the value in Table 1 below to compensate the x-axis position.

For **CNMG/WNMG-SW/-FW (Type L)**
Compensation values for x-axis (mm)

Nose radius (mm)	Taper angle α (θ)																		
	0	5	10	15	20	25	30	35	40	45	50	55	60	65	70	75	80	85	90
R0.4	0	0.01	0.02	0.03	0.04	0.05	0.05	0.06	0.06	0.07	0.07	0.08	0.09	0.10	0.11	0.11	0.11	0.11	0
R0.8	0	0.01	0.03	0.05	0.06	0.07	0.08	0.09	0.09	0.10	0.11	0.13	0.14	0.16	0.17	0.18	0.17	0.13	0
R1.2	0	0.01	0.03	0.05	0.06	0.07	0.08	0.09	0.10	0.10	0.11	0.13	0.14	0.16	0.17	0.18	0.18	0.16	0



● Compensations ③ Program compensation for corner radii (proceed after ①) (mm)

To achieve the correct corner radius dimension on the workpiece, compensate the tool position, using the values listed below for respective insert styles.

CNMG/WNMG-SW/-FW(Type L)

Nose Radius	Deviation on the corner radius	Compensate radius by
R0.4	0.05	+0.12
R0.8	0.07	+0.17
R1.2	0.07	+0.18

Compensations for DNMG / TNMG -SW / -FW

Compensations ④ Tool offsets (Compensations for X- and Z-axis)

Match the insert approach angle and the insert style to find the value and compensate the machining program for the insert radius.
*This compensation procedure will not be necessary if the insert is compensated with the built-in tool presetter after insert replacement.

DNMG-SW/-FW (Type J)

Nose Radius	X-axis direction	Z-axis direction
R0.4	0.24	0.03
R0.8	0.23	0.04
R1.2	0.12	0.03

TNMG-SW/-FW (Type J)

Nose Radius	X-axis direction	Z-axis direction
R0.4	0.24	0.04
R0.8	0.21	0.05
R1.2	0.16	0.04

TNMG-SW/-FW (Type G)

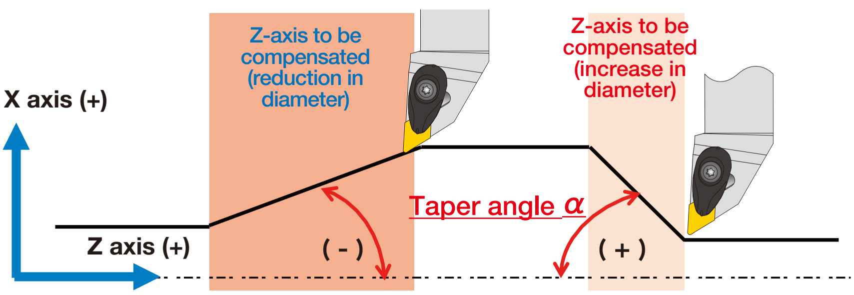
Nose Radius	X-axis direction	Z-axis direction
R0.4	0.24	0.02
R0.8	0.21	0.02
R1.2	0.15	0.02

TNMG-SW/-FW (Type F)

Nose Radius	X-axis direction	Z-axis direction
R0.4	0.02	0.24
R0.8	0.02	0.21
R1.2	0.02	0.15

Compensations ⑤ Program compensations for tapered surface (proceed after ④) (mm)

To machine tapered surfaces with DNMG or TNMG-SW/-FW insert, compensate both the x-axis and z-axis positions. Since these inserts are commonly used for profiling, to machine a tapered surface with a gradual reduction in diameter, the z-axis position has to be compensated in the negative direction.



Compensations for x- and z-axes when using DNMG or TNMG-SW/-FW

Match the insert nose radius and the angle of the surface taper to find the value in below to compensate the x-axis and/or z-axis positions.

For DNMG-SW/-FW (Type J)

X-axis compensation values for plus-tapered surface (increase in diameter) (mm)

Nose radius (mm)	Taper angle α (θ)																		
	0	5	10	15	20	25	30	35	40	45	50	55	60	65	70	75	80	85	90
R0.4	0	-0.01	-0.01	-0.01	-0.01	-0.02	-0.03	-0.04	-0.06	-0.08	-0.10	-0.14	-0.19	-0.20	-0.20	-0.19	-0.19	-0.19	0
R0.8	0	0.01	0.02	0.02	0.03	0.03	0.02	0.01	-0.00	-0.02	-0.05	-0.09	-0.15	-0.17	-0.15	-0.13	-0.12	-0.11	0
R1.2	0	0.02	0.04	0.05	0.06	0.07	0.07	0.06	0.04	0.02	-0.02	-0.09	-0.17	-0.19	-0.16	-0.14	-0.13	-0.15	0

Z-axis compensation values for minus-tapered surface (reduction in diameter) (mm)

Nose radius (mm)	Taper angle α (θ)				
	-25	-20	-15	-10	-5
R0.4	0.33	0.34	0.34	0.34	0.34
R0.8	0.30	0.32	0.33	0.34	0.34
R1.2	0.33	0.35	0.38	0.40	0.40

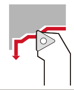
* Match the taper angle and insert nose radius to find the value in Table 2 and compensate the NC program by either adding or deducting the value.

Example:
Tapering a surface of +45° (increase in diameter) with a R0.8 mm insert.
Current NC program: X100
Compensation value: -0.02
Parameter after compensation: X99.98

Wiper Insert

Compensations for DNMG / TNMG -SW / -FW

● Compensations ⑤ Program compensations for tapered surface (proceed after ④) (mm)


J 93°

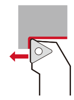
For TNMG-SW/-FW (Type J)

X-axis compensation values for plus-tapered surface (increase in diameter) (mm)

Nose radius (mm)	Taper angle α (θ)																		
	0	5	10	15	20	25	30	35	40	45	50	55	60	65	70	75	80	85	90
R0.4	0	0	0	-0.01	-0.01	-0.02	-0.03	-0.04	-0.05	-0.07	-0.10	-0.14	-0.18	-0.25	-0.28	-0.28	-0.27	-0.27	0
R0.8	0	0.01	0.02	0.03	0.04	0.04	0.04	0.03	0.02	0.00	-0.02	-0.06	-0.11	-0.19	-0.22	-0.20	-0.19	-0.21	0
R1.2	0	0.02	0.05	0.07	0.08	0.09	0.10	0.09	0.08	0.06	0.03	-0.02	-0.10	-0.22	-0.26	-0.25	-0.25	-0.31	0

Z-axis compensation value for minus-tapered surface (reduction in diameter) (mm)

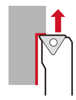
Nose radius (mm)	Taper angle α(θ)				
	-25	-20	-15	-10	-5
R0.4	0.42	0.42	0.42	0.41	0.40
R0.8	0.35	0.32	0.33	0.34	0.33
R1.2	0.42	0.36	0.38	0.39	0.37


G 91°

For TNMG-SW/-FW (Type G)

X-axis compensation values for plus-tapered surface (increase in diameter) (mm)

Nose radius (mm)	Taper angle α (θ)																		
	0	5	10	15	20	25	30	35	40	45	50	55	60	65	70	75	80	85	90
R0.4	0	0.00	-0.01	-0.01	-0.02	-0.03	-0.04	-0.05	-0.07	-0.09	-0.12	-0.16	-0.22	-0.28	-0.29	-0.29	-0.29	-0.32	0
R0.8	0	0.01	0.02	0.02	0.03	0.02	0.02	0.01	-0.01	-0.03	-0.06	-0.10	-0.17	-0.25	-0.25	-0.25	-0.28	-0.40	0
R1.2	0	0.03	0.06	0.08	0.09	0.10	0.11	0.10	0.09	0.07	0.04	-0.01	-0.09	-0.18	-0.18	-0.18	-0.20	-0.34	0


F 91°

For TNMG-SW/-FW (Type F)

X-axis compensation values for plus-tapered surface (increase in diameter) (mm)

Nose radius (mm)	Taper angle α (θ)																		
	0	5	10	15	20	25	30	35	40	45	50	55	60	65	70	75	80	85	90
R0.4	0	-0.03	-0.05	-0.08	-0.10	-0.13	-0.13	-0.11	-0.10	-0.09	-0.08	-0.07	-0.06	-0.05	-0.05	-0.04	-0.03	-0.02	0
R0.8	0	-0.04	-0.05	-0.07	-0.09	-0.12	-0.10	-0.07	-0.05	-0.03	-0.01	0.01	0.03	0.05	0.07	0.09	0.11	0.13	0
R1.2	0	-0.03	-0.04	-0.05	-0.07	-0.09	-0.05	-0.01	0.03	0.07	0.11	0.15	0.18	0.22	0.25	0.28	0.32	0.35	0

● Compensations ⑥ Program compensation for corner radii (proceed after ④) (mm)

To achieve the correct corner radius dimension on the workpiece, compensate the tool position, using the values listed below for respective insert styles.

DNMG-SW/-FW (Type J)

Nose Radius	Deviation on the corner radius	Compensate radius by
R0.4	0	0
R0.8	0.02	+0.20
R1.2	0.10	+0.34

TNMG-SW/-FW(Type J)

Nose Radius	Deviation on the corner radius	Compensate radius by
R0.4	0	0
R0.8	0.03	+0.13
R1.2	0.11	+0.36

TNMG-SW/-FW(Type G, Type F)

Nose Radius	Deviation on the corner radius	Compensate radius by
R0.4	0	0
R0.8	0.02	+0.15
R1.2	0.09	+0.38

Additional information on offsetting -SW / -FW wiper inserts

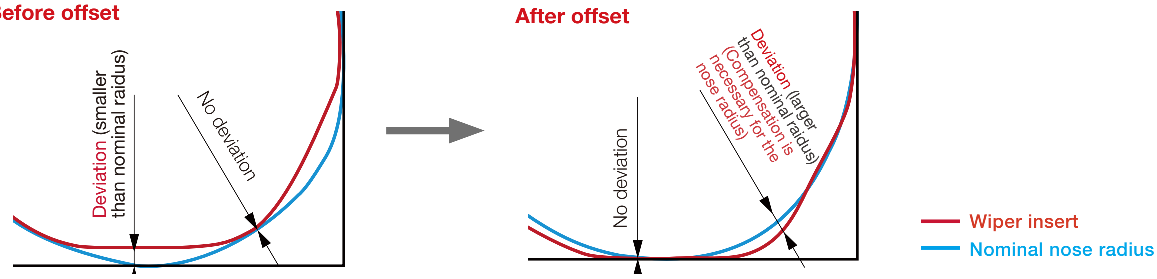
● Compensations ①, ④ Tool offsets (Compensations for X- and Z-axis)

Why need to offset ?

Ex. When using DNMG150412

The wiper insert does not provide the exact corner radius. A deviation from the standard nose radius shape as shown below will always occur when going into a corner. An additional program adjustment is, therefore, required to achieve the correct corner radius or tapered surface dimension on the workpiece.

Before offset | **After offset**



Wiper nose radius' contour is slightly smaller than the nominal radius.
→ The nose radius profile deviates from the required corner radius, thus the actual corner profile will be incorrect.

Wiper nose radius' contour is partially larger than the nominal radius.
→ No compensations necessary for ID, OD, or face turning.
Meanwhile, due to these deviations, compensations to the NC program are necessary when turning corners and tapered surfaces for the correct workpiece dimensions.

● Compensations ③, ⑥ Program compensation for corner radii (proceed after ①, ④) (mm)

Compensation for corner radius

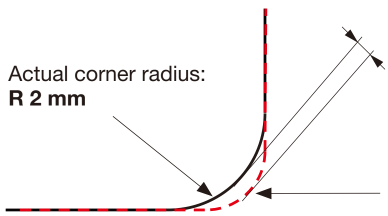
Ex. When using DNMG150412

Example: to machine a corner radius = R2 mm, using insert nose radius = R1.2 mm.

For standard ISO insert: DNMG150412-**
Input R0.8 for G2 or G3 (circular interpolation) to compensate the nose radius deviation.

Wiper insert
For wiper insert: DNMG150412-SW/-FW
Input **R1.14** (= R1.2 + 0.34 from the list) for the nose radius, instead of R0.8, to compensate the nose radius deviation.

Actual corner radius:
R 2 mm



The deviation generated when using the ISO insert parameters for the wiper insert.
0.1 mm

Theoretical corner radius shape when R1.2 (=nominal nose radius) is programmed for the wiper insert
The actual corner radius becomes smaller than the required radius due to the insert radius deviation.
Corner radius = R1.66 mm
(R2 - 0.34)

Designation System for ISO Inserts

● How to decide the insert designation (conforms to JIS B4120-1998, ISO 1832 / AM1:1998)

❶ Shape

Symbol	Shape	Nose angle (degree)	Figure
H	Hexagonal	120°	
O	Octagonal	135°	
P	Pentagonal	108°	
S	Square	90°	
T	Triangular	60°	
C	Rhombic	80°	
D	Rhombic	55°	
E	Rhombic	75°	
F	Rhombic	50°	
G	G-shape (Tungaloy's symbol)	70°	
M	Rhombic	86°	
V	Rhombic	35°	
Y	Y-shape (Tungaloy's symbol)	25°	
W	Trigon	80°	
L	Rectangular	90°	
A	Parallelogram	85°	
B	Parallelogram	82°	
K	Parallelogram	55°	
R	Round	-	

Note: For rhombic and parallelogram inserts, use the smaller nose angle.

❷ Relief angle

Symbol	Relief angle
A	3°
B	5°
C	7°
D	15°
E	20°
F	25°
G	30°
N	0°
P	11°
O	Others
X	Special

❸ Accuracy

Symbol (class)	Tolerance (mm) Corner height (M)	Thickness (S)	I.C. dia. (IC)
A	±0.005	±0.025	±0.025
F	±0.005	±0.025	±0.013
C	±0.013	±0.025	±0.025
H	±0.013	±0.025	±0.013
E	±0.025	±0.025	±0.025
G	±0.025	±0.13	±0.025
J	±0.005	±0.025	±0.005 ~ ±0.13
K	±0.013	±0.025	±0.05 ~ ±0.13
L	±0.025	±0.025	±0.05 ~ ±0.13
M	±0.08 ~ ±0.18	±0.13	±0.05 ~ ±0.13
N	±0.08 ~ ±0.18	±0.025	±0.05 ~ ±0.13
U	±0.13 ~ ±0.38	±0.13	±0.08 ~ ±0.25

	❶	❷	❸	❹	❺
[Example]	T	N	M	G	16
[Example]	C	C	G	T	09

❹ Groove and hole

Symbol	Hole	Shape of hole	Chip-breaker	Shape
N	Without	-	Without	
R	Without	-	Single-sided	
F	Without	-	Double-sided	
A	With	Cylindrical hole	Without	
M	With	Cylindrical hole	Single-sided	
G	With	Cylindrical hole	Double-sided	
W	With	Partly cylindrical hole, single-side 40° ~ 60° Counter sink	Without	
T	With	Partly cylindrical hole, single-side 40° ~ 60° Counter sink	Single-sided	
Q	With	Partly cylindrical hole, double-side 40° ~ 60° Counter sink	Without	
U	With	Partly cylindrical hole, double-side 40° ~ 60° Counter sink	Double-sided	
B	With	Partly cylindrical hole, single-side 70° ~ 90° Counter sink	Without	
H	With	Partly cylindrical hole, single-side 70° ~ 90° Counter sink	Single-sided	
C	With	Partly cylindrical hole, double-side 70° ~ 90° Counter sink	Without	
J	With	Partly cylindrical hole, double-side 70° ~ 90° Counter sink	Double-sided	
X	Special			

❺ Cutting edge length and I.C. symbol

*R Symbol	R Length	S Symbol	S Length	C Symbol	C Length	W Symbol	W Length	T Symbol	T Length	D Symbol	D Length	V Symbol	V Length	K Symbol	K Length	I.C. dia.
		03	3.97	03	4.0			06	6.9	04	4.8					3.97
		04	4.76	04	4.8			08	8.2	05	5.8	08	8.3			4.76
05	5	–	–	–	–	–	–	–	–	–	–	–	–	–	–	5
		05	5.56	05	5.6	03	3.8	09	9.6	06	6.8					5.56
06	6	–	–	–	–	–	–	–	–	–	–	–	–	–	–	6
		06	6.35	06	6.5	04	4.3	11	11	07	7.8	11	11.2			6.35
		07	7.94	08	8.1	05	5.4	13	13.8	09	9.7					7.94
08	8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	8
09	9.525	09	9.525	09	9.7	06	6.5	16	16.5	11	11.6	16	16.6	16	19.7	9.525
10	10	–	–	–	–	–	–	–	–	–	–	–	–	–	–	10
12	12	–	–	–	–	–	–	–	–	–	–	–	–	–	–	12
12	12.7	12	12.7	12	12.9	08	8.7	22	22	15	15.5	22	22.1			12.7
15	15.875	15	15.875	16	16.1	10	10.9	27	27.5	19	19.4					15.875
16	16	–	–	–	–	–	–	–	–	–	–	–	–	–	–	16
19	19.05	19	19.05	19	19.3	13	13	33	33	23	23.3					19.05
20	20	–	–	–	–	–	–	–	–	–	–	–	–	–	–	20
		22	22.225	22	22.6			38	38.5	27	27.1					22.225
25	25	–	–	–	–	–	–	–	–	–	–	–	–	–	–	25
25	25.4	25	25.4	25	25.8			44	44	31	31					25.4
31	31.75	31	31.75	32	32.2			55	55	38	38.8					31.75
32	32	–	–	–	–	–	–	–	–	–	–	–	–	–	–	32

*When M0 is included in Designation, the inscribed-circle diameter is metric size. (mm)

● Detailed accuracy for J,K,L,M,N and U classes

For inserts with nose corner angles larger than 55˚

(mm)

Inscribed circle	Tolerance on inscribed circle dia. (IC)		Tolerance on corner height (M)		Applicable insert shape
	J,K,L,M,N (class)	U (class)	J,K,L,M,N (class)	U (class)	
6.35	±0.05	±0.08	±0.08	±0.13	H, W, O, R, P, S, T, C,E,M
9.525					
12.7	±0.08	±0.13	±0.13	±0.2	
15.875	±0.1	±0.18	±0.15	±0.27	
19.05					
25.4	±0.13	±0.25	±0.18	±0.38	
31.75	±0.15	±0.25	±0.2	±0.38	
32					

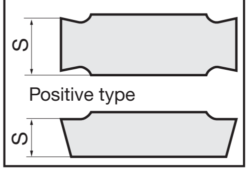
For M-type inserts with nose corner angles of 55˚ (Shape: D), 35˚ (Shape: V), 25˚ (Shape: Y)

(mm)

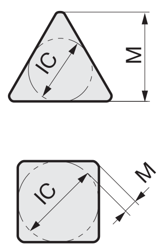
Inscribed circle	Tolerance on inscribed circle dia. (IC)	Tolerance on corner height (M)	Applicable insert shape
6.35	±0.05	±0.11	D
9.525			
12.7	±0.08	±0.15	
15.875	±0.1	±0.18	
19.05			
6.35	±0.05	±0.16	V, Y
9.525			

● Insert thickness

For many of the inserts with chipbreaker, the insert height of the cutting edge is lower. In that case, the insert thickness outlined in the drawing of external dimensions is equivalent of "S" in the figure on the right.



Inscribed circle (IC)
Corner height (M)



Symbol	Thickness (mm)
X1	1.39
01	1.59
T1	1.98(1.79)
02	2.38
T2	2.78
03	3.18
T3	3.97
04	4.76
05	5.56
06	6.35
07	7.94
09	9.52

⑥ Thickness

[Example]

⑥ 04 ⑦ 08 - ⑩ TM

⑥ T3 ⑦ 04 ⑧ F ⑨ N - ⑩ JS

(Optional symbol) (Optional symbol) (Supplementary symbol)

⑦ Corner radius

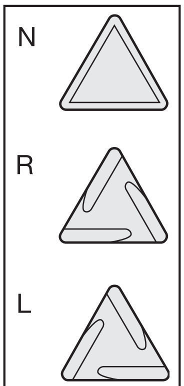
Symbol	Corner radius RE (mm)
008	0.08
00	0.03
01	0.1
018	0.18
02	0.2
04	0.4
08	0.8
12	1.2
16	1.6
20	2
24	2.4
28	2.8
32	3.2

⑧ Major cutting edge

Symbol	Cutting edge	Shape
F	Sharp	
E	Rounded	
W.T	Chamfered	
S	Combination	
M	RE minus tolerance	

⑨ Hand of insert

Symbol	Hand
R	Right
L	Left
N	Neutral



⑩ Chipbreaker

Symbol	Applications	Symbol	Applications
01(TF)	Precision finishing (Basic selection)	AFW	Small depth of cut and high feed (Wiper type Inserts)
TS	Finishing (Basic selection)	ASW	Small depth of cut and high feed (Wiper type Inserts)
TSF	Finishing (Basic selection)	CB	Medium cutting
TM	Medium cutting (Basic selection)	CM	Medium cutting of cast irons
THS	Medium to heavy cutting (Basic selection)	All-round	Medium cutting
TRS	Medium to heavy cutting	A	Finishing (Right and left hand)
TUS	Heavy cutting	B	Finishing (Right and left hand)
DM	Medium cutting	C	Finishing (Right and left hand)
HRF	Finishing	D	Finishing (Right and left hand)
HRM	Finishing to medium cutting	P	Finishing of Aluminium alloys
HMM	Finishing to medium cutting	W	Finishing (Angular type)
SF	Finishing of stainless steels	PSF	Finishing (Positive type)
SS	Finishing of stainless and mild steels	PSS	Finishing to light cutting (Positive insert)
SM	Medium cutting of stainless steels	PS	Finishing to medium cutting (Positive type Basic selection)
S	Medium cutting of stainless steels	PM	Medium cutting (Positive type)
SH	Medium to heavy cutting of stainless steels	AL	Finishing to medium cutting of aluminium alloys
SA	For heat-resisting alloys and stainless steels	RS	Medium cutting (For round inserts)
ZF	Finishing and profiling	W□□	Finishing (Angular type)
ZM	Finishing to medium cutting and profiling	H□□	Finishing to medium cutting (Parallel)
NS	Finishing and profiling	11	Finishing
NM	Finishing to medium cutting and profiling	61	Small depth of cut and high feed (For round inserts)
AS	Small depth of cut and high feed	S1	Finishing (For KNMX type)
TA	Medium cutting	J08,J10	For small lathes
TQ	Medium cutting	JS	For small lathes
AM	Small depth of cut and high feed	JRP	For small lathes
FW	Finishing (Wiper type)	JPP	For small lathes
SW	Finishing to medium cutting (Wiper type)	JSP	For small lathes

Corner radius (RE) with a sign of inequality (<) : minus tolerance

G class

RE (mm)	Range
<0.05	0.01 < RE < 0.05
<0.1	0.06 < RE < 0.10
<0.2	0.16 < RE < 0.20
<0.4	0.36 < RE < 0.40

E class

RE (mm)	Range
<0.08	0.06 < RE < 0.08
<0.1	0.08 < RE < 0.10
<0.18	0.16 < RE < 0.18
<0.2	0.18 < RE < 0.20

Designation System for External Toolholders

❶ Clamping system

Symbol	Clamping system
A	Double Clamping
JP	Side lever clamping
C	Clamp-on
JS	Screw-on
X	Double Clamping
D	One-Double
JT	Side clamping
S	Screw-on
P	Lever-lock
M	Multi clamping
T	Taper-lock

❸ Cutting edge style

Symbol	Shape	Offset
A	90°	Without
B	75°	Without
C	90°	Without
D	45°	Without
E		Without
F	91°	With
G	91° / 91°	With
H	100°	With
I	76.5°	Without
J	93°	With
J2 *	93°	Without
K	75°	With
L	95° / 95°	With
L2 *	95° / 95°	Without
N	63°	Without
N3 *	63°	With
P *	62.5°	Without
P *	117.5°	Without
Q *	45°	With
S	45°	With
V	72.5°	Without
U	93°	With
X	100°	With
Y	80°	With
Z	93°	Without

No mark: ISO symbol
*mark: Tungaloy's symbol

(Example) ① A ② W ③ L ④ N ⑤ R

(Example) ① P ② T ③ G ④ N ⑤ R

② Insert shape

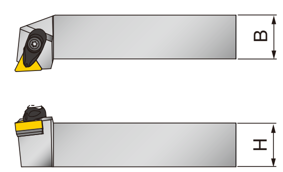
Symbol	Shape
C	80° Rhombic
D	55° Rhombic
K	55° Parallelogram
R	Round
S	Square
T	Triangular
V	35° Rhombic
W	Trigon

④ Relief angle of insert

Symbol	Relief angle
C	7°
B	5°
N	0°
P	11°

⑤ Hand of tool

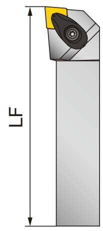
Symbol
L
N
R



⑥ Height: H (mm) ⑦ Width: B (mm)

Shank size

F	80	
F	85*	*MiniForceTurn
H	100	
X	120	
K	125	
M	150	
P	170	
Q	180	
R	200	
S	250	
T	300	
U	350	



⑧ Holder length

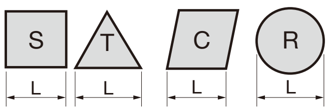
RD	Ceramic insert with dimple
C	For ceramic insert
A	Turning A

⑪ Added symbol

⑥	⑦	⑧	⑨		⑪ / ⑩
25	25	M	08	-	A
20	20	K	3		3

⑨ Insert size

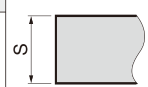
Symbol	Inscribed circle (mm)
3	9.525
4	12.7
5	15.875
6	19.05
8	25.4



In the ISO metric system, edge length of inserts is expressed by L in 2 digits.

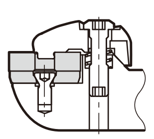
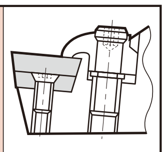
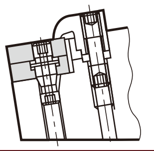
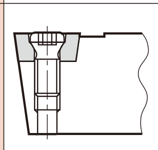
⑩ Insert thickness

Symbol	Thickness (mm)
2	3.18
3	4.76

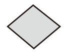
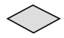
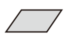
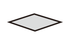


Designation System for Internal Toolholders

❹ Clamping system

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

❺ Insert shape

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

A ① **12** ② **M** ③ **-** **S** ④ **T** ⑤

❶ Bar composition

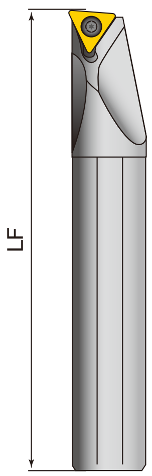
A	Steel shank with oil hole
E	Carbide shank with steel head & oil hole
C	Carbide shank with steel head
S	Steel shank
T	Steel shank reinforced with carbide plates (“Tsuppari-Ichiban”)
JS	J series Steel shank

❷ Bar diameter

Bar diameter is shown in mm.

❸ Toolholder length (mm)

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



Symbol	Style	Offset	Symbol	Style	Offset	Symbol	Style	Offset
A	90°	Without	G	91° / 91°	With	S	45°	With
						V	72.5°	Without
			J	93°	With	U	93°	With
B	75°	Without	K	75°	With	X *	100°	With
C	90°	Without	L	95° / 95°	With	Y	80°	With
D	45°	Without	N	63°	Without	Z	93°	Without
E	60°	Without	P *	62.5°	Without	Note *mark: Tungaloy standard No mark: ISO standard		
F	91°	With	Q *	45°	With			

6 Cutting edge style

C	7°
B	5°
N	0°
P	11°
X	Special

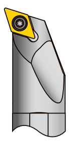
7 Relief angle of insert

U P R 11 0 2 C - D140

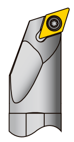
6 U · 7 P · 8 R · 9 1102 · 10 C · 11 D140

8 Hand of tool

R



L



9 Insert size

For M, S, & C types conformed to ISO

S L · T L · C L · R L

"In ISO metric system, a two digit number indicates the edge length (L) of the insert to be used in mm.
If the insert thickness is different for the same edge length, add the thickness symbol (S) (two digit number).

In above example, TP□□1102□□

10 Oil hole

Only "Tsuppari-Ichiban" holder

11 Min. bore diameter (mm)

Stream Jet Bar		Tsuppari-Ichiban	
D140	ø14	D14	ø14

Designation System for CBN / PCD Inserts

CBN Insert

Regular type

T 2 QP - CNGA120404 -L

1 2 3 4 5

1 "T" means 10 pieces per package.

2 Number of corners

3 Type

QP	Flat-brazed type inserts
QS	WavyJoint

4 ISO symbol

5 Special feature & chipbreaker

Without, SR	Standard cutting edge	SP	Standard cutting edge (MiniForce-Turn)
F	Sharp edge	-HP	With chipbreaker
-L	Excellent wear resistance	-HS	With chipbreaker
-LF	Lower cutting force, superior sharpness	-HF	With chipbreaker
-LC	Excellent crater wear resistance	-HM	With chipbreaker
-H, HC	Excellent fracture resistance	W	With wiper
-E	Lower cutting force	W□	With wiper
LT	For smooth machining with lower cutting force		

Regrindable type

TNGA160402 - QBN

1 2

1 ISO symbol

2 CBN inserts

For TUNGCUT

S G N 200 - 020 -S

1 2 3 4 5 5

1 Number of edge

S	Single corner

2 Application

G	Grooving
T	Turning・Grooving

3 For use

N	Non breaker
H	High feed

4 Groove width (mm)

200	2

5 Corner radius: RE (mm)

020	0.2

5

Without	Lower cutting force
-S, -SR	Standard cutting edge
-H	Excellent fracture resistance

For XG R/L

XG R 63 15 S - QBN

1 2 3 4 5

1 For grooving tool GX-type

2 Hand of Insert

L	Left
R	Right

3 Groove width (mm)

10	1
15	1.5

4 Corner radius: RE (mm)

S	0.2

5 CBN inserts

For TUNGTHREAD

1 QP - 16 E R 60 - 014 -SP

1 2 3 4 5 6 7 8

1 Number of corners

2 Type

QP	Flat-brazed type inserts

3 Type

16	9.525

4 Internal/ External

E	External

5 Hand of Insert

R	Right

6 Thread profile

60	60°

7 Corner radius: RE (mm)

014	0.14

8 Special feature & chipbreaker

-SP	Standard cutting edge (TungThred)

PCD Insert

Regular type

1 QP - CCGT09T304 -NS

①Number of corners

② Type	
QP	Flat-brazed type inserts

③ ISO symbol

⑧ Special feature & chipbreaker	
-NS	With chipbreaker

Regrindable type

TPGW110204 - DIA

① ISO symbol

② PCD inserts

For DUOJUST CUT

JX D X 12 R 20 F

① For grooving tool JSXX-type

② Application	
D	Turning and deep grooving

② Chipbreaker style	
X	General purpose

④ Insert size (mm)	
12	ø12
16	ø16

⑤ Hand of Insert	
R	Right

⑥ Groove width (mm)	
20	2
25	2.5

⑦ Special feature & chipbreaker	
F	Sharp edge

CBN Inserts

Edge preparation specifications

CBN inserts with special edge preparation specifications are made to order. Refer to the following description.

Designation system for edge specifications

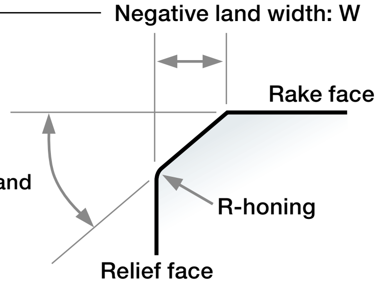
Example:
Negative land width: 0.13 mm
Negative land angle: -25°
With R-honing

S 0 1 3 2 5

Shape — Negative land width: W — Negative land angle: α

Negative land angle: α

T … Chamfered
S … Chamfered + R-honing
E … R-honing alone
F … Sharp edge



● Standard edge specifications

Grade	BXA10	BXA20	BR35F	BXM10	BXM20	BXC50	BX310	BX330	BX360	BX380	BX470	BX480	BX910	BX930
Negative insert	S01325	S01325	S01325	S01325	S01325	S01325	S01325	S01325	S01325	S01325	T01315	S01325	S01315	S01315
Positive insert	S01325	S01325	S01325	S01325	S01325	–	S00515	S00515	S00515	–	T01315	S00515	S01315	S00515

5 edge preparation options covering various hard turning

● Edge preparations turning applications

Negative land angle → Large

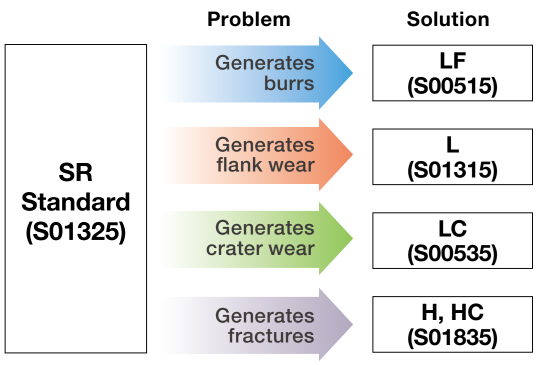
Negative land width → Wide

W (mm) \ α	15°	25°	35°
0.05	LF	-	LC
0.13	L	Standard SR	-
0.18	-	-	H HC

BXA10, BXA20, BR35F inserts

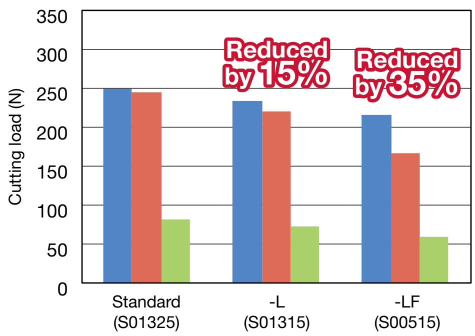
● Selections of edge preparations

Allows you to select the most suited types of edge prep for your applications



● Cutting loads

The -L and -LF provide reduced cutting loads over the standard edge prep type

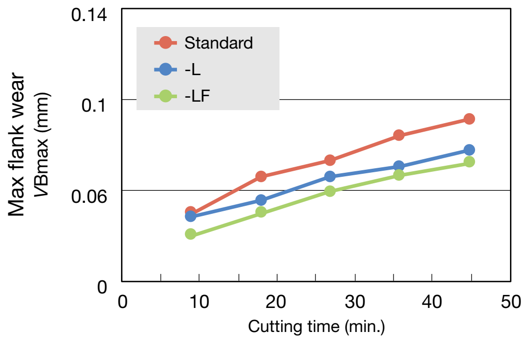


H

Insert	: 2QP-CNGA120408
Workpiece material	: SCM440 (Alloy steel, 60HRC)
Cutting speed	: *Vc* = 100 m/min
Feed	: *f* = 0.3 mm/rev
Depth of cut	: *ap* = 0.2 mm
Coolant	: Dry

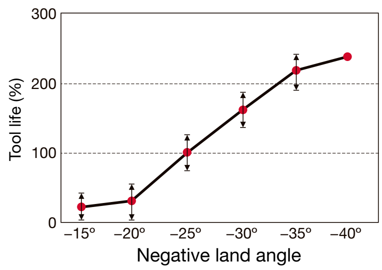
● Flank wear

The -L and -LF provide reduced flank wear over the standard edge prep type



H Insert	: 2QP-CNGA120408
Workpiece material	: SCM440 (Alloy steel, 60HRC)
Cutting speed	: *Vc* = 130 m/min
Feed	: *f* = 0.15 mm/rev
Depth of cut	: ap = 0.2 mm
Coolant	: Wet

Relationship between negative land angle and tool life in interrupted turning

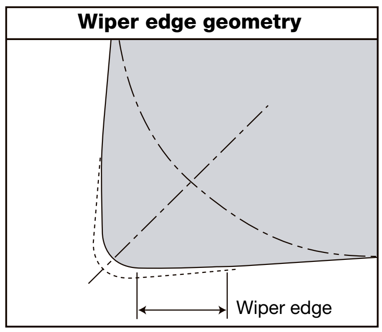


Insert	: TNGN160404 BX360
Edge preparation	-□□°+ R-honing
Workpiece material	: SCM415 (Alloy steel, 60HRC)
Cutting speed	: *Vc* = 100 m/min
Feed	: ap = 0.25 mm
Depth of cut	: Dry
Coolant	

•For interrupted cutting, large negative land angle is favorable to minimize fracture.

Wiper insert

● A finishing edge (wiper edge) is formed at the point of intersection between corner radius and straight cutting edge.



• Effect of wiper edge

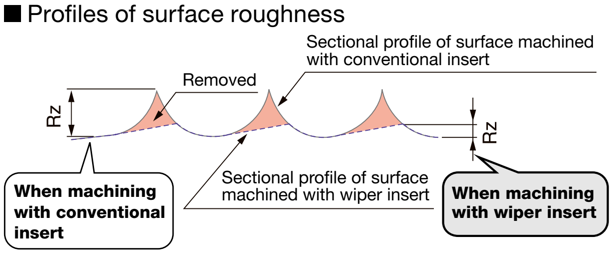
● Doubles the productivity → Reduced machining time

The wiper edge can double the feed rate and moreover does not deteriorate the surface roughness. (Note: Feed rate: *f* < 0.3 mm/rev)

● Superior surface roughness → By integrating roughing and finishing into one process, productivity can be increased.

Compared with conventional inserts only with corner radius, surface roughness can be improved with the wiper edge.

■ Profiles of surface roughness



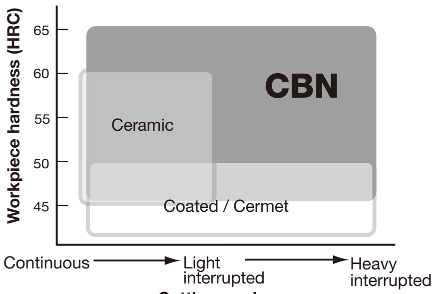
■ Recommended toolholders for wiper inserts

	2QP-CNGA1204**FW	3QP-WNGA080408FW	2QP-DNGA1504**WJ	3QP-TNGA1604**WG
End cutting angle	95°		93°	91°
External toolholder	ACLNR/L**12-A	AWLNR/L**08-A	ADJNR/L**15-A	ATGNR/L**16-A
				ATFNR/L**16-A
	DCLNR/L**12	DWLNR/L**08	DDJNR/L**15	DTGNR/L**16
				DTFNR/L**16
Internal toolholder	A**-ACLNR/L12-D...	A**-AWLNR/L08-D...	A**-ADUNR/L15-D...	A**-ATFNR/L16-D...

CBN Grades

H CBN series for hardened steel and hard material

Application area



Necessity of CBN grades

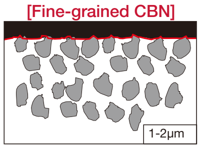
The condition necessary to cut the work

Material is:
Hardness of tool ≥ Hardness of tool X 3

● Hardened steel (60HRC) →700 Hv ● Cemented carbide →1600 Hv
● CBN (BX360) →3300 Hv

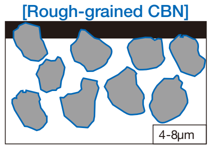
Relation of CBN grain size, surface roughness, and cutting speed

[Fine-grained CBN]



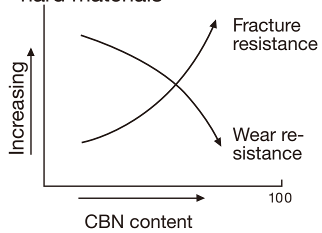
Fine grained CBN provided with sharp cutting edge.
Good surface roughness

[Rough-grained CBN]



Rough grained CBN. CBN particles are hold firmly.
Allows high speed machining

● Features of CBN grades for machining hardened steel and other hard materials



Fewer CBN content ⇨ Increasing wear resistance
Much CBN content ⇨ Increasing impact resistance

Basic selection of CBN grades in machining of hardened steel and hard material

● Coated CBN grades

BXA10 For continuous and light interrupted cutting

BXA20 For general purpose, less than Vc = 180 m/min

BR35F For Interrupted cutting

BXM10 For high speeds cutting

BXM20 For general purpose, more than Vc = 180 m/min

● Uncoated CBN grades

BX310 For high speeds / Priority on wear resistance in continuous cutting

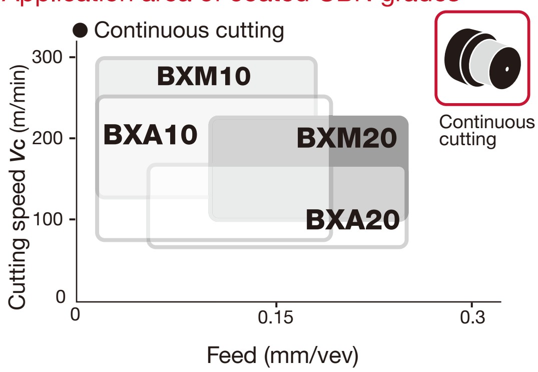
BX330 For medium speeds / Priority on surface quality

BX360 For low to medium speeds / General purpose grade with excellent fracture resistance

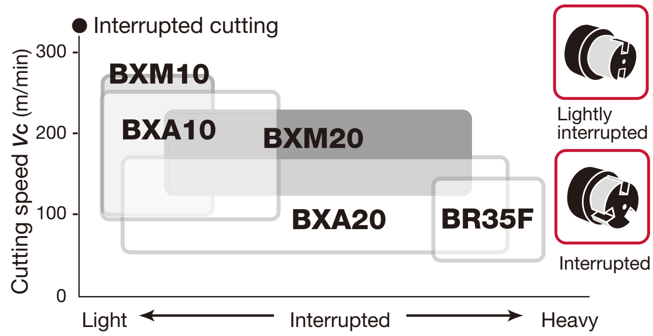
BX380 For low to medium speeds / Priority on fracture resistance in heavy interrupted cutting

Application area of coated CBN grades

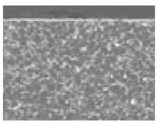
● Continuous cutting



● Interrupted cutting



Effects of Coated CBN grades



Coated on hard CBN
Hardness:
CBN > Coating layer

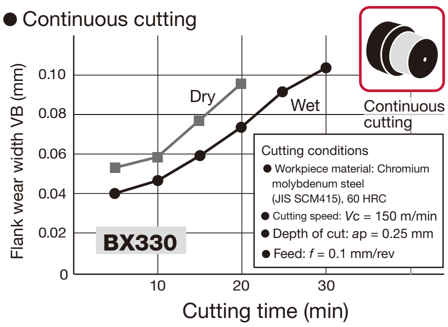
● **Protect CBN from oxidation wear**
Since the coating layer intercepts air, oxidation wear of CBN can be prevented.

● **Peeling of coating layer can be prevented**
Hard and deformation resistant CBN is excellent substrate material.

➡ **Improved resistance to flank wear**

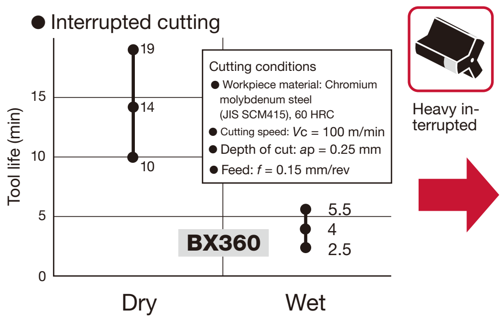
Effects of coolant in machining of hardened steel

● Continuous cutting



Cutting conditions
● Workpiece material: Chromium molybdenum steel (JIS SCM415), 60 HRC
● Cutting speed: Vc = 150 m/min
● Depth of cut: ap = 0.25 mm
● Feed: f = 0.1 mm/rev

● Interrupted cutting



Cutting conditions
● Workpiece material: Chromium molybdenum steel (JIS SCM415), 60 HRC
● Cutting speed: Vc = 100 m/min
● Depth of cut: ap = 0.25 mm
● Feed: f = 0.15 mm/rev

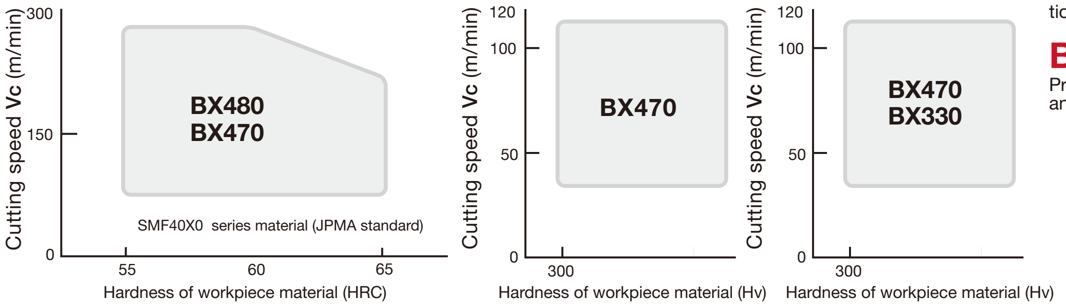
● In continuous cutting, wet cutting is superior to dry cutting in tool life for wear.

● In interrupted cutting, dry cutting is superior to wet cutting in tool life for fracture.

CBN series for sintered metal

Sintered metal

Application area

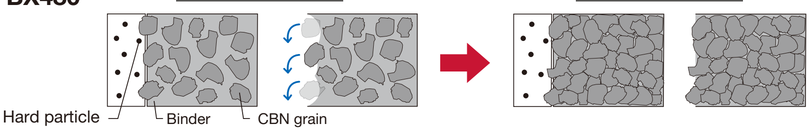


BX470
Priority on burr prevention and surface finish

BX480
Priority on wear resistance and versatility

Features of BX470 and BX480

● Machining of sintered metal with hard particles



Binder phase are selectively worn away by hard particles.
⇨ Wear proceeds with falling-out of CBN grains,

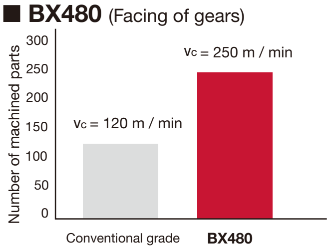
By increasing CBN content, wear of binder layer is suppressed.
⇨ Improved wear resistance

● Features of BX470 and BX480

CBN content: 95 vol%
Hv = 4100 ~ 4300

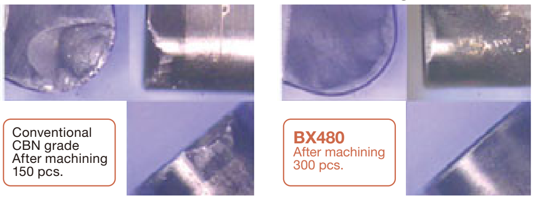
The world highest CBN content as a commercially available material.

BX480 (Facing of gears)



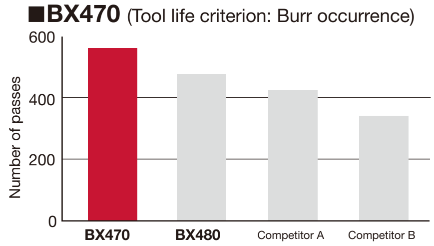
Cutting conditions
- Workpiece material: Sintered metal (> HRA60)
- Insert: DCMW11T308
- Depth of cut: **ap** = 0.2 ~ 0.5 mm
- Feed : ***f*** = 0.07 mm/rev
- Coolant : Water soluble type
- Interrupted cutting

BX470/BX480 Tool failure after machining sintered metal



Cutting conditions
- Workpiece material: Sintered metal (> HRA60), Nitriding, Hard particles included
- Cutting speed: ***Vc*** = 110 m/min
- Depth of cut: **ap** = 0.15 mm
- Feed: ***f*** = 0.1 mm/rev
- Coolant : Water soluble type
- Interrupted cutting

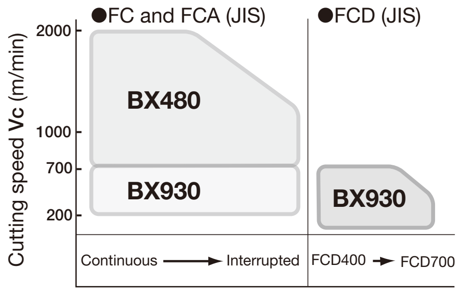
BX470 (Tool life criterion: Burr occurrence)



Cutting conditions
- Workpiece material: Ferrous Sintered metal
- Cutting speed: ***Vc*** = 100 m/min
- Depth of cut: **ap** = 0.15 ~ 0.3 mm
- Feed: ***f*** = 0.07 ~ 0.25 mm/rev
- Dry and interrupted cutting

K CBN series for grey cast iron and ductile cast iron

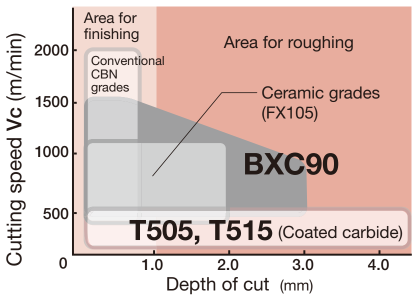
Application area



BX480
· General purpose, first choice grade.

BX930
· Dedicated grade for machining ductile Cast iron

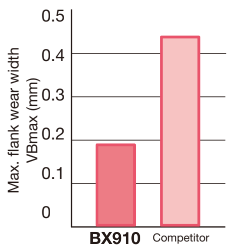
● FC Solid coated CBN grades



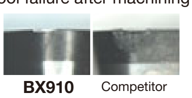
BXC90
· One-piece solid structure
· Applicable for small to large depths of cut

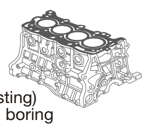
Machining of cylinder liners (Machining example of BX910)

● Wear width after machining 120 pcs.



● Tool failure after machining 120 pcs.

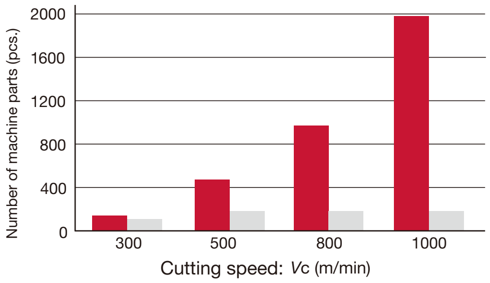




Cutting conditions
- Workpiece material: Cylinder liner (Spin casting) Machining type: Finish boring
- Cutting speed: Vc = 1,000 m/min
- Machine: Special purpose machine
- Coolant: Wet

BX910 For machining cylinder liners

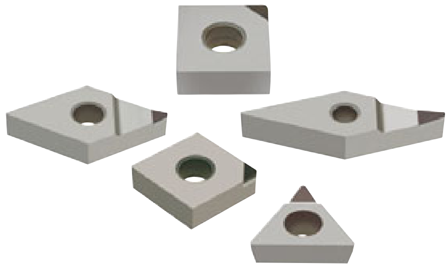
Tool life comparison in machining of disc brakes



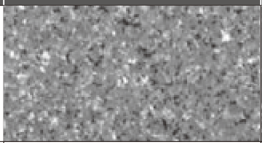
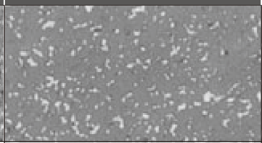
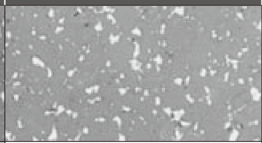
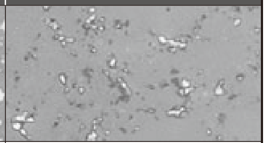
Cutting conditions
- Workpiece material: Disc rotor (JIS FC250)
- Insert: SNGN 120412 BXC90
- Depth of cut: ap = 0.7 mm
- Feed: f = 0.35 mm/rev
- Coolant: Dry
- Tool life criterion: Conditions of finished surface

PCD grade, DIA series

Expanded product line allows DIA tools to be applied to wider workpiece materials and cutting conditions.

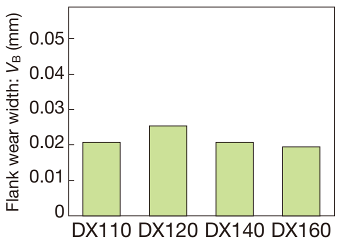


Features and applications (Physical and mechanical properties)

	DX110	DX120	DX140	DX160
Grade				
Property	Super fine grained grade. Excels in surface finish.	Fine grained grade. Excels in surface finish.	General purpose grade	High purity grade for hard materials
Approx. grain size of diamond (μm)	< 1	5	13	28
Hardness (Hv)	8500 →			10000 (Harder)
Wear resistance	→			Higher
Grindability (Cutting edge sharpness)	Better ←			

Cutting performance (Wear resistance)

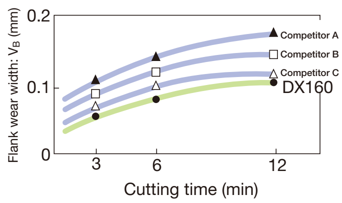
When machining aluminium alloy:



Continuous external turning

- Workpiece material: 10 % Si, aluminium alloy
- Insert: SPGN120308-DIA
- Toolholder: CSBPR2525M4
- Cutting speed: v_c = 500 m/min
- Feed: f = 0.1 mm/rev
- Depth of cut: a_p = 0.5 mm
- Coolant: Dry cutting
- Cutting time: 30 min

When machining FRP:



Face milling

- Workpiece material: Fiber reinforced plastics (FRP)
- Insert: SFCN42ZFN-DIA
- Milling cutter: THF4408RIA
- Cutting speed: v_c = 942 m/min
- Feed: f = 0.1 mm/rev
- Depth of cut: a_p = 1.5 mm
- Coolant: Dry cutting

Grade selection guide

First choice
Excellent finish
DX110
Suitable for finishing aluminum alloys and copper alloy

→ Good electrical discharge machinability → **Complex shape tools** **DX120**

→ High diamond content compared to DX110. Suitable for high-speed machining → **High speed machining** **DX140**

→ Ideal for machining hard materials
Suited for machining bi-metal (ex.aluminum+cast iron) components → **High wear resistance** **DX160**

STANDARD CUTTING CONDITIONS

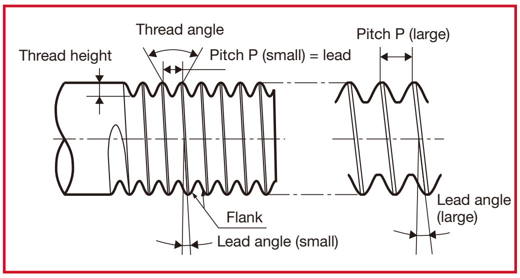
ISO	Workpiece material	Grade DX110	DX120	DX140	DX160	Cutting speed v_c (m/min)	Depth of cut a_p (mm)	Feed f (mm/rev)
N	Aluminium alloys (Si < 12 %)	◎	○	○		1500 (1000 - 2500)	0.5 (0.05 - 2.0)	0.1 (0.05 - 0.2)
	Aluminium alloys (Si ≥ 12 %)	◎	○	○	○	600 (400 - 800)	0.5 (0.05 - 2.0)	0.1 (0.05 - 0.2)
	Copper, brass	◎	○			800 (500 - 1500)	0.5 (0.05 - 2.0)	0.1 (0.05 - 0.2)
	Phosphor bronze	◎	○	○		400 (300 - 500)	0.5 (0.05 - 2.0)	0.1 (0.05 - 0.2)
	Carbon, graphite		○	○	◎	400 (300 - 500)	0.5 (0.05 - 2.0)	0.1 (0.05 - 0.2)
	FRP		○	○	◎	700 (500 - 1000)	0.2 (0.05 - 0.5)	0.05 (0.03 - 0.1)
	Plastics	◎	○	○		700 (500 - 1000)	0.2 (0.05 - 0.5)	0.03 (0.01 - 0.05)
	Cemented carbides			○	◎	15 (10 - 20)	0.1 (0.05 - 0.2)	0.03 (0.01 - 0.05)
	Green ceramics			○	◎	130 (100 - 150)	0.5 (0.05 - 2.0)	0.05 (0.03 - 0.1)

(Note) ◎ : First choice ○ : Second choice

Fundamentals of screw threads

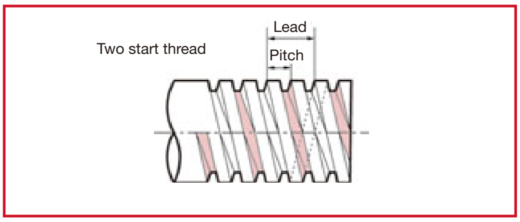
Relationship between lead, lead angle and pitch

1. Lead is the axial distance a screw advances in one rotation. In single start screw, the lead is equal to the pitch.
2. The inclination angle of a threaded groove is called lead angle. In screws of the same diameter, the lead angle increases as the pitch increases.
3. The side face of a completed thread groove is called flank. The distance between the crest and the root is called thread height.



Single and multi start thread

1. The single start thread has a single groove. Two start thread or three start thread has two grooves or three grooves respectively.
2. The pitch of multi start thread is the distance of adjoining groove.
3. When viewing the section of the multi start thread, the pitch is same as that of the single start thread. The lead of the two or three start thread is twice or three times the pitch. The multi start thread is mainly used for trapezoidal threads.



Tolerance class of threads

Tolerance classes of screw threads are expressed as follows:
Metric coarse external thread: 6h, 6g Metric coarse internal thread: 5H, 6H
These classes are ranked with tolerances of thread diameter, pitch, thread angle, etc. For fastening applications, 6H- and 6g-class (former JIS second class) threads, manufactured by cutting or rolling, are generally used. 5H- and 4h-class threads (former JIS first class) are generally finished by grinding.
For example, M8-6g means metric coarse external thread of 6g tolerance class.

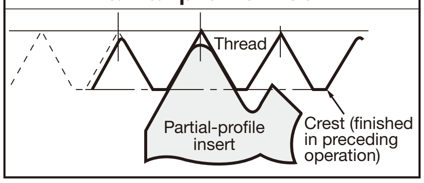
TAC threading insert

Difference between full-profile and partial-profile insert

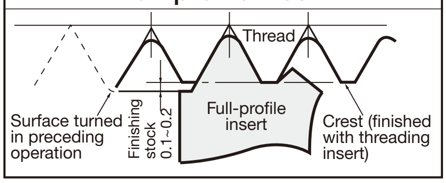
Full-profile insert

In the full-profile insert, the major diameter of the thread is finished by the profiled finishing edge as shown in Figure below. Therefore, about 0.1 mm of finishing stock must be left on the outer surface of the workpiece before threading. In trapezoidal threads, since slants of 15° to 30° are left on the crest of the thread as shown in Figure below, these portions must be finished by another tool later.
Full-profile insert could produce no burr and good thread by the profiled finishing edge.

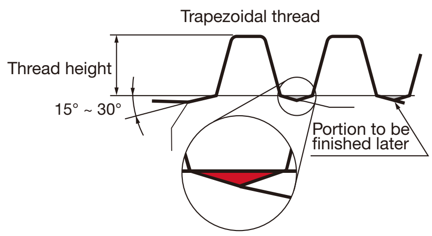
Partial-profile insert



Full-profile insert



When machining trapezoidal threads:



Partial-profile insert

Partial-profile inserts can not be used for finishing of the crest, but can be applied to a wide range of pitches.

For example

Designation	Pitch (mm)	TPI	Insert radius RE (mm)
16ERA60	0.5 ~ 1.5	48 ~ 16	0.06
16ERG60	1.75 ~ 3	14 ~ 8	0.22

Corner radii of inserts are fitted to the thread of the smallest pitch.

Difference between external and internal use inserts

In full-profile inserts for metric and unified threads, the corner radius and thread height differ from those for the external and internal use insert respectively. Therefore, the right hand insert for external use and the left hand insert for internal use are not the same tool.
Since the rake angles of toolholders are -10° for external toolholders and -15° for internal toolholders, the external / internal toolholders can not be used for machining internal / external thread.
In Whitworth thread, though the external thread and internal thread have the same thread form, the external and internal toolholders are incompatible because of the different rake angle.

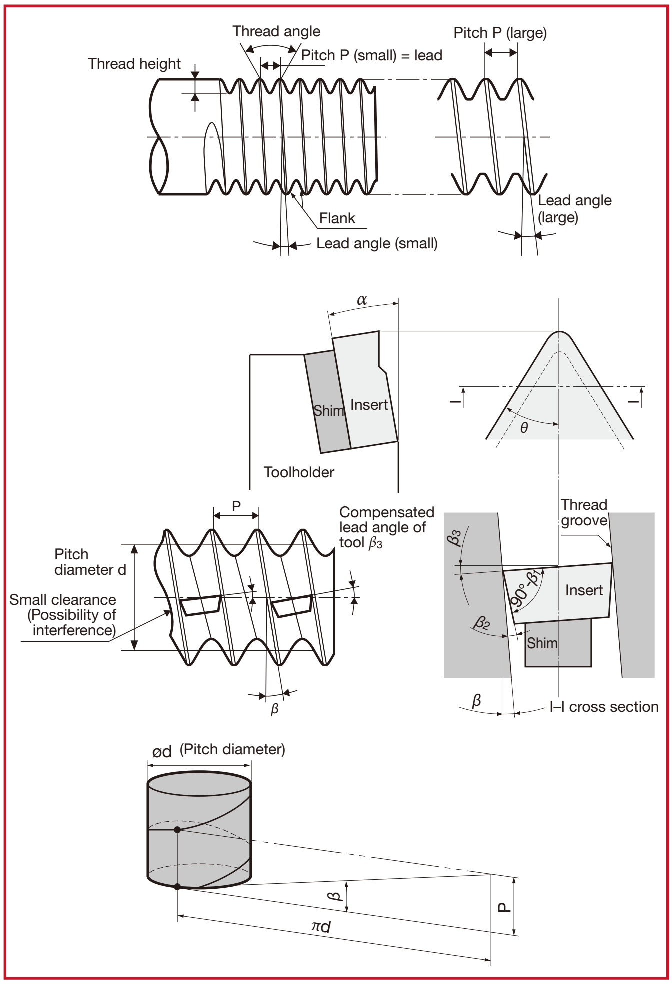
For example

Designation	Applicable inserts	Insert radius R RE (mm)	Thread hight (mm)	Rake angle of holders
16ER20ISO	External	0.25	1.52	-10°
16IL20ISO	Internal	0.14	1.3	-15°

Shim replacement method of ST-type tools

Compensated lead angle of tool and tool relief angle

When the pitch is large or the screw diameter is small, the lead angle becomes large and the effective relief angle on the advance flank side β_2 becomes small. In particular, this will cause shorter life of the insert in the case of trapezoidal screw with small flank angle. It is ideal without any interference for the thread cutting insert to have an equal relief angle on both right and left. Replace the shim so that the rake face of insert faces the thread groove direction (that is, $\beta = \beta_3$).



Calculating the thread lead angle

The thread lead angle is calculated as follows:

$$\beta = \tan^{-1}(\ell/\pi d) = \tan^{-1}(nP/\pi d)$$

β : Thead lead angle
ℓ : Lead
n : No. of threads
P : Pitch
d : Pitch diameter

Calculating the relief angle of tool

The relief angle β_1 is calculated as follows:

$$\beta_1 = \tan^{-1}(\tan\theta \cdot \tan\alpha)$$

The α of a standard toolholder is 10° for external threading and 15° for internal threading.

Included angle 2θ	θ	β_1	
		External threading tool	Internal threading tool
60°	30°	5.8°	8.8°
55°	27.5°	5.2°	7.9°
30°	15°	2.7°	4.1°
29°	14.5°	2.6°	4°

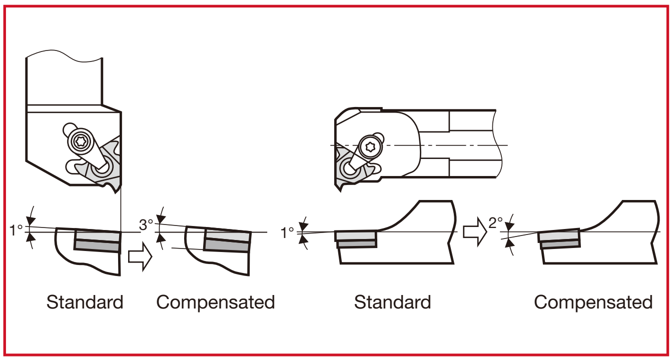
Accordingly, the effective relief angle is calculated as follows:

$$\beta_2 = \beta_1 + \beta_3 - \beta$$

β : Thread lead angle
β_2 : Effective relief angle of tool
β_3 : Compensated lead angle of tool

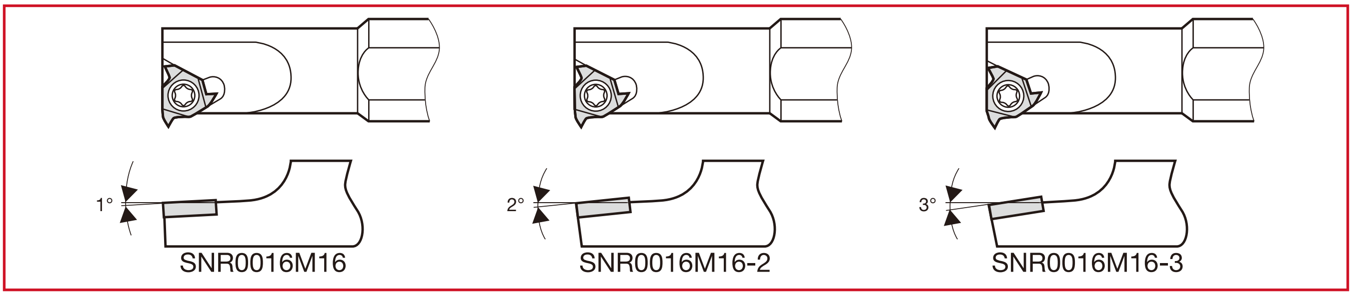
In other words, $\beta_1 = \beta_2$ when the thread lead angle is equal to the compensated lead angle of tool. Namely, the relief angle of the tool itself is equal to the effective relief angle. If the wrong compensated lead angle is used, $\beta_1 > \beta_2$. The effective relief angle becomes smaller and cause the interference between the frank side of insert and the thread groove. Therefore, carry out compensation of the lead angle so that the following range is obtained:

±1° when the thread angle is 60° and 55°
±0.5° when the thread angle is 30° and 29°



Compensation of lead angle for shim less internal toolholders

When using internal threading toolholders without shim, the above-mentioned method can not be applied for lead angle compensation. Therefore, special toolholders for large lead angles are available as shown below. The final figure of the designation (-2 or -3) indicates 2° or 3° lead angle to be used respectively. For the toolholders without these figures, please check GAMP of toolholders by catalog.



Type of shim and compensated lead angle of tool

The designation of the shim and compensated lead angles of tool are shown in the table.

Compensated lead angles of tool $\beta 3$	-2°	-1°	0°	1°	2°	3°	4°
Shim	□□□-98	□□□-99	□□□-0	□□□-1	□□□-2	□□□-3	□□□-4

Note: The last numeral of the shim designation is the compensated lead angle.v

Toolholders and applicable shims

Shim replacement method of ST-type tools

Screw-on / clamp-on dual toolholders

Toolholder designation	Shim	
	R	L
CER/L □□□□□ 16DT	AE16-□DT	AN16-□DT
CER/L □□□□□ 22DT	GXE22-□DT	GXN22-□DT
TCNR/L □□□□□ 16DT	AN16-□DT	AE16-□DT
TCNR/L □□□□□ 22DT	GXN22-□DT	GXE22-□DT

Note: Standard shim is AE16-1DT or GX22-1DT. Other types are optional.

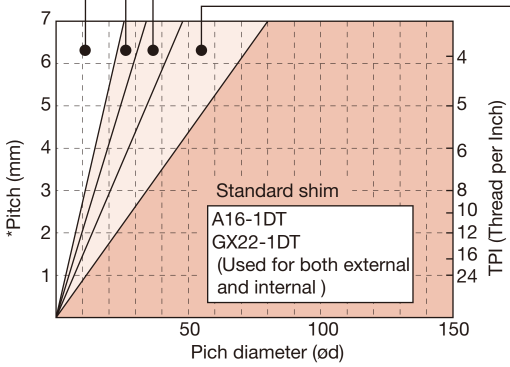
Clamp-on type toolholders

Toolholder designation	Shim	
	R	L
CER/L □□□□□ 16-T	AE16-□	AN16-□
CER/L □□□□□ 22-T	NXE22-□	NXN22-□
CER/L □□□□□ 27-T	NXE27-□	NXN27-□
CNR/L □□□□□ 16	AN16-□	AE16-□
CNR/L □□□□□ 22	NXN22-□	NXE22-□
CNR/L □□□□□ 27	NXN27-□	NXE27-□
B-CER/L □□□ 16	AE16-□	AN16-□

Note: Standard shim is □□□□□-1. Other types are optional.

Shim selection guide for screw-on / clamp-on dual ST-type tools

Need special toolholders



AE16-4DT AN16-4DT GXE22-4DT GXN22-4DT	AE16-3DT AN16-3DT GXE22-3DT GXN22-3DT	AE16-2DT AN16-2DT GXE22-2DT GXN22-2DT

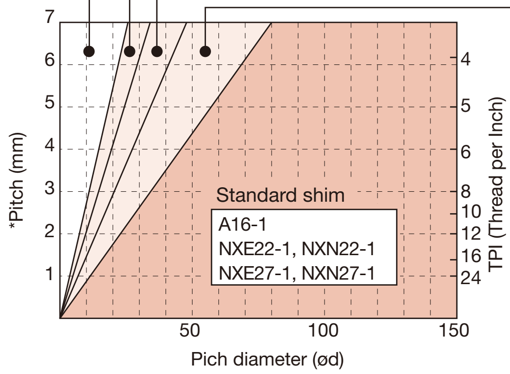
* For the multi start thread lead (multiplied by the pitch and No. of threads)

● List of exchangeable shims

	Designation	D30	Designation	D30	Designation	D30	Designation	D30
$\beta 3$ = 4°	**AE16-4DT**	●	**AN16-4DT**	●	**GXE22-4DT**	●	**GXN22-4DT**	●
$\beta 3$ = 3°	**AE16-3DT**	●	**AN16-3DT**	●	**GXE22-3DT**	●	**GXN22-3DT**	●
$\beta 3$ = 2°	**AE16-2DT**	●	**AN16-2DT**	●	**GXE22-2DT**	●	**GXN22-2DT**	●
$\beta 3$ = 1° Standard shim	**A16-1DT**	●	**A16-1DT**	●	**GX22-1DT**	●	**GX22-1DT**	●
$\beta 3$ = 0°	**AE16-0DT**	●	**AN16-0DT**	●	**GXE22-0DT**	●	**GXN22-0DT**	●
$\beta 3$ = -1°	**AE16-99DT**	●	**AN16-99DT**	●	**GXE22-99DT**	●	**GXN22-99DT**	●
$\beta 3$ = -2°	**AE16-98DT**	●	**AN16-98DT**	●	**GXE22-98DT**	●	**GXN22-98DT**	●
Applicable toolholders	CER--16DT TCNL--16DT		CEL--16DT TCNR--16DT		CER--22DT TCNL--22DT		CEL--22DT TCNR--22DT	

Shim selection guide for clamp-on type ST-tools

Need special toolholders



AE16-4, AN16-4 NXE22-4, NXN22-4 NXE27-4, NXN27-4	AE16-3, AN16-3 NXE22-3, NXN22-3 NXE27-3, NXN27-3	AE16-2, AN16-2 NXE22-2, NXN22-2 NXE27-2, NXN27-2

* For the multi start thread lead (multiplied by the pitch and No. of threads)

● List of exchangeable shims

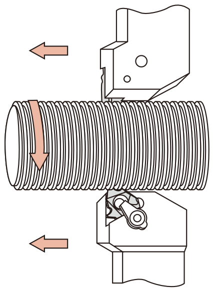
	Designation	D30	Designation	D30	Designation	D30	Designation	D30	Designation	D30	Designation	D30
$\beta 3$ = 4°	**AE16-4**	●	**AN16-4**	●	**NXE22-4**	●	**NXN22-4**	●	**NXE27-4**		**NXN27-4**	
$\beta 3$ = 3°	**AE16-3**	●	**AN16-3**	●	**NXE22-3**	●	**NXN22-3**	●	**NXE27-3**		**NXN27-3**	
$\beta 3$ = 2°	**AE16-2**	●	**AN16-2**	●	**NXE22-2**	●	**NXN22-2**	●	**NXE27-2**		**NXN27-2**	
$\beta 3$ = 1° Standard shim	**A16-1**	●	**A16-1**	●	**NXE22-1**	●	**NXN22-1**	●	**NXE27-1**	●	**NXN27-1**	●
$\beta 3$ = 0°	**AE16-0**	●	**AN16-0**	●	**NXE22-0**	●	**NXN22-0**	●	**NXE27-0**		**NXN27-0**	
$\beta 3$ = -1°	**AE16-99**	●	**AN16-99**	●	**NXE22-99**	●	**NXN22-99**	●	**NXE27-99**		**NXN27-99**	
$\beta 3$ = -2°	**AE16-98**	●	**AN16-98**	●	**NXE22-98**	●	**NXN22-98**	●	**NXE27-98**		**NXN27-98**	
Applicable toolholders	CER--16T CNL--16 B-CER--16		CEL--16T CNR--16 B-CEL--16		CER--22T CNL--22		CEL--22T CNR--22		CER--27T CNL--27		CEL--27T CNR--27	

● : Line up

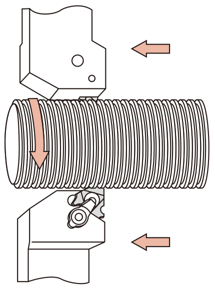
Threading Methods and Combinations

External threading

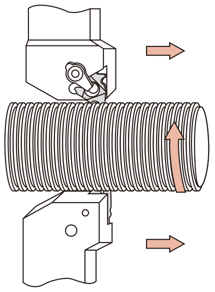
Right hand thread



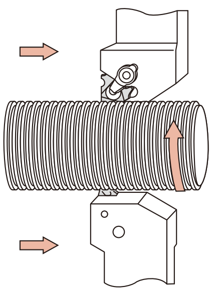
Work rotation	Regular
Feed direction	Push
Hand of toolholder	Right
Hand of insert	Right
Standard shim	①



Work rotation	Regular
Feed direction	Pull
Hand of toolholder	Left
Hand of insert	Left
Standard shim	④

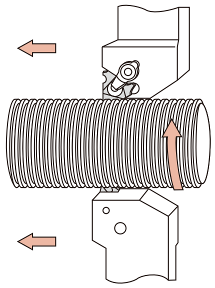


Work rotation	Reverse
Feed direction	Push
Hand of toolholder	Right
Hand of insert	Right
Standard shim	①

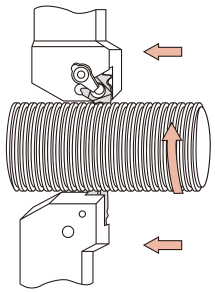


Work rotation	Reverse
Feed direction	Pull
Hand of toolholder	Left
Hand of insert	Left
Standard shim	④

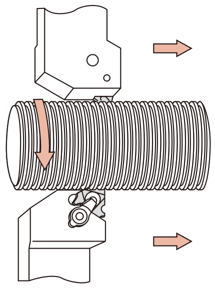
Left hand thread



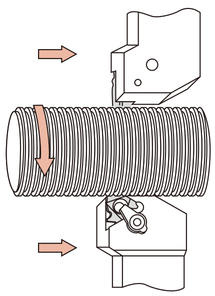
Work rotation	Reverse
Feed direction	Push
Hand of toolholder	Left
Hand of insert	Left
Standard shim	②



Work rotation	Reverse
Feed direction	Pull
Hand of toolholder	Right
Hand of insert	Right
Standard shim	③



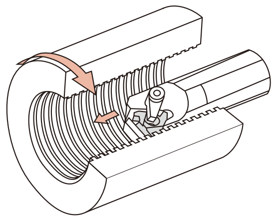
Work rotation	Regular
Feed direction	Push
Hand of toolholder	Left
Hand of insert	Left
Standard shim	②



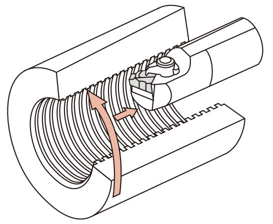
Work rotation	Regular
Feed direction	Pull
Hand of toolholder	Right
Hand of insert	Right
Standard shim	③

Internal threading

Right hand thread

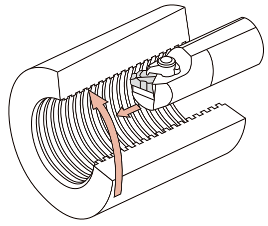


Work rotation	Regular
Feed direction	Push
Hand of toolholder	Right
Hand of insert	Right
Standard shim	②

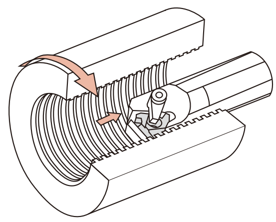


Work rotation	Reverse
Feed direction	Pull
Hand of toolholder	Left
Hand of insert	Left
Standard shim	③

Left hand thread



Work rotation	Reverse
Feed direction	Push
Hand of toolholder	Left
Hand of insert	Left
Standard shim	①



Work rotation	Regular
Feed direction	Pull
Hand of toolholder	Right
Hand of insert	Right
Standard shim	④

Standard shim

No.	New	No.	New
①	A16-1DT	②	A16-1DT
	A16-1		A16-1
	GX22-1DT		GX22-1DT
	NXE22-1		NXN22-1
	NXE27-1		NXN27-1
③	AE16-99DT	④	AN16-99DT
	AE16-99		AN16-99
	GXE22-99DT		GXN22-99DT
	NXE22-99		NXN22-99
	NXE27-99		NXN27-99

Infeed per Pass and Number of Passes

ISO metric full-profile inserts (for external)

	Pitch	0.5	0.75	1	1.25	1.5	1.75	2	2.5	3	3.5	4	4.5	5	5.5	6
	Height of thread	0.32	0.47	0.63	0.79	0.95	1.11	1.27	1.58	1.9	2.21	2.53	2.85	3.16	3.48	3.8
	Total depth of cut	0.42	0.57	0.73	0.89	1.05	1.21	1.37	1.68	2	2.31	2.63	2.95	3.26	3.58	3.9
Number of passes	1	0.15	0.18	0.25	0.25	0.3	0.3	0.3	0.3	0.35	0.35	0.4	0.4	0.45	0.5	0.5
	2	0.12	0.12	0.2	0.2	0.25	0.25	0.25	0.25	0.3	0.3	0.35	0.35	0.35	0.35	0.4
	3	0.1	0.12	0.13	0.15	0.2	0.2	0.2	0.25	0.25	0.3	0.3	0.3	0.3	0.3	0.3
	4	0.05	0.1	0.1	0.14	0.15	0.16	0.2	0.23	0.2	0.25	0.25	0.25	0.25	0.25	0.25
	5		0.05	0.05	0.1	0.1	0.15	0.15	0.2	0.2	0.21	0.2	0.2	0.25	0.23	0.25
	6				0.05	0.05	0.1	0.12	0.15	0.15	0.2	0.2	0.2	0.2	0.2	0.2
	7						0.05	0.1	0.15	0.15	0.15	0.15	0.2	0.2	0.2	0.2
	8							0.05	0.1	0.15	0.15	0.15	0.15	0.18	0.15	0.15
	9								0.05	0.1	0.15	0.15	0.15	0.15	0.15	0.15
	10									0.1	0.1	0.13	0.15	0.15	0.15	0.15
	11									0.05	0.1	0.1	0.15	0.13	0.15	0.15
	12										0.05	0.1	0.1	0.1	0.15	0.15
	13											0.1	0.1	0.1	0.15	0.15
	14											0.05	0.1	0.1	0.1	0.15
	15												0.1	0.1	0.1	0.1
	16												0.05	0.1	0.1	0.1
	17													0.1	0.1	0.1
	18													0.05	0.1	0.1
	19														0.1	0.1
	20														0.05	0.1
	21															0.1
	22															0.05
	23															
	24															

ISO metric full-profile inserts (for internal)

	Pitch	0.5	0.75	1	1.25	1.5	1.75	2	2.5	3	3.5	4	4.5	5	5.5	6
	Height of thread	0.29	0.43	0.58	0.72	0.87	1.01	1.16	1.45	1.74	2.03	2.32	2.61	2.9	3.19	3.48
	Total depth of cut	0.39	0.53	0.68	0.82	0.97	1.11	1.26	1.55	1.84	2.13	2.42	2.71	3	3.29	3.58
Number of passes	1	0.08	0.1	0.14	0.15	0.2	0.2	0.2	0.25	0.25	0.3	0.3	0.35	0.35	0.4	0.4
	2	0.07	0.09	0.13	0.13	0.16	0.18	0.18	0.22	0.22	0.25	0.25	0.25	0.25	0.25	0.25
	3	0.07	0.08	0.11	0.12	0.14	0.16	0.17	0.2	0.2	0.22	0.22	0.22	0.22	0.22	0.22
	4	0.06	0.08	0.1	0.11	0.12	0.14	0.16	0.18	0.18	0.2	0.2	0.2	0.2	0.2	0.2
	5	0.06	0.07	0.08	0.1	0.12	0.12	0.14	0.16	0.16	0.18	0.18	0.18	0.2	0.2	0.19
	6	0.05	0.06	0.07	0.09	0.1	0.1	0.12	0.15	0.15	0.16	0.18	0.18	0.18	0.18	0.18
	7		0.05	0.05	0.07	0.08	0.09	0.1	0.1	0.14	0.14	0.16	0.16	0.16	0.16	0.17
	8				0.05	0.05	0.07	0.08	0.1	0.13	0.13	0.14	0.14	0.14	0.14	0.16
	9						0.05	0.06	0.08	0.12	0.12	0.14	0.14	0.14	0.14	0.15
	10							0.05	0.06	0.1	0.11	0.12	0.12	0.13	0.13	0.14
	11								0.05	0.08	0.1	0.12	0.12	0.13	0.13	0.14
	12									0.06	0.1	0.1	0.12	0.12	0.13	0.13
	13									0.05	0.07	0.1	0.11	0.12	0.12	0.13
	14										0.05	0.09	0.1	0.12	0.12	0.13
	15											0.07	0.1	0.11	0.12	0.12
	16											0.05	0.09	0.1	0.12	0.12
	17												0.08	0.1	0.1	0.12
	18												0.05	0.1	0.1	0.1
	19													0.08	0.1	0.1
	20													0.05	0.1	0.1
	21														0.08	0.1
	22														0.05	0.1
	23															0.08
	24															0.05

Unified full-profile inserts

		For external							For internal						
	TPI	24	20	18	16	14	12	8	24	20	18	16	14	12	8
	Height of thread	0.67	0.8	0.89	1.01	1.15	1.34	2.01	0.61	0.74	0.82	0.92	1.05	1.23	1.84
	Total depth of cut	0.77	0.9	0.99	1.11	1.25	1.44	2.11	0.71	0.84	0.92	1.02	1.15	1.33	1.94
Number of passes	1	0.25	0.25	0.28	0.3	0.3	0.3	0.35	0.2	0.2	0.2	0.2	0.25	0.25	0.3
	2	0.22	0.2	0.23	0.25	0.25	0.25	0.3	0.16	0.16	0.18	0.18	0.2	0.2	0.25
	3	0.15	0.16	0.18	0.18	0.23	0.21	0.25	0.12	0.13	0.15	0.16	0.18	0.18	0.22
	4	0.1	0.14	0.15	0.15	0.18	0.18	0.22	0.1	0.12	0.14	0.14	0.16	0.16	0.2
	5	0.05	0.1	0.1	0.1	0.14	0.15	0.2	0.08	0.1	0.1	0.11	0.13	0.13	0.18
	6		0.05	0.05	0.08	0.1	0.12	0.2	0.05	0.08	0.1	0.1	0.1	0.1	0.16
	7				0.05	0.05	0.1	0.16		0.05	0.05	0.08	0.08	0.1	0.14
	8						0.08	0.16				0.05	0.05	0.08	0.12
	9						0.05	0.12						0.08	0.12
	10							0.1						0.05	0.1
	11							0.05							0.1
	12														0.05
	13														
	14														

Whitworth full-profile inserts

		For external									For internal								
	TPI	20	19	18	16	14	12	11	10	8	20	19	18	16	14	12	11	10	8
	Height of thread	0.83	0.88	0.92	1.04	1.19	1.39	1.51	1.66	2.08	0.83	0.88	0.92	1.04	1.19	1.39	1.51	1.66	2.08
	Total depth of cut	0.93	0.98	1.02	1.14	1.29	1.49	1.61	1.76	2.18	0.93	0.98	1.02	1.14	1.29	1.49	1.61	1.76	2.18
Number of passes	1	0.25	0.28	0.3	0.3	0.3	0.3	0.3	0.35	0.35	0.2	0.2	0.22	0.22	0.25	0.25	0.25	0.3	0.35
	2	0.2	0.22	0.24	0.25	0.25	0.25	0.25	0.3	0.3	0.18	0.18	0.18	0.18	0.21	0.21	0.21	0.25	0.3
	3	0.18	0.18	0.18	0.18	0.23	0.2	0.2	0.23	0.25	0.16	0.16	0.17	0.17	0.2	0.2	0.2	0.22	0.25
	4	0.15	0.15	0.15	0.14	0.2	0.18	0.18	0.2	0.23	0.14	0.16	0.16	0.16	0.18	0.18	0.18	0.2	0.22
	5	0.1	0.1	0.1	0.12	0.16	0.15	0.15	0.15	0.22	0.12	0.13	0.14	0.14	0.16	0.16	0.16	0.16	0.2
	6	0.05	0.05	0.05	0.1	0.1	0.14	0.14	0.14	0.2	0.08	0.1	0.1	0.12	0.14	0.14	0.14	0.14	0.18
	7				0.05	0.05	0.12	0.12	0.12	0.18	0.05	0.05	0.05	0.1	0.1	0.1	0.12	0.12	0.16
	8						0.1	0.12	0.12	0.16				0.05	0.05	0.1	0.1	0.12	0.14
	9						0.05	0.1	0.1	0.14						0.1	0.1	0.1	0.12
	10							0.05	0.05	0.1						0.05	0.1	0.1	0.11
	11									0.05							0.05	0.05	0.1
	12																		0.05
	13																		
	14																		
	15																		

Infeed per Pass and Number of Passes

30° Trapezoidal (TR) inserts

	For external					For internal				
Pitch	2	3	4	5	6	2	3	4	5	6
Height of thread	1.25	1.75	2.25	2.75	3.5	1.25	1.75	2.25	2.75	3.5
Total depth of cut	1.35	1.85	2.35	2.85	3.6	1.35	1.85	2.35	2.85	3.6
Number of passes 1	0.25	0.25	0.3	0.3	0.3	0.2	0.22	0.25	0.25	0.25
2	0.2	0.22	0.25	0.25	0.25	0.18	0.2	0.22	0.22	0.22
3	0.2	0.2	0.22	0.2	0.23	0.18	0.18	0.2	0.2	0.21
4	0.18	0.18	0.2	0.2	0.2	0.16	0.16	0.2	0.18	0.2
5	0.15	0.17	0.18	0.18	0.18	0.15	0.16	0.17	0.18	0.18
6	0.12	0.16	0.16	0.16	0.18	0.13	0.16	0.16	0.16	0.18
7	0.1	0.14	0.15	0.16	0.16	0.1	0.14	0.16	0.16	0.16
8	0.1	0.14	0.14	0.15	0.16	0.1	0.14	0.14	0.15	0.16
9	0.05	0.12	0.14	0.14	0.16	0.1	0.12	0.14	0.14	0.16
10		0.12	0.12	0.14	0.16	0.05	0.12	0.12	0.14	0.16
11		0.1	0.12	0.14	0.16		0.1	0.12	0.14	0.16
12		0.05	0.12	0.12	0.15		0.1	0.12	0.12	0.15
13			0.1	0.12	0.15		0.05	0.1	0.12	0.15
14			0.1	0.12	0.15			0.1	0.12	0.15
15			0.05	0.12	0.14			0.1	0.12	0.14
16				0.1	0.14			0.05	0.1	0.14
17				0.1	0.12				0.1	0.12
18				0.1	0.12				0.1	0.12
19				0.05	0.12				0.1	0.12
20					0.12				0.05	0.12
21					0.1					0.1
22					0.1					0.1
23					0.05					0.1
24										0.05
25										
26										

29° Trapezoidal (TR) inserts

	For external			For internal		
TPI	8	6	5	8	6	5
Height of thread	1.88	2.41	2.92	1.88	2.41	2.92
Total depth of cut	1.98	2.51	3.02	1.98	2.51	3.02
Number of passes 1	0.25	0.25	0.25	0.22	0.22	0.22
2	0.22	0.22	0.22	0.2	0.2	0.2
3	0.2	0.2	0.2	0.18	0.18	0.18
4	0.18	0.18	0.18	0.16	0.18	0.18
5	0.16	0.17	0.18	0.16	0.16	0.16
6	0.16	0.16	0.16	0.16	0.15	0.16
7	0.16	0.16	0.16	0.15	0.15	0.15
8	0.14	0.14	0.14	0.14	0.14	0.14
9	0.14	0.14	0.14	0.14	0.14	0.14
10	0.12	0.14	0.14	0.12	0.14	0.14
11	0.1	0.14	0.14	0.1	0.14	0.14
12	0.1	0.12	0.14	0.1	0.12	0.14
13	0.05	0.12	0.12	0.1	0.12	0.12
14		0.12	0.12	0.05	0.12	0.12
15		0.1	0.12		0.1	0.12
16		0.1	0.12		0.1	0.12
17		0.05	0.12		0.1	0.12
18			0.12		0.05	0.12
19			0.1			0.1
20			0.1			0.1
21			0.05			0.1
22						0.05
23						
24						
25						
26						

PT full-profile inserts

	For external				For internal		
TPI	28	19	14	11	19	14	11
Height of thread	0.6	0.86	1.16	1.48	0.86	1.16	1.48
Total depth of cut	0.7	0.96	1.26	1.58	0.96	1.26	1.58
Number of passes 1	0.25	0.28	0.3	0.3	0.22	0.25	0.25
2	0.2	0.2	0.25	0.25	0.2	0.22	0.22
3	0.1	0.18	0.2	0.22	0.18	0.18	0.18
4	0.1	0.15	0.15	0.18	0.16	0.14	0.18
5	0.05	0.1	0.11	0.15	0.1	0.12	0.15
6		0.05	0.1	0.12	0.05	0.1	0.13
7			0.1	0.11	0.05	0.1	0.12
8			0.05	0.1		0.1	0.1
9				0.1		0.05	0.1
10				0.05			0.1
11							0.05
12							
13							
14							
15							
16							
17							
18							
19							
20							
21							
22							
23							
24							
25							
26							

NPT full-profile inserts

	For external				For internal		
TPI	18	14	11.5	8	14	11.5	8
Height of thread	1.14	1.47	1.79	2.58	1.47	1.79	2.58
Total depth of cut	1.24	1.57	1.89	2.68	1.57	1.89	2.68
Number of passes 1	0.2	0.25	0.25	0.3	0.22	0.22	0.25
2	0.18	0.22	0.22	0.25	0.2	0.2	0.2
3	0.17	0.2	0.2	0.2	0.18	0.18	0.2
4	0.16	0.18	0.18	0.2	0.18	0.18	0.2
5	0.14	0.17	0.18	0.2	0.16	0.16	0.2
6	0.12	0.16	0.17	0.2	0.14	0.16	0.2
7	0.12	0.12	0.16	0.18	0.12	0.16	0.18
8	0.1	0.12	0.14	0.18	0.12	0.14	0.18
9	0.05	0.1	0.12	0.16	0.1	0.12	0.16
10		0.05	0.12	0.16	0.1	0.12	0.16
11			0.1	0.14	0.05	0.1	0.14
12			0.05	0.14		0.1	0.14
13				0.12		0.05	0.12
14				0.1			0.1
15				0.1			0.1
16				0.05			0.1
17							0.05
18							
19							
20							
21							
22							
23							
24							
25							
26							

Standard Cutting Conditions and Infeed Method

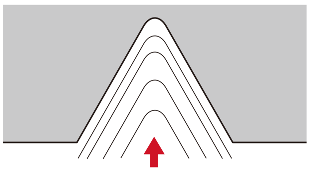
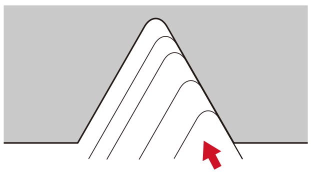
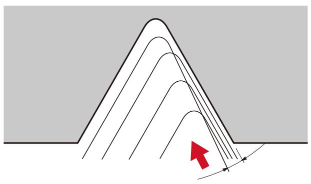
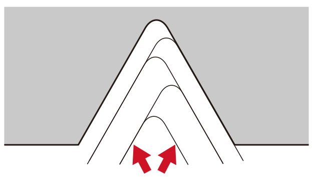
Threading guidelines

Determine the infeed per pass and number of threads whilst referring to the table and description below.

Pitch	0.5	0.75	1	1.25	1.5	1.75	2	2.5	3	3.5	4	4.5	5 ~
TPI	48	32	24	20	16	14	12	10	8	7	6	5.5	5 ~
No. of passes	4 ~ 6	4 ~ 7	4 ~ 8	5 ~ 9	6 ~ 10	7 ~ 12	7 ~ 12	8 ~ 14	10 ~ 16	11 ~ 18	11 ~ 18	11 ~ 19	12 ~ 24

Note:
- When using the full-profile insert, set the total infeed amount by taking the finish stock of 0.1mm into account.
- Set the first infeed to 150 ~ 200% of nose R and do not allow it to exceed 0.5 mm.
- The infeed amount during the final pass must be a minimum of 0.05 mm. No zero cuts should be made. (Extra small infeed or zero cutting of work hardened surfaces will reduce tool life.)
- The partial-profile insert or inside diameter insert has small nose R. Reduce the infeed per pass and increase the no. of passes.
- Regarding standard infeed per passes and no. of passes, please refer to page L033.

Infeed methods for threading tools

Infeed method	Features
 Straight infeed (radial infeed)	• Most simple and usual method Suitable for relatively small pitch threads of easily machinable material. • Chip contact length on right and left is longer, causing chattering, with increased load on the nose end. • When the half included angle is not symmetrical to the right and left, infeeding in the direction of 1/2 of the included angle will ensure equal machining with right and left cutting edges.
 Single edge infeed (flank infeed)	• Suitable for large pitch threads or easy to tear materials. Effectively prevents chattering. • Chips are discharged in one direction only. Satisfactory chip control. • Edge on the right (with zero infeed) tends to be worn heavily.
 Modified single-edge infeed (flank infeed)	• Suitable for large pitch threads or easy to tear materials. Effectively prevents chattering. • Chips are discharged in one direction only. Satisfactory chip control. • Edge on the right performs some cutting, therefore wear of this edge can thus be suppressed.
 Alternating flank infeed	• Suitable for large pitch threads or easy to tear material. Effectively prevents chattering. • Chips are discharged alternately in right and left directions, resulting possibly in entanglement. • Right and left edges are used alternately, ensuring uniform wear and extending tool life.

Selection of ST-type Toolholders

Selection of internal threading toolholders

Relation between internal toolholders and machinable threads

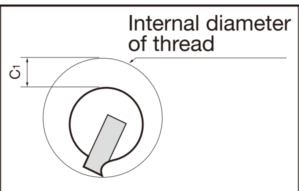
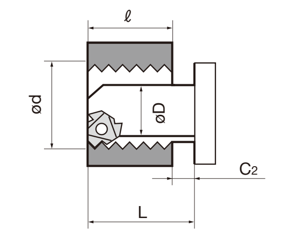
In the tables starting from next page, the relationships between toolholders, inserts, threads to be machined, and shims to be replaced are shown. In these tables, the criteria are set as follows.

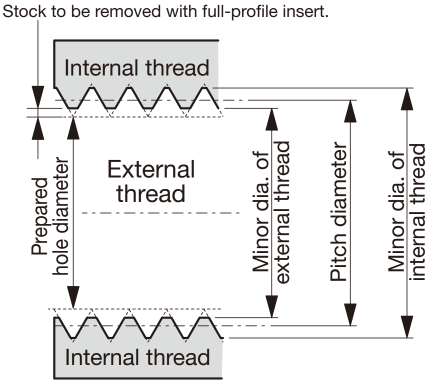
- **The minimum machining diameter.**
- **The L/D ratio of the toolholder.**
- **The lead angle of the thread.**
- **Cutting conditions**

Especially when machining near the minimum machining diameter, the compensation for the lead angle should be done carefully.
Moreover, in threading, because chips generally can not be broken into small pieces, the shank size should be selected in consideration of adequate clearance (C_1).

Symbols

- ○ Recommended
- • Usable
- 2 Needs replacing of the shim. "2" indicates "Change to the shim for 2° lead angle".
- (grey) Unusable

Clearance C_1		$C_1 \geq 3$ mm (1 mm for 6IR insert holders)
Overhang ratio L/D		Steel shank: L/D ≤ 2→○ Carbide shank: L/D ≤ 3→○



How to use the tables

①Firstly, find the nominal thread diameter. Example: M35 X 1.5
②The table indicates that the lead angle is 0°48′.
③The Cat. No. of the insert to be used corresponds with IR15ISO.
④By following the row to the right, • and ○ marks are found. The ○ mark indicates the optimum toolholder type. The toolholders of • mark are usable, but less rigid because the shank diameter against the threading diameter is smaller than those of ○ marked toolholder. In this example, CNR0025R16 and TCNR0020R16DT are the optimum toolholders. The insert Cat.No. is 16IR15ISO.
⑤In the case of M33 X 3 thread, the lead angle is 1°46′. By following the row to the right. 2 mark is found. This indicates that the shim should be replaced to 2° type. For calculation of the lead angle, refer to page L030.

Metric fine screw thread (ISO)

(For full size of this table, see page L038.)

Nominal size	Pitch	Effective diameter	Lead angle	Shank material / Insert size / Holder Cat. No. / Insert Cat. No.	Steel shank 6IR SNR0006H06-2	SNR0006H06-3	SNR0008H06-2	SNR0008H06-3	11IR SNR0010K11	SNR0010K11-2	SNR0013L11	SNR0013L11-2	16IR SNR0016M16	SNR0016M16-2	CNR0020P16	CNR0025R16	CNR0032S16	22IR SNR0020Q22	SNR0020Q22-2	CNR0025R22	CNR0032S22	Carbide shank 6IR SNR0006K06SC-2	SNR0006K06SC-3	SNR0008K06SC-2	SNR0008K06SC-3	11IR SNR0010M11SC	SNR0010M11SC-2	SNR0012P11SC	SNR0012P11SC-2	16IR SNR0016R16SC	SNR0016R16SC-2	"Tsuppari-Ichiban" 16IR TSNR0016Q16	TCNR0020R16DT	TCNR0025S16DT	(TCNR0032T16DT)	22IR TSNR0020R22	TCNR0025S22DT
M33×1.5	1.5	32.03	0°51′	IR15ISO					•		•		•		○											•		•		•		•	○				
M33×2	2	31.7	1°09′	IR20ISO	•		•		•		•		•		•	○						•		•		•		•		•		•	○				
M33×3	3	31.05	1°46′	IR30ISO											2																	•	2				
M35×1.5	1.5	34.03	0°48′	IR15ISO					•		•		•		•	○										•		•		•		•	○				
M36×1.5	1.5	35.03	0°47′	IR15ISO					•		•		•		•	○										•		•		•		•	○				
M36×2	2	34.7	1°03′	IR20ISO											•	○						•		•		•		•		•		•	○				
M36×3	3	34.05	[illegible]																													•	2				
M38×1.5	1.5	[illegible]																								•		•		•		•	•	○			
																										•		•		•		•	•				

Selection of Internal Toolholders—Relationship between thread sizes, toolholders, and inserts—Part 1

Metric coarse screw thread (ISO)

Shank material					Steel shank																	Carbide shank								"Tsuppari-Ichiban"	
Insert size					6IR				11IR				16IR		22IR					27IR		6IR				11IR		16IR		22IR	
Nominal size	Pitch	Pitch diameter	Lead angle	Insert Cat. No. \ Holder Cat. No.	SNR0006H06-2	SNR0006H06-3	SNR0008H06-2	SNR0008H06-3	SNR0010K11-2	SNR0010K11-3	SNR0013L11-2	SNR0013L11-3	SNR0016M16-2	SNR0016M16-3	SNR0020Q22-2	SNR0020Q22-3	CNR0025R22	CNR0032S22	(CNR0040T22)	CNR0040T27	(CNR0050U27)	SNR0006K06SC-2	SNR0006K06SC-3	SNR0008K06SC-2	SNR0008K06SC-3	SNR0010M11SC-2	SNR0010M11SC-3	SNR0016R16SC-2	(SNR0016R16SC-3)	TCNR0025S22DT	(TCNR0032T22DT)
M10	1.5	9.03	3°02′	IR15ISO																											
M11	1.5	10.03	2°44′	IR15ISO		○																	○								
M12	1.75	10.86	2°56′	IR175ISO		○																	○								
M14	2	12.7	2°52′	IR20ISO		•		○															•		○						
M16	2	14.7	2°29′	IR20ISO	•		○															•		○							
M18	2.5	16.38	2°47′	IR25ISO																											
M20	2.5	18.38	2°29′	IR25ISO																											
M22	2.5	20.38	2°14′	IR25ISO																											
M24	3	22.05	2°29′	IR30ISO																											
M27	3	25.05	2°11′	IR30ISO									○															○			
M30	3.5	27.73	2°18′	IR35ISO																											
M33	3.5	30.73	2°05′	IR35ISO											○																
M36	4	33.4	2°11′	IR40ISO											○																
M39	4	36.4	2°00′	IR40ISO											•		2													2	
M42	4.5	39.08	2°06′	IR45ISO											•		2													2	
M45	4.5	42.08	1°57′	IR45ISO											•		2													2	
M48	5	44.75	2°02′	IR50ISO											•		2	2												2	2
M52	5	48.75	1°52′	IR50ISO											•		2	2												2	2
M56	5.5	52.43	1°55′	IR55ISO																											
M60	5.5	56.43	1°47′	IR55ISO																2											
M64	6	60.1	1°49′	IR60ISO																2											
M68	6	64.1	1°42′	IR60ISO																2	2										

2 : Change the shim to NXN22-2

2 : Change the shim to NXN27-2

2 : Change the shim to GXN22-2DT

Metric fine screw thread (ISO)

1/4

Shank material					Steel shank														Carbide shank						
Insert size					6IR				11IR						6IR				11IR					
Nominal size	Pitch	Pitch diameter	Lead angle	Insert Cat. No. \ Holder Cat. No.	SNR0006H06-2	SNR0006H06-3	SNR0008H06-2	SNR0008H06-3	SNR0010K11	SNR0010K11-2	SNR0010K11-3	SNR0013L11	SNR0013L11-2	SNR0013L11-3	SNR0006K06SC-2	SNR0006K06SC-3	SNR0008K06SC-2	SNR0008K06SC-3	SNR0010M11SC	SNR0010M11SC-2	SNR0010M11SC-3	SNR0012P11SC	SNR0012P11SC-2	SNR0012P11SC-3
M9×0.75	0.75	8.51	1°36′	IR075ISO																				
M9×1	1	8.32	2°11′	IR10ISO																				
M10×0.75	0.75	9.51	1°26′	IR075ISO																				
M10×1	1	9.35	1°57′	IR10ISO	○										○									
M10×1.25	1.25	9.19	2°29′	IR125ISO																				
M11×0.75	0.75	10.51	1°18′	IR075ISO																				
M11×1	1	10.35	1°46′	IR10ISO	○										○									
M12×1	1	11.35	1°36′	IR10ISO	•		○								•		○							
M12×1.25	1.25	11.19	2°02′	IR125ISO	○										○									
M12×1.5	1.5	11.03	2°29′	IR15ISO	○										○									
M14×1	1	13.35	1°22′	IR10ISO																				
M14×1.25	1.25	13.19	1°44′	IR125ISO	•		○								•		○							
M14×1.5	1.5	13.03	2°06′	IR15ISO	•		○								•		○							
M15×1	1	14.35	1°16′	IR10ISO																				
M15×1.5	1.5	14.03	1°57′	IR15ISO	•		○								•		○							
M16×1	1	15.35	1°11′	IR10ISO					○															
M16×1.5	1.5	15.03	1°49′	IR15ISO	•		○								•		○							
M17×1	1	16.35	1°07′	IR10ISO					○										○					
M17×1.5	1.5	16.03	1°42′	IR15ISO	•		•			○					•		○							
M18×1	1	17.35	1°03′	IR10ISO					○										○					
M18×1.5	1.5	17.03	1°36′	IR15ISO	•		•			○					•		•			○				
M18×2	2	16.7	2°11′	IR20ISO	•		•			○					•		•			○				
M20×1	1	19.35	0°57′	IR10ISO					•			○							•			○		
M20×1.5	1.5	19.03	1°26′	IR15ISO					•			○							•			○		
M20×2	2	18.7	1°57′	IR20ISO	•		•			○					•		•			•			○	

Note : The above tables show correspondence of internal toolholders at the time of setting clearance between thread and toolholder to 3 mm (1 mm in case of SN type) and the finishing stock to 0.1 mm.

Selection of ST-type Toolholders

Metric fine screw thread (ISO)

2/4

Nominal size	Pitch	Pitch diameter	Lead angle	Shank material	Steel shank													Carbide shank														"Tsuppari-Ichiban"	
				Insert size	6IR				11IR					16IR				6IR				11IR						16IR				16IR	
				Holder Cat. No. / Insert Cat. No.	SNR0006H06-2	SNR0006H06-3	SNR0008H06-2	SNR0008H06-3	SNR0010K11	SNR0010K11-2	SNR0013L11	SNR0013L11-2	SNR0013L11-3	SNR0016M16	SNR0016M16-2	SNR0016M16-3	CNR0020P16	SNR0006K06SC-2	SNR0006K06SC-3	SNR0008K06SC-2	SNR0008K06SC-3	SNR0010M11SC	SNR0010M11SC-2	SNR0010M11SC-3	SNR0012P11SC	SNR0012P11SC-2	SNR0012P11SC-3	SNR0016R16SC	SNR0016R16SC-2	(SNR0016R16SC-3)	TSNR0016Q16	TCNR0020R16DT	TCNR0025S16DT
M22×1	1	21.35	0°51′	IR10ISO					•		○											•			○								
M22×1.5	1.5	21.03	1°18′	IR15ISO	•		•		•		○								•		•		•			○							
M22×2	2	20.7	1°46′	IR20ISO	•		•			•		○						•		•			•			○							
M24×1	1	23.35	0°47′	IR10ISO							○			•								•			○						•		
M24×1.5	1.5	23.03	1°11′	IR15ISO	•		•				○			•				•		•		•			○						•		
M24×2	2	22.07	1°39′	IR20ISO	•		•			•		○						•		•			•			○							
M25×1	1	24.35	0°45′	IR10ISO					•		○			•											○			•			•		
M25×1.5	1.5	24.03	1°08′	IR15ISO	•		•		•		○			•				•		•					○			•			•		
M25×2	2	23.7	1°32′	IR20ISO	•		•			•		○			•			•		•			•			○							
M26×1.5	1.5	25.03	1°06′	IR15ISO	•		•		•		•			○				•		•		•			•			•			○		
M27×1	1	26.35	0°42′	IR10ISO					•		•			○								•			•			•			○		
M27×1.5	1.5	26.03	1°03′	IR15ISO	•		•		•		•			○				•		•		•			•			•			○		
M27×2	2	25.7	1°25′	IR20ISO	•		•		•		•			○				•		•		•			•			•			○		
M28×1	1	27.35	0°40′	IR10ISO					•		•			○								•			•			•			○		
M28×1.5	1.5	27.03	1°01′	IR15ISO	•		•		•		•			○				•		•		•			•			•			○		
M28×2	2	26.7	1°22′	IR20ISO	•		•		•		•			○				•		•		•			•			•			○		
M30×1	1	29.35	0°37′	IR10ISO					•		•			○								•			•			•			○		
M30×1.5	1.5	29.03	0°57′	IR15ISO					•		•			○								•			•			•			○		
M30×2	2	28.7	1°16′	IR20ISO	•		•		•		•			○				•		•		•			•			•			○		
M30×3	3	28.05	1°57′	IR30ISO											○														○				
M32×1.5	1.5	31.03	0°53′	IR15ISO					•		•			○			○					•			•			•			•	○	
M32×2	2	30.07	1°11′	IR20ISO	•		•		•		•			○			○	•		•		•			•			•			•	○	

Metric fine screw thread (ISO)

3/4

Nominal size	Pitch	Pitch diameter	Lead angle	Shank material	Steel shank																	Carbide shank										"Tsuppari-Ichiban"					
				Insert size	6IR				11IR				16IR					22IR				6IR				11IR				16IR		16IR				22IR	
				Holder Cat. No. / Insert Cat. No.	SNR0006H06-2	SNR0006H06-3	SNR0008H06-2	SNR0008H06-3	SNR0010K11	SNR0010K11-2	SNR0013L11	SNR0013L11-2	SNR0016M16	SNR0016M16-2	CNR0020P16	CNR0025R16	CNR0032S16	SNR0020Q22	SNR0020Q22-2	CNR0025R22	CNR0032S22	SNR0006K06SC-2	SNR0006K06SC-3	SNR0008K06SC-2	SNR0008K06SC-3	SNR0010M11SC	SNR0010M11SC-2	SNR0012P11SC	SNR0012P11SC-2	SNR0016R16SC	SNR0016R16SC-2	TSNR0016Q16	TCNR0020R16DT	TCNR0025S16DT	(TCNR0032T16DT)	TSNR0020R22	TCNR0025S22DT
M33×1.5	1.5	32.03	0°51′	IR15ISO					•		•		•		○											•		•		•		•	○				
M33×2	2	31.7	1°09′	IR20ISO	•		•		•		•		•		•	○						•		•		•		•		•		•	○				
M33×3	3	31.05	1°46′	IR30ISO											[2]																	•	[2]				
M35×1.5	1.5	34.03	0°48′	IR15ISO					•		•		•		•	○										•		•		•		•	○				
M36×1.5	1.5	35.03	0°47′	IR15ISO					•		•		•		•	○										•		•		•		•	○				
M36×2	2	34.7	1°03′	IR20ISO	•		•		•		•		•		•	○						•		•		•		•		•		•	○				
M36×3	3	34.05	1°36′	IR30ISO											[2]																	•	[2]				
M38×1.5	1.5	37.03	0°44′	IR15ISO					•		•		•		•	○										•		•		•		•	•	○			
M39×1.5	1.5	38.03	0°43′	IR15ISO					•		•		•		•	○										•		•		•		•	•	○			
M39×2	2	38.7	0°58′	IR20ISO					•		•		•		•	○										•		•		•		•	•	○			
M39×3	3	37.05	1°29′	IR30ISO									•		•	○														•		•	•	○			
M40×1.5	1.5	39.03	0°42′	IR15ISO					•		•		•		•	○										•		•		•		•	•	○			
M40×2	2	37.8	0°57′	IR20ISO					•		•		•		•	○										•		•		•		•	•	○			
M40×3	3	38.05	1°26′	IR30ISO									•		•	○														•		•	•	○			
M42×1.5	1.5	41.03	0°40′	IR15ISO					•		•		•		•	○										•		•		•		•	•	○			
M42×2	2	40.7	0°54′	IR20ISO					•		•		•		•	○										•		•		•		•	•	○			
M42×3	3	40.05	1°22′	IR30ISO									•		•	○														•		•	•	○			
M42×4	4	39.4	1°51′	IR40ISO																[2]																•	[2]
M45×1.5	1.5	44.03	0°37′	IR15ISO					•		•		•		•	•	○									•		•		•		•	•	○	○		
M45×2	2	43.7	0°50′	IR20ISO					•		•		•		•	•	○									•		•		•		•	•	○	○		
M45×3	3	43.05	1°16′	IR30ISO									•		•	•	○					•		•		•		•		•		•	•	○	○		
M45×4	4	42.4	1°43′	IR40ISO																[2]																•	[2]
M48×1.5	1.5	47.03	0°35′	IR15ISO					•		•		•		•	•	○									•		•		•		•	•	○	○		
M48×2	2	46.7	0°47′	IR20ISO					•		•		•		•	•	○									•		•		•		•	•	○	○		
M48×3	3	46.05	1°11′	IR30ISO									•		•	•	○													•		•	•	○	○		
M48×4	4	45.4	1°36′	IR40ISO																	[2]															•	[2]

[2] : Change the shim to AN16-2
[2] : Change the shim to NXN22-2
[2] : Change the shim to AN16-2DT
[2] : Change the shim to GXN22-2DT

Note : The above tables show correspondence of internal toolholders at the time of setting clearance between thread and toolholder to 3 mm (1 mm in case of SN type) and the finishing stock to 0.1 mm.

Metric fine screw thread (ISO)

Nominal size	Pitch	Pitch diameter	Lead angle	Shank material	Steel shank																				Carbide shank										“Tsuppari-Ichiban”						
				Insert size	6IR				11IR				16IR							22IR					6IR				11IR				16IR		16IR				22IR		
				Holder Cat. No. / Insert Cat. No.	SNR0006H06-2	SNR0006H06-3	SNR0008H06-2	SNR0008H06-3	SNR0010K11	SNR0010K11-2	SNR0013L11	SNR0013L11-2	SNR0016M16	SNR0016M16-2	CNR0020P16	CNR0025R16	CNR0032S16	(CNR0040T16)	(CNR0050U16)	SNR0020Q22	SNR0020Q22-2	CNR0025R22	CNR0032S22	(CNR0040T22)	SNR0006K06SC-2	SNR0006K06SC-3	SNR0008K06SC-2	SNR0008K06SC-3	SNR0010M11SC	SNR0010M11SC-2	SNR0012P11SC	SNR0012P11SC-2	SNR0016R16SC	SNR0016R16SC-2	TSNR0016Q16	TCNR0020R16DT	TCNR0025S16DT	(TCNR0032T16DT)	TSNR0020R22	TCNR0025S22DT	(TCNR0032T22DT)
M50×1.5	1.5	49.03	0°33′	IR15ISO					•		•		•		•	•	○	•											•		•		•		•	•	○	○			
M50×2	2	48.7	0°45′	IR20ISO					•		•		•		•	•	○												•		•		•		•	•	○	○			
M50×3	3	48.05	1°08′	IR30ISO									•		•	•	○																•		•	•	○	○			
M52×1.5	1.5	51.03	0°32′	IR15ISO					•		•		•		•	•	•	○											•		•		•		•	•	○	○			
M52×2	2	50.7	0°43′	IR20ISO					•		•		•		•	•	•	○											•		•		•		•	•	○	○			
M52×3	3	50.05	1°06′	IR30ISO									•		•	•	○	•															•		•	•	○	○			
M52×4	4	49.4	1°29′	IR40ISO																•	•	•	•																•	•	○
M55×1.5	1.5	54.03	0°30′	IR15ISO					•		•		•		•	•	○	•											•		•		•		•	•	○	○			
M55×2	2	53.7	0°41′	IR20ISO					•		•		•		•	•	•	○											•		•		•		•	•	○	○			
M55×3	3	53.05	1°02′	IR30ISO									•		•	•	•	○															•		•	•	○	○			
M55×4	4	52.4	1°24′	IR40ISO																•	•	•	•	○															•	•	○
M56×1.5	1.5	55.03	0°30′	IR15ISO					•		•		•		•	•	•	○											•		•		•		•	•	○	○			
M56×2	2	54.7	0°40′	IR20ISO					•		•		•		•	•	•	○											•		•		•		•	•	○	○			
M56×3	3	54.05	1°01′	IR30ISO									•		•	•	•	○															•		•	•	○	○			
M56×4	4	53.4	1°22′	IR40ISO																•	•	•	•	○															•	•	○
M58×1.5	1.5	57.03	0°29′	IR15ISO					•		•		•		•	•	•	○											•		•		•		•	•	○	○			
M58×2	2	56.7	0°39′	IR20ISO					•		•		•		•	•	•	○											•		•		•		•	•	○	○			
M58×3	3	56.05	0°59′	IR30ISO									•		•	•	•	○															•		•	•	○	○			
M58×4	4	55.4	1°19′	IR40ISO																•	•	•	•	○															•	•	○
M60×1.5	1.5	59.03	0°28′	IR15ISO					•		•		•		•	•	•	○											•		•		•		•	•	○	○			
M60×2	2	58.7	0°37′	IR20ISO					•		•		•		•	•	•	○											•		•		•		•	•	○	○			
M60×3	3	58.05	0°57′	IR30ISO									•		•	•	•	○															•		•	•	○	○			
M60×4	4	57.4	1°16′	IR40ISO																•	•	•	•	○															•	•	○

Unified coarse screw thread (UNC)

Nominal size	TPI	Pitch diameter	Lead angle	Shank material	Steel shank																		Carbide shank									“Tsuppari-Ichiban”	
				Insert size	11IR						16IR			22IR						27IR			11IR						16IR			22IR	
				Holder Cat. No. / Insert Cat. No.	SNR0010K11	SNR0010K11-2	SNR0010K11-3	SNR0013L11	SNR0013L11-2	SNR0013L11-3	SNR0016M16	SNR0016M16-2	SNR0016M16-3	SNR0020Q22	SNR0020Q22-2	SNR0020Q22-3	CNR0025R22	CNR0032S22	(CNR0040T22)	CNR0040T27	(CNR0050U27)	(CNR0063V27)	SNR0010M11SC	SNR0010M11SC-2	SNR0010M11SC-3	SNR0012P11SC	SNR0012P11SC-2	SNR0012P11SC-3	SNR0016R16SC	SNR0016R16SC-2	(SNR0016R16SC-3)	TCNR0025S22DT	(TCNR0032T22DT)
7/16-14UNC	14	9.93	3°20′	(IR14UN)																													
1/2-13UNC	13	11.43	3°07′	(IR13UN)																													
9/16-12UNC	12	12.91	2°59′	IR12UN																													
5/8-11UNC	11	14.38	2°56′	(IR11UN)																													
3/4-10UNC	10	17.4	2°40′	(IR10UN)																													
7/8-9UNC	9	20.39	2°31′	IR9UN																													
1-8UNC	8	23.34	2°29′	IR8UN								○																					
1 1/8-7UNC	7	26.22	2°31′	(IR7UN)																													
1 1/4-7UNC	7	29.39	2°15′	(IR7UN)											○																		
1 3/8-6UNC	6	32.17	2°24′	(IR6UN)											○																		
1 1/2-6UNC	6	35.35	2°11′	(IR6UN)											○		$\boxed{2}$															$\boxed{2}$	
1 3/4-5UNC	5	41.15	2°15′	(IR5UN)											○		$\boxed{2}$															$\boxed{2}$	
2-4 1/2UNC	4.5	47.14	2°11′	(IR45UN)																													
2 1/4-4 1/2UNC	4.5	53.49	1°55′	(IR45UN)																$\boxed{2}$													
2 1/2-4UNC	4	59.38	1°57′	(IR4UN)																$\boxed{2}$													
2 3/4-4UNC	4	65.73	1°46′	(IR4UN)																$\boxed{2}$	$\boxed{2}$												
3-4UNC	4	72.08	1°36′	(IR4UN)																$\boxed{2}$	$\boxed{2}$												
3 1/4-4UNC	4	78.43	1°29′	(IR4UN)																•	•	○											
3 1/2-4UNC	4	84.78	1°22′	(IR4UN)																•	•	○											
3 3/4-4UNC	4	91.13	1°16′	(IR4UN)																•	•	○											
4-4UNC	4	97.48	1°11′	(IR4UN)																•	•	○											

$\boxed{2}$: Change the shim to NXN22-2

$\boxed{2}$: Change the shim to GXN22-2DT

$\boxed{2}$: Change the shim to NXN27-2

Note : The above tables show correspondence of internal toolholders at the time of setting clearance between thread and toolholder to 3 mm (1 mm in case of SN type) and the finishing stock to 0.1 mm.

Technical Reference

Parts for Tools

Selection of ST-type Toolholders

Unified fine screw thread (UNF)

Nominal size	TPI	Pitch diameter	Lead angle	Shank material / Insert size / Holder Cat. No. / Insert Cat. No.	Steel shank 6IR SNR0006H06-2	Steel shank 6IR SNR0006H06-3	Steel shank 6IR SNR0008H06-2	Steel shank 6IR SNR0008H06-3	Steel shank 11IR SNR0010K11-2	Steel shank 11IR SNR0013L11-2	Steel shank 16IR SNR0016M16	Steel shank 16IR SNR0016M16-2	Steel shank 16IR CNR0020P16	Steel shank 16IR CNR0025R16	Carbide shank 6IR SNR0006K06SC-2	Carbide shank 6IR SNR0006K06SC-3	Carbide shank 6IR SNR0008K06SC-2	Carbide shank 6IR SNR0008K06SC-3	Carbide shank 11IR SNR0010M11SC	Carbide shank 11IR SNR0010M11SC-2	Carbide shank 11IR SNR0012P11SC	Carbide shank 11IR SNR0012P11SC-2	Carbide shank 16IR SNR0016R16SC	Carbide shank 16IR SNR0016R16SC-2	"Tsuppari-Ichiban" 16IR TSNR0016Q16	"Tsuppari-Ichiban" 16IR TCNR0020R16DT	"Tsuppari-Ichiban" 16IR TCNR0025S16DT
3/8-24UNF	24	8.84	2°11′	(IR24UN)																							
				IRA60																							
7/16-20UNF	20	10.29	2°15′	(IR20UN)																							
				IRA60	○										○												
1/2-20UNF	20	11.87	1°57′	(IR20UN)																							
				IRA60	•		○								•		○										
9/16-18UNF	18	13.37	1°55′	(IR18UN)																							
				IRA60	•		○								•		○										
5/8-18UNF	18	14.96	1°43′	(IR18UN)																							
				IRA60	•		○								•		○										
3/4-16UNF	16	18.02	1°36′	IR16UN					○											○							
7/8-14UNF	14	21.05	1°34′	IR14UN					•	○										•		○					
1-12UNF	12	24.03	1°36′	IR12UN								○												○			
1 1/8-12UNF	12	27.2	1°25′	IR12UN							○												○		○		
1 1/4-12UNF	12	30.38	1°16′	IR12UN							•		○										○		•	○	
1 3/8-12UNF	12	33.55	1°09′	IR12UN							•		•	○									○		•	•	○
1 1/2-12UNF	12	36.73	1°03′	IR12UN							•		•	○									○		•	•	○

Unified extra fine screw thread (UNEF))

Nominal size	TPI	Pitch diameter	Lead angle	Shank material / Insert size / Holder Cat. No. / Insert Cat. No.	Steel shank 6IR SNR0006H06-2	Steel shank 6IR SNR0008H06-2	Steel shank 11IR SNR0010K11	Steel shank 11IR SNR0010K11-2	Steel shank 11IR SNR0013L11	Steel shank 11IR SNR0013L11-2	Steel shank 16IR SNR0016M16	Steel shank 16IR SNR0016M16-2	Steel shank 16IR CNR0020P16	Steel shank 16IR CNR0025R16	Steel shank 16IR CNR0032S16	Carbide shank 6IR SNR0006H06SC-2	Carbide shank 6IR SNR0008H06SC-2	Carbide shank 11IR SNR0010K11	Carbide shank 11IR SNR0010K11-2	Carbide shank 11IR SNR0012L11	Carbide shank 11IR SNR0012L11-2	Carbide shank 16IR SNR0016M16	Carbide shank 16IR SNR0016M16-2	"Tsuppari-Ichiban" 16IR TSNR0016Q16	"Tsuppari-Ichiban" 16IR TCNR0020R16DT	"Tsuppari-Ichiban" 16IR TCNR0025S16DT
3/8	32	9.01	1°61′	IR32UN																						
7/16	28	10.52	1°57′	IR28UN	○											○										
1/2	28	12.11	1°37′	IR28UN																						
9/16	24	13.6	1°42′	IR24UN																						
5/8	24	15.19	1°27′	IR24UN																						
11/16	24	16.77	1°15′	IR24UN			○											○								
3/4	20	18.22	1°27′	IR20UN			○											○								
13/16	20	19.81	1°17′	IR20UN			•		○									•		○						
7/8	20	21.4	1°08′	IR20UN			•		○									•		○						
15/16	20	22.99	1°01′	IR20UN			•		•		○							•		○				○		
1	20	24.57	0°94′	IR20UN			•		•		○							•		•		○		○		
1 1/16	18	26.07	0°99′	IR18UN			•		•		○							•		•		○		○		
1 1/8	18	27.66	0°93′	IR18UN			•		•		○							•		•		○		○		
1 3/16	18	29.25	0°88′	IR18UN			•		•		•		○					•		•		○		•	○	
1 1/4	18	30.83	0°84′	IR18UN			•		•		•		○					•		•		○		•	○	
1 5/16	18	32.42	0°79′	IR18UN			•		•		•		○					•		•		○		•	○	
1 3/8	18	34.01	0°76′	IR18UN			•		•		•		•	○				•		•		○		•	•	○
1 7/16	18	35.6	0°72′	IR18UN			•		•		•		•	○				•		•		○		•	•	○
1 1/2	18	37.18	0°69′	IR18UN			•		•		•		•	○				•		•		○		•	•	○
1 9/16	18	38.77	0°66′	IR18UN			•		•		•		•	○				•		•		○		•	•	○
1 5/8	18	40.36	0°64′	IR18UN			•		•		•		•	•	○			•		•		○		•	•	○
1 11/16	18	41.95	0°61′	IR18UN			•		•		•		•	•	○			•		•		○		•	•	○

Note : The above tables show correspondence of internal toolholders at the time of setting clearance between thread and toolholder to 3 mm (1 mm in case of SN type) and the finishing stock to 0.1 mm.

Whitworth British Standard (BSW) (for pipe)

Nominal size	TPI	Pitch diameter	Lead angle	Shank material	Steel shank											Carbide shank		"Tsuppari-Ichiban"				
				Insert size	16IR						22IR					16IR		16IR			22IR	
				Holder Cat. No. / Insert Cat. No.	SNR0016M16	SNR0016M16-2	SNR0016M16-3	CNR0020P16	CNR0025R16	CNR0032S16	SNR0020Q22	SNR0020Q22-2	SNR0020Q22-3	CNR0025R22	CNR0032S22	SNR0016M16	SNR0016M16-2	TSNR0016Q16	TCNR0020R16DT	TCNR0025S16DT	TSNR0020R22	TCNR0025S22DT
7/16	14	9.95	3°32´	IR14W																		
1/2	12	11.34	3°40´	IR12W																		
9/16	12	12.93	2°98´	IR12W																		
5/8	11	14.4	2°92´	IR11W																		
11/16	11	15.98	2°63´	IR11W																		
3/4	10	17.42	2°66´	IR10W																		
7/8	9	20.42	2°52´	IR9W																		
1	8	23.37	2°48´	IR8W																		
1 1/8	7	26.25	2°52´	IR7W																		
1 1/4	7	29.43	2°25´	IR7W								○										
1 1/2	6	35.39	2°18´	IR6W								○										
1 3/4	5	41.2	2°25´	IR5W								•		$\boxed{2}$								$\boxed{2}$

$\boxed{2}$: Change the shim to NXN22-2

$\boxed{2}$: Change the shim to GXN22-2DT

Whitworth British Standard Fine (BSF) (for pipe)

Nominal size	TPI	Pitch diameter	Lead angle	Shank material	Steel shank														Carbide shank				"Tsuppari-Ichiban"				
				Insert size	6IR		11IR		16IR					22IR					6IR		16IR		16IR			22IR	
				Holder Cat. No. / Insert Cat. No.	SNR0006H06-2	SNR0008H06-2	SNR0010K11	SNR0010K11-2	SNR0016M16	SNR0016M16-2	SNR0016M16-3	CNR0020P16	CNR0025R16	SNR0020Q22	SNR0020Q22-2	SNR0020Q22-3	CNR0025R22	CNR0032S22	SNR0006H06SC-2	SNR0008H06SC-2	SNR0016M16	SNR0016M16-2	TSNR0016Q16	TCNR0020R16DT	TCNR0025S16DT	TSNR0020R22	TCNR0025S22DT
7/16	18	10.21	2°52´	IR18W																							
1/2	16	11.68	2°48´	IR16W	○														○								
9/16	16	13.27	2°18´	IR16W	•	○													•	○							
5/8	14	14.71	2°25´	IR14W																							
11/16	14	16.3	2°03´	IR14W				○																			
3/4	12	17.69	2°18´	IR12W																							
7/8	11	20.75	2°03´	IR11W																							
1	10	23.77	1°95´	IR10W						○																	
1 1/8	9	26.77	1°92´	IR9W						○												○					
1 1/4	9	29.94	1°72´	IR9W						•		$\boxed{2}$										○		$\boxed{2}$			
1 3/8	8	32.89	1°76´	IR8W						•		$\boxed{2}$										○		$\boxed{2}$			
1 1/2	8	36.07	1°61´	IR8W						•		•	$\boxed{2}$									○		•	$\boxed{2}$		
1 5/8	8	39.24	1°48´	IR8W					•			•	○								○		•	•	○		
1 3/4	7	42.13	1°57´	IR7W											○		$\boxed{2}$										$\boxed{2}$
2	7	48.48	1°37´	IR7W										•			•	○								•	○
2 1/4	6	54.44	1°42´	IR6W										•			•	○								•	○
2 1/2	6	60.79	1°27´	IR6W										•			•	○								•	○
2 3/4	6	67.14	1°15´	IR6W										•			•	○								•	○
3	5	72.95	1°27´	IR5W										•			•	○								•	○
3 1/4	5	79.3	1°17´	IR5W										•			•	○								•	○

$\boxed{2}$: Change the shim to AN16-2

$\boxed{2}$: Change the shim to NXN22-2

$\boxed{2}$: Change the shim to AN16-2DT

$\boxed{2}$: Change the shim to GXN22-2DT

Note : The above tables show correspondence of internal toolholders at the time of setting clearance between thread and toolholder to 3 mm (1 mm in case of SN type) and the finishing stock to 0.1 mm.

Selection of ST-type Toolholders

30° trapezoidal thread (TR) (for machine parts)

1/2

Nominal size	Pitch	Pitch diameter	Lead angle	Shank material	Steel shank															Carbide shank			"Tsuppari-Ichiban"						
				Insert size	16IR								22IR					27IR		16IR			16IR				22IR		
				Insert Cat. No. \ Holder Cat. No.	SNR0016M16	SNR0016M16-2	SNR0016M16-3	CNR0020P16	CNR0025R16	CNR0032S16	CNR0040T16	CNR0050U16	SNR0020Q22	SNR0020Q22-2	SNR0020Q22-3	CNR0025R22	CNR0032S22	CNR0040T27	(CNR0050U27)	SNR0016R16SC	SNR0016R16SC-2	(SNR0016R16SC-3)	TSNR0016Q16	TCNR0020R16DT	TCNR0025S16DT	(TCNR0032T16DT)	TSNR0020R22	TCNR0025S22DT	(TCNR0032T22DT)
TR22×3	3	20.5	2°40′	IR30TR																									
TR24×5	5	21.5	4°14′	IR50TR																									
TR24×3	3	22.5	2°26′	IR30TR																									
TR26×5	5	23.5	3°52′	IR50TR																									
TR26×3	3	24.5	2°14′	IR30TR		○																							
TR28×5	5	25.5	3°34′	IR50TR																									
TR28×3	3	26.5	2°04′	IR30TR		•															○								
TR30×6	6	27	4°03′	IR60TR																									
TR30×3	3	28.5	1°55′	IR30TR		•															○								
TR32×6	6	29	3°46′	IR60TR																									
TR32×3	3	30.5	1°48′	IR30TR		•		[2]													•			[2]					
TR34×6	6	31	3°32′	IR60TR																									
TR34×3	3	32.5	1°41′	IR30TR		•		[2]													•			[2]					
TR36×6	6	33	3°19′	IR60TR																									
TR36×3	3	34.5	1°35′	IR30TR		•		2	[2]												•			[2]	[2]				
TR38×3	3	36.5	1°30′	IR30TR		•		2	[2]												•			[2]	[2]				
TR40×3	3	38.5	1°25′	IR30TR	•			•	○											○				•	○				
TR42×3	3	40.5	1°21′	IR30TR	•			•	○											○				•	○				
TR44×3	3	42.5	1°17′	IR30TR	•			•	•	○										○				•	•	○			
TR46×3	3	44.5	1°14′	IR30TR	•			•	•	○										○				•	•	○			
TR48×3	3	46.5	1°11′	IR30TR	•			•	•	○										○				•	•	○			
TR50×3	3	48.5	1°08′	IR30TR	•			•	•	○										○				•	•	○			
TR52×3	3	50.5	1°05′	IR30TR	•			•	•	•	○									○				•	•	○			
TR55×3	3	53.5	1°01′	IR30TR	•			•	•	•	○									○				•	•	○			
TR60×3	3	58.5	0°56′	IR30TR	•			•	•	•	○									○				•	•	○			

[2] : Change the shim to AN16-2 ◄

[2] : Change the shim to AN16-2DT ◄

30° trapezoidal thread (TR) (for machine parts)

2/2

Nominal size	Pitch	Pitch diameter	Lead angle	Shank material	Steel shank																	Carbide shank			"Tsuppari-Ichiban"						
				Insert size	16IR						22IR								27IR			16IR			16IR				22IR		
				Insert Cat. No. \ Holder Cat. No.	SNR0016M16	SNR0016M16-2	SNR0016M16-3	CNR0020P16	CNR0025R16	CNR0032S16	SNR0020Q22	SNR0020Q22-2	SNR0020Q22-3	CNR0025R22	CNR0032S22	(CNR0040T22)	(CNR0050U22)	(CNR0063V22)	CNR0040T27	(CNR0050U27)	(CNR0063V27)	SNR0016R16SC	SNR0016R16SC-2	(SNR0016R16SC-3)	TSNR0016Q16	TCNR0020R16DT	TCNR0025S16DT	(TCNR0032T16DT)	TSNR0020R22	TCNR0025S22DT	(TCNR0032T22DT)
TR65×4	4	63	1°09′	IR40TR							•			•	•	•	○												•	•	○
TR70×4	4	68	1°04′	IR40TR							•			•	•	•	○												•	•	○
TR75×4	4	73	1°00′	IR40TR							•			•	•	•	○												•	•	○
TR80×4	4	78	0°56′	IR40TR							•			•	•	•	•	○											•	•	○
TR85×4	4	83	0°53′	IR40TR							•			•	•	•	•	○											•	•	○
TR90×4	4	88	0°50′	IR40TR							•			•	•	•	•	○											•	•	○
TR95×4	4	93	0°47′	IR40TR							•			•	•	•	•	○											•	•	○
TR100×4	4	98	0°45′	IR40TR							•			•	•	•	•	○											•	•	○
TR105×4	4	103	0°42′	IR40TR							•			•	•	•	•	○											•	•	○
TR110×4	4	108	0°41′	IR40TR							•			•	•	•	•	○											•	•	○
TR115×6	6	112	0°59′	IR60TR															•	•	○										
TR120×6	6	117	0°56′	IR60TR															•	•	○										
TR125×6	6	122	0°54′	IR60TR															•	•	○										
TR130×6	6	127	0°52′	IR60TR															•	•	○										
TR135×6	6	132	0°50′	IR60TR															•	•	○										
TR140×6	6	137	0°48′	IR60TR															•	•	○										
TR145×6	6	142	0°46′	IR60TR															•	•	○										
TR150×6	6	147	0°45′	IR60TR															•	•	○										
TR155×6	6	152	0°43′	IR60TR															•	•	○										
TR160×6	6	157	0°42′	IR60TR															•	•	○										
TR165×6	6	162	0°41′	IR60TR															•	•	○										
TR170×6	6	167	0°39′	IR60TR															•	•	○										

Note : The above tables show correspondence of internal toolholders at the time of setting clearance between thread and toolholder to 3 mm (1 mm in case of SN type) and the finishing stock to 0.1 mm.

Parallel pipe thread (G) (for pipe) This table is also applied to PF, Rp, and PS type threads.

Nominal size	TPI	Pitch	Pitch diameter	Lead angle	Shank material	Steel shank													Carbide shank										"Tsuppari-Ichiban"			
					Insert size	6IR		11IR				16IR							6IR				11IR				16IR		16IR			
					Holder Cat. No. / Insert Cat. No.	SNR0006H06-2	SNR0008H06-2	SNR0010K11	SNR0010K11-2	SNR0013L11	SNR0013L11-2	SNR0016M16	SNR0016M16-2	CNR0020P16	CNR0025R16	CNR0032S16	(CNR0040T16)	(CNR0050U16)	SNR0006K06SC-2	SNR0006K06SC-3	SNR0008K06SC-2	SNR0008K06SC-3	SNR0010M11SC	SNR0010M11SC-2	SNR0012P11SC	SNR0012P11SC-2	SNR0016R16SC	SNR0016R16SC-2	TSNR0016Q16	TCNR0020R16DT	TCNR0025S16DT	(TCNR0032T16DT)
G1/4	19	1.34	12.30	1°59′	IR19W	•	○												•		○											
G3/8	19	1.34	15.81	1°33′	IR19W	•	•		○										•		○											
G1/2	14	1.81	19.79	1°40′	IR14W				•		○													•		○						
G5/8	14	1.81	21.75	1°31′	IR14W				•		○													•		○						
G3/4	14	1.81	25.28	1°18′	IR14W			•		•		○											•		•		○		○			
G7/8	14	1.81	29.04	1°08′	IR14W			•		•		•		○									•		•		○		•	○		
G1	11	2.31	31.77	1°20′	IR11W							•		○													○		•	○		
G1-1/8	11	2.31	36.42	1°09′	IR11W							•		•	○												○		•	•	○	
G1-1/4	11	2.31	40.43	1°02′	IR11W							•		•	○												○		•	•	○	
G1-1/2	11	2.31	46.32	0°55′	IR11W							•		•	•	○											○		•	•	•	○
G1-3/4	11	2.31	52.27	0°48′	IR11W							•		•	•	•	○										○		•	•	•	○
G2	11	2.31	58.14	0°43′	IR11W							•		•	•	•	○										○		•	•	•	○
G2-1/4	11	2.31	64.23	0°39′	IR11W							•		•	•	•	•	○									○		•	•	•	○
G2-1/2	11	2.31	73.71	0°34′	IR11W							•		•	•	•	•	○									○		•	•	•	○
G2-3/4	11	2.31	80.06	0°32′	IR11W							•		•	•	•	•	○									○		•	•	•	○
G3	11	2.31	86.41	0°29′	IR11W									0	0	0	0	[0]												0	0	[0]
G3-1/2	11	2.31	98.85	0°26′	IR11W									0	0	0	0	[0]												0	0	[0]
G4	11	2.31	111.55	0°23′	IR11W									0	0	0	0	[0]												0	0	[0]
G4-1/2	11	2.31	124.25	0°20′	IR11W									0	0	0	0	[0]												0	0	[0]
G5	11	2.31	136.95	0°18′	IR11W									0	0	0	0	[0]												0	0	[0]
G6	11	2.31	162.35	0°16′	IR11W									0	0	0	0	[0]												0	0	[0]

[0] : Change the shim to AN16-0 ← (steel shank)

[0] : Change the shim to AN16-0DT ← ("Tsuppari-Ichiban")

Taper pipe thread (PT) (for pipe) This table is also applied to Rc type pipe thread.

Nominal size	TPI	Pitch	Pitch diameter	Lead angle	Shank material	Steel shank															Carbide shank										"Tsuppari-Ichiban"			
					Insert size	6IR				11IR				16IR							6IR				11IR				16IR		16IR			
					Holder Cat. No. / Insert Cat. No.	SNR0006H06-2	SNR0006H06-3	SNR0008H06-2	SNR0008H06-3	SNR0010K11	SNR0010K11-2	SNR0013L11	SNR0013L11-2	SNR0016M16	SNR0016M16-2	CNR0020P16	CNR0025R16	CNR0032S16	(CNR0040T16)	(CNR0050U16)	SNR0006K06SC-2	SNR0006K06SC-3	SNR0008K06SC-2	SNR0008K06SC-3	SNR0010M11SC	SNR0010M11SC-2	SNR0012P11SC	SNR0012P11SC-2	SNR0016R16SC	SNR0016R16SC-2	TSNR0016Q16	TCNR0020R16DT	TCNR0025S16DT	(TCNR0032T16DT)
PT1/4	19	1.34	12.30	1°59′	IR19PT	○															○													
PT3/8	19	1.34	15.81	1°33′	IR19PT	•		○													•		○											
PT1/2	14	1.81	19.79	1°40′	IR14PT						○															•		○						
PT3/4	14	1.81	25.28	1°19′	IR14PT									○											•		•		○		○			
PT1	11	2.31	31.77	1°20′	IR11PT									•		○													○		•	○		
PT1 1/4	11	2.31	40.43	1°02′	IR11PT									•		•	○												○		•	•	○	
PT1 1/2	11	2.31	46.32	0°55′	IR11PT									•		•	•	○											○		•	•	•	○
PT2	11	2.31	58.14	0°43′	IR11PT									•		•	•	•	○										○		•	•	•	○
PT2 1/2	11	2.31	73.71	0°34′	IR11PT									•		•	•	•	•	○									○		•	•	•	○
PT3	11	2.31	86.41	0°29′	IR11PT											0	0	0	0	[0]												0	0	[0]
PT3 1/2	11	2.31	98.85	0°26′	IR11PT											0	0	0	0	[0]												0	0	[0]
PT4	11	2.31	111.55	0°23′	IR11PT											0	0	0	0	[0]												0	0	[0]
PT5	11	2.31	136.95	0°18′	IR11PT											0	0	0	0	[0]												0	0	[0]
PT6	11	2.31	162.35	0°16′	IR11PT											0	0	0	0	[0]												0	0	[0]
PT7	11	2.31	187.75	0°13′	IR11PT											0	0	0	0	[0]												0	0	[0]
PT8	11	2.31	213.15	0°12′	IR11PT											0	0	0	0	[0]												0	0	[0]
PT9	11	2.31	238.55	0°11′	IR11PT											0	0	0	0	[0]												0	0	[0]
PT10	11	2.31	263.95	0°10′	IR11PT											0	0	0	0	[0]												0	0	[0]
PT12	11	2.31	314.75	0°08′	IR11PT											0	0	0	0	[0]												0	0	[0]

[0] : Change the shim to AN16-0

[0] : Change the shim to AN16-0DT

Note : The above tables show correspondence of internal toolholders at the time of setting clearance between thread and toolholder to 3 mm (1 mm in case of SN type) and the finishing stock to 0.1 mm.

Selection of ST-type Toolholders

National taper pipe thread (NPT) (for pipe)

Nominal size	TPI	Pitch	Lead angle	Shank material	Steel shank												Carbide shank							"Tsuppari-Ichiban"			
				Insert size	6IR				16IR								6IR				16IR			16IR			
				Holder Cat. No. / Insert Cat. No.	SNR0006H06-2	SNR0006H06-3	SNR0008H06-2	SNR0008H06-3	SNR0016M16	SNR0016M16-2	SNR0016M16-3	CNR0020P16	CNR0025R16	CNR0032S16	(CNR0040T16)	(CNR0050U16)	SNR0006K06SC-2	SNR0006K06SC-3	SNR0008K06SC-2	SNR0008K06SC-3	SNR0016R16SC	SNR0016R16SC-2	(SNR0016R16SC-3)	TSNR0016Q16	TCNR0020R16DT	TCNR0025S16DT	(TCNR0032T16DT)
3/8NPT	18	1.41	1°37′	IR18NPT	•		○										•		○								
1/2NPT	14	1.81	1°40′	IR14NPT																							
3/4NPT	14	1.81	1°19′	IR14NPT					○												○			○			
1NPT	11.5	2.21	1°17′	IR115NPT					○			○									○			•	○		
1 1/4NPT	11.5	2.21	1°00′	IR115NPT					○			•	•	○							○			•	•	•	○
1 1/2NPT	11.5	2.21	0°52′	IR115NPT					○			•	•	○							○			•	•	•	○
2NPT	11.5	2.21	0°41′	IR115NPT					○			•	•	•	•	○					○			•	•	•	○
2 1/2NPT	8	3.175	0°50′	IR8NPT					○			•	•	•	•	○					○			•	•	•	○
3NPT	8	3.175	0°40′	IR8NPT					○			•	•	•	•	○					○			•	•	•	○
3 1/2NPT	8	3.175	0°35′	IR8NPT					○			•	•	•	•	○					○			•	•	•	○
4NPT	8	3.175	0°31′	IR8NPT					○			•	•	•	•	○					○			•	•	•	○
5NPT	8	3.175	0°25′	IR8NPT								0	0	0	0	$\boxed{0}$									0	0	$\boxed{0}$
6NPT	8	3.175	0°21′	IR8NPT								0	0	0	0	$\boxed{0}$									0	0	$\boxed{0}$
8NPT	8	3.175	0°16′	IR8NPT								0	0	0	0	$\boxed{0}$									0	0	$\boxed{0}$
10NPT	8	3.175	0°13′	IR8NPT								0	0	0	0	$\boxed{0}$									0	0	$\boxed{0}$
12NPT	8	3.175	0°11′	IR8NPT								0	0	0	0	$\boxed{0}$									0	0	$\boxed{0}$
14NPT	8	3.175	0°10′	IR8NPT								0	0	0	0	$\boxed{0}$									0	0	$\boxed{0}$
16NPT	8	3.175	0°09′	IR8NPT								0	0	0	0	$\boxed{0}$									0	0	$\boxed{0}$
18NPT	8	3.175	0°08′	IR8NPT								0	0	0	0	$\boxed{0}$									0	0	$\boxed{0}$
20NPT	8	3.175	0°07′	IR8NPT								0	0	0	0	$\boxed{0}$									0	0	$\boxed{0}$
24NPT	8	3.175	0°06′	IR8NPT								0	0	0	0	$\boxed{0}$									0	0	$\boxed{0}$

$\boxed{0}$: Change the shim to AN16-0

$\boxed{0}$: Change the shim to AN16-0DT

29° trapezoidal thread (ACME) (for machine parts, pipe)

Nominal size	TPI	Pitch	Pitch diameter	Lead angle	Shank material	Steel shank													Carbide shank			"Tsuppari-Ichiban"			
					Insert size	16IR						22IR					27IR		16IR			16IR		22IR	
					Holder Cat. No. / Insert Cat. No.	SNR0016M16	SNR0016M16-2	SNR0016M16-3	CNR0020P16	CNR0025R16	CNR0032S16	SNR0020Q22	SNR0020Q22-2	SNR0020Q22-3	CNR0025R22	CNR0032S22	CNR0040T27	(CNR0050U27)	SNR0016R16SC	SNR0016R16SC-2	SNR0016R16SC-3	TSNR0016Q16	TCNR0020R16DT	TCNR0025S22DT	(TCNR0032T22DT)
3/8	12	2.12	8.465	4°33′	IR12ACME																				
7/16	12	2.12	10.053	3°50′	IR12ACME																				
1/2	10	2.54	11.43	4°03′	IR10ACME																				
5/8	8	3.18	14.274	4°03′	IR8ACME																				
3/4	6	4.23	16.934	4°33′	IR6ACME																				
7/8	6	4.23	20.109	3°50′	IR6ACME																				
1	5	5.08	22.86	4°03′	IR5ACME																				
1-1/8	5	5.08	26.035	3°33′	IR5ACME																				
1-1/4	5	5.08	29.21	3°10′	IR5ACME																				
1-3/8	4	6.35	31.75	3°39′	IR4ACME																				
1-1/2	4	6.35	34.925	3°19′	IR4ACME																				
1-3/4	4	6.35	41.275	2°48′	IR4ACME																				
2	4	6.35	47.625	2°26′	IR4ACME																				

Because this thread standard is characterized with large pitch and small diameter, (that is a large lead angle) the standard inserts and toolholders can not be used for machining this thread type. The application is limited to outside of the standard.

Note : The above tables show correspondence of internal toolholders at the time of setting clearance between thread and toolholder to 3 mm (1 mm in case of SN type) and the finishing stock to 0.1 mm.

Threading Inserts

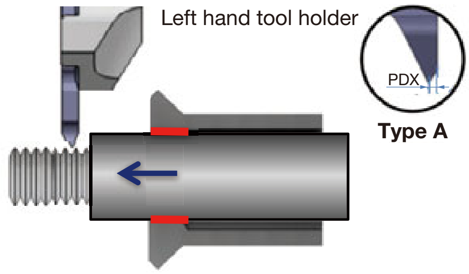
Edge Orientation and Description of Threading Inserts

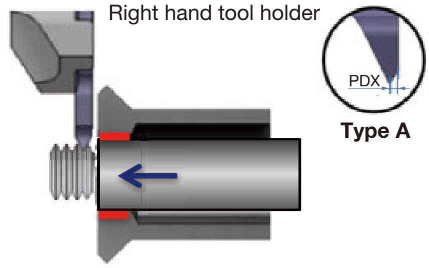
	Edge Orientation		
	Type A	Type B	Type N
Right hand	a > b	a < b	a = b
Left hand	a > b	a < b	a = b

JXTG 12 F R - 60 A - 005

- JXTG: Insert shape
- 12: Insert size
- F: sharp edge
- R: Hand
- 60: Thread angle
- A: Edge orientation
- 005: Corner radius

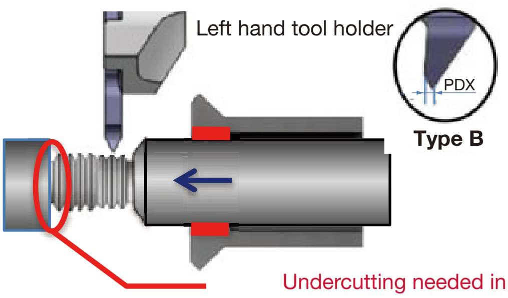
When to Use Type a Threading Insert or Type B

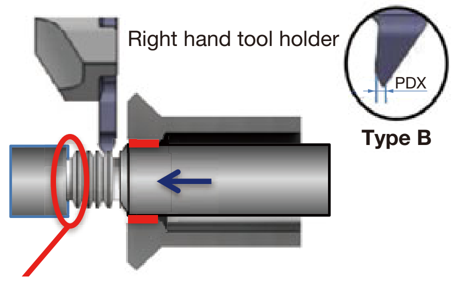




Threading close to the wall

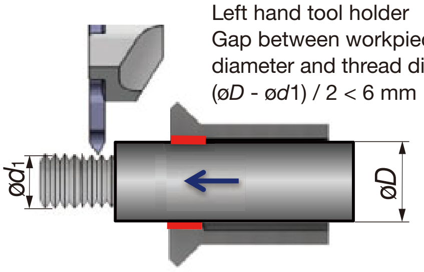
Threading operation following back-turning



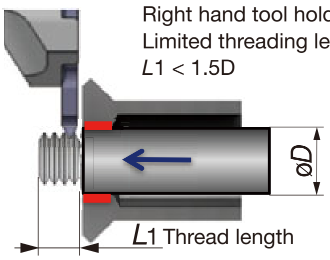


Undercutting needed in previous process

Threading Workpiece in Main Spindle

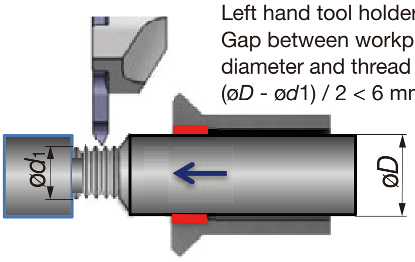


Left hand tool holder
Gap between workpiece diameter and thread diameter
(øD - ød1) / 2 < 6 mm

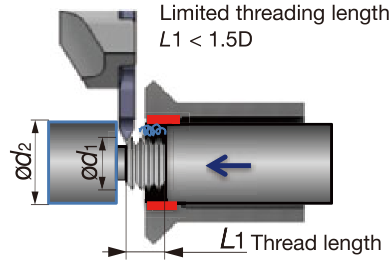


Right hand tool holder
Limited threading length *L*1
*L*1 < 1.5D

Threading operation following back-turning



Left hand tool holder
Gap between workpiece diameter and thread diameter
(øD - ød1) / 2 < 6 mm



Right hand tool holder
Limited threading length *L*1
*L*1 < 1.5D

Designation system for Threading Inserts

Designation system for TT-type insert

Insert

TT | R ① | 42 ② | M ③ | -005 ④

① Hand	
R	Right
L	Left

② Insert size (mm)	
Inscribed circle	12.7
Thickness	3.2

③ Thread type	
M	60˚ thread angle
W	55˚ thread angle

④ Corner radius (mm)	
Blank	0
-005	0.05

Toolholder

TT- | 20 ① | 20 ② | R ③ | E ④

① Shank height (mm)

② Shank width (mm)

③ Hand	
R	Right
L	Left

④ External or Internal	
E	External
I	Internal

Designation system for ST-type insert

16 ① | I ② | R ③ | 175 ④ | ISO ⑤ - B ⑥

① Insert size	
Symbol	I. C. dia (mm)
6	-
11	6.35
16	9.525
22	12.7
27	15.875

② External or Internal	
E	External
I	Internal

③ Hand of cut	
R	Right hand
L	Left hand

④ Thread type	
Partial-profile inserts	
A	Pitch: 0.5 ~ 1.5 mm TPI: 48 ~ 16
AG	Pitch: 0.5 ~ 3 mm TPI: 48 ~ 8
G	Pitch: 1.75 ~ 3 mm TPI: 14 ~ 8
N	Pitch: 3.5 ~ 5 mm TPI: 7 ~ 5
Z	Pitch: 4 ~ 6 mm TPI: 6 ~ 4
Full-profile inserts	
pitch (mm)×10 or 100 TPI (Thread Per Inch) (Examples) 05: 0.5 mm pitch×10 175: 1.75 mm pitch×100 14: 14 TPI	

⑤ Thread type	
Partial-profile inserts	
60°	60° thread angle
55°	55° thread angle
TR	30° trapezoidal
ACME	29° trapezoidal
Full-profile inserts	
ISO	Metric
UN	Unified
W	Whitworth
PT	Taper pipe
NPT	National taper pipe
NPTF	National taper pipe
RAPI	API round
RD	API round
BAPI	API buttress
RD	Round (DIN405)
UNJ	UNJ
MJ	

⑥ Chipbreaker	
B	With (Basic selection)
M	With
CB	With
-	Without

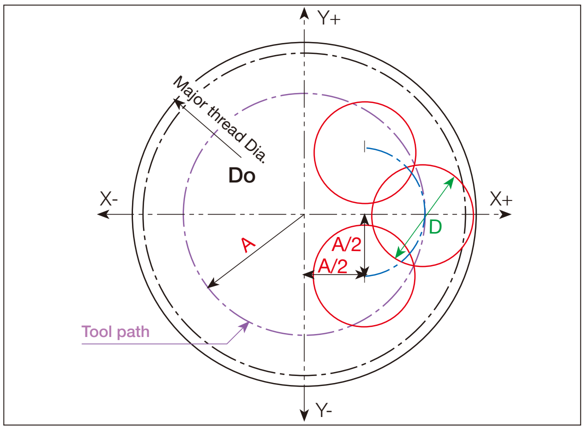
Thread Milling CNC Program for Internal Thread

THREADMILLING

Right-hand thread (climb milling) from bottom up. Program is based on tool center.
This method of programming needs no tool radius compensation value, other than an offset for wear.

$$A = \frac{Do - D}{2}$$

A = Radius of tool path
Do = Major thread diameter
D = Cutting diameter



General Program

```
G90  G00 G54 G43 H1X0 Y0 Z10 S (n : Number of revolutions)
G00  Z-(to thread depth)
G01  G91 G41 D1 X (A/2) Y-(A/2) Z0  F (Center of tool)
G03  X(A/2) Y(A/2) R (A/2) Z(1/8 pitch)  F (Cutting edge)
G03  X0 Y0 I -(A) J0 Z (pitch)
G03  X-(A/2) Y(A/2) R (A/2) Z(1/8 pitch)
G01  G40 X -(A/2) Y-(A/2) Z0
G90   X0 Y0 Z0
```

F (Center of tool) = n x *f* x z

$$F\ (\text{Cutting edge}) = \frac{Do - D}{Do} \times n \times f \times z$$

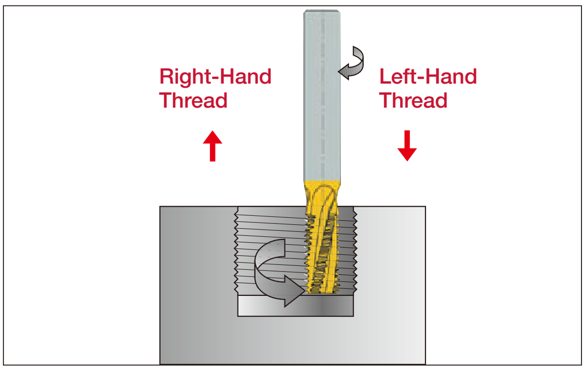
n : Number of revolutions
f : rev / tooth
z : Number of edge

Internal Thread

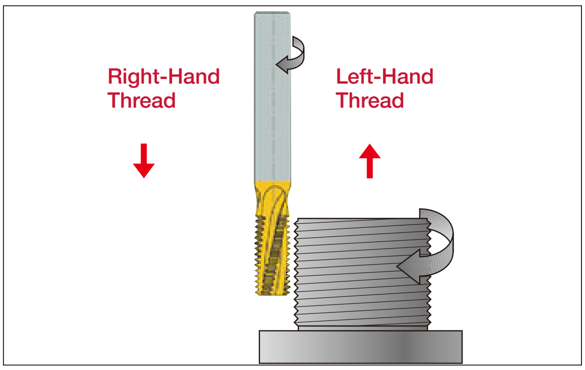
Example: M20x2.0 **IN-RH** (Thread depth 20 mm)
Tool : **MTEC1010C27 2.0ISO**
(Cutting dia. 10 mm)
A=(**Do**-**D**)/2=(20-10)/2=5
A/2=2.5
(Tool compensation of radius=0)

```
G90   G0 G54 G43 G17 H1X0 Y0 Z10 S4000
G0    Z-20
G01   G91 G41 D1X 2.5 Y-2.5 Z0 F840
G03   X2.5 Y2.5 R2.5 Z0.25 F420
G03   X0 Y0 I-5.0 J0 Z2.0
G03   X-2.5 Y2.5 R2.5 Z0.25
G01   G40 X-2.5 Y-2.5 Z0
G90   G0 X0 Y0 Z0
M30
%
```

Internal Thread



External Thread



A thread milling operation is applicable for thread cutting in non-symmetrical parts utilizing the advantage of helical interpolation programs on modern machining centers.

For more details, please check ThreadMilling advisor.

SOLIDTHREAD Designation system

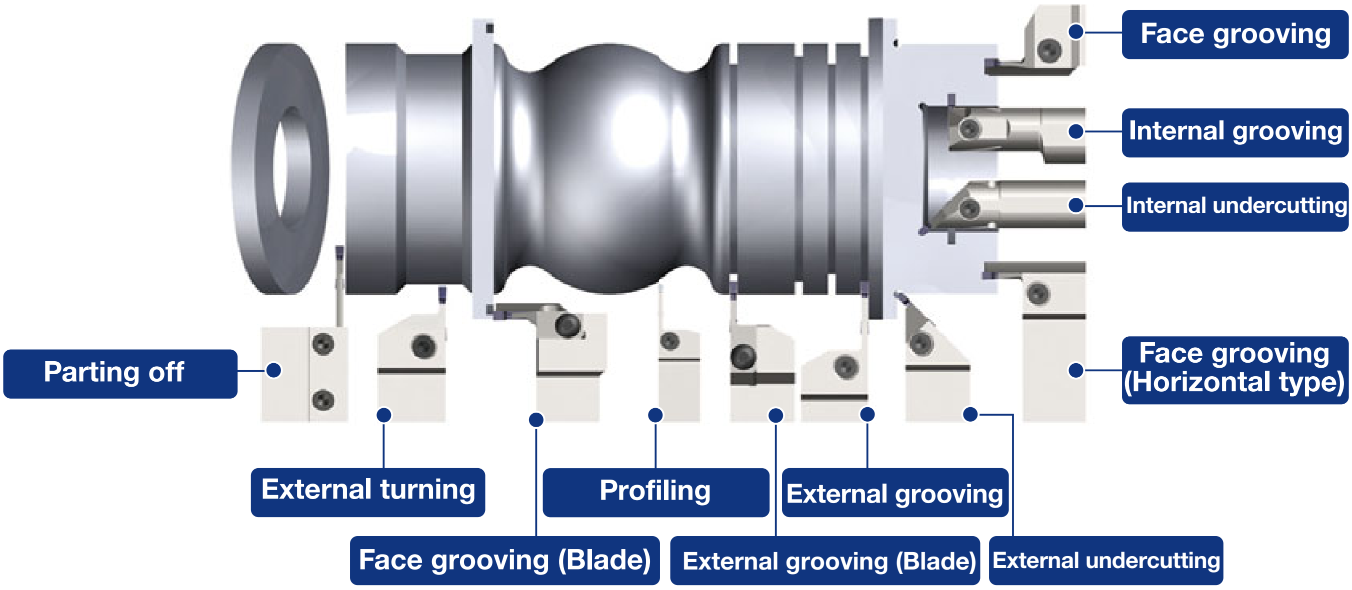
MTEC	□	06	04	C	ISO
ThreadMilling Endmill Carbide	I - Single Point S - Short SH - Short for Hardened steel B - with Coolant Bore Q - with Coolant Bore with long neck Z - with Coolant hole with through hole D - with Drilling (end mill) cutting edge E - for External thread	Shank Dia.	Tool Dia.	No. of Flutes C = 3 flutes D = 4 flutes E = 5 flutes F = 6 flutes	Thread Standard

Grooving and Parting Tools

TUNGCUT

Features of TungCut

● Multi-functional grooving system



Mono block toolholders

High rigidity !

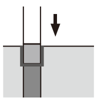
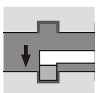
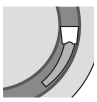
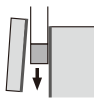
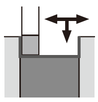
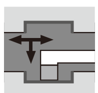
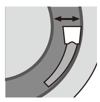
Adaptor

Available for various machining !

Blades with tool blocks

Suitable for large diameter machining !

● Insert Application

Insert	Application: Grooving External	Grooving Internal	Grooving Face	Parting	Turning External	Turning Internal	Turning Face
							
DGM / SGM	●		●	●			
DGS / SGS	●		●	●			
DGG	●		●	●			
DGL	●		●	●			
DGE	●						
DTM	●		●	●	●		●
DTE	●		●		●		●
DTX	●	●	●	●	●	●	●
DTR / STR	●		●		●		●
DTIU	● Undercutting	● Undercutting					
DTI		●				●	
DGIM / DGIS		●					
DTF			●				●
DTA					● Al wheel machining	● Al wheel machining	
SGN	●						
STH					●	●	●

Grooving and Parting Tools

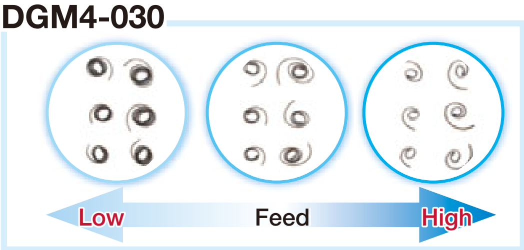
TUNGCUT

Ideal chip forms of TungCut inserts

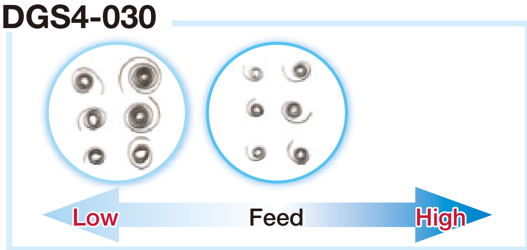
GROOVING AND PARTING

Carbon steel
(S45C / C45)
P

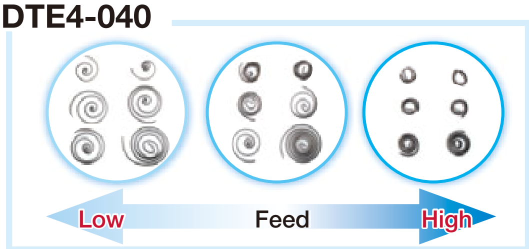
DGM4-030



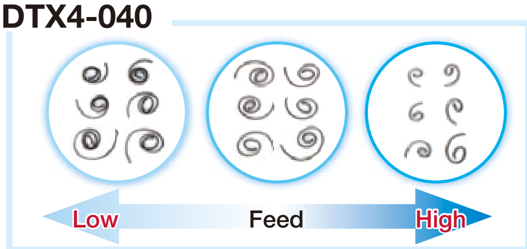
DGS4-030



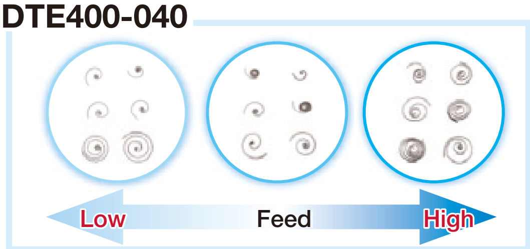
DTE4-040



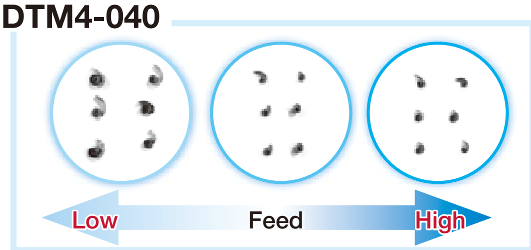
DTX4-040



DTE400-040



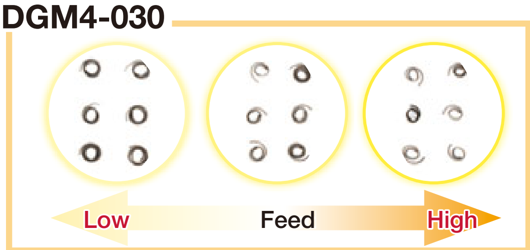
DTM4-040



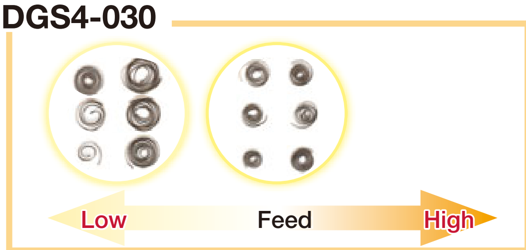
GROOVING AND PARTING

Stainless steel
(SUS304 / X5CrNi18-9)
M

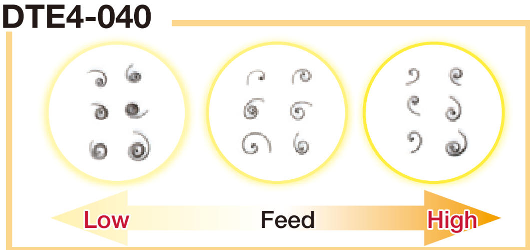
DGM4-030



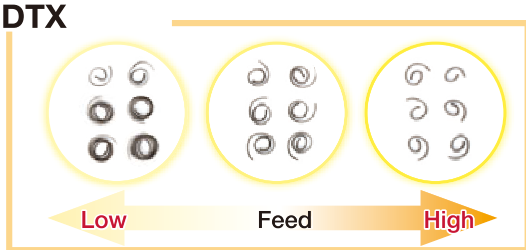
DGS4-030



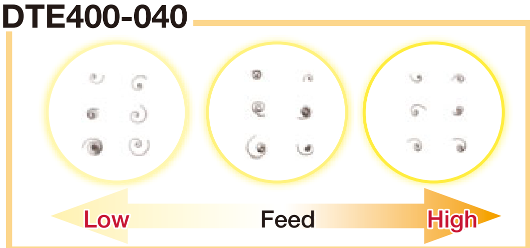
DTE4-040



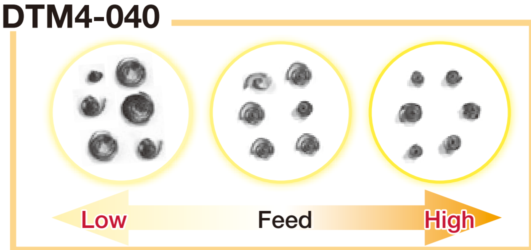
DTX



DTE400-040



DTM4-040



GROOVING, PARTING, AND TURNING

DTE

Its wide cutting edge is designed to provide good chip control at high feed rates

DTM

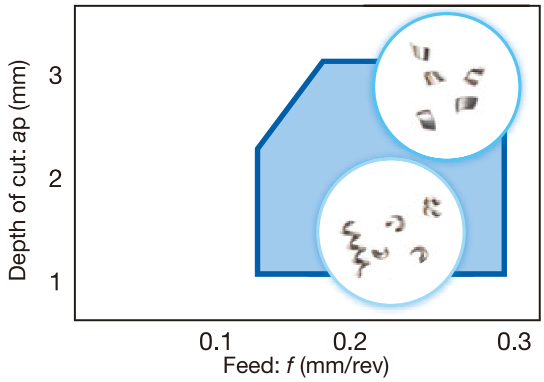
First choice chipbreaker for various applications. Optimized geometry for smooth chip breaking and flow

DTX

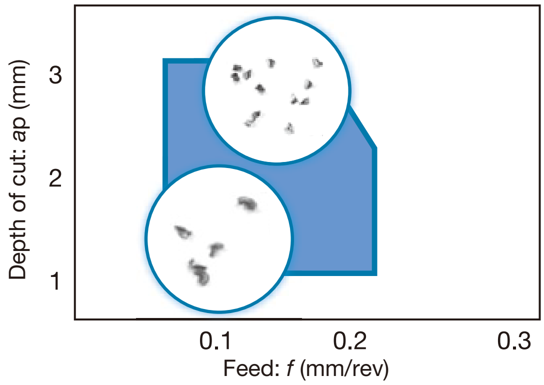
Provides good cutting performance in grooving. Its narrow cutting edge width provides excellent chip formation at low feed rates

P Carbon steel
(S45C / C45)

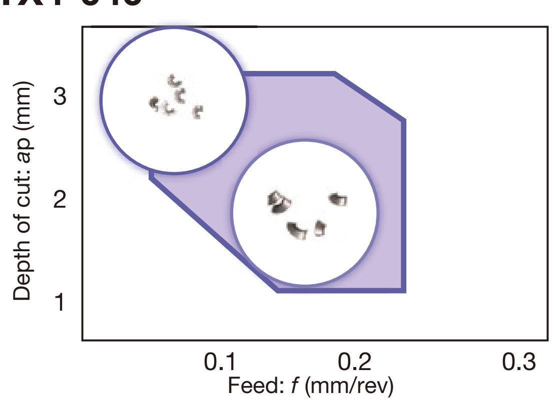
DTE4-040



DTM4-040

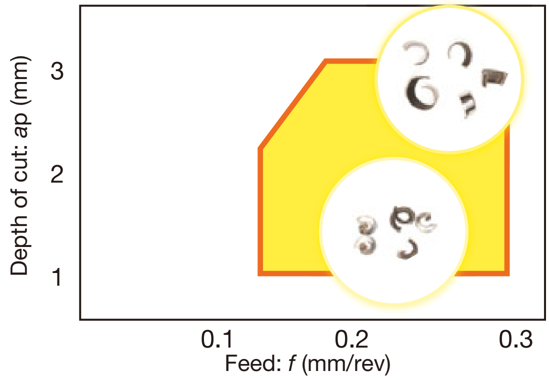


DTX4-040



M Stainless steel
(SUS304 / X5CrNi18-9)

DTE4-040



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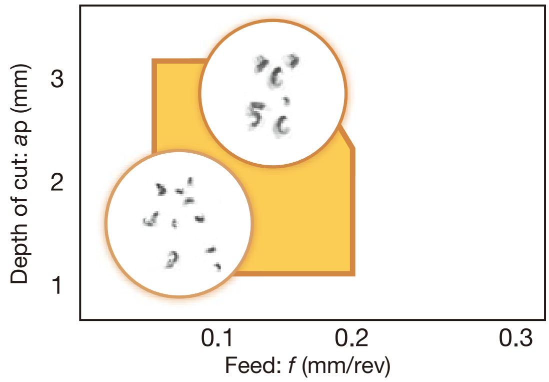
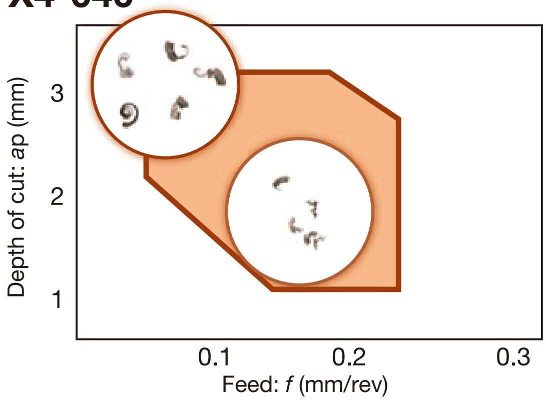


DTX4-040



Grooving and Parting Tools

TUNGCUT

Ideal chip forms of TungCut inserts

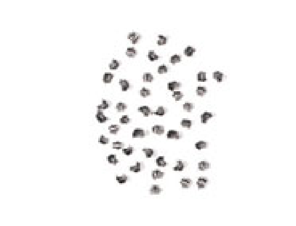
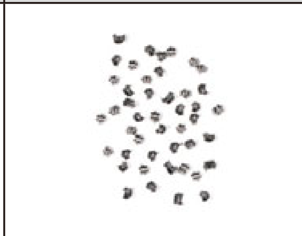
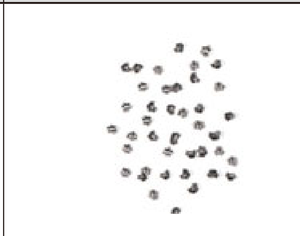
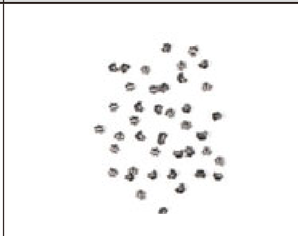
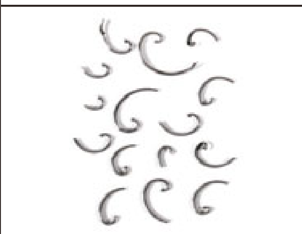
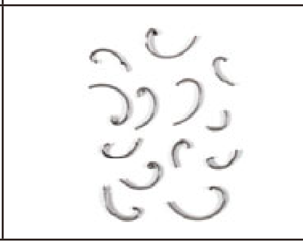
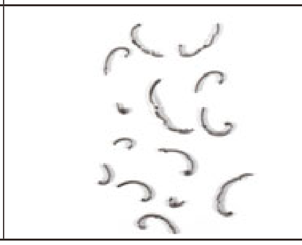
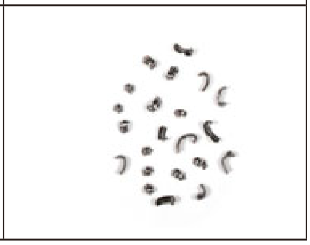
● Excellent chip control at low feed rates

P Bearing steel (B1/52100/SUJ2)

DGL

First choice chipbreaker for bearing steel. Excellent chip control at low feed rates.

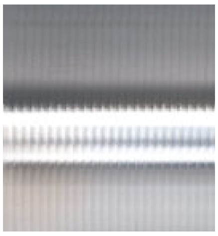
Material : SUJ2
Holder : CTER2525-3T09
Insert : DGL3-025
Cutting speed : *Vc* = 50, 100 m/min
Groove width : 3 mm

	f = 0.03	*f* = 0.05	*f* = 0.07	*f* = 0.1
Vc = 50				
Vc = 100				

Notes when using STH insert

Since the wiper geometry consists of a long arc, TungCut CBN insert provides wavy surface finishing, despite the results with excellent Ra values.

TUNGCUT
Feed: *f* = 1 mm/rev



Surface quality
Ra = 0.3 µm

ISO turning insert (with 0.8 mm nose radius)
Feed: *f* = 0.1 mm/rev

Surface quality
Ra = 0.4 µm

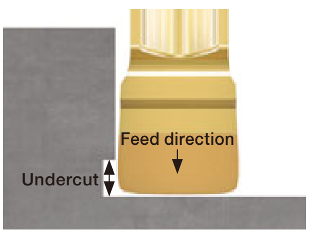
H

Insert : STH500-SR BXA10
: 2QP-CNGA120408 BXA10
Holder : CTEL2525-5T12
: ACLNL2525M12-A
Workpiece material : SCM415 (60HRC)
Cutting speed : *Vc* = 150 m/min
Feed : *f* = 0.1, 1 mm/rev
Depth of cut : *ap* = 0.1 mm
Application : External turning, continuous cut
Coolant : Wet

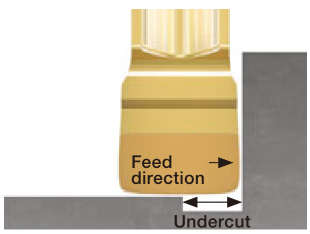
Due to the wiper geometry, ensure to program so that the wiper section of the cutting edge completely passes over the workpiece edge when external turning or face turning, otherwise, material will be left uncut on the workpiece edge. When cutting towards the wall or bottom, provide proper undercutting, as listed below, at the wall or bottom to eliminate uncut material.

Designation	CW±0.025	Application	Minimum undercutting required (mm)
STH300-SR	3	External	1.5
		Face	0.4
STH500-SR	5	External	2.5
		Face	0.7

Face turning



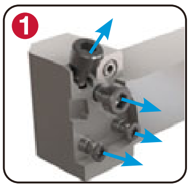
External turning



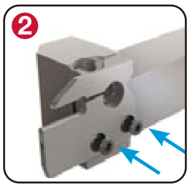
TungModularSystem

How to install and remove the blade and insert

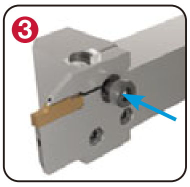
● Assembly



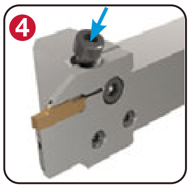
❶ Remove all 4 screws and ensure the O rings are all in place.



❷ Place the blade and tighten 2 bottom clamping screws.



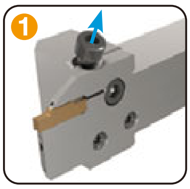
❸ Place the insert in the pocket and tighten the fixing screw in the center.



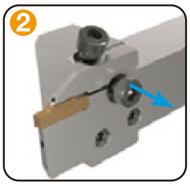
❹ Place the long screw in the angular direction and tighten to clamp the insert.

Please follow the installation order as shown above. When the screws are tightened in the ❹→❸ order, the insert clamping may be insufficient and unstable.

● Disassembly

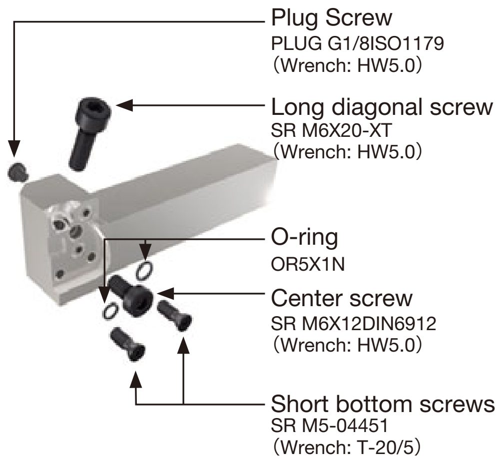


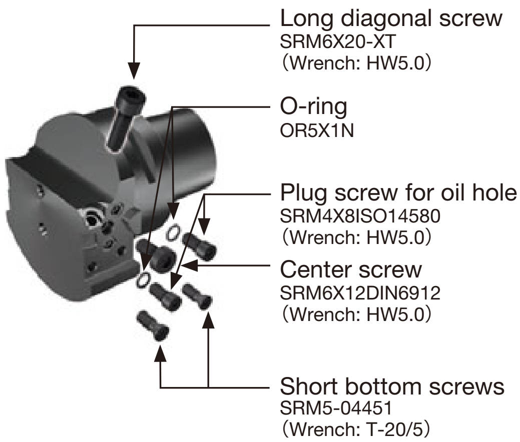
❶ First loosen the long screw in the angular direction.



❷ Loosen the Fixing screw in the center and remove the insert.

Loosing the long screw alone may not release the insert.

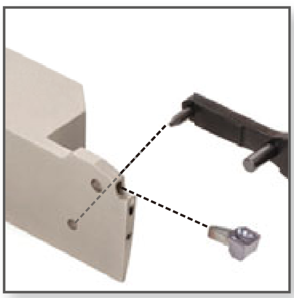




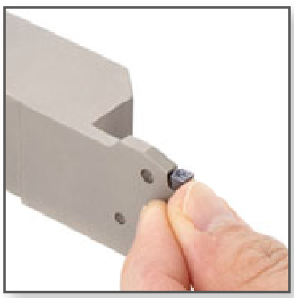
All parts listed here are included in the tool holder.

EasyMulticut

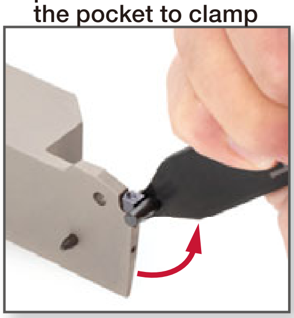
Procedure to clamp and unclamp insert



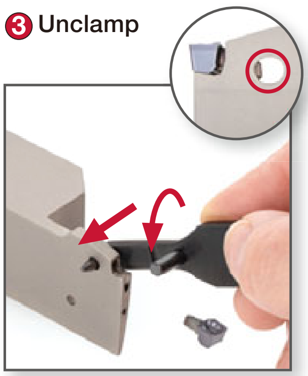
❶ Put the insert in the pocket



❷ Turn the wrench and push the insert into the pocket to clamp

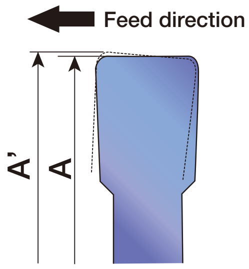
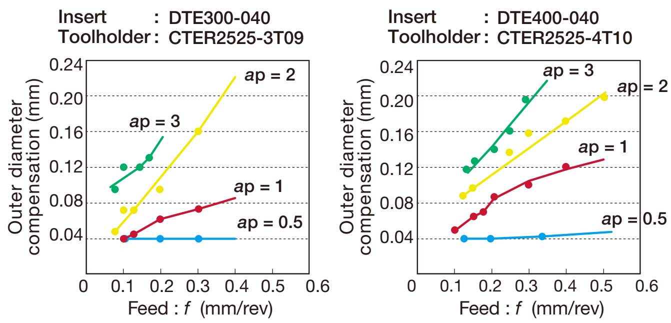


❸ Unclamp



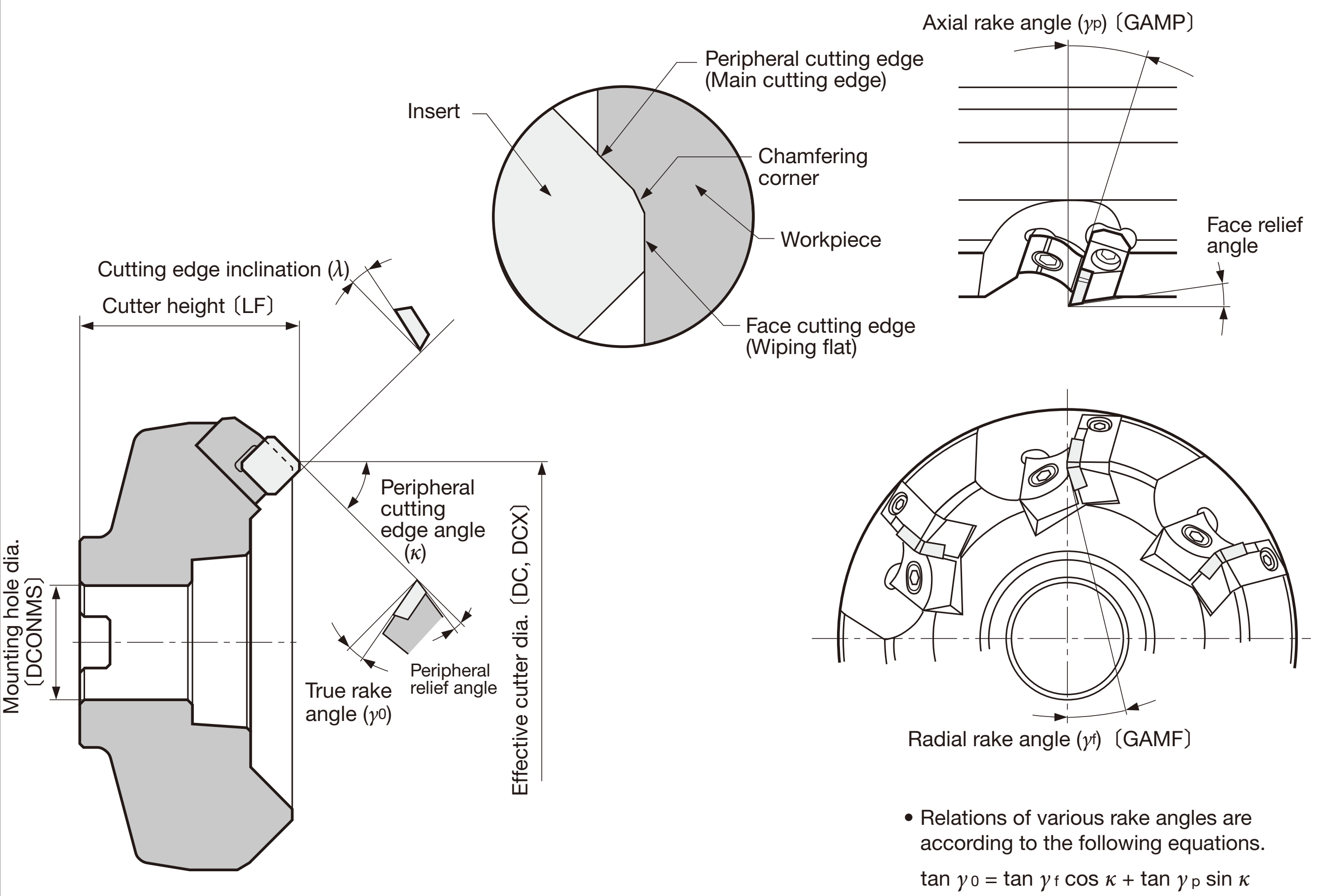
Grooving and Parting Tools

Points to consider for grooving and parting operations

Application	Points
Groove-turning	• To achieve best wiper effect, aP must be greater than the corner radius of the insert. • Do not use no more than 80% of the cutting edge length. • Use a chipbreaker geometry best suited for turning. • Use the toolholder with the shortest possible CDX (cutting depth maximum) to ensure maximum tool rigidity and process security. • The insert may be deflected by axial cutting force during turning, causing the workpiece diameter to be smaller than the required dimension(See Fig. 1). A minor tool length compensation may, therefore, be required. Exact amount of change can be measured by running a test workpiece. Refer to the charts in Fig. 2 below for diameter compensation values.  Fig. 1  Fig. 2 Value of compensation
Parting off	• Adjustment of the cutting edge height is crucial to obtain the best possible part quality in parting operations. Adjust so that the center height should not be off by no more than ±0.1 mm. • Setting the parting tool upside down aids in better chip evacuation and preventing parts from flying when parted off. • If the center height is set too low, a pip is prone on the parted parts. • Optimize tool life by reducing feed to 30% about 5 mm before the workpiece center. • Use a left- or right-handed insert with an angled front and smallest possible corner radii to prevent or minimize pips. • Use a parting tool with the thickest shank height (H) as possible for maximum tool rigidity and stability. • Use an overhang as short as possible for minimum tool deflection and process security. • When the parting distance is greater than the insert length, use a single-ended insert. • Use a insert as thin as possible. This minimizes the cutting force and saves material. • To avoid part surface from being damaged after the cut, move the tool in the axial direction to keep the cutting edge off the part before retreating the tool in the radial direction.
Face grooving	• Chip control during face grooving operations is, generally, more challenging than general grooving operations. Optimize the insert geometry considering whether the application involves grooving or groove-and-turning. • DAXMIN (axial groove inside diameter minimum) and DAXX (axial groove outside diameter maximum) in the lists indicate the diameter range of face groove width machinable from the first cut. • Choose the diameter range of the first cut (DAXMIN and DAXX). Use the tool for the largest diameter that fits your groove and turn from the outside towards the center to expand, and never cut the other way around. • Use the same feed and aP as for O.D. grooving. • For effective chip evacuation, use peck grooving method or set the tool upside down to eliminate chip nesting and chip re-cutting.
Internal grooving	• DMIN indicates minimum bore diameter that can be machined with no interference. • Optimize the insert geometry considering whether the application involves grooving or groove-and-turning. • Chip evacuation is challenging in internal grooving operations. Use coolant-through toolholder whenever possible. • Use a toolholder as thick as possible or use a vibration-resistant carbide shank to increase tool rigidity for chatter-free machining. • Always turn from the bore end towards the entrance to reduce chip nesting inside the bore and promote better chip evacuation.

Milling tools

Nomenclature for face milling cutter



- Relations of various rake angles are according to the following equations.

$\tan \gamma_0 = \tan \gamma_f \cos \kappa + \tan \gamma_p \sin \kappa$

$\tan \lambda = \tan \gamma_p \cos \kappa - \tan \gamma_f \sin \kappa$

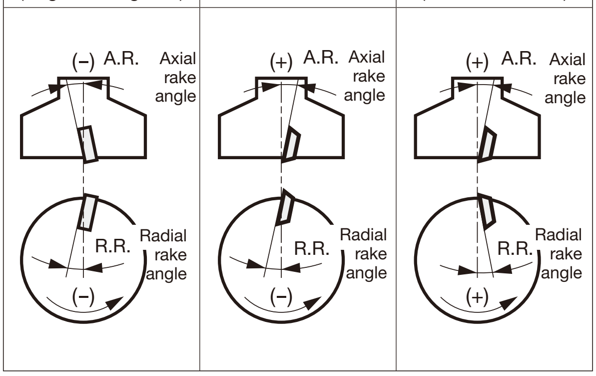
〔 〕The notation in the brackets is the one used in the catalog (ISO compliant)

Cutter geometry and applications

Condition		Rake angle combination and applicability: Negative-Negative	Negative-Positive	Positive-Positive
Shapes of cutting edge	γp〔GAMP〕	-	+	+
	γf〔GAMF〕	-	-	+
	γo	-	+	+
Workpiece material	Carbon steels, alloy steels (< 300HB)	△	◎	◎
	Stainless steels (< 300HB)	×	◎	○
	Die steels (< 300HB)	△	◎	○
	Cast irons Ductile cast irons	◎	○	○
	Aluminium alloys	×	○	◎
	Copper and its alloys	×	○	◎
	Titanium and its alloys	×	○	○
	Hardened steels (40 ~ 55HRC)	○	○	×
Features		· Higher cutting edge strength · Many usable corners of inserts	· Excellent chip removal · Higher cutting edge strength and Freer cutting action	· Most excellent cutting action
Typical examples of mills		DoPent	TungMill DoTriple-Mill	TFE12 DPD09

〔 〕The notation in the brackets is the one used in the catalog (ISO compliant)

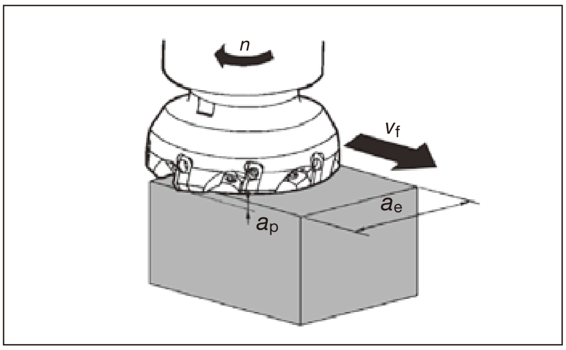
Rake angle combination		
Negative type (Negative-Negative)	Negative-Positive type	Positive type (Positive-Positive)



Milling tools

Calculation formulas for milling

●Cutting speed



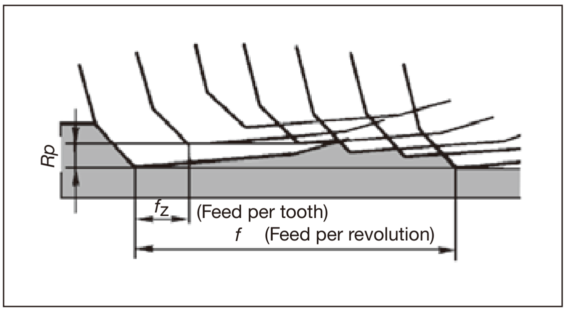
●Cutting speed (Calculated from number of revolutions)

$$\underset{(m/min)}{v_c} = \frac{\pi \times D \times n}{1000}$$

v_c : Cutting speed (m/min)
D : Effective diameter (mm) 〔DC, DCX〕
n : Number of revolutions (min^{-1})
$\pi \approx 3.14$

●Number of revolution (Calculated from cutting speed)

$$\underset{(min^{-1})}{n} = \frac{1000 \times v_c}{\pi \times D}$$



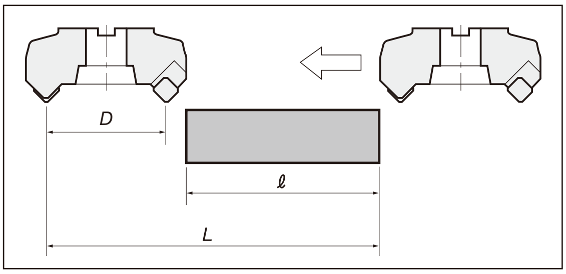
●Feed speed and feed per tooth

$$\underset{(mm/min)}{v_f} = f_z \times z \times n$$

v_f : Feed speed (mm/min)
f_z : Feed per tooth (mm/t)
z : No. of teeth of the cutter
n : Number of revolutions (min^{-1})

Feed speed is relative speed of cutter and Workpiece material and in the normal milling machine, it is the table speed.
In milling, the feed per tooth is very important. The recommended cutting condition is expressed by v_c and f_z and using the above equation calculate n and v_f and input in the machine.

●Cutting time on face milling

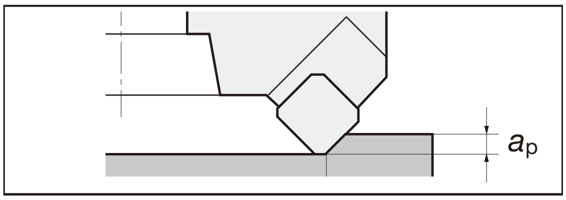


$$\underset{(min)}{T} = \frac{L}{v_f}$$

T : Cutting time (min)
L : Total table feed length.
(ℓ : Workpieces length (mm) + $ØD_c$: Effective cutter diameter (mm) 〔DC, DCX〕)
v_f : Feed speed (mm/min)

〔 〕 The notation in the brackets is the one used in the catalog (ISO compliant)

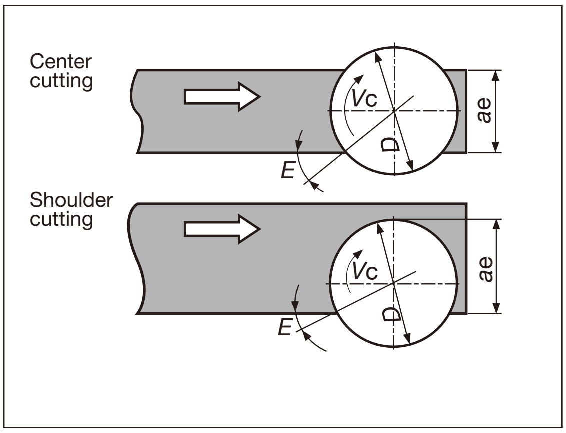
Depth of cut and width of cut



●Depth of cut

Determine by required allowance for machining and capacity of the machine. In case of mill, there are cutting limits according to shape and size of the insert. Please see spec in the catalogue.

a_p : Depth of cut (mm)



●Width of cut and engagement angle

There is an appropriate engage angle depending on the cutter diameter, cutting position, Workpiece material, etc., and ordinarily the values in the table below are used as a guide.

D : Cutter diameter (mm) 〔DC, DCX〕
E : Engage angle
a_e : Width of cut (mm)
〔 〕 The notation in the brackets is the one used in the catalog (ISO compliant)

Center cutting

Workpiece material	Appropriate E	Cutter dia. and ae
Steel	~ 42°	$a_e \fallingdotseq \frac{2}{3} D$
Cast iron	~ 53°	$a_e \fallingdotseq \frac{4}{5} D$

Shoulder cutting

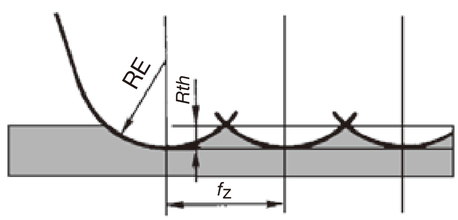
Workpiece material	Appropriate E	Cutter dia. and ae
Steel	~ 30°	$a_e \fallingdotseq \frac{3}{5} D$
Cast iron	~ 40°	$a_e \fallingdotseq \frac{3}{4} D$

Roughness of finished surface

(1) Theoretical surface roughness
Theoretical roughness as shown below, is the same as for single point turning

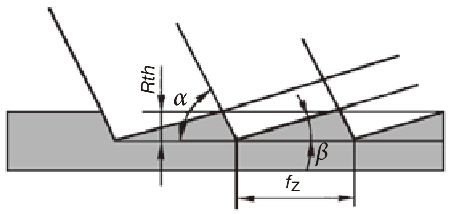
●With corner radius RE

$$Rth=\frac{fz^2}{8RE}\times1000$$

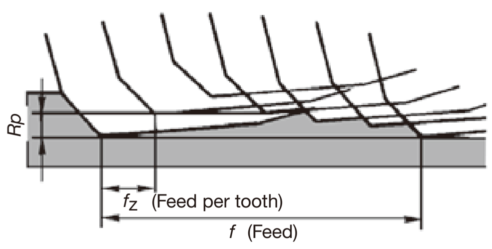


●Without corner radius RE

$$Rth=fz\left(\frac{\tan\alpha\cdot\tan\beta}{\tan\alpha+\tan\beta}\right)\times1000$$



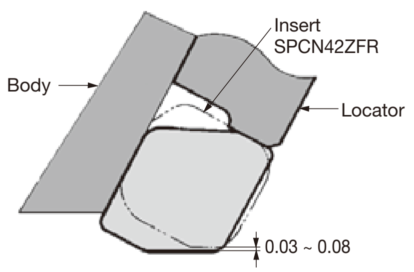
Rth : Theoretical roughness (μm)
f_z : Feed per tooth (mm/t)
RE : Corner radius (mm)
α : Corner angle
β : Face cutting edge angle



(2) Actual surface roughness

A facemill cutter in practice is composed of multiple point cutting edges and is prone to create uneven peaks, or an axial runout error (*Rp*) on cutting edges. One or two cutting edges being non-coplanar to the rest invariably create the dominant mark on a face-milled surface, producing periodic patterns corresponding to the feed per revolution *f* (mm/rev) superimposing on the feed per tooth *fz* (mm/t).

Improving surface roughness



Face run out must be minimized and a low feed and high speed should be used. Also, in order to attain good finished surface at high efficiency, there are the following methods:

(1) In case of ordinary mill
Use wiper insert as shown in the figure at left.

(2) Use of super finish mill for finishing.
- Use of combination mills with finishing insert such as TFD4400-A and TFP4000IA (a_p < 1.0 mm).
- Use of super finish mill for finishing such as NMS cutters and SFP4000 etc.

Milling tools

Calculating power requirement

$$P_c = \frac{k_c \times a_p \times a_e \times v_f}{60 \times 1000 \times 1000}$$
(kW)

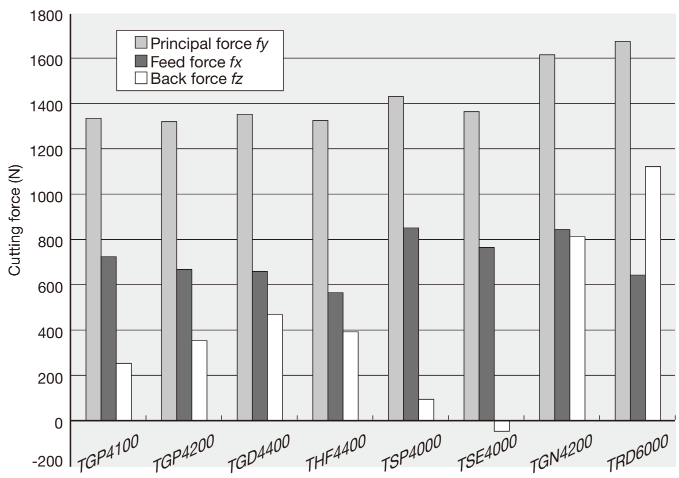
P_c : Net power requirement (kW)
k_c : Specific cutting force (N/mm²)
[Refer to the Table below]
a_p : Depth of cut (mm)
a_e : Width of cut (mm)
v_f : Feed speed (mm/min)

Because practical power requirements depend on the type of mill (proportional to the true rake angle) and the motor efficiency of the machine used, the result calculated from the above formula should be considered as a rough guide.

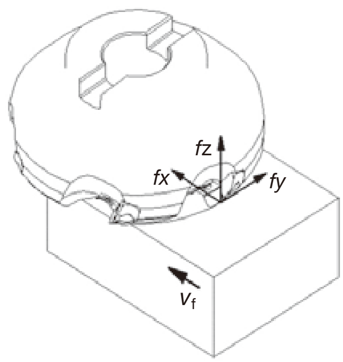
●Values of specific cutting force (k_c)

Workpiece material (JIS)	Tensile strength	Value of specific cutting force on feed per tooth k_c (N/mm²)				
	MPa	0.1 (mm/t)	0.15 (mm/t)	0.2 (mm/t)	0.3 (mm/t)	0.4 (mm/t)
SS400	520	2150	2000	1900	1750	1650
S55C	770	1970	1860	1800	1760	1620
SCM435	730	2450	2350	2200	1980	1710
SKT4	(HB352)	2030	2010	1810	1680	1590
SC450	520	2710	2530	2410	2240	2120
FC250	(HB200)	1660	1450	1320	1150	1030
Al (Si)	200	660	580	522	460	410
Brass	500	1090	960	877	760	680

●Values of cutting force



Workpiece material : S50C (210HB), Diameter of mill : ø160 mm
Cutting speed : V_c = 150 m/min, Feed per tooth: fz = 0.20 mm/t
Depth of cut: a_p = 3 mm, Cutting by a single edge, dry



●Conversion from cutting speed to number of revolutions

(unit : min⁻¹)

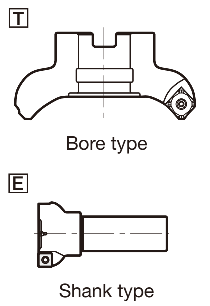
Cutter diameter DC, DCX (mm)	Cutting speed (V_c) m/min												
	10	30	50	100	125	150	200	300	500	800	1,000	2,000	4,000
10	318	955	1,592	3,184	3,980	4,777	6,369	9,554	15,923	25,477	31,847	63,694	127,388
12	265	796	1,326	2,653	3,317	3,980	5,307	7,961	13,269	21,231	26,539	53,078	106,157
16	199	597	995	1,990	2,488	2,985	3,980	5,971	9,952	15,923	19,904	39,808	79,617
20	159	477	796	1,592	1,990	2,388	3,184	4,777	7,961	12,738	15,923	31,847	63,694
25	127	382	636	1,273	1,592	1,910	2,547	3,821	6,369	10,191	12,738	25,477	50,955
30	106	318	530	1,061	1,326	1,592	2,123	3,184	5,307	8,492	10,615	21,231	42,462
32	99	298	497	995	1,244	1,492	1,990	2,985	4,976	7,961	9,952	19,904	39,808
35	90	272	454	909	1,137	1,364	1,819	2,729	4,549	7,279	9,099	18,198	36,396
40	79	238	398	796	995	1,194	1,592	2,388	3,980	6,369	7,961	15,923	31,847
50	63	191	318	636	796	955	1,273	1,910	3,184	5,095	6,369	12,738	25,477
63	50	151	252	505	631	758	1,011	1,516	2,527	4,044	5,055	10,110	20,220
80	39	119	199	398	497	597	796	1,194	1,990	3,184	3,980	7,961	15,923
100	31	95	159	318	398	477	636	955	1,592	2,547	3,184	6,369	12,738
125	25	76	127	254	318	382	509	764	1,273	2,038	2,547	5,095	10,191
160	19	59	99	199	248	298	398	597	995	1,592	1,990	3,980	7,961
200	15	47	79	159	199	238	318	477	796	1,273	1,592	3,184	6,369
250	12	38	63	127	159	191	254	382	636	1,019	1,273	2,547	5,095
315	10	30	50	101	126	151	202	303	505	808	1,011	2,022	4,044

Note: In this table, the effects of centrifugal force on the rotating balance of the tool and the toolholder, flying risk of cutter parts, and limited value of toolholder destruction are not considered. Therefore, when using the tool at high speeds, be sure to observe the specified condition range.

Trouble shooting in face milling

Trouble	Possible causes	Countermeasures
Rapid wear of cutting edge	• Improper insert grade selection (Insufficient wear resistance)	• Use a grade with high wear resistance P30 → P20
	• Excessive cutting speed	• Select cutting speed suited for Workpiece material and insert grade
	• Inadequate feed	• Use standard cutting condition in catalog as guide
Rapid chipping of cutting edge	• Improper Insert grade selection (Insufficient toughness)	• Use a grade with high fracture resistance P10 → P20
	• Cutting hard material and unfavorable surface condition	• Decrease cutting speed • Use cutter with strong cutting edge
	• Excessive feed	• Proper selection of feed conditions, using recommended cutting conditions in catalog as guide
	• Excessive pressure applied on cutting edge	• Proper selection of engaging angle
	• Machining superalloys	• Use a negative-positive type cutter with large corner angle
Fracturing	• Cracking due to thermal shock	• Select insert grade of stronger thermal shock resistance • Decrease cutting speed
	• Continuous use of excessively worn insert	• Shorten replacement standard time of insert
	• Cutting hard material	• Use cutter with stronger cutting edge • Use cutter of larger corner angle
	• Obstruction to chip flow • Recutting of chips after chip welding	• Use cutter with better chip expulsion • Select insert grades difficult for chips to adhere Cemented carbides → cermets, coated grades • Use air blow
	• Excessively slow cutting, too fine feed	• Select cutting speed and feed optimized for insert grade and Workpiece material
Excessive chip welding or build-up on cutting edge	• Cutting soft material such as aluminium, copper, mild steel	• Use cutter with large rake angle
	• Cutting stainless steel	• Coated grades (AH130、AH3135)
	• Use of cutter with negative rake or too small rake angle	• Use cutter with large rake angle
Rough finish	• Effect of built-up edge	• Increase cutting speed • Appropriate cutting depth (finish allowance) • Change insert grade For steels : P → coated → cermet For cast irons : K → coated
	• Effect of face cutting edge run out	• Proper installing of inserts • Use insert of high dimensional accuracy • Cleaning of insert pocket
	• Continuous use of excessively worn insert	• Shorten replacement standard time of insert
	• Remarkable feed marks	• Feed per revolution to be set within flatland width • Use wiper insert type cutter such as T/EAW13 • Use cutter exclusively for finishing
Chattering	• Unstable clamping of workpiece	• Check clamping method of workpiece
	• Cutting of welded construction of thin steel plate	• Use cutter of large rake angle and small corner angle
	• Excessive cutting condition	• Re-examine allowable chip removal rate according to motor HP
	• Face milling of narrow width workpiece	• Use cutter of small cutter diameter and with many teeth
	• Too many simultaneous cutting teeth engagement	• Reduce No. of teeth

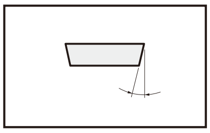
New Designation System for Milling Cutters



Symbol	Type
T	Bore type
E	Shank type

① Type

H	Hybrid TAC Mill Series



Symbol	Relief angle
C	7°
P	11°
D	15°
E	20°
F	25°
N	0°
Others	Special

③ Relief angle

Symbol	Hand
R	Right
L	Left

⑤ Direction of cut

Symbol	Unit
M	mm
U	in

⑦ Unit

Symbol	Type
T~: General type	
–	JIS
E	ISO
A	ANSI
E~: Shank type	
–	Cylindrical
W	Weldon
C	Combination

⑨ Attachment specification

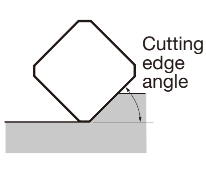
Symbol	Type
W	Wedge clamp
L	Long shank
LE	Long edge
CS	Carbide shank

⑪ Additional feature

①	②	③	④	⑤	⑥	⑦	⑧	⑨	⑩	⑪
T	A	W	13	R	080	M	25.4	-	06	--
E	V	H	07	R	012	M	12.0	-	02	L

② Angle, Category

Symbol	Cutting edge angle
P	90° ~ 80°
E	80° ~ 70°
D	60° ~ 50°
A	50° ~ 40°
L	With long cutting edge
Others	Special

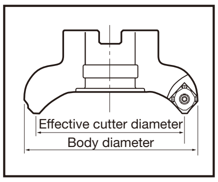


④ Cutting edge length

Symbol	Size (ℓ)
S	ℓ
T	ℓ
R	ℓ
H	ℓ
A	ℓ

⑥ Effective cutter diameter

Symbol	Size
M: Unit in mm	
080	80 mm
200	200 mm
I: Unit in inch	
200	2 in
10H	10 in

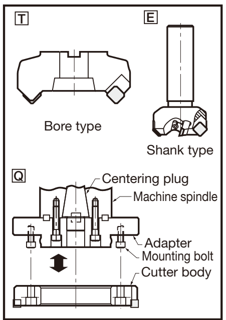


⑧ Attachment size

Symbol	Size
M: Unit in mm Hole diameter	
20.0	20 mm
25.4	25.4 mm
31.7	31.75 mm
47.6	47.625 mm
I: Unit in inch Hole diameter	
0075	0.75 in
0125	1.25 in
0200	2 in
E~: Shank type Shank diameter	
10.0	10 mm
12.0	12 mm
16.0	16 mm
25.0	25 mm
32.0	32 mm

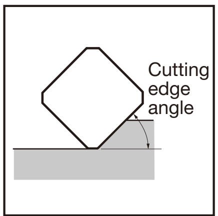
⑩ Number of inserts

Previous Designation System for Milling Cutters



Symbol	Type
V	Vertical insert
Q	Quick change
E	Shank
T	Bore
S	Special
D	All PCD tipped
Q	All PCBN tipped

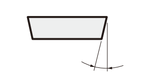
① Type



Symbol	Cutting edge angle
X	Others
Z	Others
V	Others
P	90˚ ~ 80˚
E	80˚ ~ 70˚
D	60˚ ~ 50˚
A	50˚ ~ 40˚

② Angle

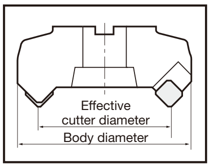
Symbol	Relief angle
C	7°
D	15°
E	20°
F	25°
N	0°
P	11°
X	Others



③ Relief angle

R Symbol	Size	S Symbol	Size	C Symbol	Size	T Symbol	Size	Inscribed circle dia. (mm)
		06	6.35	06	6.5	11	11	6.35
		07	7.94	08	8.1	13	13.8	7.94
09	9.525	09	9.525	09	9.7	16	16.5	9.525
10	10	–	–	–	–	–	–	10
12	12	–	–	–	–	–	–	12
12	12.7	12	12.7	12	12.9	22	22	12.7
15	15.875	15	15.875	16	16.1	27	27.5	15.875
16	16	–	–	–	–	–	–	16
19	19.05	19	19.05	19	19.3	33	33	19.05
20	20	–	–	–	–	–	–	20
25	25	–	–	–	–	–	–	25
25	25.4	25	25.4	25	25.8	44	44	25.4
31	31.75	31	31.75	32	32.2	55	55	31.75

④ Cutting edge length



Symbol	Effective diameter (mm)
050	50
063	63
080	80
100	100
125	125
160	160
200	200
250	250
315	315
355	355
400	400

⑤ Effective cutter diameter

Example
Metric system

①	②	③	④	⑤	⑥
T	F	E	12	063	R

Example
Inch system

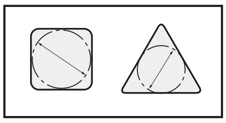
T	M	D	4	4	06	R	I
①	⑧	③	⑨	⑩	⑪	⑥	⑦

⑧ Application, etc.

Symbol	Application, geometry etc.
M	For machining centers
F	For finishing
G	General purpose
S	For square shoulder milling
H	High rake geometry
P	Negative axial, positive radial rake geometry
R	Use round inserts
U	For difficult to cut materials
C	For chamfering
L	Long edge type
T	For threading

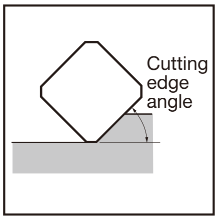
⑨ Size of applicable insert

Symbol	I. C. (mm)
3	9.525
4	12.7
5	15.875
6	19.05
7	22.225
8	25.4
9	31.75



⑩ Angle

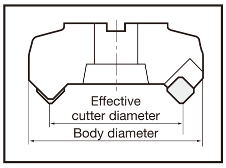
Symbol	Cutting edge angle
0	90˚ ~ 80˚
1	80˚ ~ 70˚
2	70˚ ~ 60˚
3	60˚ ~ 50˚
4	50˚ ~ 40˚
5	40˚ ~ 30˚
6	30˚ ~ 20˚
7	20˚ ~ 10˚



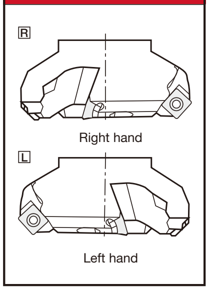
⑪ Effective cutter diameter

Symbol	Effective diameter (mm)
50	50
63	63
03	80
04	100
05	125
06	160
08	200
10	250
12	315
14	355
16	400

Note: For diameter of less than 80mm,nominal dimensions (mm) of effective diameter are shown

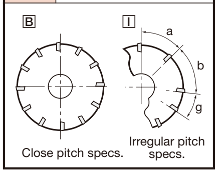


⑥ Direction of cut



⑦ Additional feature

Symbol	Additional feature
B	Close pitch
I	Irregular pitch
A(-A)	Modified type
S	For distinguishing shank size
L	Long shank



Note: The above nomenclature is not applicable for VSN6000I, MS cutter, TCB, PES1500 and TBN etc.

Designation System for Milling Inserts

④ Groove and hole

Symbol	Hole	Shape of hole	Chipbreaker	Shape
N	Without	–	Without	
R			Single-sided	
F			Double-sided	
W	With	Partly cylindrical hole, single-side 40° ~ 60° Counter sink	Without	
T			Single-sided	
Q		Partly cylindrical hole, double-side 40° ~ 60° Counter sink	Without	
U			Double-sided	
B		Partly cylindrical hole, single-side 70° ~ 90° Counter sink	Without	
H			Single-sided	
C		Partly cylindrical hole, double-side 70° ~ 90° Counter sink	Without	
J			Double-sided	
X	–	–	–	

⑤ Cutting edge length

Shape	Cutting edge length (ℓ)
S	
T	
R	
H	
A	

⑥ Thickness

Symbol	Thickness (mm)
02	2.38
03	3.18
T3	3.97
04	4.76
05	5.56
06	6.35
07	7.94
09	9.52

Thickness

(Example) **Metric**: ① P ② N ③ C ④ U ⑤ 09

(Example) **Inch**: ① S ② D ③ K ④ N ⑤ 4

① Shape

Symbol	Shape	Nose angle (degree)	Figure
H	Hexagonal	120°	
S	Square	90°	
T	Triangular	60°	
C	Rhombic	80°	
E		75°	
G		70°	
L	Rectangular	90°	
A	Parallelogram	85°	
R	Round		
W	Wiper	80°	
W	Special	–	
O	Octagonal	135°	
P	Pentagonal	108°	
X	Special	Others	
Y	Special		
Z	Special		

② Relief angle

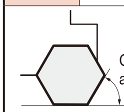
Symbol	Relief angle
C	7°
D	15°
E	20°
F	25°
G	30°
M	Others
N	0°
P	11°
Q	Other applications
O	Other applications
X	Other applications
S	Other applications
W	2-step relief

③ Accuracy (mm)

Symbol (class)	Corner height (m)	Thickness (s)	I. C. dia. (ød)
A	± 0.005	± 0.025	± 0.025
C	± 0.013	± 0.025	± 0.025
E	± 0.025	± 0.025	± 0.025
G	± 0.025	± 0.13	± 0.025
H	± 0.013	± 0.025	± 0.013
K	± 0.013	± 0.025	± 0.05 ~ ± 0.13
M	± 0.08 ~ ± 0.18	± 0.13	± 0.05 ~ ± 0.13
N	± 0.08 ~ ± 0.18	± 0.025	± 0.05 ~ ± 0.13

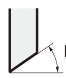
Standard I. C. dia.	I. C. dia. (ød) tolerance		Corner height (mm) tolerance	
	J, K, L, M, N	U	M, N	U
6.35	± 0.05	± 0.08	± 0.08	± 0.13
9.525				
12.7	± 0.08	± 0.13	± 0.13	± 0.2
15.875	± 0.1	± 0.18	± 0.15	± 0.27
19.05				
25.4	± 0.13	± 0.25	± 0.18	± 0.38

Symbol	Cutting edge angle
A	45°
D	60°
E	75°
F	85°
G	70°
H	87°
P	90°
U	Special, small entering angle
Z	Special, universal



⑦ Cutting edge angle

Symbol	Relief angle
A	3°
B	5°
C	7°
D	15°
E	20°
F	25°
G	30°
N	0°
P	11°
Z	Special



⑧ Wiper relief angle

Symbol	Cutting edge	Shape
F	Sharp	
E	Round	
T	Chamfer	
S	Combination	
P	Combination	

⑨ Major cutting edge

Symbol	Hand of insert
R	Right
L	Left
N	Without

⑩ Hand of insert

Symbol	Description
HM	General-purpose high feed milling chipbreaker
MM	General-purpose milling chipbreaker
MW	Milling insert with wiper edge
B	Milling insert for burr removal
D	Insert with diamond sintered body
W	Wiper insert (multiple corners)
WS	Wiper insert (single corner)
WD	Wiper insert (with diamond sintered body)
BD	Wiper for burr removal (diamond sintered body)
MJ	General-purpose milling chipbreaker
MH	Milling chipbreaker with reinforced cutting edge
ML	Milling chipbreaker for low cutting force
MS	Milling chipbreaker for stainless steel
HJ	High feed milling chipbreaker
AJ	Milling chipbreaker for non-ferrous metal
NMJ	General-purpose milling chipbreaker with serration
NAJ	Milling chipbreaker with serration for non-ferrous metal

⑪ Supplementary symbol

⑥	⑦	⑧	⑨	⑩		⑪
05	**G**	**N**	**E**	**R**	**-**	**MJ**
2	**Z**		**T**	**N**		**16**
⑥	⑦		⑨	⑩		⑪

④ Groove and hole

Symbol	Shape of hole	Hole
A	Without	With
F	Double side	Without
G	Double side	With
M	Single side	With
N	Without	With
U	Without	Without
W	Without	With

⑤ Inscribed circle (I. C.)

	Symbol	I. C. dia. (mm)
Inch	**3**	9.525
	4	12.7
	5	15.875
	6	19.05

⑥ Thickness

	Symbol	Thickness (mm)
Inch	**2**	3.18
	3	4.76
	4	6.35
	6	9.52

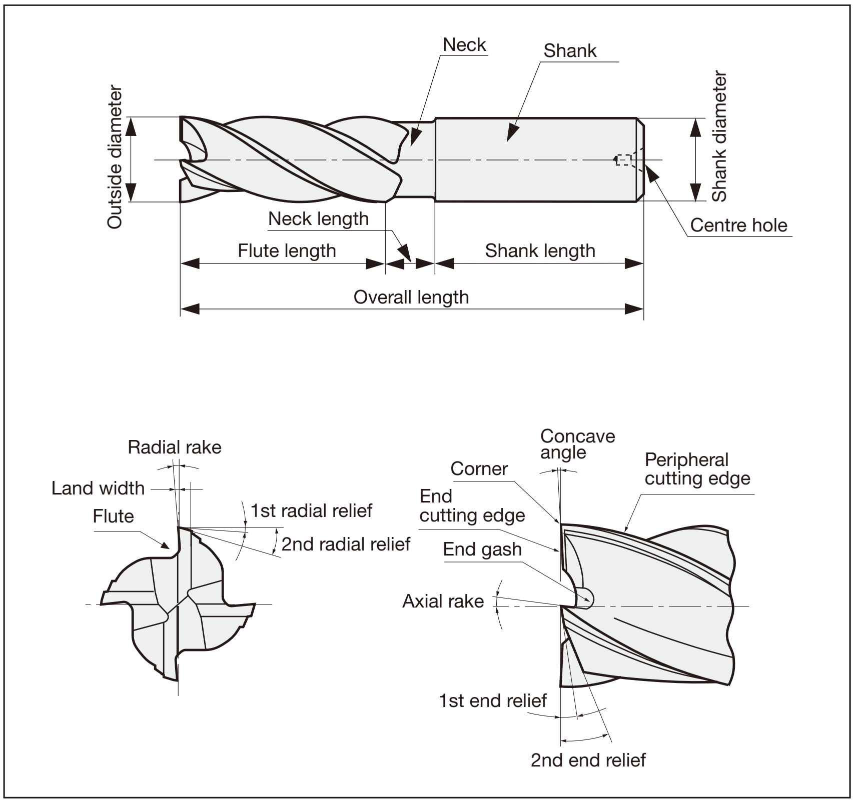
⑦ Corner radius

Symbol	Corner radius (mm)
1	0.4 (0.397)
2	0.8 (0.794)
3	1.2 (1.191)
4	1.6 (1.588)
5	2.0 (1.984)
6	2.4 (2.381)
Symbol	**Description**
F	Special design (e.g. for MS cutter)
H	 Chamfer for corner angle 60°
S	 Chamfer for corner angle 15°
Z	 Flat chamfer

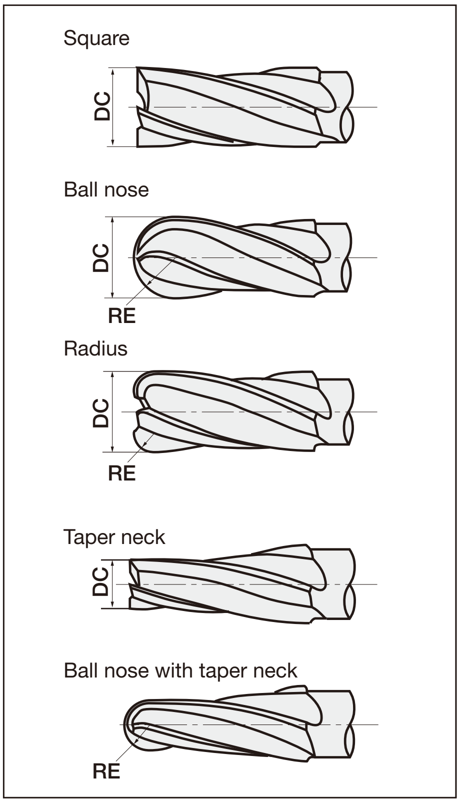
*For wiper inserts, the designation uses “W” as the shape symbol of inch items. For metric items, the shape symbol is the same as that of regular inserts, and a supplementary symbol, such as W, WS, and WD, is at the end of each designation.

Solid Carbide Endmills

Part details

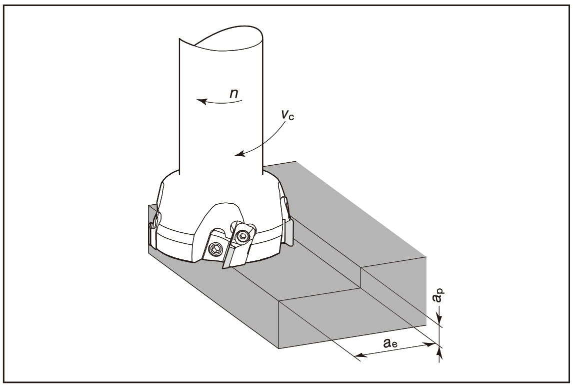


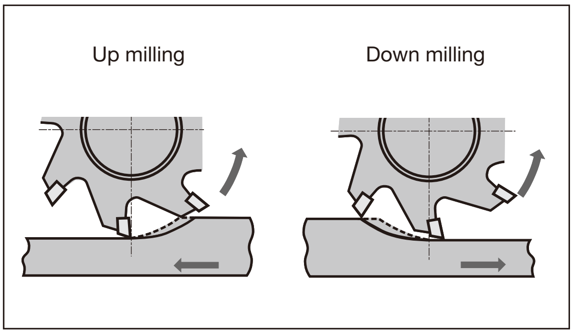
Types



Cutting condition of Endmills

● Cutting speed





● Cutting speed (Calculated from number of revolutions)

$$\underset{\text{(m/min)}}{v_c} = \frac{\pi \times D \times n}{1000}$$

v_c : Cutting speed (m/min)
d : Effective diameter (mm) 〔DC〕
n : Number of revolutions (min^{-1})
$\pi \approx 3.14$

● Number of revolution (Calculated from cutting speed)

$$\underset{(min^{-1})}{n} = \frac{1000 \times v_c}{\pi \times D}$$

● Feed speed and feed per tooth

$$\underset{\text{(mm/min)}}{v_f} = f_z \times z \times n$$

v_f : Feed speed (mm/min)
f_z : Feed per tooth (mm/t)
z : No. of teeth of the endmills 〔NOF〕
n : Number of revolutions (min^{-1})
〔 〕 The notation in the brackets is the one used in the catalog (ISO compliant)

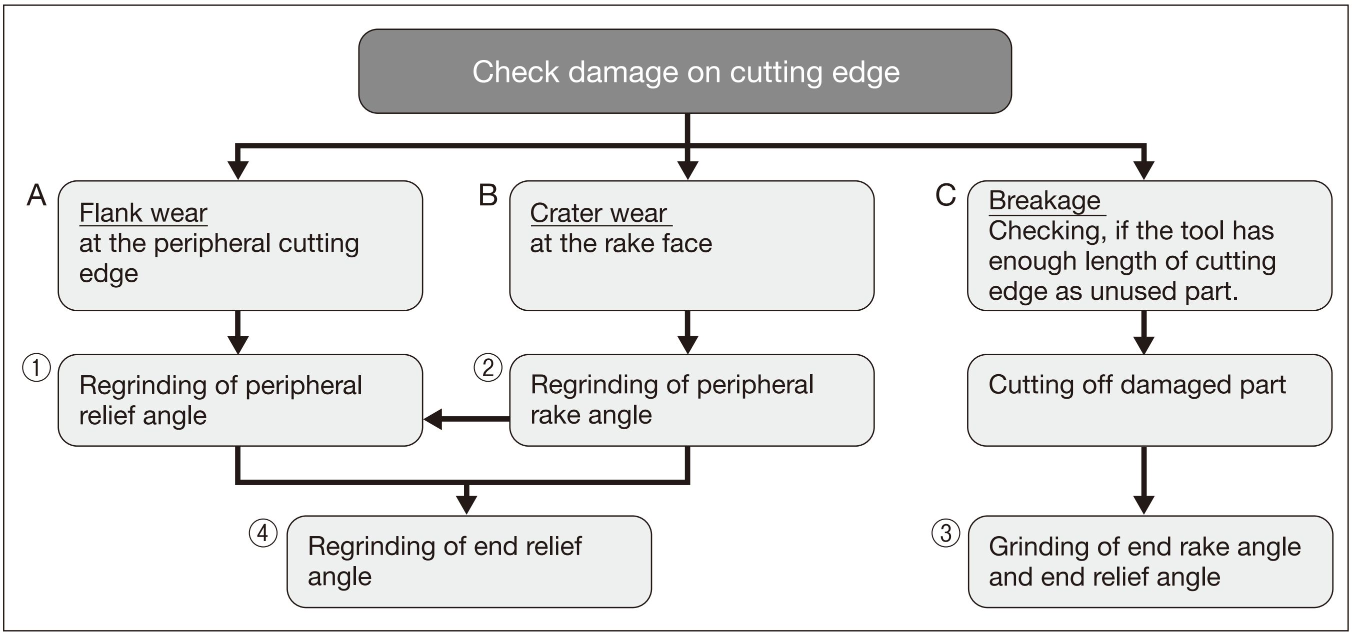
● Depth of cut

The necessary capacity of the machine is limited by the length of cut edge of the endmill.

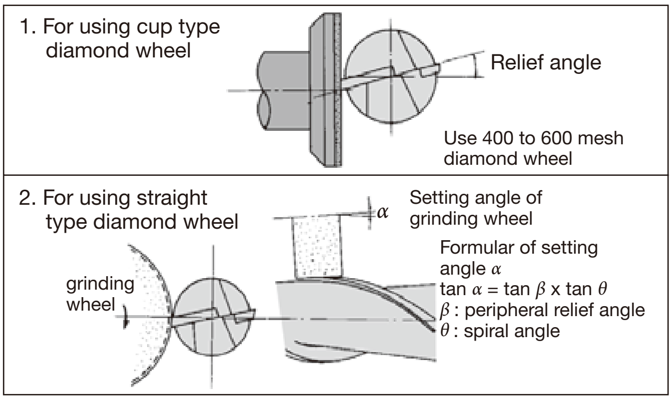
● Up milling and down milling

Down milling generally produces better tool life and surface roughness.
In case of cast iron sand inclusion or welding surface, up milling is recommended.

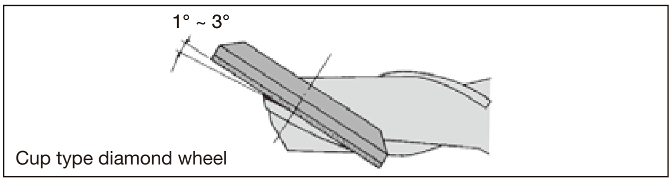
Regrinding procedures of solid carbide endmill



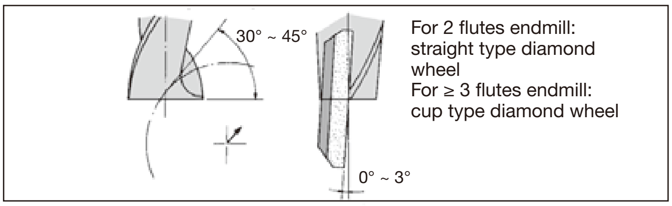
1 Regrinding of end relief angle



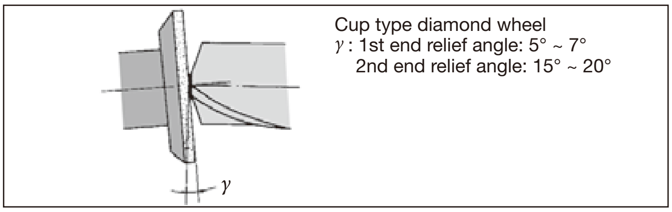
2 Regrinding of peripheral rake angle



3 Regrinding of end rake angle (End gash)



4 Regrinding of end relief angle



● Notice of regrinding

(1) If, after checking the damage of the cutting edge, the damage is as case "A" or "B" of the flow chart, the tool must be reground.
Too much damage of the cutting edge requires too much stock removal and thus reduces tool life.

(2) Please use diamond grinding wheel.

(3) Peripheral relief angle must be ground between 18° and 10°.
Relief angle of small diameter cutters for aluminium machining must be a large degree.

(4) First check if "C" in flow chart can be adapted for the case of coated endmill or not.
If procedure "C" can be adapted for regrinding, tool life after the grinding would be more improved than new one. The reason is remaining coated layer of cutting edge and shorter tool length will keep much higher rigidity of the tool than before regrinding.

(5) Please check run out of peripheral cutting edge, face cutting edge, with Vee block after regrinding.
The value of the run out must be controlled within 0.01 mm.

● Notice for regrinding of ball nose endmill

- Regrinding of relief angle only is available. The dimension of nose radius will be smaller after grinding.
- Honing of cutting edge is necessary after regrinding.

Solid Carbide Endmills

Trouble shooting in Endmilling

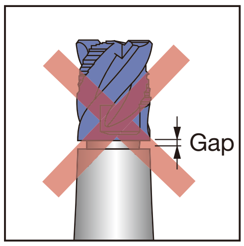
Trouble	Possible causes	Countermeasures
Breakage	● At the start of machining ● At the end of machining	● Reduce feed. ● Reduce tool overhang length. ● Exchange to short cutting edge tool.
	When usual machining	● Reduce feed. ● Managing tool life → Exchange in shorter time. ● Replace chuck or collet to new one. ● Reduce tool overhang length. ● Make optimum honing on the edge. ● Reduce flutes. E.g. 4 flutes → 3flutes, or 2flutes. ● Use enough coolant. Change direction of supplying coolant.
	When change the direction of feed	● Use the circular interpolation in NC machine. Stop feed shortly before changing. ● Lower feed around changing part. ● Replace chuck or collet to new one.
Fracture on cutting edge	Chipping on corner edge	● Chamfer the corner with hand-stick grinder. ● Down cutting ⇒ Upward milling.
	Chipping on boundary part	● Change cutting direction, Down cutting → Upward milling. ● Reduce cutting speed.
	Chipping on central part or all edges.	● Make slight honing on the edge. Or make honing bigger. ● Change spindle revolution number. ● Increase cutting speed. ● If chattering, increase feed. ● Use coolant or air blast. ● Replace chuck or collet to new one. ● Decrease cutting speed.
	Fracture on cutting edge	● Decrease feed. ● Reduce flutes. E.g. 4 flutes → 3flutes, or 2flutes. ● Make slight honing on the edge. Or make honing bigger. ● Replace chuck or collet to new one. **【For Solid carbide endmill】** ● Decrease cutting speed. ● Use enough coolant. Change direction of supplying coolant.
Large wear in short time		● Decrease cutting speed. ● Change cutting direction, Upward milling → down cutting. ● Increase feed. ● Use coolant or air blast. ● In reground tool, grind flank face with FINER wheel.

(Continued on next page)

Trouble	Possible causes	Countermeasures
Poor surface finish	Bright, but Wavy surface	● Reduce feed per tooth. ● Increase flutes; E.g. 2 flutes → 3flutes, or 4flutes.
	Small chips are welded on surface.	● Increase cutting speed. ● Use coolant or air blast, or increase coolant. ● Make slight honing on the edge. ● Upward milling → Down cutting. ● Increase feed per tooth. Increase Depth of Cut.
	Scratches on the surface	● Make slight honing on the edge. ● Use non-water soluble coolant. ● Down cutting → Upward milling.
	Poor surface by over cutting	● Reduce depth of cut. ● Increase cutting speed. ● Reduce feed per tooth.
Poor accuracy	Finish size becomes a minus tendency.	● Upward milling → Down cutting. ● Reduce depth of cut. ● Replace chuck or collet to new one. ● Reduce overhang length. ● Increase cutting speed.
	Poor straightness	● Reduce depth of cut. ● Replace chuck or collet to new one. ● Reduce overhang length. ● Increase cutting speed. ● Increase flutes; E.g. 2 flutes → 4flutes. ● Reduce feed per tooth. ● Check the edge. Change tool, when needed.
Chattering		● Increase feed per tooth. Reduce feed per tooth, when current feed is more than 0.07 mm/t. ● Change cutting speed. ● Replace chuck or collet to new one. ● Reduce overhang length. ● Use 2 flutes tool in roughing. Use 4 flutes tool in finishing. ● Down cutting → Upward milling.

■CAUTIONARY POINTS IN USE

- The cutting heads specified by Tungaloy must be used. Avoid using alternate heads that are not Tungaloy products as this will damage the shank and can cause severe accident or injury.
- Before setting the head, clean the connection screw with an air blast or a wiping cloth to remove chips and other foreign matter that may remain.
- Do not apply the lubricant to the connection screw.
- Please use the correct wrench with the correct cutting head. Tighten the head slowly until the face of the head contacts the shank. (Please refer to the picture shown on the right.) Do not re-tightening or over-tightening. Excessive tightening may cause the cutting head to break.
- Do not apply excessive force or a hammer when tightening or exchanging the cutting heads.



SOLIDMEISTER Designation System

① Endmill Code

TE	Solid Carbide
TC	Ceramic

② Endmill type

C	Square endmill
CK	Square endmill for Ti
CA	Square endmill for aluminium
CC	Square endmill with chamfered
CH	Square endmill for finishing
B	Ball nose
FF	High feed
FS	FINISHMEISTER
CP	Chip splitter
CR/RC/RF	Rougher
TR	Tapered & radius
BRF	Ball nose & rougher

③ Cutting diameter (mm)

004	0.4
045	4.5
100	10

① TE ② C ③ 009 A 2 - ⑥ 0135

TE C 100 ④ E ⑤ 4L - ⑥ 22

④ Helix angle

N	0°
C	10°
T	20°
A	30°
E	38°
B	45°
D	50°
F	55°
H	Variable helix

⑤ No. of flutes

2	2 flutes
3	3 flutes
4	4 flutes
4M	4 flutes & medium length
4L	4 flutes & long length
4X	4 flutes & extra long length
4MF	4 flutes & medium length for hardened steel
44	4 variable pitch flutes

⑥ Effective cutting length (mm)

006	0.6
0135	1.35
06	6
20	20

Tolerance

Diameter range	Cutting diameter DC^{e8}	Shank $DCONMS^{h6}$
< 3	-0.014 - 0.028	0 - 0.007
3 - 6	-0.02 - 0.038	0 - 0.008
6 - 10	-0.025 - 0.047	0 - 0.009
10 - 18	-0.032 - 0.059	0 - 0.011
18 - 30	-0.04 - 0.073	0 - 0.013

⑦ Length of neck / Angle neck (mm)

/04	4
/10 /1.5	10 / 1.5°
/14	14

⑧ Shank type

C	Cylindrical
W	Weldon

⑨ Shank diameter (mm)

055	5.5
08	8
4	4

⑦ /06 ⑧ C ⑨ 4 M E66

/32 C 10 ⑩ CF- ⑪ 72

⑩ Workpiece material / Additional feature

-	General
S	Stainless steel
M	Steel medium hardness ≤ 55 HRC
H	Steel high hardness ≥ 55 HRC
R02A	Aluminium
CF	VARIABLEMEISTER
R16	Corner radius: 1.6

⑪ Overall length / Corner radius

66	66 mm
180	180 mm
E**	Eco type
M	Medium
R08	Corner radius: 0.8

TUNGMEISTER Designation System

Shank

V (1) SS (2) D10 (3) L070 (4) S (5) 06 (6) - W (7) - A (8)

1 Series	
V	TungMeister

2 Shank type	
SS	Straight neck
TS	Taper neck
SC	Slotting
ST	T-slotting
AD	TungFlex adapter
ER	ER collet holder

3 Shank diameter (mm)	
D06	ø6
D08	ø8
D10	ø10
D12	ø12
D16	ø16
D20	ø20
D25	ø25
D32	ø32
VSC, VAD type	
100	ø10
120	ø12
130	ø13
180	ø18
210	ø21
VER type	
11A	Collet size
16A	Collet size

4 Length (mm)	
L070	70

5 Shape of shank	
S	Cylindrical
W	Weldon

6 Connection screw size	
04	S04
05	S05
06	S06
08	S08
10	S10
12	S12
15	S15
21	S21

7 Shank material	
S	Steel
C	Carbide
W	Tungsten

8 Additional feature	
A	with coolant hole
M	Thread size (TungFlex adapters)

Head

● Square endmill

V (1) E (2) E (3) 080 (4) L05.0 (5) R00 (6) - (7) 03 (8) S05 (9)

● Ball nose endmill

V (1) B (2) D (3) 200 (4) L15.0 (5) - BG (6) - (7) 04 (8) S12 (9)

1 Series	
V	TungMeister

2 Cutting edge	
E	Square
B	Ball
R	Radius
FX	High feed
CA	Chamfering
CP	Spot drilling
DS	Spot drill with helical flutes
CW	Chamfering (front and back)
CR	R chamfering
GC	Counterboring
DP	Center drilling
S	Slotting
TB	T-slotting
FM	Face milling
BO	Taper barrel
BN	Bull nose
BL	Lens
MT	Threading (full profile)
TR	Threading (partial profile)

3 Helix angle / Rake face	
B	0°
C	15°
D	30°, 37°, 47°
E	38°, 45°, 50°
F	60°
H	43°
T	Land

4 Diameter (mm)	
060	ø6
200	ø20

5 Cutting edge length (mm)	
Length	
L07.0	7
L15.0	15
Groove width	
W1.50	1.5
W1.57	1.57
W10.0	10

6 Corner shape / Angle	
Nose radius	
R00	Sharp edge
R005	R0.05
R01	R0.1
R05	R0.5
R10	R1.0
Chamfer type	
C15	0.15 x 45°
C30	0.3 x 45°
C60	0.6 x 45°
Chamfering head	
A30	30°
A60	60°
R chamfering head	
R10	R1.0
R16	R1.6
Ball nose	
SG	Sphere / high precision
BM	Ball / general purpose
BG	Ball / high precision
Threading	
IS**	ISO metric, pitch**
UN**	Unified, **TPI
W**	Whitworth, pitch**

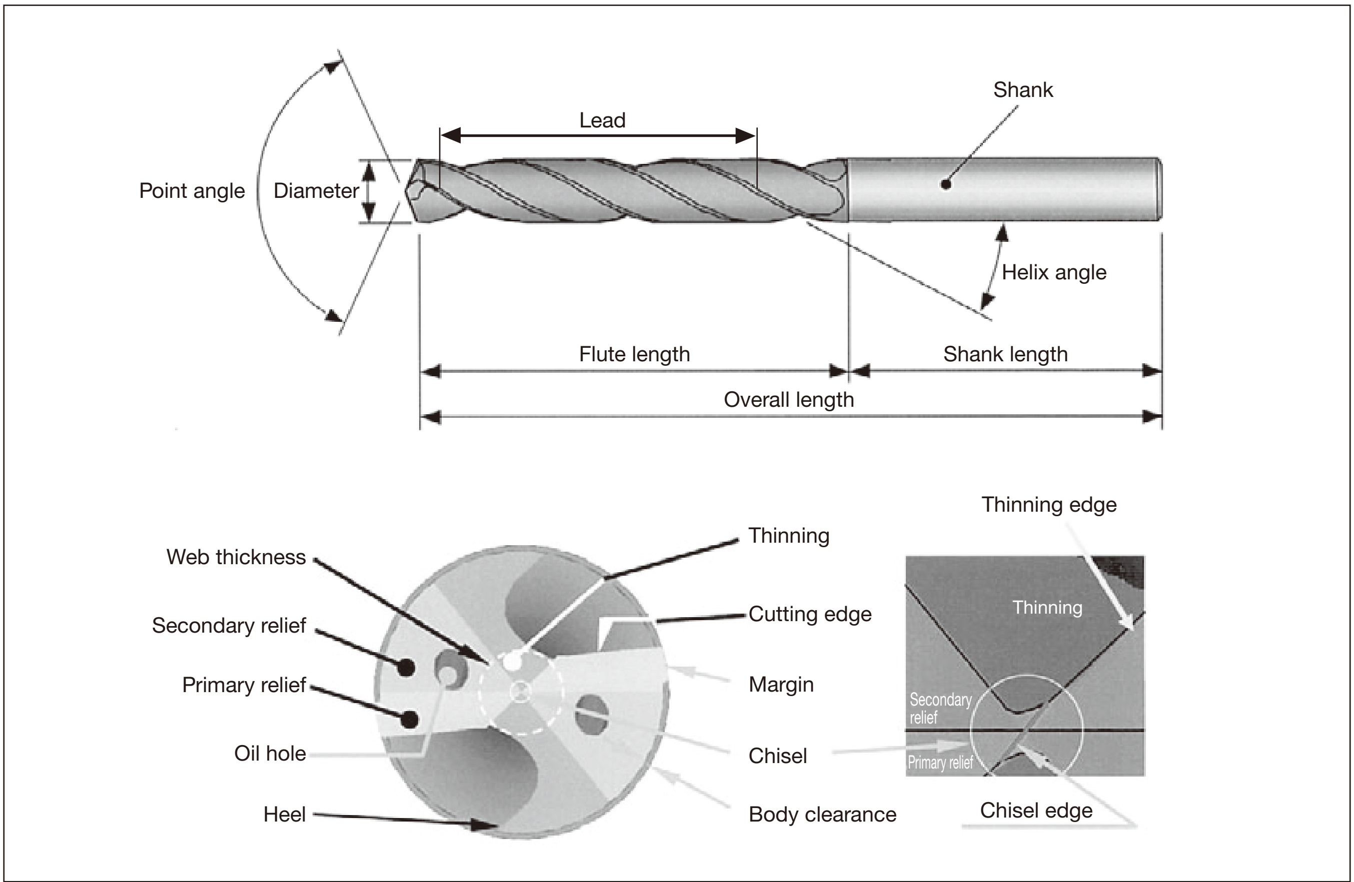
7 Additional feature	
I	Irregular pitch (or Intermittent edge)
A	for aluminium
R	Serrated edge
C	Combined edge

8 The number of flutes	
General	
02	2
06	6
Slotting head VST type	
3	3
4	4

9 Connection screw size	
S04	S04
S05	S05
S06	S06
S08	S08
S10	S10
S12	S12
S15	S15
S21	S21

Drill

Nomenclature for solid carbide drills



Cutting forces and power requirement

●Twist drill

Power requirement

$$P_C = KD^2 n \,(0.647 + 17.29f) \times 10^{-6}$$
(kW)

Thrust force

$$T_C = 570KDf^{0.85}$$
(N)

Torque

$$M_C = \frac{KD^2\,(0.630 + 16.84f)}{100}$$
(N·m)

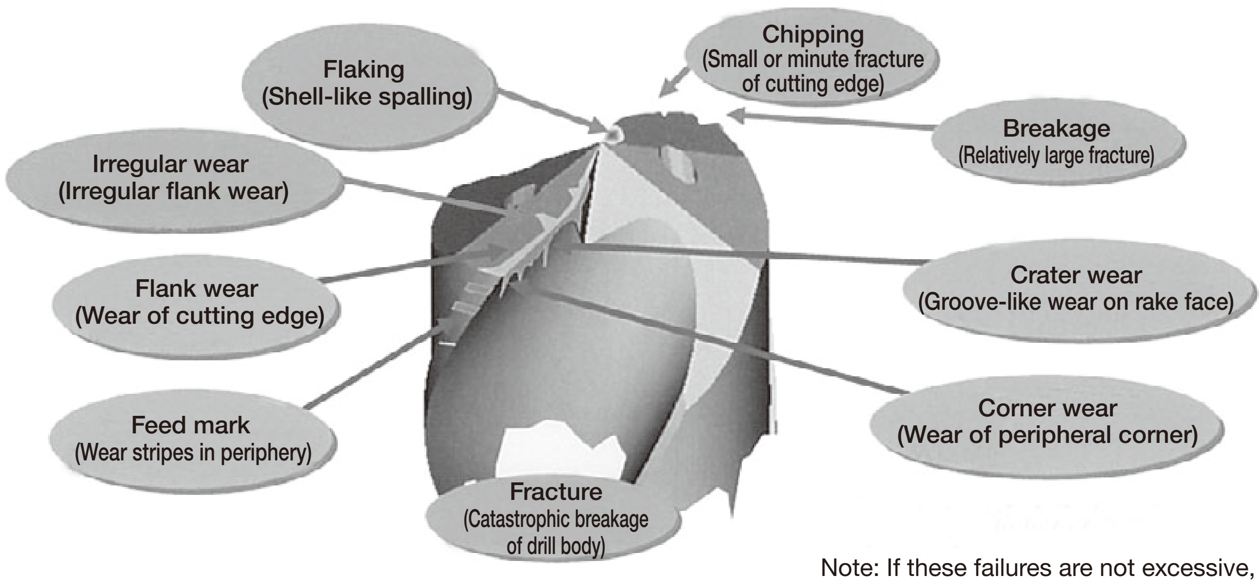
- P_C : Power requirement (kW)
- T_C : Thrust force (N)
- M_C : Torque (N·m)
- D : Drill diameter (mm) 〔DC〕
- f : Feed (mm/rev)
- n : No. of revolutions (min^{-1})
- K : Material constant···· Refer to the Table at right

〔 〕 The notation in the brackets is the one used in the catalog (ISO compliant)

●Material constant compensating for power requirement and thrust force

Workpiece material	Tensile strength MPa(N/mm²)	Tensile strength {Kgf/mm²}	Brinell hardness (HB)	Material constant (K)
Cast iron	210	21	177	1.00
Cast iron	280	28	198	1.39
Cast iron	350	35	224	1.88
Aluminium	250	25	100	1.01
Low carbon steel (JIS S20C)	550	55	160	2.22
Free cutting steel (JIS SUM32)	620	62	183	1.42
Manganese steel (JIS SMn438)	630	63	197	1.45
Nickel chromium steel (JIS SNC236)	690	69	174	2.02
4115 steel Cr0.5, Mo0.11, Mn0.8	630	63	167	1.62
Chromium molybdenum steel (JIS SCM430)	770	77	229	2.10
Chromium molybdenum steel (JIS SCM440)	940	94	269	2.41
Nickel chromium molybdenum steel (JIS SNCM420)	750	75	212	2.12
Nickel chromium molybdenum steel (JIS SNCM625)	1,400	140	390	3.44
Chromium vanadium steel				
Cr0.6, Mn0.6, V0.12	580	58	174	2.08
Cr0.8, Mn0.8, V0.1	800	80	255	2.22

Cutting edge failure of solid carbide drills



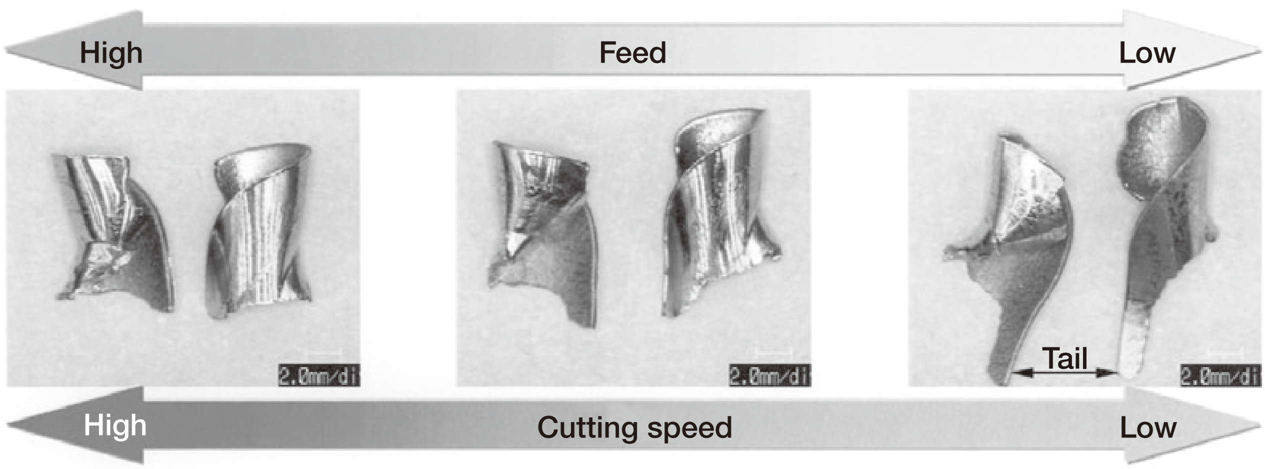
Note: If these failures are not excessive, the tool is in a normal condition.

Change of chip shapes in drilling

● Change of chip shapes relating to cutting conditions

Photographs below show the change of chip shapes relating to change of the feed and the cutting speed. These chip shapes are all well controlled in a proper condition range.

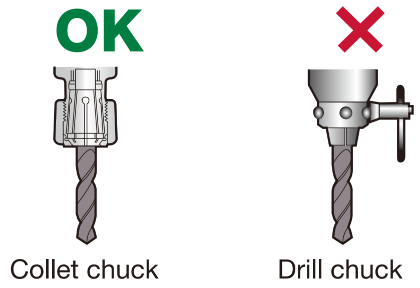
When the speed and feed are low, the chip shows whitish color and the tail of the chip tends to lengthen gradually. In contrast, as the speed or the feed increases, the chip tends to increase in brightness and becomes a compact shape with a short tail. These changes in the shape depend on the cutting temperature. As the temperature increases, chips tend to be broken.



Guidelines for correct usage of carbide drills

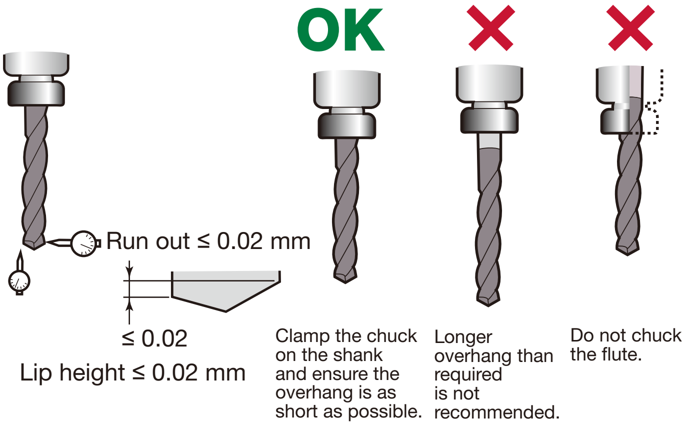
● Holders for solid carbide drills:

A collet chuck holder is recommended for use with carbide drills. When using a milling chuck holder, a collet chuck with a straight shank or straight collet should be used.



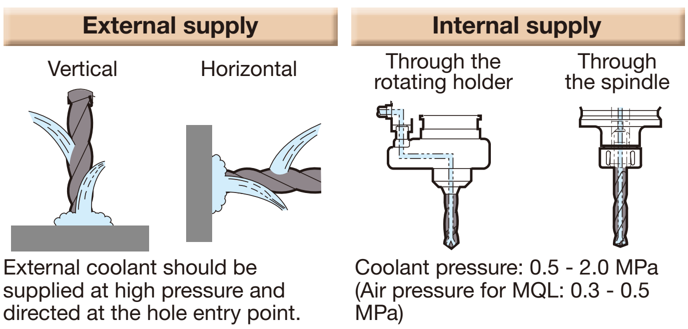
● Chucking drills:

- Radial run out and lip height should be less than 0.02mm. If run out or lip height is larger (close to 0.05mm), machining is possible. However, less accurate holes or short tool life may be a result.
- Overhang length should be as short as possible.



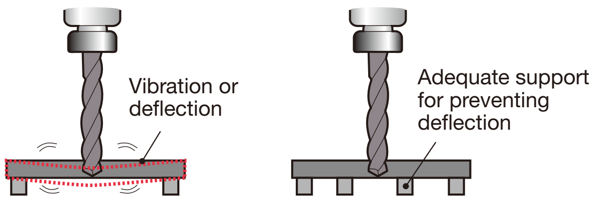
● Coolant Supply:

When using a drill without a coolant hole, such as the DSW-DE type, coolant should always be directed to the entrance of the hole. Maintaining this supplying is very important for stable drilling performance.



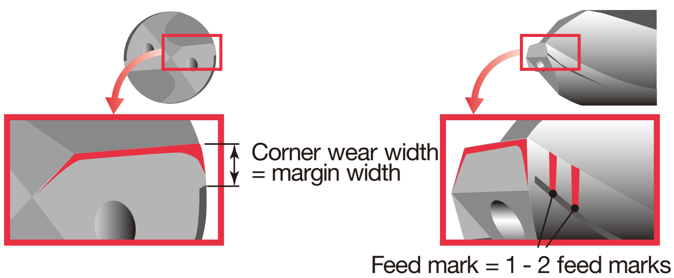
● Clamping workpieces:

As solid carbide drills have a higher thrust force, machining with low rigidity or inadequate support can cause fractures or breakages through vibration. It is important the workpiece is rigidly clamped and has adequate support.

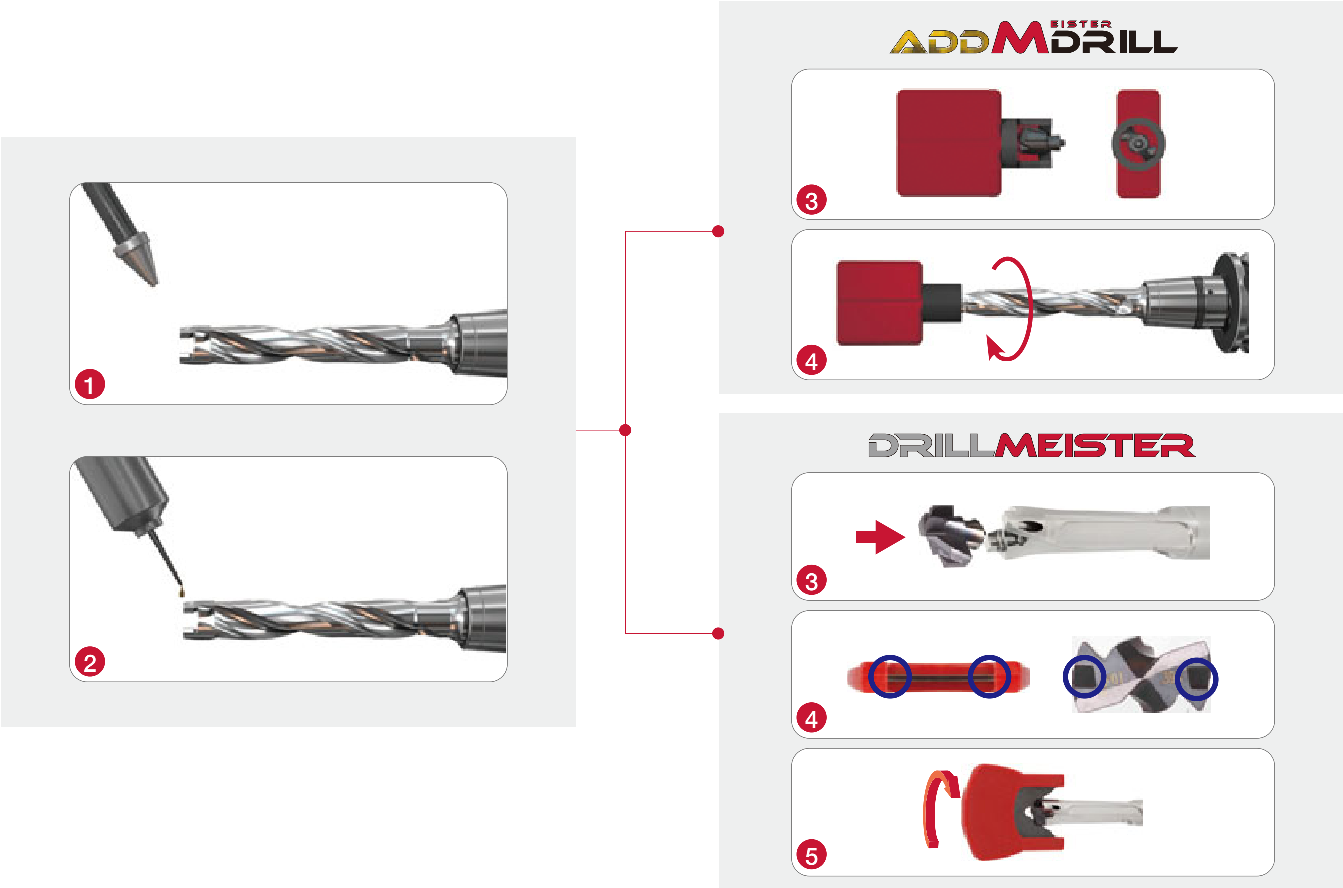


● The criteria of tool life:

- Corner wear width: equal to margin width
- Feed mark: 1 - 2 feed marks on the margin
- Spindle load increase: 30% higher than starting level
- Irregular situation: worse chip control, hole diameter change, worse surface finish, larger burrs, bigger sound.



Drilling head mounting procedure



Instruction for proper head mounting

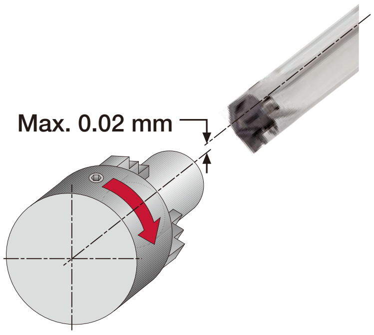
Fig. #1 Fig. #2 Fig. #3

Procedures

① Thoroughly clean the contacting areas on the drill body and the head with compressed air, lubricate them, and put the drill head in the pocket.
② Place the clamping key in the grooves on the drill head. Push the head in the pocket with equal torque on the right and the left sides. Rotate the clamping key to lock the head in the pocket completely. (Fig. #1).
③ Be sure that there is no gap in the contact surfaces between the head and the drill body. Use a 0.01 mm shim to check for the gap. (Fig. #2)
④ If there is a gap thicker than 0.01 mm, unclamp the head and return to procedure No. ① .
⑤ Measure the run-out at the margin of the drill head. Run-out must be 0.05 mm or smaller. (Fig. #3) (Recommended value: 0.02 mm or smaller)
If the run-out exceeds 0.05 mm, unclamp the head and return to procedure No. ① .

Note: #1: If the clamping torque is not equally applied on the right and the left sides of the drill head, there may be a gap between the head and the body, which increases the run-out of the head.
Note: #2: Low accuracy in holding the drill body may affect the run-out. If the run-out is large, check the accuracy in holding the drill body.

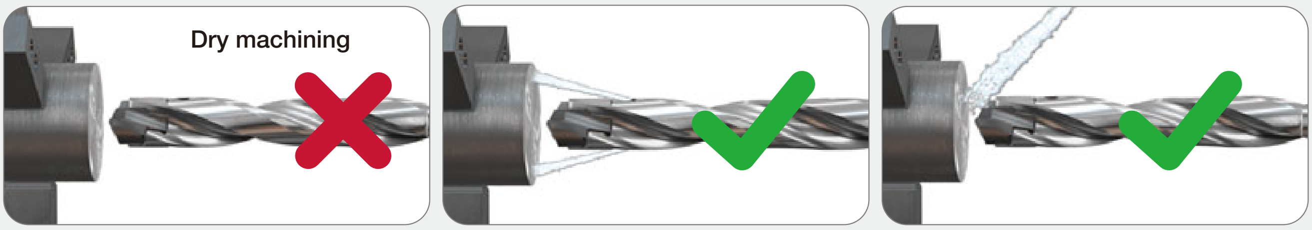
Alignment recommendation



Runout recommendation

ADDMEISTERDRILL	DRILLMEISTER	
Max. 0.02 mm	Ideal	: ≤ 0.02 mm
	Acceptable	: ≤ 0.05 mm
	Not acceptable	: > 0.05 mm

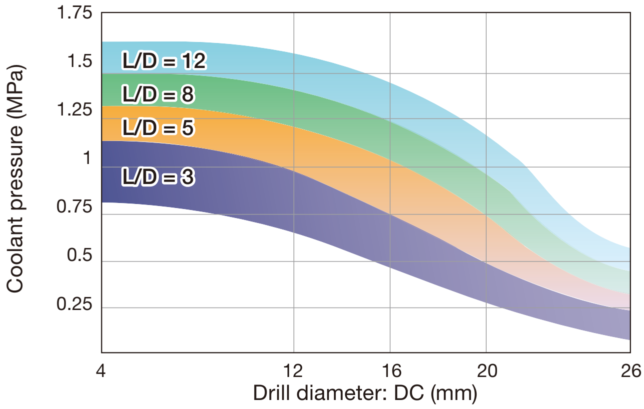
● Coolant recommendation

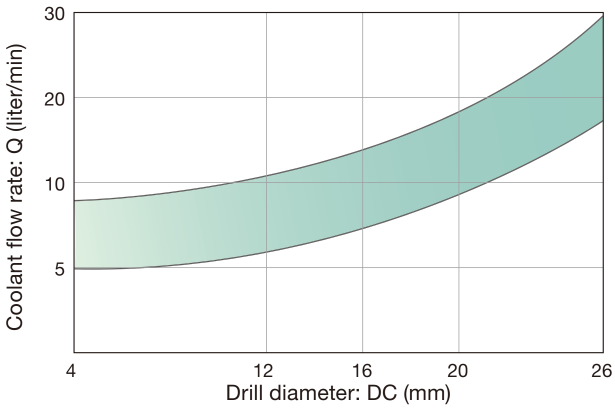


ADDMEISTERDRILL
Up to 2XD

DRILLMEISTER
If hole depth excess 2XD, recommend to add dwell or step cycle for better chip evacuation

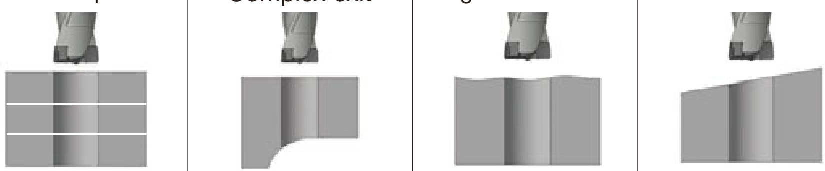
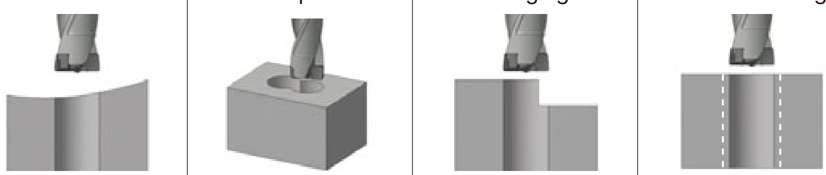
● Recommended coolant flow rate and pressures





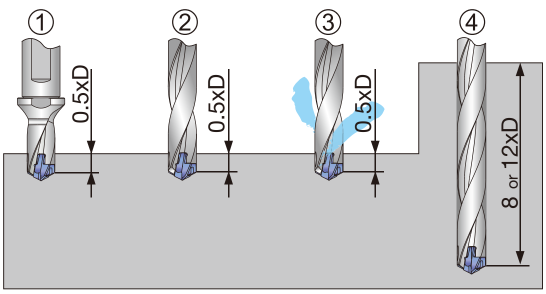
● Application range and recommended tool lengths for application irregularities

Please use the shortest tool length possible

	Stacked plate	Complex exit	Rough / cast surface	Inclined surface
Application				
ADDMEISTERDRILL	×	×	×	×
DRILLMEISTER	✓	Up to 8xD ✓	Up to 5xD ✓	Up to 3xD ✓
	Curved surface	Hole expansion	Plunging	Counter boring
Application				
ADDMEISTERDRILL	×	×	×	×
DRILLMEISTER	Up to 3xD ✓	Up to 3xD ✓	Up to 3xD ✓	×

✓ OK
× Impossible

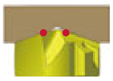
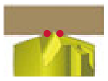
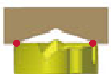
● Tips when using 8xD and 12xD drills



① Drill a pilot hole in the depth of 0.5xD.
The same head diameter should be used for the pre-hole and the main drilling process.
② Rotate the drill at a low speed (eg. 100 rpm). While maintaining the drill speed, slowly feed into the pilot hole for several millimeters from the entry.
③ Activate the internal coolant and increase the drill rotation to the required speed.
④ Drill to the required depth using the recommended cutting parameters.

Note: Use DMC-style drill head for deep holes from 8xD up to 12xD depths without a pilot hole.

● Head combinations of pre-hole to main hole

		Pre-hole		
		DMP	DMC	DMF
Hole	DMP	Good 	Not good 	Not good 
	DMC	Good 	Good 	Good 
	DMF	Not good 	Not good 	Good 

● Holders recommended for M/C

TID-F...

First choice


Power chuck


Collet chuck


Side lock

TID-R...


Hydro chuck

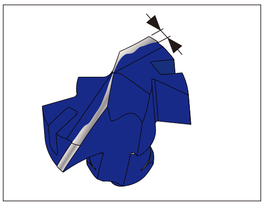

Power chuck


Collet chuck

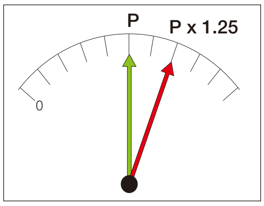
Note: If you need to use a 12xD body with a side-lock holder, the shank will need to have a flat area which may be placed additionally.

● When to change drill heads (Criteria for the end of tool life)

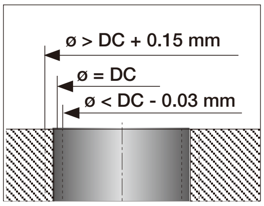
Replace the drill head when the following phenomena occur during the machining:


Width of corner wear reaches

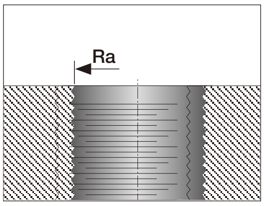
ADDMEISTER DRILL : 0.1 - 0.2 mm
DRILLMEISTER : 0.2 - 0.3 mm



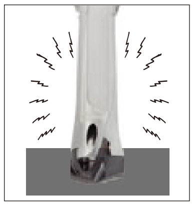
Spindle load exceeds 125% of the normal value



Hole diameter is 0.15 mm larger or 0.03 mm smaller than the drill diameter



Surface roughness deterioration


Vibration or unusual noise

KEY FOR MEASURING HEAD RELEASE TORQUE

The release torque in unclamping a head is measured with a torque driver to determine the body's tool life. Please refer to the below for the standard release torque value which indicates the end of tool life (The value less than the standard should be judged as the end of tool life).

Dedicated key designation：
KHS-TID10-19.99


*Can be connected with a commercially available torque driver.

Head designation	Release torque value to indicate tool replacement (N・m)	(cN・m)
DMP100-109	0.2	20
DMP110-119	0.2	20
DMP120-129	0.25	25
DMP130-139	0.25	25
DMP140-149	0.3	30
DMP150-159	0.3	30
DMP160-169	0.35	35
DMP170-179	0.35	35
DMP180-189	0.4	40
DMP190-199	0.4	40

DRILLFORCE MEISTER

How to change drill head

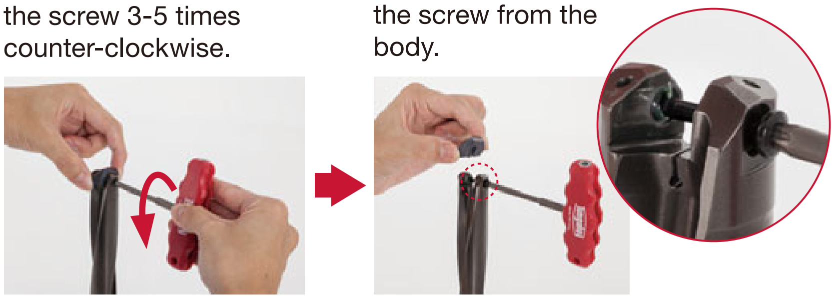
- Caution when installing the drill head

Install the drill head so that the arrow etched on the drill head should be facing to the arrow on the drill body.

- Tightening and loosening of insert clamping screw

To unclamp rotate the screw 3-5 times counter-clockwise.

No need to remove the screw from the body.



.Please change the screw to new one when the screw does not rotate smoothly

Application range and recommended tool lengths for application irregularities

Please use the shortest tool length possible.

✓ OK

Application	Stacked plate	Irregular exit	Rough / cast surface	Inclined surface
DRILLFORCE MEISTER	✓	Up to 8xD ✓	Up to 5xD ✓	Up to 3xD ✓
Application	Curved surface	Overlapping holes	Plunging	Boring
DRILLFORCE MEISTER	Up to 3xD ✓	Up to 3xD ✓	Up to 3xD ✓	Up to 3xD ✓

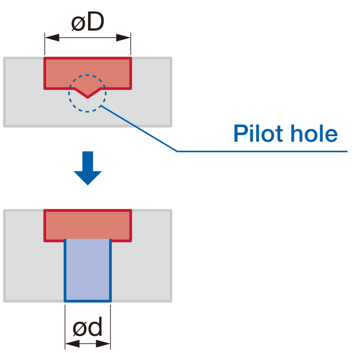
Drilling of step holes

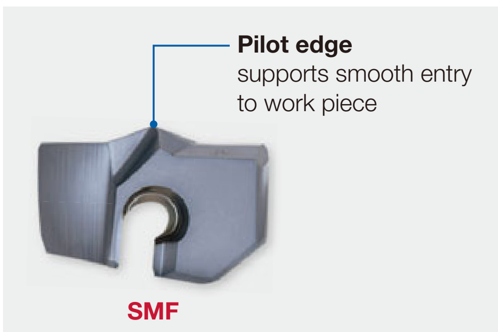
- Follow the procedures outlined below for efficient drilling of step holes.
- SMF drill head creates a small divot in the center of the hole bottom. The divot will then pilot a drill used in the following process to create a concentric hole.

Recommended procedures

① Use SMF to make a counterbore for the bolt head.

② Drill a smaller diameter hole for threads.

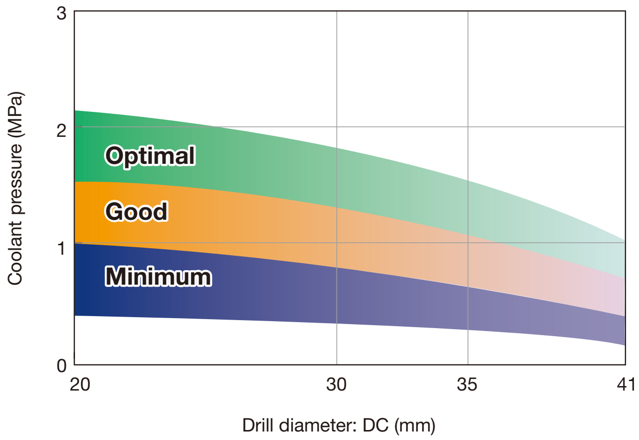


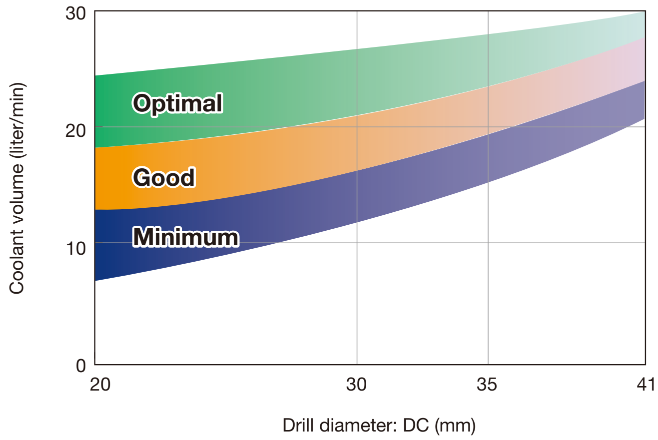


When using for boring operations

- The above procedures can also be used for boring operations.
- For boring operations, use SMF drill head with flat edges.
- SMF drill head will create long chips in the continuous cuts. For successful chip evacuation, use a dwelling or pecking method.

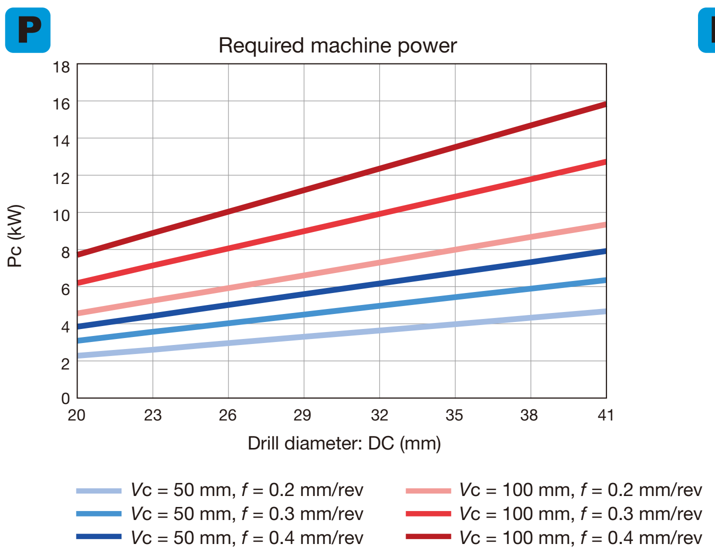
Recommended coolant pressure and volume

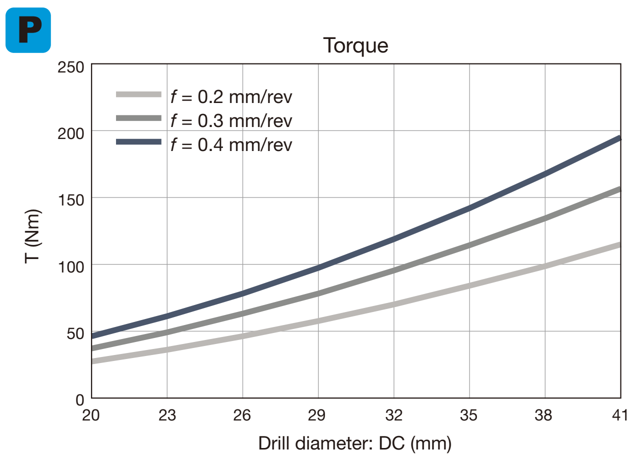




Note: External coolant will also do. For holes exceeding 2xD depth, use dwelling or peck drilling method to promote smooth chip evacuation.

Required machine power and torque





- **Please access to "Tungaloy machining power" to calculate more detailed cutting forces.**

  https://www.imc-i.com/mpwr/Unit/mm/Company/Tungaloy

Troubleshooting for solid carbide drills

Problem		Cause	Countermeasure
Abnormal wear	Relief surface	Inappropriate cutting speed	•Increase the cutting speed by 10 % within standard conditions if abnormal wear is around center. •Lower the cutting speed by 10 % within standard conditions if abnormal wear is on the periphery.
		Inappropriate cutting fluid	•Check the filter. •Use the cutting fluid superior in lubricity. (Increase the dilution rate)
	Margin	Inappropriate cutting speed	•Lower the cutting speed by 10 %.
		Regrinding timing, insufficient reground amount	•Shorten the regrinding timing.
		Insufficient rigidity of the machine and workpiece	•Change the clamp method to the one with rigidity.
		Insufficient drill rigidity	•Use smallest possible overhang.
		Inappropriate cutting fluid	•Check the filter. •Use the cutting fluid superior in lubricity. (increase the dilution rate)
		Intermittent cutting when entering	•Avoid interruption at entry and exit. •Lower the feed by about 50 % during entering into and leaving from the workpiece.
Chipping and fracture	Chisel section (center of drill cutting edge)	Insufficient rigidity of the drill	•Reduce the drill overhang as much as possible. •Increase the feed at entry when the low speed feed is selected in standard cutting condition range. •Use a bushing or a center drill.
		Insufficient rigidity of the machine and workpiece	•Change the clamp method to the one with rigidity.
		Inappropriate entry into the workpiece	•Avoid interruption at entry into the workpiece. •Lower the feed by 10 % at entry.
		High workpiece hardness	•Lower the feed by 10 %.
		Inappropriate honing	•Check if honing has been made to the center of cutting edge.
	Peripheral cutting edge	Insufficient drill rigidity	•Lower the cutting speed by 10 %. •Increase the feed at entry when the low speed feed is selected in standard cutting condition range.
		Inappropriate drill mounting accuracy	•Check the run out accuracy after drill installation. (0.03 mm or less)
		Insufficient machinery and workpiece rigidity	•Change the clamp method to the one with rigidity. •Lower the feed during entering into and leaving from the workpiece.
		Inappropriate honing	•Check if honing has been made to the cutting edge periphery.
	Margin	Insufficient machine and workpiece rigidity	•Change the clamp method to the one with rigidity.
		Insufficient drill rigidity	•Use smallest possible overhang. •Use a bushing or center drill.
		Regrinding timing and insufficient amount of reground stock	•Shorten the regrinding timing.
		Intermittent cutting when entering or exiting the cut	•Avoid interruption at entry and exit. •Lower the feed by about 50 % during entering into and leaving from the workpiece.
Breakage		Tendency to cause chipping or develop abnormal wear	•Check the failure mode condition before breakage and find out the wear and chip countermeasures.
		Chip packing in the drill flutes	•Review the cutting conditions. •For internal coolant supply, raise the supply pressure of cutting fluid. •Use peck feed for deep holes.
		Insufficient machine output	•Review the cutting conditions. •Use the machine with high power.
Insufficient hole accuracy		Insufficient rigidity of the machinery and workpiece	•Change to the clamp method with rigidity
		Inappropriate drill installation accuracy	•Check the run out accuracy of drill mounting. (0.03 mm or less)
		Chip packing in the flutes.	•Review the cutting conditions. •Raise the cutting oil supply pressure. •Use peck-feed for deep holes.
		Inappropriate edge sharpening accuracy	•Check the edge shape accuracy.
Prolonged chips		Inappropriate cutting conditions	•Increase the feed by 10 % within standard conditions.
		Inappropriate honing	•Provide the appropriate honing.
		Cutting edge with chipping or breakage	•Lower the cutting speed by 10 %.

Regrinding method

Please refer to the following instructions prior to regrinding DSW type drills.

Before regrinding
Check the cutting edge for damage and wear. If any large fracture is found, remove with a silicon carbide wheel.

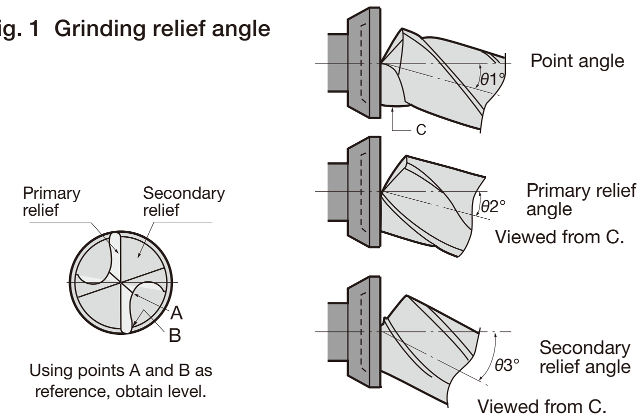
(1) Grinding the flank

● Use a 280 to 400 grit diamond cup type wheel of 100 ~ 200 mm in diameter.

1) Grind the relief surface so that primary relief angle (θ) of 2° can be formed as shown in Fig.1. After grinding the other side likewise, do sparkout grinding so that the difference of the lip height will be kept within 0.02 mm.

2) In the cases of DSW types: After grinding the primary relief angle (θ) 2°, without rotating the drill, grind the secondary relief surface so that the relief angle (θ) of 3° can be formed. In the same way as 2), take care to bring the ridge line formed between the primary and secondary relief surfaces to the drill center. (Values (θ) of 1° ~ 3° are shown in Table 1)

Fig. 1 Grinding relief angle



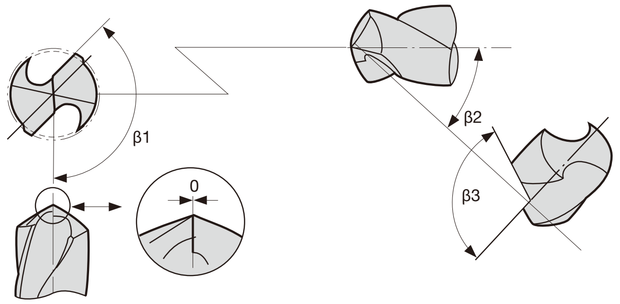
(2) Thinning

- Use a 280 ~ 400 grit diamond straight-type wheel of 100 ~ 200 mm in diameter.
- Conduct thinning in the same manner as cross thinning (X-type).
- Values of $\beta 1$ to $\beta 3$ written in the figures are given in the Table 2.

Table 1	$\theta 1$ (Point angle)	$\theta 2$ (Primary relief angle)	$\theta 3$ (Secondary relief angle)
DSW	–20°	–6° ~ –12°	–23° ~ –27°

Table 2	$\beta 1$	$\beta 2$	$\beta 3$
DSW	147° ~ 153°	30° ~ 42°	95° ~ 110°

Fig. 2



(3) Honing

- The honing angle θ and width H should be varied depending on the drill type, diameter, and work material. Recommended honing specifications are given in the Table below.
- Honing procedures (refer to Fig.3)
  (1) Round the R portion shown in Fig.3 in large.
  (2) Then, roughly hone the cutting edge lines by using an electro-deposited diamond file of around 170 grit.
  (3) Carry out finish honing by using a diamond hand stick of 400 to 600 grit.
- The honing width should be changed depending on the drill diameter. For smaller side of diameters, the width should be in smaller side of values given in the Table.

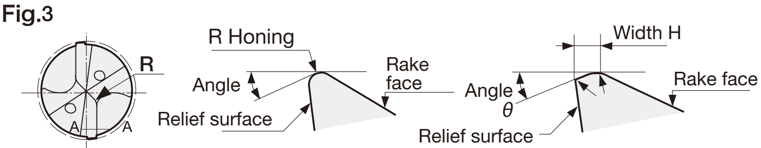
• Angle honing

	~ ø6 mm	ø6 ~ ø10 mm	ø10 ~ ø16 mm
θ	- 20°	- 20°	- 20°
H	0.03 ~ 0.05	0.05 ~ 0.08	0.08 ~ 0.1

• R Honing

Dimensions (mm)	R Honing R (mm)
DC ≤ ø6	0.02 ~ 0.04
ø6 < DC ≤ ø16	0.03 ~ 0.05

Fig.3



R Honing (A-A section) **Angle Honing** (A-A section)

After regrinding, check the following before use.

- The difference of the lip height is kept within 0.02 mm.
- Any damaged portion on the cutting edges is not left.
- Cutting edges are properly honed.
- Any grinding burr is not left.

Notes:
- For more details on regrinding, consult the nearest Tungaloy sales office.

SOLIDDRILL Designation System

DSW	088	-	035	-	10	-	D	E	3
1	2		3		4		5	6	7

1 Series	
DSW	Series name of solid drill

2 Drill diameter DC (mm)	
088	ø8.8

3 Effective flute length LU (mm)	
035	35

4 Shank diameter DCONMS (mm)	
10	ø10

5 DIN 6535 - Form HA

6 Coolant Supply	
E	External (without coolant hole)
I	Internal (with coolant hole)

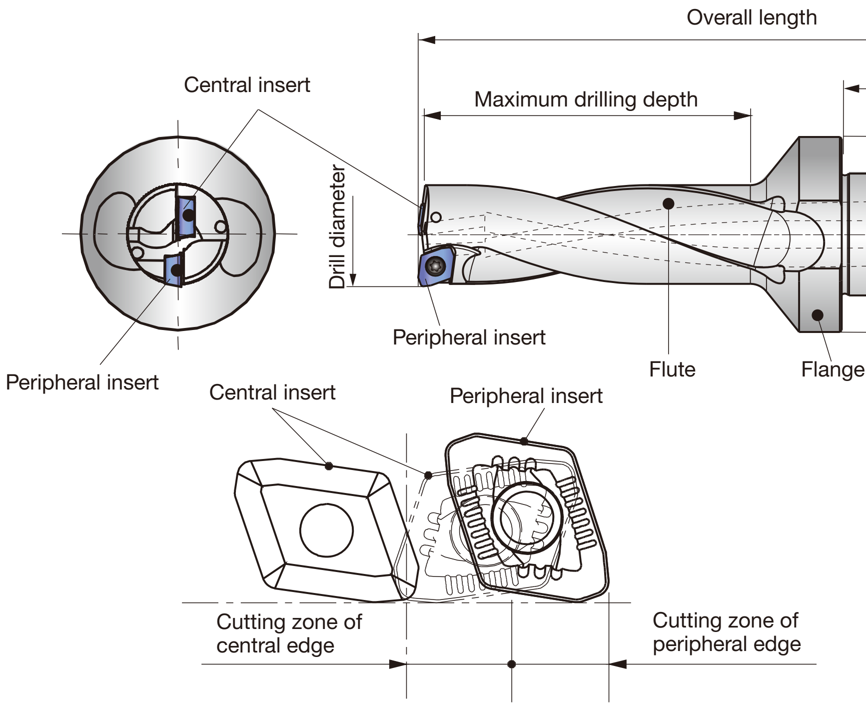
7 Drilling depth

Approximate value of L/D ratio.
Caution: Code may be different from the actual length. This is dependent upon the tool diameter.

Caution: "Effective flute length" shows the maximum flute length for eff ective chip evacuation. The actual drilling depth may be shorter than described depending on the work material or cutting conditions.

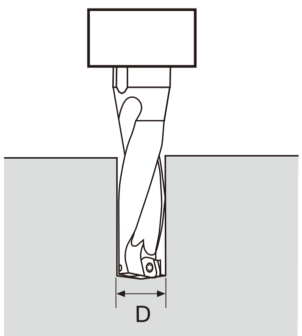
Indexable Drill

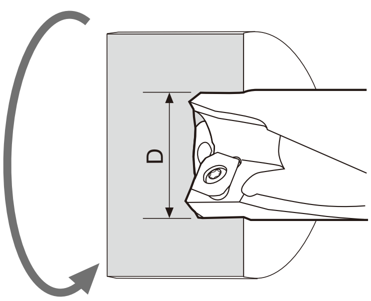
Nomenclature for Indexable drill



Calculation formulas for Indexable drill

●Cutting speed





●When calculating cutting speed from number of revolutions: (Drilling formulas)

$$\underset{(\text{m/min})}{v_c} = \frac{\pi \times D \times n}{1000}$$

v_c : Cutting speed (m/min)
D : Drill diameter (mm) 〔DC〕
n : Number of revolutions (min^{-1})
$\pi \approx 3.14$

●When calculating required number of revolutions from cutting speed: (Drilling formulas)

$$\underset{(\text{min}^{-1})}{n} = \frac{1000 \times v_c}{\pi \times D}$$

●When calculating cutting speed from number of revolutions: (Where the workpiece rotates.)

$$\underset{(\text{m/min})}{v_c} = \frac{\pi \times D \times n}{1000}$$

v_c : Cutting speed (m/min)
D : Drilling diameter (mm) 〔DC〕
n : Number of revolutions (min^{-1})
$\pi \approx 3.14$

●When calculating required number of revolutions from cutting speed: (Where the workpiece rotates.)

$$\underset{(\text{min}^{-1})}{n} = \frac{1000 \times v_c}{\pi \times D}$$

●Calculation of feed speed

$$\underset{(\text{mm/min})}{v_f} = f \times n$$

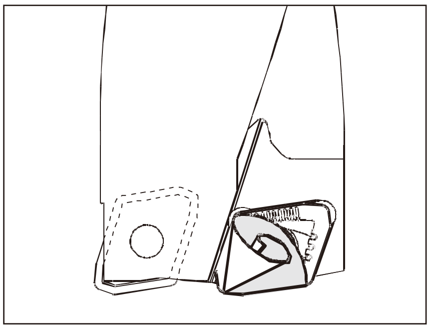
v_f : Feed speed (mm/min)
f : Feed (mm/rev)
n : Number of revolutions (min^{-1})

〔 〕 The notation in the brackets is the one used in the catalog (ISO compliant)

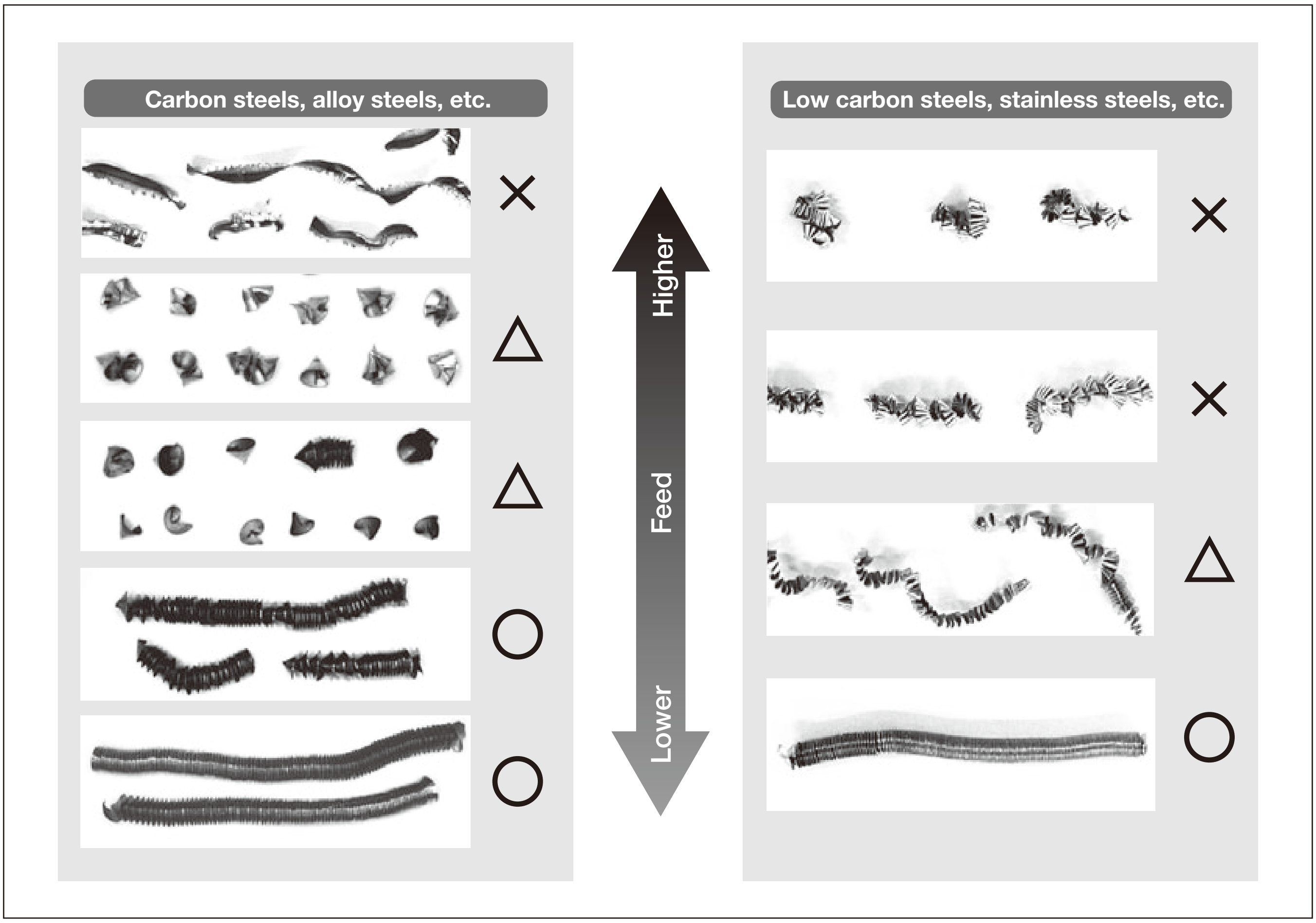
Chip shapes

● Chip shape produced with central insert

- A conical coil shape whose apex point coincides with the rotating center of the drill is the basic shape. The chips are broken into small sections with increases in feed. However, excessively high feed causes the chip to increase in thickness and develops vibration which disturbs stable machining.
- In TDX drills, ○ marked chips shown below are the most preferable shapes. This type of chip is broken into adequate lengths by centrifugal forces when used in tool-rotating condition. On the other hand, when used in work-rotating condition such as on a lathe, a continuously long chip is often produced without entangling.

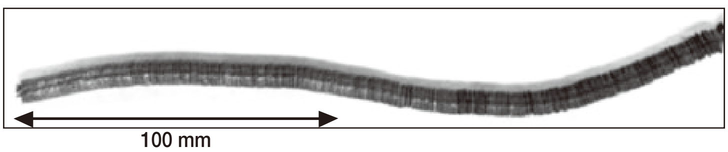


● Relation between chip shapes and feeds (In the case of central insert)



● Example of chip shape in work-rotating applications (In the case of central insert)

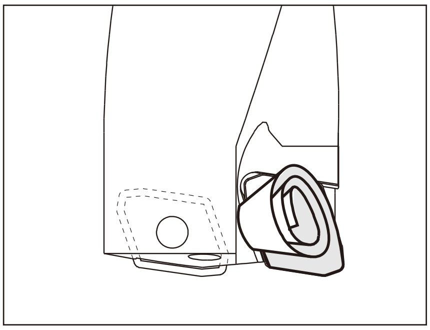
(ø26, JIS S45C, V_c = 100 m/min, f = 0.1 mm/rev)



Indexable Drill

Chip shape produced with peripheral insert

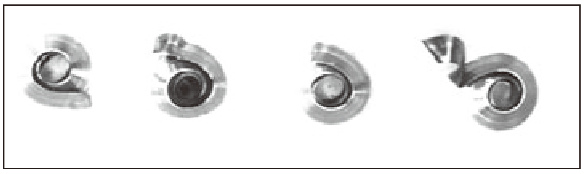
- Chip problems such as entangling are mainly caused by chips produced with the peripheral insert. These problems are dependent on the types of Workpiece material and the cutting conditions.
- As shown below, when the feed is extremely low, the chips jump over the chipbreaker groove and the continuously long chips may wrap around the drill body.
- When the feed is too high, the chips increase in thickness and can not be curled.
- Therefore, it is important to select proper cutting conditions to suit the machining so that well controlled chips will be formed.



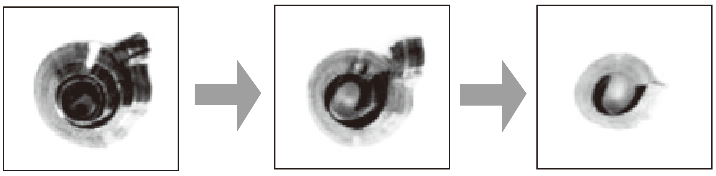
Medium to high carbon steels, alloy steels, etc.

As shown below, several turns of coil are an ideal shape.
As the feed increases, the curl radius and the number of turns tend to decrease.

Typical chip shapes of general steels



Variation of chip shapes relating to feeds

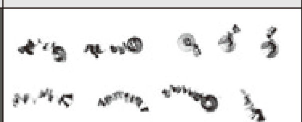
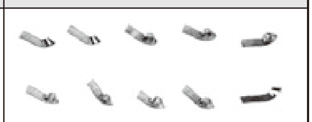
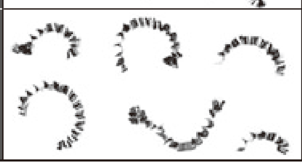
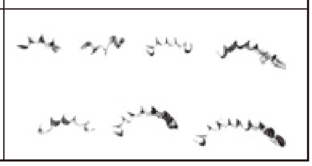


f = 0.07 mm/rev   *f* = 0.1 mm/rev   *f* = 0.13 mm/rev

Stainless steels, low-carbon steels, low-alloy steels, etc.

- When machining long-chip materials such as stainless steels and mild steels, the wrong selection of cutting conditions results in chip entangling and tool breakage at worst. Therefore, cutting conditions should be carefully selected.
- “C” shaped, continuous coils of several to ten turns having adequately divided lengths are the ideal shape.

Ideal chip shapes

	Stainless steel (JIS SUS 304) (ø22, *V*c = 100 m/min, *f* = 0.1 mm/rev)	Mild steel (JIS SS400) (ø22, *V*c = 160 m/min, *f* = 0.08 mm/rev)
DS chipbreaker		
DJ chipbreaker		

For machining stainless steels or low carbon steels, DS chipbreaker is recommended.
When using a TDX drill in tool-rotating condition, DS chipbreaker produces compact chips and allows more stable machining than DJ chipbreaker. When using it in work-rotating condition, DS chipbreaker provides outstanding affect on chip control.

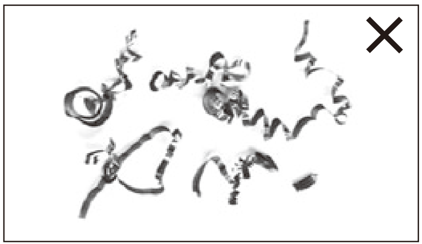
Chip shapes which tend to entangle and remedies against them

① Apple-peel-like chips

These chips are often produced in machining mild steels or low-carbon steels at low-speeds and low-feeds.

Remedies

Increase the cutting speed in stages by 20% within the range of standard cutting conditions. If there is no effect, increase the feed by about 10 % as the cutting speed is raised by 20%.



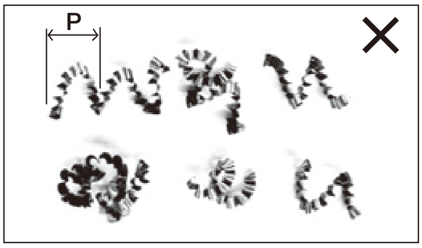
Apple-peel-like chips (Without curling)

② Short-lead chips

These chips are often produced in machining stainless steels at low-feeds and tend to entangle to the tool in spite of short length.

Remedies

Increase the feed by about 10 %. If there is no effect, increase the cutting speed in stages by 10% within the range of standard cutting conditions.



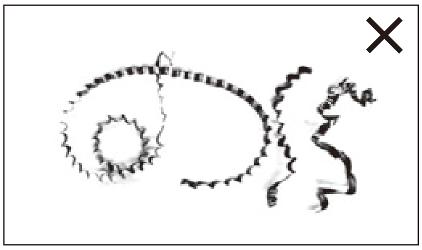
Continuously curled "C" shape chips with short lead (P).

③ Very long chips

Often produced in machining mild steels or low-carbon steels under improper cutting conditions.

Remedies

Increase the cutting speed in stages by 20% within the range of standard cutting conditions. If there is no effect, decrease the feed by about 10 % as the cutting speed is raised by 20%.

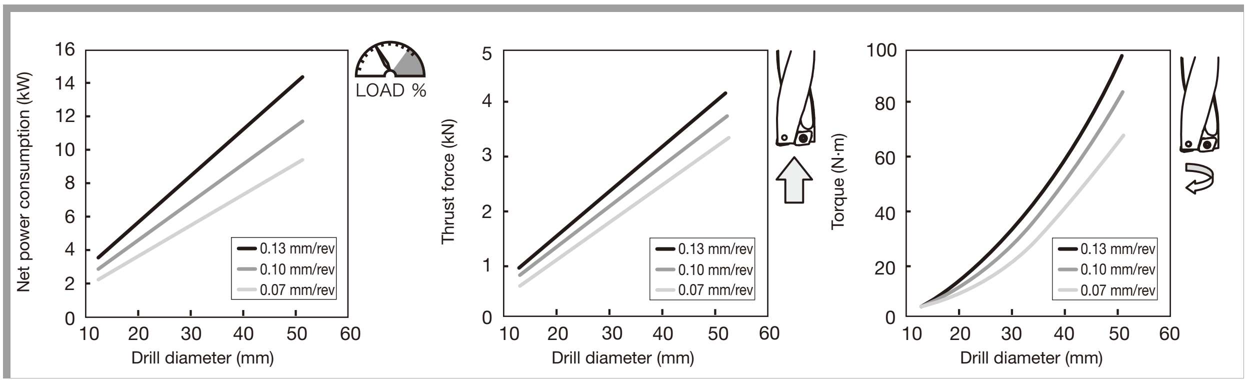


Continuously coiled long chips

Cutting forces

The charts below show a guideline for cutting forces. Use TDX drills on a machine with ample power and sufficient rigidity.

Guidelines for cutting forces



Cutting speed: V_C = 100 m/min
Workpiece material: Alloy steel (JIS SCM440), 240HB
Cutting fluid: Used

Indexable Drill

TUNGSIX-DRILL / TUNGDRILLTWISTED

Troubleshooting for indexable drills

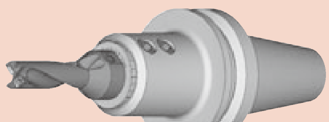
Use EZ sleeves for the following purposes

Hole diameter adjustment on the milling machine

Adjusting the finishing diameter when milling

Adjusting the finishing diameter in tool-rotating applications such as on machining centres and milling machines:

By using EZ sleeve, the finishing diameter can be adjusted in the range from +0.6 mm to -0.2 mm.

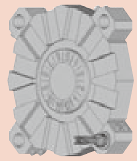


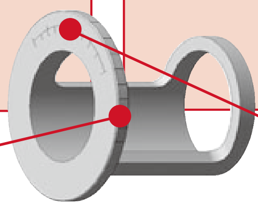
Adjusting cutting edge height on lathe

Lathe

Adjusting of the cutting edge height in work rotating applications such as on lathes:

By using EZ sleeve, the cutting edge height can be adjusted in the range from +0.3 mm to -0.2 mm. It results in eliminating troubles caused by improper cutting-edge height.





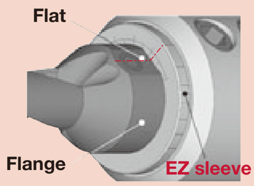
Scale for adjusting finishing diameter in milling (Periphery of sleeve)

Scale for adjusting cutting edge height in turning (Front face of sleeve)

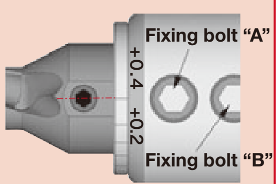
Setting of EZ sleeve

Hole diameter adjustment on the milling machine

As shown in the Figure right, set the EZ sleeve between the drill shank and the toolholder.



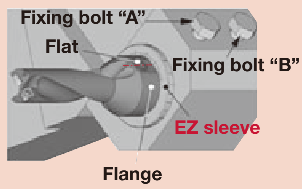
Align the graduated scale on the periphery of the EZ sleeve with the center of the flat of the drill flange.
In the Figure shown right, the sleeve is set so that the finishing diameter will be increased by 0.4 mm.



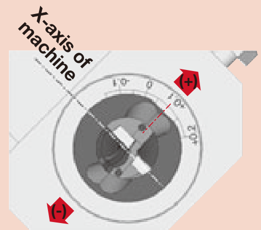
When rotating the EZ sleeve, insert the wrench into the hole at the flange periphery and rotate the EZ sleeve.
Screws A + B have to be loosened.
Secure the drill by screw A.
Secure the EZ sleeve by lightly tightening screw B.
Tighten screw B only lightly otherwise EZ sleeve can be damaged!

Adjusting cutting edge height on lathe

As shown in the Figure right, set the EZ sleeve between the drill shank and the toolblock.



Align the graduated scale on the front face of the Esleeve with the center of the flat of the drill flange.
In the Figure shown right, the sleeve is set so that the center of the drill will shift by 0.1 mm to the plus (+) direction.



Cautious points

- The scale is only a rough guide, so be sure to measure the actual drilling diameter to confirm the result. Especially in turning, test machining is recommended as the drilling diameter will vary according to theadjustment.
- Can not be used for collect chuck holders.
- Over L/D 4 or bigger adjustment, please reduce feed.
- For smaller adjustment, the drill itself will interfere with the hole diameter. It is recommended that hole diameter should be adjusted to a larger diameter than the drill diameter.

Troubleshooting for indexable drills

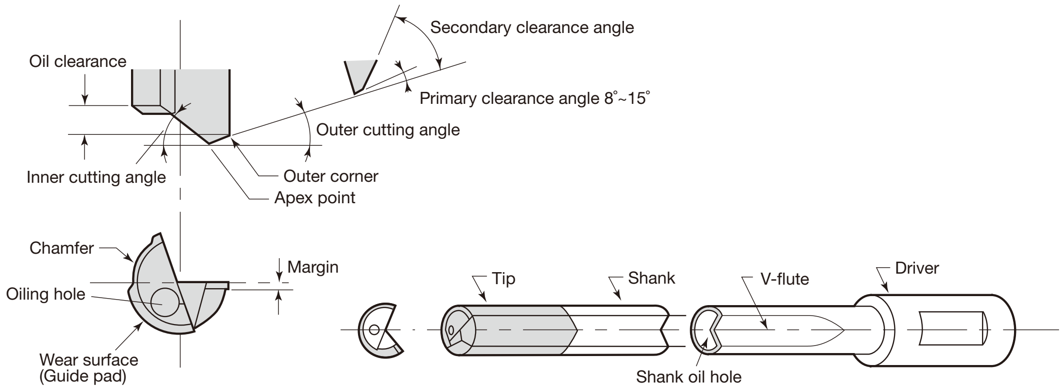
Problem			Cause	Countermeasure
Abnormal wear	Central cutting edge	Relief surface	Inappropriate cutting conditions	● Increase the cutting speed by 10 % within standard conditions. ● Lower the feed by 10 %.
	Peripheral cutting edge	Relief surface	Inappropriate cutting conditions	● Increase the cutting speed by 10 % within standard conditions. ● When the feed is extremely low or high, set up it within standard conditions.
	Common	Relief surface	Varieties and supply of cutting fluid	● Confirm that the cutting fluid flow is higher than 7 liter/min. ● The concentration of cutting fluid must be higher than 5 %. ● Use the cutting fluid superior in lubricity. ● Change to internal cutting fluid supply from external one.
			Vibration in drilling	● Change to the machine with higher torque. ● Change to the clamp method with rigidity. ● Change the drill setting method.
			Unsuitable for selection of grade	● Change the grade to high wear resistant.
			Looseness of screws	● Tighten the screw.
		Crater	Cutting heat is too high	● Change to internal cutting fluid supply from external one. ● Increase the supply rate of the cutting fluid. (Higher than 10 liter/min.) ● Lower the feed by 20 % within standard conditions. ● Lower the cutting speed by 20 % within standard conditions.
			Excessive chip welding	● Lower the feed by 20 % within standard conditions. ● Lower the cutting speed by 20 % within standard conditions.
		Chipbreaker	Chip packing	● Increase the cutting speed by 20% and lower the feed by 20% within standard conditions. ● Raise the fluid pressure (for higher than 1.5 MPa).
Chipping and fracture	Central cutting edge	The rotation center of drill	Misalignment for workpiece rotation	● Set the misalignment to 0 ~ 0.2 mm.
			Large offset	● Check the manual and use the tool in the allowable offset range.
			No flatness of machined surface	● Flatten the entry surface in pre-machining. ● Set the feed for lower than 0.05 mm/rev in rough surface area.
			High feed	● Lower the feed by 20 ~ 50 % within standard conditions.
			Using a chipping corner	● Confirm the corner when exchanging inserts.
	Peripheral cutting edge	Peripheral corner area	Using inserts in excess of tool-life	● Exchange the corner or the insert before the nose wear reaches 0.3 mm.
			No flatness of machined surface	● Flatten the entry surface in pre-machining. ● Set the feed for lower than 0.05 mm/rev at rough surface area.
			The existence of interrupted area	● Set the feed for lower than 0.05 mm/rev in interrupted area.
			Using a chipped corner	● Confirm the corner when exchanging inserts.
	Common	The unused corner area and cutting edge	High hardness of workpiece	● Increase the cutting speed by 20 % and lower the feed by 20 % within standard conditions. ● Raise the fluid pressure (for higher than 1.5 MPa).
			Chip packing	● Lower the feed by 20 % within standard conditions.
			Machinery impact	● Change to continuous feed in case of pick feeding.
		Contact boundary	Using inserts in excess of tool-life	● Exchange the corner or the insert before the nose wear reaches 0.3 mm.
			Vibration in drilling	● Change to the machine with higher rigidity. ● Change to the clamp method with rigidity. ● Change the drill setting method.
		Flaking	High hardness of workpiece	● Set the feed for lower than 0.05 mm/rev.
			Thermal impact	● Change to internal cutting fluid supply from external one. ● Lower the feed by 20 % within standard conditions.
		Common	Unsuitable for selection of grade	● Change the grade to toughness.
			Looseness of screws	● Tighten the screw.

Indexable Drill

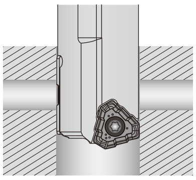
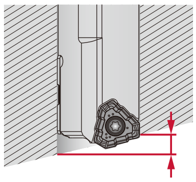
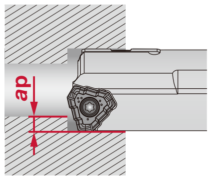
Troubleshooting for indexable drills

Problem		Cause	Countermeasure
Scratch marks on the tool	The tool periphery	Misalignment of workpiece rotation	● Set the misalignment to 0 ~ 0.2 mm.
		Offset machining in excess of allowable range	● Use the tool in the allowable offset range.
		Offset direction reduced diameter of workpiece	● Set offset direction extended diameter of workpiece
		No flatness of the entry surface	● Flatten the entry surface in pre-machining. ● Set the feed for lower than 0.05 mm/rev in rough surface area.
		Chipping of peripheral cutting edge	● Exchange the insert.
		Bend of workpiece	● Change to the clamp method with rigidity.
		Chip packing	● Increase the cutting speed by 20 % and lower the feed by 20 % within standard conditions. ● Raise the fluid pressure (for higher than 1.5 MPa).
Inappropriate hole accuracy	Hole diameter	Misalignment for workpiece rotation	● Set the misalignment to 0 ~ 0.2 mm.
		Inappropriate offset contents	● Adjust offset contents.
		No flatness of the entry surface	● Flatten the entry surface in pre-machining. ● Set the feed for lower than 0.05 mm/rev at rough surface area.
		Bend of workpiece	● Change to the clamp method with rigidity.
	Roughness	Varieties and supply of cutting fluid	● The concentration of cutting fluid must be higher than 5 %. ● Use the cutting fluid superior in lubricity. ● Change to internal cutting fluid supply from external one.
		Inappropriate cutting conditions	● Increase the cutting speed by 20 % within standard conditions. ● Lower the feed by 20 % within standard conditions.
	Common	Failures of inserts	● Exchange the insert.
		Chip packing	● Increase the cutting speed by 20 % and lower the feed by 20 % within standard conditions. ● Raise the fluid pressure (for higher than 1.5 MPa).
		Looseness of screws	● Tighten the screw.
Chip control	Prolonged and twisted of chips	Inappropriate cutting conditions	● Work within standard conditions. ● Increase the cutting speed by 10 % within standard conditions. ● Increase the feed by 10 % within standard conditions.
		Failures of inserts	● Exchange inserts.
		Machining by external fluid supply	● Change to internal cutting fluid supply from external one. ● Work by step feed. ● Use dwell function for 0.1 sec approximately.
		Chips around the central cutting edge	● There is a tendency to shorten the chips when shifting to higher speed and feed.
	Chip packing	Fluid supply	● Change to internal cutting fluid supply from external one. ● Raise the fluid pressure (for higher than 1.5 MPa).
		Inappropriate cutting conditions	● Increase the cutting speed by 20 % and lower the feed by 20 % within standard conditions. ● Raise the fluid pressure (for higher than 1.5 MPa).
	Common	Large failure of drill holders	● Exchange the drill holder.
		Looseness of screws	● Tighten the screw.
Others	Chatter	Inappropriate cutting conditions	● Lower the cutting speed by 20 % within standard conditions. ● Increase the feed by 10 % within standard conditions.
		Large wear of inserts	● Exchange the insert.
		Vibration in drilling	● Change to the machine with higher torque rigidity. ● Change to the clamp method with rigidity. ● Change the drill setting method.
		Looseness of screws	● Tighten the screw.
	Machine stop	Insufficient machine power and torque	● Use the range of number of revolutions suited machine spec. Lower the feed by 20 ~ 50%.
		Burned inserts	● Exchange inserts before the failure becomes larger. ● Check the oil-hole plug screw is tightly screwed in place. ● Check that the fluid flows powerfully from the drill. ● Lower the cutting speed and the feed by 20 % within standard conditions.
	Large burr	Failures of inserts	● Exchange the insert.
		Inappropriate cutting conditions	● Lower the feed by 20 ~ 50% just before leaving from the workpiece.

Nomenclature for gun drill



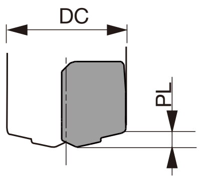
APPLICATION RANGE

Feed *f* (mm/rev)	0.03 - 0.05	0.03 - 0.05	0.1 - 0.3
Application	**OK** Cross hole drilling 	**OK** Inclined exit  16 mm or less (for standard drill)	**OK** Boring 

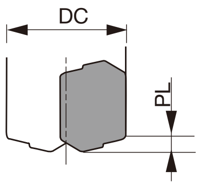
BLIND HOLE SHAPES OF THE HOLE BOTTOM

DC	Insert	Maximum difference PL
10 - 11.8	ZSGT06...	1.7
11.81 - 13.99	LOGT06...	1.8
14 - 15.99	TOHT07...	2
16 - 18	TOHT08...	2.2
18.01 - 20	TOHT09...	3
20.01 - 21.99	TOHT10...	3.2
22 - 25	TOHT11...	3.4
25.01 - 28	TOHT12...	3.6

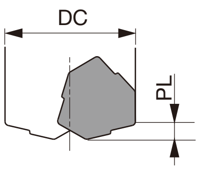
ZSGT06...



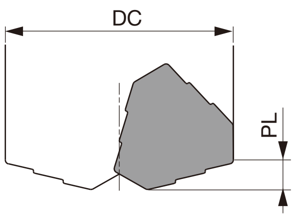
LOGT06...



TOHT07..., 08...

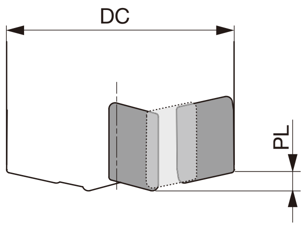


TOHT09... - TOHT12...



DC	Insert Central	Insert Intermediate	Insert Peripheral	Maximum difference PL
28.01 - 28.84	FBM07**-C	FBM06**-I	FBH06**-P	2.5
28.85 - 29	FBM07**-C	FBM06**-I	FBH06**-P	2.6
29.01 - 29.83	FBM07**-C	FBM06**-I	FBH06**-P	2.5
29.84 - 29.99	FBM07**-C	FBM06**-I	FBH06**-P	2.8
30 - 30.63	FBM07**-C	FBM07**-I	FBH08**-P	2.8
30.64 - 31.53	FBM07**-C	FBM07**-I	FBH08**-P	2.9
31.54 - 32.4	FBM07**-C	FBM07**-I	FBH08**-P	3
32.41 - 33	FBM07**-C	FBM07**-I	FBH08**-P	3.1
33.01 - 33.53	FBM07**-C	FBM07**-I	FBH08**-P	2.9
33.54 - 34.43	FBM07**-C	FBM07**-I	FBH08**-P	3
34.44 - 35	FBM07**-C	FBM07**-I	FBH08**-P	3.1
35.01 - 35.42	FBM08**-C	FBM07**-I	FBH08**-P	3
35.43 - 36	FBM08**-C	FBM07**-I	FBH08**-P	3.1
36.01 - 36.52	FBM08**-C	FBM07**-I	FBH08**-P	2.9
36.53 -37.42	FBM08**-C	FBM07**-I	FBH08**-P	3
37.43 - 38	FBM08**-C	FBM07**-I	FBH08**-P	3.1
38.01 - 38.12	FBM08**-C	FBM07**-I	FBH09**-P	3.3
38.13 - 39	FBM08**-C	FBM07**-I	FBH09**-P	3.4
39.01 - 39.22	FBM08**-C	FBM07**-I	FBH09**-P	3.2
39.23 - 40	FBM08**-C	FBM07**-I	FBH09**-P	3.3

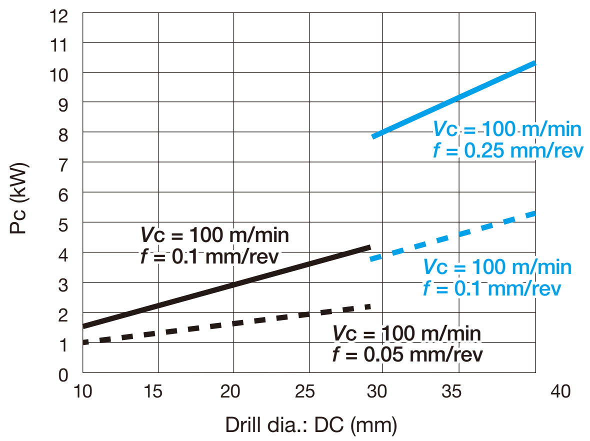
FBM...



REQUIRED SPINDLE POWER AND COOLANT PRESSURE

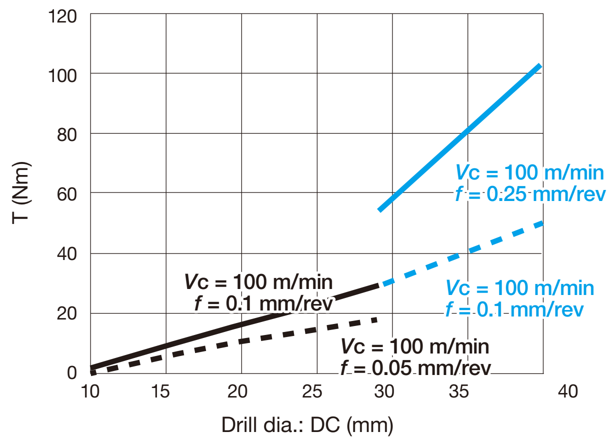
Net power

P S55C / C55

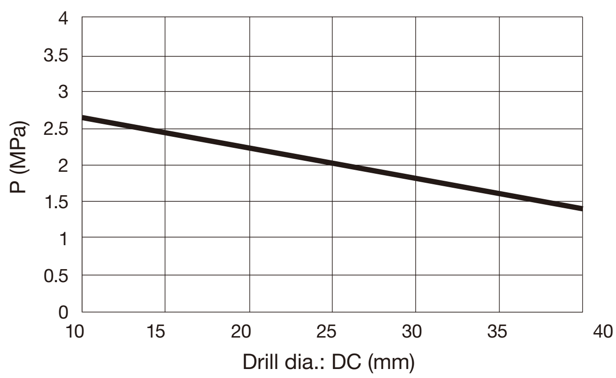


Torque

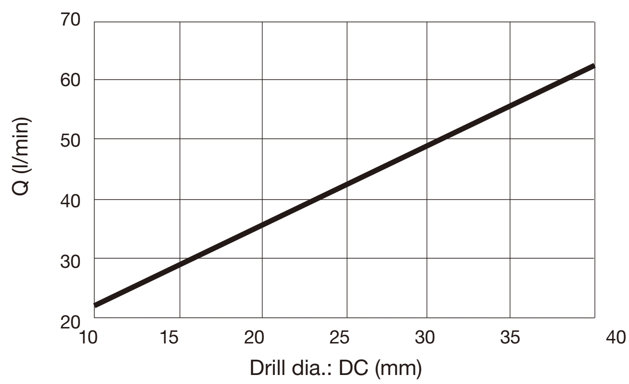
P S55C / C55



Coolant pressure



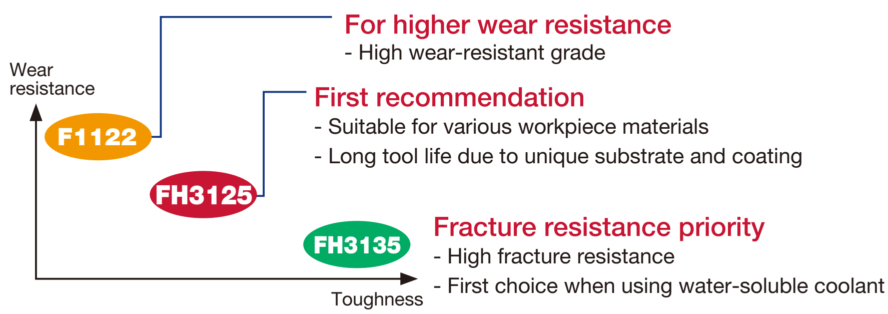
Coolant flow rate

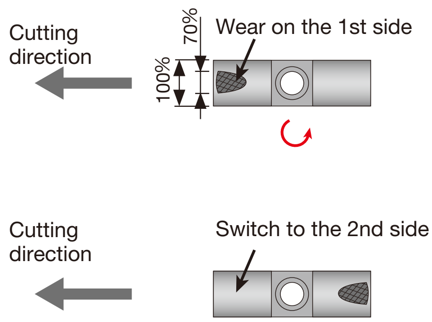


■ Guide pad grade and the timing for replacement

Guide pads are subject to wear, like inserts

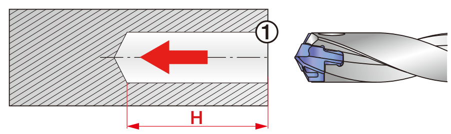
- The guide pad has two sides.
- Each guide pad can be used on two sides. When the first corner wears out to 70% of the width, reverse the guide pad to use the second side.
- Replace with a new guide pad when the second side wears out.



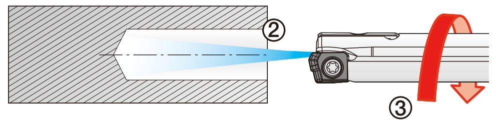


Drilling procedure on machining centers and lathes

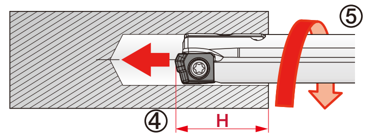
Proceed as instructed below in order to maximize the tool performance.



① Drill a pilot hole
Hole diameter tolerance: +0.01 - +0.05 mm
Hole depth: H = 25 mm
Note: Drill H = 45 mm when using an MCTRCH drill (for cross-hole).
Please use DrillMeister or DrillForce-Meister for a pilot hole.
Use a drill with 3xD or smaller.
Note: Recommend to use a drill with 5xD when using an MCTRCH drill.

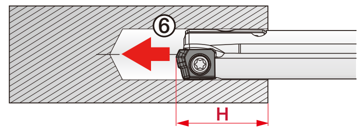


② Start coolant
③ Slowly insert DeepTri-Drill into the pilot hole
No. of revolution: n = 50 - 100 min^{-1}
Feed rate: Vf = 100 - 300 mm/min
Note: Do not rotate the drill at full machining speed before engaging the pilot hole.

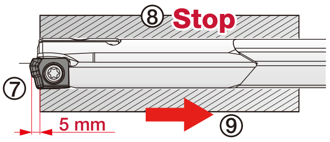


④ Stop the drill at H = 20 mm depth
Note: Stop at H = 40 mm when using an MCTRCH drill.

⑤ Start rotating at full machining speed



⑥ Start feeding
At the entry (H = 20 - 30 mm) → Feed: f = 80% of programmed feed
Note: Drill H = 40 - 50 mm when using an MCTRCH drill.
Hole depth: H ≥ 30 mm → Feed: f = 100%
Note: Drill H = 50 mm or more when using an MCTRCH drill.



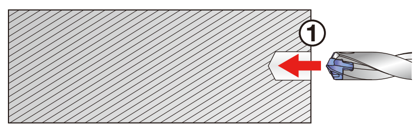
⑦ For a through hole
Continue drilling until the drill head passes through the workpiece by 5 mm.

Note: When machining gummy materials such as low carbon steel, reduce the feed rate to 70% of the normal level right before exiting the material to prevent chips from scattering.

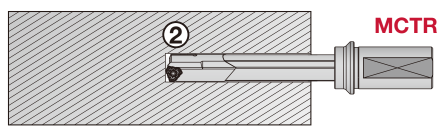
⑧ Stop the rotation and coolant
⑨ Return the drill, and operation finished

How to use a trlg type deeptri-drill on a horizontal machining center or boring machine

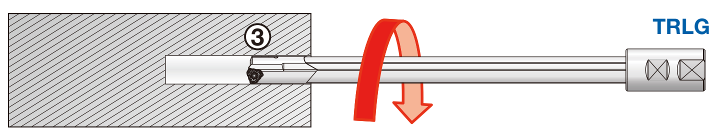
When using the TRLG drill on a conventional machining center or horizontal boring machine where there are no drilling-bush supports available, a pilot hole needs to be further deepened with a MCTR drill to better support the long gundrill. A long gundrill such as the TRLG type drill tends to “whip” when the pilot hole is too short to support the gundrill.



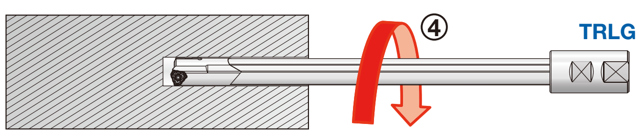
① Drill a pilot hole



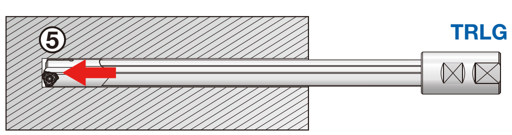
② Expand the pilot hole deeper using a MCTR drill



③ Drill with a TRLG drill at a reduced rotation and feed. Use the following parameters:
No. of revolution: n = 50 - 100 min^{-1}
Feed speed: Vf = 100 - 300 mm/min



④When DeepTri-Drill reaches all the way to the end of the pilot hole, increase drill rotation to full machining speed.



⑤Start feeding to complete the drilling

(Caution)
Always use Step ② to prevent the gundrill from whipping, which may lead to drill breakage and a possible superfluous injury.

Troubleshooting in gun drilling

Problem		Cause	Trigger	Countermeasure
Breaking of drill	At entry into workpiece	Machine	Clamping the workpiece is unstable.	Clamp the workpiece firmly.
			The guide bush is apart from the workpiece surface at the entry.	Contact the guide bush closely with the workpiece.
			The machine's rapid feed is used.	Use cutting feed.
			Whipping effect occurs.	Place a whip guide at the appropriate position.
			The shape of the guide bush is not suitable.	Use the guide bush in the shape suitable for the workpiece.
		Drill	The drill is not set properly.	Set the drill with an appropriate torque, hydraulic pressure, etc.
			Regrinding is in poor quality.	Make sure no damage is left on the drill and that the cutting edge geometry is not changed.
		Cutting condition	The feed (*f*) is too high.	Use low feed.
		Workpiece	The workpiece surface is slanted.	Use low feed.
	During drilling	Machine	Clamping the workpiece is unstable.	Clamp the workpiece firmly.
			The shape of the guide bush is not suitable.	Modify the shape of the guide bush. See “Chip packing” for the details.
			The feed speed (*Vf*) varies.	Use mechanical feed.
			The number of revolutions varies (decreases).	Increase the machine power or adjust the cutting conditions.
		Drill	Abnormal damage occurs.	See “Short tool life” for the details.
		Cutting condition	The feed (*f*) is not suitable.	Use an appropriate feed.
		Workpiece	Interrupted or cross drilling is required.	Change the tool to a standard gundrill.
		Others	Chip packing occurs.	See “Chip packing” for the details.
	At exit from workpiece	Drill	The tip is too long.	Make the tip length short.
			The selection of the guide pads is not suitable.	Use 2 guide pads instead of 3.
			The clearance of the coolant hole is too large.	Reduce the clearance of the coolant hole.
		Cutting condition	The feed (*f*) is too high.	Use low feed.
		Workpiece	The workpiece surface is slanted.	Use low feed.
	During retracting	Machine	Clamping the workpiece is unstable.	Clamp the workpiece firmly.
		Cutting condition	Burnishing torque (cutting power) is increased due to reduced hole diameter.	Reduce cutting speed (*Vc*).

Troubleshooting in gun drilling

Problem		Cause	Trigger	Countermeasure
Hole accuracy	Rough surface finish	Machine	Clamping the workpiece is unstable.	Clamp the workpiece firmly.
			The type of coolant is not appropriate.	Use water-insoluble coolant.
			Foreign material is in the coolant.	Thoroughly filtrate the coolant (Use a filter with the filtration accuracy in 10μm or less).
			The run-out of the spindle is too large.	Minimize the run-out of the spindle.
			The clearance between the guide bush and the drill is not appropriate.	Replace the guide bush (The clearance should be between +0.003 and +0.008).
			The feed speed (*Vf*) varies.	Use mechanical feed.
			The number of revolutions varies (decreases).	Increase the machine power or adjust the cutting conditions.
		Drill	Abnormal damage occurs.	See “Short tool life” for the details.
			Regrinding is in poor quality.	Make sure no damage is left on the drill and that the cutting edge geometry is not changed.
		Cutting condition	The feed (*f*) is too high.	Reduce the feed.
		Others	Chip packing occurs.	See “Chip packing” for the details.
	Unacceptable circularity, cyndricity, and oversize	Machine	The clearance between the guide bush and the drill is not appropriate.	Replace the guide bush (The clearance should be between +0.003 and +0.008).
			The guide bush is apart from the workpiece surface at the entry.	Contact the guide bush closely with the workpiece.
			The type of coolant is not appropriate.	Use water-insoluble coolant.
			The concentricity of the guide bush and the spindle is too large.	Decrease the concentricity of the guide bush and the spindle.
		Drill	Abnormal damage occurs.	See “Short tool life” for the details.
			Regrinding is in poor quality.	Make sure no damage is left on the drill and that the cutting edge geometry is not changed.
		Cutting condition	The feed (*f*) is not suitable.	Use an appropriate feed.
		Workpiece	Interrupted or cross drilling is required.	Change the tool to a standard gundrill.
		Others	Chip packing occurs.	See “Chip packing” for the details.
	Bending of hole	Machine	Clamping the workpiece is unstable.	Clamp the workpiece firmly.
			The guide bush is apart from the workpiece surface at the entry.	Contact the guide bush closely with the workpiece.
			The concentricity of the guide bush and the spindle is too large.	Decrease the concentricity of the guide bush and the spindle.
			The clearance between the guide bush and the drill is not appropriate.	Replace the guide bush (The clearance should be between +0.003 and +0.008).
		Drill	The selection of the guide pads is not suitable.	Use 2 guide pads instead of 3.
			Regrinding is in poor quality.	Make sure no damage is left on the drill and that the cutting edge geometry is not changed.
		Cutting condition	The feed (*f*) is too high.	Reduce the feed.
		Workpiece	The workpiece has blow holes or unevenness.	Use the workpiece without defect.
			The workpiece surface is slanted at the entry.	Use low feed.
			Interrupted or cross drilling is required.	Change the tool to a standard gundrill.

Troubleshooting in gun drilling

Problem		Cause	Trigger	Countermeasure
Short tool life	Abnormal wear	Machine	The type of coolant is not appropriate.	Use water-insoluble coolant.
			Foreign material is in the coolant.	Thoroughly filtrate the coolant (Use a filter with the filtration accuracy in 10µm or less).
			The clearance between the guide bush and the drill is not appropriate.	Replace the guide bush (The clearance should be between +0.003 and +0.008).
			Whipping effect occurs.	Place a whip guide at the appropriate position.
			The concentricity of the guide bush and the spindle is too large.	Decrease the concentricity of the guide bush and the spindle.
			The coolant temperature is too high.	Increase the capacity of the tank.
		Drill	The selection of the guide pads is not suitable.	Use 2 guide pads instead of 3.
			Regrinding is in poor quality.	Make sure no damage is left on the drill and that the cutting edge geometry is not changed.
			The drill's overall length is excessive.	Reduce the drill’s overall length.
			Excessive wear occurs and the chip shape changes.	Regrind the gundrill (ease the tool life criteria).
		Cutting condition	The cutting speed (*Vc*) is too high.	Reduce the cutting speed.
			The feed (*f*) is too high.	Reduce the feed.
			The coolant pressure is not high enough.	Increase the coolant pressure.
		Workpiece	The material quality varies.	Reduce the cutting speed (*Vc*).
Chip control	Chip packing	Machine	The shape of the guide bush is not suitable.	Modify the tip of the guide bush to match the shape of the workpiece surface at the entry.
			The number of revolutions varies (decreases).	Increase the machine power or adjust the cutting conditions.
			The chip box is too small for smooth chip evacuation.	Enlarge the chip box.
		Cutting condition	The feed (*f*) is not suitable.	Use an appropriate feed.
			The coolant pressure is not high enough.	Increase the coolant pressure.
		Workpiece	Interrupted or cross drilling is required.	Change the tool to a standard gundrill.
			The operation is for stacked plates.	Change the cutting edge shape so that the cores become small.
			The material quality varies.	Increase the feed.
	Chip entanglement	Drill	The cutting edge is fractured or chipped.	See “Breakage” for the details.
			Wear on the outer corner is excessive.	Regrind the gundrill (ease the tool life criteria).
		Cutting condition	The feed (*f*) is too low.	Increase the feed.
		Workpiece	Drilling a center hole is required.	Make the center hole as small as the drill diameter and increase the coolant pressure.

DEEP TRI DRILL Designation system

Designation for tailor-made tools

Special tool code may be created per below according to your specific drilling needs.

MCTR (1) 18.50 (2) XM 25 (3) - 22 (4)

① Series	
MCTR	DeepTri-Drill (For machining centers and lathes)
MCTRCH	DeepTri-Drill (For cross hole drilling on machining centers and CNC lathes)

② Drill dia. DC (mm)	
18.50	18.50

③ Driver dia. DCONMS (mm)	
25	25

④ LU/DC ratio

For tailor-made drills, use the guide below to make the designation (Cat. No).

TRLG (1) 18.50 (2) X 900 (3) - 23 (4)

① Series	
TRLG	DeepTri-Drill (For gundrill machines)
TRLGCH	DeepTri-Drill (For cross hole drilling on gundrilling machines)

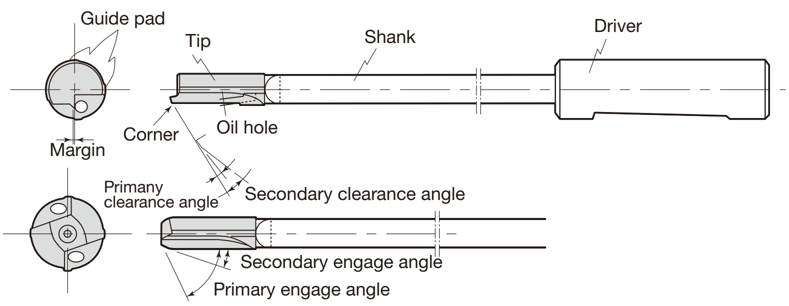
② Drill dia. DC (mm)	
18.50	18.50

③ Overall length: *L* (mm)	
900	900

④ Driver code	
23	23

Reamer

Nomenclature for gun reamer



Troubleshooting in gun reaming

Trouble		Possible cause		Countermeasure
Breaking of reamer		Increased burnishing torque due to excessively small stock allowance	● Chamfer angle small	● Enlarge chamfer angle and increase stock allowance
			● Excessive wear in peripheral cutting edge.	● Reduce cutting speed to prevent peripheral wear of edge ● Increase lubricity of cutting fluid
		Sticking	● Faulty filtering of cutting fluid ● Incorrect selection of cutting fluid ● Insufficient cutting fluid pressure	● Improve filtering accuracy ● Change to fluid with higher lubricity ● Increase fluid pressure
		Mechanical trouble		● Repair electrical system ● Improve clamping method of workpiece
Faulty machining accuracy	Unacceptable surface roughness Too large and inconsistent over size	Excessive feed rate per tooth		● Reduce fluid pressure ● Increase number of teeth
		Improper tool specifications	● Excessive chamfer angle ● Excessive back taper ● Peripheral run out excessive	● Reduce chamfer angle ● Reduce back taper ● Improve run out accuracy
		Faulty regrinding	● Cutting edge run out is large ● Residual damage of preceding process	● Improve run out accuracy ● Remove residual damage completely
		Improper cutting fluid	● Excessive fluid pressure ● Improper selection of cutting fluid	● Reduce fluid pressure ● Increase activity and lubricity of the fluid
		Faulty machine accuracy		● Correct spindle run out and bushing clearance and alignment
		Faulty clamping of workpiece	● Clamping position wrong ● Clamping force inadequate	● Improper clamping position ● Increase clamping force
	Defective out-of-roundness	Faulty machine accuracy	● Excessive bushing clearance ● Faulty spindle run out and alignment	● Correct bushing clearance ● Correct spindle run out and alignment
		Improper tool specifications	● Outer run out of reamer large ● Insufficient reamer rigidity	● Correct peripheral run out ● Increase reamer rigidity
		Faulty clamping position of workpiece		● Change clamping position
		Unevenness in wall thickness of workpiece		● Reduce reamer guide width (margin width)
	Insufficient oversize allowance	Chamfer angle small		● Increase chamfer angle
		Excessive wear in peripheral cutting edge	● Too high cutting speed ● Faulty lubricity of cutting fluid	● Decrease cutting speed ● Increase lubricating capacity
		Faulty regrinding (residual damage)		● Increase regrinding stock amount

International Tolerance

IT (International Tolerance) Grades

IT grades shows a tolerance allowable for difference of the diameters of a hole and a shaft. As the number added after IT increases, the tolerance becomes rough. Depending on the basic size, the tolerance value in each grade varies.
In the catalog, IT grades are shown as a guide of dimensional dispersion in the diameters of holes machined with the drill. For information, H8 tolerance for a ø8.0 hole is 0 to + 0.022 mm, the width of the value is the same as that of IT 8.
In the Table shown below, tolerance areas attainable with typical drilling tools are distinguished by using different colors. Solid drills are generally used for machining holes of IT 9 to 12. For machining a hole of better than IT 8, finishing process such as reaming is required. For a hole better than IT 5, high-precision finishing is required. Above description is based on machining of general steel. In practice, the IT grade attained with the tool varies widely depending on the hardness and the composition of the work material.

Basic size (mm)		International tolerance grade																	
		IT1	IT2	IT3	IT4	IT5	IT6	IT7	IT8	IT9	IT10	IT11	IT12	IT13	IT14	IT15	IT16	IT17	IT18
>	≤						(μm)									(mm)			
-	3	0.8	1.2	2	3	4	6	10	14	25	40	60	0.1	0.14	0.25	0.4	0.6	1	1.4
3	6	1	1.5	2.5	4	5	8	12	18	30	48	75	0.12	0.18	0.3	0.48	0.75	1.2	1.8
6	10	1	1.5	2.5	4	6	9	15	22	36	58	90	0.15	0.22	0.36	0.58	0.9	1.5	2.2
10	18	1.2	2	3	5	8	11	18	27	43	70	110	0.18	0.27	0.43	0.7	1.1	1.8	2.7
18	30	1.5	2.5	4	6	9	13	21	33	52	84	130	0.21	0.33	0.52	0.84	1.3	2.1	3.3
30	50	1.5	2.5	4	7	11	16	25	39	62	100	160	0.25	0.39	0.62	1	1.6	2.5	3.9
50	80	2	3	5	8	13	19	30	46	74	120	190	0.3	0.46	0.74	1.2	1.9	3	4.6
80	120	2.5	4	6	10	15	22	35	54	87	140	220	0.35	0.54	0.87	1.4	2.2	3.5	5.4
120	180	3.5	5	8	12	18	25	40	63	100	160	250	0.4	0.63	1	1.6	2.5	4	6.3
180	250	4.5	7	10	14	20	29	46	72	115	185	290	0.46	0.72	1.15	1.85	2.9	4.6	7.2
250	315	6	8	12	16	23	32	52	81	130	210	320	0.52	0.81	1.3	2.1	3.2	5.2	8.1
315	400	7	9	13	18	25	36	57	89	140	230	360	0.57	0.89	1.4	2.3	3.6	5.7	8.9
400	500	8	10	15	20	27	40	63	97	155	250	400	0.63	0.97	1.55	2.5	4	6.3	9.7
500	630	9	11	16	22	32	44	70	110	175	280	440	0.7	1.1	1.75	2.8	4.4	7	11
630	800	10	13	18	25	36	50	80	125	200	320	500	0.8	1.25	2	3.2	5	8	12.5
800	1000	11	15	21	28	40	56	90	140	230	360	560	0.9	1.4	2.3	3.6	5.6	9	14
1000	1250	13	18	24	33	47	66	105	165	260	420	660	1.05	1.65	2.6	4.2	6.6	10.5	16.5
1250	1600	15	21	29	39	55	73	125	195	310	500	780	1.25	1.95	3.1	5	7.8	12.5	19.5
1600	2000	18	25	35	46	65	92	150	230	370	600	920	1.5	2.3	3.7	6	9.2	15	23
2000	2500	22	30	41	55	78	110	175	280	440	700	1100	1.75	2.8	4.4	7	11	17.5	28
2500	3150	26	36	50	68	96	135	210	330	540	860	1350	2.1	3.3	5.4	8.6	13.5	21	33

Tolerance area requiring finishing process such as with a reamer.

Tolerance area attainable with a solid drill.

Tolerance area attainable with an indexable drill.

Deviations in Commonly Used Fits

Deviations of Shafts to be Used in Commonly Used Fits (JIS B0401 extrac)

Basic size step (mm)		Tolerance zone class of shaft (μm)															
>	≤	e9	f6	f7	f8	g5	g6	h5	h6	h7	h8	h9	js5	js6	js7	k5	k6
–	3	−14 −39	−6 −12	−6 −16	−6 −20	−2 −6	−2 −8	0 −4	0 −6	0 −10	0 −14	0 −25	±2	±3	±5	+4 0	+6 0
3	6	−20 −50	−10 −18	−10 −22	−10 −28	−4 −9	−4 −12	0 −5	0 −8	0 −12	0 −18	0 −30	±2.5	±4	±6	+6 +1	+9 +1
6	10	−25 −61	−13 −22	−13 −28	−13 −35	−5 −11	−5 −14	0 −6	0 −9	0 −15	0 −22	0 −36	±3	±4.5	±7	+7 +1	+10 +1
10	14	−32 −75	−16 −27	−16 −34	−16 −43	−6 −14	−6 −17	0 −8	0 −11	0 −18	0 −27	0 −43	±4	±5.5	±9	+9 +1	+12 +1
14	18																
18	24	−40 −92	−20 −33	−20 −41	−20 −53	−7 −16	−7 −20	0 −9	0 −13	0 −21	0 −33	0 −52	±4.5	±6.5	±10	+11 +2	+15 +2
24	30																
30	40	−50 −112	−25 −41	−25 −50	−25 −64	−9 −20	−9 −25	0 −11	0 −16	0 −25	0 −39	0 −62	±5.5	±8	±12	+13 +2	+18 +2
40	50																
50	65	−60 −134	−30 −49	−30 −60	−30 −76	−10 −23	−10 −29	0 −13	0 −19	0 −30	0 −46	0 −74	±6.5	±9.5	±15	+15 +2	+21 +2
65	80																
80	100	−72 −159	−36 −58	−36 −71	−36 −90	−12 −27	−12 −34	0 −15	0 −22	0 −35	0 −54	0 −87	±7.5	±11	±17	+18 +3	+25 +3
100	120																

In every step given in the table, the value on the upper side shows the upper deviation and the value on the lower side, the lower deviation.

Deviations of Holes to be Used in Commonly Used Fits. (JIS B0401 extrac)

Basic size step (mm)		Tolerance zone class of hole (μm)																
>	≤	E7	E8	E9	F6	F7	F8	G6	G7	H6	H7	H8	H9	H10	JS6	JS7	K6	K7
–	3	+24 +14	+28 +14	+39 +14	+12 +6	+16 +6	+20 +6	+8 +2	+12 +2	+6 0	+10 0	+14 0	+25 0	+40 0	±3	±5	0 −6	0 −10
3	6	+32 +20	+38 +20	+50 +20	+18 +10	+22 +10	+28 +10	+12 +4	+16 +4	+8 0	+12 0	+18 0	+30 0	+48 0	±4	±6	+2 −6	+3 −9
6	10	+40 +25	+47 +25	+61 +25	+22 +13	+28 +13	+35 +13	+14 +5	+20 +5	+9 0	+15 0	+22 0	+36 0	+58 0	±4.5	±7	+2 −7	+5 −10
10	14	+50 +32	+59 +32	+75 +32	+27 +16	+34 +16	+43 +16	+17 +6	+24 +6	+11 0	+18 0	+27 0	+43 0	+70 0	±5.5	±9	+2 −9	+6 −12
14	18																	
18	24	+61 +40	+73 +40	+92 +40	+33 +20	+41 +20	+53 +20	+20 +7	+28 +7	+13 0	+21 0	+33 0	+52 0	+84 0	±6.5	±10	+2 −11	+6 −15
24	30																	
30	40	+75 +50	+89 +50	+112 +50	+41 +25	+50 +25	+64 +25	+25 +9	+34 +9	+16 0	+25 0	+39 0	+62 0	+100 0	±8	±12	+3 −13	+7 −18
40	50																	
50	65	+90 +60	+106 +60	+134 +60	+49 +30	+60 +30	+76 +30	+29 +10	+40 +10	+19 0	+30 0	+46 0	+74 0	+120 0	±9.5	±15	+4 −15	+9 −21
65	80																	
80	100	+107 +72	+126 +72	+159 +72	+58 +36	+71 +36	+90 +36	+34 +12	+47 +12	+22 0	+35 0	+54 0	+87 0	+140 0	±11	±17	+4 −18	+10 −25
100	120																	

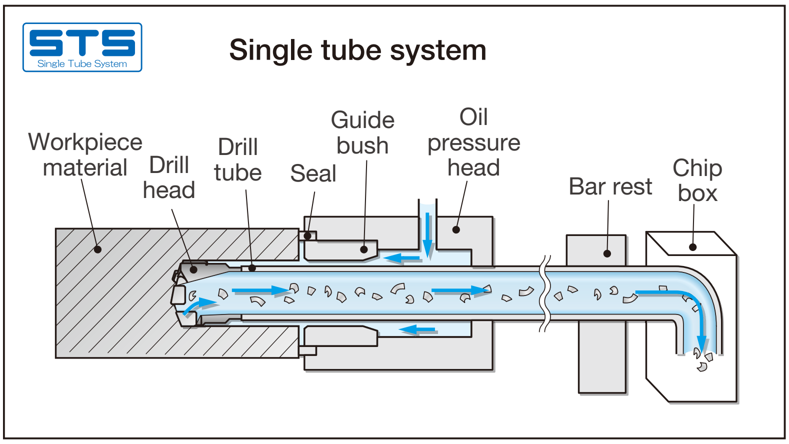
In every step given in the table, the value on the upper side shows the upper deviation and the value on the lower side, the lower deviation.

Deep hole drilling head series

Single Tube System (STS) and Double Tube System (DTS)

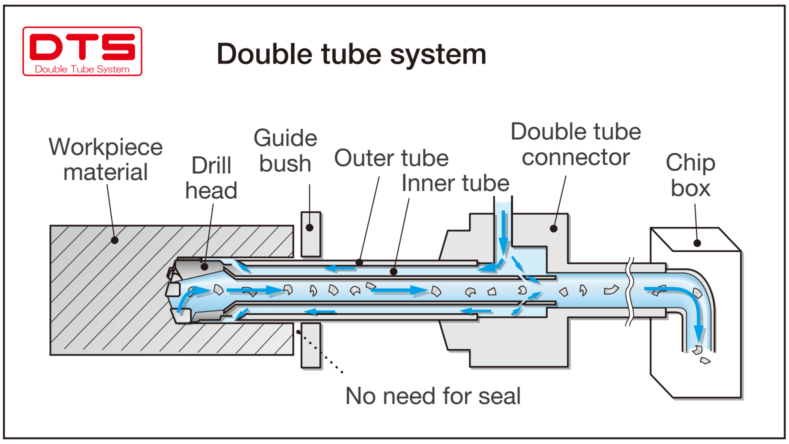
Single Tube System (STS)

The STS may also be referred to as the BTA system in the deep hole drilling process. A large volume of coolant is pumped under high pressure to the cutting area in the workpiece. Chips are then forced out through the drill tube at the back and they do not touch workpiece allowing super surface finish. STS is a very good method to obtain holes of high productivity and high accuracy by using a dedicated drilling machine and a sealing with the workpiece.



Double Tube System (DTS)

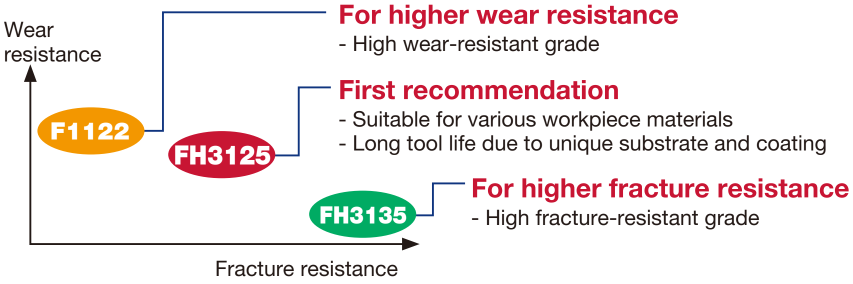
The DTS is characterized by its two tube construction and is therefore known as the double tube system. A sealing system and pressure head, which is required in the Single Tube System (STS) is not necessary for the DTS and it is therefore suitable for conventional general purpose machines such as lathes or machining centers.
In general, because of less efficient chip evacuation than the STS the recommended max drilling depth is 1000mm. However, the unique DTC-R tube connector that is capable of supplying high pressure coolant can successfully achieve drilling depths of up to 2000 mm.

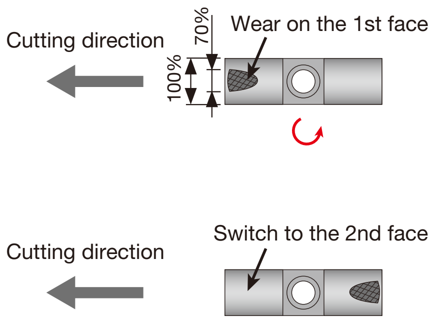


Replacing guide pads

Guide pads are subject to wear, like inserts

- The guide pad can be used on two end faces.
- When the first face wears up to 70% of its width, reverse the guide pad to use the second face.
- Replace with a new guide pad when the second face wears out.



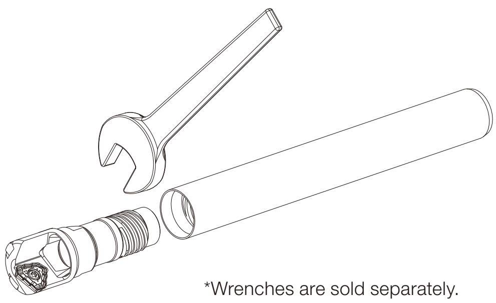


GP	06-085	F1122
Series	Size	Grade

GP	06-20-085	-DC	FH3135
Series	Size	Double chamfer	Grade

NOTE FOR MOUNTING A DRILL HEAD

Please be sure to use a wrench for a drill head to be clamped firmly.



*Wrenches are sold separately.

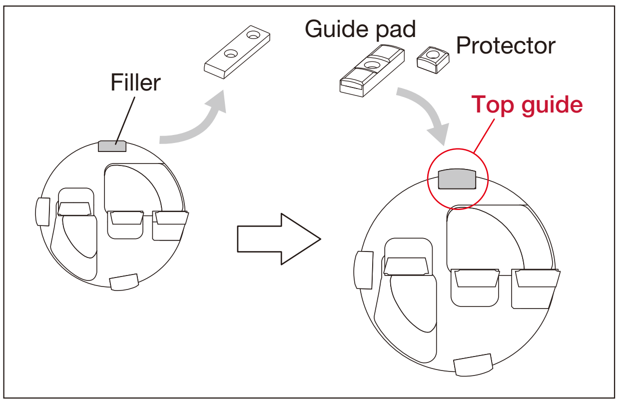
WHEN TO REPLACE THE FILLER WITH A GUIDE PAD AND PROTECTOR

Replace the filler with a guide pad and protector when following is required:

- Higher hole precision
- Deep holes with an L/D ratio of over 50:1
- Drilling parts with a center hole
- A large stock removal that exceeds the marginal DOC* of the peripheral edge as specified in the list below.

*Maximum DOC of peripheral insert

Cartridge	DOC (mm)	Guide pad
OZ402-04	6.4	GP08.../GP10...
OZ402-32	7.2	GP10.../GP14...
OZ402-43	10.4	GP14.../GP18...
OZ402-63	12.0	GP18...



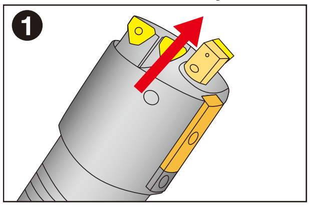
There is no pocket for the top guide pad furnished on the drill heads in diameters smaller than 92 mm.
Please contact your dealer for further information.

Deep hole drilling head series

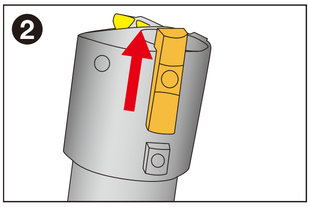
Drill diameter calibration

Please note that inserts must be ordered separately as they are not included in the UNIDEX tool.
To achieve successful drilling with UNIDEX deep hole drill, it is critical to set and maintain adequate clearance between the tool diameter and guide pad diameter. After installing inserts, make sure to properly calibrate the tool diameter by following the steps outlined below.
Always proceed with the same calibration procedures when the inserts are indexed or exchanged.
This is especially important when using inserts from a new batch as they may greatly deviate the tool diameter.

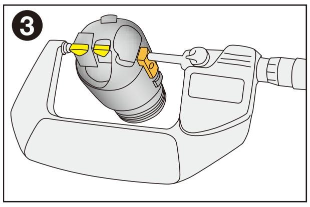
⚠ Poor hole precision, abnormal wear of inserts or guide pads, or serious tool damage may occur if the insert and guide pad diameters are not properly calibrated.



1. Remove the intermediate cartridge to avoid interference with the guide screw.

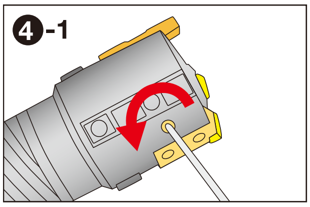


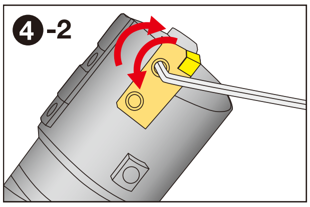
2. Move the dimensional guide pad to the measuring position parallel to the peripheral insert.
   - 2-1 Unscrew the lock screw of the dimensional guide pad and slide the dimensional guide pad to the measuring position.
   - 2-2 Tighten the lock screw to fix the guide pad.

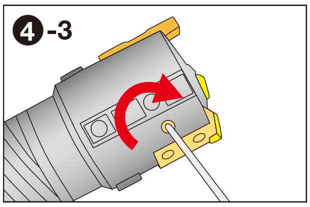


3. Measure the diameter with a micrometer.
   Use an h8 tolerance for the tool diameter unless otherwise required.

> If the diameter at this point is out of tolerance, go to Step 4.
> If the diameter at this point is in tolerance, go to Step 5.

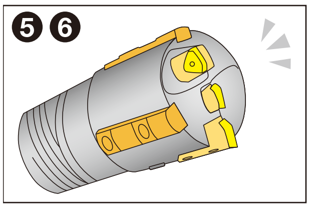






4. Adjust the peripheral cartridge
   - 4-1 First loosen the lock screw of the peripheral cartridge and then slightly re-tighten the lock screw.
   - 4-2 Adjust the cartridge by loosening or tightening the two adjusting screws on the cartridge and measure the diameter using a micrometer. Repeat steps until the required diameter is attained.
   - 4-3 After attaining the required diameter, securely tighten the lock screw to fix the cartridge.
   - 4-4 Measure the diameter with a micrometer to assure that the required diameter is attained. If not attained, start from Step 4-1.

> ⚠ Make sure that the two adjusting screws on the peripheral cartridge are tightened. If the tool is used with either of the screws left loosened, the cartridge will move during machining due to cutting forces and may cause damage.



5. Return the dimensional guide pad to the original position and tighten the lock screw.
6. Replace the intermediate cartridge to the original position and tighten the lock screw.

> ⚠ Whenever inserts are indexed or exchanged, always make sure that all the screws on the drill are securely tightened. If chatter occurred during machining, it may cause the screws to be loosened.

Approximate Conversion Table of Hardness

● Approximate conversion value for Brinell hardness. *1

(The source: JIS HB Ferrous Materials and Metallurgy I -2005)

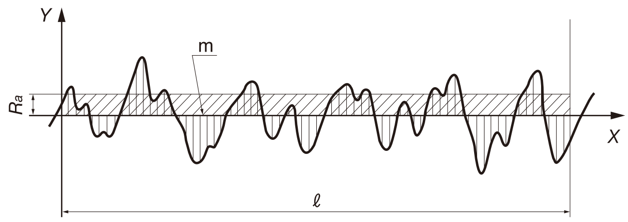
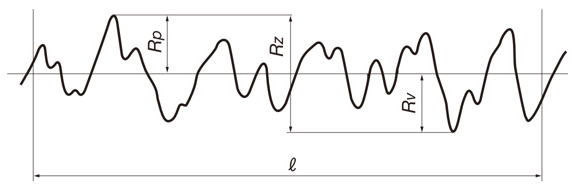
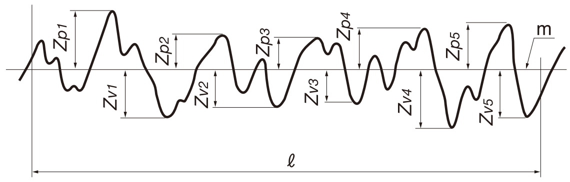
HB Brinell, 10mm ball, Load 3000kg		HV	Rockwell *3				HS	Approx. tensile strength (MPa) *2
			HRA	HRB	HRC	HRD		
Standard ball	Tungsten carbide ball	Vickers	A Scale, Load 60kg, Brale Diamond	B Scale, Load 100kg, Diameter 1/16 in. Steel ball	C Scale, Load 150kg, brale diamond	D Scale, Load 100kg, Brale Diamond	Shore	
–	–	940	85.6	–	68.0	76.9	97	–
–	–	920	85.3	–	67.5	76.5	96	–
–	–	900	85.0	–	67.0	76.1	95	–
–	(767)	880	84.7	–	66.4	75.7	93	–
–	(757)	860	84.4	–	65.9	75.3	92	–
–	(745)	840	84.1	–	65.3	74.8	91	–
–	(733)	820	83.8	–	64.7	74.3	90	–
–	(722)	800	83.4	–	64.0	73.8	88	–
–	(712)	–	–	–	–	–	–	–
–	(710)	780	83.0	–	63.3	73.3	87	–
–	(698)	760	82.6	–	62.5	72.6	86	–
–	(684)	740	82.2	–	61.8	72.1	–	–
–	(682)	737	82.2	–	61.7	72.0	84	–
–	(670)	720	81.8	–	61.0	71.5	83	–
–	(656)	700	81.3	–	60.1	70.8	–	–
–	(653)	697	81.2	–	60.0	70.7	81	–
–	(647)	690	81.1	–	59.7	70.5	–	–
–	(638)	680	80.8	–	59.2	70.1	80	–
–	630	670	80.6	–	58.8	69.8	–	–
–	627	667	80.5	–	58.7	69.7	79	–
–	–	677	80.7	–	59.1	70.0	–	–
–	601	640	79.8	–	57.3	68.7	77	–
–	–	640	79.8	–	57.3	68.7	–	–
–	578	615	79.1	–	56.0	67.7	75	–
–	–	607	78.8	–	55.6	67.4	–	–
–	555	591	78.4	–	54.7	66.7	73	2055
–	–	579	78.0	–	54.0	66.1	–	2015
–	534	569	77.8	–	53.5	65.8	71	1985
–	–	553	77.1	–	52.5	65.0	–	1915
–	514	547	76.9	–	52.1	64.7	70	1890
(495)	–	539	76.7	–	51.6	64.3	–	1855
–	–	530	76.4	–	51.1	63.9	–	1825
–	495	528	76.3	–	51.0	63.8	68	1820
(477)	–	516	75.9	–	50.3	63.2	–	1780
–	–	508	75.6	–	49.6	62.7	–	1740
–	477	508	75.6	–	49.6	62.7	66	1740
(461)	–	495	75.1	–	48.8	61.9	–	1680
–	–	491	74.9	–	48.5	61.7	–	1670
–	461	491	74.9	–	48.5	61.7	65	1670
444	–	474	74.3	–	47.2	61.0	–	1595
–	–	472	74.2	–	47.1	60.8	–	1585
–	444	472	74.2	–	47.1	60.8	63	1585

HB Brinell, 10mm ball, Load 3000kg		HV	Rockwell *3				HS	Approx. tensile strength (MPa) *2
			HRA	HRB	HRC	HRD		
Standard ball	Tungsten carbide ball	Vickers	A Scale, Load 60kg, Brale Diamond	B Scale, Load 100kg, Diameter 1/16 in. Steel ball	C Scale, Load 150kg, brale diamond	D Scale, Load 100kg, Brale Diamond	Shore	
429	429	455	73.4	–	45.7	59.7	61	1510
415	415	440	72.8	–	44.5	58.8	59	1460
401	401	425	72.0	–	43.1	57.8	58	1390
388	388	410	71.4	–	41.8	56.8	56	1330
375	375	396	70.6	–	40.4	55.7	54	1270
363	363	383	70.0	–	39.1	54.6	52	1220
352	352	372	69.3	(110.0)	37.9	53.8	51	1180
341	341	360	68.7	(109.0)	36.6	52.8	50	1130
331	331	350	68.1	(108.5)	35.5	51.9	48	1095
321	321	339	67.5	(108.0)	34.3	51.0	47	1060
311	311	328	66.9	(107.5)	33.1	50.0	46	1025
302	302	319	66.3	(107.0)	32.1	49.3	45	1005
293	293	309	65.7	(106.0)	30.9	48.3	43	970
285	285	301	65.3	(105.5)	29.9	47.6	–	950
277	277	292	64.6	(104.5)	28.8	46.7	41	925
269	269	284	64.1	(104.0)	27.6	45.9	40	895
262	262	276	63.6	(103.0)	26.6	45.0	39	875
255	255	269	63.0	(102.0)	25.4	44.2	38	850
248	248	261	62.5	(101.0)	24.2	43.2	37	825
241	241	253	61.8	100.0	22.8	42.0	36	800
235	235	247	61.4	99.0	21.7	41.4	35	785
229	229	241	60.8	98.2	20.5	40.5	34	765
223	223	234	–	97.3	(18.8)	–	–	–
217	217	228	–	96.4	(17.5)	–	33	725
212	212	222	–	95.5	(16.0)	–	–	705
207	207	218	–	94.6	(15.2)	–	32	690
201	201	212	–	93.8	(13.8)	–	31	675
197	197	207	–	92.8	(12.7)	–	30	655
192	192	202	–	91.9	(11.5)	–	29	640
187	187	196	–	90.7	(10.0)	–	–	620
183	183	192	–	90.0	(9.0)	–	28	615
179	179	188	–	89.0	(8.0)	–	27	600
174	174	182	–	87.8	(6.4)	–	–	585
170	170	178	–	86.8	(5.4)	–	26	570
167	167	175	–	86.0	(4.4)	–	–	560
163	163	171	–	85.0	(3.3)	–	25	545
156	156	163	–	82.9	(0.9)	–	–	525
149	149	156	–	80.8	–	–	23	505
143	143	150	–	78.7	–	–	22	490
137	137	143	–	76.4	–	–	21	460
131	131	137	–	74.0	–	–	–	450
126	126	132	–	72.0	–	–	20	435
121	121	127	–	69.8	–	–	19	415
116	116	122	–	67.6	–	–	18	400
111	111	117	–	65.7	–	–	15	385

Note :
*1: This table is based on AMS Metals Handbook, the 8th Edition, Volume 1, and includes some information added to "Approx. tensile strength (MPa)," such as the values calculated in metric; and Brinell hardness that exceeds recommended values.
*2: 1 MPa = 1 N/mm^2
*3: Figures in ( ) are not commonly used. It's just reference.

Surface Roughness

(According to JIS B 0601, 2001 and its explanation.)

Type	Symbol	How to determine	Example (Fig.)
Arithmetic mean roughness	*Ra*	*Ra* means the value obtained by the following formula and expressed in micrometer (μm) when sampling only the reference length from the roughness curve in the direction of mean line, taking X-axis in the direction of mean line and Y-axis in the direction of longitudinal magnification of this sampled part and the roughness curve is expressed by *y- f (x)*: $$Ra = \frac{1}{\ell}\int_0^{\ell} \lvert f(x) \rvert \, dx$$ where, ℓ : reference length	
Maximum height	*Rz*	*Rz* shall be that only the reference length is sampled from the roughness curve in the direction of mean line, the distance between the top of profile peak line and the bottom of profile valley line on this sampled portion is measured in the longitudinal magnification direction of roughness curve and the obtained value is expressed in micrometer (μm). $$R_z = R_p + R_v$$	
Ten point mean roughness	Rz_{JIS}	Rz_{JIS} shall be that only the reference length is sampled from the roughness curve in the direction of its mean line, the sum of the average value of absolute values of the heights of five highest profile peaks (*Zp*) and the depths of five deepest profile valleys (*Zv*) measured in the vertical magnification direction from the mean line of this sampled portion and this sum is expressed in micrometer (μm) $$Rz_{JIS} = \frac{\lvert Zp1+Zp2+Zp3+Zp4+Zp5 \rvert + \lvert Zv1+Zv2+Zv3+Zv4+Zv5 \rvert}{5}$$	 where, $Z_{p1}, Z_{p2}, Z_{p3}, Z_{p4}, Z_{p5}$: altitudes of the heights of five highest profile peaks of the sampled portion corresponding to the reference length ℓ where, $Z_{v1}, Z_{v2}, Z_{v3}, Z_{v4}, Z_{v5}$: altitudes of the depths of five deepest profile valleys of the sampled portion corresponding to the reference length ℓ

Symbols of Metals

● Carbon steel and alloy steel for structural use

Type	Japan	International	Other countries				
			U.S.A.	Great Britain	Germany	France	Russia
	JIS	ISO	AISI SAE	BS BS/EN	DIN DIN/EN	NF NF/EN	ГОСТ
Carbon steel	S10C	C10	1010	C10 C10E C10R	C10E C10R	C10E C10R	–
	S15C	C15E4 C15M2	1015	C15 C15E C15R	C15E C15R	C15E C15R	–
	S20C	–	1020	C22, C22E C22R	C22 C22E C22R	C22 C22E C22R	–
	S25C	C25 C25E4 C25M2	1025	C25 C25E C25R	C25 C25E C25R	C25 C25E C25R	–
	S30C	C30 C30E4 C30M2	1030	C30 C30E C30R	C30 C30E C30R	C30 C30E C30R	30Г
	S35C	C35 C35E4 C35M2	1035	C35 C35E C35R	C35 C35E C35R	C35 C35E C35R	35Г
	S40C	C40 C40E4 C40M2	1039 1040	C40 C40E C40R	C40 C40E C40R	C40 C40E C40R	40Г
	S43C	–	1042 1043	080A42	–	–	40Г
	S45C	C45 C45E4 C45M2	1045 1046	C45 C45E C45R	C45 C45E C45R	C45 C45E C45R	45Г
	S48C	–	–	–	–	–	45Г
	S50C	C50 C50E4 C50M2	1049	C50 C50E C50R	C50 C50E C50R	C50 C50E C50R	50Г
	S53C	–	1050 1053	–	–	–	50Г
	S55C	C55 C55E4 C55M2	1055	C55 C55E C55R	C55 C55E C55R	C55 C55E C55R	–
	S58C	C60 C60E4 C60M2	1059 1060	C60 C60E C60R	C60 C60E C60R	C60 C60E C60R	60Г

Type		Japan	International	Other countries				
				U.S.A.	Great Britain	Germany	France	Russia
		JIS	ISO	AISI SAE	BS BS/EN	DIN DIN/EN	NF NF/EN	ГОСТ
Alloy steel	Nickel chromium steel	SNC236	–	–	–	–	–	40XH
		SNC415(H)	–	–	–	–	–	–
		SNC631(H)	–	–	–	–	–	30XH3A
		SNC815(H)	15NiCr13	–	15NiCr13	15NiCr13	15NiCr13	–
		SNC836	–	–	–	–	–	–
	Nickel chromium molybdenum steel	SNCM220	20NiCrMo2 20NiCrMoS2	8615 8617(H) 8620(H) 8622(H)	20NiCrMo2-2 20NiCrMoS2-2	20NiCrMo2-2 20NiCrMoS2-2	20NiCrMo2-2 20NiCrMoS2-2	–
		SNCM240	41CrNiMo2 41CrNiMoS2	8637 8640	–	–	–	–
		SNCM415	–	–	–	–	–	–
		SNCM420(H)	–	4320(H)	–	–	–	20XH2M(20XHM)
		SNCM431	–	–	–	–	–	–
		SNCM439	–	4340	–	–	–	–
		SNCM447	–	–	–	–	–	–
		SNCM616	–	–	–	–	–	–
		SNCM625	–	–	–	–	–	–
		SNCM630	–	–	–	–	–	–
		SNCM815	–	–	–	–	–	–

Note: The above chart is based on published data and not authorized by each manufacturer.

Symbols of Metals

● Alloy steel

Type		Japan	International	Other countries				
				U.S.A.	Great Britain	Germany	France	Russia
		JIS	ISO	AISI SAE	BS BS/EN	DIN DIN/EN	NF NF/EN	ГОСТ
Alloy steel	Chromium steel	SCr415(H)	–	–	17Cr3 17CrS3	17Cr3 17CrS3	17Cr3 17CrS3	15X 15XA
		SCr420(H)	20Cr4(H) 20CrS4	5120(H)	–	–	–	20X
		SCr430(H)	34Cr4 34CrS4	5130(H) 5132(H)	34Cr4 34CrS4	34Cr4 34CrS4	34Cr4 34CrS4	30X
		SCr435(H)	34Cr4 34CrS4 37Cr4 37CrS4	5132	37Cr4 37CrS4	37Cr4 37CrS4	37Cr4 37CrS4	35X
		SCr440(H)	37Cr4 37CrS4 41Cr4 41CrS4	5140(H)	530M40 41Cr4 41CrS4	41Cr4 41CrS4	41Cr4 41CrS4	40X
		SCr445(H)	–	–	–	–	–	45X
	Chromium molybdenum steel	SCM415(H)	–	–	–	–	–	–
		SCM418(H)	18CrMo4 18CrMoS4	–	18CrMo4 18CrMoS4	18CrMo4 18CrMoS4	18CrMo4 18CrMoS4	20XM
		SCM420(H)	–	–	708M20(708H20)	–	–	20XM
		SCM430	–	4130	–	–	–	30XM 30XMA
		SCM432	–	–	–	–	–	–
		SCM435(H)	34CrMo4 34CrMoS4	4137(H)	34CrMo4 34CrMoS4	34CrMo4 34CrMoS4	34CrMo4 34CrMoS4	35XM
		SCM440(H)	42CrMo4 42CrMoS4	4140(H) 4142(H)	42CrMo4 42CrMoS4	42CrMo4 42CrMoS4	42CrMo4 42CrMoS4	–
		SCM445(H)	–	4145(H) 4147(H)	–	–	–	–
	Manganese steel and manganese chromium steel	SMn420(H)	22Mn6(H)	1522(H)		–	–	–
		SMn433(H)	–	1534	–	–	–	30Г2 35Г2
		SMn438(H)	36Mn6(H)	1541(H)	–	–	–	35Г2 40Г2
		SMn443(H)	42Mn6(H)	1541(H)	–	–	–	40Г2 45Г2
		SMnC420(H)	–	–	–	–	–	–
		SMnC443(H)	–	–	–	–	–	–
	Aluminium chromium molybdenum steel	SACM645	41CrAlMo74	–	–	–	–	–

● Stainless steel

Type		Japan	International	Other countries					
				U.S.A.		Great Britain	Germany	France	Russia
		JIS	ISO	UNS	AISI SAE	BS BS/EN	DIN DIN/EN	NF NF/EN	ГОСТ
Stainless steel	Austenitic	SUS201	X12CrMnNiN17-7-5	S20100	201			Z12CMN17-07Az	
		SUS202	X12CrMnNiN18-9-5	S20200	202	284S16			12X17Г9AH4
		SUS301	X10CrNi18-8	S30100	301	301S21	X12CrNi17-7	Z11CN17-08	07X16H6
		SUS301L	X2CrNiN18-7				X2CrNiN18-7		
		SUS301J1					X12CrNi17-7		
		SUS302		S30200	302	302S25		Z12CN18-09	12X18H9
		SUS302B	X12CrNiSi18-9-3	S30215	302B				
		SUS303	X10CrNiS18-9	S30300	303	303S21	X10CrNiS18-9	Z8CNF18-09	
		SUS303Se		S30323	303Se	303S41			12X18H10E
		SUS303Cu							
		SUS304	X5CrNi18-9	S30400	304	304S31	X5CrNi18-10	Z7CN18-09	08X18H10
		SUS304L	X2CrNi18-9	S30403	304L	304S11	X2CrNi19-11	Z3CN19-11	03X18H11
		SUS304N1	X5CrNiN18-8	S30451	304N			Z6CN19-09Az	
		SUS304N2		S30452					
		SUS304LN	X2CrNiN18-9	S30453	304LN		X2CrNiN18-10	Z3CN18-10Az	
		SUS304J1							
		SUS304J2							
		SUS304J3		S30431	S30431				
		SUS305	X6CrNi18-12	S30500	305	305S19	X5CrNi18-12	Z8CN18-12	06X18H11

Note: The above chart is based on published data and not authorized by each manufacturer.

Stainless steel

Type		Japan JIS	International ISO	U.S.A. UNS	U.S.A. AISI SAE	Great Britain BS BS/EN	Germany DIN DIN/EN	France NF NF/EN	Russia ГОСТ
Stainless steel	Austenitic	SUS305J1							
		SUS309S		S30908	309S			Z10CN24-13	
		SUS310S	X6CrNi25-21	S31008	310S	310S31		Z8CN25-20	10X23H18
		SUS315J1							
		SUS315J2							
		SUS316	X5CrNiMo17-12-2 X3CrNiMo17-12-3	S31600	316	316S31	X5CrNiMo17-12-2 X5CrNiMo17-13-3	Z7CND17-12-02 Z6CND18-12-03	
		SUS316F							
		SUS316L	X2CrNiMo17-12-2 X2CrNiMo17-12-3 X2CrNiMo18-14-3	S31603	316L	316S11	X2CrNiMo17-13-2 X2CrNiMo17-14-3	Z3CND17-12-02 Z3CND17-12-03	03X17H14M3
		SUS316N		S31651	316N				
		SUS316LN	X2CrNiMoN17-11-2 X2CrNiMoN17-12-3	S31653	316LN		X2CrNiMoN17-12-2 X2CrNiMoN17-13-3	Z3CND17-11Az Z3CND17-12Az	
		SUS316Ti	X6CrNiMoTi17-12-2	S31635			X6CrNiMoTi17-12-2	Z6CNDT17-12	08X17H13M2T
		SUS316J1							
		SUS316J1L							
		SUS317		S31700	317	317S16			
		SUS317L	X2CrNiMo19-14-4	S31703	317L	317S12	X2CrNiMo18-16-4	Z3CND19-15-04	
		SUS317LN	X2CrNiMoN18-12-4	S31753				Z3CND19-14Az	
		SUS317J1							
		SUS317J2							
		SUS317J3L							
		SUS836L		N08367					
		SUS890L	X1CrNiMoCu25-20-5	N08904	N08904	904S14		Z2NCDU25-20	
		SUS321	X6CrNiTi18-10	S32100	321	321S31	X6CrNiTi18-10	Z6CNT18-10	08X18H10T
		SUS347	X6CrNiNb18-10	S34700	347	347S31	X6CrNiNb18-10	Z6CNNb18-10	08X18H12Б
		SUS384	X3NiCr18-16	S38400	384			Z6CN18-16	
		SUSXM7	X3CrNiCu18-9-4	S30430	304Cu	394S17		Z2CNU18-10	
		SUSXM15J1		S38100				Z15CNS20-12	
	Austenitic Ferritic	SUS329J1		S32900	329				
		SUS329J3L	X2CrNiMoN22-5-3	S31803	31803			Z3CNDU22-05Az	08X21H6M2T
		SUS329J4L	X2CrNiMoCuN25-6-3	S32250	32250			Z3CNDU25-07Az	
	Ferritic	SUS405	X6CrAl13	S40500	405	405S17	X6CrAl13	Z8CA12	
		SUS410L						Z3C14	
		SUS429		S42900	429				
		SUS430	X6Cr17	S43000	430	430S17	X6Cr17	Z8C17	12X17
		SUS430F	X7CrS17	S43020	430F		X7CrS18	Z8CF17	
		SUS430LX	X3CrTi17 X3CrNb17	S43035			X6CrTi17	Z4CT17	
		SUS430J1L	X2CrTi17				X6CrNb17	Z4CNb17	
		SUS434	X6CrMo17-1	S43400	434	434S17	X6CrMo17-1	Z8CD17-01	
		SUS436L	X1CrMoTi16-1	S43600	436				
		SUS436J1L							
		SUS444	X2CrMoTi18-2	S44400	444			Z3CDT18-02	
		SUS445J1							
		SUS445J2							
		SUS447J1		S44700					
		SUSXM27		S44627				Z1CD26-01	
	Martensitic	SUS403		S40300	403				
		SUS410	X12Cr13	S41000	410	410S21	X10Cr13	Z13C13	
		SUS410S	X6Cr13	S41008	410S	403S17	X6Cr13	Z8C12	08X13
		SUS410F2							
		SUS410J1		S41025					
		SUS416	X12CrS13	S41600	416	416S21		Z11CF13	
		SUS420J1	X20Cr13	S42000	420	420S29	X20Cr13	Z20C13	20X13
		SUS420J2	X30Cr13	S42000	420	420S37	X30Cr13	Z33C13	30X13
		SUS420F	X29CrS13	S42020	420F			Z30CF13	
		SUS420F2							
		SUS429J1							
		SUS431	X19CrNi16-2	S43100	431	431S29	X20CrNi17-2	Z15CN16-02	20X17H2
		SUS440A	X70CrMo15	S44002	440A			Z70C15	
		SUS440B		S44003	440B				
		SUS440C	X105CrMo17	S44004	440C			Z100CD17	95X18
		SUS440F		S44020	S44020				
	Precipitation hardening type	SUS630	X5CrNiCuNb16-4	S17400	S17400			Z6CNU17-04	
		SUS631	X7CrNiAl17-7	S17700	S17700		X7CrNiAl17-7	Z9CNA17-07	09X17H7Ю
		SUS631J1							

Note: The above chart is based on published data and not authorized by each manufacturer.

Symbols of Metals

Heat resistant steel

Type		Japan JIS	International ISO	U.S.A. UNS	U.S.A. AISI SAE	Great Britain BS BS/EN	Germany DIN DIN/EN	France NF NF/EN	Russia ГОСТ
Heat resistant steel	Austenitic	SUH31				331S42		Z35CNWS14-14	45X14H14B2M
		SUH35		S63008		349S52		Z52CMN21-09Az	
		SUH36				349S54	X53CrMnNi21-9	Z55CMN21-09Az	55X20Г9 AH4
		SUH37		S63017		381S34			
		SUH38							
		SUH309		S30900	309	309S24		Z15CN24-13	
		SUH310		S31000	310	310S24	CrNi2520	Z15CN25-20	20X25H20C2
		SUH330		N08330	N08330			Z12NCS35-16	
		SUH660		S66286				Z6NCTV25-20	
		SUH661		R30155					
	Ferritic	SUH21					CrAl1205		
		SUH409	X6CrTi12	S40900	409	409S19	X6CrTi12	Z6CT12	
		SUH409L	X2CrTi12					Z3CT12	
		SUH446		S44600	446			Z12C25	15X28
	Martensitic	SUH1		S65007		401S45	X45CrSi9-3	Z45CS9	
		SUH3						Z40CSD10	40X10C2M
		SUH4				443S65		Z80CSN20-02	
		SUH11							40X9C2
		SUH600							20X12BHMБФР
		SUH616		S42200					

(Other countries: U.S.A., Great Britain, Germany, France, Russia)

Tool steel

Type	Japan JIS	International ISO	U.S.A. AISI ASTM
Carbon tool steel	SK140	–	–
	SK120	C120U	W1-11 1/2
	SK105	C105U	W1-10
	SK95	–	W1-9
	SK90	C90U	–
	SK85	–	W1-8
	SK80	C80U	–
	SK75	–	–
	SK70	C70U	–
	SK65	–	–
	SK60	–	–
High speed steel	SKH2	HS18-0-1	T1
	SKH3	–	T4
	SKH4	–	T5
	SKH10	–	T15
	SKH40	HS6-5-3-8	–
	SKH50	HS1-8-1	–
	SKH51	HS6-5-2	M2
	SKH52	HS6-6-2	M3-1
	SKH53	HS6-5-3	M3-2
	SKH54	HS6-5-4	M4
	SKH55	HS6-5-2-5	–
	SKH56	–	M36
	SKH57	HS10-4-3-10	–
	SKH58	HS2-9-2	M7
	SKH59	HS2-9-1-8	M42
Alloy tool steel	SKS11	–	F2
	SKS2	–	–
	SKS21	–	–

Type	Japan JIS	International ISO	U.S.A. AISI ASTM
Alloy tool steel	SKS5	–	–
	SKS51	–	L6
	SKS7	–	–
	SKS81	–	–
	SKS8	–	–
	SKS4	–	–
	SKS41	–	–
	SKS43	105V	W2-9 1/2
	SKS44	–	W2-8 1/2
	SKS3	–	–
	SKS31	–	–
	SKS93	–	–
	SKS94	–	–
	SKS95	–	–
	SKD1	X210Cr12	D3
	SKD2	X210CrW12	–
	SKD10	X153CrMoV12	–
	SKD11	–	D2
	SKD12	X100CrMoV5	A2
	SKD4	–	–
	SKD5	X30WCrV9-3	H21
	SKD6	–	H11
	SKD61	X40CrMoV5-1	H13
	SKD62	X35CrWMoV5	H12
	SKD7	32CrMoV12-28	H10
	SKD8	38CrCoWV18-17-17	H19
	SKT3	–	–
	SKT4	55NiCrMoV7	–
	SKT6	45NiCrMo16	–

Special use steel

Type	Japan JIS	International ISO	U.S.A. AISI ASTM
Free cutting carbon steels	SUM11	–	1110
	SUM12	–	1109
	SUM21	9S20	1212
	SUM22	11SMn28	1213
	SUM22L	11SMnPb28	–
	SUM23	–	1215
	SUM23L	–	–
	SUM24L	11SMnPb28	12L14
	SUM25	12SMn35	–
	SUM31	–	1117
	SUM31L	–	–

Type	Japan JIS	International ISO	U.S.A. AISI ASTM
Free cutting carbon steels	SUM32	–	–
	SUM41	–	1137
	SUM42	–	1141
	SUM43	44SMn28	1144
High carbon chromium	SUJ1	–	–
	SUJ2	B1	52100
	SUJ3	B2	ASTM A 485 Grade 1
	SUJ4	–	–
	SUJ5	–	–

Note: The above chart is based on published data and not authorized by each manufacturer.

Casting or forging steel

	Type	Japan JIS	International ISO	Other countries: U.S.A. AISI ASTM	Great Britain BS BS/EN	Germany DIN DIN/EN	France NF NF/EN	Russia ГОСТ
Casting steel	Carbon steel casting	SC	200-400, 230-450, 270-480	U-	A1, A2	GS-	GE230, GE280, GE320	–
Casting steel	Steel casting for welded structure	SCW	200-400W, 230-450W, 270-480W, 340-550W	WCA, WCB, WCC	A4	–	GE230, GE280	–
Casting steel	Heat resisting steel casting	SCH	GX40CrSi24, GX40CrNiSi22-10, GX40NiCrSi38-19	Grade HC, HD, HF	309C30, 310C45, 330C12	–	GX40NiCrNb45-35, GX50NiCrCoW35-25-15-5	–
Casting steel	Steel casting for high temperature and high pressure service	SCPH	–	Grade WC1, WC6, WC9	A1, A2, B1, B2, B3, B4, B5, B7	G20Mo5, G17CrMo5-5, G17CrMo5-10	G17CrMo9-10, GX15CrMo5, GP240GH, GP280GH	–
Casting steel	Steel casting for low temperature and high pressure service	SCPL	–	Grade LCB, LC1, LC2, LC3	AL1, BL2	–	FB-M, FC1-M, FC2-M,FC3-M	–
Casting iron	Grey iron casting	FC	100,150,200,250, 300,350	No.20,25,30,35, 40,45,50	EN-GJL-	EN-GJL-	EN-GJL-	–
Casting iron	Spheroidal graphite iron casting	FCD	700-2, 600-3, 500-7, 450-10, 400-15, 400-18, 350-22	60-40-18, 65-45-12, 8-55-06, 100-70-03, 120-90-02	EN-GJS-	EN-GJS-	EN-GJS-	ВЧ
Casting iron	Austempered spheroidal graphite iron casting	FCAD	–	–	EN-GJS-	EN-GJS-	EN-GJS-	–
Casting iron	Austenitic iron casting	FCA- FCDA-	L-, S-	Type 1, 2, Type D-2, D-3A Class 1, 2	F1, F2, S2W, S5S	GGL-, GGG-	L-, S-	–
Forging steel	Carbon steel forging for general use	SF	–	Class A, B, C, D, E, F	C22, C25, C30, C35, C40, C45, C50, C55, C60	P285, P355	P245, P280, P305	–
Forging steel	Chromium molybdenum steel forgings for general use	SFCM	–	Class E, F, G, I Grade 3A, 4 Class G, J, K, L, M	–	–	–	–
Forging steel	Nickel Chromium molybdenum steel forgings for general use	SFNCM	–	Class G, H, I, J Class 3A, 4, 5, 6 Class K, L, M	–	–	–	–

Non-ferrous alloy

	Type	Japan JIS	International ISO	Other countries: U.S.A. ASTM SAE		Great Britain BS BS/EN	Germany DIN DIN/EN
Copper alloy, Nickel alloy	Copper alloy casting	CAC101	–	–	–	–	
		CAC102	–	–	–	Cu-C(CC040AgrodeC)	
		CAC103	–	–	–	Cu-C(CC040AgrodeA,B)	
	Brass casting	CAC201	–	–	–	CuZn15As-C(CC760S)	
		CAC202	–	C85400	–	CuZn33Pb2-C(CC750S)	
		CAC203	–	C85700	–	CuZn39Pb1-C(CC754S)	
	High strength brass casting	CAC301	–	C86500	–	CuZn35Mn2Al1Fe-C(CC765S)	
		CAC302	–	C86400	–	CuZn34Mn3Al2Fe1-C(CC764S)	
		CAC303	–	C86200	–	CuZn25Al5Mn4Fe3-C(CC762S)	
		CAC304	–	C86300	–	CuZn25Al5Mn4Fe3-C(CC762S)	
	Bronze casting	CAC401	–	C84400	–	CuSn3Zn8Pb5-C(CC490K)	
		CAC402	–	C90300	–	–	
		CAC403	–	C90500	–	–	
		CAC406	–	C83600	–	CuSn5Zn5Pb5-C(CC490K)	
		CAC407	–	C92200	–	–	
	Phosphor bronze casting	CAC502A	–	C90700 C90800	–	CuSn10-C(CC480K) CuSn12-C(CC483K)	
		CAC502B	–		–		
		CAC503A	–		–		
		CAC503B	–		–		
	Aluminium bronze casting	CAC701	–	C95200	–	CuAl10Fe2-C(CC331G)	
		CAC702	–	C95400	–	CuAl10Ni3Fe2-C(CC332G)	
			–	C95410	–		
		CAC703	–	C95800	–	CuAl10Fe5Ni5-C(CC333G)	
		CAC704	–	C95700	–	–	
	Silicon bronze castings	CAC801	–	–	–	–	
		CAC802	–	C87500	–	–	
		CAC803	–	C87400	–	CuZn16Si4-C(CC761S)	

Note: The above chart is based on published data and not authorized by each manufacturer.

Symbols of Metals

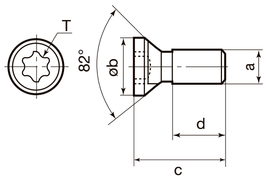
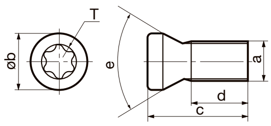
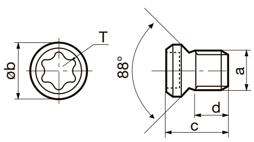
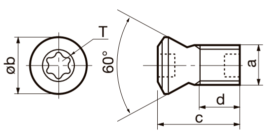
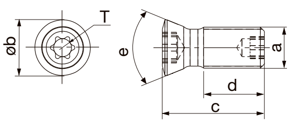
● Non-ferrous alloy

Type		Japan JIS	International ISO	Other countries: U.S.A. ASTM SAE	Other countries: Great Britain BS BS/EN	Other countries: Germany DIN DIN/EN	Other countries: France NF NF/EN
Aluminium alloy	Aluminium alloy ingots for casting	AC1B	Al-Cu4MgTi	204.0	EN AC-2100		
		AC2A	–	–	–		
		AC2B	–	319.0	–		
		AC3A	–	–	EN AC-44100		
		AC4A	–	–	–		
		AC4B	Al-Si8Cu3	333.0	EN AC-46200		
		AC4C	Al-Si7Mg(Fe)	356.0	EN AC-42000		
		AC4CH	Al-Si7Mg0.3	A356.0	EN AC-42100		
		AC4D	–	355.0	EN AC-45300		
		AC5A	Al-Cu4Ni2Mg2	242.0	–		
		AC7A	–	514.0	–		
		AC8A	Al-Si12CuNiMg	–	EN AC-48000		
		AC8B	–	–	–		
		AC8C	–	332.0	–		
		AC9A	–	–	–		
		AC9B	–	–	–		
	Aluminium alloy die casting	ADC1	–	A413.0	–		
		ADC3	–	A360.0	–		
		ADC5	–	518.0	–		
		ADC6	–	–	–		
		ADC10	–	–	–		
		ADC10Z	–	A380.0	–		
		ADC12	–	–	–		
		ADC12Z	–	383.0	–		
		ADC14	–	B390.0	–		
Magnesium alloy	Magnesium alloy casting	MC5	–	AM100A	–		
		MC6	–	ZK51A	–		
		MC7	–	ZK61A	–		
		MC8	MgRE3Zn2Zr	EZ33A	EN MC65120		
		MC9	MgAg3RE2Zr	QE22A	EN MC65210		
		MC10	MgZn4RE1Zr	ZE41A	EN MC35110		
	Magnesium alloy die casting	MD1A	–	AZ91A	G-A9Z1Y4		
		MDC1B	–	AZ91B	–		
		MDC1D	MgAl9Zn1(A)	AZ91D	EN MC21120		
		MDC2B	MgAl6Mn	AM60B	EN MC21320		

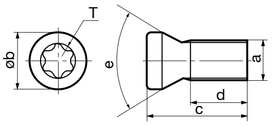
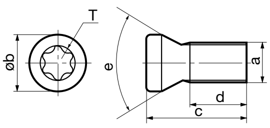
Type		Japan JIS	International ISO	Other countries: U.S.A. ASTM AA	Other countries: Great Britain BS BS/EN	Other countries: Germany DIN DIN/EN	Other countries: France NF NF/EN
Aluminium alloy	Aluminium alloy extruded shapes	A5052S	–	5052	EN AW-5052		
		A5454S	–	5454	EN AW-5454		
		A5083S	AlMg4.5Mn0.7	5083	EN AW-5083		
		A5086S	–	5086	EN AW-5086		
		A6061S	AlMg1SiCu	6061	EN AW-6061		
		A6063S	AlMg0.7Si	6063	EN AW-6063		
		A7003S	–	–	EN AW-7003		
		A7N01S	–	–	–		
		A7075S	AlZn5.5MgCu	7075	EN AW-7075		

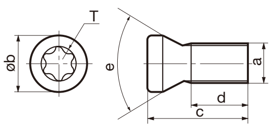
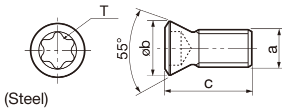
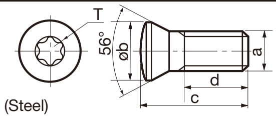
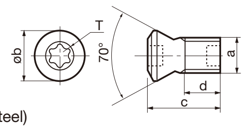
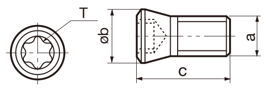
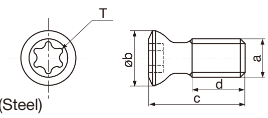
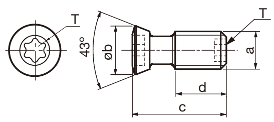
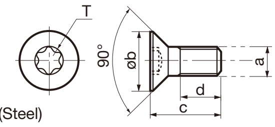
Note: The above chart is based on published data and not authorized by each manufacturer.

Screws

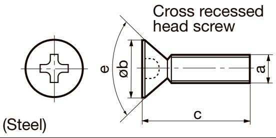
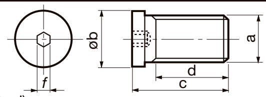
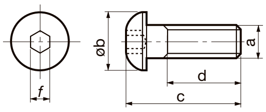
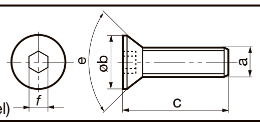
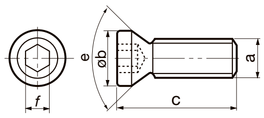
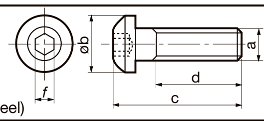
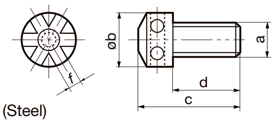
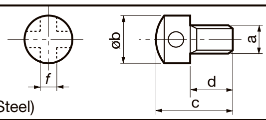
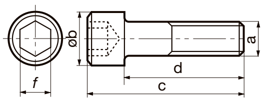
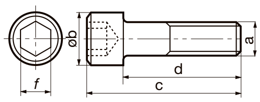
Shape	Designation	Dimension (mm)						Torque (N·m)
		a	øb	c	d	e	T / f	
	CSTA-NO2	#2-56UNC	4	6	4	82°	T8	1.3
	CSTA-NO2S			5	3			
	CSTA-NO2L			8	6			
	CSTA-NO3	#3-48UNC	4.3	7	4		T9	2.3
	CSTA-NO5	#5-40UNC	5	8	5			
	CSTA-1.6	M1.6x0.35	2.5	3.1	0.9	80°	T6	0.6
	CSTA-4	M4x0.7	7	10	7.7	82°	T15	3.5
	CSTA-5	M5x0.8	7.2	15	11			
	CSTA-5S			12	8			
	CSTA-5SS			9.5	5.5			
	CSTA-5ST25			12	8		T25	5
	CSPA-5IP15		7.1	15	11		15IP	3.5
	CSPA-5SIP15			12	8			
	CSPA-5IP20			15	11		20IP	5
(Steel)	CSPA-5SIP20			12	8			
	CSP-2L033	M2x0.4	2.6	3.3	1.9	88°	6IP	0.7
	CSTB-2		2.7	3.3	1.4	60°	T6	0.7
	CSTB-2L			5.2	3.3			
	CSTB-2L040			4	2.1			
	CSTB-2.2	M2.2x0.45	3.5	6.1	3.5		T7	1
	CSTB-2.2L038			3.8	2.2			
	CSTB-2.2S			4.6	2			
	CSTB-2.2L053DR		3	5.3	3.2			
	CSTB-2.2L053DL		3	5.3	3.2			
	CSTB-2.2R		3.1	6.1	3.7			
	CSTB-2.5	M2.5x0.45	3.5	6	3.4		T8	1.3
	CSTB-2.5L046		3.25	4.6	2.6		T7	0.9
	CSTB-2.5L080		3.5	8	5.4		T8	1.3
	CSTB-2.5B			5.5	2.6			
	CSTB-2.5L054DR			5.4	2.9		T7	
CSP-2L033 type shown	CSTB-2.5L054DL							
	CSTB-2.5S			4.8	2.2		T8	
	CSTB-3	M3x0.5	4.1	8	4.5		T9	2.3
	CSTB-3L042			4.2	0.7			
	CSTB-3L050			5	2			
	CSTB-3L081		4.2	8.1	4.7		T8	1.3
	CSTB-3S		4.1	6	2.5		T9	2.3
	CSTB-3.5ST	M3.5x0.6	5.3	12.5	4		T15	3.5
	CSTB-3.5H		5.2	6.5	3.1			
CSTB-4SD type shown	CSTB-3.5		5.5	8.4	4.3			
	CSTB-3.5T		6.5	10	5.5		T20	5
	CSTB-3.5TS			8.5	4			
	CSTB-3.5D		4.7	8.4	4.9		T9	2.3
	CSTB-3.5L110		5.5	11	7.5		T15	3.5
	CSTB-3.5L115		4.8	11.5	7		T10	2.5
	CSTB-3.5L115-S		4.8	11.5	6.5			3.5
	CSTB-3.5L		5.3	12.5	8.4		T15	3.5
CSTC-4L type shown	CSTB-4	M4x0.7	5.5	11.4	7.4			
	CSTB-4L060			6	2			
	CSTB-4L085			8.48	3.48			
	CSTB-4L090		5.7	9	5.5			
	CSTB-4L115-S		5.5	11.5	6.5			5.5
	CSTB-4S		5.5	8	4			3.5
	CSTB-4ST	M4x0.5	6.4	14.7				
	CSTB-4SD	M4x0.7	5.5	8			T8	1.3
	CSTB-4M			9.5	5.5		T15	3.5
	CSTB-4F	M4x0.5	7	14.7	8.7			
	CSTB-4TS	M4x0.7	6.5	9	4.5		T20	5
	CSTB-5	M5x0.8	7	12	7.5			
	CSTB-5S			9.5	5			
(Steel)	CSTB-5L105			10.5	6.1			

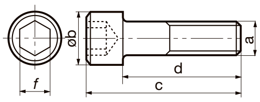
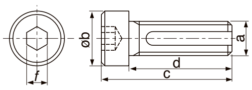
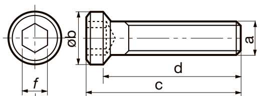
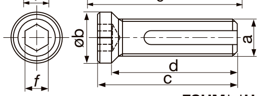
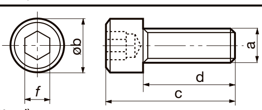
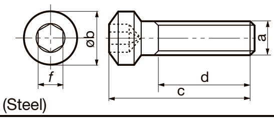
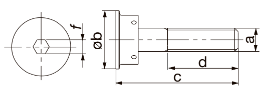
Screws

Shape	Designation	Dimension (mm)						Torque (N·m)
		a	øb	c	d	e	T / *f*	
 (Steel)	CSTB-5L120			12	6.5			
	CSTB-5L159		7.2	15.9	11.2			
	CSTB-5L163-S		6.9	16.3	11.3			6
	CSTC-4L055DR	M4x0.5	5.42	5.5	2	44°	T8/T10	1.3/2.5
	CSTC-4L055DL	M4x0.5	5.42	5.5	2		T8/T10	1.3/2.5
	CSTC-4L100DR	M4x0.7	5.42	10	5.95		T8/T10	1.3/2.5
	CSTC-4L100DL	M4x0.7	5.42	10	5.95		T8/T10	1.3/2.5
	CSPB-1.8L3.3	M1.8x0.35	2.4	3.3	1	60°	6IP	0.5
	CSPB-1.8L3.6			3.6	1.3			
	CSPB-1.8FL3.6	M1.8x0.2		3.6	1.6			
	CSPB-1.8FL4.3			4.3	2.3			
	CSPB-2L043	M2x0.4	2.7	4.3	2.5		6IP	0.7
	CSPB-2H		2.6	3.4	1.6			
	CSPB-2.2	M2.2x0.45	3	6	3.9		7IP	1
	CSPB-2.2SH			4	2			1.1
	CSPB-2.5	M2.5x0.45	3.5	6	3.5		8IP	1.3
	CSPB-2.5S			4.2	1.7			
	CSPB-2.5SH		3.3	5.2	3.3		7IP	1.1
	CSPB-3.5	M3.5x0.6	5.2	9	5.6		15IP	3.5
 (Steel)	CSPB-3.5S	M3.5x0.6	5.2	6.5	3.1	60°	15IP	3.5
	CSPB-4	M4x0.7	5.5	11.6	7.4			
	CSPB-4S			8.2	4			
	CSPB-5	M5x0.8	7	12	7.5		20IP	5
	VX040024A	M4	5.45	9	6		T15	4.5
	VX040028A	M4	5.2	9.7	4.7	44°	T15	4.5
	SR M2.5X0.45-L6 IP7	M2.5x0.45	3.4	6	3.45	60°	7IP	1.2
	SR10503833L040	M2.5x0.45	3.25	4	2		T7	1.3
	SR14-500-L5.1	M4	5.5	5.1	2.3		T15	3.5
	SR 14-500-L7.0	M4	5.5	7	4.2		T15	3.5
	SR14-506	M4x0.7	5.7	8	4.7		T15	4.8
	SR14-554/S	M4x0.7	5.7	9.3	5		T15	4.5
	SR 14-560	M2.2x0.45	3.5	6.4	3.8	50°	T8	1.2
	SR 14-560/S	M2.5x0.45	3.5	5.35	2.75		T8	1.2
	SR 14-562	M3.5	4.8	8.75	5.55	60°	T10	3.2
	SR 14-562/S	M3.5	4.8	6.5	3.3		T10	3.2
	SR 14-571/S	M3.5x0.6	5.1	7.5	4		T10	3.2
	SR14-591	M5x0.8	6.6	13.5	7.6		T20	5
	SR 34-508	M2.2x0.45	3.15	4.6	2.67		T7	0.9
	SR 34-514	M2.5x0.45	3.3	5.2	3.2		T7	0.9
	SR 76-943	M6	9.6	20	10	90°	T20	5
	SR 76-961	M5	6.6	13.5	7.35	61°	T15	3.5
	SR 76-963	M5	8.6	20	9.6	91°	T15	3.5
	SR 10503833-S	M2.5X0.45	3.25	3.8	1.75	60°	T7	0.9
	SR 114-018-L3.40	M2.5	3.6	3.35	2	56°	T6	0.7
	SM35-114-H0	M3.5x0.6	5.6	11.4	5.1	60°	T15	3.5
	SM40-143-H0	M4X0.7	5.6	14.3	8.4	61°	T15	3.5
	TS25F080A	M2.25X0.35	3.7	6.9	2.1	60°	T8	1.3
	TS25064I	M2.5X0.45	3.5	6.4	3.8	50°	T8	1.3
	TS30F100A	M3X0.35	4.6	8.3	2.2	60°	T10	2.5
	TS30085I/HG	M3X0.5	4.3	8.5	5.6		T9	2.3
	TS30100I/HG-P	M3x0.5	4.3	7	4.1		9IP	2
	TS30C72I	M3X0.5	4.2	7.2	4.5		T9	2.3
	TS40085I/HG	M4	5.7	8.5	4.5		T15	3.5
	TS35085I/HG	M3.5X0.6	5.3	8.5	4.3		T15	3.5
	TS40093I/HG	M4	5.7	9.3	4.3		T15	3.5
	TS40B100I	M4	6	10	6	R3.0	T15	3.5
	TS40F120A	M4X0.5	6	10.6	3	60°	T15	3.5
	TS45120I	M4.5	6.9	12	7.5	R3.5	T20	5
	TS50115I	M5	7	11.35	6.4	60°	T20	5
	TS50230D3	M5X0.8	7	23	13.5		T20	-
	TS50250D35	M5X0.8	7.5	25	14.5		T25	-
	TS50F160A	M5X0.5	7	13.9	3.5		T20	5

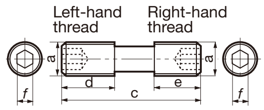
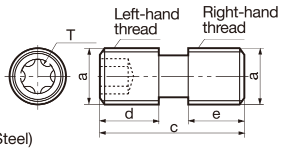
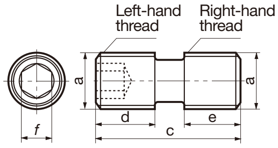
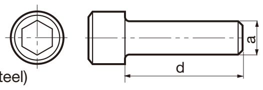
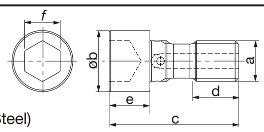
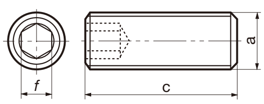
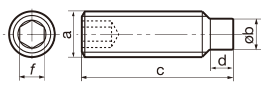
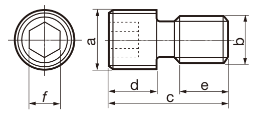
Shape	Designation	Dimension (mm)						Torque (N·m)
		a	øb	c	d	e	T / f	
 (Steel)	TS60265D4	M6X1.0	8	26.5	15.5	60°	T25	-
	TS60285D42	M6X1.0	8.5	28.5	16.7		T25	-
	TS60320D5	M6X1.0	9.5	31	18		T25	-
	TS60F200A	M6X0.75	8.2	16.7	4.5		T20	7
	TS70F250A	M7X0.75	10	21	5.6		T25	7
	TS80340D6	M8X1.25	10	34	20		T25	-
	TS80F300A	M8X1.0	12	25	7.3		T30	10
 (Steel)	CSPD-1.8S	M1.8x0.35	2.4	3.3	1.4		6IP	0.7
	CSTD-3T	M3x0.5	4.3	7	4.5		T10	2.5
	CSPD-3				4.2		10IP	2.5
 (Steel)	CSTB-4.5L110P	M4.5X0.75	6.6	11.7	7		T15	3.5
 (Steel)	SRM5X0.8IP20X+ACROLYTE	M5X0.8	9.2	15	9.8		20IP	7.5
 (Steel)	CSTC-2	M2x0.4	3.1	5.1	-		T6	0.7
 (Steel)	CSTR-4L100	M4x0.7	5.7	10	5.5		T15	3.5
 (Steel)	SR16-212-01397	M5x0.8	6.4	12.5	6.8		T20/T10	2.5
	SR16-212-01397L							
 (Steel)	CST-3.5	M3.5X0.6	6	4.8	-		T9	2.3
	CST-3.5S			3.5	-			
	CST-5	M5x0.8	10	18	13		T25	5
	CST-5S			12	7			
	CSTF-2L055-S	M2x0.4	2.7	5.5	3.8		T6	0.7

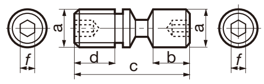
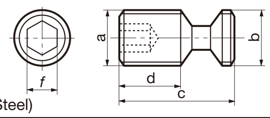
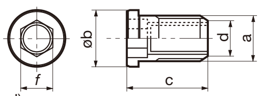
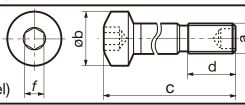
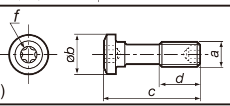
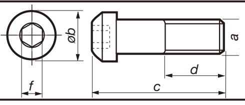
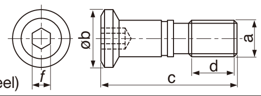
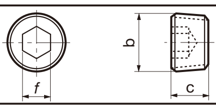
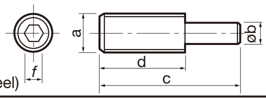
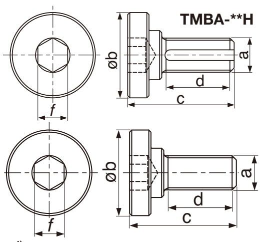
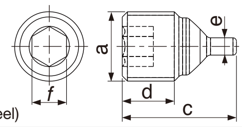
Screws

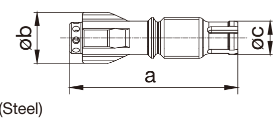
Shape	Designation	Dimension (mm) a	øb	c	d	T / *f*	e	Torque (N·m)
 (Steel)	**SM2.5×0.45×8**	M2.5x0.45	5	8	-	-	90°	-
	SM2.5×0.5×8	M2.5x0.5	5	8	-	-	90°	-
	SM3×0.5×6	M3x0.5	6	6	-	-	90°	-
	SM3×0.5×8			8	-	-	90°	-
	SM3×0.5×10			10	-	-	90°	-
 (Steel)	**MSP-5**	M5x0.8	6.1	7.9	4.9	2		1.5
	MSP-6.3	M6.3x1	7.7	12.7	9.9	2.5		3
 (Steel)	**BHM3-8**	M3x0.5	5.5	10	8	2		1.5
	BHM4-8	M4x0.7	7	10.6		2.5		2.2
	BHM4-10			12.6	10			
	BHM5-14	M5x0.8	9	17.6	14	3		3
	BHM6-20-A	M6x1.0	10.5	24	20	4		5
	BHM8-25U	M8	14	29.3	25	5		8.5
	BHM8-30U			34.3	30			
 (Steel)	**CSHM-3-8**	M3	6	8	-	2	90°	1.5
 (Steel)	**CSHB-4-A**	M4	5.5	11		T15	60°	2
	CSHB-6	M6	8.5	19	-	4	60°	5
	CSHB-6-A	M6	8.5	19				5
 (Steel)	**RT-1**	M6	10	22.5	14	4		5
	RT-2	M8	13	31	20	5		8.5
 (Steel)	**ASM6**	M6	10	18	12	3		-
	AJM5F	M5x0.5	9	13	8	2		-
	AJM5	M5x0.8	9	13	8	2		-
 (Steel)	**ASM34S**	M3	4.8	8	5	2		-
	ASM34L			11	8			-
	ASM54	M5x0.8	9	14	9	3		-
 (Steel)	**CHHM3.5-10**	M3.5x0.6	6	13.5	10	3		3
	CHHM4-10	M4x0.7	7	14				
	CHHM5-14	M5x0.8	8.5	19	14	4		5
	CHHM5-18			23	18			
	CHHM6-15	M6	10	21	15	5		8.5
	CHHM6-20			26	20			
	CHHM6-25			31	25			
 Hex. socket head screw (JISB1176) (Steel)	**CM3X0.5X6**	M3x0.5	5.5	9	6	2.5		2.2
	CM3X0.5X10			13	10			
	CM4X0.7X10	M4x0.7	7	14		3		3
	CM4X0.7X12			16	12			
	CM4X0.7X14			18	14			
	CM4X0.7X15			19	15			
	CM4X0.7X20			24	20			
	CM5X0.8X8	M5x0.8	8.5	13	8	4		5
	CM5X0.8X10-A			15	10			
	CM5X0.8X12			17	12			
	CM5X0.8X12-A			17	12			
	CM5X0.8X14			18	14			
	CM5X0.8X16			21	16			
	CM5X0.8X16-A			21	16			
	CM5X0.8X18			23	18			
	CM5X0.8X20-A			25	20			
	CM5X0.8X25-A			30	25			

Shape	Designation	Dimension (mm)							Torque (N·m)
		a	øb	c	d	e	*f*	g	
 Hex. socket head screw (JISB1176)  CM***H (Steel)	CM6X1X16-A	M6x1.0	10	22	16		5		8.5
	CM6X1X20-A			26	20				
	CM6X1X25-A			31	25				
	CM6X1.0X40-A			46	40				
	CM6X10	M6		16	10				
	CM6X16			22	16				
	CM6X20			26	20				
	CM6X25			31	25				
	CM6X30-S	M6x1.0	10	36	30				
	CM8X1.25X20-A	M8x1.25	13	28	20		6		25
	CM8X1.25X25-A			33	25				
	CM8X30H			36	30		5		
	CM10X30H	M10x1.5	16	38	30		6		40
	CM12X30H	M12x1.75	18	40			8		70
	CM16X40H	M16x2	24	54	40		10		100
	CM16x75	M16	24	91	75		14		100
	CM16x120	M16	24	136	120		14		100
	CM16x140	M16	24	156	140		14		100
	CM20x80	M20	30	100	80		17		150
	CM20x120	M20	30	140	120		17		150
	CM20x150	M20	30	170	150		17		150
	CAP-CM12x1.75x50	M12	18	62	50		10		70
	CAP-CM16X2.0X55	M16	24	71	55		14		40
	CAP-CM20X2.5X50	M20	30	70	50		17		100
	C0.375X1.125H	3/8-24UNF	14.27	38.11	28.58		5.55		35
	C0.500X1.375H	1/2-20UNF	19.05	47.63	34.93		7.94		70
	SD06-A3	M10x1.5	16	70	60		8		40
	SRM6X16DIN912-12.9	M6x1	10	22	16		5		
	VC00TEDI12040F	M12	26	51	40		8		60
	VC00TEDI20040F	M20	49	50	34.5		12		150
	VC00TANG16040F	M16	46	46.5	33		10		60
	SD08-98	M12x1.75	18	77	65		10		70
	LHM12x1.75x30-C	M12	18	36.9	30		8		70
	VC004762I10035F	M10	16	45	35		8		60
	FCS3	M3x0.5	5.5	16	12		2.5		
	FCS6	M6x1	10	26	20		5		
  (Steel) FSHM*-*H	FSHM8-30	M8x1.25	11	30	27		5		25
	FSHM8-30H								25
	FSHM10-40	M10	14	40	36.5		6		40
	FSHM10-40H								40
 (Steel)	SHCM4-10	M4x0.7	6	14	10		3		3
	SHCM4-12			16	12				
	SHCM4-16			20	16				
 (Steel)	CTS-M6	M6x1	10	25	19		4		5
 (Steel)	RSFTS-050M	M10	25	52	42.5		6		

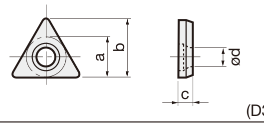
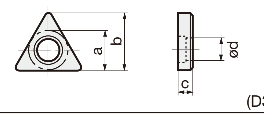
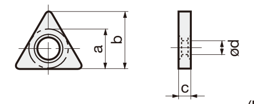
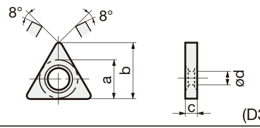
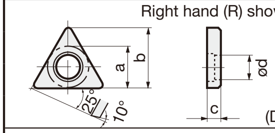
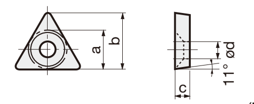
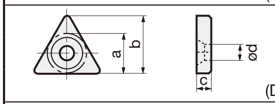
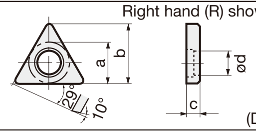
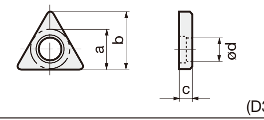
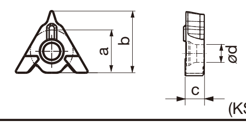
Screws

Shape	Designation	Dimension (mm)						Torque (N·m)
		a	øb	c	d	e	T / *f*	
 (Steel)	**MCS520-2.5**	M5×0.8		20	7	6	2.5	3
	MCS620-3	M6×1				7	3	6
	MCS625-3			25	10	8		
	MCS825-4	M8×1			12.5	6.5	4	8
	MCS828-4			28.5	12	10.5		
	NDS-8A			30	11.5	11.5		
	NDS-8S	M8×1.25		20	8	8		
	RSRGR5M40	M4×0.5		9	3.67	4.17	T8	1.3
	SR PS 118-0273	M10		40	16.5	15	5	40
 (Steel)	**DS-5T**	M5×0.8		12	5	5	T10	3.5
	DS-6T	M6		15	6	6	T15	3.5
	DS-6P	M6×1		21	7	7	15IP	6
	FDS-8ST	M8×1		20	8	8	T27	10
	FDS-8ST-18			18		6		
 (Steel)	**DS-6**	M6×1		15	6	6	3	6
	DS-8	M8×1.25		16	7	7	4	8
	DS-8S			13	5.5	5.5		
	DS-10	M10×1.5		26	10	12	5	8
	FDS-6Z	M6×0.75		20.5		5.5	3	6
	FDS-8	M8×1		26		10	4	8
	FDS-8S			20	8	8		
	FDS-8SS			18.5		6.5		
 (Steel)	**SS100**	1/4-20UNC			19.05			
	S-412	10-32UNF			19.05			
 (Steel)	**SHM8x1.25x35-C**	M8	13	43	23	8	6	25
	SHM10x1.5x30-C	M10	16	40	17	10	8	40
	SHM16x2x35-C	M16	24	51	18	16	14	100
	SHM20x2.5x40-C	M20	30	58	20	18	17	150
 Hex. socket screw (Flat end)(JISB1177) (Steel)	**SSHM2.5-3**	M2.5		3			1.5	1
	SSHM3-3	M3		3				
	SSHM3-4			4				
	SSHM3-6			6				
	SSHM4-4	M4		4			2	1.5
	SSHM4-5			5				
	SSHM4-6			6				
	SSHM4-8			8				
	SSHM4-10			10				
	SSHM4-14			14				
	SSHM5-6	M5		6			2.5	2
	SSHM5-10			10				
	SSHM5-16			16				
	SSHM6-12	M6		12			3	3
	SSHM6-16			16				
	SSHM6-18			18				
	SSHM6-20			20				
	SSHM8-8	M8		8			4	5
	SSHM8-10			10				
	SSHM8-12			12				
	SSHM8-14			14				
	SSHM8-16			16				
	SSHM8-18			18				
 Hex. socket screw (Cylindrical end) (JISB1177) (Steel)	**M5×7**	M5	3.5	7	1.25	-	2.5	2
	M5×8			8		-		
	M5×10			10		-		
	M6×30	M6	4	30	1.5	-	3	3
 (Steel)	**JDS-3525**	M3.5x0.35	M2.5 x0.45	7.5	3	2.5	2	1
	JDS-5040	M5x0.5	M4 x0.7	10	4	4	2.5	1

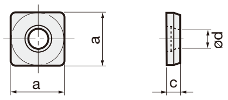
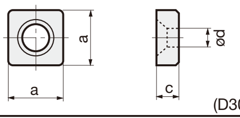
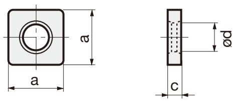
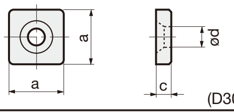
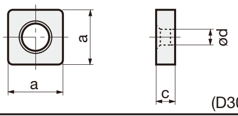
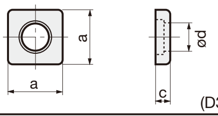
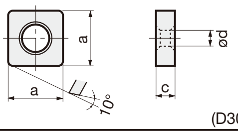
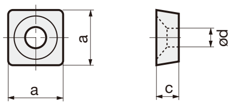
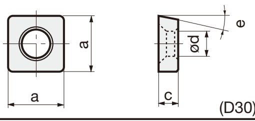
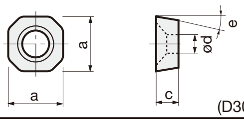
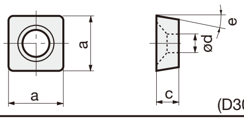
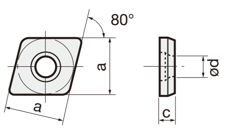
Shape	Designation	Dimension (mm) a	b	c	d	e	T / *f*	Torque (N·m)
 LCS2 has a hex. socket in threaded end only. (Steel)	LCS2	M5	5	14	6.5		2	1.5
	LCS3	M6	6	17			2.5	2
	LCS3B			15				
	LCS4	M8	8	21			3	3
	LCS4K				9.6			
	LCS4CA			17.5	6.5			
	LCS5			25	8.5			
	LCS5CA			20.5				
	LCS6	M10	9.8	27.2	9.9		4	5
	LCS8	M12	11.8	36	12.8		5	8
	LCS8C	M10	9.8	30.2	13.3		4	5
 (Steel)	LCS22	M5	M5	10	4.7		2	1.5
	LCS22A	M6	M6	10.7				
	LCS23A	M5	M5	13.1	5.1		2.5	2
	LCS33	M5	M5	12	6.2		2	1.5
	LCS43	M6	M6	13.5	7.3		2.5	2
 (Steel)	DTS5-3.5	M5	6.3	8.65	M3.5		3.5	4
	DTS5-3.5SS			6.8				
	DTS5-3.5S			7				
	DTS6-4	M6	7.7	10.2	M4		4	5
	DTS6-4.5		7.5	10	M4.5		4.5	5
 (Steel)	DLCS33	M5	9	31.5	10		3	3
	DLCS43	M6	12	34	9.5		4	5
	DLCS54	M8x1	14	41	11			7
	DLCS64	M10x1	16	50	15		5	8
 (Steel)	ACS-5W	M5	8	20	8.5		T15	4
	ACS-6W	M6	10	26	12.1		T20	6.4
 (Steel)	ACS3	M5x0.8	7.5	25.6	12-15		3	4
	ACS4	M6x1	9	27.7	14-17		4	7
 (Steel)	WCS3	M6	9.5	22.5	8		3	3
 (Steel)	PT1/4GN		13.175	10	-		6	9.5
	1/8-28		9.728	7	-		5	8
 (Steel)	LS-8	M8	6	33	20		4	5
(Steel)	CCS4-A							
	BH5-10-A							
	BH4-10-A							
	BH-40050-A							
 (Steel)	TMBA-M10	M10x1.5	27	30	21		8	40
	TMBA-M12	M12x1.75	33	36	26		10	70
	TMBA-M12H	M12x1.75		34.5			8	
	TMBA-M16	M16x2	40	50	40		14	100
	TMBA-M16H	M16x2						
	TMBA-M20	M20x2.5	50	56	42		17	150
	TMBA-M20H	M20x2.5						
	TMBA-M24	M24x3	65	69	55		19	150
	TMBA-M24H	M24x3						
	TMBA-0.500H	1/2-20UNF	33	33.9	25.4		7.94	70
	TMBA-0.750H	3/4-16UNF	50	58.28	47.28		12.7	150
 (Steel)	SR-10400611	M4X0.5		6.6	3	1	2	

Shape	Designation	Dimension (mm) a	øb	øc	Torque (N·m)
 (Steel)	SCR-TRM-T5	26.2	5.8	4.3	7 - 8
	SCR-TRM-T6	26.5	6.3	4.8	8 - 10
	SCR-TRM-T7	28	7.4	5.8	13 - 15
	SCR-TRM-T8	31.7	9.8	6.3	17 - 20
	SCR-TRM-T9	34.5	11.7	6.7	21 - 23

Shims

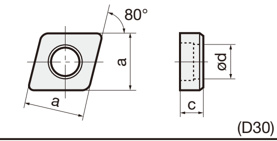
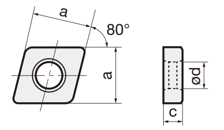
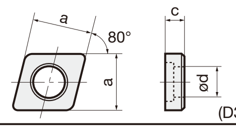
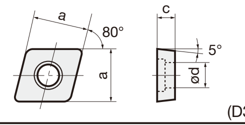
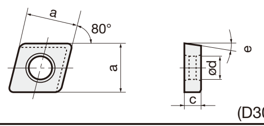
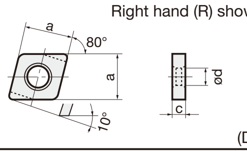
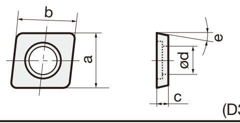
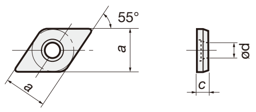
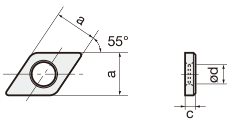
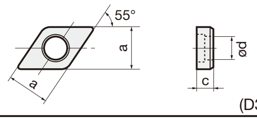
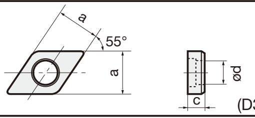
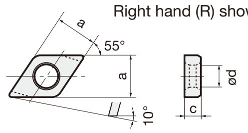
Shape	Designation	Dimension (mm)				
		a	b	c	ød	
 (D30)	AST322	9.3	13.2	3.2	4.4	
	AST422	12.5	18			
 (D30)	MST-322	9.1	12.9	3.24	5.8	
	MST-432	12.5	17.9	4.8	7.3	
	MST-533	15.6	22.2		9.7	
	MST-644	18.8	26.6	6.4	11.3	
 (D30)	LST317	9.3	13.2	2.7	5	
	LST42	12.5	18	3.2	6.7	
	LST53	15.7	22.3	4.8	7.7	
	LST42K	10.9	15.6	3.2	6.7	
 (D30)	LST317CA	9.3	13.2	2.7	5	
	LST42CA	12.5	18	3.2	6.7	
Right hand (R) shown  (D30)	ELST42	11.5	16.5	3.2	6.5	
	ELST317	8.5	12	2.7	4.9	
	ELST317BR					
	ELST317BL					
 (D30)	PAT-32	8.2	11.7	3.2	3.5	
	*PAT-53	13.4	19.8	4.8	5	
 (D30)	NAT-32	9.5	13.4	3.2	3.5	
	NAT-42E	12.4	17.8		3.1	
Right hand (R) shown  (D30)	LST317BR	9.3	13.2	2.7	5	
	LST317BL					
 (D30)	SST32	8.5	11.9	3.2	5.4	
 (KS15F)	LST33	11	15.85	4.76	4.4	

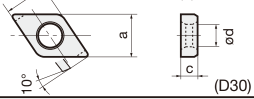
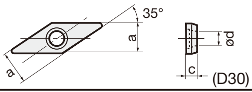
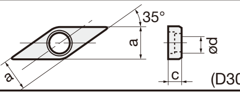
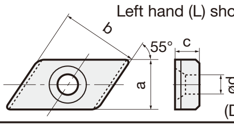
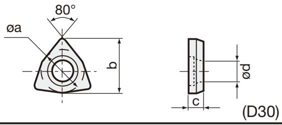
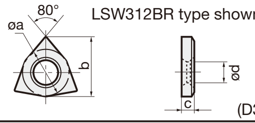
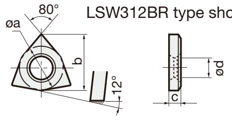
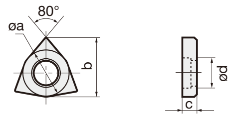
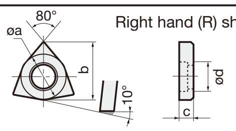
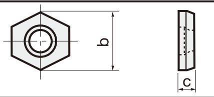
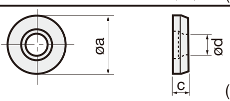
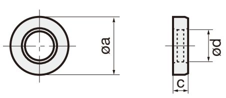
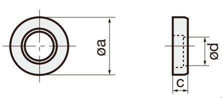
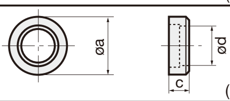
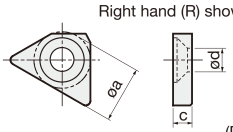
Note: * marked shims are made of steel.

Shape	Designation	Dimension (mm) a	b	c	ød	e
 (D30)	ASS422	12.5		3.2	4.4	
	CS44-A			4.7		
 (D30)	ASS533	15.7		4.8	5.5	
	ASS634	18.9				
 (D30)	ELSS32	8.5		3.2	4.9	
	LSS33	9.3		4.3	5	
	ELSS42	11.7		3.2	6.5	
	LSS42	12.5			6.7	
	ELSS53	14.7		4.8	8	
	LSS53	15.7			7.7	
	ELSS63	17.9			9.7	
	LSS63	18.9				
	ELSS84	24.2		6.4	12.9	
	LSS84	25.2			13.1	
 (D30)	NAS-42	12.7		3.2	3.5	
	NAS-04	31.5		6.4	9.1	
 (D30)	MSS-432	12.5		4.8	7.3	
	MSS-442			6.4		
 (D30)	SSS32	8.5		3.2	5.4	
Right hand (R) shown  (D30)	LSS42BR	12.5		3.2	6.7	
	LSS42BL					
 (D30)	PAS-32	8.2		3.2	3	
	PAS-42	11.4			3.5	
	*PAS-63	17		4.8	5	
 (D30)	LSS42CA	12.5		3.2	6.7	8°
	LSS53CA	15.7		4.8	7.7	10°
 (D30)	FSSA1102	11.6		2	5.5	13°
 (D30)	FSSP1102	11		2	5.5	17°
 (D30)	ASC322	9.3		3.2	4.4	
	ASC422	12.5				
	ASC533	15.7		4.8	5.5	
	ASC634	18.9				
	CC44-A	12.5		4.7		

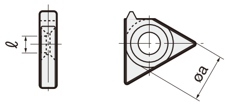
Note: * marked shims are made of steel.

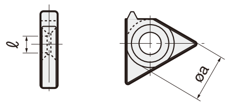
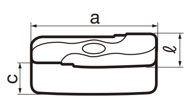
Shims

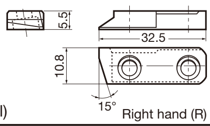
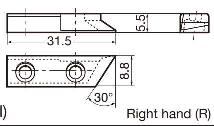
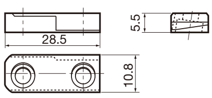
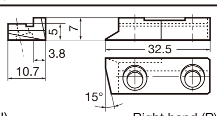
Shape	Designation	Dimension (mm)				
		a	b	c	ød	e
	MSC-432	12.5		4.8	7.3	
	MSC-442			6.4		
	MSC-533	15.6		4.8	9.7	
	MSC-543			6.4		
(D30)	MSC-634	18.8			11.3	
	ELSC32	8.5		3.2	6.2	
	LSC42	12.5			6.5	
	ELSC42	11.7				
	LSC53	15.7		4.8	7.7	
	ELSC53	14.7			8.1	
	ELSC63	17.9			9.7	
	LSC63	18.9				
(D30)	LSC317	9.3		2.7	5	
	SSC32	8.5		3.2	5.4	
(D30)	SSC4T3	11.4		4	6.6	
	SSC4T3-P	11.4		4	6.6	5°
(D30)	SSC54-P	13.4				5°
	LSC42CA	12.5		3.2	6.7	8°
(D30)	LSC53CA	15.7		4.8	7.7	10°
Right hand (R) shown 	LSC42BR	12.5		3.2	6.7	
(D30)	LSC42BL					
	ZSA1102	10.5	11	2	5.475	11°
(D30)	ZSA1502	15.6	12.4		6	11°
	ASD322	9.3		3.2	4.4	
	ASD423	12.5		3.2	4.4	
	ASD432	12.5		4.8	4.4	
(D30)	CD44-A	12.5		4.7		
	ELSD32	8.5		3.2	4.9	
	ELSD42	11.7			6.5	
	LSD42	12.5			6.7	
	LSD42A					
	LSD43			4.8		
(D30)	LSD43A					
	MSD-322	9.3		3.2	5.8	
	MSD-432	12.5		4.8	7.3	
(D30)	MSD-442			6.4		
 (D30)	SSD32	8.5		3.2	5.4	
Right hand (R) shown 	ELSD317BR	8.5		2.7	4.9	
	ELSD317BL					
	LSD42BR	12.5		3.2	6.7	
(D30)	LSD42BL					

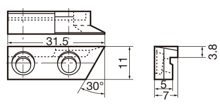
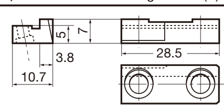
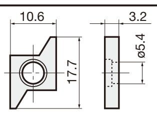
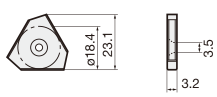
Shape	Designation	Dimension (mm)			
		øa	b	c	ød
Left hand (L) shown  (D30)	LSZ42BR	12.5		3.2	6.7
	LSZ42BL				
 (D30)	ASV322	9.3		3.2	4.4
	CV34-A	9.3		4.7	
 (D30)	MSV-322	9.26		3.2	5.8
	SSV32	8.4			5.4
	SSV42	11			6.3
Left hand (L) shown  (D30)	CSK54R	9.4	14.8	4.8	3.5
	CSK54L				
 (D30)	ASW322	9.33	11.5	3.2	4.4
	ASW422	12.5	15.2		
LSW312BR type shown  (D30)	LSW312	9.33	11.5	2.7	5
	LSW42	12.5	15.5	3.2	6.7
LSW312BR type shown  (D30)	LSW312BR	9.33	11.5	2.7	5
	LSW312BL				
 (D30)	MSW-432	12.8	15.8	4.8	7.3
	MSW-533	16	19.7		9.7
	MSW-633	19.2	23.7		11.3
Right hand (R) shown  (D30)	MSW-432BR	12.8	15.8	4.8	7.3
	MSW-432BL				
 (D30)	CH44-A		12.5	4.7	
 (D30)	ASR420	12.5		3.2	4.4
 (D30)	LSR32	8.9		3.2	5
	LSR32C	8.4			
	LSR42	12.1			6.7
	LSR42C	9.9			5
	LSR53C	14		4.8	6.7
	LSR63C	17.2			8.2
	LSR84C	21.9		6.4	9.7
 (D30)	MSR-43	12.5		4.8	7.3
	MSR-44			6.4	
 (D30)	SSR32	8.7		3.18	5.2
Right hand (R) shown  (D30)	G16EL/IR	9.5	-	3.2	4
	G16ER/IL			3.2	
	G16EL/IR-DT			3.97	5.4
	G16ER/IL-DT			3.97	

Shims

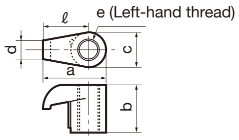
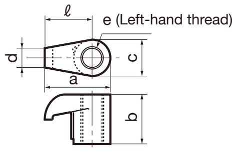
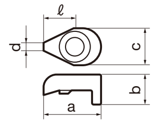
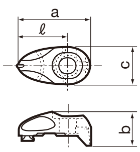
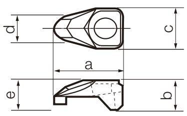
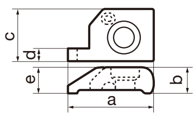
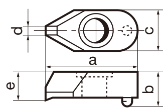
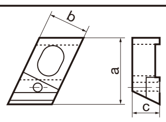
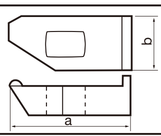
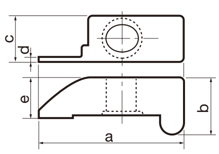
Shape	Designation	Dimension (mm)		
		øa	ℓ	Lead angle
	AE16-4DT	9.5	5.4	4°
	AE16-3DT		5.4	3°
	AE16-2DT		5.4	2°
	A16-1DT		5.4	1°
	AE16-0DT		5.4	0°
	AE16-99DT		5.4	-1°
	AE16-98DT		5.4	-2°
	AE16-4		4	4°
	AE16-3		4	3°
	AE16-2		4	2°
	A16-1		4.3	1°
	AE16-0		4	0°
	AE16-99		4	-1°
	AE16-98		4	-2°
	AN16-4DT	9.5	5.4	4°
	AN16-3DT		5.4	3°
	AN16-2DT		5.4	2°
	AN16-0DT		5.4	0°
	AN16-99DT		5.4	-1°
	AN16-98DT		5.4	-2°
	AN16-4		4	4°
	AN16-3		4	3°
	AN16-2		4	2°
	AN16-0		4	0°
	AN16-99		4	-1°
	AN16-98		4	-2°
	GXE16-98	9.5	4	-2°
	GXE16-98DT		5.4	-2°
	GXE16-99		4	-1°
	GXE16-99DT		5.4	-1°
	GXE16-0		4	0°
	GXE16-0DT		5.4	0°
	GXE16-1		4.3	1°
	GX16-1DT		5.4	1°
	GXE16-2		4	2°
	GXE16-2DT		5.4	2°
	GXE16-3		4	3°
	GXE16-3DT		5.4	3°
	GXE16-4		4	4°
	GXE16-4DT		5.4	4°
	GXE22-98DT	12.7	6.6	-2°
	GXE22-99DT			-1°
	GXE22-0DT			0°
	GX22-1DT			1°
	GXE22-2DT			2°
	GXE22-3DT			3°
	GXE22-4DT			4°
	GXN16-98	9.5	4	-2°
	GXN16-98DT		5.4	-2°
	GXN16-99		4	-1°
	GXN16-99DT		5.4	-1°
	GXN16-0		4	0°
	GXN16-0DT		5.4	0°
	GXN16-1		4.3	1°
	GXN16-2		4	2°
	GXN16-2DT		5.4	2°
	GXN16-3		4	3°
	GXN16-3DT		5.4	3°
	GXN16-4		4	4°
	GXN16-4DT		5.4	4°
	GXN22-98DT	12.7	6.6	-2°
	GXN22-99DT			-1°
	GXN22-0DT			0°
	GXN22-2DT			2°
	GXN22-3DT			3°
(D30)	GXN22-4DT			4°

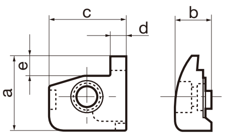
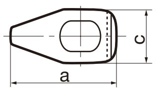
Shape	Designation	Dimension (mm) a	øa	ℓ	c	Lead angle
	NXE22-98					-2°
	NXE22-99			4		-1°
	NXE22-0					0°
	NXE22-1		12.7	4.5		1°
	NXE22-2					2°
	NXE22-3			4		3°
	NXE22-4					4°
	NXE27-98					-2°
	NXE27-99			4		-1°
	NXE27-0					0°
	NXE27-1		15.9	4.5		1°
	NXE27-2					2°
	NXE27-3			4		3°
	NXE27-4					4°
	NXN22-98					-2°
	NXN22-99			4		-1°
	NXN22-0					0°
	NXN22-1		12.7	4.5		1°
	NXN22-2					2°
	NXN22-3			4		3°
	NXN22-4					4°
	NXN27-98					-2°
	NXN27-99			4		-1°
	NXN27-0					0°
	NXN27-1		15.9	4.5		1°
	NXN27-2					2°
	NXN27-3			4		3°
(D30)	NXN27-4					4°
	TSL12R	12		4.7	4.5	4.5°
	TSL12L	12		4.7	4.5	4.5°
	TSL16R	15.9		6.4	5	5°
	TSL16L	15.9		6.4	5	5°
	TSL24R	23.8		9.4	7.1	7°
	TSL24L	23.8		9.4	7.1	7°
	TSL12RI	10.7		4.7	4.5	4.5°
	TSL12LI	10.7		4.7	4.5	4.5°
	TSL16RI	18.8		6.4	5	5°
(D30)	TSL16LI	18.8		6.4	5	5°

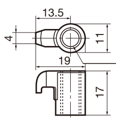
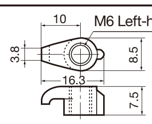
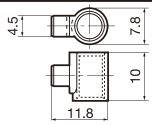
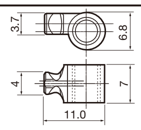
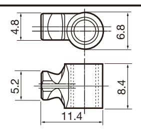
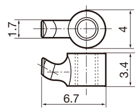
Shape	Designation
 (Steel) Right hand (R) shown	SL-1R SL-1L
 (Steel) Right hand (R) shown	SL-2R SL-2L
 (Steel) Right hand (R) shown	SL-3R SL-3L
 (Steel) Right hand (R) shown	SL-6R SL-6L

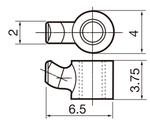
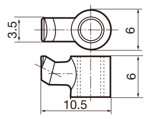
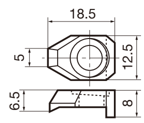
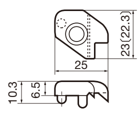
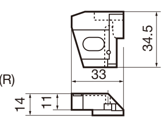
Shape	Designation
 (Steel) Right hand (R) shown	SL-7R SL-7L
 (Steel) Right hand (R) shown	SL-8R SL-8L
 (D30) Right hand (R) shown	SGSR151 SGSL151
 (D30) Right hand (R) shown	STN62R STN62L

Clamps

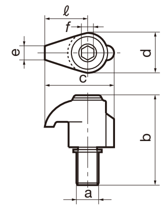
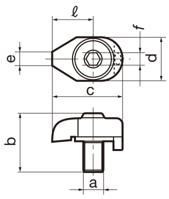
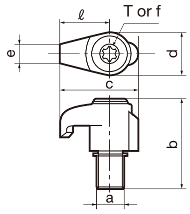
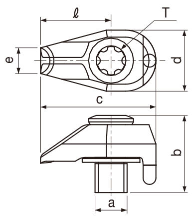
Shape	Designation	Dimension (mm)					
		a	b	c	d	e	ℓ
 (Steel)	MCL-5M	14.7	11	7.8	4	M5	10.8
	MCL-6	18.6	11.5	9.5		M6	13.8
	MCL-8S	19.1	13.5	10.9	5	M8	13.6
	MCL-8M	22.5					17
	MCL-8L	25.5	14.5		4		20
 (Steel)	MCPM-6	14.7	11.2	7.9	4	M5	10.8
	MCPM-9	19.1	16.8	10.9	5	M8×1	13.6
	MCPM-12	22.5					17
	MCPM-20	18.6	9.5	9.5	4	M6	13.8
	MCPM-21		12.2				
	MCPM-22	21.5	13.2				16.7
	MCPM-30	25.5	16.8	10.9	5	M8×1	20
 (Steel)	DCPM-33	16	9.3	10.5	2.4		8.5
	DCPM-43	21.2	11.5	13.5	3		13.2
	DCPM-54	25.8	15.25	14	3.5		
	DCPM-64	28.4	15.5	16	4		
 (Steel)	ACP3S	22.8	9.5	10			15
	ACP3S-E	21.7	9.5	10			13.9
	ACP3L	31.3	12	13			23.3
	ACP3L-E	26.4	12	13			18.4
	ACP4S	25.7	12	13			17.7
	ACP5S	30.1	12.9	15	-	-	20.7
	ACP6S	33.4	12.8	16.5	-	-	24
 (Steel)	ACP3	17.9	10	10	6.5	6.3	
	ACP4	25.9	13.9	12	7	10.8	
 (Steel) Right hand (R) shown	CTC-3R	29	8.8	16	2.2	8	
	CTC-3L						
	CTC-4R			17	3.2		
	CTC-4L						
	CTC-5R			18	4.2		
	CTC-5L						
 (Steel)	CP81A	28	10.5	12	3.5	8	
	CP81B						
 (Steel) TC-3 type shown, TC-4 : Left-hand thread	TC-3	19	12.5	8.3	–	–	–
	TC-4	21.6		8			
 (Steel)	TF-72	22	11.3				
	TF-73	22	11.3				
	TF-184	22	11.3				
	TF-185	22	11.3				
 (Steel)	CCR2	34.7	14.9	10.7	1.2	10.5	
	CCL2						
	CCR3				2.2		
	CCL3						
	CCR4				2.8		
	CCL4						
	CCR5				3.2		
	CCL5						
	CCR6				3.9		
	CCL6						
	CCR8				4.9		
	CCL8						

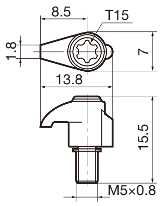
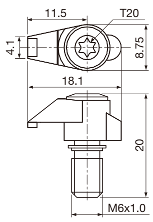
Shape	Designation	Dimension (mm) a	b	c	d	e	
 Right hand (R) shown	CFG-3SR	22	11	23.1	2	6	
	CFG-3SL						
	CFG-4SR				3		
	CFG-4SL						
	CFG-4DR	32				16	
	CFG-4DL						
	CFG-5SR	22			4	6	
	CFG-5SL						
	CFG-5DR	32				16	
	CFG-5DL						
	CFG-6SR	23			5	7	
	CFG-6SL						
	CFG-6DR	33				17	
	CFG-6DL						
	CFG-8SR	28		27.1	7	8	
	CFG-8SL						
	CFG-8DR	38				18	
(Steel)	CFG-8DL						
 (Steel)	CCP4-A	29.1		14			

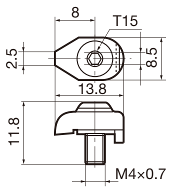
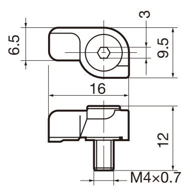
Shape	Designation
 M8 Left-hand thread (Steel)	NF-84A
 M6 Left-hand thread (Steel)	CP536
 (Steel)	CP91
 (Steel)	CP900
 (Steel)	CP910
 (Steel)	JCP-1

Shape	Designation
 (Steel)	JCP-2
 (Steel)	JCP-3 JCP-3N
 (Steel)	CQ-1
 Right hand (R) shown (Steel)	CPK5R CPK5L
 Right hand (R) shown (Steel)	C11R-5 C11L-5

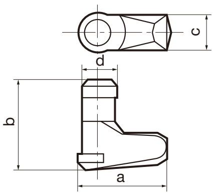
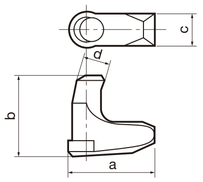
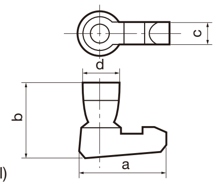
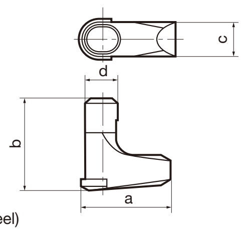
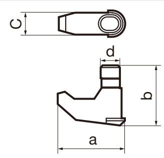
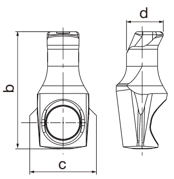
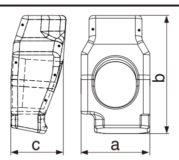
Clamp Sets

Shape	Designation	Dimension (mm)						
		a	b	c	d	e	ℓ	T / f
 (Steel)	CSG-5S	M5×0.8	13.5	13.8	7	1.8	8.5	2.5
	CSG-5		15.5					
	CSG-6S	M6×1		16.3	8.5	2.5	10	3
	CSG-6		18					
	CSG-6L		21.5					
	CSG-8S	M8×1	21	20.5	11	3.5	12.5	4
	CSG-8		23.5					
 (Steel)	CSW-00	M4×0.7	11.5	12	8	2	7.5	2.5
	CSW-1	M5×0.8	16.5	16.5	9.5	4	10	3
	CSW-0	M4×0.7	11.5	13.8	8.5	2.5	8	2.5
	CSW-2	M6×1	20	20.5	11	6	13	4
	CSW-40	M4×0.7	12	13.2	8	2	7.5	2.5
	CSW-50	M5×0.8	15	16.9	10		9.5	3
 (Steel)	CSP16	M5×0.8	15.5	14.4	6.9	3.2	9.1	T15
	CSP22	M6×1	20	18.1	8.9	4.2	11.5	T20
	CSP27	M8×1.25	23.5	24.4	11.9	3.9	15.6	4
 (Steel)	CSY-15	M4×0.7	11.6	11.5	7	3	6	15IP
	CSY-20	M5×0.8	12	18	9.5	4	11	20IP

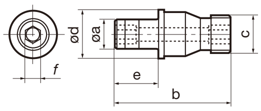
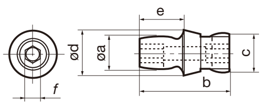
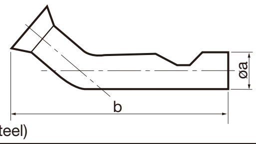
Shape	Designation
 (Steel)	CSG-5T
 (Steel)	CSX20

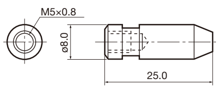
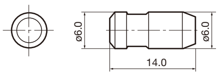
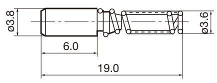
Shape	Designation
 (Steel)	CSW-0T
 (Steel)	CSL-4

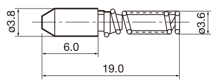
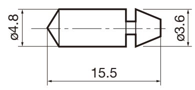
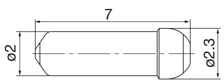
Levers

Shape	Designation	Dimension (mm)				
		a	b	c	d	
 (Steel)	**LCL3**	10	12	3.7	3.6	
	LCL4	14.6	14	4.7	4.7	
	LCL5	17.1	17	6	6	
	LCL6	20.5	21	7.5	7.5	
	LCL8	25.4	25.4	8.6	8.6	
 (Steel)	**LCL3C**	10.8	11.8	3.4	3	
	LCL4C	13	13.4	3.7	3.4	
	LCL5C	18.6	17.7	4.7	4.5	
	LCL6C	20.5	19	6	5.7	
	LCL8C	24.2	23.5	7.5	6.2	
 (Steel)	**LCL22N**	7.5	6.5	2.6	2.06	
	LCL32N	10	7.8	3.2	3.2	
	LCL33NL	11.5	9.5	3.1	3.6	
	LCL33N	10	9.4	3.2	3.2	
	LCL43N	13.4	10	4.7	4.7	
 (Steel)	**LCL23**	7.8	8.5	2.6	2.1	
	LCL33	10.1	12.1	3.6	3.7	
	LCL33L	12	11.5	3.1	3.6	
	LCL43S	13.5	13.2	4.7	4.7	
	LCL43M					
	LCL44	16.1	14.6	4.7	4.7	
	LCL54	16.5	17.2	6.1	6	
 (Steel)	**DLCL43**	15.55	14	5	4.7	
	DLCL54	19.1	19.1	6.1	6	
	DLCL64	21.5	21	7.5	7.5	
 (Steel)	**SLLV-1**		7.75	3.4	2.43	
	SLLV-2		7.75	3.4	2.75	
 (Steel)	**FCL4**	5	7.78	3.81		
	FCL8	10	14.3	5.39		

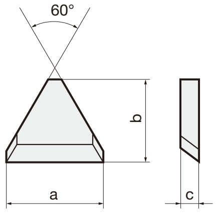
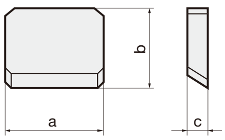
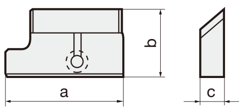
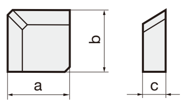
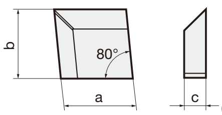
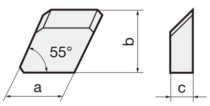
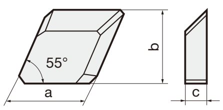
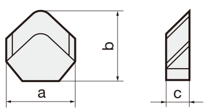
Pins

Shape	Designation	Dimension (mm)					
		øa	b	øc	ød	e	*f*
 (Steel)	**MLP32L**	3.9	8.8	M5×0.8	5.6	3.5	2
	MLP33	3.7					
	MLP34L	3.7	13.1		6.2	5	
	MLP46	5	17.2	M6.3×1	7.8	5.5	2.5
	MLP46L		18.6			6.9	
	MLP58	6.2	21.9	M8×1	10.3		3
	MLP68	7.8		M10×1	11.9		4
	MLP68L		24.1			9.1	
 (Steel)	**MLP44**	5	13.2	M6.3×1	7.1	5.5	2.5
	MLP33L	3.7	10.4	M5×0.8	5.6	5.1	2
 (Steel)	**SW99**	8	47.5				

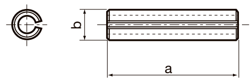
Shape	Designation
 (Steel)	**SP-8**
 (Steel)	**SP-6**
 (Steel)	**BP-3**

Shape	Designation
 (Steel)	**BP-360**
 (Steel)	**BP-490**
 (Steel)	**SL-PI-2**

Chipbreaker Pieces

Shape	Designation	Dimension (mm)				
		a	b	c		
 (TX30)	CBT-2S	8.8	7.6	2		
	CBT-2M	7.4	6.6			
	CBT-3S	13.3	12.1	2.5		
	CBT-3M	12.3	11.1			
	CBT-3L	11.3	10.1			
	CBT-4S	18.8	16.9			
	CBT-4M	17.8	15.9			
	CBT-4L	16.8	14.4			
	NCT-2S	14.2	11.8			
	NCT-2M	13	10.8			
	NCT-2L	11.9	9.8			
 (TX30)	CBS-3S	9.5	8.3	2		
	CBS-3M		7.3			
	CBS-4S	12.7	11.6	2.5		
	CBS-4SN					
	CBS-4M		10.6			
	CBS-4L		9.1			
	NCS-3S		11.2			
	NCS-3M		10.2			
	NCS-3L		8.7			
 Right hand (R) shown (TX30)	B11 R-5	24	13	5		
	B11 L-5					
 (TX30)	CBS-4SN	11.5	11.5	2.5		
	CBS-4MN	10.5	10.5			
	CBS-4LN	9	9			
	NCS-3SN	11.2	11.2			
	NCS-3MN	10.2	10.2			
	NCS-3LN	8.7	8.7			
 (TX30)	CBC-4SN	11.5	11.5	2.5		
	CBC-4MN	10.5	10.5			
	CBC-4LN	9.5	9.5			
 Right hand (R) shown (TX30)	CBD-4SR	12.7	11.5	2.5		
	CBD-4MR		10.5			
	CBD-4ML					
	CBD-4LR		9.5			
 (TX30)	CBD-4SN	11.5	11.5	2.5		
	CBD-4MN	10.5	10.5			
 (TX30)	CBR-4SN	12.7	11.9	2.5		
	CBR-4MN		10.9			

Springs (Springs for Shims)

<table>
<tr><th rowspan="2">Shape</th><th rowspan="2">Designation</th><th colspan="6">Dimension (mm)</th></tr>
<tr><th>a</th><th>b</th><th>c</th><th>d</th><th></th><th></th></tr>
<tr><td rowspan="2"> (Steel)</td><td>SP-2.5</td><td>12</td><td>2.7</td><td></td><td></td><td></td><td></td></tr>
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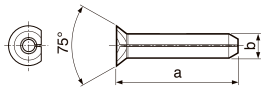
<tr><td rowspan="2"> (Steel)</td><td>SP-16-L14</td><td>13.6</td><td>2.85</td><td></td><td></td><td></td><td></td></tr>
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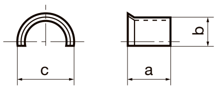
<tr><td rowspan="8"> (Steel)</td><td>LSP3</td><td>5.5</td><td rowspan="2">3</td><td rowspan="2">5.9</td><td></td><td></td><td></td></tr>
<tr><td>LSP3L</td><td rowspan="2">7</td><td></td><td></td><td></td></tr>
<tr><td>LSP4</td><td rowspan="2">4</td><td rowspan="2">7.6</td><td></td><td></td><td></td></tr>
<tr><td>LSP4S</td><td>6</td><td></td><td></td><td></td></tr>
<tr><td>LSP5</td><td>8.5</td><td>4.5</td><td>8.8</td><td></td><td></td><td></td></tr>
<tr><td>LSP6</td><td>11</td><td>5.9</td><td>10.9</td><td></td><td></td><td></td></tr>
<tr><td>LSP6C</td><td>8.5</td><td>4.8</td><td>9.3</td><td></td><td></td><td></td></tr>
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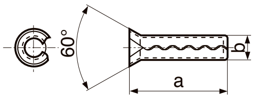
<tr><td rowspan="4"> (Steel)</td><td>PSP-2.5</td><td>10</td><td>2.7</td><td></td><td></td><td></td><td></td></tr>
<tr><td>PSP-4.0</td><td>16</td><td>4.2</td><td></td><td></td><td></td><td></td></tr>
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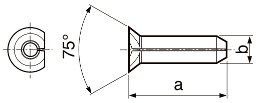
<tr><td rowspan="2"> (Steel)</td><td>PSP-16</td><td>9.75</td><td>2.85</td><td></td><td></td><td></td><td></td></tr>
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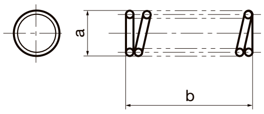
<tr><td rowspan="8"> (Steel)</td><td>BP-0</td><td>3.6</td><td>13</td><td></td><td></td><td></td><td></td></tr>
<tr><td>BP-5-A</td><td></td><td></td><td></td><td></td><td></td><td></td></tr>
<tr><td>BP-7</td><td>7</td><td>11</td><td></td><td></td><td></td><td></td></tr>
<tr><td>BP-8.8</td><td>8.8</td><td rowspan="3">10</td><td></td><td></td><td></td><td></td></tr>
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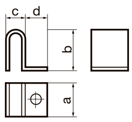
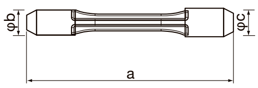
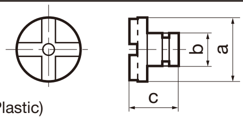
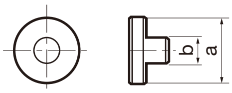
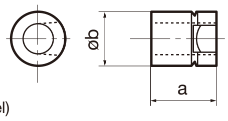
<tr><td>BP-10</td><td>9.8</td><td></td><td></td><td></td><td></td></tr>
<tr><td>SP913</td><td>9</td><td>13</td><td></td><td></td><td></td><td></td></tr>
<tr><td></td><td></td><td></td><td></td><td></td><td></td><td></td></tr>
<tr><td rowspan="2"> (Steel)</td><td>BSP-1</td><td>7.8</td><td>7.5</td><td>4.8</td><td>6</td><td></td><td></td></tr>
<tr><td></td><td></td><td></td><td></td><td></td><td></td><td></td></tr>
<tr><td rowspan="2"> (Steel)</td><td>PN3-4</td><td>64</td><td>9</td><td>10</td><td></td><td></td><td></td></tr>
<tr><td></td><td></td><td></td><td></td><td></td><td></td><td></td></tr>
</table>

Parts for Tools

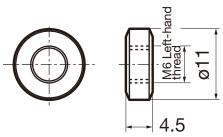
Coolant Supply Attachment

Shape	Designation	Dimension (mm)					
		a	b	c	Thread		
 (Plastic)	**EA-20**	20	10	15			
	EA-25	25					
	EA-32	32	16				
 (Plastic)	**CA-16**	16	8		M6		
	CA-20	20	8.5		M6		
	CA-25	25	11.5		R1/8		
	CA-32	32	11.5		R1/8		
	CA-40	40	11.5		R1/8		

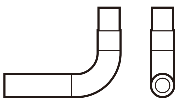
Pistons

Shape	Designation	Dimension (mm)				
		a	øb			
 (Steel)	**DPIS33**	12.6	9			
	DPIS43	11.8	10			
	DPIS44	13.4	10			
	DPIS54	16	13			
	DPIS64		15			

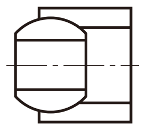
Nuts

Shape	Designation
	**SRW11**

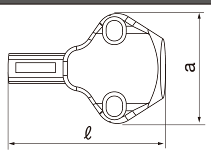
Coolant Pipe & Nozzle

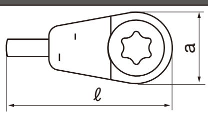
Shape	Designation
	**PNZ5**

Coolant Nozzle

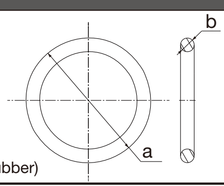
Shape	Designation
	**CNZ125**
	SATZ-M8X1-M3
	SATZ-M10X1-M5
	EZ104
	EZ83

Coolant unit

Shape	Designation	Dimension (mm)	
		a	ℓ
	**CU-CW-CHP**	20.8	29.7
	CU-D-CHP	20.8	29.6
	CU-V-CHP	20.8	30

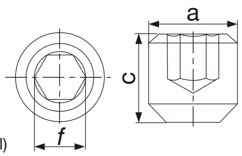
Shape	Designation	Dimension (mm)	
		a	ℓ
	**S-CU-CHP**	7	16.2

O-ring for TungTurn-Jet

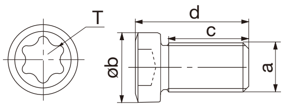
Shape	Designation	Dimension (mm)				
		a	øb			
 (Rubber)	**OR6.4X0.9N**	8.2	0.9			
	OR14X2.5NN	19	2.5			

Parts for Tools

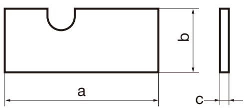
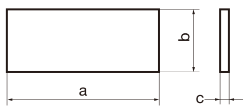
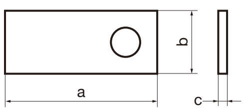
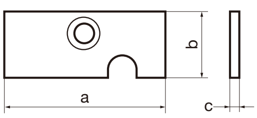
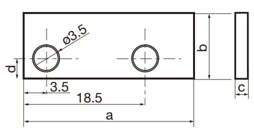
Coolant screw for TungTurn-Jet

Shape	Designation	Dimension (mm)				
		a	c			T / *f*
 (Steel)	**SRM4X4 TL360**	M4	4			2

Mounting screw for TungTurn-Jet

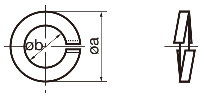
Shape	Designation	Dimension (mm)				
		a	øb	c	d	T / *f*
 (Steel)	**SRM3**	M3X0.5	4.2	7	4.9	T8

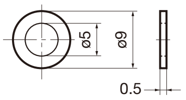
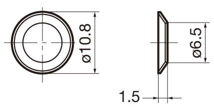
Sizing Plates

Shape	Designation	Dimension (mm)					
		a	b	c	d		
 (Steel)	**S0816A**	55	15.5	0.8			
	S1016A			1			
	S0816B	50		0.8			
	S1016B			1			
	S0816C	45		0.8			
	S1016C			1			
	S0820A	61	19.5	0.8			
	S1020A			1			
	S0820B	54.5		0.8			
	S1020B			1			
	SM-00	18	8	1			
 (Steel)	**SW04**	25.5	5.8	0.25 0.5 1			
	SW05	37	8.3	0.25			
	SW06	36	10.8	0.5 1			
	SW08	35.5	12.3	2			
 (Steel)	**S0810**	40	11	0.8			
	S1010			1			
 Attached with fix screw and wrench. (Steel)	**PSTR08**	24	11	1.5			
	PSTL08						
	PSTR10	42	16.5	2			
	PSTL10						
	PSTR12	47	19	2			
	PSTL12						
 (Steel)	**AP0801**	26	9.5	0.5	3		
	AP0802			1			
	AP0803			1.5			
	AP0804			2			
	AP0805			2.5			
	AP1101	30	11.5	0.5	5		
	AP1102			1			
	AP1103			1.5			
	AP1104			2			
	AP1105			2.5			
	AP1106			3			

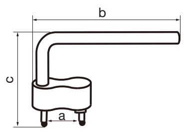
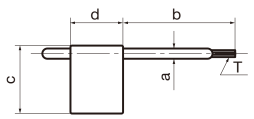
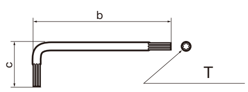
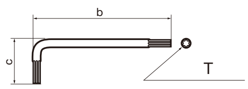
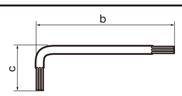
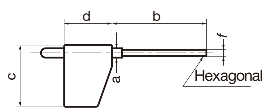
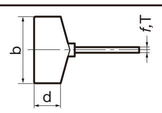
SW04 is composed of three plates and SW05 to SW08 are composed of four plates.
Note on fixing screws: PSTR/L08 is attached with CSSM2-4 and other types are attached with CSHM3-8.

Washers

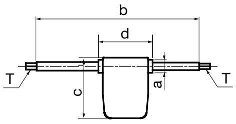
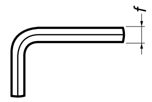
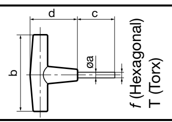
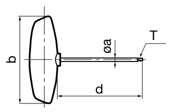
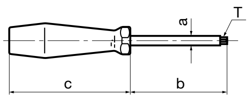
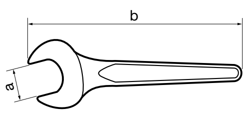
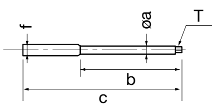
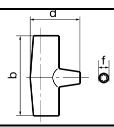
Shape	Designation	Dimension (mm) øa	øb				
	**VA4**	7.6	4.1				
	VA5	9.2	5.1				
	VA6	10.5	6.1				

Shape	Designation
	**CPW5**
	**CDW6**

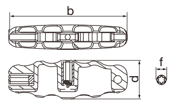
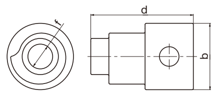
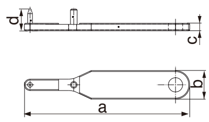
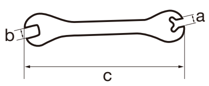
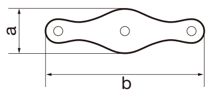
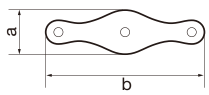
Wrenches and Drivers

Shape	Designation	Dimension (mm) a	b	c	d	*f*	T
	**CRW23**	9.7	78.5	55.0			
	CRW33	9.3					
	**T-6F**	2	35	14.5	15		T6
	T-7F			19	19		T7
	T-8F	2.5	40				T8
	T-9F	3		23.5	20		T9
	T-15F	3.5	45	28	21		T15
	T-20F	4					T20
	IP-6F	2	35	14.8	14.9		6IP
	SET T-15/5	3.5	45	28	21		T15
	T-20TORX	3.9	49	30	22		T20
	**T-6L**		48	16			T6
	T-8L						T8
	T-9L						T9
	T-15L		59	22			T15
	T-25TORX		66	23.3			T25
	**KEYV-T20**		60	22			T20
	KEYV-T25		65	23			T25
	KEYV-T30L		190	37			T30
	KEYV-T40L		208	43			T40
	KEYV-T50L		232	48			T50
	**QL-39**		85	30			
	**P-2F**	4	44	20	12.5	2	
	P-2.5F	5	45	25	20	2.5	
	HW2.0/5RED	3	38	15	15	2	
	**P-2.5T**		42		15	2.5	
	T-15DF		40		20		T15

Wrenches, Drivers and Lubricant

Shape	Designation	Dimension (mm) a	b	c	d	*f*	T
	T-1008/5	6.5	85	28	25	-	T10/T8
	T-2010/5					-	T10/T20
	1/4HEX					6.35	
	5/32HEX					3.97	
	1/8HEX					3.18	
	3/32HEX					2.38	
	P-2					2	
	P-2.5					2.5	
	P-3					3	
	P-3.5					3.5	
	P-4					4	
	P-4.5					4.5	
	P-5					5	
	P-6					6	
	TP-3A		70	30	45.5	3	
	TP-4		85	32	53	4	
	TP-5			40.5		5	
	T-27T		83	27	51		T27
	T-15T	4	80		100		T15
	T-20T						T20
	IP-20T						20IP
 Handle shape somewhat varies depending on the type number from the above figure.	T-6D	2.5	45	70			T6
	T-7DB			75			T7
	T-7D	2		70			
	T-8D	2.6	61	67.5			T8
	T-9D	3	65	80			T9
	T-10D	3.3	70	90			T10
	T-15D	3.65	71	100			T15
	T-20D	4.6	90				T20
	T-25D	4.4	87	86			T25
	IP-6DB		45	70			6IP
	IP-7D	2.5	45	75			7IP
	IP-8D	3	55	80			8IP
	IP-9D	3.3	60	100			9IP
	IP-10D	3.3	71	89			10IP
	IP-15D	4	80	100			15IP
	IP-20D	4	90	100			20IP
	KS-21	21	195				
	KS-24	24	215				
	KS-27	27	235				
	KS-32	32	275				
	KS-36	36	305				
	M-1000						
	BT15S	3.9	50	90		6	T15
	BT15M	3.9	50	118		6	T15
	BT20S	4.6	50	90		6	T20
	BT20M	4.6	50	118		6	T20
	BLD IP15/S7	3.9	50	90		6	15IP
	BLD IP15/M7	3.9	50	118		6	15IP
	BLD IP20/S7	4.6	50	90		6	20IP
	BLD IP20/M7	4.6	50	118		6	20IP
	BLD T10/S7	3.9	57	75		6	T10
	BLD T10/S7-A	3.9	57	75		6	T10
	H-TB		100		37	6	
	H-TBS		75		37	6	

Wrenches and Drivers

Shape	Designation	Dimension (mm)					
		a	b	c	d	*f*	T
	**H-TB2W**		95		31.4	6	
	**AJC08**		11		17	4.1	
	**ECW-456EF**	87	15	4	11.5		
	ECW-456I	80.5	22	4	10.5		
	**KEYV-S05**	4	5.5	100			
	KEYV-S06	5.4	8	125			
	KEYV-S08	6.6	10	150			
	KEYV-S10	7.7	13	175			
	KEYV-S12	9.4	16	250			
	KEYV-W20						
	**KEYV-177**	29	110				
	KEYV-217	29	110				
	**KGDT-100**	32	108.5				
	KGDT-110	32	108.5				
	KGDT-120	32	108.5				
	KGDT-130	32	108.5				
	KGDT-140	32	108.5				
	KGDT-150	32	108.5				
	K-TRM-T5	22	81.5				
	K-TRM-T6	27	92				
	K-TRM-T7	31.4	107				
	K-TRM-T8	36	110				
	K-TRM-T9	38	110				

Parts for Tools

Locators

Designation	Applicable Tool
LD150R	TXD15125R ~ TXD15315R
LD440R/L	TMD44 TGD4400R/L-A TFD44
LD442R/L	EGD4400R
LD540R/L	TMD54
LE302R	ESE3050R (RS**) ~ 3063R (RS**)
LE303R/L	TSE3003R/LIA ~ 3006R/LIA
LE402AR	ESE4050RA ESE4063RA
LE403R/L	TSE4003R/LIA TSE4004R/LIA ESE4003RIA-S32
LE405R/L	TSE4005R/LIA ~ 4012R/LIA
LE413R/L	THE40
LE444R/L	TME4403R/LI ~ 4405R/LI TME4403R/LB ~ 4405R/LB EME4405R ~ 4404RI
LE446R/L	TME4406R/LI ~ 4412R/LI TME4406R/LB ~ 4412R/LB
LE540R/L	TME54
LF440R/L	THF44
LF540R/L	THF54
LF602R	ERF6050R ~ ERF6063R
LF602R/L	TRF6003R/LI ~ TRF6006R/LI TRF6008R/LI ~ TRF6012R/LI
LMS56R/L	MS08R/L ~ MS12R/L
LN423R/L	TGN42
LN645R/L	TPN64
LP403R/L	TSP4003R/LIA ~ TSP4004R/LIA TFP4004R/LIA
LP405R/L	TSP4005R/LIA ~ TSP4012R/LIA TFP4005R/LIA ~ TFP4012R/LIA
LP413R/L	TGP41 TGP42
LP514R/L	TGP51
LPP16R	TPP16
LR602R/L	ERD6050RA ~ ERD6063RA
LR603R/L	TRD6003R/L TRD6004R/L ~ TRD6008R/L
LV525R/L	VSN 1
LV530R/L	VSN 2
LV556R/L	VSN60
LW400R	EFP4063R
LW400R/L	TFD44 TFP4000 SFP4000
LW402R	EFP4050R

Insert locking wedges

Designation	Applicable Tool
FDS-8SST	EDPD09063R EDPD09063RB
FDS-8ST-18	EDP09080R EDPD09080RB DPD09100R~DPD09160R DPD09100RB~DPD09160RB
FW-242R/L	ø63
FW-243R/L	ø80~100
FW-245R/L	ø125 ~
FW304R/L-D	DAD15 DPD15 EDPD15 QPP15
WF150R	TXD15125R ~ TXD15315R
WF310R/L	TGP4100BA TGP4103R/LIA
WF330N	TSE4003R/LIA TSE4004R/LIA ESE4003RIA-S32 TSP4003R/LIA ~ TSP4004R/LIA TFP4004R/LIA
WF330R/L	TSE3003R/LIA ~ 3006R/LIA
WF444R/L	TME4403R/LI ~ 4405R/LI TME4403R/LB ~ 4405R/LB EME4405R ~ 4404RI TME4406R/LI ~ 4412R/LI TME4406R/LB ~ 4412R/LB
WF500R	TSE4005R/LIA ~ 4012R/LIA TSP4005R/LIA ~ TSP4012R/LIA TFP4005R/LIA ~ TFP4012R/LIA
WF500R/L	TMD54 TGP51 THF54
WF50R/L	TME54
WF602R	ERF6050R ~ ERF6063R
WF603R/L	TRF6003R/LI ~ TRF600R/LI
WF608R/L	TRF6008R/LI ~ TRF6012R/LI
WF875N	TPYD06 EPYD06
WN645R/L	TPN64
WP193TR/L	EGD4400R
WP440R/L	TMD44 TGD4400R/L-A TFD44 TGP4100IA ~ TGP4112R/LIA TGP42 THF44 THE40
WR602R/LW	ERD6050RA ~ ERD6063RA
WR603R/L	TRD6003R/L TRD6004R/L ~ TRD6008R/L
WT402R	ESE4050RA ESE4063RA
WT402R/L	EME4450RB ~ 4404RB

Locator adjusting wedges

Designation	Applicable Tool
FW-305	TFD44 TFP40 SFP4000 EFP4063
FW325R/L-D	DAD15 QPP15 DPD15 EDPD15
RSFTC1008	TPYP12...
RSFTC1009	EPYP12M032C25.0R05
RSFTC1011	EPYP12M025C25.0R03

Fine adjusting screws

Designation	Applicable Tool
AJM5	DPD09 EDPD09
ASM34L	DPD24

Cover

Designation	Applicable Tool
RSFTS6063M	TPYP12M063B22.0R10
RSFTS6080	TPYP12*080B**R12
RSFTS6100	TPYP12*100B**R16
RSFTS6125	TPYP12*125B**R20

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