

External Toolholder



External Toolholder - Content structure

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

How to use the page

Method 1 Select the cutting edge shape described at the left end of each page, jump to the page on the left index, and choose a designation you need (4) in the dimension table (3). Applicable inserts are shown in (6) and (8).

Method 2 Select the cutting edge on C003 and check the details on the product page.

Method 3 Select the series name of a toolholder on C003 and check the details on each page.

Method 4 Select an item from Quick Guide on C006-C013.

ISO TURN ACLNR/L-Eco
Double-clamp toolholder with 95° approach angle, for negative 80° rhombic inserts

ISO TURN PCLNR/L-Eco
Lever-lock toolholder with 95° approach angle, for negative 80° rhombic inserts

ISO TURN PCLNR/L-CHP-Eco
Lever-lock toolholder with 95° approach angle, for negative 80° rhombic inserts, with high pressure coolant capability

ISO TURN TUNGJET PCLNR/L-CHP-Eco
Lever-lock toolholder with 95° approach angle, for negative 80° rhombic inserts, with high pressure coolant capability

INSERT SELECTION

Application	Grade	Chipbreaker shape	Cutting conditions
Finishing	TB10	TM	B000
Medium cutting	TB10	TM	B000
Medium cutting	TM	TM	B010
Medium cutting	TM	TM	B014

Reference pages: ACLNR/L-Eco, PCLNR/L-CHP-Eco: Inserts → B054 - Parts for coolant hose → C134

Reference pages: PCLNR/L-Eco: Inserts → B054 -

- 1: Cutting edge shape
- 2: Series name of indexable external toolholders
- 3: Dimension table
- 4: Toolholder designation
e.g. right-hand, 25x25 square shank
- 5: Dimension drawing (conforming to ISO13399)
- 6: Applicable insert
- 7: Spare parts
- 8: Basic selection
- 9: Reference pages

→ **ACLNR2525 M0904-A**

When ordering

- Please specify the designation and quantity.

e.g. ACLNR2525M12-A ... 1 (one external toolholder per package)

* Inserts are not included. Please order those separately.

Main products

L	95°		C016
J	93°		C037
N	63°		C065
V	72.5°		C067
P	62.5°		C072
A	91°		C074
G	91°		C080
B-R	75°		C091
X	20°		C096
D	45°		C099
S	45°		C105
K	75°		C109
F	91°		C112
Q-H	45°		C118
Special			C129



TURN^{EN}FEED

Innovative tool realizing both high productivity and economy

C014, C096



ISO E^{CO}TURN

Small-sized "Eco" insert series for maximized profits

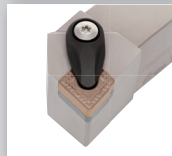
C015



MINIF^{ORCE}TURN

Economical double-sided inserts with excellent sharpness

C031 - C033, C039 - C041
C056 - C058, C129 - C130



TURNINGA

Highly rigid clamping system with excellent repeatability

C006



TUNG T^{URN}JET

Toolholders for high pressure coolant supply

C016, C019, C021, C029,
C034 - C035, C043, C045,
C048, C054, C060 - C062,
C088, C125, C132 - C133



DIMPLEFX

Ceramic insert with dimple for highly efficient cast iron machining

C006



TURNTEC

Inserts and toolholders for roughing large depths of cut with high productivity

C078, C092, C113



Y-PRO SERIES

Inserts with 25° corner angle for profiling

C064, C128, C131



TURNFEED

Tool series for super high-feed cutting

C098



FIX^RTURN

Highly productive round insert with 6 indexes

C085, C101

Designation system for Toolholders

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

1 Clamping system

Symbol	Shape	Offset	H	Angle	With	P	Angle	With
A		Without	I	100°	With	*	117.5°	Without
			J	76.5°	Without	*	45°	With
B		Without	J2	93°	With		45°	With
			*	93°	Without		72.5°	Without
C		Without	K	75°	With		93°	With
D		Without	L	95°	With		100°	With
E		Without	L2	95°	Without		80°	With
			*	95°	With		93°	Without
F		With	N	63°	Without		93°	Without
					With			
G		With	N3	63°	With			
			*	62.5°	Without			

3 Cutting edge style

(Example)

1
A

2
W

3
L

4
N

5
R

(Example)

P

T

G

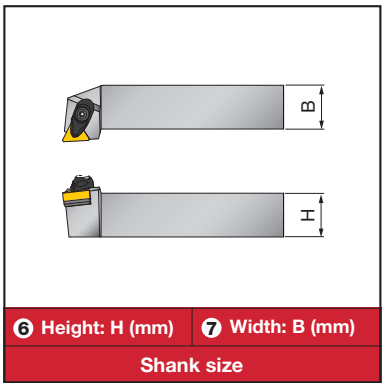
N

R

2 Insert 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	
C	7°
B	5°
N	0°
P	11°

5 Hand of tool	
L	
N	
R	



6
 25
 20

7
 25
 20

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

8 Holder length

8
 M
 K

9
 08
 3

RD	Ceramic insert with dimple
C	M-type for ceramic insert
A	Turning A

11 Added symbol

11
 A
 3


9 Insert size

Symbol	Inscribed circle (mm)	
3	9.525	<p>In the ISO metric system, edge length of inserts is expressed by L in 2 digits.</p>
4	12.7	
5	15.875	
6	19.05	
8	25.4	

10 Insert thickness

Symbol	Thickness (mm)	
2	3.18	
3	4.76	

External Toolholder - Quick Guide (Negative type)

Name	Appearance/Feature	External profiling					Turning
		Turning / Facing					
		L 95°	J 93°	N 63°	V 72.5°	P 62.5°	G 91°
TURNING Double clamp	 <ul style="list-style-type: none"> Improved clamping rigidity realizes excellent repeatability and long tool life. The enlarged surface of insert pressing provides excellent repeatability. Great performance even with VNMG type (corner angle 35°), which is particularly prone to the displacement of the cutting edge position. *Corner angle 25° and YNMG type also can be used. The simple structure contributes to cost reduction. Easy operation with one wrench. 	80°  CN□□ ACLNR/L □0904-A □12-A □16-A □19-A C016, C018	55°  DN□□ ADJNR/L □1104-A □15-A □1506-A C037, C042		35°  VN□□ AVVNN □1204-A □16-A C067, C069	55°  DN□□ ADPNN □15-A C072	60°  TN□□ ATGNR/L □16-A □22-A C087
		70°  GN□□ ACLNR/L □12-A C018	60°  TN□□ ATJNR/L □16-A C053		25°  YNMG AVVNN □16-A C069		
		80°  WN□□ AWLNR/L □06-A □08-A C029, C034	35°  VN□□ AVJNR/L □1204-A □16-A C054, C059		25°  YNMG AWJNR/L □16-A C059		
D One-Double	 <ul style="list-style-type: none"> Excellent usability that the clamp and the lever simultaneously hold the insert in tightening. The tool can be handled from the back side and provides excellent usability even when the tool is placed in the reverse. 	80°  CN□□ DCLNR/L □12 C023	55°  DN□□ DDJNR/L □15 □1506 C047				60°  TN□□ DTGNR/L □16 □22 C090
		70°  GN□□ DCLNR/L □12 C023					
		80°  WN□□ DWLNR/L □06 □08 C036					
DIMPLEFX Double clamp for dimple ceramic insert	 <ul style="list-style-type: none"> Firmly clamp the insert at two locations: drawing by dimple and holding from the top. Two locations can be clamped simultaneously with one screw. Excellent operability. The tool can be handled from the back side. Easy to change inserts when mounting those on the back. 	80°  CN□□ CCLNR/L □1207-RD C022	55°  DN□□ CDJNR/L □1507-RD C046	55°  DNGD CDNND □1507-RD C065	35°  VNGD CVVND □1607-RD C070		

Please see the page C*** for the product details.

Turning	Turning / Chamfering	Turning / Facing Chamfering	Facing		Profiling	External profiling
B-R 75° 	D 45° 	S 45° 	K 75° 	F 91° 	Q*1 · H*1 45° 	Special
90° SN□□ ASBNR/L □12-A □15-A □19-A C093	90° SN□□ ASDNN □12-A C102	90° SN□□ ASSNR/L □12-A □15-A □19-A C106	90° SN□□ ASKNR/L □12-A C109	60° TN□□ ATFNR/L □16-A □22-A C115	55° DN□□ ADQNR/L □1104-A □15-A □1506-A C118, C119 60° TN□□ ATQNR/L □16-A C122 35° VN□□ AVQNR/L □1204-A □16-A C123, C124 25° YNMG AVQNR/L □16-A C124	- RN□□ ARGNR/L □12-A C080
90° SN□□ DSBNR/L □12 C095	90° SN□□ DSDNN □12 C103	90° SN□□ DSSNR/L □12 C109	90° SN□□ DSKNR/L □12 C111	60° TN□□ DTFNR/L □16 □22 C117	55° DN□□ DDQNR/L □15 □1506 C120	- RN□□ DRGNR/L □12 C082
		90° SNGD CSSNR/L □1207-RD C108 90° HNGD CHSNR/L □0507-RD C105				

*1: Symbol used exclusively by Tungaloy

Grade	A
Insert	B
Ext. Toolholder	C
Int. Toolholder	D
Threading	E
Grooving	F
Miniature tool	G
Milling cutter	H
Endmill	I
Drilling tool	J
Tooling System	K
User's Guide	L
Index	M

External Toolholder - Quick Guide (Negative type)






















Name	Appearance/Feature	Turning / Facing		External profiling			Turning
		L 95° 	J 93° 	V 72.5° 	P 62.5° 	A 91° 	
P Lever lock	 <ul style="list-style-type: none"> • Great repeatability of the cutting edge position with the two-face holding system. Excellent performance on NC lathes and special-purpose machines. • There are many types of inserts, such as square, triangle, round, and rhombus. So are the cutting edges. • Economical downsized type is also available. 	80°  CN□□ PCLNR/L □0904 □09 □12 □16 □19 C016, C017, C019, C020, C021, G044	80°  CN□□ PCMNN □12 C132	55°  DN□□ PDJNR/L □11 □1104 □15 □1506 C037, C038, C043, C044, C045	35°  VN□□ PVVNN □1204 C068	55°  DN□□ PDPNN □15 C073	
		80°  CN□□ PCL2NR □12 G044	80°  WN□□ PWLNR/L □0604 □08 C029, C030, C034, C035	60°  TN□□ PTJNR/L □1104 C052		55°  DN□□ PDMNL □1104 C133	
		70°  GN□□ PCLNR/L □12 C019, C020, C021, G044	70°  GN□□ PCMNN □12 C132	35°  VN□□ PVJNR/L □1204 □16 C054, C055, C060, C061			
		70°  GN□□ PCL2NR □12 G044	60°  TN□□ PTL2NR/L □16 C027	25°  YNMG PVJNR/L □16 C060, C061			
H Retract pin	 <ul style="list-style-type: none"> • Toolholder for super heavy cutting 						
JT Back clamp	 <ul style="list-style-type: none"> • Toolholder that pursues usability on the machines with a narrow space for changing inserts, such as a gang tooling lathes. • Inserts can be clamped with screws from the back side of the tool, providing good usability. • Shank sizes are available in 8, 10, 12, 16 mm. 	60°  TN□□ JTTLNR/L □16 C028					
						60°  TN□□ JTANR/L □16 C075	


Please see the page C*** for the product details.

	Turning		Turning / Chamfering	Turning / Facing Chamfering	Facing		Profiling	External profiling
	G 91° 	B-R 75° 	D 45° 	S 45° 	K 75° 	F 91° 	Q*1 · H*1 45° 	Special
	60° TN□□ PTG NR/L □1104 □16 □22 C086, C088, C089	90° SN□□ PSB NR/L □09 □12 □19 C094	90° SN□□ PSD NN □09 □12 C102	90° SN□□ PSS NR/L □09 □12 □19 C107	90° SN□□ PSK NR/L □09 □12 □19 C110	60° TN□□ PTF NR/L □1104 □16 □22 C114, C116	55° DN□□ PDQ NR/L □15 C120	- RNMG PRG NR/L □09 □12 C081
		100° CN□□ PCB NR/L □12 C091				80° CN□□ PCF NR/L □12 C112	35° VN□□ PVQ NR/L □1204 □16 C123, C125	48.5° POMG PPX OR/L-HD □11-HD □13-HD C096
							25° YNMG PVQ NR/L □16 C125	22.5° POMG PPX OR/L-HF □11-HF □13-HF C096
		90° SNMM HSR NR/L □31 C095						

*1: Symbol used exclusively by Tungaloy

External Toolholder - Quick Guide (Positive type)

Name	Appearance/Feature	Turning / Facing	External profiling				Turning
		L 95°	J 93°	N 72.5°	N 62.5°	A 91°	
X Double clamp (screw-on)	 <ul style="list-style-type: none"> • Super high feed machining increases productivity by 8 times. • The insert is secured by double clamping system with clamp + clamp screw. Both the insert and the tool body achieve high rigidity. 						
P Lever lock	 <ul style="list-style-type: none"> • Clamping positive round insert with lever lock leads to good indexing accuracy. • Can be used for external turning, facing, and profiling. High-feed machining is possible. • Insert diameters: $\phi 10$, $\phi 12$, $\phi 16$, $\phi 20$, $\phi 25$ mm. 	80°  WXGU JPWL2XR/L □04 C032	55°  DXGU JPDJ2XR/L □07 C040				
J Screw-on	 <ul style="list-style-type: none"> • Suitable for machining complex small parts on small NC lathes. A great variety of cutting edge geometries. • The screw-on method firmly holds the small positive inserts. The clamp screw is a reliable and durable Torx® screw. • J type is high-precision shank with 4 faces ground. 	80°  CC□□ JSCLCR/L □06 □09 C024, G021	55°  DC□□ JSDJCR/L □07 □11 C050, G028	55°  DXGU JSDJXR/L □07 C039, G025 JSDJ2XR/L □07 C039, C040, G023, G024	35°  VB□□ JSVNB □11 G037	55°  DC□□ JSDNCN □07 □11 G036	60°  TC□□ JSTACR/L □08 □11 C076, G039
		80°  CC□□ JSCL2CR/L ⁺² □06 □09 G019, G020	55°  DC□□ JSDJ2CR/L ⁺² □07 □11 C048, G026, G027	35°  VXGU JSVJXR/L □09 C056, C058, G032 JSVJ2XR/L □09 C056, C057, G030, G031		55°  DC□□ JSDN3CR/L ⁺³ □07 □11 G036	35°  VB□□ JSVABR/L □11 G040
		80°  WXGU JSWLXR/L □04 C031, C033, G018 JSWL2XR/L □04 C031, C032, G017	55°  DXGU JSDJXR-F □07 C041, G025	35°  VB□□ JSVJBR/L □11 G035			35°  VB□□ JSVJ2BR/L □11 C062, G034
		35°  VP□□ JSVL2PR/L □08 □11 G022					

*2: L2 and J2: without offset 

Please see the page C*** for the product details.

	Turning	Turning / Facing	Facing	Profiling	External profiling	Back turning	Front turning Reverse turning
	G 91° 	X 20° 	F 91° 	P 117.5° 	Special 		
		80° WPMT XWXPR/L □09 C098					
					- RCM□ PRGCR/L □10 □12 □16 □20 C083 - RCM□ PRDCN □10 □12 □16 □20 □25 C099		
	80° CC□□ JSCGCR/L □06 □09 G041		55° DC□□ JSDFCR/L □07 □11 G043	25° VP□□ JSVP2PR/L □08 □11 G038		JXB JSXBR/L □08 G052 JTB JSTBR/L □03 G048 JTB JS□□K-TBL □3 G048 J10E JSEGR/L □10 G050	JX□□ JSXGR/L □08 G043 55° DC□□ JS□□K-SDUCL □07 □11 G029 55° DXGU JS□□□-SDUXL □07 C129, G025 35° VXGU JS□□□-SVUXL □09 C130, G032

Grade

Insert

Ext. Toolholder

Int. Toolholder

Threading

Grooving

Miniature tool

Milling cutter

Endmill

Drilling tool















Tooling System

User's Guide
















Index



External Toolholder - Quick Guide (Positive type)

Name	Appearance/Feature	Turning / Facing	External profiling				Turning	Turning / Chamfering
		L 95°	J 93°	V 72.5°	N 62.5°	A 91°	D 45°	
S Screw-on	 <ul style="list-style-type: none"> Suitable for machining complex small parts on small NC lathes. A great variety of cutting edge geometries. The screw-on method firmly holds the small positive inserts. The clamp screw is a reliable and durable Torx® screw. 	80°  CC□□ SCLCR/L □09 □12 C026	55°  DC□□ SDJCR/L □11 C051	35°  VC□□ SVVCN □16 C071	55°  DC□□ SDNCN □11 C066	60°  TC□□ STACR/L □16 C077	90°  SC□□ SSDCN □07 □09 C104	
		35°  VC□□ SVJCR/L □16 C063	25°  YWMT SYJBR/L □16 C064	90°  SP□□ SSDPN <small>Tungaloy standard</small> □07 □09 C104				
JT Back clamp	 <ul style="list-style-type: none"> Toolholder that pursues usability on the machines with a narrow space for changing inserts, such as a gang tooling lathes. Inserts can be clamped with screws from the back side of the tool, providing good usability. Shank sizes are available in 8, 10, 12, 16 mm. 	80°  CC□□ JTCL2CR/L □06 □09 C025, G020	55°  DC□□ JTDJ2CR/L □07 □11 C049, G026			60°  TC□□ JTTACR/L □08 □11 C076, G039		

Please see the page C*** for the product details.

Profiling				External profiling	Back turning	Front turning Reverse turning				
<p>Q*145° · H*17.5°</p> 		<p>H 100°</p> 		<p>I 76.5°</p> 		<p>Special</p> 				
<p>35°  VC□□ SVQCR/L □16 C126</p>		<p>55°  DC□□ SDQCR/L □11 C121</p>		<p>25°  YWMT SYHBR/L □16 C128</p>		<p>25°  YWMT SYIBN □16 C131</p>		<p>-  RCMT SRACR/L □05 □06 □08 C074</p>	<p>Note: JSXBR/L can be used with JXT threading insert.</p>	<p>Note: JSXGR/L can be used with JXG grooving insert.</p>
<p>35°  VCG□ SVHCR/L □22 C127</p>		<p>25°  YWMT SYQBR/L □16 C128</p>		<p>-  RCMT SRGCR/L □05 □06 □08 □10 □12 C084, C085</p>		<p>-  RCMT SRDCN □06 □08 □10 □12 C100, C101</p>				

*1: Symbol used exclusively by Tungaloy

TURN^{EN}FEED

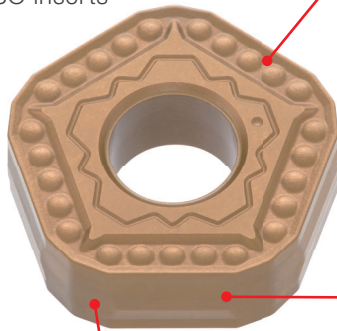


Economical, 10-cornered insert ensures high machining efficiency

- Available in 2 types of holders: HD type for large depths of cut and HF type for high feed turnin
- Maximum 7 mm depth of cut, or maximum 2.0 mm feed per rev is attainable!

Economical 10-cornered, double-sided, M-class insert

Achieves outstanding cost efficiency over standard ISO inserts



Flat Wiper

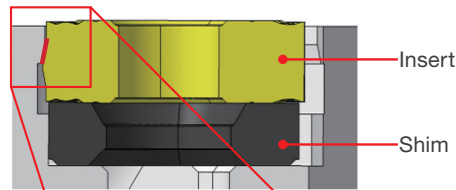
Built in the cutting edge to achieve superior machining surface at higher feed rates!

New – MNW style chipbreaker

Features protrusions on the rake face to facilitate smooth chip control, while achieving high crater wear resistance

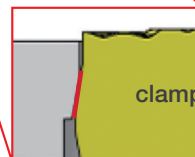
Dovetail clamping

Ensures secure insert retention while promoting smooth chip flow thanks to the integration of lever lock and dovetail clamping methods.



Insert

Shim



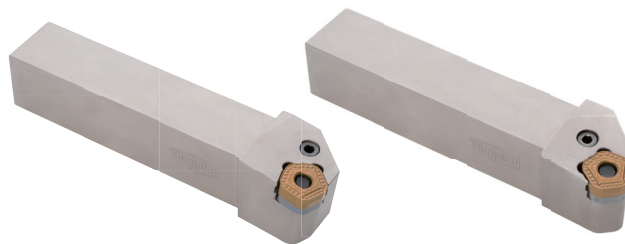
clamp contact cross section

Holder selections

Available in 2 types:

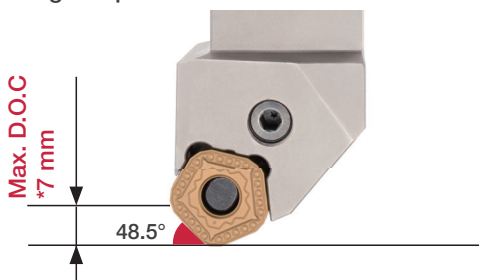
- HD holder for large depths of cut
- HF holder for high feed turning

Inserts are interchangeable between these two holders.



Features of Holders

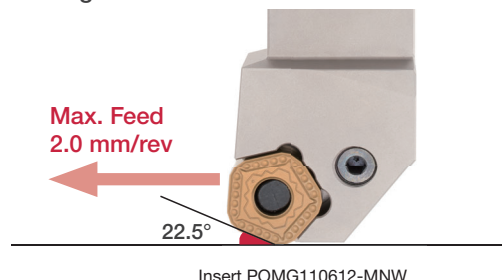
HD holder
For High Depth of Cut



Max. D.O.C
7 mm

48.5°

HF holder
For High Feed



Max. Feed
2.0 mm/rev

22.5°

Insert POMG110612-MNW

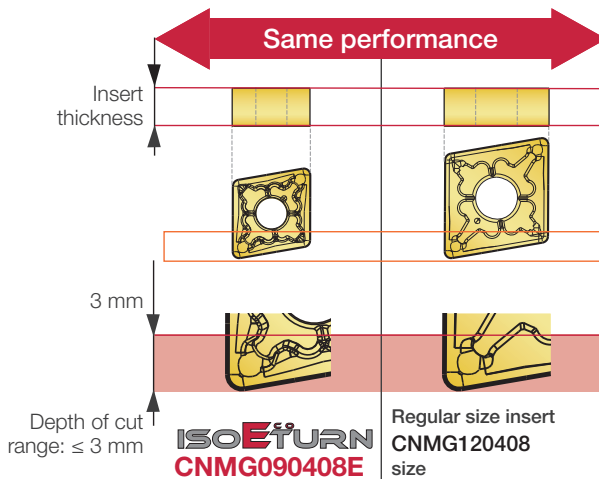
Reference pages: C096



ISO-EcoTurn Small size inserts, for an economical advantage

Uncompromising insert performance

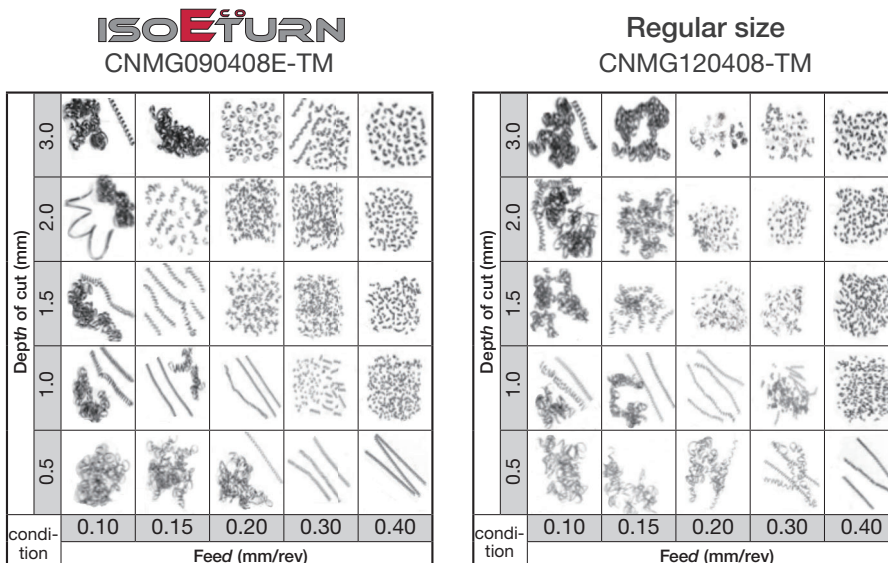
Comparison of ISO-EcoTurn and regular size inserts



ISO-EcoTurn inserts feature the identical thickness and chipbreaker geometry as Tungaloy's regular size inserts. These properties provide cutting performance equal to that of the regular size inserts, including chip control at a depth of cut up to 3 mm.

Chip control

ISO-EcoTurn inserts incorporate an identical chipbreaker geometry as regular size inserts providing the same chip removal at a depth of cut up to 3 mm.



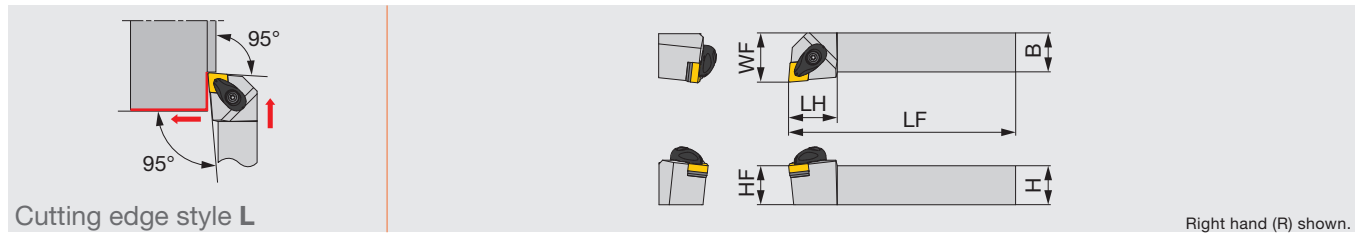
Workpiece : S45C
Cutting speed : $V_c = 200$ m/min
Coolant : Wet



ISO^{ECO}TURN

ACLNR/L-Eco

Double-clamp toolholder with 95° approach angle, for negative 80° rhombic inserts



Designation	H	B	LF	LH	HF	WF	RE**	Insert	Torque*
ACLNR/L2020K0904-A	20	20	125	25	20	25	0.8	CN**0904...	3
ACLNR/L2525M0904-A	25	25	150	25	25	32	0.8	CN**0904...	3

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

SPARE PARTS

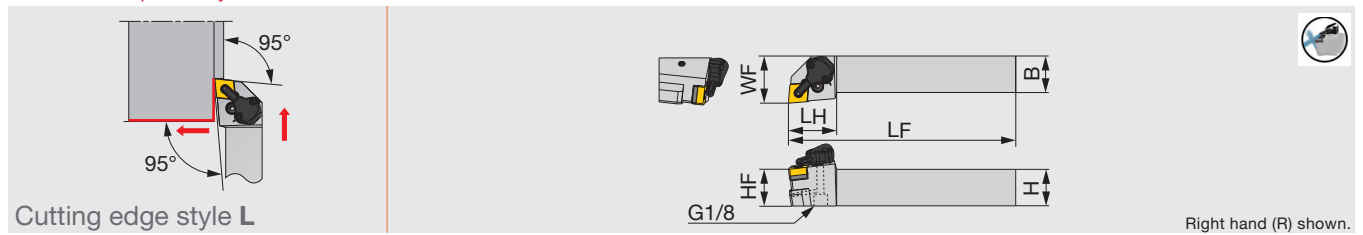
Designation	Clamp	Clamp screw	Spring	Spring pin	Shim	Shim screw	Wrench
ACLNR/L**0904-A	ACP3S-E	ACS-5W	BP-7	SP-2.5	ASC322	CSTB-3.5	T-15F

ISO^{ECO}TURN

PCLNR/L-CHP-Eco

TUNG^{TURN}TJET

Lever-lock toolholder with 95° approach angle, for negative 80° rhombic inserts, with high pressure coolant capability



Designation	H	B	LF	LH	HF	WF	RE**	Insert	Torque*
PCLNR/L2020K0904-CHP	20	20	125	33	20	32	0.8	CN**0904...	2
PCLNR/L2525M0904-CHP	25	25	150	33	25	32	0.8	CN**0904...	2

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

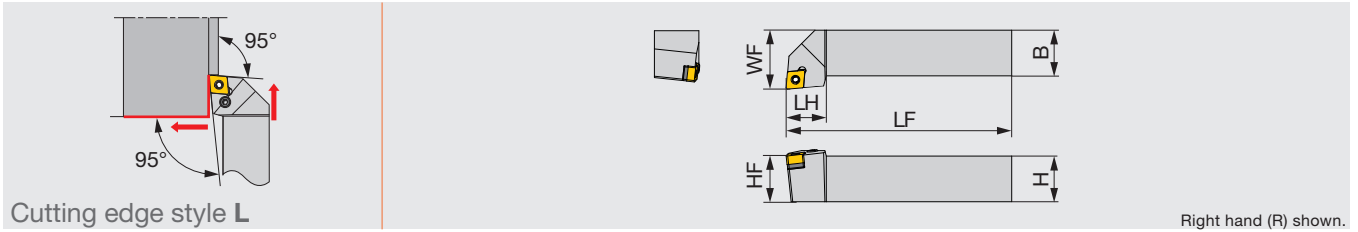
SPARE PARTS

Designation	Shim	Clamping screw	Wrench1	Spring pin	Lever
PCLNR/L**0904-CHP	LSC317	LCS3	P-2.5	LSP3	LCL33

SPARE PARTS

Designation	Coolant unit	Mounting screw	Wrench2	O-ring	Coolant screw	Wrench3
PCLNR/L**0904-CHP	CU-CW-CHP	SRM3	T-8F	OR6.4X0.9N	SRM4X4TL360	P-2

Reference pages: ACLNR/L-Eco, PCLNR/L-CHP-Eco: Inserts → **B054** -
Parts for coolant hose → **C134**



Designation	H	B	LF	LH	HF	WF	RE**	Insert	Torque*
PCLNR/L2020K0904	20	20	125	20	20	25	0.8	CN**0904...	2
PCLNR/L2525M0904	25	25	150	25	25	32	0.8	CN**0904...	2

*Torque: Recommended clamping torque (N·m)

**RE: Standard corner radius

SPARE PARTS

Designation	Shim	Clamping screw	Wrench	Spring pin	Lever
PCLNR/L**0904	LSC317	LCS3	P-2.5	LSP3	LCL33



INSERT SELECTION

P

Application	Finishing	Medium cutting
Grade	T9215	T9215
Chipbreaker shape	TSF	TM
Cutting conditions	B006	

M

Application	Finishing	Medium cutting
Grade	T6120	T6130
Chipbreaker shape	SS	SM
Cutting conditions	B008	

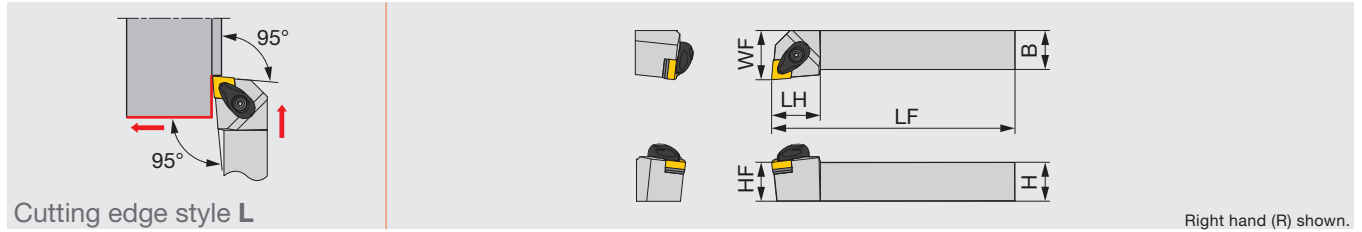
K

Application	Medium cutting
Grade	T515
Chipbreaker shape	TM
Cutting conditions	B010

S

Application	Medium cutting
Grade	AH8015
Chipbreaker shape	TM
Cutting conditions	B014

Double-clamp toolholder with 95° approach angle, for negative 80° rhombic inserts



Designation	H	B	LF	LH	HF	WF	RE**	Insert	Torque*
ACLNR/L2020H12-A	20	20	100	26	20	25	0.8	CN**1204...	3
ACLNR/L2020K12-A	20	20	125	26	20	25	0.8	CN**1204...	3
ACLNR/L2525K12-A	25	25	125	30	25	32	0.8	CN**1204...	3
ACLNR/L2525M12-A	25	25	150	30	25	32	0.8	CN**1204...	3
ACLNR/L3225P12-A	32	25	170	30	32	32	0.8	CN**1204...	3
ACLNR/L2525M16-A	25	25	150	31	25	32	1.2	CN**1606...	6.4
ACLNR/L3225P16-A	32	25	170	31	32	32	1.2	CN**1606...	6.4
ACLNR/L3232P16-A	32	32	170	31	32	40	1.2	CN**1606...	6.4
ACLNR/L3232P19-A	32	32	170	40	32	40	1.2	CN**1906...	6.4
ACLNR/L4040S19-A	40	40	250	40	40	50	1.2	CN**1906...	6.4

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

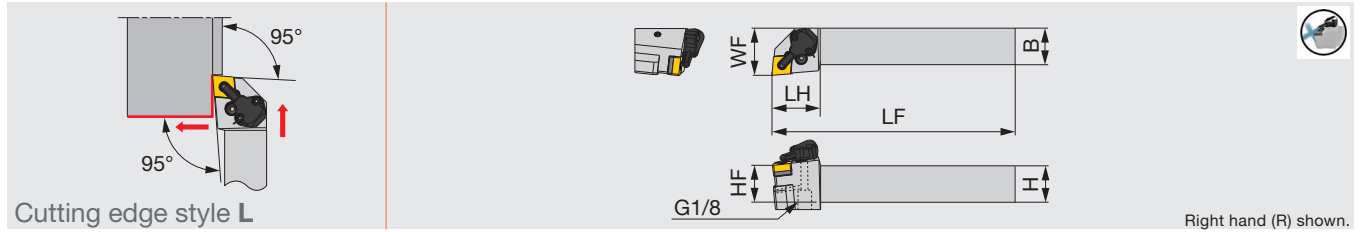
Designation	Clamp	Clamp screw	Spring	Spring pin	Shim	Shim screw	Wrench1	Wrench2
ACLNR/L**12-A	ACP4S	ACS-5W	BP-7	SP-2.5	ASC422	CSTB-3.5	T-15F	-
ACLNR/L**16-A	ACP5S	ACS-6W	BP-8.8	SP-2.5	ASC533	CSTB-5	-	KEYV-T20
ACLNR/L**19-A	ACP6S	ACS-6W	BP-8.8	SP-2.5	ASC634	CSTB-5	-	KEYV-T20

INSERT SELECTION

P	Application	Precision finishing	Finishing	Medium cutting	Medium to heavy cutting
	Grade	NS9530	GT9530	T9215	T9215
	Chipbreaker shape	TF	TSF	TM	TH
	Cutting conditions	B006			
M	Application	Finishing	Medium cutting	Medium to heavy cutting	
	Grade	T6120	T6130	T6130	
	Chipbreaker shape	SF	SM	SH	
	Cutting conditions	B008			
K	Application	Finishing	Medium cutting	Medium to heavy cutting	
	Grade	T515	T515	T515	
	Chipbreaker shape	All-round	All-round	All-round	
	Cutting conditions	B010			
N	Application	Precision finishing	Finishing	Medium cutting	
	Grade	DX120	DX140	TH10	
	Chipbreaker shape	T-DIA	with rake T-DIA	P	
	Cutting conditions	B012			
S	Application	Precision finishing	Finishing	Medium cutting	
	Grade	BX470	AH8005	AH8005	
	Chipbreaker shape	T-CBN	HRF	HRM	
	Cutting conditions	B014			
H	Application	Precision finishing	Finishing		
	Grade	BXM10	BXM20		
	Chipbreaker shape	T-CBN	T-CBN		
	Cutting conditions	B016			

Reference pages: ACLNR/L: Inserts → B054 -, CBN → B170 -, PCD → B192 -

Lever-lock toolholder, for negative 80° rhombic inserts, with high pressure coolant capability



Designation	H	B	LF	LH	HF	WF	RE**	Insert	Torque*
PCLNR/L2020K12-CHP	20	20	125	33	20	32	0.8	CN/GN**1204...	3
PCLNR/L2525M12-CHP	25	25	150	33	25	32	0.8	CN/GN**1204...	3

*Torque: Recommended clamping torque (N·m)

**RE: Standard corner radius

SPARE PARTS

Designation	Shim	Clamping screw	Wrench1	Spring pin	Lever
PCLNR/L**12-CHP	LSC42	LCS4	P-3	LSP4	LCL4

SPARE PARTS

Designation	Coolant unit	Mounting screw	Wrench2	O-ring	Coolant screw	Wrench3
PCLNR/L**12-CHP	CU-CW-CHP	SRM3	T-8F	OR6.4X0.9N	SRM4X4TL360	P-2

INSERT SELECTION

Application	Precision finishing	Finishing	Medium cutting	Medium to heavy cutting
	Grade	NS9530	GT9530	T9215
Chipbreaker shape	TF	TSF	TM	TH
Cutting conditions	B006			

Application	Finishing	Medium cutting	Medium to heavy cutting
	Grade	T6120	T6130
Chipbreaker shape	SF	SM	SH
Cutting conditions	B008		

Application	Finishing	Medium cutting	Medium to heavy cutting
	Grade	T515	T515
Chipbreaker shape	All-round	All-round	All-round
Cutting conditions	B010		

Application	Precision finishing	Finishing	Medium cutting
	Grade	DX120	DX140
Chipbreaker shape	T-DIA	with rake T-DIA	P
Cutting conditions	B012		

Application	Precision finishing	Finishing	Medium cutting
	Grade	BX470	AH8005
Chipbreaker shape	T-CBN	HRF	HRM
Cutting conditions	B014		

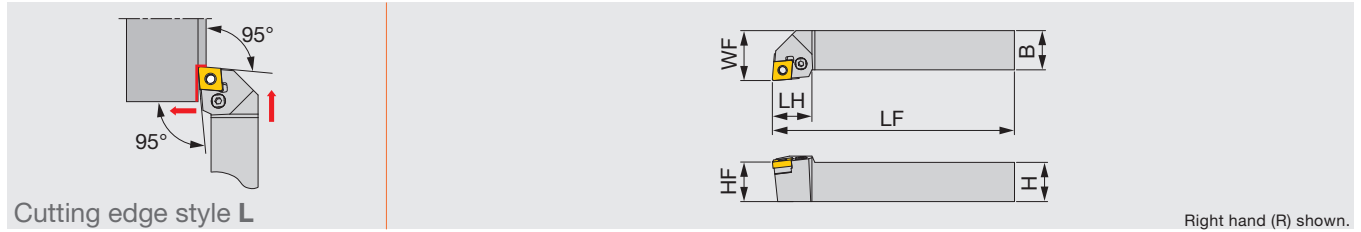
Application	Precision finishing	Finishing
	Grade	BXM10
Chipbreaker shape	T-CBN	T-CBN
Cutting conditions	B016	

Reference pages: PCLNR/L-CHP: Inserts → **B054** -, CBN → **B170** -, PCD → **B192** -
Parts for coolant hose → **C134**



PCLNR/L

Lever-lock toolholder with 95° approach angle, for negative 80° rhombic inserts



Right hand (R) shown.

Designation	H	B	LF	LH	HF	WF	RE**	Insert
PCLNR/L1616H09	16	16	100	20	16	20	0.8	CN**0903...
PCLNR/L2020K09	20	20	125	20	20	25	0.8	CN**0903...
PCLNR/L2525M09	25	25	150	20	25	32	0.8	CN**0903...
PCLNR/L1616	16	16	100	26	16	20	0.8	CN/GN**1204...
PCLNR/L2020	20	20	125	28	20	25	0.8	CN/GN**1204...
PCLNR/L2525M4	25	25	150	28	25	32	0.8	CN/GN**1204...
PCLNR/L3225P4	32	25	170	28	32	32	0.8	CN/GN**1204...
PCLNR/L3232	32	32	170	40	32	40	1.2	CN**1906...
PCLNR/L1616H12E	16	16	100	26	16	20	0.8	CN/GN**1204...
PCLNR/L2020K12E	20	20	125	28	20	25	0.8	CN/GN**1204...
PCLNR/L2525M12E	25	25	150	28	25	32	0.8	CN/GN**1204...
PCLNR/L3225P12E	32	25	170	28	32	32	0.8	CN/GN**1204...
PCLNR/L2525M16E	25	25	150	31	25	25	1.2	CN**1606...
PCLNR/L3225P16E	32	25	150	31	32	32	1.2	CN**1606...
PCLNR3232P16E	32	32	170	31	32	40	1.2	CN**1606...
PCLNR/L3232P19E	32	32	170	40	32	40	1.2	CN**1906...

**RE: Standard corner radius

SPARE PARTS

Designation	Shim	Clamping screw	Wrench	Spring pin	Lever
PCLNR/L1616H09	ELSC32	LCS3	P-2.5	LSP3L	LCL33
PCLNR/L2020K09	ELSC32	LCS3	P-2.5	LSP3L	LCL33
PCLNR/L2525M09	ELSC32	LCS3	P-2.5	LSP3L	LCL33
PCLNR/L1616	LSC42	LCS4CA	P-3	LSP4	LCL4
PCLNR/L2020	LSC42	LCS4	P-3	LSP4	LCL4
PCLNR/L2525M4	LSC42	LCS4	P-3	LSP4	LCL4
PCLNR/L3225P4	LSC42	LCS4	P-3	LSP4	LCL4
PCLNR/L3232	LSC63	LCS6	P-4	LSP6	LCL6
PCLNR/L1616H12E	ELSC42	LCS4CA	P-3	LSP4S	LCL43S
PCLNR/L2020K12E	ELSC42	LCS4	P-3	LSP4S	LCL43M
PCLNR/L2525M12E	ELSC42	LCS4	P-3	LSP4S	LCL43M
PCLNR/L3225P12E	ELSC42	LCS4	P-3	LSP4S	LCL43M
PCLNR/L2525M16E	ELSC53	LCS5	P-3	LSP6C	LCL54
PCLNR/L3225P16E	ELSC53	LCS5	P-3	LSP6C	LCL54
PCLNR/L3232P16E	ELSC53	LCS5	P-3	LSP6C	LCL54
PCLNR/L3232P19E	ELSC63	LCS6	P-4	LSP6	LCL6

INSERT SELECTION

Application	Precision finishing	Finishing	Medium cutting	Medium to heavy cutting
	Grade	Grade	Grade	Grade
	NS9530	GT9530	T9215	T9215
Chipbreaker shape	TF	TSF	TM	TH
Cutting conditions	B006			

Application	Finishing	Medium cutting	Medium to heavy cutting
	Grade	Grade	Grade
	T6120	T6130	T6130
Chipbreaker shape	SF	SM	SH
Cutting conditions	B008		

Application	Finishing	Medium cutting	Medium to heavy cutting
	Grade	Grade	Grade
	T515	T515	T515
Chipbreaker shape	All-round	All-round	All-round
Cutting conditions	B010		

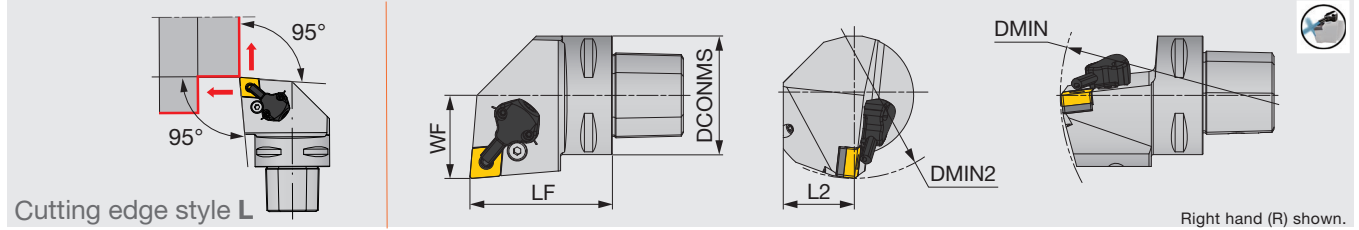
Application	Precision finishing	Finishing	Medium cutting
	Grade	Grade	Grade
	DX120	DX140	TH10
Chipbreaker shape	T-DIA	with rake T-DIA	P
Cutting conditions	B012		

Application	Precision finishing	Finishing	Medium cutting
	Grade	Grade	Grade
	BX470	AH8005	AH8005
Chipbreaker shape	T-CBN	HRF	HRM
Cutting conditions	B014		

Application	Precision finishing	Finishing
	Grade	Grade
	BXM10	BXM20
Chipbreaker shape	T-CBN	T-CBN
Cutting conditions	B016	

Reference pages: PCLNR/L: Inserts → B054 -, CBN → B170 -, PCD → B192 -

Lever-lock toolholder with TungCap connection, for negative 80° rhombic inserts, with high pressure coolant capability



Designation	DCONMS	LF	L2	WF	DMIN	DMIN2	RE**	Insert
C4PCLNR/L27050-0904-CHP	40	50	25	27	140	110	0.8	CN**0904...
C4PCLNR/L27050-12-CHP	40	50	25	27	140	110	0.8	CN/GN**1204...
C5PCLNR/L35060-12-CHP	50	60	32	35	165	110	0.8	CN/GN**1204...
C6PCLNR/L45065-0904-CHP	63	65	41	45	190	125	0.8	CN**0904...
C6PCLNR/L45065-12-CHP	63	65	41	45	190	125	0.8	CN/GN**1204...

**RE: Standard corner radius

INSERT SELECTION

P	Application	Precision finishing	Finishing	Medium cutting	Medium to heavy cutting
	Grade	NS9530	GT9530	T9215	T9215
	Chipbreaker shape	TF	TSF	TM	TH
	Cutting conditions	B006			

M	Application	Finishing	Medium cutting	Medium to heavy cutting
	Grade	T6120	T6130	T6130
	Chipbreaker shape	SF	SM	SH
	Cutting conditions	B008		

K	Application	Finishing	Medium cutting	Medium to heavy cutting
	Grade	T515	T515	T515
	Chipbreaker shape	All-round	All-round	All-round
	Cutting conditions	B010		

N	Application	Precision finishing	Finishing	Medium cutting
	Grade	DX120	DX140	TH10
	Chipbreaker shape	T-DIA	with rake T-DIA	P
	Cutting conditions	B012		

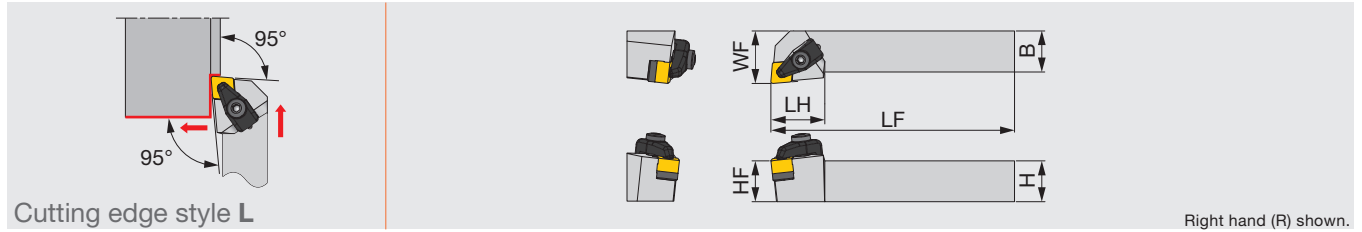
S	Application	Precision finishing	Finishing	Medium cutting
	Grade	BX470	AH8005	AH8005
	Chipbreaker shape	T-CBN	HRF	HRM
	Cutting conditions	B014		

H	Application	Precision finishing	Finishing
	Grade	BXM10	BXM20
	Chipbreaker shape	T-CBN	T-CBN
	Cutting conditions	B016	

Reference pages: C-PCLNR/L-CHP: Inserts → **B054** -, CBN → **B170** -, PCD → **B192** -
Parts for coolant hose → **C134**



Double-clamp toolholder with 95° approach angle, for negative 80° rhombic ceramic inserts with dimple



Designation	H	B	LF	LH	HF	WF	RE**	Insert	Torque*
CCLNR/L2525M1207-RD	25	25	150	33	25	32	1.2	CN*D1207...	4
CCLNR3225P1207-RD	32	25	170	33	32	32	1.2	CN*D1207...	4

*Torque: Recommended clamping torque (N·m)

**RE: Standard corner radius

SPARE PARTS

Designation	Clamp	Clamp screw	Shim	Shim screw	Spring	Wrench1	Wrench2
CCLNR/L*-RD	CCP4-A	CCS4-A	CC44-A	BH5-10-A	BP-5-A	P-3	P-4

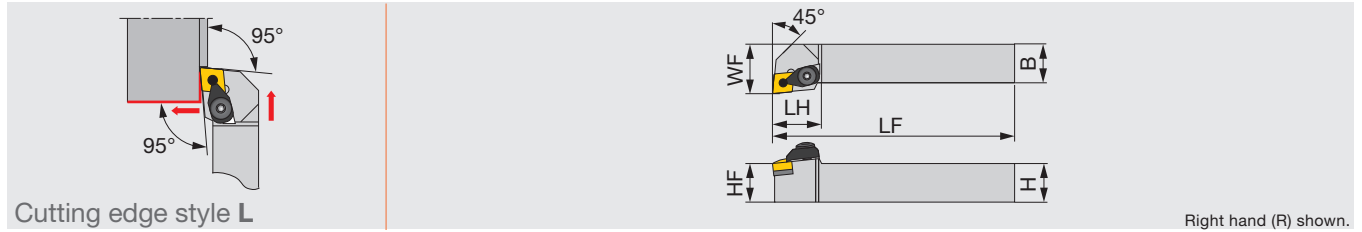
INSERT SELECTION

K	Application	Finishing to medium cutting
	Grade	FX105
	Chipbreaker shape	
	Cutting conditions	C136

Reference pages: CCLNR/L-RD: Inserts → **B064**,
Standard cutting conditions → **C136**

DCLNR/L

"One-Double" toolholder with 95° approach angle, for negative 80° rhombic inserts



Designation	H	B	LF	LH	HF	WF	RE**	Insert
DCLNR/L2020K12	20	20	125	30	20	25	0.8	CN**1204...
DCLNR/L2525M12	25	25	150	30	25	32	0.8	CN**1204...
DCLNR/L3225P12	32	25	170	30	32	32	0.8	CN**1204...

Note: Except for 57-type chipbreaker inserts

**RE: Standard corner radius

SPARE PARTS

Designation	Clamp	Lever	Piston	Clamp screw	Shim	Spring	Spring pin	Wrench1	Wrench2
DCLNR/L...	DCPM-43	DLCL43	DPIS43	DLCS43	LSC42	BP-10	LSP4	P-3	P-4

INSERT SELECTION

Application	Precision finishing	Finishing	Medium cutting	Medium to heavy cutting
	Grade	NS9530	GT9530	T9215
Chipbreaker shape	TF	TSF	TM	TH
Cutting conditions	B006			

Application	Finishing	Medium cutting	Medium to heavy cutting
	Grade	T6120	T6130
Chipbreaker shape	SF	SM	SH
Cutting conditions	B008		

Application	Finishing	Medium cutting	Medium to heavy cutting
	Grade	T515	T515
Chipbreaker shape	All-round	All-round	All-round
Cutting conditions	B010		

Application	Precision finishing	Finishing	Medium cutting
	Grade	DX120	DX140
Chipbreaker shape	T-DIA	with rake T-DIA	P
Cutting conditions	B012		

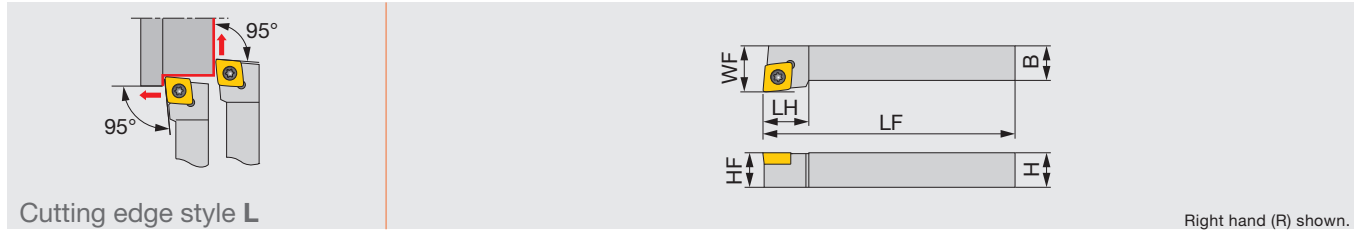
Application	Precision finishing	Finishing	Medium cutting
	Grade	BX480	AH8005
Chipbreaker shape	T-CBN	HRF	HRM
Cutting conditions	B014		

Application	Precision finishing	Finishing
	Grade	BXM10
Chipbreaker shape	T-CBN	T-CBN
Cutting conditions	B016	

Reference pages: DCLNR/L: Inserts → B054 -, CBN → B170 -, PCD → B192 -



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



Right hand (R) shown.

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

*Torque: Recommended clamping torque (N-m)

**RE: Standard corner radius

SPARE PARTS

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

INSERT SELECTION

Application	Precision finishing	Finishing	Finishing to medium cutting	Medium cutting
	SH725	SH725	T9215	T9215
Grade	01	JS	PS	PM
Chipbreaker shape				
Cutting conditions	B018			

Application	Precision finishing	Finishing	Finishing to medium cutting	Medium cutting
	SH725	SH725	T9215	T9215
Grade	01	JS	PS	PM
Chipbreaker shape				
Cutting conditions	B020			

Application	Finishing to medium cutting
	T515
Grade	CM
Chipbreaker shape	
Cutting conditions	B022

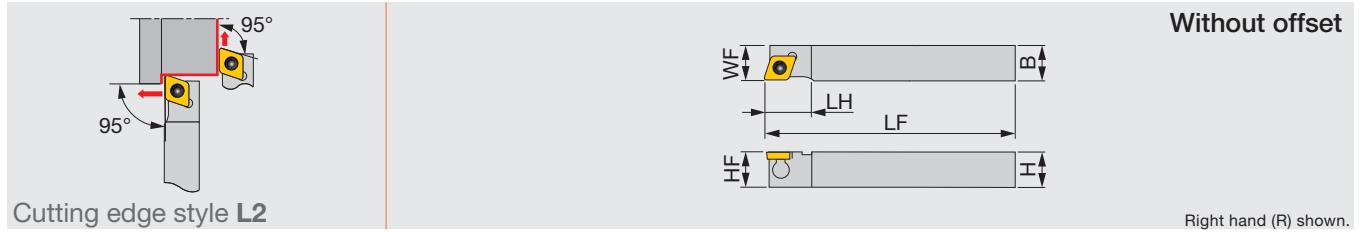
Application	Precision finishing	Finishing	Medium cutting
	DX120	TH10	KS05F
Grade	T-DIA	with rake W20	AL
Chipbreaker shape			
Cutting conditions	B024		

Application	Precision finishing	Finishing to medium cutting
	BX470	AH8005
Grade	T-CBN	PS
Chipbreaker shape		
Cutting conditions	B026	

Application	Precision finishing	Finishing
	BXM10	BXM20
Grade	T-CBN	T-CBN
Chipbreaker shape		
Cutting conditions	B028	

Reference pages: JSCLCR/L: Inserts → B109 -, CBN → B180 -, PCD → B194 -

Back-clamp toolholder with 95° approach angle, for positive 80° rhombic inserts



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

*Torque: Recommended clamping torque (N·m)

**RE: Standard corner radius

SPARE PARTS



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

INSERT SELECTION

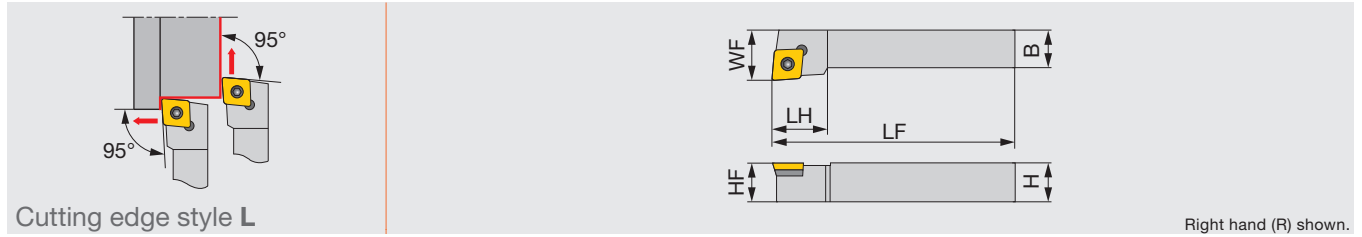
P	Application	Precision finishing	Finishing	Finishing to medium cutting	Medium cutting
	Grade	SH725	SH725	T9215	T9215
	Chipbreaker shape	01	JS	PS	PM
	Cutting conditions	B018			
M	Application	Precision finishing	Finishing	Finishing to medium cutting	Medium cutting
	Grade	SH725	SH725	T9215	T9215
	Chipbreaker shape	01	JS	PS	PM
	Cutting conditions	B020			
K	Application	Finishing to medium cutting			
	Grade	T515			
	Chipbreaker shape	CM			
	Cutting conditions	B022			
N	Application	Precision finishing	Finishing	Medium cutting	
	Grade	DX120	TH10	KS05F	
	Chipbreaker shape	T-DIA with rake W20	AL		
	Cutting conditions	B024			
S	Application	Precision finishing	Finishing to medium cutting		
	Grade	BX470	AH8005		
	Chipbreaker shape	T-CBN	PS		
	Cutting conditions	B026			
H	Application	Precision finishing	Finishing		
	Grade	BXM10	BXM20		
	Chipbreaker shape	T-CBN	T-CBN		
	Cutting conditions	B028			

Reference pages: JTCL2CR/L: Inserts → B109 -, CBN → B180 -, PCD → B194 -



SCLCR/L

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



Designation	H	B	LF	LH	HF	WF	RE**	Insert
SCLCR/L1616H09	16	16	100	16	16	20	0.8	CC**09T3...
SCLCR/L2020K12	20	20	125	20	20	25	0.8	CC**1204...

**RE: Standard corner radius

SPARE PARTS

Designation	Clamping screw	Shim screw	Shim	Wrench1	Wrench2
SCLCR/L1616H09	CSTB-3.5L	DTS5-3.5	SSC32	P-3.5	T-15F
SCLCR/L2020K12	CSTB-4F	DTS6-4	SSC4T3	P-4	T-15F

INSERT SELECTION

Application	Precision finishing	Finishing	Finishing to medium cutting	Medium cutting
	Grade	NS9530	NS9530	T9215
Chipbreaker shape	01	PSS	PS	PM
Cutting conditions	B018			

Application	Precision finishing	Finishing	Finishing to medium cutting	Medium cutting
	Grade	GH330	AH725	AH630
Chipbreaker shape	W**	PSF	PSS	PM
Cutting conditions	B020			

Application	Finishing to medium cutting	
	Grade	T515
Chipbreaker shape	CM	CM
Cutting conditions	B022	

Application	Precision finishing	Finishing	Medium cutting
	Grade	DX120	DX140
Chipbreaker shape	T-DIA	with rake T-DIA	AL
Cutting conditions	B024		

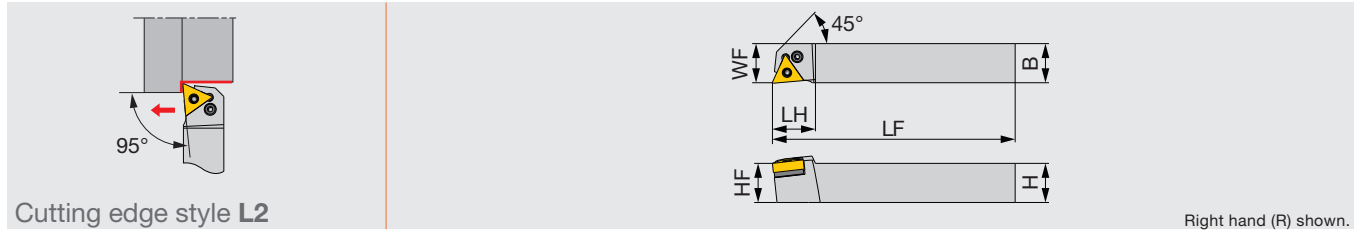
Application	Finishing	Finishing to medium cutting
	Grade	AH8015
Chipbreaker shape	PSS	PS
Cutting conditions	B026	

Application	Precision finishing	Finishing
	Grade	BXM10
Chipbreaker shape	T-CBN	T-CBN
Cutting conditions	B028	

Reference pages: SCLCR/L: Inserts → B109 -, CBN → B180 -, PCD → B194 -

PTL2NR/L

Lever-lock toolholder with 95° approach angle, for negative 60° triangular inserts



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

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

SPARE PARTS

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

INSERT SELECTION

Application	Precision finishing	Finishing	Medium cutting	Medium to heavy cutting
	Grade	NS9530	GT9530	T9215
Chipbreaker shape	TF	TSF	TM	TH
Cutting conditions	B006			

Application	Finishing	Medium cutting
	Grade	T6120
Chipbreaker shape	SF	SM
Cutting conditions	B008	

Application	Finishing	Medium cutting	Medium to heavy cutting
	Grade	T515	T515
Chipbreaker shape	All-round	All-round	All-round
Cutting conditions	B010		

Application	Precision finishing	Finishing	Medium cutting
	Grade	DX120	DX140
Chipbreaker shape	T-DIA	with rake T-DIA	P
Cutting conditions	B012		

Application	Precision finishing	Finishing	Medium cutting
	Grade	BX470	AH8005
Chipbreaker shape	T-CBN	HRF	HRM
Cutting conditions	B014		

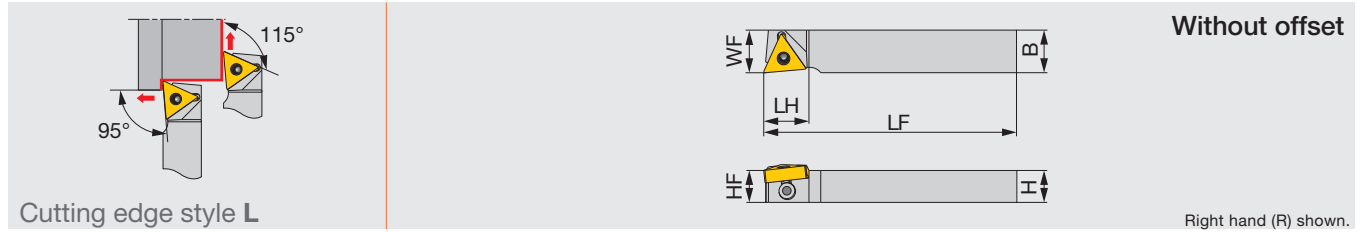
Application	Precision finishing	Finishing
	Grade	BXM10
Chipbreaker shape	T-CBN	T-CBN
Cutting conditions	B016	

Reference pages: PTL2NR/L: Inserts → B084 -, CBN → B176 -, PCD → B192 -

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



Back-clamp toolholder with 95° approach angle, for negative 60° triangular inserts



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

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

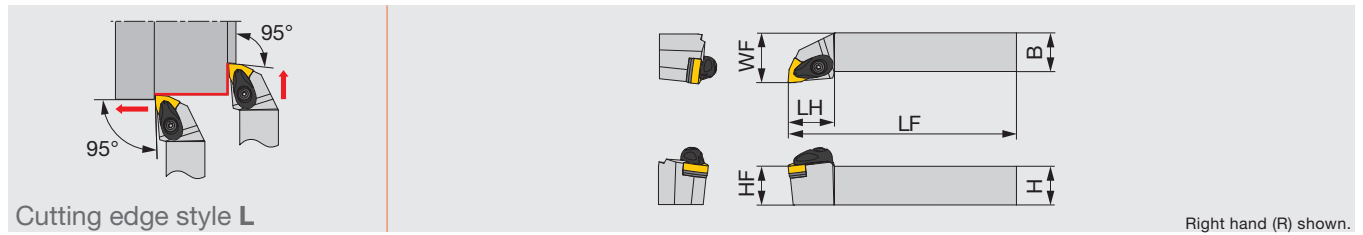
SPARE PARTS			
Designation	Clamp	Clamping screw	Wrench
JTTLNR/L...	JCP-3N	JDS-5040	P-2.5F

INSERT SELECTION

P	Application	Precision finishing	M	Application	Precision finishing	
	Grade	SH725		Grade	SH725	
	Chipbreaker shape	01		Chipbreaker shape	01	
	Cutting conditions	B006		Cutting conditions	B008	
K	Application	Finishing to medium cutting	N	Application	Precision finishing	
	Grade	T515		Grade	DX120	
	Chipbreaker shape	CM		Chipbreaker shape	T-DIA with rake	
	Cutting conditions	B010		Cutting conditions	B012	
S	Application	Precision finishing	H	Application	Precision finishing	Finishing
	Grade	BX470		Grade	BXM10	BXM20
	Chipbreaker shape	T-CBN		Chipbreaker shape	T-CBN	T-CBN
	Cutting conditions	B014		Cutting conditions	B016	

Reference pages: JTTLNR/L: Inserts → B084 -, CBN → B176 -, PCD → B192 -

Double-clamp toolholder with 95° approach angle, for negative 80° trigon inserts

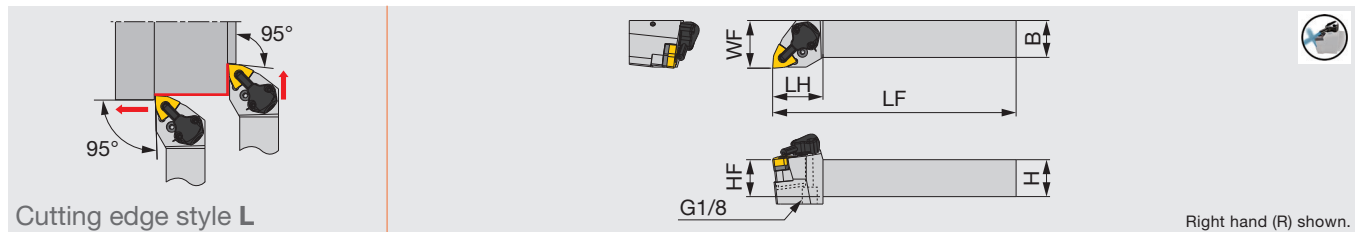


Designation	H	B	LF	LH	HF	WF	RE**	Insert	Torque*
AWLNR/L2020K0604-A	20	20	125	27	20	25	0.8	WN**0604...	3
AWLNR/L2525M0604-A	25	25	150	27	25	32	0.8	WN**0604...	3

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

Designation	Clamp	Clamp screw	Spring	Spring pin	Shim	Shim screw	Wrench
AWLNR/L**0604-A	ACP3S-E	ACS-5W	BP-7	SP-2.5	ASW322	CSTB-3.5	T-15F

Lever-lock toolholder with 95° approach angle, for negative 80° trigon inserts, with high pressure coolant capability



Designation	H	B	LF	LH	HF	WF	RE**	Insert	Torque*
PWLNR/L2020K0604-CHP	20	20	125	34	20	32	0.8	WN**0604...	2
PWLNR/L2525M0604-CHP	25	25	150	34	25	32	0.8	WN**0604...	2

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

Designation	Shim	Clamping screw	Wrench1	Spring pin	Lever
PWLNR/L**0604-CHP	LSW312	LCS3	P-2.5	LSP3	LCL3

Designation	Coolant unit	Mounting screw	Wrench2	O-ring	Coolant screw	Wrench3
PWLNR/L**0604-CHP	CU-CW-CHP	SRM3	T-8F	OR6.4X0.9N	SRM4X4TL360	P-2

INSERT SELECTION

Application	Finishing	Medium cutting
	Grade	T9215
Chipbreaker shape	TSF	TM
Cutting conditions		
B006		

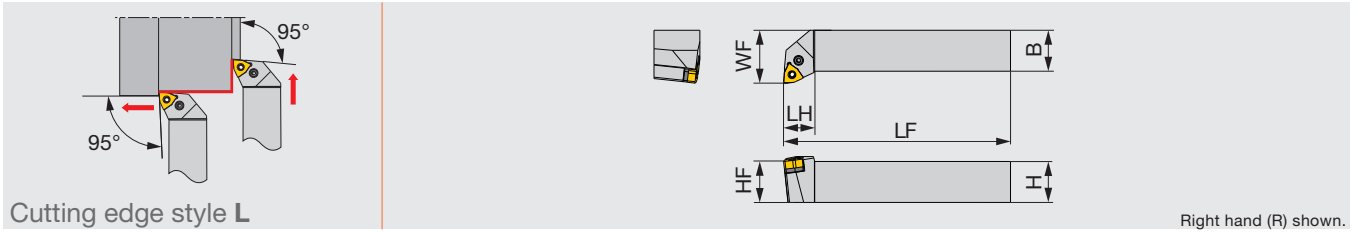
Application	Finishing	Medium cutting
	Grade	T6120
Chipbreaker shape	SS	SM
Cutting conditions		
B008		

Application	Medium cutting
Grade	T515
Chipbreaker shape	TM
Cutting conditions	
B010	

Reference pages: AWLNR/L-Eco, PWLNR/L-CHP: Inserts → **B100** -
Parts for coolant hose → **C134**



Lever-lock toolholder with 95° approach angle, for negative 80° trigon inserts



Designation	H	B	LF	LH	HF	WF	RE**	Insert	Torque*
PWLNR/L2020K0604	20	20	125	15	20	25	0.8	WN**0604...	2
PWLNR/L2525M0604	25	25	150	19	25	32	0.8	WN**0604...	2

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

SPARE PARTS

Designation	Shim	Clamping screw	Wrench	Spring pin	Lever
PWLNR/L**0604	LSW312	LCS3	P-2.5	LSP3	LCL3

INSERT SELECTION

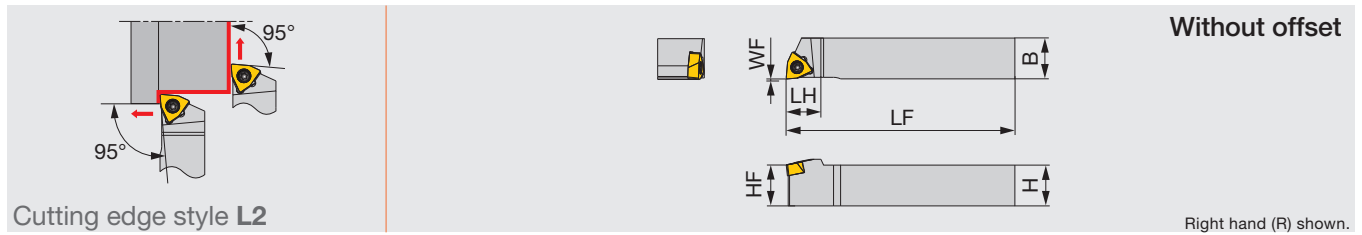
P	Application	Finishing	Medium cutting
	Grade	T9215	T9215
Chipbreaker shape	TSF	TM	TM
Cutting conditions	B006		

M	Application	Finishing	Medium cutting
	Grade	SS	T6120
Chipbreaker shape	SS	SM	SM
Cutting conditions	B008		

K	Application	Medium cutting
	Grade	T515
Chipbreaker shape	TM	
Cutting conditions	B010	

Reference pages: PWLNR/L-Eco: Inserts → **B100 -**

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



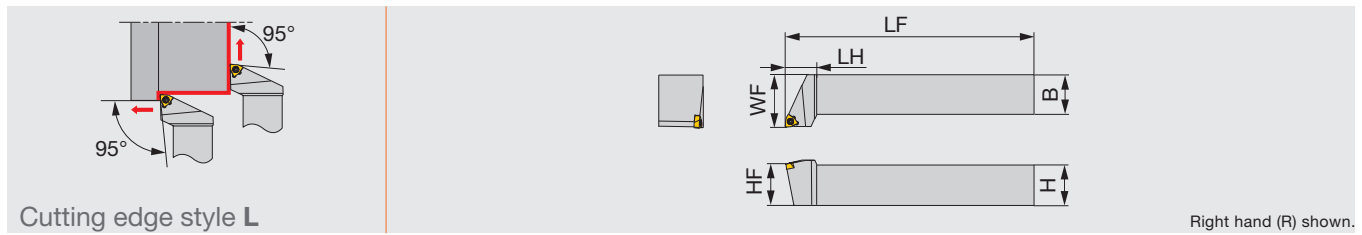
Designation	H	B	LF	LH	HF	WF	RE**	Insert	Torque*
JSWL2XR/L1010X04	10	10	120	11	10	0	0.2	WXGU0403**L/R...	0.9
JSWL2XR/L1212F04	12	12	85	11	12	0	0.2	WXGU0403**L/R...	0.9
JSWL2XR/L1212X04	12	12	120	11	12	0	0.2	WXGU0403**L/R...	0.9
JSWL2XR/L1616X04	16	16	120	13	16	0	0.2	WXGU0403**L/R...	0.9
JSWL2XR/L2020H04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

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

SPARE PARTS

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

Lever-lock toolholder with 95° approach angle, for negative 80° trigon inserts



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

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

SPARE PARTS

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

INSERT SELECTION

Swiss lathes

Application	Finishing		Medium cutting	
	Grade	Grade	Grade	Grade
Chipbreaker shape	JSS	SH725	JTS	AH725
Cutting conditions		C135		

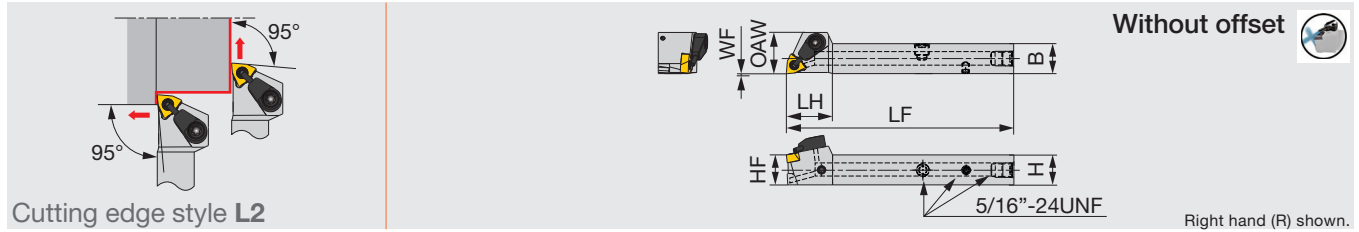
Small CNC lathes

Application	Finishing		Medium cutting	
	Grade	Grade	Grade	Grade
Chipbreaker shape	SS	AH725	TS	AH725
Cutting conditions		C135		

Reference pages: JSWL2XR/L, JSWLXR/L: Inserts → **B158** -
 Standard cutting conditions → **C135**



Screw-on toolholder with 95° approach angle, for WXGU inserts, with high pressure coolant capability



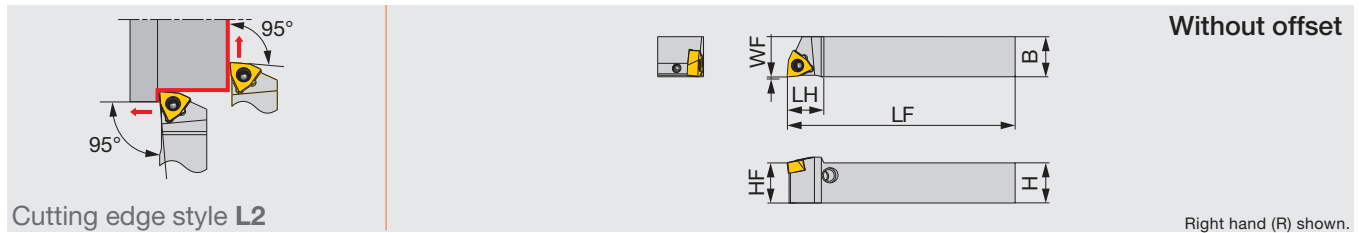
Designation	H	B	LF	LH	HF	WF	OAW	RE**	Insert	Torque*
JSWL2XR/L1212F04-CHP	12	12	85	18	12	0	16.5	0.2	WXGU0403**L/R...	0.9
JSWL2XR/L1212X04-CHP ⁽¹⁾	12	12	120	18.5	12	0	16.5	0.2	WXGU0403**L	0.9
JSWL2XR/L1616X04-CHP ⁽¹⁾	16	16	120	18.5	16	0	16.5	0.2	WXGU0403**L	0.9

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

SPARE PARTS

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

Back-clamp toolholder with 95° approach angle, for WXGU inserts



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

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

SPARE PARTS

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

INSERT SELECTION

Swiss lathes

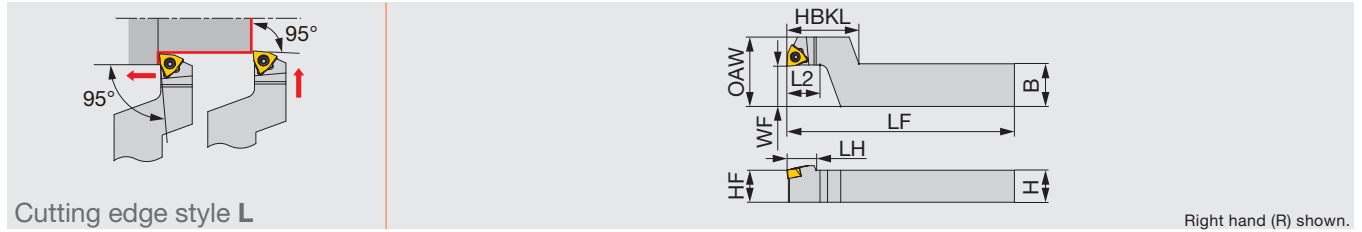
Application	Finishing		Medium cutting	
	Grade	Chipbreaker shape	Grade	Chipbreaker shape
P	SH725	JSS	AH725	JTS
	Cutting conditions → C135			
M	SH725	JSS	AH725	JTS
	Cutting conditions → C135			

Small CNC lathes

Application	Finishing		Medium cutting	
	Grade	Chipbreaker shape	Grade	Chipbreaker shape
P	AH725	SS	AH725	TS
	Cutting conditions → C135			
M	AH8015	SS	AH8015	TS
	Cutting conditions → C135			

Reference pages: JSWL2XR/L-CHP, JPWL2XR/L: Inserts → **B158** -
 Standard cutting conditions → **C135**

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



Cutting edge style L

Right hand (R) shown.

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

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

SPARE PARTS

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

INSERT SELECTION

Swiss lathes

Application	Finishing	Medium cutting
	Grade	SH725
Chipbreaker shape	JSS	JTS
Cutting conditions	C135	

Application	Finishing	Medium cutting
	Grade	SH725
Chipbreaker shape	JSS	JTS
Cutting conditions	C135	

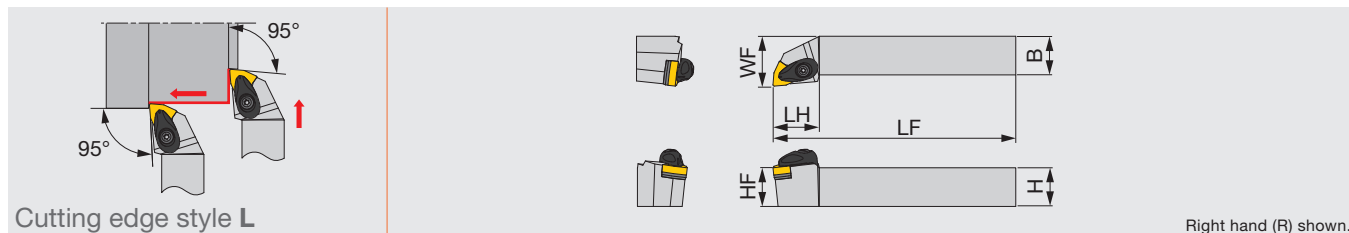
Small CNC lathes

Application	Finishing	Medium cutting
	Grade	AH725
Chipbreaker shape	SS	TS
Cutting conditions	C135	

Application	Finishing	Medium cutting
	Grade	AH8015
Chipbreaker shape	SS	TS
Cutting conditions	C135	

Reference pages: JSWLXR-F: Inserts → [B158](#) -
Standard cutting conditions → [C135](#)

Double-clamp toolholder with 95° approach angle, for negative 80° trigon inserts



Designation	H	B	LF	LH	HF	WF	RE**	Insert	Torque*
AWLNR/L2020H08-A	20	20	100	30	20	25	0.8	WN**0804...	3
AWLNR/L2020K08-A	20	20	125	30	20	25	0.8	WN**0804...	3
AWLNR/L2525K08-A	25	25	125	30	25	32	0.8	WN**0804...	3
AWLNR/L2525M08-A	25	25	150	30	25	32	0.8	WN**0804...	3
AWLNR/L3225P08-A	32	25	170	30	32	32	0.8	WN**0804...	3

*Torque: Recommended clamping torque (N·m)

**RE: Standard corner radius

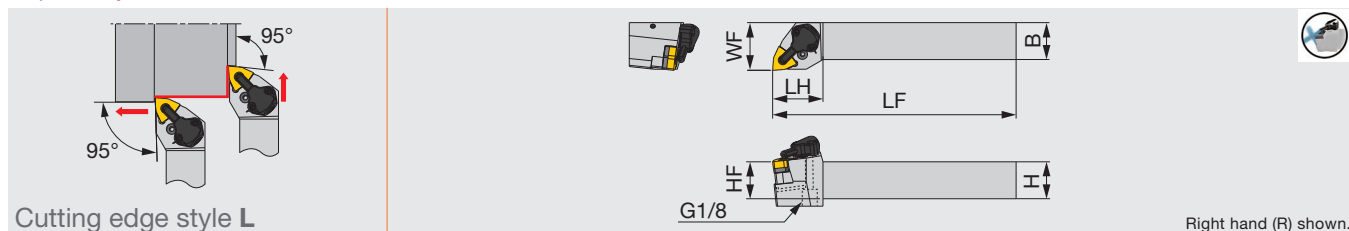
SPARE PARTS

Designation	Clamp	Clamp screw	Spring	Spring pin	Shim	Shim screw	Wrench
AWLNR/L**08-A	ACP4S	ACS-5W	BP-7	SP-2.5	ASW422	CSTB-3.5	T-15F

TUNG T^{URN}JET

PWLNR/L-CHP

Lever-lock toolholder with 95° approach angle, for negative 80° trigon inserts, with high pressure coolant capability



Designation	H	B	LF	LH	HF	WF	RE**	Insert	Torque*
PWLNR/L2020K08-CHP	20	20	125	34	20	32	0.8	WN**0804...	3
PWLNR/L2525M08-CHP	25	25	150	34	25	32	0.8	WN**0804...	3

*Torque: Recommended clamping torque (N·m)

**RE: Standard corner radius

SPARE PARTS

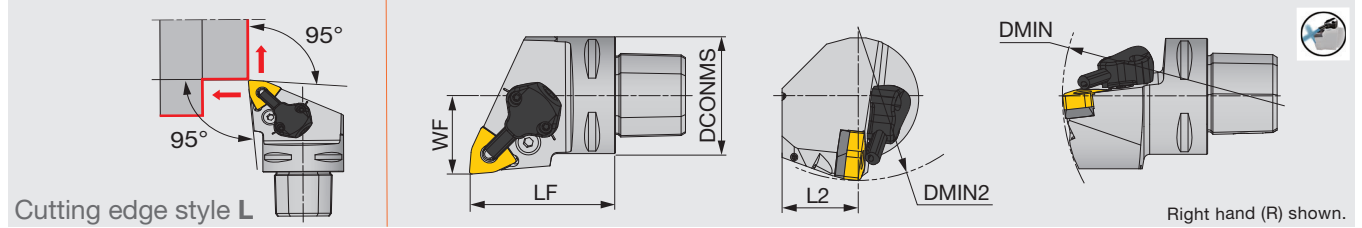
Designation	Shim	Clamping screw	Wrench1	Spring pin	Lever
PWLNR/L**08-CHP	LSW42	LCS4	P-2.5	LSP4	LCL4

SPARE PARTS

Designation	Coolant unit	Mounting screw	Wrench2	O-ring	Coolant screw	Wrench3
PWLNR/L**08-CHP	CU-CW-CHP	SRM3	T-8F	OR6.4X0.9N	SRM4X4TL360	P-2

Reference pages: AWLNR/L, PWLNR/L-CHP: Inserts → **B099** -, CBN → **B179**
Parts for coolant hose → **C134**

Lever-lock toolholder with TungCap connection, for negative 80° trigon inserts, with high pressure coolant capability



Designation	DCONMS	LF	L2	WF	DMIN	DMIN2	RE**	Insert
C4PWLNR/L27050-0604-CHP	40	50	25	27	140	110	0.8	WN**0604...
C4PWLNR/L27050-08-CHP	40	50	25	27	140	110	0.8	WN**0804...
C6PWLNR/L45065-08-CHP	63	65	41	45	190	110	0.8	WN**0804...

**RE: Standard corner radius

SPARE PARTS FOR P-TYPE

Designation	Shim	Clamping screw	Wrench1	Spring pin	Lever
C*PCLNR/L**-12-CHP	LSC42	LCS4	P-3	LSP4	LCL4
C*PWLNR/L**-08-CHP	LSW42BL	LCS4	P-3	LSP4	LCL4
C*PDJNR/L**-15-CHP	LSD43A	LCS4	P-3	LSP4	LCL4
C*PCLNR/L**0904-CHP	LSC317	LCS3	P-2.5	LSP3	LCL33
C*PWLNR/L**0604-CHP	LSW312	LCS3	P-2.5	LSP3	LCL3
C*PDJNR/L**1104-CHP	ELSD32	LCS3	P-2.5	LSP3	LCL33L

COOLANT SET

Designation	Coolant unit	Mounting screw	Wrench2	O-ring
C*PCLNR/L**-CHP	CU-CW-CHP	SRM3	T-8F	OR6.4X0.9N
C*PWLNR/L**-CHP	CU-CW-CHP	SRM3	T-8F	OR6.4X0.9N
C*PDJNR/L**-CHP	CU-D-CHP	SRM3	T-8F	OR6.4X0.9N

INSERT SELECTION

P

Application	Precision finishing	Finishing	Medium cutting	Medium to heavy cutting
Grade	NS9530	GT9530	T9215	T9215
Chipbreaker shape	TF	TSF	TM	TH
Cutting conditions	B006			

M

Application	Finishing	Medium cutting	Medium to heavy cutting
Grade	T6120	T6130	T6130
Chipbreaker shape	SF	SM	SH
Cutting conditions	B008		

K

Application	Finishing	Medium cutting	Medium to heavy cutting
Grade	T515	T515	T515
Chipbreaker shape	All-round	All-round	All-round
Cutting conditions	B010		

S

Application	Precision finishing	Finishing	Medium cutting
Grade	BX480	AH8005	AH8005
Chipbreaker shape	T-CBN	HRF	HRM
Cutting conditions	B014		

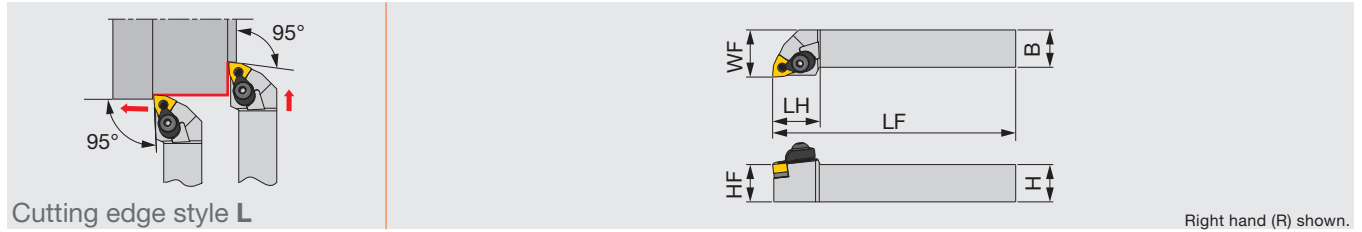
H

Application	Precision finishing	Finishing
Grade	BXM10	BXM20
Chipbreaker shape	T-CBN	T-CBN
Cutting conditions	B016	

Reference pages: C-PWLNR/L-CHP: Inserts → **B099 -**, CBN → **B179**
Parts for coolant hose → **C134**

DWLNLR/L

One-Double toolholder with 95° approach angle, for negative 80° trigon inserts



Right hand (R) shown.

Designation	H	B	LF	LH	HF	WF	RE**	Insert
DWLNLR/L2020K06	20	20	125	25.5	20	25	0.8	WN**0604...
DWLNLR/L2020K08	20	20	125	31	20	25	0.8	WN**0804...
DWLNLR/L2525M06	25	25	150	26	25	32	0.8	WN**0604...
DWLNLR/L2525M08	25	25	150	31	25	32	0.8	WN**0804...
DWLNLR/L3225P08	32	25	170	30	32	32	0.8	WN**0804...

Note: Except for 57-type chipbreaker inserts
 **RE: Standard corner radius

SPARE PARTS									
Designation	Clamp	Lever	Piston	Clamp screw	Shim	Spring	Spring pin	Wrench1	Wrench2
DWLNLR/L**06	DCPM-33	LCL33	DPIS33	DLCS33	LSW312	BP-9	LSP3	P-2.5	P-3
DWLNLR/L**08	DCPM-43	DLCL43	DPIS43	DLCS43	LSW42	BP-10	LSP4	P-3	P-4

INSERT SELECTION

Application	Precision finishing	Finishing	Medium cutting	Medium to heavy cutting
	Grade	NS9530	GT9530	T9215
Chipbreaker shape				
Cutting conditions	B006			

Application	Finishing	Medium cutting	Medium to heavy cutting
	Grade	T6120	T6130
Chipbreaker shape			
Cutting conditions	B008		

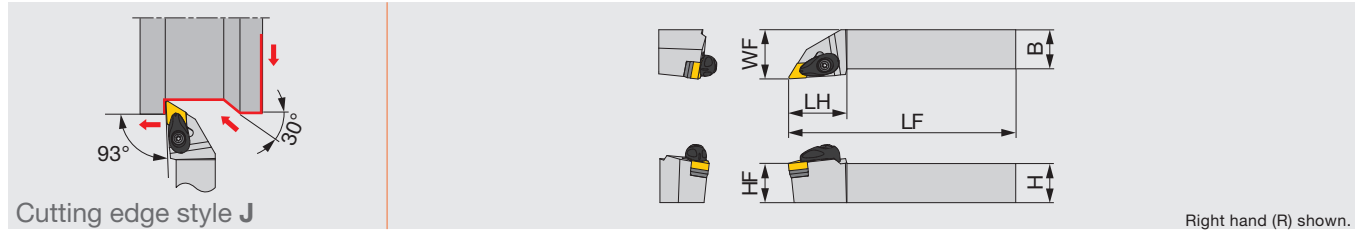
Application	Finishing	Medium cutting	Medium to heavy cutting
	Grade	T515	T515
Chipbreaker shape			
Cutting conditions	B010		

Application	Precision finishing	Finishing	Medium cutting
	Grade	BX480	AH8005
Chipbreaker shape			
Cutting conditions	B014		

Application	Precision finishing	Finishing
	Grade	BXM10
Chipbreaker shape		
Cutting conditions	B016	

Reference pages: DWLNLR/L: Inserts → B099 -, CBN → B179

Double-clamp toolholder with 93° approach angle, for negative 55° rhombic inserts

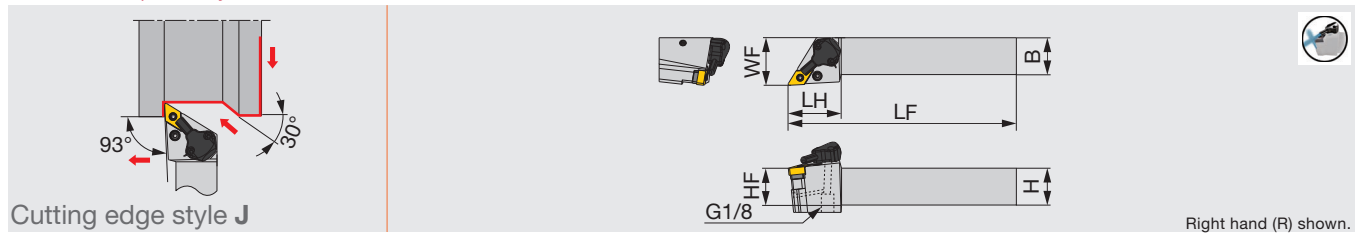


Designation	H	B	LF	LH	HF	WF	RE**	Insert	Torque*
ADJNR/L2020K1104-A	20	20	125	30	20	25	0.8	DN**1104...	3
ADJNR/L2525M1104-A	25	25	150	30	25	32	0.8	DN**1104...	3

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

Designation	Clamp	Clamp screw	Spring	Spring pin	Shim	Shim screw	Wrench
ADJNR/L**1104-A	ACP3S-E	ACS-5W	BP-7	SP-2.5	ASD322	CSTB-3.5	T-15F

Lever-lock toolholder with 93° approach angle, for negative 55° rhombic inserts, with high pressure coolant capability



Designation	H	B	LF	LH	HF	WF	RE**	Insert	Torque*
PDJNR/L2020K1104-CHP	20	20	125	36	20	32	0.8	DN**1104...	2
PDJNR/L2525M1104-CHP	25	25	150	36	25	32	0.8	DN**1104...	2

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

Designation	Shim	Clamping screw	Wrench1	Spring pin	Lever
PDJNR/L**1104-CHP	ELSD32	LCS3	P-2.5	LSP3	LCL33L

Designation	Coolant unit	Mounting screw	Wrench2	O-ring	Coolant screw	Wrench3
PDJNR/L**1104-CHP	CU-D-CHP	SRM3	T-8F	OR6.4X0.9N	SRM4X4TL360	P-2

INSERT SELECTION

Application	Finishing	Medium cutting
	Grade	T9215
Chipbreaker shape	TSF	TM
Cutting conditions		B006

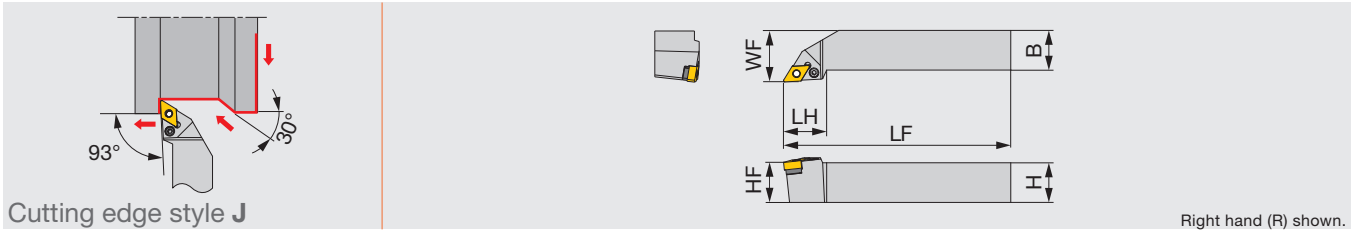
Application	Finishing	Medium cutting
	Grade	T6120
Chipbreaker shape	SS	SM
Cutting conditions		B008

Application	Medium cutting	
Grade	T515	
Chipbreaker shape	TM	
Cutting conditions		B010

Reference pages: ADJNR/L-Eco, PDJNR/L-CHP-Eco: Inserts → **B065 -**
Parts for coolant hose → **C134**



Lever-lock toolholder with 93° approach angle, for negative 55° rhombic inserts



Designation	H	B	LF	LH	HF	WF	RE**	Insert	Torque*
PDJNR/L1616H1104	16	16	100	27	16	20	0.8	DN**1104...	2
PDJNR/L2020K1104	20	20	125	27	20	25	0.8	DN**1104...	2
PDJNR/L2525M1104	25	25	150	27	25	32	0.8	DN**1104...	2

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

SPARE PARTS

Designation	Shim	Clamping screw	Wrench	Spring pin	Lever
PDJNR/L**1104	ELSD32	LCS3	P-2.5	LSP3	LCL33L

INSERT SELECTION

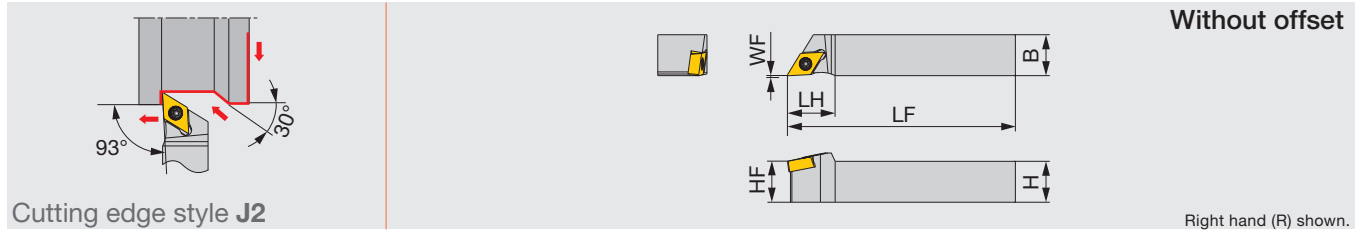
Application	Finishing	Medium cutting
	Grade	T9215
Chipbreaker shape	TSF	TM
Cutting conditions	B006	

Application	Finishing	Medium cutting
	Grade	T6120
Chipbreaker shape	SS	SM
Cutting conditions	B008	

Application	Medium cutting
Grade	T515
Chipbreaker shape	TM
Cutting conditions	B010

Reference pages: PDJNR/L-Eco: Inserts → **B065 -**

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



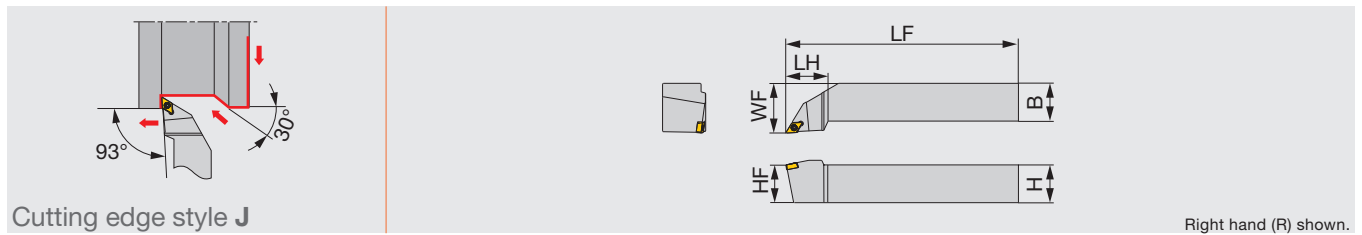
Designation	H	B	LF	LH	HF	WF	RE**	Insert	Torque*
JSDJ2XR/L1010X07	10	10	120	14	10	0	0.2	DXGU0703**L/R...	0.9
JSDJ2XR/L1212F07	12	12	85	14	12	0	0.2	DXGU0703**L/R...	0.9
JSDJ2XR/L1212X07	12	12	120	14	12	0	0.2	DXGU0703**L/R...	0.9
JSDJ2XR/L1616X07	16	16	120	18	16	0	0.2	DXGU0703**L/R...	0.9
JSDJ2XR/L2020H07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

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

SPARE PARTS

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

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



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

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

SPARE PARTS

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

INSERT SELECTION

Swiss lathes

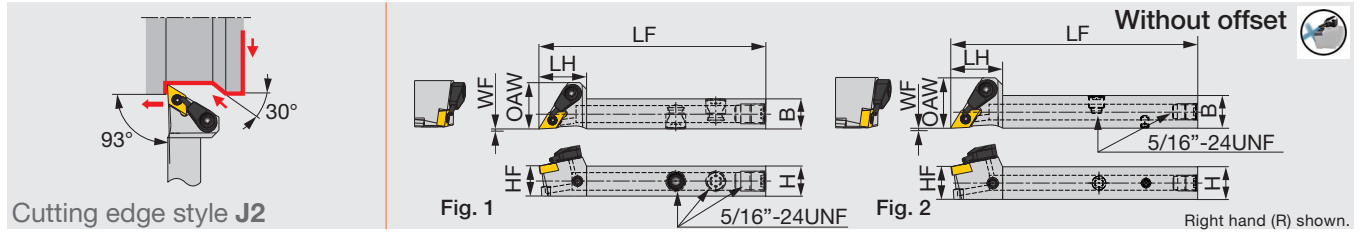
Application	Finishing		Medium cutting	
	Grade	SH725	Grade	AH725
Chipbreaker shape	JSS	JTS	JSS	JTS
Cutting conditions	C135			

Small CNC lathes

Application	Finishing		Medium cutting	
	Grade	AH725	Grade	AH725
Chipbreaker shape	SS	TS	SS	TS
Cutting conditions	C135			

Reference pages: JSDJ2XR/L, JSDJXR/L: Inserts → **B125** -
 Standard cutting conditions → **C135**

Screw-on toolholder with 93° approach angle, for DXGU inserts, with high pressure coolant capability



Designation	H	B	LF	LH	HF	WF	OAW	RE**	Insert	Torque*	Fig.
JSDJ2XR/L1212F07-CHP	12	12	85	19	12	0	18.5	0.2	DXGU0703**L/R...	0.9	1
JSDJ2XR/L1212X07-CHP ⁽¹⁾	12	12	120	19	12	0	18.5	0.2	DXGU0703**L...	0.9	2
JSDJ2XR/L1616X07-CHP ⁽¹⁾	16	16	120	19	16	0	18.5	0.2	DXGU0703**L...	0.9	2

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

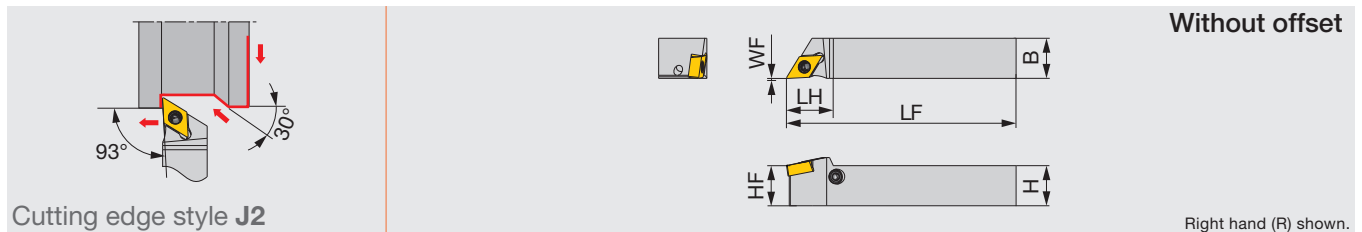
SPARE PARTS

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

MINIFORCE

JPDJ2XR/L

Back-clamp toolholder with 93° approach angle, for DXGU inserts



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

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

SPARE PARTS

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

INSERT SELECTION

Swiss lathes

Application	Finishing	Medium cutting
	Grade	SH725
Chipbreaker shape	JSS	JTS
Cutting conditions		C135

Application	Finishing	Medium cutting
	Grade	SH725
Chipbreaker shape	JSS	JTS
Cutting conditions		C135

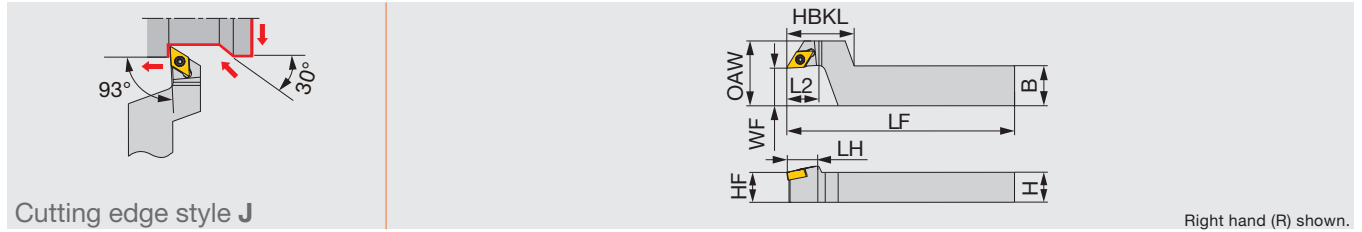
Small CNC lathes

Application	Finishing	Medium cutting
	Grade	AH725
Chipbreaker shape	SS	TS
Cutting conditions		C135

Application	Finishing	Medium cutting
	Grade	AH8015
Chipbreaker shape	SS	TS
Cutting conditions		C135

Reference pages: JSDJ2XR/L-CHP, JPDJ2XR/L: Inserts → **B125** -
 Standard cutting conditions → **C135**

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



Right hand (R) shown.

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

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

SPARE PARTS

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

INSERT SELECTION

Swiss lathes

Application	Finishing	Medium cutting
	Grade	SH725
Chipbreaker shape	JSS	JTS
Cutting conditions	C135	

Application	Finishing	Medium cutting
	Grade	SH725
Chipbreaker shape	JSS	JTS
Cutting conditions	C135	

Small CNC lathes

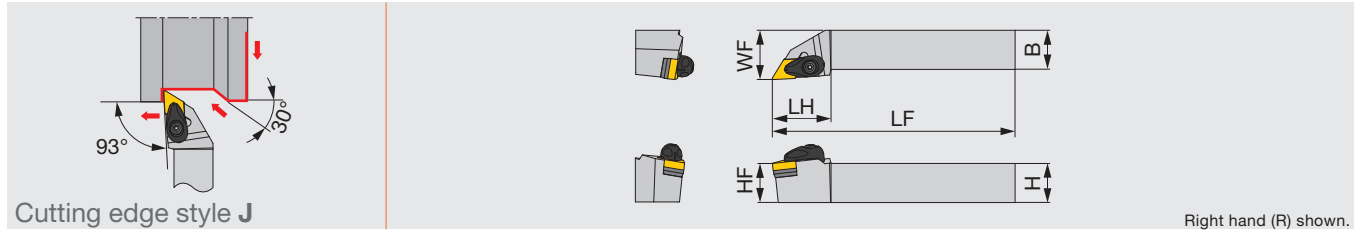
Application	Finishing	Medium cutting
	Grade	AH725
Chipbreaker shape	SS	TS
Cutting conditions	C135	

Application	Finishing	Medium cutting
	Grade	AH8015
Chipbreaker shape	SS	TS
Cutting conditions	C135	

Reference pages: JSDJXR-F: Inserts → **B125** -
Standard cutting conditions → **C135**



Double-clamp toolholder with 93° approach angle, for negative 55° rhombic inserts



Designation	H	B	LF	LH	HF	WF	RE**	Insert	Torque*
ADJNR/L2020K15-A	20	20	125	36	20	25	0.8	DN**1504...	3
ADJNR/L2020K1506-A	20	20	125	36	20	25	0.8	DN**1506...	3
ADJNR/L2525M15-A	25	25	150	36	25	32	0.8	DN**1504...	3
ADJNR/L2525M1506-A	25	25	150	36	25	32	0.8	DN**1506...	3
ADJNR/L3225P15-A	32	25	170	36	32	32	0.8	DN**1504...	3

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

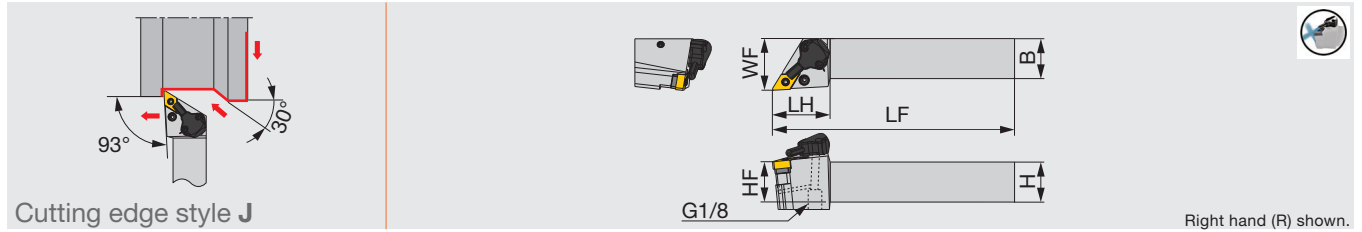
SPARE PARTS							
Designation	Clamp	Clamp screw	Spring	Spring pin	Shim	Shim screw	Wrench
ADJNR/L**15-A	ACP4S	ACS-5W	BP-7	SP-2.5	ASD432	CSTB-3.5	T-15F
ADJNR/L**1506-A	ACP4S	ACS-5W	BP-7	SP-2.5	ASD423	CSTB-3.5	T-15F

INSERT SELECTION

P	Application	Precision finishing	Finishing	Medium cutting	Medium to heavy cutting
	Grade	NS9530	GT9530	T9215	T9215
	Chipbreaker shape	TF	TSF	TM	TH
	Cutting conditions	B006			
M	Application	Finishing	Medium cutting	Medium to heavy cutting	
	Grade	T6120	T6130	T6130	
	Chipbreaker shape	SF	SM	SH	
	Cutting conditions	B008			
K	Application	Finishing	Medium cutting	Medium to heavy cutting	
	Grade	T515	T515	T515	
	Chipbreaker shape	All-round	All-round	All-round	
	Cutting conditions	B010			
N	Application	Precision finishing	Finishing	Medium cutting	
	Grade	DX120	DX140	TH10	
	Chipbreaker shape	T-DIA	with rake T-DIA	P	
	Cutting conditions	B012			
S	Application	Precision finishing	Finishing	Medium cutting	
	Grade	BX470	AH8005	AH8005	
	Chipbreaker shape	T-CBN	HRF	HRM	
	Cutting conditions	B014			
H	Application	Precision finishing	Finishing		
	Grade	BXM10	BXM20		
	Chipbreaker shape	T-CBN	T-CBN		
	Cutting conditions	B016			

Reference pages: ADJNR/L: Inserts → B065 -, CBN → B172 -, PCD → B192 -

Lever-lock toolholder, for negative 55° rhombic inserts, with high pressure coolant capability



Designation	H	B	LF	LH	HF	WF	RE**	Insert	Torque*
PDJNR/L2020K15-CHP	20	20	125	36	20	32	0.8	DN**1504...	3
PDJNR/L2525M15-CHP	25	25	150	36	25	32	0.8	DN**1504...	3

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

SPARE PARTS

Designation	Shim	Clamping screw	Wrench1	Spring pin	Lever
PDJNR/L**15-CHP	LSD43A	LCS4	P-3	LSP4	LCL4

SPARE PARTS

Designation	Coolant unit	Mounting screw	Wrench2	O-ring	Coolant screw	Wrench3
PDJNR/L**15-CHP	CU-D-CHP	SRM3	T-8F	OR6.4X0.9N	SRM4X4TL360	P-2

INSERT SELECTION

Application	Precision finishing	Finishing	Medium cutting	Medium to heavy cutting
	Grade	NS9530	GT9530	T9215
Chipbreaker shape	TF	TSF	TM	TH
Cutting conditions	B006			

Application	Finishing	Medium cutting	Medium to heavy cutting
	Grade	T6120	T6130
Chipbreaker shape	SF	SM	SH
Cutting conditions	B008		

Application	Finishing	Medium cutting	Medium to heavy cutting
	Grade	T515	T515
Chipbreaker shape	All-round	All-round	All-round
Cutting conditions	B010		

Application	Precision finishing	Finishing	Medium cutting
	Grade	DX120	DX140
Chipbreaker shape	T-DIA	with rake T-DIA	P
Cutting conditions	B012		

Application	Precision finishing	Finishing	Medium cutting
	Grade	BX470	AH8005
Chipbreaker shape	T-CBN	HRF	HRM
Cutting conditions	B014		

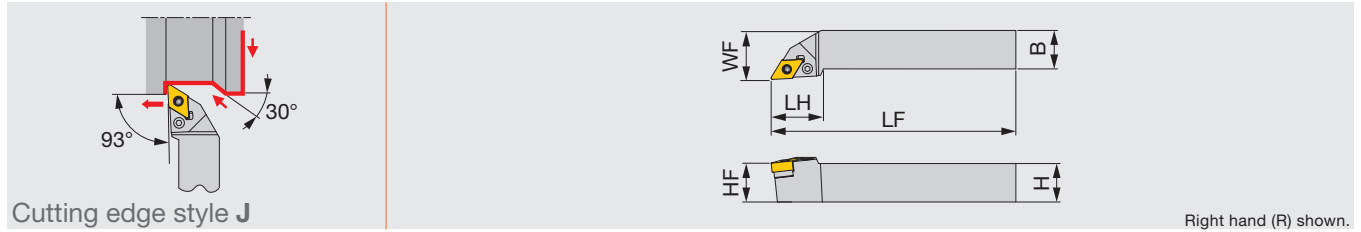
Application	Precision finishing	Finishing
	Grade	BXM10
Chipbreaker shape	T-CBN	T-CBN
Cutting conditions	B016	

Reference pages: PDJNR/L-CHP: Inserts → B065 -, CBN → B172 -, PCD → B192 -
 Parts for coolant hose → C134



PDJNR/L

Lever-lock toolholder with 93° approach angle, for negative 55° rhombic inserts



Designation	H	B	LF	LH	HF	WF	RE**	Insert
PDJNR/L1616H11	16	16	100	27	16	20	0.8	DN**1104...
PDJNR/L2020K11	20	20	125	27	20	25	0.8	DN**1104...
PDJNR/L2020	20	20	125	34	20	25	0.8	DN**1504...
PDJNR/2020K15E	20	20	125	36	20	25	0.8	DN**1506...
PDJNR/L2520	25	20	150	34	25	25	0.8	DN**1504...
PDJNR/L2525M11	25	25	150	27	25	32	0.8	DN**1104...
PDJNR/L2525	25	25	150	34	25	32	0.8	DN**1504...
PDJNR/L2525M15E	25	25	150	36	25	32	0.8	DN**1506...
PDJNR/L3225	32	25	170	32	32	32	0.8	DN**1504...
PDJNR3225P15E	32	25	170	36	32	34	0.8	DN**1506...

**RE: Standard corner radius

SPARE PARTS

Designation	Shim	Clamping screw	Wrench	Spring pin	Lever
PDJNR/L1616H11, 2020K11	ELSD32	LCS3	P-2.5	LSP3	LCL33L
PDJNR/L2020	LSD42	LCS4	P-3	LSP4	LCL4
PDJNR/2020K15E	ELSD42	ELCS4	P-3	LSP4S	LCL44
PDJNR/L2520	LSD42	LCS4	P-3	LSP4	LCL4
PDJNR/L2525	LSD42	LCS4	P-3	LSP4	LCL4
PDJNR/L2525M15E	ELSD42	ELCS4	P-3	LSP4S	LCL44
PDJNR/L3225	LSD42	LCS4	P-3	LSP4	LCL4
PDJNR3225P15E	ELSD42	ELCS4	P-3	LSP4S	LCL44

INSERT SELECTION

Application	Precision finishing	Finishing	Medium cutting	Medium to heavy cutting
	Grade	NS9530	GT9530	T9215
Chipbreaker shape	TF	TSF	TM	TH
Cutting conditions	B006			

Application	Finishing	Medium cutting	Medium to heavy cutting
	Grade	T6120	T6130
Chipbreaker shape	SF	SM	SH
Cutting conditions	B008		

Application	Finishing	Medium cutting	Medium to heavy cutting
	Grade	T515	T515
Chipbreaker shape	All-round	All-round	All-round
Cutting conditions	B010		

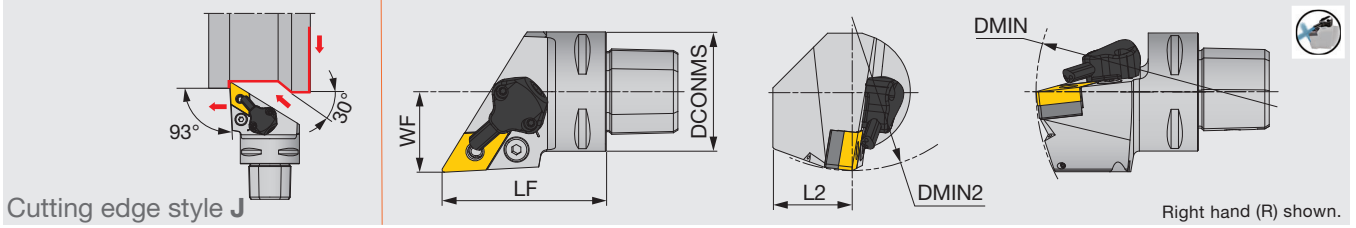
Application	Precision finishing	Finishing	Medium cutting
	Grade	DX120	DX140
Chipbreaker shape	T-DIA	with rake T-DIA	P
Cutting conditions	B012		

Application	Precision finishing	Finishing	Medium cutting
	Grade	BX470	AH8005
Chipbreaker shape	T-CBN	HRF	HRM
Cutting conditions	B014		

Application	Precision finishing	Finishing
	Grade	BXM10
Chipbreaker shape	T-CBN	T-CBN
Cutting conditions	B016	

Reference pages: PDJNR/L: Inserts → B065 -, CBN → B172 -, PCD → B192 -

Lever-lock toolholder with TungCap connection, for negative 55° rhombic inserts, with high pressure coolant capability



Designation	DCONMS	LF	L2	WF	DMIN	DMIN2	RE**	Insert
C4PDJNR/L27055-1104-CHP	40	55	25	27	140	110	0.8	DN**1104...
C4PDJNR/L27055-15-CHP	40	55	25	27	140	110	0.8	DN**1504(06)...
C5PDJNR/L35060-15-CHP	50	60	32	35	165	110	0.8	DN**1504(06)...
C6PDJNR/L45065-1104-CHP	63	65	41	45	190	110	0.8	DN**1104...
C6PDJNR/L45065-15-CHP	63	65	41	45	190	110	0.8	DN**1504(06)...

**RE: Standard corner radius

INSERT SELECTION

P

Application	Precision finishing	Finishing	Medium cutting	Medium to heavy cutting
Grade	NS9530	GT9530	T9215	T9215
Chipbreaker shape	TF	TSF	TM	TH
Cutting conditions	B006			

M

Application	Finishing	Medium cutting	Medium to heavy cutting
Grade	T6120	T6130	T6130
Chipbreaker shape	SF	SM	SH
Cutting conditions	B008		

K

Application	Finishing	Medium cutting	Medium to heavy cutting
Grade	T515	T515	T515
Chipbreaker shape	All-round	All-round	All-round
Cutting conditions	B010		

N

Application	Precision finishing	Finishing	Medium cutting
Grade	DX120	DX140	TH10
Chipbreaker shape	T-DIA	with rake T-DIA	P
Cutting conditions	B012		

S

Application	Precision finishing	Finishing	Medium cutting
Grade	BX470	AH8005	AH8005
Chipbreaker shape	T-CBN	HRF	HRM
Cutting conditions	B014		

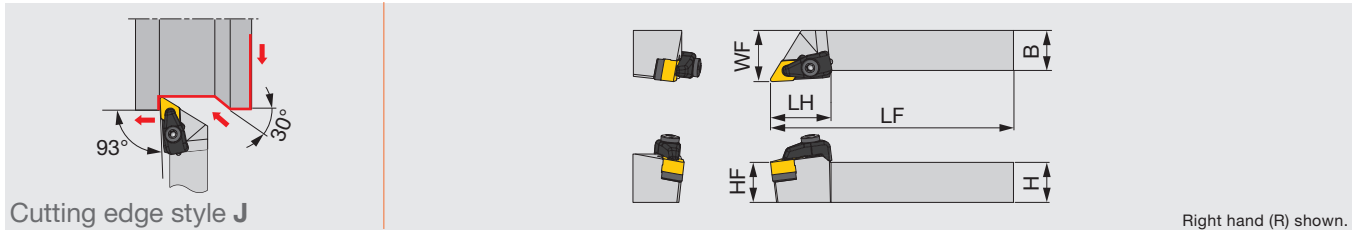
H

Application	Precision finishing	Finishing
Grade	BXM10	BXM20
Chipbreaker shape	T-CBN	T-CBN
Cutting conditions	B016	

Reference pages: C-PDJNR/L-CHP: Inserts → B065 -, CBN → B172 -, PCD → B192 -



Double-clamp toolholder with 93° approach angle, for negative 55° rhombic ceramic inserts with dimple



Right hand (R) shown.

Designation	H	B	LF	LH	HF	WF	RE**	Insert	Torque*
CDJNR/L2525M1507-RD	25	25	150	38	25	32	1.2	DN*D1507...	4
CDJNR3225P1507-RD	32	25	170	38	32	32	1.2	DN*D1507...	4

*Torque: Recommended clamping torque (N·m)

**RE: Standard corner radius

SPARE PARTS

Designation	Clamp	Clamp screw	Shim	Shim screw	Spring	Wrench1	Wrench2
CDJNR/L*-RD	CCP4-A	CCS4-A	CD44-A	BH5-10-A	BP-5-A	P-3	P-4

INSERT SELECTION

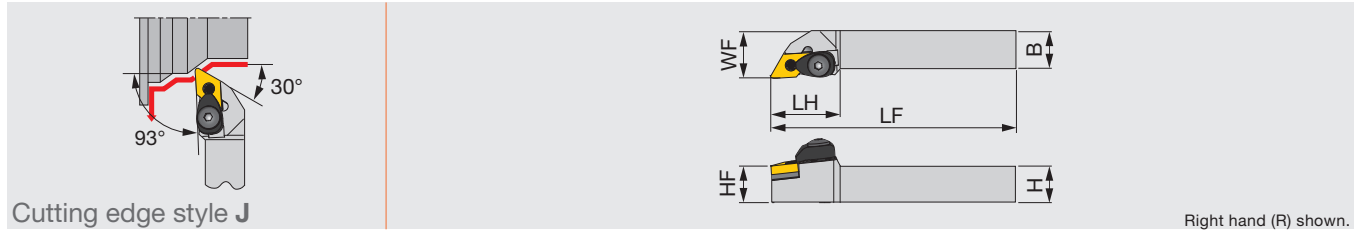
K	Application	Finishing to medium cutting
	Grade	FX105
	Chipbreaker shape	
	Cutting conditions	C136

Reference pages: CDJNR/L-RD: Inserts → **B073**

Standard cutting conditions → **C136**

DDJNR/L

One-Double toolholder with 93° approach angle, for negative 55° rhombic inserts



Designation	H	B	LF	LH	HF	WF	RE**	Insert
DDJNR/L2020K15	20	20	125	38	20	25	0.8	DN**1504...
DDJNR/L2020K1506	20	20	125	38	20	25	0.8	DN**1506...
DDJNR/L2525M15	25	25	150	38	25	32	0.8	DN**1504...
DDJNR/L2525M1506	25	25	150	38	25	32	0.8	DN**1506...
DDJNR/L3225P15	32	25	170	38	32	32	0.8	DN**1504...
DDJNR/L3225P1506	32	25	170	38	32	32	0.8	DN**1506...

Note: Except for 57-type chipbreaker inserts
 **RE: Standard corner radius

SPARE PARTS									
Designation	Clamp	Lever	Piston	Clamp screw	Shim	Spring	Spring pin	Wrench1	Wrench2
DDJNR/L**15	DCPM-43	DLCL43	DPIS43	DLCS43	LSD42	BP-10	LSP4	P-3	P-4
DDJNR/L**1506	DCPM-43	DLCL43	DPIS44	DLCS43	LSD42	BP-10	LSP4	P-3	P-4

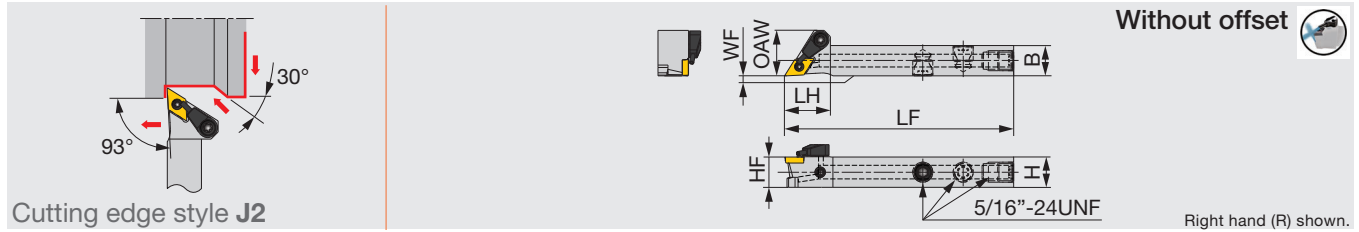
INSERT SELECTION

P	Application	Precision finishing	Finishing	Medium cutting	Medium to heavy cutting
	Grade	NS9530	GT9530	T9215	T9215
	Chipbreaker shape	TF	TSF	TM	TH
	Cutting conditions	B006			
M	Application	Finishing	Medium cutting	Medium to heavy cutting	
	Grade	T6120	T6130	T6130	
	Chipbreaker shape	SF	SM	SH	
	Cutting conditions	B008			
K	Application	Finishing	Medium cutting	Medium to heavy cutting	
	Grade	T515	T515	T515	
	Chipbreaker shape	All-round	All-round	All-round	
	Cutting conditions	B010			
N	Application	Precision finishing	Finishing	Medium cutting	
	Grade	DX120	DX140	TH10	
	Chipbreaker shape	T-DIA	T-DIA with rake	P	
	Cutting conditions	B012			
S	Application	Precision finishing	Finishing	Medium cutting	
	Grade	BX470	AH8005	AH8005	
	Chipbreaker shape	T-CBN	HRF	HRM	
	Cutting conditions	B014			
H	Application	Precision finishing	Finishing		
	Grade	BXM10	BXM20		
	Chipbreaker shape	T-CBN	T-CBN		
	Cutting conditions	B016			

Reference pages: DDJNR/L: Inserts → B065 -, CBN → B172 -, PCD → B192 -



Screw-on toolholder with 93° approach angle, for positive 55° rhombic inserts, with high pressure coolant capability



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

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

Designation	Clamping screw	Coolant unit	Wrench1	Coolant plug	Wrench2	DirectJet plug	Wrench3
JSDJ2CR/L1212F07-CHP	CSTB-2.5	S-CU-CHP	T-8F	-	-	-	-
JSDJ2CR/L1212F11-CHP	CSTB-4SD	S-CU-CHP	T-8F	-	-	-	-
JSDJ2CR**11-CHP	CSTB-4SD	S-CU-CHP	T-8F	SR5/16UNFTL360	P-4	SSHM4-6-TB	P-2

INSERT SELECTION

P

Application	Finishing	Finishing to medium cutting	Medium cutting
Grade	NS9530	T9215	T9215
Chipbreaker shape	PSS	PS	PM
Cutting conditions	B018		

M

Application	Precision finishing	Finishing	Finishing to medium cutting	Medium cutting
Grade	GH330	AH725	AH630	T6130
Chipbreaker shape	W**	PSF	PSS	PM
Cutting conditions	B020			

K

Application	Finishing to medium cutting
Grade	T515
Chipbreaker shape	CM
Cutting conditions	B022

N

Application	Precision finishing	Finishing	Medium cutting
Grade	DX120	DX140	KS05F
Chipbreaker shape	T-DIA	with rake T-DIA	AL
Cutting conditions	B024		

S

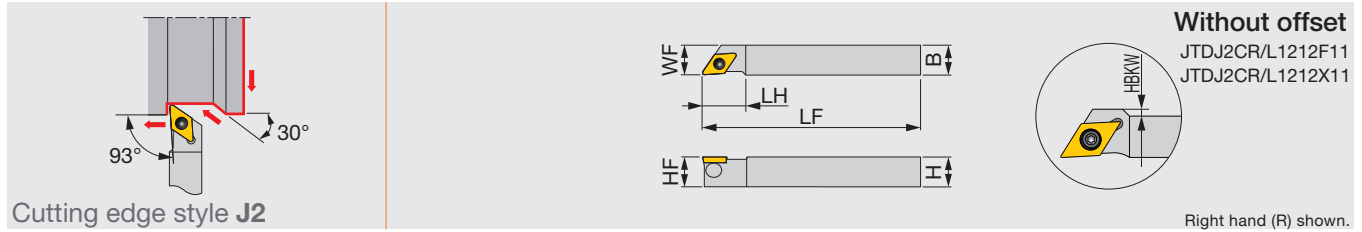
Application	Finishing	Finishing to medium cutting
Grade	AH8015	AH8015
Chipbreaker shape	PSS	PS
Cutting conditions	B026	

H

Application	Precision finishing	Finishing
Grade	BXM10	BXM20
Chipbreaker shape	T-CBN	T-CBN
Cutting conditions	B028	

Reference pages: JSDJ2CR/L-CHP: Inserts → **B119 -**, CBN → **B182 -**, PCD → **B194 -**
Parts for coolant hose → **C134**

Back-clamp toolholder with 93° approach angle, for positive 55° rhombic inserts



Designation	H	B	LF	LH	HF	WF	HBKW	RE**	Insert	Torque*
JTDJ2CR/L1010X07	10	10	120	14	10	10	-	0.2	DC**0702...	0.9
JTDJ2CR/L1212F07	12	12	85	14	12	12	-	0.2	DC**0702...	0.9
JTDJ2CR/L1212X07	12	12	120	14	12	12	-	0.2	DC**0702...	0.9
JTDJ2CR/L1212F11	12	12	85	20	12	12	2	0.2	DC**11T3...	1.2
JTDJ2CR/L1212X11	12	12	120	20	12	12	2	0.2	DC**11T3...	1.2
JTDJ2CL1212M11	12	12	150	20	12	12	-	0.8	DC**11T3...	1.2
JTDJ2CR/L1616X11	16	16	120	20	16	16	-	0.2	DC**11T3...	1.2

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

SPARE PARTS

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

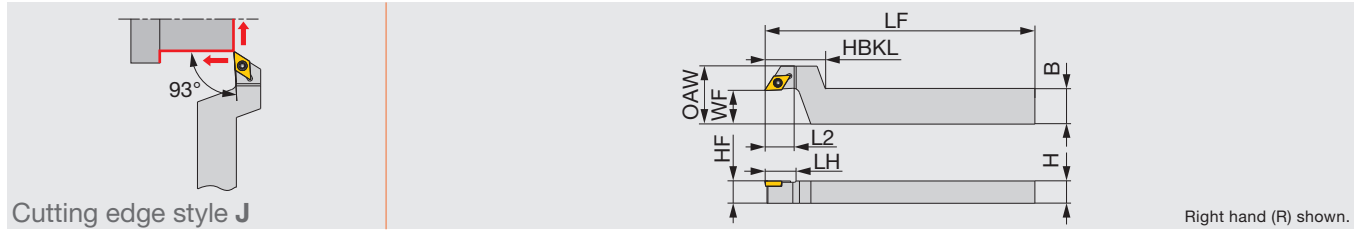
INSERT SELECTION

P	Application	Precision finishing	Finishing	Finishing to medium cutting	Medium cutting
	Grade	SH725	SH725	T9215	T9215
	Chipbreaker shape	01	JS	PS	PM
	Cutting conditions	B018			
M	Application	Precision finishing	Finishing	Finishing to medium cutting	Medium cutting
	Grade	SH725	SH725	T9215	T9215
	Chipbreaker shape	01	JS	PS	PM
	Cutting conditions	B020			
K	Application	Finishing to medium cutting			
	Grade	T515			
	Chipbreaker shape	CM			
	Cutting conditions	B022			
N	Application	Precision finishing	Medium cutting		
	Grade	DX120	KS05F		
	Chipbreaker shape	T-DIA	with rake AL		
	Cutting conditions	B024			
S	Application	Precision finishing	Finishing to medium cutting		
	Grade	BX470	AH8005		
	Chipbreaker shape	T-CBN	PS		
	Cutting conditions	B026			
H	Application	Precision finishing	Finishing		
	Grade	BXM10	BXM20		
	Chipbreaker shape	T-CBN	T-CBN		
	Cutting conditions	B028			

Reference pages: JTDJ2CR/L: Inserts → **B119 -**, CBN → **B182 -**, PCD → **B194 -**



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



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

*Torque: Recommended clamping torque (N-m)

**RE: Standard corner radius

SPARE PARTS

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

INSERT SELECTION

Application	Precision finishing	Finishing	Finishing to medium cutting	Medium cutting
	SH725	SH725	T9215	T9215
Grade	01	JS	PS	PM
Chipbreaker shape				
Cutting conditions	B018			

Application	Precision finishing	Finishing	Finishing to medium cutting	Medium cutting
	SH725	SH725	T9215	T9215
Grade	01	JS	PS	PM
Chipbreaker shape				
Cutting conditions	B020			

Application	Finishing to medium cutting
	T515
Grade	T515
Chipbreaker shape	CM
Cutting conditions	B022

Application	Precision finishing	Medium cutting
	DX120	KS05F
Grade	DX120	KS05F
Chipbreaker shape	T-DIA	with rake AL
Cutting conditions	B024	

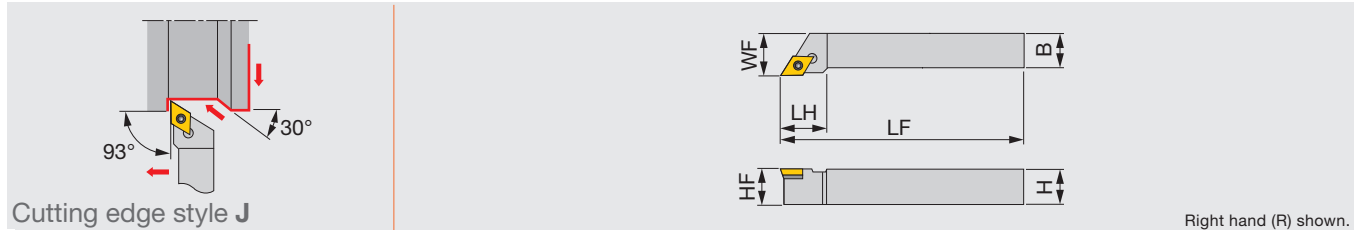
Application	Precision finishing	Finishing to medium cutting
	BX470	AH8005
Grade	BX470	AH8005
Chipbreaker shape	T-CBN	PS
Cutting conditions	B026	

Application	Precision finishing	Finishing
	BXM10	BXM20
Grade	BXM10	BXM20
Chipbreaker shape	T-CBN	T-CBN
Cutting conditions	B028	

Reference pages: JSDJCR-F: Inserts → B119 -, CBN → B182 -, PCD → B194 -

SDJCR/L

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



Designation	H	B	LF	LH	HF	WF	RE**	Insert
SDJCR1616H11	16	16	100	20	16	20	0.8	DC**11T3...
SDJCR/L2020K11	20	20	125	20.5	20	25	0.8	DC**11T3...
SDJCR/L2525M11	25	25	150	21.5	25	32	0.8	DC**11T3...

**RE: Standard corner radius

SPARE PARTS

Designation	Clamping screw	Shim screw	Shim	Wrench1	Wrench2
SDJCR/L...	CSTB-3.5L	DTS5-3.5	SSD32	P-3.5	T-15F

INSERT SELECTION

P

Application	Finishing	Finishing to medium cutting	Medium cutting
Grade	NS9530	T9215	T9215
Chipbreaker shape	PSS	PS	PM
Cutting conditions	B018		

M

Application	Precision finishing	Finishing	Finishing to medium cutting	Medium cutting
Grade	GH330	AH725	AH630	T6130
Chipbreaker shape	W**	PSF	PSS	PM
Cutting conditions	B020			

K

Application	Finishing to medium cutting
Grade	T515
Chipbreaker shape	CM
Cutting conditions	B022

N

Application	Precision finishing	Finishing	Medium cutting
Grade	DX120	DX140	KS05F
Chipbreaker shape	T-DIA	with rake T-DIA	AL
Cutting conditions	B024		

S

Application	Finishing	Finishing to medium cutting
Grade	AH8015	AH8015
Chipbreaker shape	PSS	PS
Cutting conditions	B026	

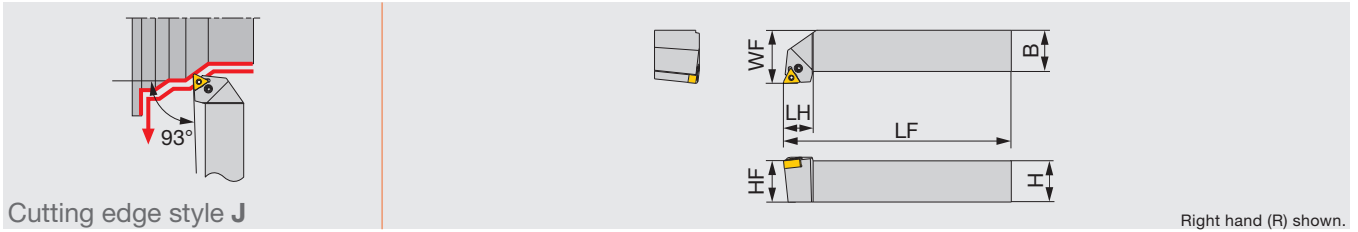
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Application	Precision finishing	Finishing
Grade	BXM10	BXM20
Chipbreaker shape	T-CBN	T-CBN
Cutting conditions	B028	

Reference pages: SDJCR/L: Inserts → B119 -, CBN → B182 -, PCD → B194 -



Lever-lock toolholder with 93° approach angle, for negative triangular inserts



Designation	H	B	LF	LH	HF	WF	RE**	Insert	Torque*
PTJNR/L2525M1104	25	25	150	18	25	32	0.8	TN**1104...	2

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

SPARE PARTS

Designation	Clamping screw	Wrench	Lever
PTJNR/L2525M1104	LCS23A	P-2.5	LCL23

- L
- J
- N
- V
- P
- A
- G
- B-R
- X
- D
- S
- K
- F
- Q+H
- Special

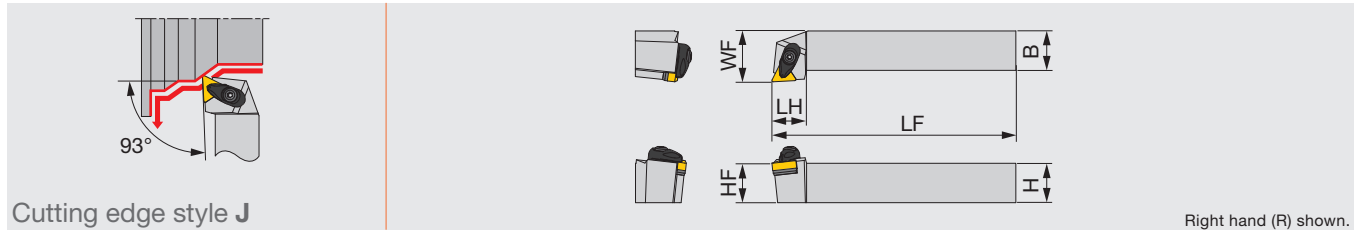
INSERT SELECTION

Application	Finishing	Medium cutting
	Grade	T9215
Chipbreaker shape	TSF	TM
Cutting conditions	B006	

Application	Finishing	Medium cutting
	Grade	T6120
Chipbreaker shape	SS	SM
Cutting conditions	B008	

Reference pages: PTJNR/L-Eco: Inserts → **B084** -

Double-clamp toolholder with 93° approach angle, for negative 60° triangular inserts



Designation	H	B	LF	LH	HF	WF	RE**	Insert	Torque*
ATJNR/L2020K16-A	20	20	125	22	20	25	0.8	TN**1604...	3
ATJNR/L2525M16-A	25	25	150	22	25	32	0.8	TN**1604...	3

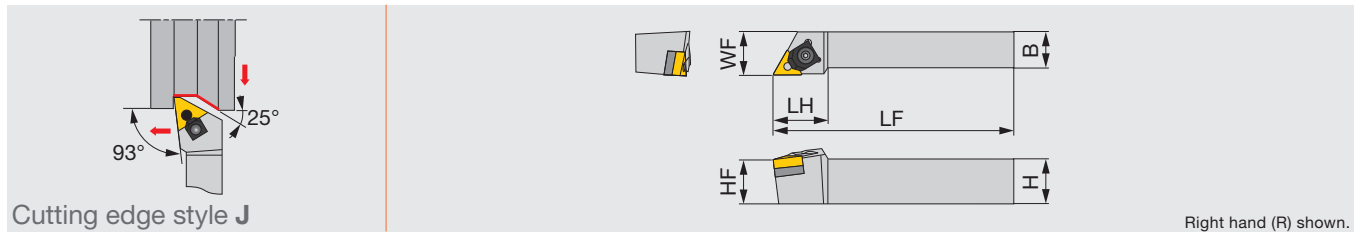
*Torque: Recommended clamping torque (N·m) **RE: Standard corner radius

SPARE PARTS

Designation	Clamp	Clamp screw	Spring	Spring pin	Shim	Shim screw	Wrench
ATJNR/L**16-A	ACP3S	ACS-5W	BP-7	SP-2.5	AST322	CSTB-3.5	T-15F

WTJNR/L

Wedge-on toolholder with 93° approach angle, for negative 60° triangular inserts



Designation	H	B	LF	LH	HF	WF	RE**	Insert
WTJNR2020	20	20	125	31	20	25	0.8	TN**1604...
WTJNR/L2525M3	25	25	150	31	25	32	0.8	TN**1604...

**RE: Standard corner radius

SPARE PARTS

Designation	Clamp	E-ring	Nut	Pin	Clamping screw	Shim	Wrench
WTJNR2020	WCW3	5103-25	WCN3S	WCP3S	WCS3	WST33	P-3
WTJNR/L2525M3	WCW3	5103-25	WCN3	WCP3S	WCS3	WST33	P-3

INSERT SELECTION

Application	Precision finishing	Finishing	Medium cutting	Medium to heavy cutting
	Grade	NS9530	GT9530	T9215
Chipbreaker shape	TF	TSF	TM	TH
Cutting conditions	B006			

Application	Finishing	Medium cutting
	Grade	T6120
Chipbreaker shape	SF	SM
Cutting conditions	B008	

Application	Finishing	Medium cutting	Medium to heavy cutting
	Grade	T515	T515
Chipbreaker shape	All-round	All-round	All-round
Cutting conditions	B010		

Application	Precision finishing	Finishing	Medium cutting
	Grade	DX120	DX140
Chipbreaker shape	T-DIA	T-DIA with rake	P
Cutting conditions	B012		

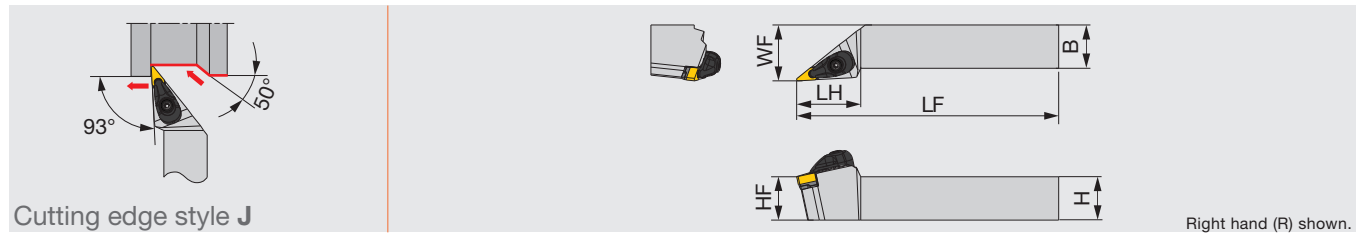
Application	Precision finishing	Finishing	Medium cutting
	Grade	BX470	AH8005
Chipbreaker shape	T-CBN	HRF	HRM
Cutting conditions	B014		

Application	Precision finishing	Finishing
	Grade	BXM10
Chipbreaker shape	T-CBN	T-CBN
Cutting conditions	B016	

Reference pages: ATJNR/L, WTJNR/L: Inserts → B084 -, CBN → B176 -, PCD → B192 -



Double-clamp toolholder with 93° approach angle, for negative 35° rhombic inserts



Designation	H	B	LF	LH	HF	WF	RE**	Insert	Torque*
AVJNR/L2020K1204-A	20	20	125	37	20	25	0.8	VN**1204...	3
AVJNR/L2525M1204-A	25	25	150	37	25	32	0.8	VN**1204...	3

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

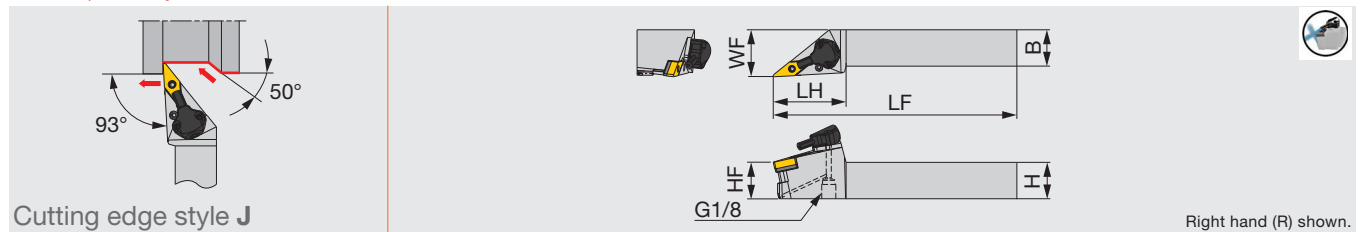
SPARE PARTS

Designation	Clamp	Clamp screw	Spring	Spring pin	Shim	Shim screw	Wrench
AVJNR/L**A	ACP3L-E	ACS-5W	BP-7	SP-2.5	ASV222	CSTB-3.0	T-15F

TUNG TJET

PVJNR/L-CHP

Lever-lock toolholder with 93° approach angle, for negative 35° rhombic inserts, with high pressure coolant capability



Designation	H	B	LF	LH	HF	WF	RE**	Insert	Torque*
PVJNR/L2020K1204-CHP	20	20	125	50	20	32	0.8	VN**1204...	2
PVJNR/L2525M1204-CHP	25	25	150	50	25	32	0.8	VN**1204...	2

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

SPARE PARTS

Designation	Shim	Clamping screw	Wrench1	Spring pin	Lever
PVJNR/L**1204-CHP	LSV212	LCS3V	P-2.5	LSP3	LCL3V

SPARE PARTS

Designation	Coolant unit	Mounting screw	Wrench2	O-ring	Coolant screw	Wrench3
PVJNR/L**1204-CHP	CU-V-CHP	SRM3	T-8F	OR6.4X0.9N	SRM4X4TL360	P-2

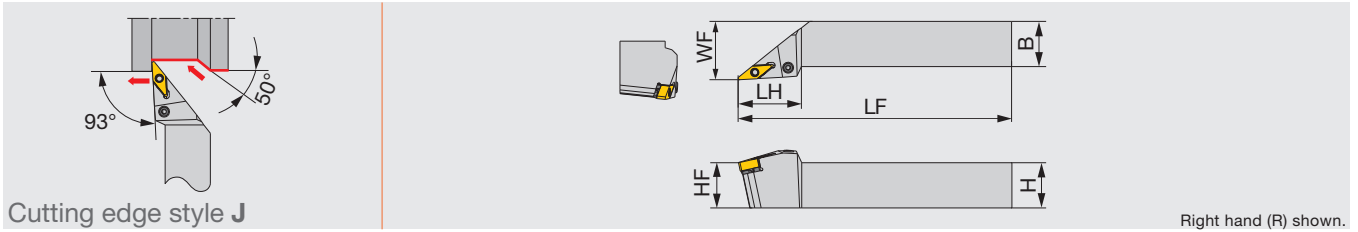
INSERT SELECTION

Application	Finishing	Medium cutting
	T9215	T9215
Grade	T9215	T9215
Chipbreaker shape	TSF	TM
Cutting conditions	B006	

Application	Finishing	Medium cutting
	T6120	T6130
Grade	T6120	T6130
Chipbreaker shape	SS	SM
Cutting conditions	B008	

Reference pages: AVJNR/L-Eco, PVJNR/L-CHP: Inserts → **B095** -
Parts for coolant hose → **C134**

Lever-lock toolholder with 93° approach angle, for negative 35° rhombic inserts



Designation	H	B	LF	LH	HF	WF	RE**	Insert	Torque*
PVJNR/L2020K1204	20	20	125	35	20	25	0.8	VN**1204...	2
PVJNR/L2525M1204	25	25	150	35	25	32	0.8	VN**1204...	2

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

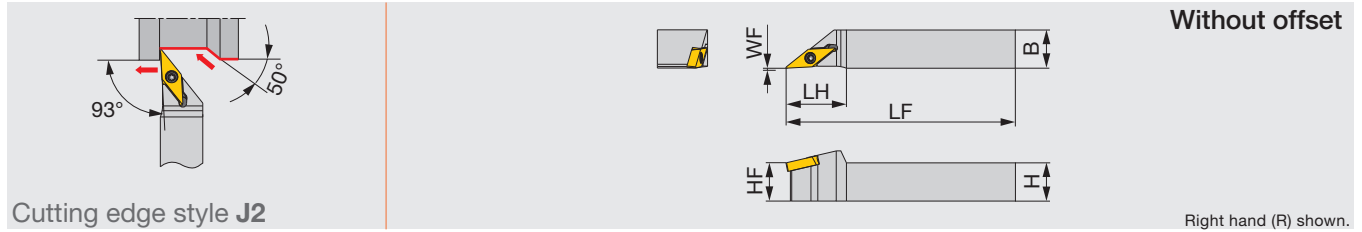
SPARE PARTS					
Designation	Shim	Clamping screw	Wrench	Spring pin	Lever
PVJNR/L**1204	LSV212	LCS3V	P-2.5	LSP3	LCL3V

INSERT SELECTION

Application	Finishing	Medium cutting
	Grade	T9215
Chipbreaker shape	TSF	TM
Cutting conditions	B006	

Application	Finishing	Medium cutting
	Grade	T6120
Chipbreaker shape	SS	SM
Cutting conditions	B008	

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



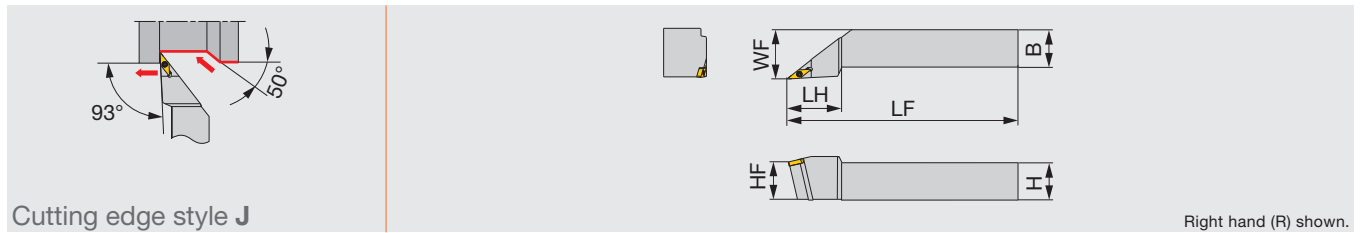
Designation	H	B	LF	LH	HF	WF	RE**	Insert	Torque*
JSVJ2XR/L1010X09	10	10	120	17	10	0	0.2	VXGU09T2**L/R...	0.9
JSVJ2XR/L1212F09	12	12	85	19	12	0	0.2	VXGU09T2**L/R...	0.9
JSVJ2XR/L1212X09	12	12	120	19	12	0	0.2	VXGU09T2**L/R...	0.9
JSVJ2XR/L1616X09	16	16	120	19	16	0	0.2	VXGU09T2**L/R...	0.9
JSVJ2XR/L2020H09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

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

SPARE PARTS

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

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



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

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

SPARE PARTS

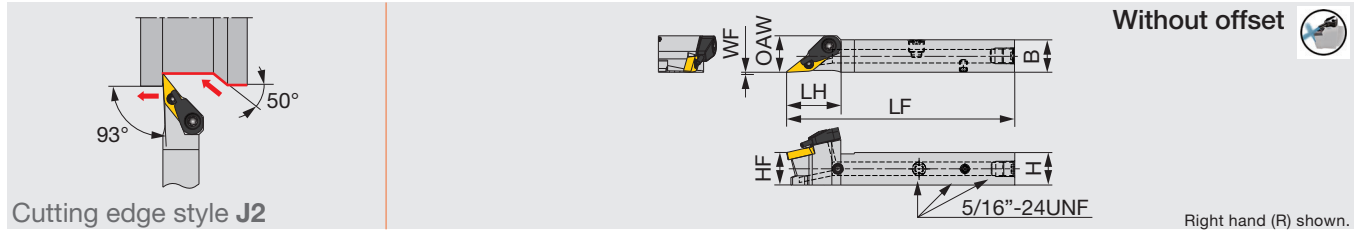
Designation	Clamping screw	Wrench
JSVJXR/L...	SR34-508	T-7F

INSERT SELECTION

Application	Finishing	Application	Finishing
Grade	SH725	Grade	SH725
Chipbreaker shape	JRP	Chipbreaker shape	JRP
Cutting conditions	C135	Cutting conditions	C135

Reference pages: JSVJ2XR/L, JSVJXR/L: Inserts → **B156**
 Standard cutting conditions → **C135**

Screw-on toolholder with 93° approach angle, for VXGU inserts, with high pressure coolant capability



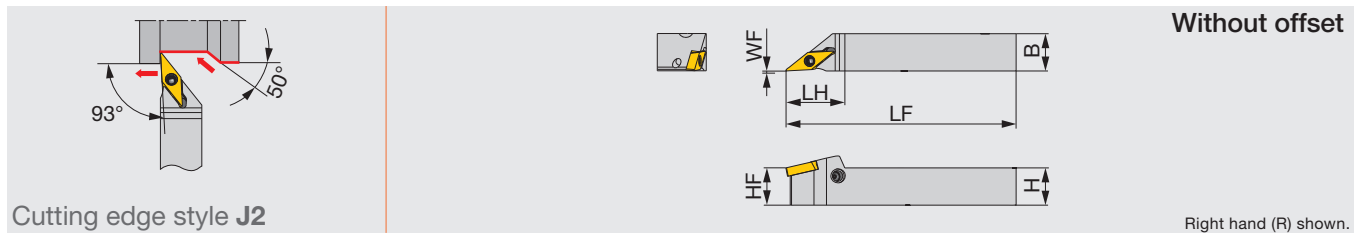
Designation	H	B	LF	LH	HF	WF	OAW	RE**	Insert	Torque*
JSVJ2XR/L1212F09-CHP	12	12	85	20	12	0	13.5	0.2	VXGU09T2**L/R...	0.9
JSVJ2XR1212X09-CHP ⁽¹⁾	12	12	120	19.5	12	0	13.4	0.2	VXGU09T2**L...	0.9
JSVJ2XR1616X09-CHP ⁽¹⁾	16	16	120	19.5	16	0	16	0.2	VXGU09T2**L...	0.9

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

SPARE PARTS

Designation	Clamping screw	Coolant unit	Wrench
JSVJ2XR/L1212F09-CHP	SR34-508	S-CU-CHP	T-7F

Back-clamp toolholder with 93° approach angle, for VXGU inserts



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

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

SPARE PARTS

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

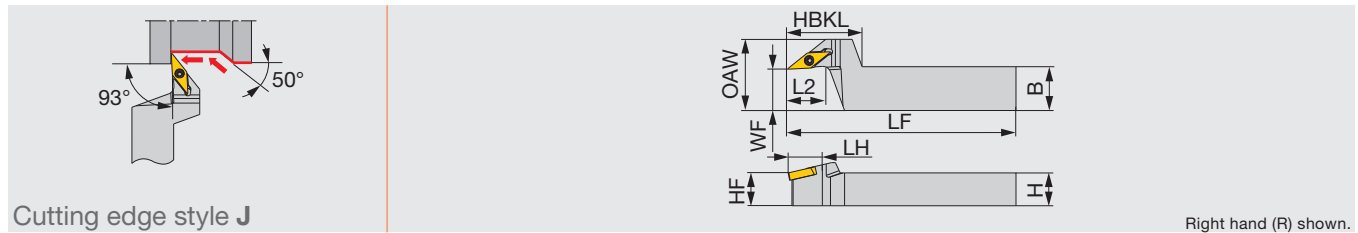
INSERT SELECTION

Application	Finishing	Application	Finishing
Grade	SH725	Grade	SH725
Chipbreaker shape	JRP	Chipbreaker shape	JRP
Cutting conditions	C135	Cutting conditions	C135

Reference pages: JSVJ2XR/L-CHP, JPVJ2XR/L: Insert → **B156**
 Standard cutting conditions → **C135**



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



Right hand (R) shown.

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

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

SPARE PARTS

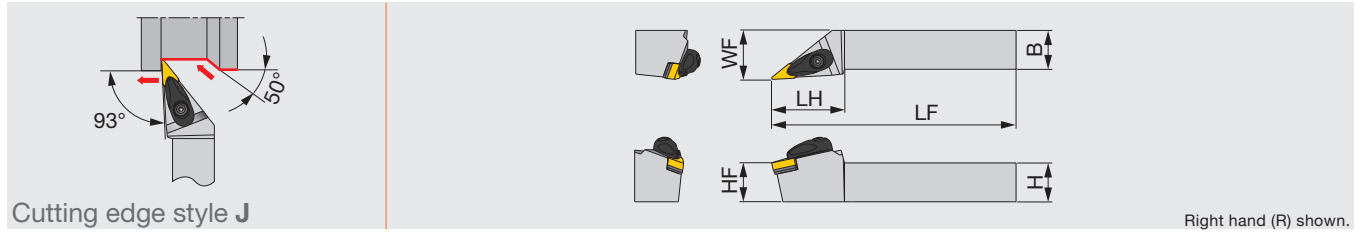
Designation	Clamping screw	Wrench
JSVJXR**-F15	SR34-508	T-7F

INSERT SELECTION

P	Application	Finishing	M	Application	Finishing
	Grade	SH725		Grade	SH725
	Chipbreaker shape	JRP		Chipbreaker shape	JRP
	Cutting conditions	C135		Cutting conditions	C135

Reference pages: JSVJXR-F: Inserts → **B156**
Standard cutting conditions → **C135**

Double-clamp toolholder with 93° approach angle, for negative 35° and 25° rhombic inserts



Right hand (R) shown.

Designation	H	B	LF	LH	HF	WF	RE**	Insert	Torque*
AVJNR/L2020K16-A	20	20	125	43	20	25	0.8	V/YN**1604...	3
AVJNR/L2525M16-A	25	25	150	46	25	32	0.8	V/YN**1604...	3

*Torque: Recommended clamping torque (N·m)

**RE: Standard corner radius

SPARE PARTS

Designation	Clamp	Clamp screw	Spring	Spring pin	Shim	Shim screw	Wrench
AVJNR/L**16-A	ACP3L	ACS-5W	BP-7	SP-2.5	ASV322	CSTB-3.5	T-15F

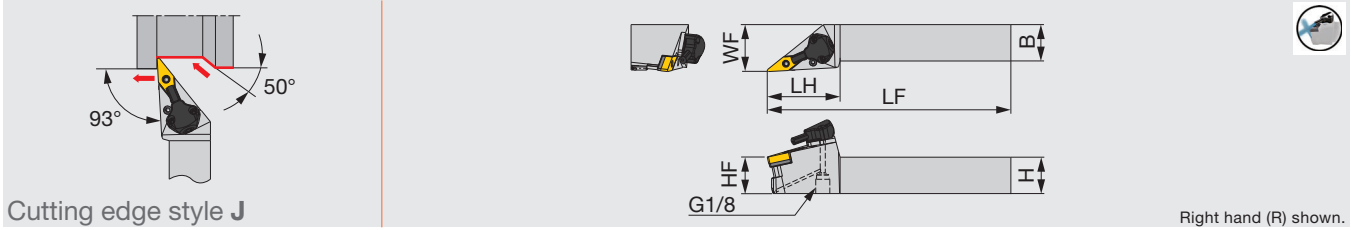
INSERT SELECTION

P	Application	Precision finishing	Finishing	Medium cutting	M	Application	Finishing	Medium cutting
	Grade	NS9530	GT9530	T9215		Grade	T6120	T6130
	Chipbreaker shape	TF	TSF	TM		Chipbreaker shape	SF	SM
	Cutting conditions	B006				Cutting conditions	B008	
K	Application	Finishing	Medium cutting	Medium to heavy cutting	N	Application	Precision finishing	
	Grade	T515	T515	T515		Grade	DX120	
	Chipbreaker shape	All-round	All-round	All-round		Chipbreaker shape	T-DIA with rake	
	Cutting conditions	B010				Cutting conditions	B012	
S	Application	Precision finishing	Finishing	Medium cutting	H	Application	Precision finishing	Finishing
	Grade	BX480	AH8005	AH8005		Grade	BXM10	BXM20
	Chipbreaker shape	T-CBN	HRF	HRM		Chipbreaker shape	T-CBN	T-CBN
	Cutting conditions	B014				Cutting conditions	B016	

Reference pages: AVJNR/L: Inserts → **B094** -, **B107**, CBN → **B178**, PCD → **B192**



Lever-lock toolholder with 93° approach angle, for negative 35° and 25° rhombic inserts, with high pressure coolant capability



Designation	H	B	LF	LH	HF	WF	RE**	Insert	Torque*
PVJNR/L2020K16-CHP	20	20	125	50	20	32	0.8	V/YN**1604...	2
PVJNR/L2525M16-CHP	25	25	150	50	25	32	0.8	V/YN**1604...	2

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

SPARE PARTS

Designation	Shim	Clamping screw	Wrench1	Spring pin	Lever
PVJNR/L**16-CHP	LSV317	LCS3V	P-2.5	LSP3	LCL3V

SPARE PARTS

Designation	Coolant unit	Mounting screw	Wrench2	O-ring	Coolant screw	Wrench3
PVJNR/L**16-CHP	CU-V-CHP	SRM3	T-8F	OR6.4X0.9N	SRM4X4TL360	P-2

INSERT SELECTION

Application	Precision finishing	Finishing	Medium cutting
	Grade	NS9530	GT9530
Chipbreaker shape	TF	TSF	TM
Cutting conditions	B006		

Application	Finishing	Medium cutting
	Grade	T6120
Chipbreaker shape	SF	SM
Cutting conditions	B008	

Application	Finishing	Medium cutting	Medium to heavy cutting
	Grade	T515	T515
Chipbreaker shape	All-round	All-round	All-round
Cutting conditions	B010		

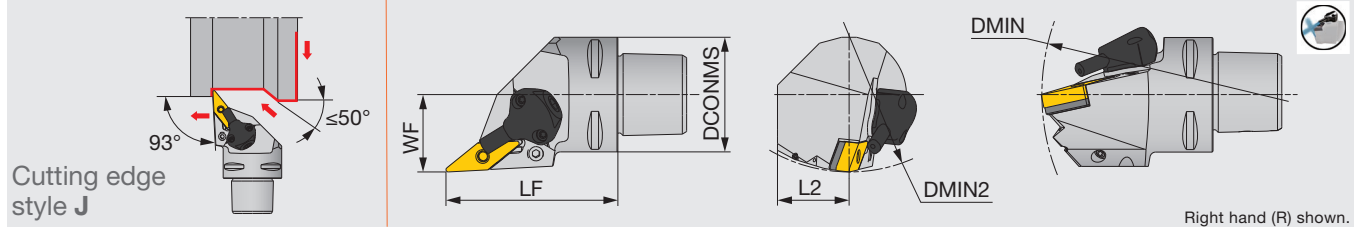
Application	Precision finishing
	Grade
Chipbreaker shape	T-DIA with rake
Cutting conditions	B012

Application	Precision finishing	Finishing	Medium cutting
	Grade	BX480	AH8005
Chipbreaker shape	T-CBN	HRF	HRM
Cutting conditions	B014		

Application	Precision finishing	Finishing
	Grade	BXM10
Chipbreaker shape	T-CBN	T-CBN
Cutting conditions	B016	

Reference pages: PVJNR/L-CHP: Inserts → **B094 -**, **B107**, CBN → **B178**, PCD → **B192**
Parts for coolant hose → **C134**

Lever-lock toolholder with TungCap connection, with 93° approach angle, for negative 35° and 25° inserts, with high pressure coolant capability



Designation	DCONMS	LF	L2	WF	DMIN	DMIN2	RE**	Insert
C4PVJNR/L27060-1204-CHP	40	60	20	27	140	90	0.8	VN**1204...
C4PVJNR/L27060-16-CHP	40	60	-	27	140	110	0.8	V/YN**1604...
C6PVJNR/L45065-1204-CHP	63	65	31.5	45	190	81	0.8	VN**1204...
C6PVJNR/L45065-16-CHP	63	65	-	45	190	81	0.8	V/YN**1604...

Applicable for 14 MPa coolant
**RE: Standard corner radius

SPARE PARTS

Designation	Shim	Clamping screw	Wrench1	Wrench2	Spring pin	Lever
C*PVJNR/L**1204-CHP	LSV212	LCS3V	P-2.5	P-3	LSP3	LCL3V
C*PVJNR/L**16-CHP	LSV317	LCS3V	P-2.5	-	LSP3	LCL3V

SPARE PARTS

Designation	Coolant unit	Mounting screw	Wrench3	O-ring
C*PVJNR/L**16-CHP	CU-V-CHP	SRM3	T-8F	OR6.4X0.9N

INSERT SELECTION

Application	Precision finishing	Finishing	Medium cutting
	Grade	NS9530	GT9530
Chipbreaker shape	TF	TSF	TM
Cutting conditions	B006		

Application	Finishing	Medium cutting
	Grade	T6120
Chipbreaker shape	SF	SM
Cutting conditions	B008	

Application	Finishing	Medium cutting	Medium to heavy cutting
	Grade	T515	T515
Chipbreaker shape	All-round	All-round	All-round
Cutting conditions	B010		

Application	Precision finishing
	Grade
Chipbreaker shape	T-DIA
Cutting conditions	B012

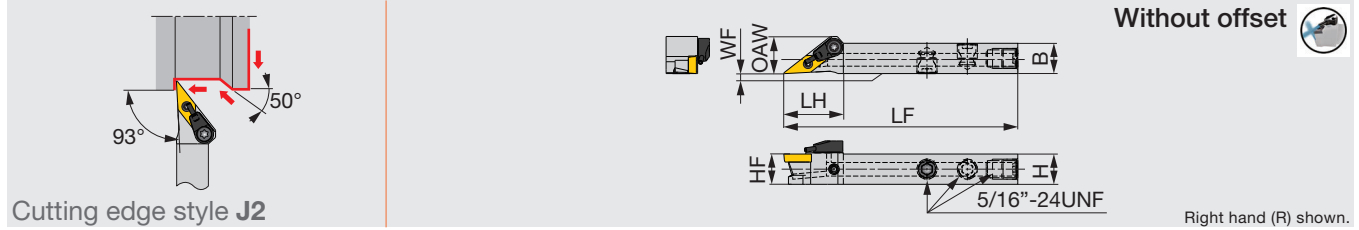
Application	Precision finishing	Finishing	Medium cutting
	Grade	BX470	AH8005
Chipbreaker shape	T-CBN	HRF	HRM
Cutting conditions	B014		

Application	Precision finishing	Finishing
	Grade	BXM10
Chipbreaker shape	T-CBN	T-CBN
Cutting conditions	B016	

Reference pages: C-PVJNR/L-CHP: Insert → **B094 - , B107**, CBN → **B178**, PCD → **B192**
Parts for coolant hose → **C134**



Screw-on toolholder with 93° approach angle, for positive 35° rhombic inserts, with high pressure coolant capability



Designation	H	B	LF	LH	HF	WF	OAW	RE**	Insert	Torque*
JSVJ2BR/L1212F11-CHP	12	12	85	23.6	12	0	14.7	0.2	VB**1103...	1.2
JSVJ2BR/L1212X11-CHP	12	12	120	23.6	12	0	14.7	0.2	VB**1103...	1.2
JSVJ2BR/L1616X11-CHP	16	16	120	23.6	16	0	16	0.2	VB**1103...	1.2

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

SPARE PARTS

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

INSERT SELECTION

P

Application	Finishing	Finishing to medium cutting
Grade	NS9530	T9215
Chipbreaker shape	PSS	PS
Cutting conditions	B018	

M

Application	Finishing	Finishing to medium cutting
Grade	AH725	AH630
Chipbreaker shape	PSF	PSS
Cutting conditions	B020	

K

Application	Finishing to medium cutting
Grade	T515
Chipbreaker shape	CM
Cutting conditions	B022

S

Application	Finishing	Finishing to medium cutting
Grade	AH8015	AH8015
Chipbreaker shape	PSS	PS
Cutting conditions	B026	

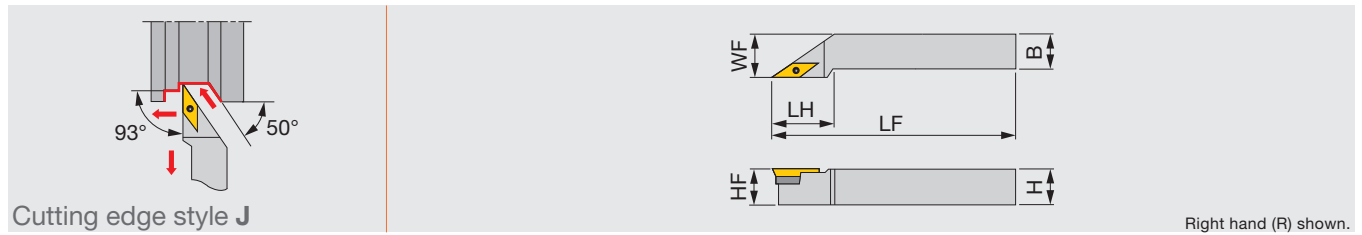
H

Application	Precision finishing	Finishing
Grade	BXM10	BXM20
Chipbreaker shape	T-CBN	T-CBN
Cutting conditions	B028	

Reference pages: JSVJ2BR/L-CHP: Inserts → **B150 -**, CBN → **B189 -**
Parts for coolant hose → **C134**

SVJCR/L

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



Right hand (R) shown.

Designation	H	B	LF	LH	HF	WF	RE**	Insert
SVJCR/L1616H16	16	16	100	32	16	20	0.8	VC**1604...
SVJCR/L2020K16	20	20	125	32	20	25	0.8	VC**1604...
SVJCR/L2525M16	25	25	150	40	25	32	0.8	VC**1604...

**RE: Standard corner radius

SPARE PARTS

Designation	Clamping screw	Shim screw	Shim	Wrench1	Wrench2
SVJCR/L...	CSTB-3.5L	DTS5-3.5	SSV32	P-3.5	T-15F

INSERT SELECTION

P	Application	Finishing	Finishing to medium cutting	M	Application	Finishing	Finishing to medium cutting	Medium cutting									
	Grade	NS9530	T9215		Grade	AH725	AH630	T6130									
	Chipbreaker shape	PSS	PS		Chipbreaker shape	PSF	PSS	PM									
Cutting conditions				B018					Cutting conditions				B020				
K	Application	Finishing to medium cutting	N	Application	Precision finishing	Finishing	Medium cutting										
	Grade	T515		Grade	DX120	DX140	KS05F										
	Chipbreaker shape	CM		Chipbreaker shape	T-DIA	with rake T-DIA	AL										
Cutting conditions				B022					Cutting conditions				B024				
S	Application	Finishing	Finishing to medium cutting	H	Application	Precision finishing	Finishing										
	Grade	AH8015	AH8015		Grade	BXM10	BXM20										
	Chipbreaker shape	PSS	PS		Chipbreaker shape	T-CBN	T-CBN										
Cutting conditions				B026					Cutting conditions				B028				

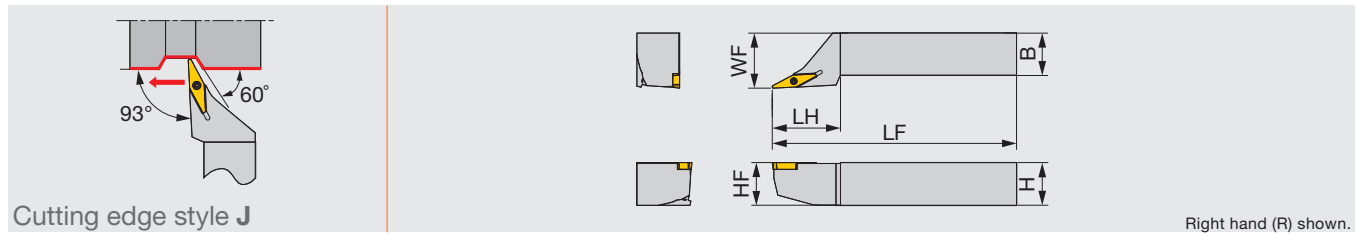
Reference pages: SVJCR/L:Inserts → B153 -, CBN → B190, PCD → B194



Y-PRO SERIES

SYJBR/L

Screw-on toolholder with 93° approach angle, for positive 25° rhombic inserts



Right hand (R) shown.

Designation	H	B	LF	LH	HF	WF	RE**	Insert
SYJBR/L2020K16	20	20	125	35	20	25	0.8	YWMT16T3...
SYJBR/L2525M16	25	25	150	40	25	32	0.8	YWMT16T3...

**RE: Standard corner radius

SPARE PARTS

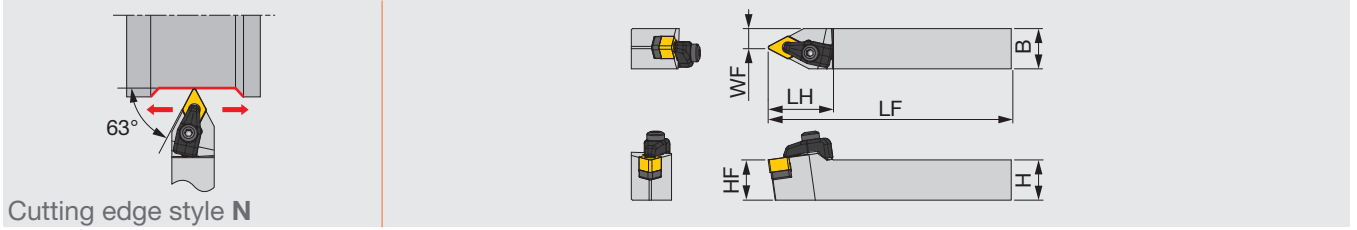
Designation	Clamping screw	Wrench
SYJBR/L...	CSTB-2.5L080	T-8F

INSERT SELECTION

Application	Finishing to medium cutting	Application	Finishing to medium cutting
Grade	T9225	Grade	GT9530
Chipbreaker shape	ZM	Chipbreaker shape	ZM
Cutting conditions	B006	Cutting conditions	B010

Reference pages: SYJBR/L: Inserts → **B160**

Double-clamp toolholder with 63° approach angle, for negative 55° rhombic ceramic inserts with dimple



Designation	H	B	LF	LH	HF	WF	RE**	Insert	Torque*
CDNNN2525M1507-RD	25	25	150	40	25	12.5	1.2	DN*D1507...	4

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

SPARE PARTS

Designation	Clamp	Clamp screw	Shim	Shim screw	Spring	Wrench1	Wrench2
CDNNN2525M1507-RD	CCP4-A	CCS4-A	CD44-A	BH5-10-A	BP-5-A	P-3	P-4

INSERT SELECTION

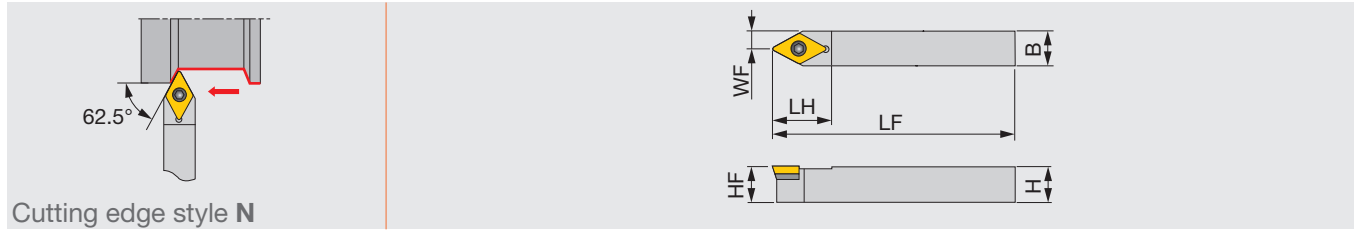
K	Application	Finishing to medium cutting
	Grade	FX105
	Chipbreaker shape	
	Cutting conditions	C136

Reference pages: CDNNN-RD: Inserts → **B073**
 Standard cutting conditions → **C136**



SDNCN

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



Designation	H	B	LF	LH	HF	WF	RE**	Insert
SDNCN1616H11	16	16	100	21	16	8	0.8	DC**11T3...
SDNCN2020K11	20	20	125	21	20	10	0.8	DC**11T3...
SDNCN2525M11	25	25	150	21	25	12.5	0.8	DC**11T3...

**RE: Standard corner radius

SPARE PARTS

Designation	Clamping screw	Shim screw	Shim	Wrench1	Wrench2
SDNCN...	CSTB-3.5L	DTS5-3.5	SSD32	P-3.5	T-15F

INSERT SELECTION

Application	Finishing	Finishing to medium cutting	Medium cutting
	Grade	NS9530	T9215
Chipbreaker shape	PSS	PS	PM
Cutting conditions	B018		

Application	Precision finishing	Finishing	Finishing to medium cutting	Medium cutting
	Grade	GH330	AH725	AH630
Chipbreaker shape	W**	PSF	PSS	PM
Cutting conditions	B020			

Application	Finishing to medium cutting
	Grade
Chipbreaker shape	CM
Cutting conditions	B022

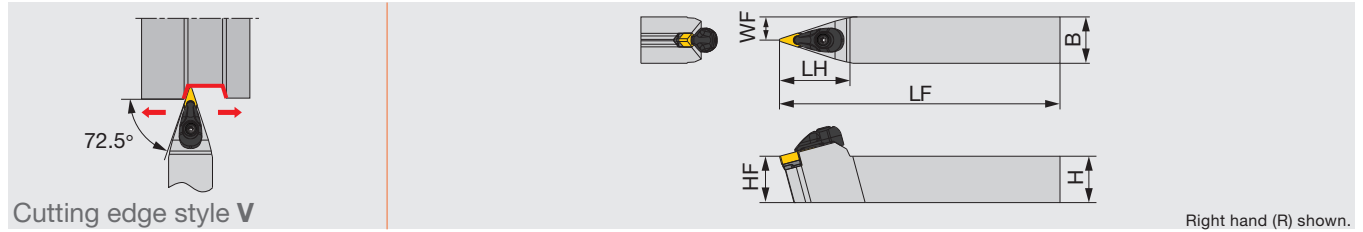
Application	Precision finishing	Finishing	Medium cutting
	Grade	DX120	DX140
Chipbreaker shape	T-DIA	with rake T-DIA	AL
Cutting conditions	B024		

Application	Finishing	Finishing to medium cutting
	Grade	AH8015
Chipbreaker shape	PSS	PS
Cutting conditions	B026	

Application	Precision finishing	Finishing
	Grade	BXM10
Chipbreaker shape	T-CBN	T-CBN
Cutting conditions	B028	

Reference pages: SDNCN:Inserts → B119 -, CBN → B182 -, PCD → B194

Double-clamp toolholder with 72.5° approach angle, for negative 35° rhombic inserts



Right hand (R) shown.

Designation	H	B	LF	LH	HF	WF	RE**	Insert	Torque*
AVVNN2020K1204-A	20	20	125	38	20	10	0.8	VN**1204...	3
AVVNN2525M1204-A	25	25	150	38	25	13	0.8	VN**1204...	3

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

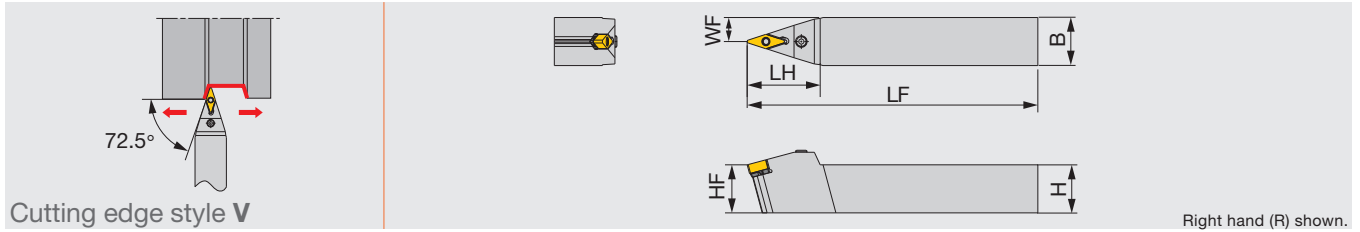
SPARE PARTS							
Designation	Clamp	Clamp screw	Spring	Spring pin	Shim	Shim screw	Wrench
AVVNN*-A	ACP3L-E	ACS-5W	BP-7	SP-2.5	ASV222	CSTB-3.0	T-15F

INSERT SELECTION

P	Application	Finishing	Medium cutting
	Grade	T9215	
Chipbreaker shape			
Cutting conditions	B006		

M	Application	Finishing	Medium cutting
	Grade	SS	T6120
Chipbreaker shape			
Cutting conditions	B008		





Designation	H	B	LF	LH	HF	WF	RE**	Insert	Torque*
PVVNN2020K1204	20	20	125	38	20	10	0.8	VN**1204...	2
PVVNN2525M1204	25	25	150	38	25	12.5	0.8	VN**1204...	2

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

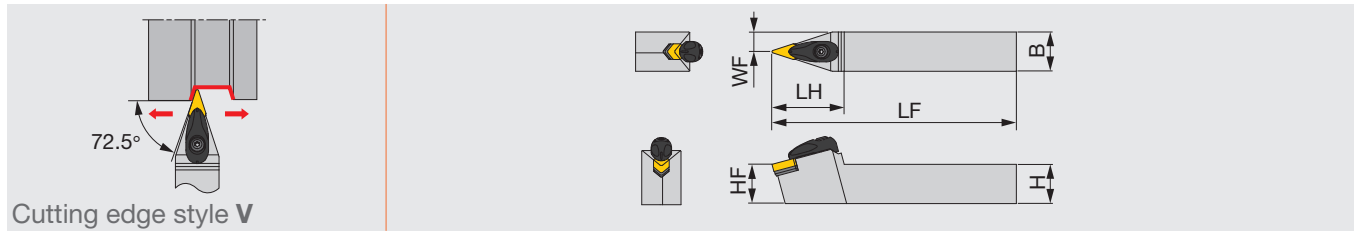
SPARE PARTS					
Designation	Shim	Clamping screw	Wrench	Spring pin	Lever
PVVNN**1204	LSV212	LCS3V	P-2.5	LSP3	LCL3V

INSERT SELECTION

Application	Finishing	Medium cutting
	Grade	T9215
Chipbreaker shape		
Cutting conditions	B006	

Application	Finishing	Medium cutting
	Grade	T6120
Chipbreaker shape		
Cutting conditions	B008	

Double-clamp toolholder with 72.5° approach angle, for negative 35° and 25° rhombic inserts



Designation	H	B	LF	LH	HF	WF	RE**	Insert	Torque*
AVVNN2020K16-A	20	20	125	46	20	10	0.8	V/YN**1604...	3
AVVNN2525M16-A	25	25	150	46	25	12.5	0.8	V/YN**1604...	3

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

SPARE PARTS							
Designation	Clamp	Clamp screw	Spring	Spring pin	Shim	Shim screw	Wrench
AVVNN**16-A	ACP3L	ACS-5W	BP-7	SP-2.5	ASV322	CSTB-3.5	T-15F

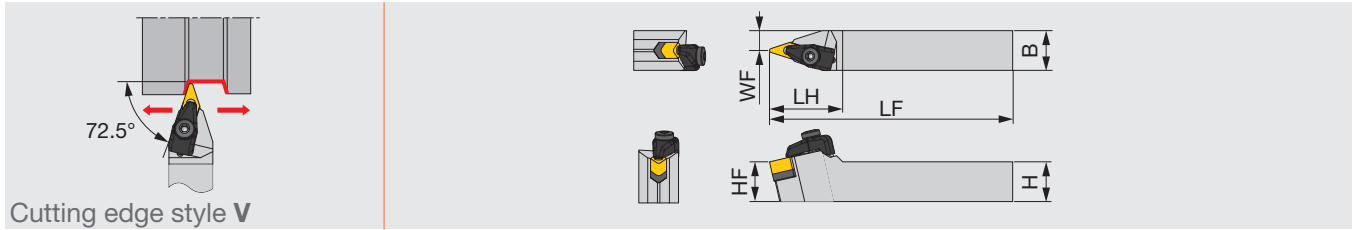
INSERT SELECTION

P	Application	Precision finishing	Finishing	Medium cutting	M	Application	Finishing	Medium cutting
	Grade	NS9530	GT9530	T9215		Grade	T6120	T6130
	Chipbreaker shape	TF	TSF	TM		Chipbreaker shape	SF	SM
	Cutting conditions	B006				Cutting conditions	B008	
K	Application	Finishing	Medium cutting	Medium to heavy cutting	N	Application	Precision finishing	
	Grade	T515	T515	T515		Grade	DX120	
	Chipbreaker shape	All-round	All-round	All-round		Chipbreaker shape	T-DIA with rake	
	Cutting conditions	B010				Cutting conditions	B012	
S	Application	Precision finishing	Finishing	Medium cutting	H	Application	Precision finishing	Finishing
	Grade	BX480	AH8005	AH8005		Grade	BXM10	BXM20
	Chipbreaker shape	T-CBN	HRF	HRM		Chipbreaker shape	T-CBN	T-CBN
	Cutting conditions	B014				Cutting conditions	B016	

Reference pages: AVVNN: Inserts → B094 -, B107, CBN → B178, PCD → B192



Double-clamp toolholder with 72.5° approach angle, for negative 35° rhombic ceramic inserts with dimple




Designation	H	B	LF	LH	HF	WF	RE**	Insert	Torque*
CVVNN2525M1607-RD	25	25	150	46	25	12.5	1.2	VN*D160712	4

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

SPARE PARTS

Designation	Clamp	Clamp screw	Shim	Shim screw	Spring	Wrench1	Wrench2
CVVNN2525M1607-RD	CCP4-A	CCS4-A	CV34-A	BH-4-10-A	BP-5-A	P-3	P-4

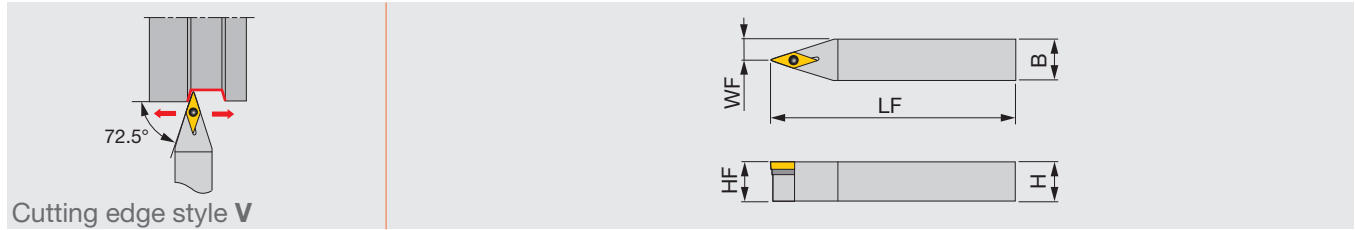
INSERT SELECTION

K	Application	Finishing to medium cutting
	Grade	FX105
	Chipbreaker shape	
	Cutting conditions	C136

Reference pages CVVNN-RD: Inserts → **B099**,
 Standard cutting conditions → **C136**

SVVCN

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



Designation	H	B	LF	HF	WF	RE**	Insert
SVVCN2020K16	20	20	125	20	10	0.8	VC**1604...
SVVCN2525M16	25	25	150	25	12.5	0.8	VC**1604...

**RE: Standard corner radius

SPARE PARTS						
Designation	Clamping screw	Shim screw	Shim	Wrench1	Wrench2	
SVVCN...	CSTB-3.5L	DTS5-3.5	SSV32	P-3.5	T-15F	

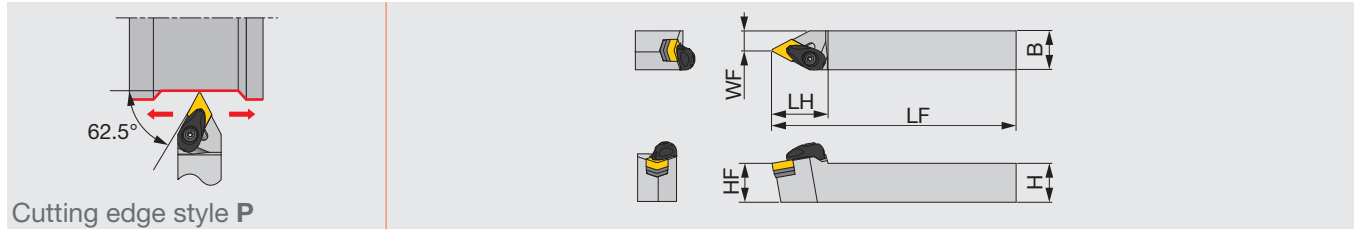
INSERT SELECTION

P	Application	Finishing	Finishing to medium cutting	M	Application	Finishing	Finishing to medium cutting	Medium cutting									
	Grade	NS9530	T9215		Grade	AH725	AH630	T6130									
	Chipbreaker shape				Chipbreaker shape												
Cutting conditions				B018					Cutting conditions				B020				
K	Application	Finishing to medium cutting	N	Application	Precision finishing	Finishing	Medium cutting										
	Grade	T515		Grade	DX120	DX140	KS05F										
	Chipbreaker shape			Chipbreaker shape	T-DIA	with rake T-DIA	AL										
Cutting conditions				B022					Cutting conditions				B024				
S	Application	Finishing	Finishing to medium cutting	H	Application	Precision finishing	Finishing										
	Grade	AH8015	AH8015		Grade	BXM10	BXM20										
	Chipbreaker shape				Chipbreaker shape	T-CBN	T-CBN										
Cutting conditions				B026					Cutting conditions				B028				

Reference pages: SVVCN: Inserts → B153 -, CBN → B190, PCD → B194

Grade A
 Insert B
 Ext. Toolholder C
 Int. Toolholder D
 Threading E
 Grooving F
 Miniature tool G
 Milling cutter H
 Endmill I
 Drilling tool J
 Tooling System K
 User's Guide L
 Index M

Double-clamp toolholder with 62.5° approach angle, for negative 55° rhombic inserts



Designation	H	B	LF	LH	HF	WF	RE**	Insert	Torque*
ADPNN2020K15-A	20	20	125	36	20	7.5	0.8	DN**1504...	3
ADPNN2525M15-A	25	25	150	36	25	12.5	0.8	DN**1504...	3

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

SPARE PARTS

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

INSERT SELECTION

Application	Precision finishing	Finishing	Medium cutting	Medium to heavy cutting
	Grade	NS9530	GT9530	T9215
Chipbreaker shape	TF	TSF	TM	TH
Cutting conditions	B006			

Application	Finishing	Medium cutting	Medium to heavy cutting
	Grade	T6120	T6130
Chipbreaker shape	SF	SM	SH
Cutting conditions	B008		

Application	Finishing	Medium cutting	Medium to heavy cutting
	Grade	T515	T515
Chipbreaker shape	All-round	All-round	All-round
Cutting conditions	B010		

Application	Precision finishing	Finishing	Medium cutting
	Grade	DX120	DX140
Chipbreaker shape	T-DIA	with rake T-DIA	P
Cutting conditions	B012		

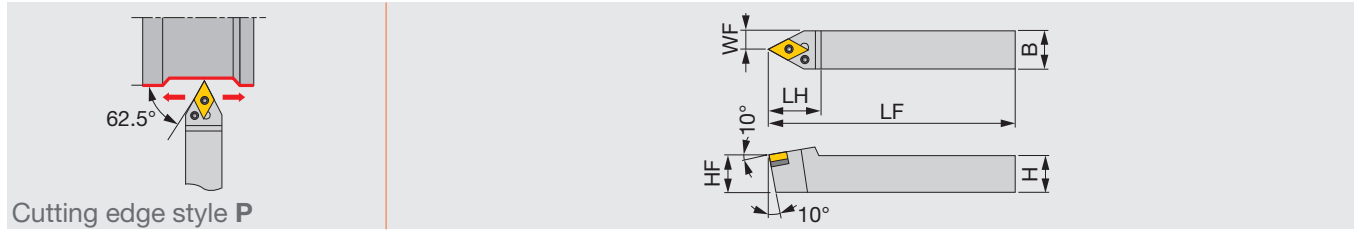
Application	Precision finishing	Finishing	Medium cutting
	Grade	BX470	AH8005
Chipbreaker shape	T-CBN	HRF	HRM
Cutting conditions	B014		

Application	Precision finishing	Finishing
	Grade	BXM10
Chipbreaker shape	T-CBN	T-CBN
Cutting conditions	B016	

Reference pages: ADPNN: Inserts → **B065 -**, CBN → **B172 -**, PCD → **B192**

PDPNN

Lever-lock toolholder with 62.5° approach angle, for negative 55° rhombic inserts



Designation	H	B	LF	LH	HF	WF	RE**	Insert
PDPNN2525	25	25	150	36	25	12.5	0.8	DN**1504...
PDPNN2525M15E	25	25	150	36	25	12.5	0.8	DN**1506...

**RE: Standard corner radius

SPARE PARTS

Designation	Shim	Clamping screw	Wrench	Spring pin	Lever
PDPNN2525	LSD42	LCS4	P-3	LSP4	LCL4
PDPNN2525M15E	ELSD42	ELCS4	P-3	LSP4S	LCL44

INSERT SELECTION

Application	Precision finishing	Finishing	Medium cutting	Medium to heavy cutting
	Grade	NS9530	GT9530	T9215
Chipbreaker shape	TF	TSF	TM	TH
Cutting conditions	B006			

Application	Finishing	Medium cutting	Medium to heavy cutting
	Grade	T6120	T6130
Chipbreaker shape	SF	SM	SH
Cutting conditions	B008		

Application	Finishing	Medium cutting	Medium to heavy cutting
	Grade	T515	T515
Chipbreaker shape	All-round	All-round	All-round
Cutting conditions	B010		

Application	Precision finishing	Finishing	Medium cutting
	Grade	DX120	DX140
Chipbreaker shape	T-DIA	with rake T-DIA	P
Cutting conditions	B012		

Application	Precision finishing	Finishing	Medium cutting
	Grade	BX470	AH8005
Chipbreaker shape	T-CBN	HRF	HRM
Cutting conditions	B014		

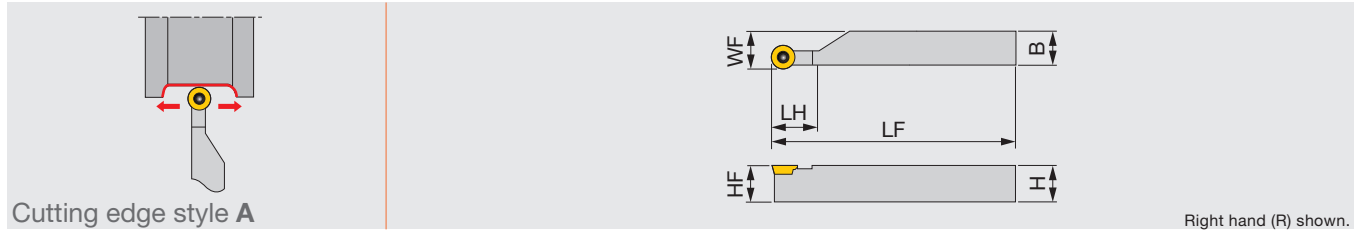
Application	Precision finishing	Finishing
	Grade	BXM10
Chipbreaker shape	T-CBN	T-CBN
Cutting conditions	B016	

Reference pages: PDPNN: Inserts → B065 -, CBN → B172 -, PCD → B192



SRACR/L

Screw-on toolholder with 91° approach angle, for positive round inserts



Designation	H	B	LF	LH	HF	WF	Insert
SRACR1010H05	10	10	100	10	10	10.3	RCMT0502...
SRACR/L1212H05	12	12	100	10	12	12.3	RCMT0502...
SRACR/L1212H06	12	12	100	12	12	12.4	RC*T0602...
SRACR1616H05	16	16	100	10	16	16.3	RCMT0502...
SRACR/L1616H06	16	16	100	12	16	16.4	RC*T0602...
SRACR/L1616H08	16	16	100	16	16	16.5	RC*T0803...
SRACR/L2020K05	20	20	125	10	20	20.3	RCMT0502...
SRACR/L2020K06	20	20	125	12	20	20.4	RC*T0602...
SRACR/L2020K08	20	20	125	16	20	20.5	RC*T0803...
SRACR/L2525M05	25	25	150	10	25	25.3	RCMT0502...
SRACR/L2525M06	25	25	150	12	25	25.4	RC*T0602...
SRACR/L2525M08	25	25	150	16	25	25.5	RC*T0803...

SPARE PARTS

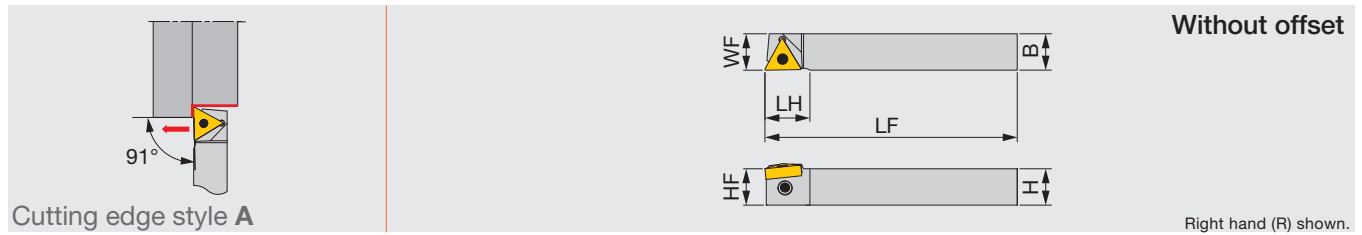
Designation	Clamping screw	Wrench
SRACR/L1*1H05	CSTB-2.2R	T-7F
SRACR/L1212H06	CSTB-2.5	T-8F
SRACR1616H05	CSTB-2.2R	T-7F
SRACR/L1616H06	CSTB-2.5	T-8F
SRACR/L1616H08	CSTB-3	T-9F
SRACR/L2020K05	CSTB-2.2R	T-7F
SRACR/L2020K06	CSTB-2.5	T-8F
SRACR/L2020K08	CSTB-3	T-9F
SRACR/L2525M05	CSTB-2.2R	T-7F
SRACR/L2525M06	CSTB-2.5	T-8F
SRACR/L2525M08	CSTB-3	T-9F

INSERT SELECTION

P	Application	Finishing to medium cutting	heavy cutting	M	Application	heavy cutting
	Grade	T9215	T9215		Grade	T9215
	Chipbreaker shape				Chipbreaker shape	
	Cutting conditions	B018			Cutting conditions	B020
K	Application	heavy cutting		N	Application	Finishing to medium cutting
	Grade	T9215			Grade	KS05F
	Chipbreaker shape				Chipbreaker shape	
	Cutting conditions	B022			Cutting conditions	B024
S	Application	Finishing to medium cutting	heavy cutting			
	Grade	AH8015	AH8015			
	Chipbreaker shape					
	Cutting conditions	B026				

Reference pages: SRACR/L: Inserts → **B129** -

Back-clamp toolholder with 91° approach angle, for negative 60° triangular inserts



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

*Torque: Recommended clamping torque (N-m)

**RE: Standard corner radius

SPARE PARTS

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

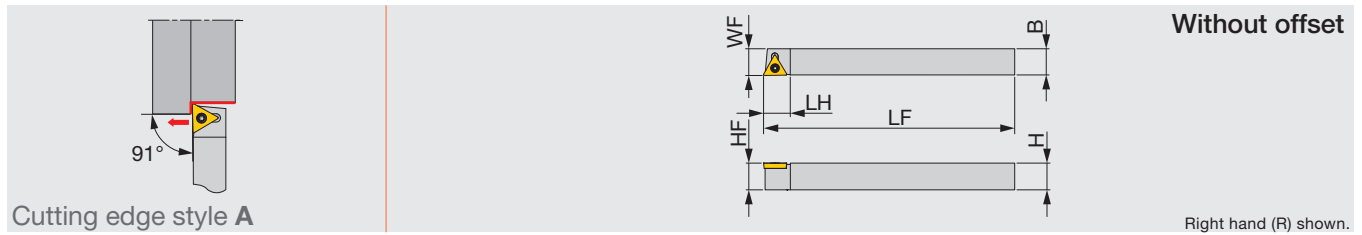
INSERT SELECTION

P	Application	Precision finishing	M	Application	Precision finishing	
	Grade	SH725		Grade	SH725	
	Chipbreaker shape	01		Chipbreaker shape	01	
	Cutting conditions	B006		Cutting conditions	B008	
K	Application	Finishing to medium cutting	N	Application	Precision finishing	
	Grade	T515		Grade	DX120	
	Chipbreaker shape	CM		Chipbreaker shape	T-DIA with rake	
	Cutting conditions	B010		Cutting conditions	B012	
S	Application	Precision finishing	H	Application	Precision finishing	Finishing
	Grade	BX470		Grade	BXM10	BXM20
	Chipbreaker shape	T-CBN		Chipbreaker shape	T-CBN	T-CBN
	Cutting conditions	B014		Cutting conditions	B016	

Reference pages: JTTANR/L: Inserts → B084 -, CBN → B176 -, PCD → B192 -



Screw-on toolholder with 91° approach angle, for positive 60° triangular inserts



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

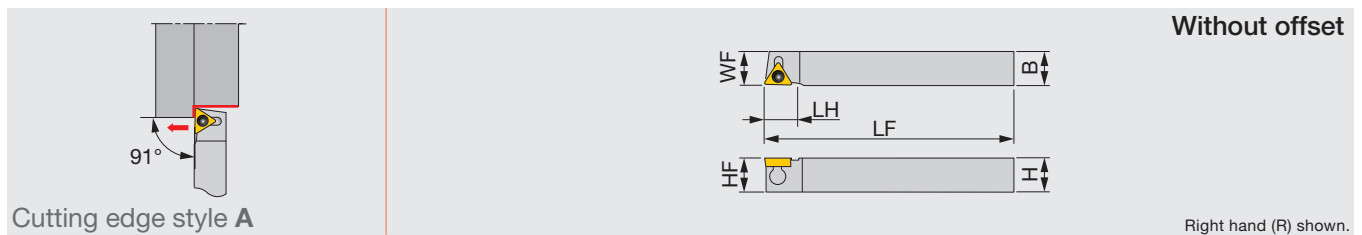
*Torque: Recommended clamping torque (N-m)

**RE: Standard corner radius

SPARE PARTS

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

Back-clamp toolholder with 91° approach angle, for positive 60° triangular inserts



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

*Torque: Recommended clamping torque (N-m)

**RE: Standard corner radius

SPARE PARTS

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

INSERT SELECTION

Application	Precision finishing	Finishing	Finishing to medium cutting	Medium cutting
	Grade	SH725	SH725	T9215
Chipbreaker shape	01	JS	PS	PM
Cutting conditions	B018			

Application	Precision finishing	Finishing	Finishing to medium cutting	Medium cutting
	Grade	SH725	SH725	T9215
Chipbreaker shape	01	JS	PS	PM
Cutting conditions	B020			

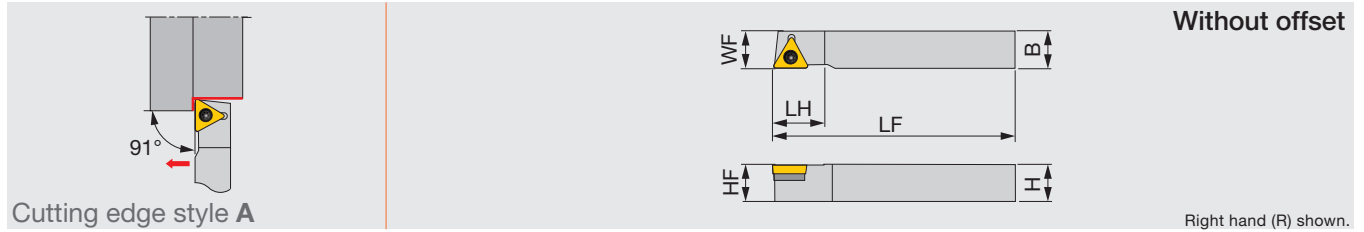
Application	Finishing to medium cutting
	Grade
Chipbreaker shape	CM
Cutting conditions	B022

Application	Precision finishing	Medium cutting
	Grade	DX120
Chipbreaker shape	T-DIA	with rake AL
Cutting conditions	B024	

Reference pages: JSTACR/L, JTTACR/L: Inserts → B137 -, PCD → B194

STACR/L

Screw-on toolholder with 91° approach angle, for positive 60° triangular inserts



Designation	H	B	LF	LH	HF	WF	RE**	Insert
STACR/L1616H16	16	16	100	22.5	16	16	0.8	TC**16T3...

**RE: Standard corner radius

SPARE PARTS

Designation	Clamping screw	Shim screw	Shim	Wrench1	Wrench2
STACR/L...	CSTB-3.5L	DTS5-3.5	SST32	P-3.5	T-15F

INSERT SELECTION

P	Application	Precision finishing	Finishing	Finishing to medium cutting	Medium cutting
	Grade	NS9530	NS9530	T9215	T9215
	Chipbreaker shape	01	PSS	PS	PM
	Cutting conditions	B018			

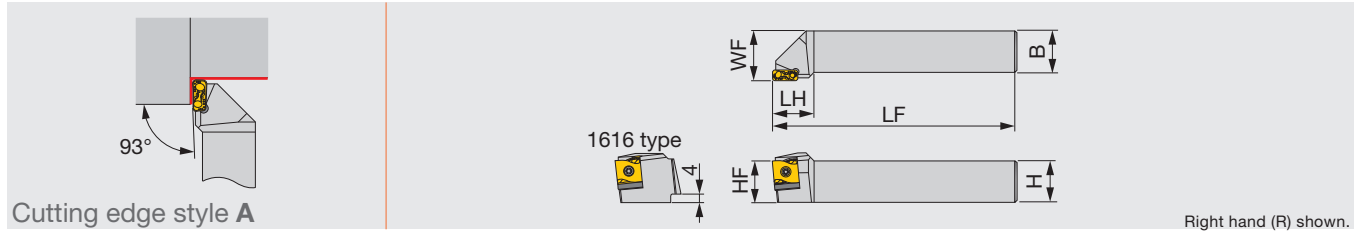
M	Application	Finishing	Medium cutting
	Grade	AH725	T6130
	Chipbreaker shape	PSF	PM
	Cutting conditions	B020	

K	Application	Finishing to medium cutting
	Grade	T515
	Chipbreaker shape	CM
	Cutting conditions	B022

N	Application	Precision finishing
	Grade	DX120
	Chipbreaker shape	T-DIA with rake
	Cutting conditions	B024

Reference pages: STACR/L: Inserts → **B137** -

Screw-on toolholder for roughing with 93° approach angle, for negative tangential inserts



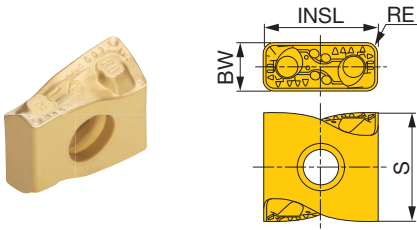
Designation	H	B	LF	LH	HF	WF	Insert
TLANR/L1616H12	16	16	100	20	16	20	LNMX1204**R/L...
TLANR/L1616M12S	16	16	150	20	16	20	LNMX1204**R/L...
TLANR/L2020K12	20	20	125	20	20	25	LNMX1204**R/L...
TLANR/L2020K16	20	20	125	25	20	25	LNMX1204**R/L...
TLANR/L2525M12	25	25	150	20	25	30	LNMX1204**R/L...
TLANR/L2525M16	25	25	150	25	25	30	LNMX1606**R/L...
TLANR/L3232P16	32	32	170	35	32	37	LNMX1606**R/L...
TLANR/L3232P24	32	32	170	35	32	38	LNMX2410**R/L...
TLANR/L4040R16	40	40	200	35	40	47	LNMX1606**R/L...
TLANR/L4040R24	40	40	200	40	40	47	LNMX2410**R/L...
TLANR/L5050S24	50	50	250	40	50	57	LNMX2410**R/L...

Designation	SPARE PARTS					
	Clamping screw	Shim screw	Shim	Spring	Wrench 1	Wrench 2
TLANR1616H12	CSTB-3.5L115-S	CSTF-2L055-S	TSL12R	-	KEYV-T10	T-6F-S
TLANL1616H12	CSTB-3.5L115-S	CSTF-2L055-S	TSL12L	-	KEYV-T10	T-6F-S
TLANR1616M12S	CSTB-3.5L115-S	CSTF-2L055-S	TSL12R	-	KEYV-T10	T-6F-S
TLANL1616M12S	CSTB-3.5L115-S	CSTF-2L055-S	TSL12L	-	KEYV-T10	T-6F-S
TLANR2020K12	CSTB-3.5L115-S	CSTF-2L055-S	TSL12R	-	KEYV-T10	T-6F-S
TLANL2020K12	CSTB-3.5L115-S	CSTF-2L055-S	TSL12L	-	KEYV-T10	T-6F-S
TLANR2020K16	CSTB-4L115-S	-	TSL16R	PSP-16	KEYV-T15	-
TLANL2020K16	CSTB-4L115-S	-	TSL16L	PSP-16	KEYV-T15	-
TLANR2525M12	CSTB-3.5L115-S	CSTF-2L055-S	TSL12R	-	KEYV-T10	T-6F-S
TLANL2525M12	CSTB-3.5L115-S	CSTF-2L055-S	TSL12L	-	KEYV-T10	T-6F-S
TLANR2525M16	CSTB-4L115-S	-	TSL16R	PSP-16	KEYV-T15	-
TLANL2525M16	CSTB-4L115-S	-	TSL16L	PSP-16	KEYV-T15	-
TLANR3232P16	CSTB-4L115-S	-	TSL16R	PSP-16	KEYV-T15	-
TLANL3232P16	CSTB-4L115-S	-	TSL16L	PSP-16	KEYV-T15	-
TLANR3232P24	CSTB-5L163-S	-	TSL24R	SP 16-L14	KEYV-T20	-
TLANL3232P24	CSTB-5L163-S	-	TSL24L	SP 16-L14	KEYV-T20	-
TLANR4040R16	CSTB-4L115-S	-	TSL16R	PSP-16	KEYV-T15	-
TLANL4040R16	CSTB-4L115-S	-	TSL16L	PSP-16	KEYV-T15	-
TLANR4040R24	CSTB-5L163-S	-	TSL24R	SP 16-L14	KEYV-T20	-
TLANL4040R24	CSTB-5L163-S	-	TSL24L	SP 16-L14	KEYV-T20	-
TLANR5050S24	CSTB-5L163-S	-	TSL24R	SP 16-L14	KEYV-T20	-
TLANL5050S24	CSTB-5L163-S	-	TSL24L	SP 16-L14	KEYV-T20	-

Reference pages: TLANR/L: Inserts → **C079**
Standard cutting conditions → **C136**

INSERT

LNMX12/16/24



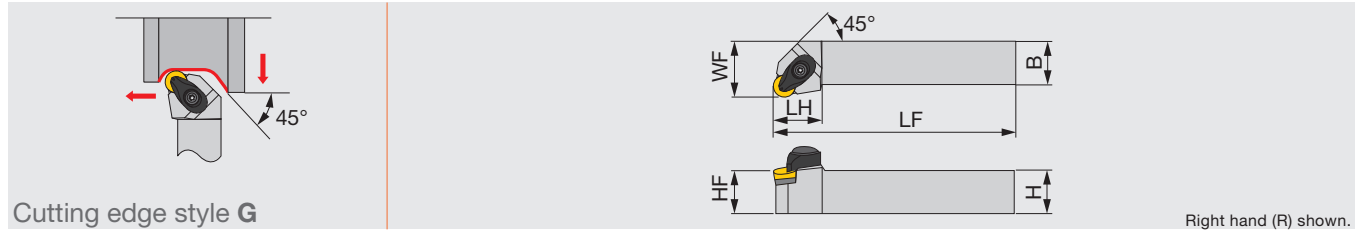
P	Steel	★	★	★						
M	Stainless			☆						
K	Cast iron	☆	☆	☆						
N	Non-ferrous									
S	Superalloys									
H	Hard materials									

★ : First choice
☆ : Second choice

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

● : Line up

Double-clamp toolholder with 91° approach angle, for negative round inserts



Designation	H	B	LF	LH	HF	WF	RE**	Insert	Torque*
ARGNR/L2525M12-A	25	25	150	28	25	32	6.35	RN**120400	3

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

SPARE PARTS							
Designation	Clamp	Clamp screw	Spring	Spring pin	Shim	Shim screw	Wrench
ARGNR/L...	ACP4S	ACS-5W	BP-7	SP-2.5	ASR420	CSTB-3.5	T-15F

- L
- J
- N
- V
- P
- A
- G**
- B-R
- X
- D
- S
- K
- F
- Q+H
- Special

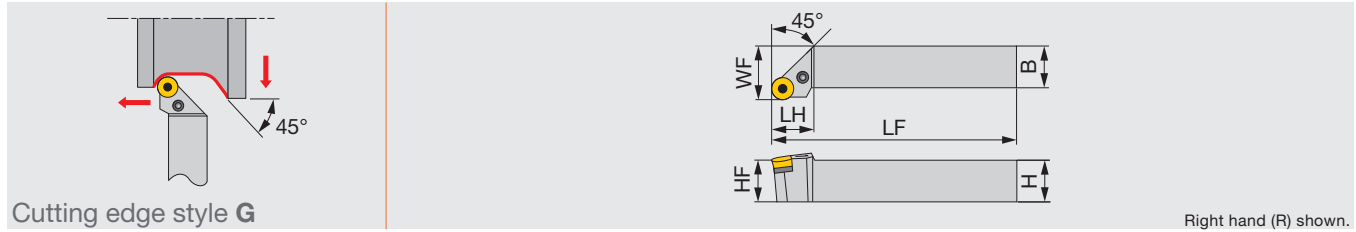
INSERT SELECTION

P	Application	Semi-finishing to medium cutting
	Grade	T9225
	Chipbreaker Shape	61
	Cutting conditions	B006

Reference pages: ARGNR/L: Inserts → **B074**

PRGNR/L

Lever-lock toolholder with 91° approach angle, for negative round inserts



Designation	H	B	LF	LH	HF	WF	RE**	Insert
PRGNR/L2020	20	20	125	19	20	25	4.76	RNMG090300-61
PRGNR/L2525M4	25	25	150	25	25	32	6.35	RN**120400

**RE: Standard corner radius

SPARE PARTS

Designation	Shim	Clamping screw	Wrench	Spring pin	Lever
PRGNR/L2020	LSR32	LCS3	P-2.5	LSP3	LCL3
PRGNR/L2525M4	LSR42	LCS4	P-3	LSP4	LCL4

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



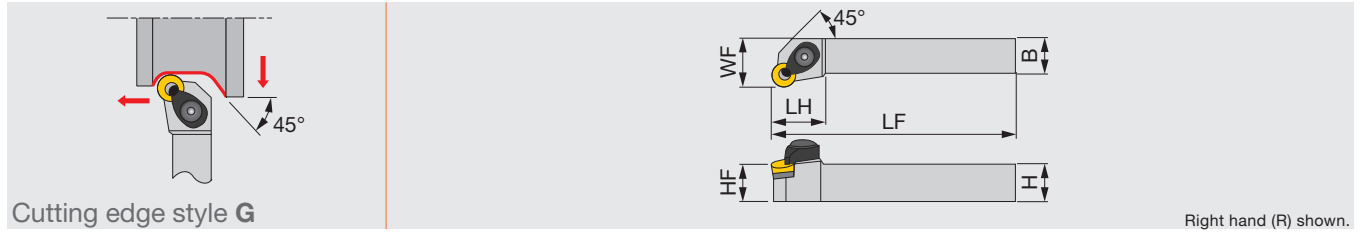
INSERT SELECTION

P	Applicadtion	Heavy cutting	M	Applicadtion	Heavy cutting
	Grade	T9215		Grade	T9215
	Chipbreaker Shape			Chipbreaker Shape	
	Cutting conditions	B006		Cutting conditions	B008
K	Applicadtion	Heavy cutting	N	Applicadtion	Heavy cutting
	Grade	T9215		Grade	TH10
	Chipbreaker Shape			Chipbreaker Shape	
	Cutting conditions	B010		Cutting conditions	B012
S	Applicadtion	Heavy cutting	H	Applicadtion	Finishing to medium cutting
	Grade	TH10		Grade	LX11
	Chipbreaker Shape			Chipbreaker Shape	
	Cutting conditions	B014		Cutting conditions	B016

Reference pages: PRGNR/L: Inserts → **B074**

DRG NR/L

"One-Double" toolholder with 91° approach angle, for negative round inserts



Designation	H	B	LF	LH	HF	WF	RE**	Insert
DRG NR/L2525M12	25	25	150	28	25	32	6.35	RN**120400

**RE: Standard corner radius

SPARE PARTS

Designation	Clamp	Lever	Piston	Clamp screw	Shim	Spring	Spring pin	Wrench 1	Wrench 2
DRG NR/L...	DCPM-43	DLCL43	DPIS43	DLCS43	LSR42	BP-10	LSP4	P-3	P-4

- L
- J
- N
- V
- P
- A
- G**
- B-R
- X
- D
- S
- K
- F
- Q+H
- Special

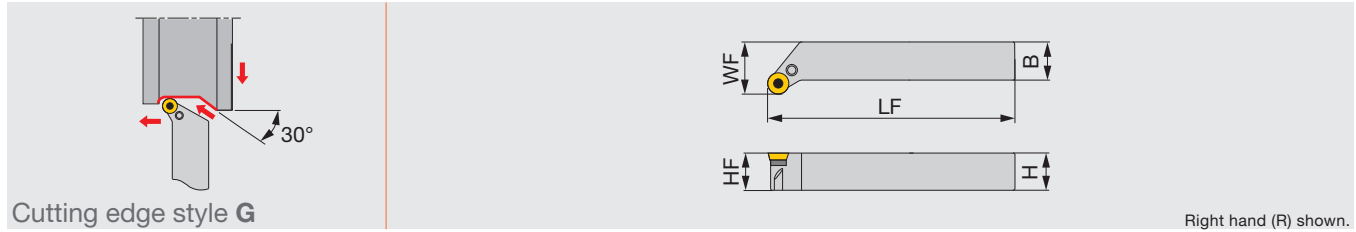
INSERT SELECTION

P	Application	Semi-finishing to medium cutting
	Grade	T9215
	Chipbreaker Shape	61
	Cutting conditions	B006

Reference pages: DRG NR/L: Inserts → **B074**

PRGCR/L

Lever-lock toolholder with 91° approach angle, for positive round inserts



Right hand (R) shown.

Designation	H	B	LF	HF	WF	Insert
PRGCR/L2020K10	20	20	125	20	25	RCMM1003...
PRGCR/L2525M12	25	25	150	25	32	RCM*1204...
PRGCR/L3225P16	32	25	170	32	32	RCM*1606...
PRGCR/L3232P20	32	32	170	32	40	RCM*2006...

SPARE PARTS

Designation	Shim	Clamping screw	Wrench	Spring pin	Lever
PRGCR/L2020K10	LSR32C	LCS2	P-2	LSP3	LCL3C
PRGCR/L2525M12	LSR42C	LCS3	P-2.5	LSP3	LCL4C
PRGCR/L3225P16	LSR53C	LCS5	P-3	LSP4	LCL5C
PRGCR/L3232P20	LSR63C	LCS5	P-3	LSP6C	LCL6C

INSERT SELECTION

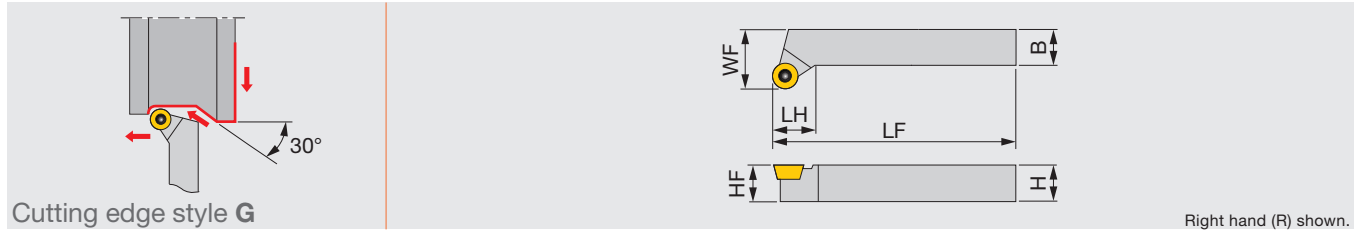
P	Application	Finishing to medium cutting	Heavy cutting	M	Application	Heavy cutting
	Grade	T9215	T9215		Grade	T9215
	Chipbreaker Shape				Chipbreaker Shape	
	Cutting conditions	B018			Cutting conditions	B020
K	Application	Heavy cutting		N	Application	Finishing to medium cutting
	Grade	T9215			Grade	KS05F
	Chipbreaker Shape				Chipbreaker Shape	
	Cutting conditions	B022			Cutting conditions	B024
S	Application	Finishing to medium cutting	Heavy cutting	H	Application	Medium cutting
	Grade	AH8015	AH8015		Grade	LX11
	Chipbreaker Shape				Chipbreaker Shape	
	Cutting conditions	B026			Cutting conditions	B028

Reference pages: PRGCR/L: Inserts → **B129 -**



SRGCR/L

Screw-on toolholder with 91° approach angle, for positive round inserts



Designation	H	B	LF	LH	HF	WF	Insert
SRGCR1212H05	12	12	100	9.5	12	16	RCMT0502...
SRGCR/L1212H06	12	12	100	10	12	16	RC*T0602...
SRGCR/L1616H05	16	16	100	9.5	16	20	RCMT0502...
SRGCR/L1616H06	16	16	100	10	16	20	RC*T0602...
SRGCR/L1616H08	16	16	100	11	16	20	RC*T0803...
SRGCR/L2020K05	20	20	125	11.2	20	25	RCMT0502...
SRGCR/L2020K06	20	20	125	12	20	25	RC*T0602...
SRGCR/L2020K08	20	20	125	12.7	20	25	RC*T0803...
SRGCR/L2020K10	20	20	125	14	25	25	RC*T1003...
SRGCR/L2525M05	25	25	150	14.7	25	32	RCMT0502...
SRGCR/L2525M06	25	25	150	15	25	32	RC*T0602...
SRGCR/L2525M08	25	25	150	16.2	25	32	RC*T0803...
SRGCR/L2525M10	25	25	150	17.5	25	32	RC*T1003...

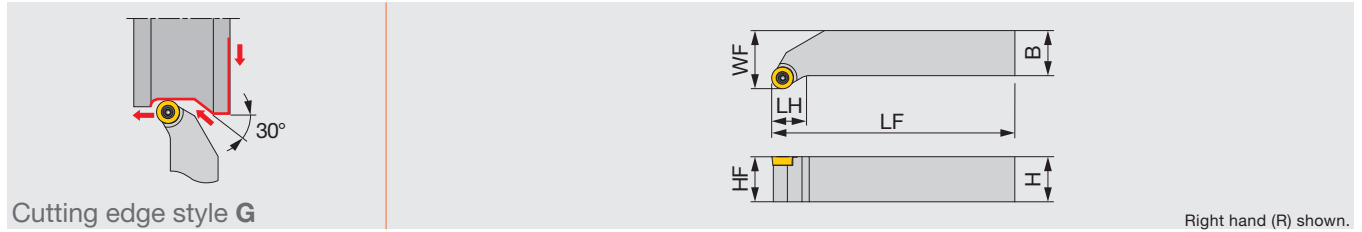
SPARE PARTS						
Designation	Clamping screw	Shim screw	Shim	Wrench 1	Wrench 2	
SRGCR1212H05	CSTB-2.2R	-	-	-	T-7F	
SRGCR/L1212H06	CSTB-2.5	-	-	-	T-8F	
SRGCR/L1616H05	CSTB-2.2R	-	-	-	T-7F	
SRGCR/L1616H06	CSTB-2.5	-	-	-	T-8F	
SRGCR/L1616H08	CSTB-3	-	-	-	T-9F	
SRGCR/L2020K05	CSTB-2.2R	-	-	-	T-7F	
SRGCR/L2020K06	CSTB-2.5	-	-	-	T-8F	
SRGCR/L2020K08	CSTB-3	-	-	-	T-9F	
SRGCR/L2020K10	CSTB-3.5L	DTS5-3.5	SSR32	P-3.5	T-15F	
SRGCR/L2525M05	CSTB-2.2R	-	-	-	T-7F	
SRGCR/L2525M06	CSTB-2.5	-	-	-	T-8F	
SRGCR/L2525M08	CSTB-3	-	-	-	T-9F	
SRGCR/L2525M10	CSTB-3.5L	DTS5-3.5	SSR32	P-3.5	T-15F	

INSERT SELECTION

P	Application	Finishing to medium cutting	Heavy cutting	M	Application	Heavy cutting
	Grade	T9215	T9215		Grade	T9215
	Chipbreaker Shape	RS	61		Chipbreaker Shape	61
Cutting conditions				B018		
Cutting conditions				B020		
K	Application	Heavy cutting		N	Application	Finishing to medium cutting
	Grade	T9215			Grade	KS05F
	Chipbreaker Shape	61			Chipbreaker Shape	AL
Cutting conditions				B022		
Cutting conditions				B024		
S	Application	Finishing to medium cutting	Heavy cutting			
	Grade	AH8015	AH8015			
	Chipbreaker Shape	RS	61			
Cutting conditions				B026		

Reference pages: SRGCR/L: Inserts → B129 -

Screw-on toolholder with 91° approach angle, for positive round inserts



Right hand (R) shown.

Designation	H	B	LF	LH	HF	WF	Insert	Torque*
SRGCR/L2525M12-6F	25	25	150	18.6	25	32	RCMT1204M0-6RS/-6RM	3

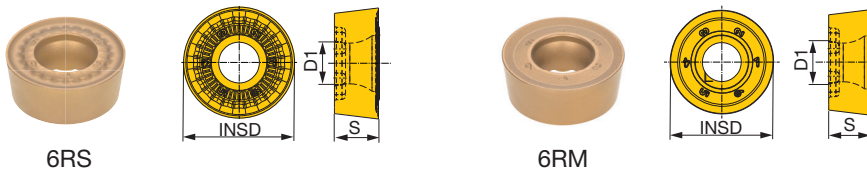
*Torque: Recommended clamping torque (N·m)

SPARE PARTS

Designation	Clamping screw	Lubricant	Wrench
SRGCR/L2525M12-6F	CSTB-4	M-1000	T-15F

INSERT

RCMT



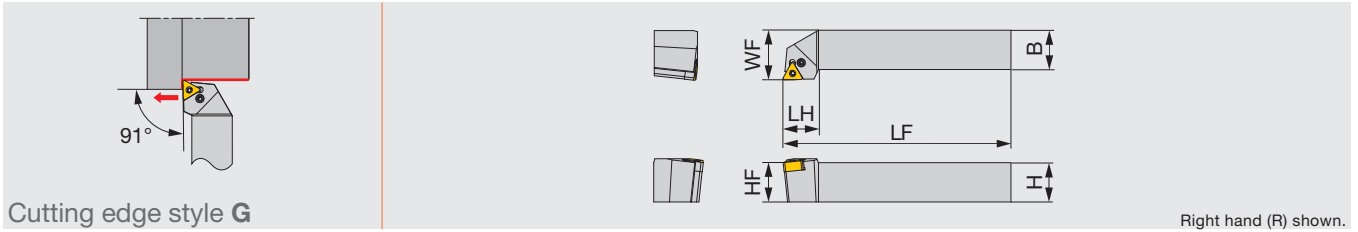
	P	M	K	N	S	H
Steel	★	★	★	★		★
Stainless						
Cast iron	☆	☆	☆	☆		☆
Non-ferrous						
Superalloys						
Hard materials						

★ : First choice
☆ : Second choice

Designation	Coated				Cermet				INSD	S	D1
	T9225	T9215	T9115	T9125	NS9530						
RCMT1204M0-6RS	●	●	●	●	●				12	4.76	5.16
RCMT1204M0-6RM	●	●	●	●	●				12	4.76	5.16

● : Line up

Lever-lock toolholder with 91° approach angle, for negative triangular inserts



Cutting edge style **G**

Right hand (R) shown.

Designation	H	B	LF	LH	HF	WF	RE**	Insert	Torque*
PTGNR/L2020K1104	20	20	125	20	20	25	0.8	TN**1104...	2
PTGNR/L2525M1104	25	25	150	20	25	32	0.8	TN**1104...	2

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

SPARE PARTS

Designation	Clamping screw	Wrench	Lever
PTGNR/L**1104	LCS23A	P-2.5	LCL23

- L
- J
- N
- V
- P
- A
- G**
- B-R
- X
- D
- S
- K
- F
- Q+H
- Special

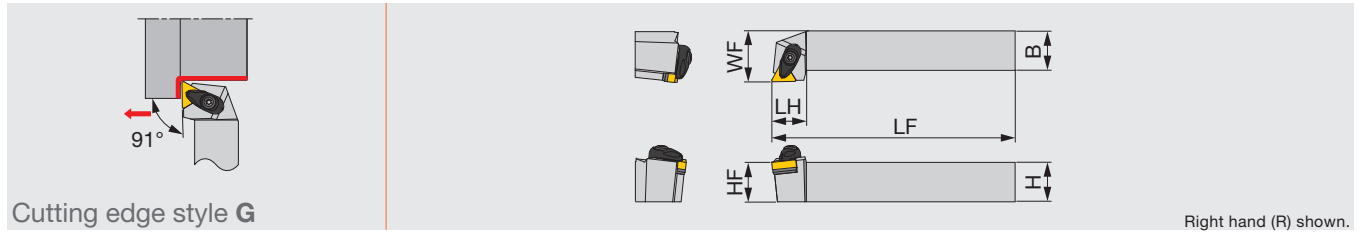
INSERT SELECTION

Application	Finishing	Medium cutting
	Grade	T9215
Chipbreaker Shape		
Cutting conditions	B006	

Application	Finishing	Medium cutting
	Grade	SS T6120
Chipbreaker Shape		
Cutting conditions	B008	

Reference pages: PTGNR/L-Eco: Inserts → **B084** -

Double-clamp toolholder with 91° approach angle, for negative 60° triangular inserts



Right hand (R) shown.

Designation	H	B	LF	LH	HF	WF	RE**	Insert	Torque*
ATG NR/L2020K16-A	20	20	125	22	20	25	0.8	TN**1604...	3
ATG NR/L2525M16-A	25	25	150	22	25	32	0.8	TN**1604...	3
ATG NR/L2525M22-A	25	25	150	26	25	32	0.8	TN**2204...	3

*Torque: Recommended clamping torque (N·m)

**RE: Standard corner radius

SPARE PARTS

Designation	Clamp	Clamp screw	Spring	Spring pin	Shim	Shim screw	Wrench
ATG NR/L**16-A	ACP3S	ACS-5W	BP-7	SP-2.5	AST322	CSTB-3.5	T-15F
ATG NR/L**22-A	ACP4S	ACS-5W	BP-7	SP-2.5	AST422	CSTB-3.5	T-15F

INSERT SELECTION

Application	Precision finishing	Finishing	Medium cutting	Medium to heavy cutting
	Grade	NS9530	GT9530	T9215
Chipbreaker Shape	TF	TSF	TM	TH
Cutting conditions	B006			

Application	Finishing	Medium cutting
	Grade	T6120
Chipbreaker Shape	SF	SM
Cutting conditions	B008	

Application	Finishing	Medium cutting	Medium to heavy cutting
	Grade	T515	T515
Chipbreaker Shape	All-round	All-round	All-round
Cutting conditions	B010		

Application	Precision finishing	Finishing	Medium cutting
	Grade	DX120	DX140
Chipbreaker Shape	T-DIA	with rake T-DIA	P
Cutting conditions	B012		

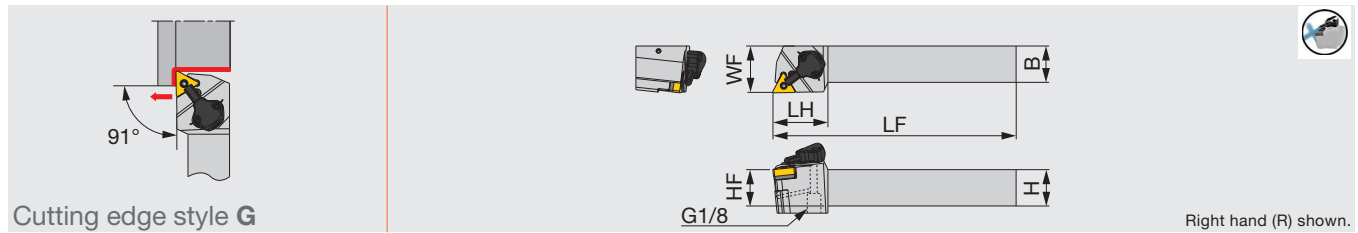
Application	Precision finishing	Finishing	Medium cutting
	Grade	BX470	AH8005
Chipbreaker Shape	T-CBN	HRF	HRM
Cutting conditions	B014		

Application	Precision finishing	Finishing
	Grade	BXM10
Chipbreaker Shape	T-CBN	T-CBN
Cutting conditions	B016	

Reference pages: ATG NR/L: Inserts → B084 -, CBN → B176 -, PCD → B192 -



Lever-lock toolholders with 91° approach angle, for negative 60° triangular inserts, with high pressure coolant capability



Designation	H	B	LF	LH	HF	WF	RE**	Insert	Torque*
PTGNR/L2020K1104-CHP	20	20	125	38	20	32	0.8	TN**1104...	2
PTGNR/L2020K16-CHP	20	20	125	38	20	32	0.8	TN**1604...	2
PTGNR/L2525M1104-CHP	25	25	150	38	25	32	0.8	TN**1104...	2
PTGNR/L2525M16-CHP	25	25	150	38	25	32	0.8	TN**1604...	2

*Torque: Recommended clamping torque (N-m)

**RE: Standard corner radius

SPARE PARTS

Designation	Shim	Clamping screw	Wrench 1	Spring pin	Lever
PTGNR/L**1104-CHP	-	LCS23A	P-2.5	LSP3	LCL23
PTGNR/L**16-CHP	LST317	LCS3	P-2.5	LSP3	LCL3

SPARE PARTS

Designation	Coolant unit	Mounting screw	Wrench 2	O-ring	Coolant screw	Wrench 3
PTGNR/L**1104-CHP	CU-CW-CHP	SRM3	T-8F	OR6.4X0.9N	SRM4X4TL360	P-2
PTGNR/L**16-CHP	CU-CW-CHP	SRM3	T-8F	OR6.4X0.9N	SRM4X4TL360	P-2

INSERT SELECTION

P

Application	Precision finishing	Finishing	Medium cutting	Medium to heavy cutting
Grade	NS9530	GT9530	T9215	T9215
Chipbreaker Shape	TF	TSF	TM	TH
Cutting conditions	B006			

M

Application	Finishing	Medium cutting
Grade	T6120	T6130
Chipbreaker Shape	SF	SM
Cutting conditions	B008	

K

Application	Finishing	Medium cutting	Medium to heavy cutting
Grade	T515	T515	T515
Chipbreaker Shape	All-round	All-round	All-round
Cutting conditions	B010		

N

Application	Precision finishing	Finishing	Medium cutting
Grade	DX120	DX140	TH10
Chipbreaker Shape	T-DIA	with rake T-DIA	P
Cutting conditions	B012		

S

Application	Precision finishing	Finishing	Medium cutting
Grade	BX470	AH8005	AH8005
Chipbreaker Shape	T-CBN	HRF	HRM
Cutting conditions	B014		

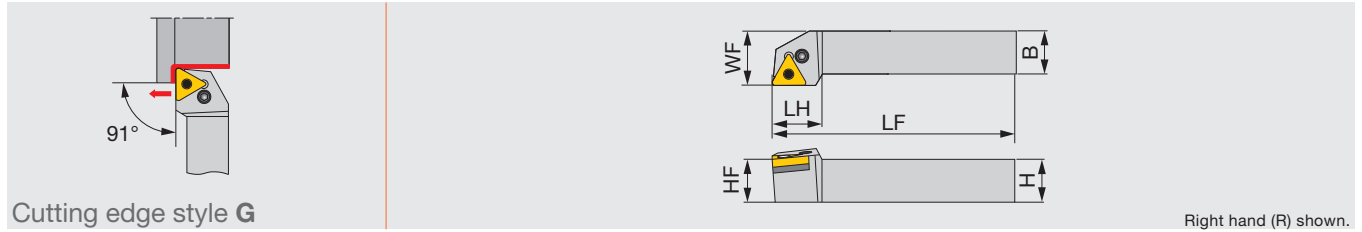
H

Application	Precision finishing	Finishing
Grade	BXM10	BXM20
Chipbreaker Shape	T-CBN	T-CBN
Cutting conditions	B016	

Reference pages: PTGNR/L-CHP: Inserts → **B084** -, CBN → **B176** -, PCD → **B192** -
Parts for coolant hose → **C134**

PTGNR/L

Lever-lock toolholder with 91° approach angle, for negative 60° triangular inserts



Designation	H	B	LF	LH	HF	WF	RE**	Insert
PTGNR/L1616	16	16	100	22	16	20	0.8	TN**1604...
PTGNR/L2020	20	20	125	22	20	25	0.8	TN**1604...
PTGNR/L2525M3	25	25	150	22	25	32	0.8	TN**1604...
PTGNR/L2525M4	25	25	150	28	25	32	0.8	TN**2204...
PTGNR3225P4	32	25	170	28	32	32	0.8	TN**2204...

**RE: Standard corner radius

SPARE PARTS

Designation					
PTGNR/L1616, 2020	LST317	LCS3	P-2.5	LSP3	LCL3
PTGNR/L2525M3	LST317	LCS3	P-2.5	LSP3	LCL3
PTGNR/L2525M4	LST42	LCS4	P-3	LSP4	LCL4
PTGNR3225P4	LST42	LCS4	P-3	LSP4	LCL4

INSERT SELECTION

Application	Precision finishing	Finishing	Medium cutting	Medium to heavy cutting
	Grade	NS9530	GT9530	T9215
Chipbreaker Shape	TF	TSF	TM	TH
Cutting conditions	B006			

Application	Finishing	Medium cutting
	Grade	T6120
Chipbreaker Shape	SF	SM
Cutting conditions	B008	

Application	Finishing	Medium cutting	Medium to heavy cutting
	Grade	T515	T515
Chipbreaker Shape	All-round	All-round	All-round
Cutting conditions	B010		

Application	Precision finishing	Finishing	Medium cutting
	Grade	DX120	DX140
Chipbreaker Shape	T-DIA	with rake T-DIA	P
Cutting conditions	B012		

Application	Precision finishing	Finishing	Medium cutting
	Grade	BX470	AH8005
Chipbreaker Shape	T-CBN	HRF	HRM
Cutting conditions	B014		

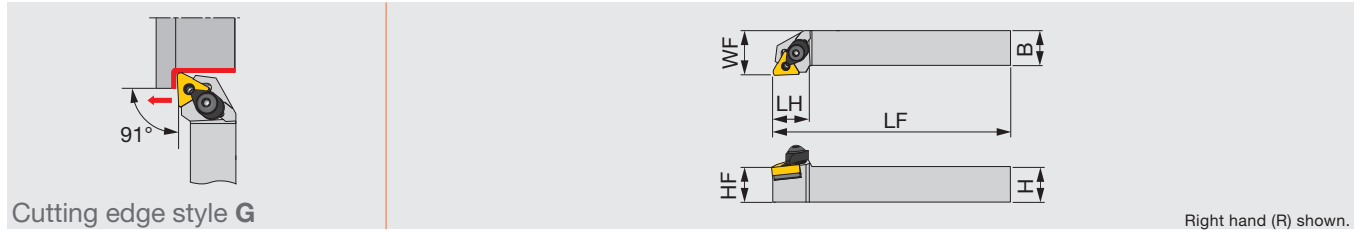
Application	Precision finishing	Finishing
	Grade	BXM10
Chipbreaker Shape	T-CBN	T-CBN
Cutting conditions	B016	

Reference pages: PTGNR/L: Inserts → B084 -, CBN → B176 -, PCD → B192 -



DTGNR/L

"One-Double" toolholder with 91° approach angle, for negative 60° triangular inserts



Cutting edge style **G**

Right hand (R) shown.

Designation	H	B	LF	LH	HF	WF	RE**	Insert
DTGNR/L2020K16	20	20	125	21	20	25	0.8	TN**1604...
DTGNR/L2525M16	25	25	150	21	25	32	0.8	TN**1604...
DTGNR/L2525M22	25	25	150	28	25	32	0.8	TN**2204...

Note: Except for 57-type chipbreaker inserts
 **RE: Standard corner radius

SPARE PARTS									
Designation	Clamp	Lever	Piston	Clamp screw	Shim	Spring	Spring pin	Wrench 1	Wrench 2
DTGNR/L**16	DCPM-33	LCL33	DPIS33	DLCS33	LST317	BP-9	LSP3	P-2.5	P-3
DTGNR/L**22	DCPM-43	DLCL43	DPIS43	DLCS43	LST42	BP-10	LSP4	P-3	P-4

INSERT SELECTION

Application	Precision finishing	Finishing	Medium cutting	Medium to heavy cutting
	Grade	NS9530	GT9530	T9215
Chipbreaker Shape				
Cutting conditions	B006			

Application	Finishing	Medium cutting
	Grade	T6120
Chipbreaker Shape		
Cutting conditions	B008	

Application	Finishing	Medium cutting	Medium to heavy cutting
	Grade	T515	T515
Chipbreaker Shape	All-round	All-round	All-round
Cutting conditions	B010		

Application	Precision finishing	Finishing	Medium cutting
	Grade	DX120	DX140
Chipbreaker Shape	T-DIA	with rake T-DIA	P
Cutting conditions	B012		

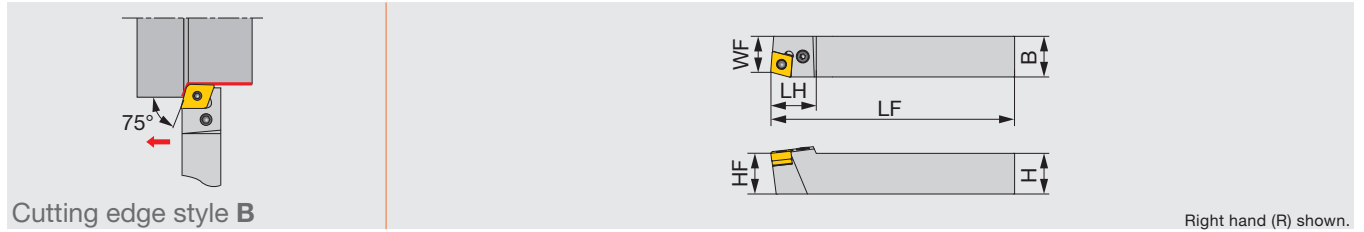
Application	Precision finishing	Finishing	Medium cutting
	Grade	BX470	AH8005
Chipbreaker Shape	T-CBN	HRF	HRM
Cutting conditions	B014		

Application	Precision finishing	Finishing
	Grade	BXM10
Chipbreaker Shape	T-CBN	T-CBN
Cutting conditions	B016	

Reference pages: DTGNR/L: Inserts → **B084 -**, CBN → **B176 -**, PCD → **B192 -**

PCBNR/L

Lever-lock toolholder with 75° approach angle, for negative 80° rhombic inserts



Designation	H	B	LF	LH	HF	WF	RE**	Insert
PCBNR/L2525	25	25	150	28	25	22	0.8	CN**1204...

Note: 100° corner is used.
**RE: Standard corner radius

SPARE PARTS					
Designation	Shim	Clamping screw	Wrench	Spring pin	Lever
PCBNR/L2525	LSC42	LCS4	P-3	LSP4	LCL4

INSERT SELECTION

P	Application	Precision finishing	Finishing	Medium cutting	Medium to heavy cutting
	Grade	NS9530	GT9530	T9215	T9215
Chipbreaker Shape	TF	TSF	TM	TH	
Cutting conditions	B006				

M	Application	Finishing	Medium cutting	Medium to heavy cutting
	Grade	T6120	T6130	T6130
Chipbreaker Shape	SF	SM	SH	
Cutting conditions	B008			

K	Application	Finishing	Medium cutting	Medium to heavy cutting
	Grade	T515	T515	T515
Chipbreaker Shape	All-round	All-round	All-round	
Cutting conditions	B010			

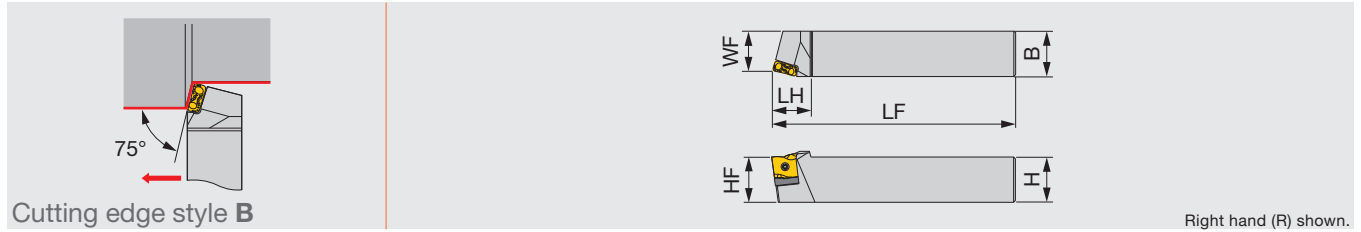
N	Application	Medium cutting
	Grade	TH10
Chipbreaker Shape	P	
Cutting conditions	B012	

S	Application	Finishing	Medium cutting
	Grade	AH8005	AH8005
Chipbreaker Shape	HRF	HRM	
Cutting conditions	B014		

Reference pages: PCBNR/L: Inserts → B054 -, CBN → B170 -, PCD → B192 -

Grade
A
Insert
B
Ext. Toolholder
C
Int. Toolholder
D
Threading
E
Grooving
F
Miniature tool
G
Milling cutter
H
Endmill
I
Drilling tool
J
Tooling System
K
User's Guide
L
Index
M

Screw-on toolholder for roughing with 75° approach angle, for negative tangential inserts



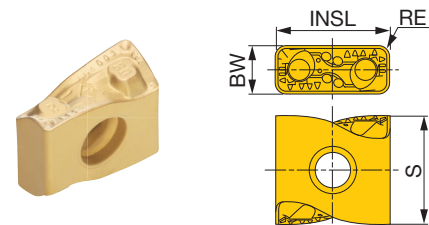
Designation	H	B	LF	LH	HF	WF	Insert
TLBNR/L4040R24	40	40	200	35	40	35	LNMX2410**R/L...

SPARE PARTS

Designation	Clamping screw	Shim	Spring pin	Wrench
TLBNR4040R24	CSTB-5L163-S	TSL24R	PSP-16	KEYV-T20
TLBNL4040R24	CSTB-5L163-S	TSL24L	PSP-16	KEYV-T20

INSERT

LNMX12/16/24



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

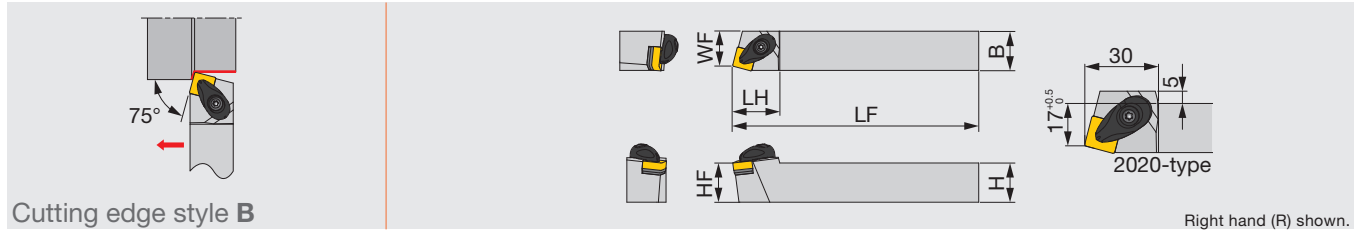
★ : First choice
☆ : Second choice

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

● : Line up

Reference pages: Standard cutting conditions → C136

Double-clamp toolholder with 75° approach angle, for negative square inserts



Right hand (R) shown.

Designation	H	B	LF	LH	HF	WF	RE**	Insert	Torque*
ASBNR/L2020K12-A	20	20	125	30	20	17	0.8	SN**1204...	3
ASBNR/L2525M12-A	25	25	150	30	25	22	0.8	SN**1204...	3
ASBNR/L2525M15-A	25	25	150	42.5	25	22	1.2	SN**1506...	6.4
ASBNR/L3232P15-A	32	32	170	42.5	32	27	1.2	SN**1506...	6.4
ASBNR/L3232P19-A	32	32	170	47.5	32	27	1.2	SN**1906...	6.4
ASBNR/L4040S19-A	40	40	250	47.5	40	35	1.2	SN**1906...	6.4

*Torque: Recommended clamping torque (N·m)

**RE: Standard corner radius

SPARE PARTS

Designation	Clamp	Clamp screw	Spring	Spring pin	Shim	Shim screw	Wrench 1	Wrench 2
ASBNR/L**12-A	ACP4S	ACS-5W	BP-7	SP-2.5	ASS422	CSTB-3.5	T-15F	-
ASBNR/L**15-A	ACP5S	ACS-6W	BP-8.8	SP-2.5	ASS533	CSTB-5	-	KEYV-T20
ASBNR/L**19-A	ACP6S	ACS-6W	BP-8.8	SP-2.5	ASS634	CSTB-5	-	KEYV-T20

INSERT SELECTION

Application	Precision finishing	Finishing	Medium cutting	Medium to heavy cutting
	Grade	Grade	Grade	Grade
Grade	NS9530	GT9530	T9215	T9215
Chipbreaker Shape	TF	TSF	TM	TH
Cutting conditions	B006			

Application	Finishing	Medium cutting	Medium to heavy cutting
	Grade	Grade	Grade
Grade	T6120	T6130	T6130
Chipbreaker Shape	SF	SM	SH
Cutting conditions	B008		

Application	Finishing	Medium cutting	Medium to heavy cutting
	Grade	Grade	Grade
Grade	T515	T515	T515
Chipbreaker Shape	All-round	All-round	All-round
Cutting conditions	B010		

Application	Finishing	Medium cutting
	Grade	Grade
Grade	DX140	TH10
Chipbreaker Shape	T-DIA	P
Cutting conditions	B012	

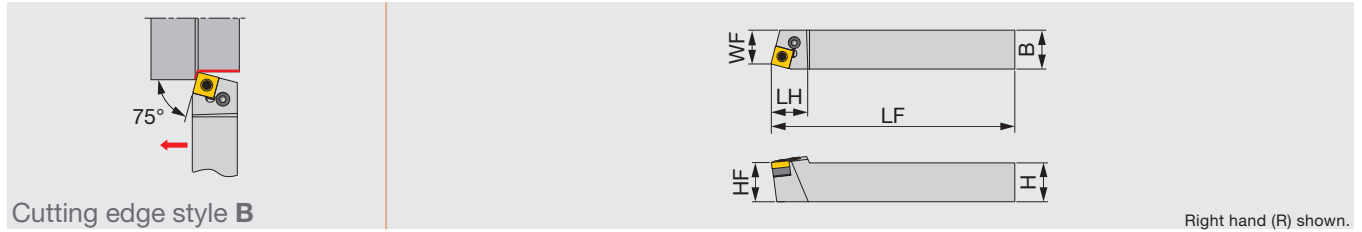
Application	Precision finishing	Finishing	Medium cutting
	Grade	Grade	Grade
Grade	BX480	AH8005	AH8005
Chipbreaker Shape	T-CBN	HRF	HRM
Cutting conditions	B014		

Reference pages: ASBNR/L: Inserts → B075 -, CBN → B175, PCD → B193



PSBNR/L

Lever-lock toolholder with 75° approach angle, for negative square inserts



Right hand (R) shown.

Designation	H	B	LF	LH	HF	WF	RE**	Insert
PSBNR/L1616	16	16	100	22	16	13	0.8	SN**0903...
PSBNR/L2020	20	20	125	28	20	17	0.8	SN**1204...
PSBNR/L2525	25	25	150	24	25	22	0.8	SN**1204...
PSBNR/L3232	32	32	170	40	32	27	1.2	SN**1906...

**RE: Standard corner radius

SPARE PARTS

Designation	Shim	Clamping screw	Wrench	Spring pin	Lever
PSBNR/L1616	LSS33	LCS3	P-2.5	LSP3L	LCL3
PSBNR/L2*2*	LSS42	LCS4	P-3	LSP4	LCL4
PSBNR/L3232	LSS63	LCS6	P-4	LSP6	LCL6

INSERT SELECTION

Application	Precision finishing	Finishing	Medium cutting	Medium to heavy cutting
	Grade	Grade	Grade	Grade
Grade	NS9530	GT9530	T9215	T9215
Chipbreaker Shape	TF	TSF	TM	TH
Image				
Cutting conditions	B006			

Application	Finishing	Medium cutting	Medium to heavy cutting
	Grade	Grade	Grade
Grade	T6120	T6130	T6130
Chipbreaker Shape	SF	SM	SH
Image			
Cutting conditions	B008		

Application	Finishing	Medium cutting	Medium to heavy cutting
	Grade	Grade	Grade
Grade	T515	T515	T515
Chipbreaker Shape	All-round	All-round	All-round
Image			
Cutting conditions	B010		

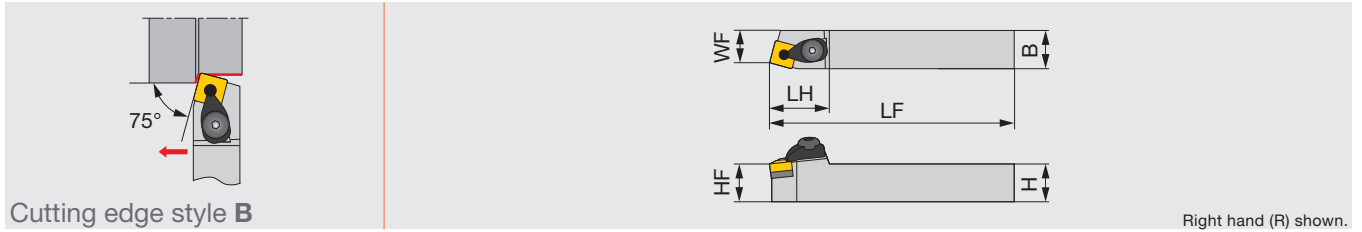
Application	Finishing	Medium cutting
	Grade	Grade
Grade	DX140	TH10
Chipbreaker Shape	T-DIA	P
Image		
Cutting conditions	B012	

Application	Precision finishing	Finishing	Medium cutting
	Grade	Grade	Grade
Grade	BX480	AH8005	AH8005
Chipbreaker Shape	T-CBN	HRF	HRM
Image			
Cutting conditions	B014		

Reference pages: PSBNR/L: Inserts → B075 -, CBN → B175, PCD → B193

DSBNR/L

"One-Double" toolholder with 75° approach angle, for negative square inserts



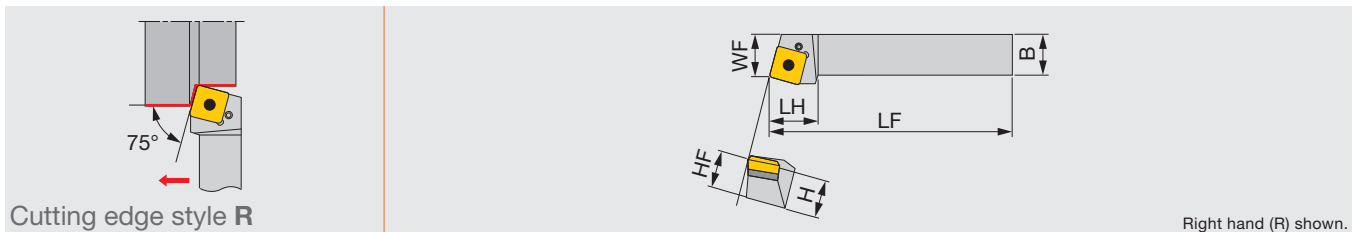
Designation	H	B	LF	LH	HF	WF	RE**	Insert
DSBNR/L2020K12	20	20	125	35	20	17	0.8	SN**1204...
DSBNR/L2525M12	25	25	150	35	25	22	0.8	SN**1204...

Note: Except for 57-type chipbreaker inserts
**RE: Standard corner radius

SPARE PARTS									
Designation	Clamp	Lever	Piston	Clamp screw	Shim	Spring	Spring pin	Wrench 1	Wrench 2
DSBNR/L...	DCPM-43	DLCL43	DPIS43	DLCS43	LSS42	BP-10	LSP4	P-3	P-4

HSRNR/L

Retract-pin toolholder with 75° approach angle, for negative square inserts



Designation	H	B	LF	LH	HF	WF	RE**	Insert
HSRNR/L4040R	40	40	200	50	40	43	1.6	SNMM3109...
HSRNR/L5050S	50	50	250	60	50	53	1.6	SNMM3109...

**RE: Standard corner radius

SPARE PARTS				
Designation	Pin	Clamping screw	Shim	Wrench
HSRNR/L...	SW99	LS-8	NAS-04	P-4

INSERT SELECTION

Application	Precision finishing	Finishing	Medium cutting	Medium to heavy cutting
	Grade	NS9530	GT9530	T9215
Chipbreaker Shape	TF	TSF	TM	TH
Cutting conditions	B006			

Application	Finishing	Medium cutting	Medium to heavy cutting
	Grade	T6120	T6130
Chipbreaker Shape	SF	SM	SH
Cutting conditions	B008		

Application	Finishing	Medium cutting	Medium to heavy cutting
	Grade	T515	T515
Chipbreaker Shape	All-round	All-round	All-round
Cutting conditions	B010		

Application	Finishing	Medium cutting
	Grade	DX140
Chipbreaker Shape	T-DIA	P
Cutting conditions	B012	

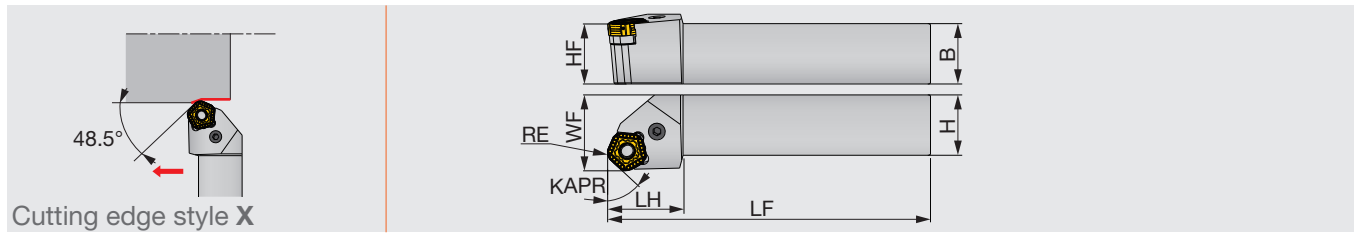
Application	Precision finishing	Finishing	Medium cutting
	Grade	BX480	AH8005
Chipbreaker Shape	T-CBN	HRF	HRM
Cutting conditions	B014		

Reference pages: DSBNR/L: Inserts → B075 -, CBN → B175, PCD → B193
HSRNR/L: Inserts → B081

TURN^{TEN}FEED

PPXOR/L-HD

Lever-lock toolholder with 48.5° approach angle, for negative 108° pentagonal inserts



Designation	H	B	LF	LH	HF	WF	KAPR	RE	Insert
PPXOR/L2525M11-HD	25	25	150	35	25	32	48.5	1.2	POMG110612
PPXOR/L3232P13-HD	32	32	170	40	32	40	48.5	1.2	POMG130612

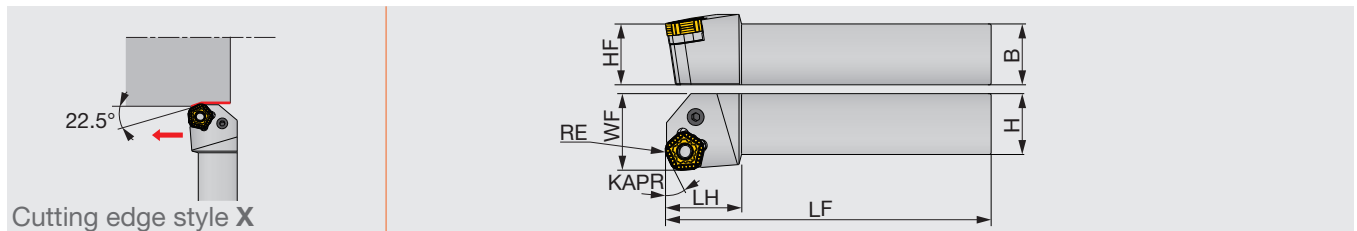
SPARE PARTS

Designation	Shim	Spring pin	Lever	Clamping screw	Wrench
PPXOR/L2525M11-HD	LSPO53	LSP5	LCL5	LCS5	P-3
PPXOR/L3232P13-HD	LSPO63	LSP6	LCL6	LCS6	P-4

TURN^{TEN}FEED

PPXOR/L-HF

Lever-lock toolholder with 22.5° approach angle, for negative 108° pentagonal inserts



Designation	H	B	LF	LH	HF	WF	KAPR	RE	Insert
PPXOR/L2525M11-HF	25	25	150	35	25	32	22.5	1.2	POMG110612
PPXOR/L3232P13-HF	32	32	170	40	32	40	22.5	1.2	POMG130612

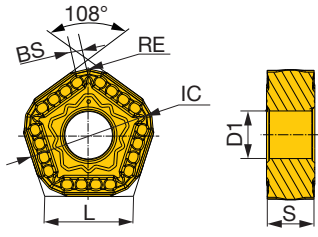
SPARE PARTS

Designation	Shim	Spring pin	Lever	Clamping screw	Wrench
PPXOR/L2525M11-HF	LSPO53	LSP5	LCL5	LCS5	P-3
PPXOR/L3232P13-HF	LSPO63	LSP6	LCL6	LCS6	P-4

Note : Since the corner angle of TurnTenFeed insert is 108°, the workpiece corner may require additional post-process to remove stock to achieve a right angle.

Reference pages: Standard cutting conditions → **C135**

INSERT
POMG-MNW



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

★ : First choice
☆ : Second choice

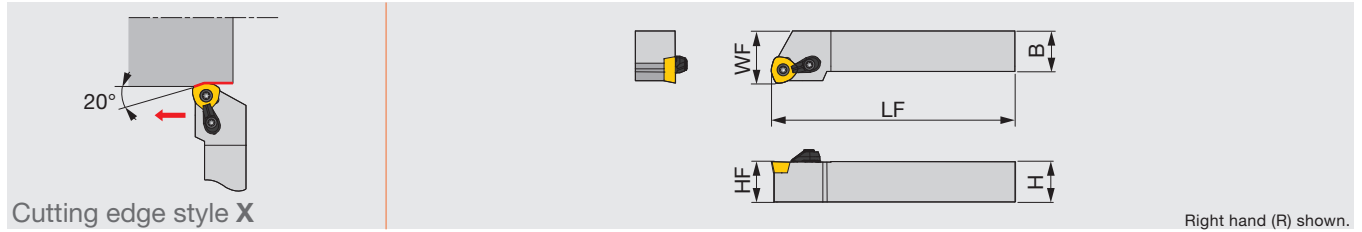
Designation	RE	Coated				IC	L	BS	S	D1
		T9225	T9215	T9125	AH8015					
POMG110612-MNW	1.2	●	●	●	●	15.875	11.53	1.5	6.35	1.2
POMG130612-MNW	1.2	●	●	●	●	19.05	13.84	2	6.35	1.2

● : Line up

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



Double-clamp toolholder for roughing with 20° approach angle, for positive 80° trigon inserts



Designation	H	B	LF	HF	WF	Insert
XWXPR/L2525M09	25	25	150	25	32	WPMT090725ZPR/L-ML
XWXPR/L3232P09	32	32	170	32	40	WPMT090725ZPR/L-ML
XWXPR/L4040S09	40	40	250	40	50	WPMT090725ZPR/L-ML

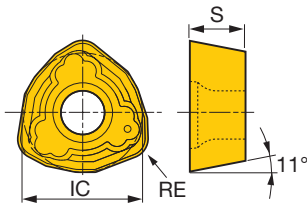
SPARE PARTS

Designation	Clamp set	Clamping screw	Wrench
XWXPR/L...	CSY-20	CSPB-5	IP-20T

Note: Each insert is either right- or left-handed. Please be sure not to use a wrong insert.

INSERT

WPMT09-ML



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

★ : First choice
☆ : Second choice

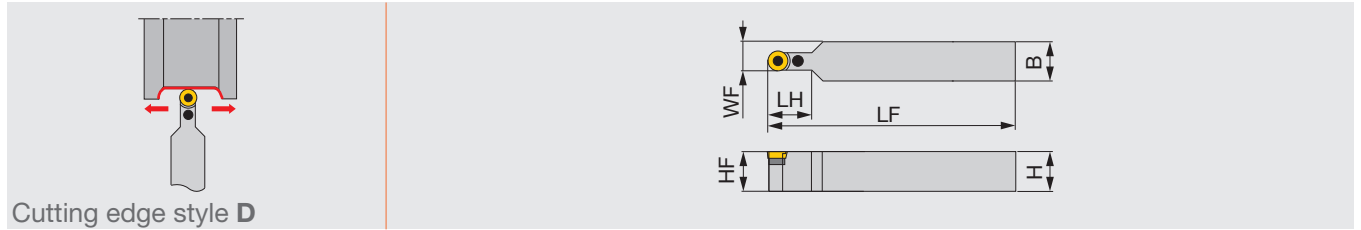
Designation	RE	Coated										IC	S		
		T9225	T9215	T9115	T9125	AH120									
WPMT090725ZPR-ML	2.5	●	●	●	●	●								1.5	7
WPMT090725ZPL-ML	2.5	●	●	●	●	●								1.5	7

● : Line up

Reference pages: Standard cutting conditions → **C135**

PRDCN

Lever-lock toolholder with 45° approach angle, for positive round inserts



Designation	H	B	LF	LH	HF	WF	Insert
PRDCN2020K10	20	20	125	22.5	20	15	RCMM1003...
PRDCN2525M12	25	25	150	24	25	18.5	RCM*1204...
PRDCN3225P12	32	25	170	24	32	18.5	RCM*1204...
PRDCN3225P16	32	25	170	28	32	20.5	RCM*1606...
PRDCN3232P20	32	32	170	32	32	26	RCM*2006...
PRDCN4040R25	40	40	200	42	40	32.5	RCM*2507...

SPARE PARTS

Designation	Shim	Clamping screw	Wrench	Spring pin	Lever
PRDCN2020K10	LSR32C	LCS2	P-2	LSP3	LCL3C
PRDCN**25*12	LSR42C	LCS3	P-2.5	LSP3	LCL4C
PRDCN3225P16	LSR53C	LCS5	P-3	LSP4	LCL5C
PRDCN3232P20	LSR63C	LCS5	P-3	LSP6C	LCL6C
PRDCN4040R25	LSR84C	LCS8C	P-4	LSP6	LCL8C

INSERT SELECTION

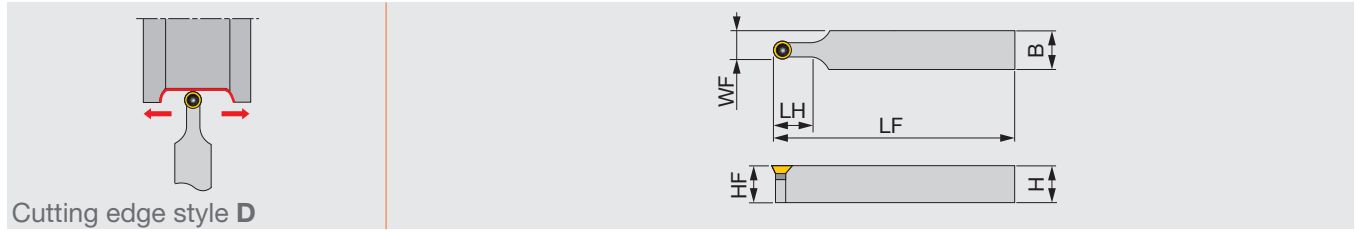
P	Application	Finishing to medium cutting	Heavy cutting	M	Application	Heavy cutting
	Grade	T9215	T9215		Grade	T9215
	Chipbreaker Shape				Chipbreaker Shape	
	Cutting conditions	B018			Cutting conditions	B020
K	Application	Heavy cutting		N	Application	Finishing to medium cutting
	Grade	T9215			Grade	KS05F
	Chipbreaker Shape				Chipbreaker Shape	
	Cutting conditions	B022			Cutting conditions	B024
S	Application	Finishing to medium cutting	Heavy cutting			
	Grade	AH8015	AH8015			
	Chipbreaker Shape					
	Cutting conditions	B026				

Reference pages: PRDCN: Inserts → **B129** -

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

SRDCN

Screw-on toolholder with 45° approach angle, for positive round inserts



Designation	H	B	LF	LH	HF	WF	Insert
SRDCN2020K06	20	20	125	12	20	13	RC*T0602...
SRDCN2020K08	20	20	125	16	20	14	RC*T0803...
SRDCN2020K10	20	20	125	20.3	25	15	RC*T1003...
SRDCN2525M06	25	25	150	12	25	15.5	RC*T0602...
SRDCN2525M08	25	25	150	16	25	16.5	RC*T0803...
SRDCN2525M10	25	25	150	20.3	25	17.5	RC*T1003...

SPARE PARTS

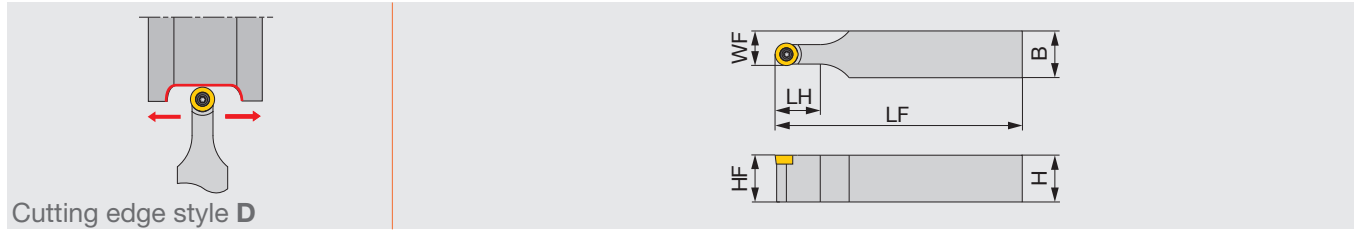
Designation	Clamping screw	Shim screw	Shim	Wrench 1	Wrench 2
SRDCN2020K06	CSTB-2.5	-	-	-	T-8F
SRDCN2020K08	CSTB-3	-	-	-	T-9F
SRDCN2020K10	CSTB-3.5L	DTS5-3.5	SSR32	P-3.5	T-15F
SRDCN2525M06	CSTB-2.5	-	-	-	T-8F
SRDCN2525M08	CSTB-3	-	-	-	T-9F
SRDCN2525M10	CSTB-3.5L	DTS5-3.5	SSR32	P-3.5	T-15F

INSERT SELECTION

P	Application	Finishing to medium cutting	Heavy cutting	M	Application	Heavy cutting
	Grade	T9215	T9215		Grade	T9215
	Chipbreaker Shape	RS	61		Chipbreaker Shape	61
	Cutting conditions	B018			Cutting conditions	B020
K	Application	Heavy cutting		N	Application	Finishing to medium cutting
	Grade	T9215			Grade	KS05F
	Chipbreaker Shape	61			Chipbreaker Shape	AL
	Cutting conditions	B022			Cutting conditions	B024
S	Application	Finishing to medium cutting	Heavy cutting			
	Grade	AH8015	AH8015			
	Chipbreaker Shape	RS	61			
	Cutting conditions	B026				

Reference pages: SRDCN: Inserts → [B129](#) -

Screw-on toolholder with 45° approach angle, for positive round inserts



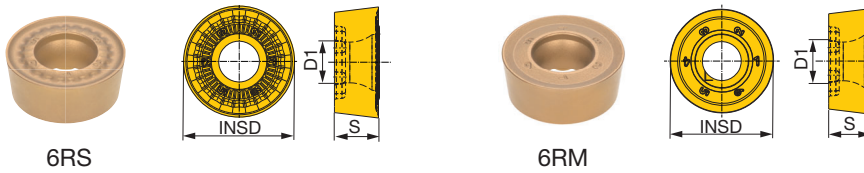
Designation	H	B	LF	LH	HF	WF	Insert	Torque*
SRDCN2525M12-6F	25	25	150	24.1	25	18.5	RCMT1204M0-6RS/-6RM	3

*Torque: Recommended clamping torque (N·m)

SPARE PARTS

Designation	Clamping screw	Lubricant	Wrench
SRDCN2525M12-6F	CSTB-4	M-1000	T-15F

INSERT RCMT



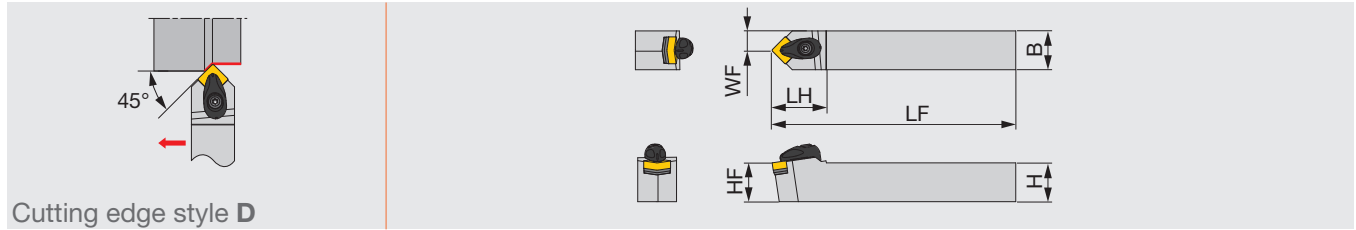
	P	M	K	N	S	H
Steel	★	★	★	★		★
Stainless						
Cast iron	☆	☆	☆	☆		☆
Non-ferrous						
Superalloys						
Hard materials						

★ : First choice
☆ : Second choice

Designation	Coated				Cermet	INSD	S	D1
	T9225	T9215	T9115	T9125	NS9530			
RCMT1204M0-6RS	●	●	●	●	●	12	4.76	5.16
RCMT1204M0-6RM	●	●	●	●	●	12	4.76	5.16

● : Line up

Double-clamp toolholder with 45° approach angle, for negative square inserts



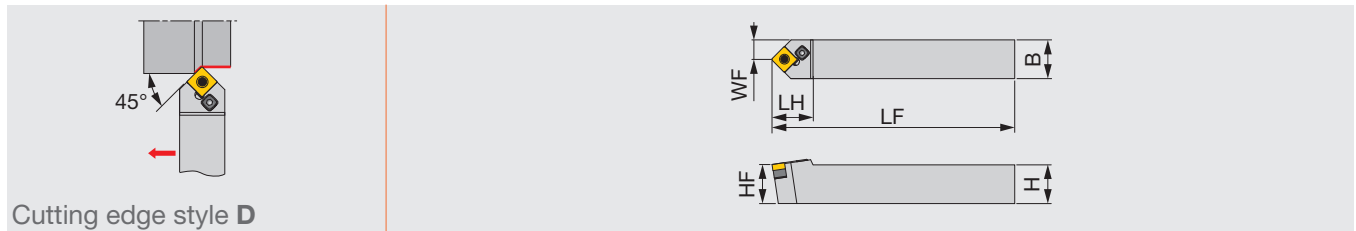
Designation	H	B	LF	LH	HF	WF	RE**	Insert	Torque*
ASDNN2020K12-A	20	20	125	35	20	10	0.8	SN**1204...	3
ASDNN2525M12-A	25	25	150	35	25	12.5	0.8	SN**1204...	3

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

SPARE PARTS							
Designation	Clamp	Clamp screw	Spring	Spring pin	Shim	Shim screw	Wrench
ASDNN**12-A	ACP4S	ACS-5W	BP-7	SP-2.5	ASS422	CSTB-3.5	T-15F

PSDNN

Lever-lock toolholder with 45° approach angle, for positive round inserts



Designation	H	B	LF	LH	HF	WF	RE**	Insert
PSDNN1616	16	16	100	22	16	8	0.8	SN**0903...
PSDNN2020	20	20	125	30	20	10.3	0.8	SN**1204...
PSDNN2525	25	25	150	30	25	12.8	0.8	SN**1204...

**RE: Standard corner radius

SPARE PARTS					
Designation	Shim	Clamping screw	Wrench	Spring pin	Lever
PSDNN1616	LSS33	LCS3	P-2.5	LSP3L	LCL3
PSDNN2020	LSS42	LCS4	P-3	LSP4	LCL4
PSDNN2525	LSS42	LCS4	P-3	LSP4	LCL4

INSERT SELECTION

Application	Precision finishing	Finishing	Medium cutting	Medium to heavy cutting
	Grade	Grade	Grade	Grade
	NS9530	GT9530	T9215	T9215
Chipbreaker Shape				
Cutting conditions	B006			

Application	Finishing	Medium cutting	Medium to heavy cutting
	Grade	Grade	Grade
	T6120	T6130	T6130
Chipbreaker Shape			
Cutting conditions	B008		

Application	Finishing	Medium cutting	Medium to heavy cutting
	Grade	Grade	Grade
	T515	T515	T515
Chipbreaker Shape			
Cutting conditions	B010		

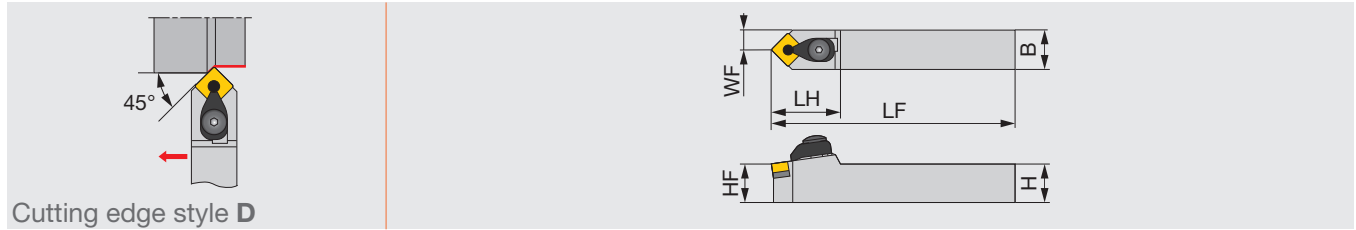
Application	Finishing	Medium cutting
	Grade	Grade
	DX140	TH10
Chipbreaker Shape		
Cutting conditions	B012	

Application	Precision finishing	Finishing	Medium cutting
	Grade	Grade	Grade
	BX480	AH8005	AH8005
Chipbreaker Shape			
Cutting conditions	B014		

Reference pages: ASDNN, PSDNN: Inserts → B075 -, CBN → B175, PCD → B193

DSDNN

One-Double toolholder with 45° approach angle, for negative square inserts



Designation	H	B	LF	LH	HF	WF	RE**	Insert
DSDNN2020K12	20	20	125	36	20	10	0.8	SN**1204...
DSDNN2525M12	25	25	150	36	25	12.5	0.8	SN**1204...

Note: Except for 57-type chipbreaker inserts
 **RE: Standard corner radius

SPARE PARTS									
Designation	Clamp	Lever	Piston	Clamp screw	Shim	Spring	Spring pin	Wrench 1	Wrench 2
DSDNN...	DCPM-43	DLCL43	DPIS43	DLCS43	LSS42	BP-10	LSP4	P-3	P-4

INSERT SELECTION

P	Application	Precision finishing	Finishing	Medium cutting	Medium to heavy cutting
	Grade	NS9530	GT9530	T9215	T9215
Chipbreaker Shape	TF	TSF	TM	TH	
Cutting conditions	B006				

M	Application	Finishing	Medium cutting	Medium to heavy cutting
	Grade	T6120	T6130	T6130
Chipbreaker Shape	SF	SM	SH	
Cutting conditions	B008			

K	Application	Finishing	Medium cutting	Medium to heavy cutting
	Grade	T515	T515	T515
Chipbreaker Shape	All-round	All-round	All-round	
Cutting conditions	B010			

N	Application	Finishing	Medium cutting
	Grade	DX140	TH10
Chipbreaker Shape	T-DIA	P	
Cutting conditions	B012		

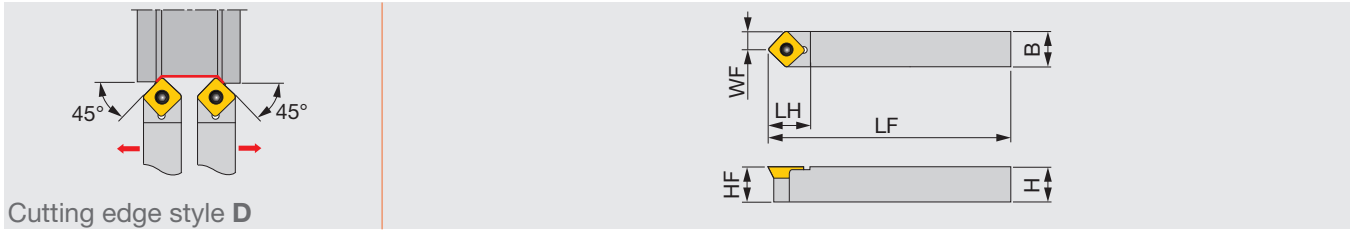
S	Application	Precision finishing	Finishing	Medium cutting
	Grade	BX480	AH8005	AH8005
Chipbreaker Shape	T-CBN	HRF	HRM	
Cutting conditions	B014			

Reference pages: DSDNN: Inserts → **B075 -**, CBN → **B175**, PCD → **B193**

Grade A
Insert B
Ext. Toolholder C
Int. Toolholder D
Threading E
Grooving F
Miniature tool G
Milling cutter H
Endmill I
Drilling tool J
Tooling System K
User's Guide L
Index M

SSDC/PN

Screw-on toolholder with 45° approach angle, for positive square inserts



Cutting edge style **D**





Designation	H	B	LF	LH	HF	WF	RE**	Insert
SSDCN1010K07	10	10	125	12	10	5	0.4	SC**0702...
SSDPN1010H	10	10	100	12	10	5	0.4	SP*P042...
SSDCN1212K09	12	12	125	15	12	6	0.8	SC**09T3...
SSDPN1212H	12	12	100	12	12	6	0.4	SP*P042...
SSDCN1616H09	16	16	100	15	16	8	0.8	SC**09T3...
SSDPN1616H	16	16	100	14	16	8	0.8	SP*M322...

**RE: Standard corner radius

SPARE PARTS

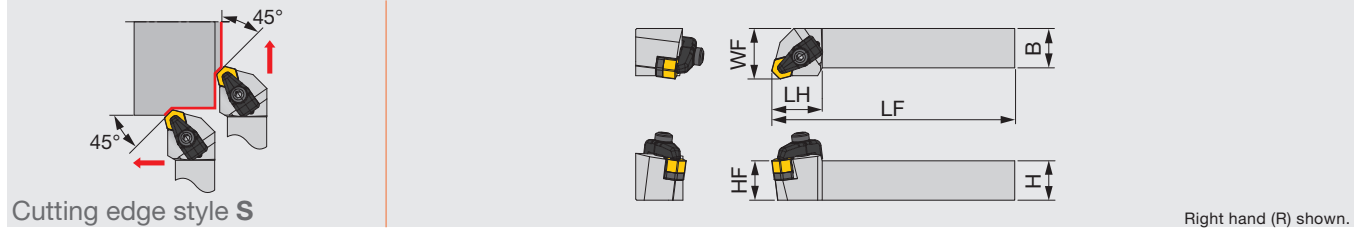
Designation	Clamping screw	Shim screw	Shim	Wrench 1	Wrench 2
SSDCN1010K07	CSTB-3	-	-	-	T-9F
SSDPN1010H	CSTA-NO3	-	-	-	T-9F
SSDCN1212K09	CSTB-4	-	-	-	T-15F
SSDPN1212H	CSTA-NO3	-	-	-	T-9F
SSDCN1616H09	CSTB-3.5L	DTS5-3.5	SSS32	P-3.5	T-15F
SSDPN1616H	CSTA-NO5	-	-	-	T-9F

INSERT SELECTION

P	Application	Finishing to medium cutting	Medium cutting	M	Application	Medium cutting
	Grade	T9215	T9215		Grade	T6130
	Chipbreaker Shape	PS 	PM 		Chipbreaker Shape	PM 
	Cutting conditions	B018			Cutting conditions	B020
K	Application	Finishing to medium cutting				
	Grade	T515				
	Chipbreaker Shape	CM 				
	Cutting conditions	B022				

Reference pages: SSDC/PN: Inserts → [B133](#), [J085](#)

Double-clamp toolholder with 45° approach angle, for negative 120° hexagonal ceramic inserts with dimple



Designation	H	B	LF	LH	HF	WF	RE**	Insert	Torque*
CHSNR2525M0507-RD	25	25	150	32	25	32	1.2	HN*D0507...	4

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

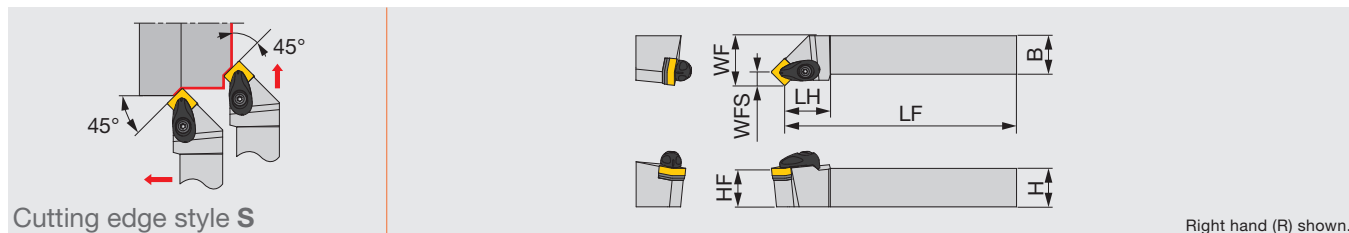
SPARE PARTS							
Designation	Clamp	Clamp screw	Shim	Shim screw	Spring	Wrench 1	Wrench 2
CHSNR2525M0507-RD	CCP4-A	CCS4-A	CH44-A	BH-40050-A	BP-5-A	P-3	P-4

INSERT SELECTION

K	Application	Finishing to medium cutting
	Grade	FX105
	Chipbreaker Shape	
	Cutting conditions	C136

Reference pages: CHSNR/L-RD: Inserts → **B108**
 Standard cutting conditions → **C136**





Right hand (R) shown.

Designation	H	B	LF	LH	HF	WF	WFS	RE**	Insert	Torque*
ASSNR/L2020K12-A	20	20	125	30	20	25	8.3	0.8	SN**1204...	3
ASSNR/L2525M12-A	25	25	150	30	25	32	8.3	0.8	SN**1204...	3
ASSNR/L2525M15-A	25	25	150	25	25	32	10.3	1.2	SN**1506...	6.4
ASSNR/L3232P15-A	32	32	170	25	32	40	10.3	1.2	SN**1506...	6.4
ASSNR/L3232P19-A	32	32	170	27.5	32	40	12.5	1.2	SN**1906...	6.4
ASSNR/L4040S19-A	40	40	250	27.5	40	50	12.5	1.2	SN**1906...	6.4

*Torque: Recommended clamping torque (N-m)

**RE: Standard corner radius

SPARE PARTS

Designation	Clamp	Clamp screw	Spring	Spring pin	Shim	Shim screw	Wrench 1	Wrench 2
ASSNR/L**12-A	ACP4S	ACS-5W	BP-7	SP-2.5	ASS422	CSTB-3.5	T-15F	-
ASSNR/L**15-A	ACP5S	ACS-6W	BP-8.8	SP-2.5	ASS533	CSTB-5	-	KEYV-T20
ASSNR/L**19-A	ACP6S	ACS-6W	BP-8.8	SP-2.5	ASS634	CSTB-5	-	KEYV-T20

INSERT SELECTION

Application	Precision finishing	Finishing	Medium cutting	Medium to heavy cutting
	Grade	Grade	Grade	Grade
	NS9530	GT9530	T9215	T9215
Chipbreaker Shape	TF	TSF	TM	TH
Cutting conditions	B006			

Application	Finishing	Medium cutting	Medium to heavy cutting
	Grade	Grade	Grade
	T6120	T6130	T6130
Chipbreaker Shape	SF	SM	SH
Cutting conditions	B008		

Application	Finishing	Medium cutting	Medium to heavy cutting
	Grade	Grade	Grade
	T515	T515	T515
Chipbreaker Shape	All-round	All-round	All-round
Cutting conditions	B010		

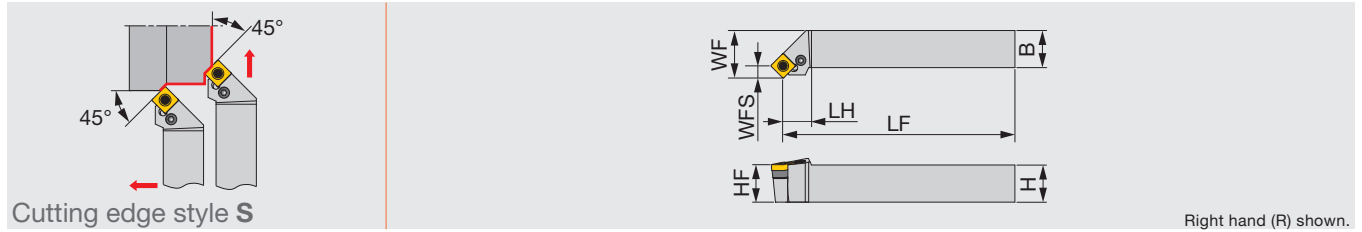
Application	Medium cutting
	Grade
	TH10
Chipbreaker Shape	P
Cutting conditions	B012

Application	Precision finishing	Finishing	Medium cutting
	Grade	Grade	Grade
	BX480	AH8005	AH8005
Chipbreaker Shape	T-CBN	HRF	HRM
Cutting conditions	B014		

Reference pages: ASSNR/L: Inserts → B075 -, CBN → B175, PCD → B193

PSSNR/L

Lever-lock toolholder with 45° approach angle, for positive round inserts



Designation	H	B	LF	LH	HF	WF	WFS	RE**	Insert
PSSNR/L1616	16	16	94	16	16	20	6.1	0.8	SN**0903...
PSSNR/L2020	20	20	116	21	20	25	8.3	0.8	SN**1204...
PSSNR/L2525	25	25	141	21	25	32	8.3	0.8	SN**1204...
PSSNR3225	32	25	161	21	32	32	8.3	0.8	SN**1204...
PSSNR/L3232	32	32	157.5	27.5	32	40	12.5	1.2	SN**1906...

**RE: Standard corner radius

SPARE PARTS

Designation	Shim	Clamping screw	Wrench	Spring pin	Lever
PSSNR/L1616	LSS33	LCS3	P-2.5	LSP3L	LCL3
PSSNR/L2020	LSS42	LCS4	P-3	LSP4	LCL4
PSSNR/L**25	LSS42	LCS4	P-3	LSP4	LCL4
PSSNR/L3232	LSS63	LCS6	P-4	LSP6	LCL6

INSERT SELECTION

Application	Precision finishing	Finishing	Medium cutting	Medium to heavy cutting
	Grade	Grade	Grade	Grade
	NS9530	GT9530	T9215	T9215
Chipbreaker Shape	TF	TSF	TM	TH
Image				
Cutting conditions	B006			

Application	Finishing	Medium cutting	Medium to heavy cutting
	Grade	Grade	Grade
	T6120	T6130	T6130
Chipbreaker Shape	SF	SM	SH
Image			
Cutting conditions	B008		

Application	Finishing	Medium cutting	Medium to heavy cutting
	Grade	Grade	Grade
	T515	T515	T515
Chipbreaker Shape	All-round	All-round	All-round
Image			
Cutting conditions	B010		

Application	Medium cutting
	Grade
	TH10
Chipbreaker Shape	P
Image	
Cutting conditions	B012

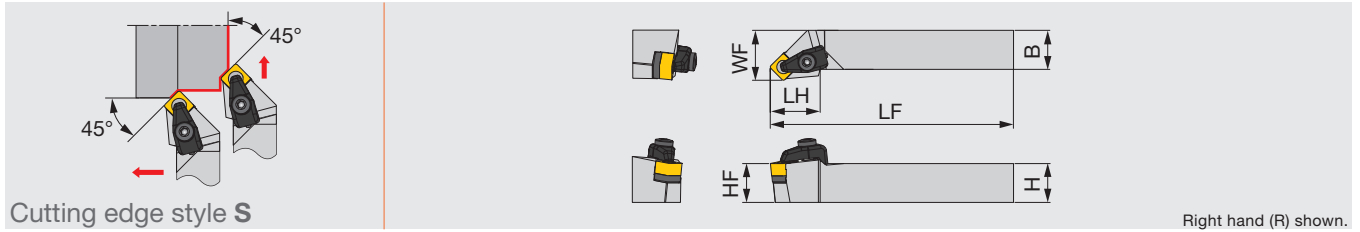
Application	Precision finishing	Finishing	Medium cutting
	Grade	Grade	Grade
	BX480	AH8005	AH8005
Chipbreaker Shape	T-CBN	HRF	HRM
Image			
Cutting conditions	B014		

Reference pages: PSSNR/L: Inserts → B075 -, CBN → B175, PCD → B193

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



Double-clamp toolholder with 45° approach angle, for negative square ceramic inserts with dimple



Designation	H	B	LF	LH	HF	WF	RE**	Insert	Torque*
CSSNR/L2525M1207-RD	25	25	150	32	25	32	1.2	SN*D1207...	4

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

SPARE PARTS

Designation	Clamp	Clamp screw	Shim	Shim screw	Spring	Wrench 1	Wrench 2
CSSNR/L2525M1207-RD	CCP4-A	CCS4-A	CS44-A	BH5-10-A	BP-5-A	P-3	P-4

INSERT SELECTION

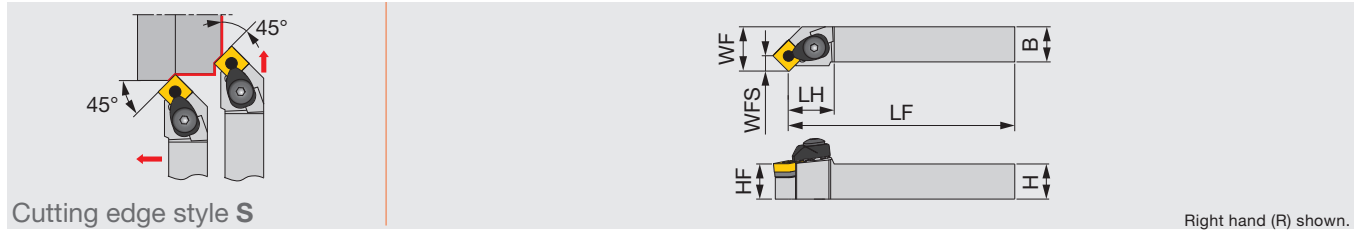
K	Application	Finishing to medium cutting
	Grade	FX105
	Chipbreaker Shape	
	Cutting conditions	C136

Reference pages: CSSNR/L-RD: Insert → **B083**

Standard cutting conditions → **C136**

DSSNR/L

"One-Double" toolholder with 45° approach angle, for negative square inserts



Designation	H	B	LF	LH	HF	WF	WFS	RE**	Insert
DSSNR/L2020K12	20	20	125	34.3	20	25	8.3	0.8	SN**1204...
DSSNR/L2525M12	25	25	150	34.3	25	32	8.3	0.8	SN**1204...

Note: Except for 57-type chipbreaker inserts
**RE : Standard corner radius

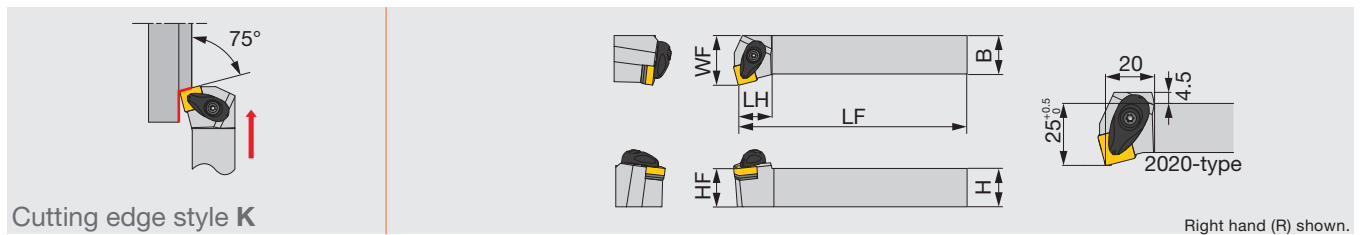
SPARE PARTS

Designation	Clamp	Lever	Piston	Clamp screw	Shim	Spring	Spring pin	Wrench 1	Wrench 2
DSSNR/L...	DCPM-43	DLCL43	DPIS43	DLCS43	LSS42	BP-10	LSP4	P-3	P-4

TURNING

ASKNR/L

Double-clamp toolholder with 75° approach angle, for negative square inserts



Designation	H	B	LF	LH	HF	WF	RE**	Insert	Torque*
ASKNR/L2020K12-A	20	20	125	20	20	25	0.8	SN**1204...	3
ASKNR/L2525M12-A	25	25	150	22	25	32	0.8	SN**1204...	3

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

SPARE PARTS

Designation	Clamp	Clamp screw	Spring	Spring pin	Shim	Shim screw	Wrench
ASKNR/L**12-A	ACP4S	ACS-5W	BP-7	SP-2.5	ASS422	CSTB-3.5	T-15F

INSERT SELECTION

Application	Precision finishing	Finishing	Medium cutting	Medium to heavy cutting
	Grade	Grade	Grade	Grade
	NS9530	GT9530	T9215	T9215
Chipbreaker Shape	TF	TSF	TM	TH
Cutting conditions	B006			

Application	Finishing	Medium cutting	Medium to heavy cutting
	Grade	Grade	Grade
	T6120	T6130	T6130
Chipbreaker Shape	SF	SM	SH
Cutting conditions	B008		

Application	Finishing	Medium cutting	Medium to heavy cutting
	Grade	Grade	Grade
	T515	T515	T515
Chipbreaker Shape	All-round	All-round	All-round
Cutting conditions	B010		

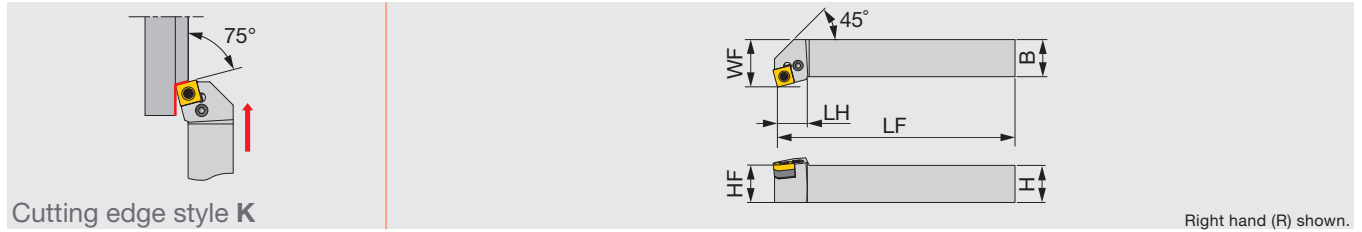
Application	Finishing	Medium cutting
	Grade	Grade
	DX140	TH10
Chipbreaker Shape	T-DIA	P
Cutting conditions	B012	

Application	Precision finishing	Finishing	Medium cutting
	Grade	Grade	Grade
	BX480	AH8005	AH8005
Chipbreaker Shape	T-CBN	HRF	HRM
Cutting conditions	B014		

Reference pages: DSSNR/L, ASKNR/L: Inserts → B075 -, CBN → B175, PCD → B193

PSKNR/L

Lever-lock toolholder with 75° approach angle, for negative square inserts



Cutting edge style K

Right hand (R) shown.

Designation	H	B	LF	LH	HF	WF	RE**	Insert
PSKNR/L1616	16	16	100	17	16	25	0.8	SN**0903...
PSKNR/L2020	20	20	125	22	20	25	0.8	SN**1204...
PSKNR/L2525	25	25	150	22	25	32	0.8	SN**1204...
PSKNR3232	32	32	170	40	32	40	1.2	SN**1906...

**RE : Standard corner radius

SPARE PARTS

Designation	Shim	Clamping screw	Wrench	Spring pin	Lever
PSKNR/L1616	LSS33	LCS3	P-2.5	LSP3L	LCL3
PSKNR/L2*2*	LSS42	LCS4	P-3	LSP4	LCL4
PSKNR3232	LSS63	LCS6	P-4	LSP6	LCL6

INSERT SELECTION

Application	Precision finishing	Finishing	Medium cutting	Medium to heavy cutting
	Grade	Grade	Grade	Grade
Grade	NS9530	GT9530	T9215	T9215
Chipbreaker Shape	TF	TSF	TM	TH
Cutting conditions	B006			

Application	Finishing	Medium cutting	Medium to heavy cutting
	Grade	Grade	Grade
Grade	T6120	T6130	T6130
Chipbreaker Shape	SF	SM	SH
Cutting conditions	B008		

Application	Finishing	Medium cutting	Medium to heavy cutting
	Grade	Grade	Grade
Grade	T515	T515	T515
Chipbreaker Shape	All-round	All-round	All-round
Cutting conditions	B010		

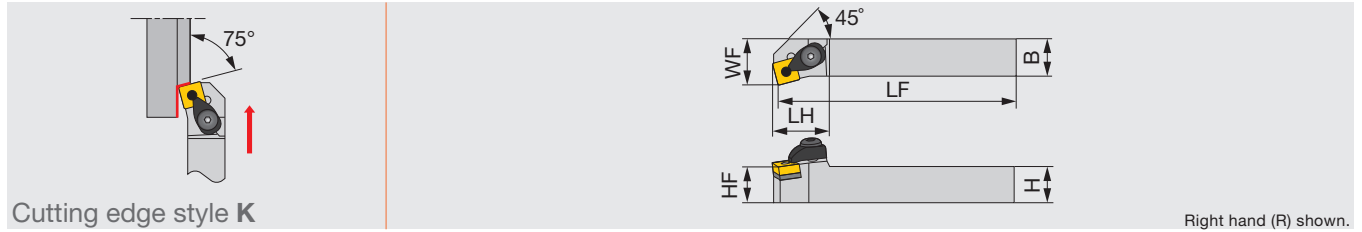
Application	Finishing	Medium cutting
	Grade	Grade
Grade	DX140	TH10
Chipbreaker Shape	T-DIA	P
Cutting conditions	B012	

Application	Precision finishing	Finishing	Medium cutting
	Grade	Grade	Grade
Grade	BX480	AH8005	AH8005
Chipbreaker Shape	T-CBN	HRF	HRM
Cutting conditions	B014		

Reference pages: PSKNR/L: Inserts → B075 -, CBN → B175, PCD → B193

DSKNR/L

"One-Double" toolholder with 75° approach angle, for negative square inserts



Designation	H	B	LF	LH	HF	WF	RE**	Insert
DSKNR/L2020K12	20	20	125	31	20	25	0.8	SN**1204...
DSKNR/L2525M12	25	25	150	31	25	32	0.8	SN**1204...

Note: Except for 57-type chipbreaker inserts
 **RE : Standard corner radius

SPARE PARTS									
Designation	Clamp	Lever	Piston	Clamp screw	Shim	Spring	Spring pin	Wrench 1	Wrench 2
DSKNR/L...	DCPM-43	DLCL43	DPIS43	DLCS43	LSS42	BP-10	LSP4	P-3	P-4

INSERT SELECTION

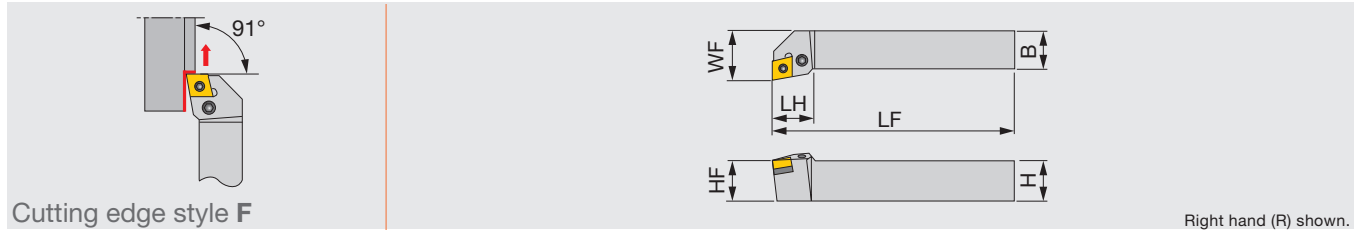
P	Application	Precision finishing	Finishing	Medium cutting	Medium to heavy cutting
	Grade	NS9530	GT9530	T9215	T9215
	Chipbreaker Shape				
	Cutting conditions	B006			
M	Application	Finishing	Medium cutting	Medium to heavy cutting	
	Grade	T6120	T6130	T6130	
	Chipbreaker Shape				
	Cutting conditions	B008			
K	Application	Finishing	Medium cutting	Medium to heavy cutting	
	Grade	T515	T515	T515	
	Chipbreaker Shape				
	Cutting conditions	B010			
N	Application	Finishing	Medium cutting		
	Grade	DX140	TH10		
	Chipbreaker Shape				
	Cutting conditions	B012			
S	Application	Precision finishing	Finishing	Medium cutting	
	Grade	BX480	AH8005	AH8005	
	Chipbreaker Shape				
	Cutting conditions	B014			

Reference pages: DSKNR/L: Inserts → **B075 -**, CBN → **B175**, PCD → **B193**

Grade **A**
 Insert **B**
 Ext. Toolholder **C**
 Int. Toolholder **D**
 Threading **E**
 Grooving **F**
 Miniature tool **G**
 Milling cutter **H**
 Endmill **I**
 Drilling tool **J**
 Tooling System **K**
 User's Guide **L**
 Index **M**

PCFNR/L

Lever-lock type toolholder for facing with 91° approach angle, for negative 80° rhombic inserts



Right hand (R) shown.

Designation	H	B	LF	LH	HF	WF	RE**	Insert
PCFNR/L2020	20	20	125	28	20	25	0.8	CN**1204...
PCFNR/L2525	25	25	150	28	25	32	0.8	CN**1204...

**RE : Standard corner radius

SPARE PARTS

Designation	Shim	Clamping screw	Wrench	Spring pin	Lever
PCFNR/L...	LSC42 D30	LCS4	P-3	LSP4	LCL4

INSERT SELECTION

Application	Precision finishing	Finishing	Medium cutting	Medium to heavy cutting
	Grade	NS9530	GT9530	T9215
Chipbreaker Shape	TF	TSF	TM	TH
Cutting conditions	B006			

Application	Finishing	Medium cutting	Medium to heavy cutting
	Grade	T6120	T6130
Chipbreaker Shape	SF	SM	SH
Cutting conditions	B008		

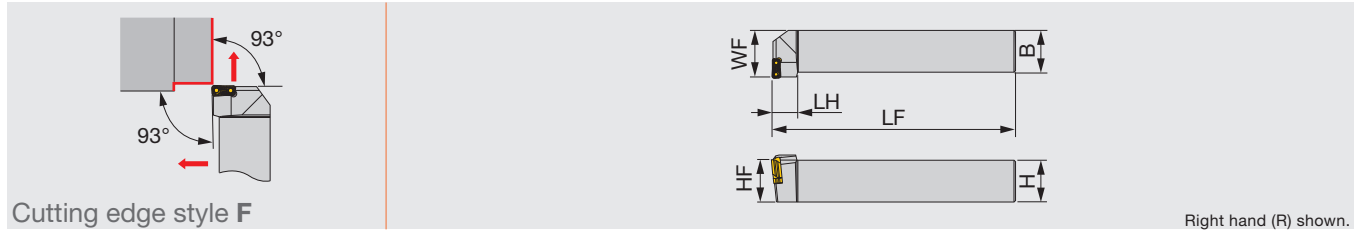
Application	Finishing	Medium cutting	Medium to heavy cutting
	Grade	T515	T515
Chipbreaker Shape	All-round	All-round	All-round
Cutting conditions	B010		

Application	Precision finishing	Finishing	Medium cutting
	Grade	DX120	DX140
Chipbreaker Shape	T-DIA	with rake T-DIA	P
Cutting conditions	B012		

Application	Precision finishing	Finishing	Medium cutting
	Grade	BX470	AH8005
Chipbreaker Shape	T-CBN	HRF	HRM
Cutting conditions	B014		

Application	Precision finishing	Finishing
	Grade	BXM10
Chipbreaker Shape	T-CBN	T-CBN
Cutting conditions	B016	

Reference pages: PCFNR/L: Inserts → B054 -, CBN → B170 -, PCD → B192 -



Right hand (R) shown.

Designation	H	B	LF	LH	HF	WF	Insert
TLFNR/L2525M16	25	25	150	20	25	30	LNMX1606**L/R...
TLFNR/L3232P16	32	32	170	20	32	37	LNMX1606**L/R...

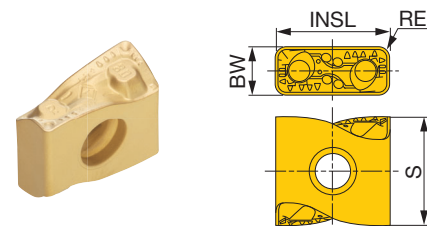
Note: Use right-hand toolholders (R) with left-hand inserts (L); and left-hand toolholders (L) with right-hand inserts (R).

SPARE PARTS

Designation	Clamping screw	Shim	Spring pin	Wrench
TLFNR2525M16	CSTB-4L115-S	TSL16L	PSP-16	KEYV-T15
TLFNL2525M16	CSTB-4L115-S	TSL16R	PSP-16	KEYV-T15
TLFNR3232P16	CSTB-4L115-S	TSL16L	PSP-16	KEYV-T15
TLFNL3232P16	CSTB-4L115-S	TSL16R	PSP-16	KEYV-T15

INSERT

LNMX12/16/24



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

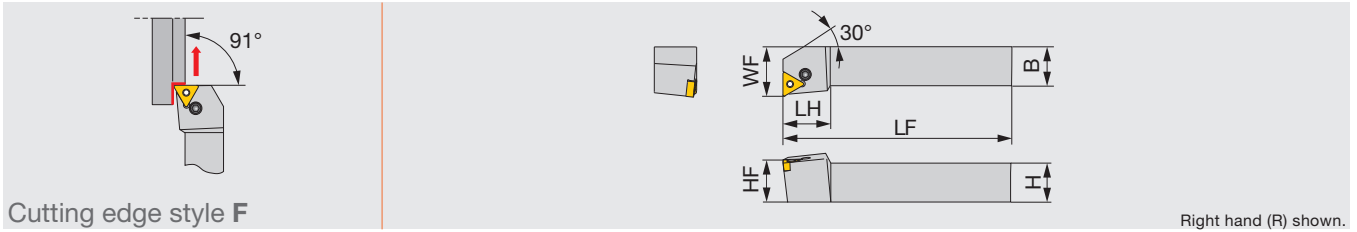
★ : First choice
☆ : Second choice

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

Reference pages: TLFNR/L: Standard cutting conditions → C136

● : Line up

Lever-lock toolholder with 91° approach angle, for negative triangular inserts



Cutting edge style F

Right hand (R) shown.

Designation	H	B	LF	LH	HF	WF	RE**	Insert	Torque*
PTFNR/L2020K1104	20	20	125	16	20	25	0.8	TN**1104...	2
PTFNR/L2525M1104	25	25	150	22	25	32	0.8	TN**1104...	2

*Torque: Recommended clamping torque (N·m)

**RE : Standard corner radius

SPARE PARTS

Designation	Clamping screw	Wrench	Lever
PTFNR/L**1104	LCS23A	P-2.5	LCL23

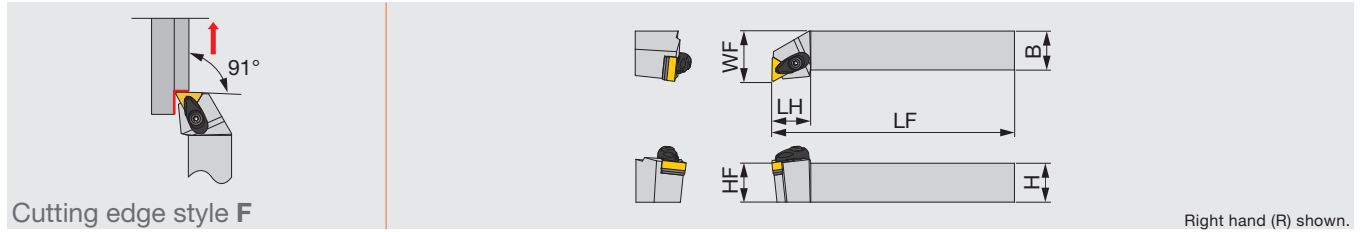
- L
- J
- N
- V
- P
- A
- G
- B-R
- X
- D
- S
- K
- F**
- Q-H
- Special

INSERT SELECTION

Application	Finishing	Medium cutting
	Grade	T9215
Chipbreaker Shape	TSF	TM
Cutting conditions	B006	

Application	Finishing	Medium cutting
	Grade	T6120
Chipbreaker Shape	SS	SM
Cutting conditions	B008	

Reference pages: PTFNR/L-Eco: Inserts → **B084** -



Designation	H	B	LF	LH	HF	WF	RE**	Insert	Torque*
ATFNR/L2020K16-A	20	20	125	25	20	25	0.8	TN**1604...	3
ATFNR/L2525M16-A	25	25	150	25	25	32	0.8	TN**1604...	3
ATFNR/L2525M22-A	25	25	150	29	25	32	0.8	TN**2204...	3

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

SPARE PARTS

Designation	Clamp	Clamp screw	Spring	Spring pin	Shim	Shim screw	Wrench
ATFNR/L**16-A	ACP3S	ACS-5W	BP-7	SP-2.5	AST322	CSTB-3.5	T-15F
ATFNR/L**22-A	ACP4S	ACS-5W	BP-7	SP-2.5	AST422	CSTB-3.5	T-15F

INSERT SELECTION

Application	Precision finishing	Finishing	Medium cutting	Medium to heavy cutting
	Grade	NS9530	GT9530	T9215
Chipbreaker Shape	TF	TSF	TM	TH
Cutting conditions	B006			

Application	Finishing	Medium cutting
	Grade	T6120
Chipbreaker Shape	SF	SM
Cutting conditions	B008	

Application	Finishing	Medium cutting	Medium to heavy cutting
	Grade	T515	T515
Chipbreaker Shape	All-round	All-round	All-round
Cutting conditions	B010		

Application	Precision finishing	Finishing	Medium cutting
	Grade	DX120	DX140
Chipbreaker Shape	T-DIA	with rake T-DIA	P
Cutting conditions	B012		

Application	Precision finishing	Finishing	Medium cutting
	Grade	BX470	AH8005
Chipbreaker Shape	T-CBN	HRF	HRM
Cutting conditions	B014		

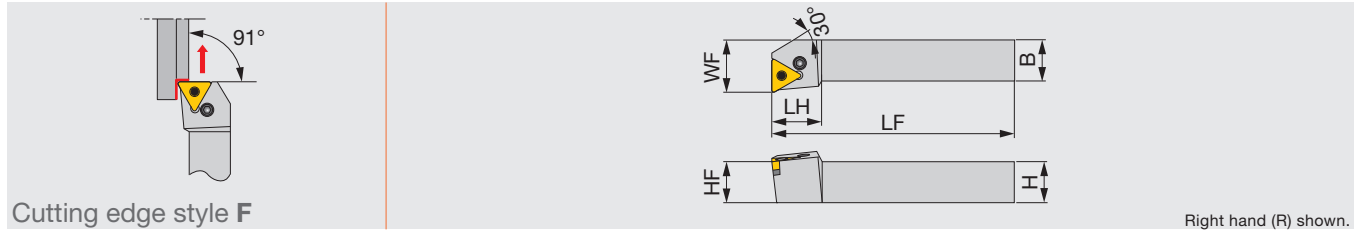
Application	Precision finishing	Finishing
	Grade	BXM10
Chipbreaker Shape	T-CBN	T-CBN
Cutting conditions	B016	

Reference pages: ATFNR/L: Inserts → B084 -, CBN → B176 -, PCD → B192 -



PTFNR/L

Lever-lock toolholder with 91° approach angle, for negative 60° triangular inserts



Cutting edge style F

Right hand (R) shown.

Designation	H	B	LF	LH	HF	WF	RE**	Insert
PTFNR/L1616	16	16	100	22	16	20	0.8	TN**1604...
PTFNR/L2020	20	20	125	22	20	25	0.8	TN**1604...
PTFNR/L2525M3	25	25	150	22	25	32	0.8	TN**1604...
PTFNR/L2525M4	25	25	150	28	25	32	0.8	TN**2204...
PTFNR/L3225P4	32	25	170	28	32	32	0.8	TN**2204...

**RE : Standard corner radius

SPARE PARTS

Designation	Shim	Clamping screw	Wrench	Spring pin	Lever
PTFNR/L1616, 2020	LST317	LCS3	P-2.5	LSP3	LCL3
PTFNR/L2525M3	LST317	LCS3	P-2.5	LSP3	LCL3
PTFNR/L**25*4	LST42	LCS4	P-3	LSP4	LCL4

INSERT SELECTION

Application	Precision finishing	Finishing	Medium cutting	Medium to heavy cutting
	Grade	NS9530	GT9530	T9215
Chipbreaker Shape	TF	TSF	TM	TH
Cutting conditions	B006			

Application	Finishing	Medium cutting
	Grade	T6120
Chipbreaker Shape	SF	SM
Cutting conditions	B008	

Application	Finishing	Medium cutting	Medium to heavy cutting
	Grade	T515	T515
Chipbreaker Shape	All-round	All-round	All-round
Cutting conditions	B010		

Application	Precision finishing	Finishing	Medium cutting
	Grade	DX120	DX140
Chipbreaker Shape	T-DIA	with rake T-DIA	P
Cutting conditions	B012		

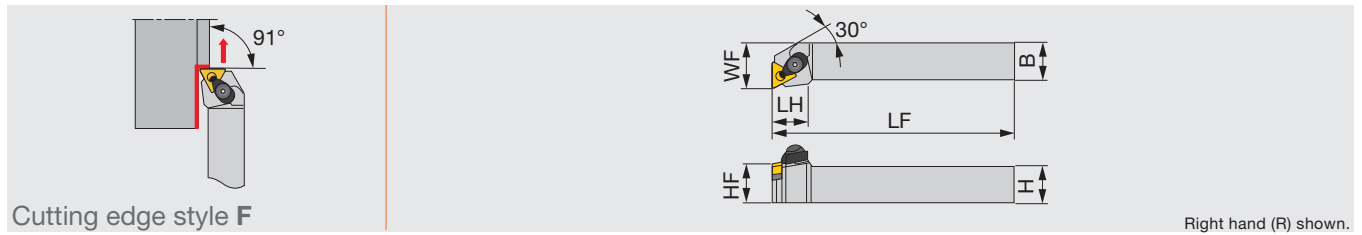
Application	Precision finishing	Finishing	Medium cutting
	Grade	BX470	AH8005
Chipbreaker Shape	T-CBN	HRF	HRM
Cutting conditions	B014		

Application	Precision finishing	Finishing
	Grade	BXM10
Chipbreaker Shape	T-CBN	T-CBN
Cutting conditions	B016	

Reference pages: PTFNR/L: Inserts → B084 -, CBN → B176 -, PCD → B192 -

DTFNR/L

"One-Double" toolholder with 91° approach angle, for negative 60° triangular inserts



Cutting edge style F

Right hand (R) shown.

Designation	H	B	LF	LH	HF	WF	RE**	Insert
DTFNR/L2020K16	20	20	125	23	20	25	0.8	TN**1604...
DTFNR/L2525M16	25	25	150	23	25	32	0.8	TN**1604...
DTFNR/L2525M22	25	25	150	31	25	32	0.8	TN**2204...

Note: Except for 57-type chipbreaker inserts
 **RE : Standard corner radius

SPARE PARTS									
Designation	Clamp	Lever	Piston	Clamp screw	Shim	Spring	Spring pin	Wrench 1	Wrench 2
DTFNR/L**16	DCPM-33	LCL33	DPIS33	DLCS33	LST317	BP-9	LSP3	P-2.5	P-3
DTFNR/L**22	DCPM-43	DLCL43	DPIS43	DLCS43	LST42	BP-10	LSP4	P-3	P-4

INSERT SELECTION

P	Application	Precision finishing	Finishing	Medium cutting	Medium to heavy cutting
	Grade	NS9530	GT9530	T9215	T9215
Chipbreaker Shape	TF	TSF	TM	TH	
Cutting conditions	B006				

M	Application	Finishing	Medium cutting
	Grade	T6120	T6130
Chipbreaker Shape	SF	SM	
Cutting conditions	B008		

K	Application	Finishing	Medium cutting	Medium to heavy cutting
	Grade	T515	T515	T515
Chipbreaker Shape	All-round	All-round	All-round	
Cutting conditions	B010			

N	Application	Precision finishing	Finishing	Medium cutting
	Grade	DX120	DX140	TH10
Chipbreaker Shape	T-DIA	with rake T-DIA	P	
Cutting conditions	B012			

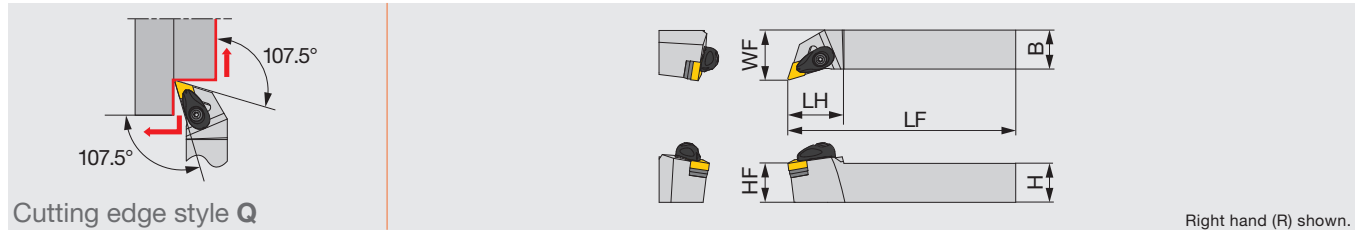
S	Application	Precision finishing	Finishing	Medium cutting
	Grade	BX470	AH8005	AH8005
Chipbreaker Shape	T-CBN	HRF	HRM	
Cutting conditions	B014			

H	Application	Precision finishing	Finishing
	Grade	BXM10	BXM20
Chipbreaker Shape	T-CBN	T-CBN	
Cutting conditions	B016		

Reference pages: DTFNR/L: Inserts → B084 -, CBN → B176 -, PCD → B192 -

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





Designation	H	B	LF	LH	HF	WF	RE**	Insert	Torque*
ADQNR/L2020K1104-A	20	20	125	30	20	25	0.8	DN**1104...	3
ADQNR/L2525M1104-A	25	25	150	30	25	32	0.8	DN**1104...	3

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

SPARE PARTS

Designation	Clamp	Clamp screw	Spring	Spring pin	Shim	Shim screw	Wrench
ADQNR/L**1104-A	ACP3S-E	ACS-5W	BP-7	SP-2.5	ASD322	CSTB-3.5	T-15F

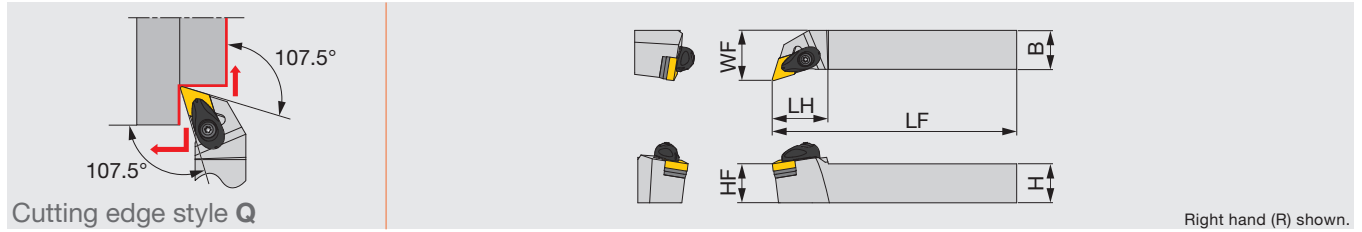
INSERT SELECTION

Application	Finishing	Medium cutting
	Grade	T9215
Chipbreaker Shape	TSF	TM
Cutting conditions	B006	

Application	Finishing	Medium cutting
	Grade	T6120
Chipbreaker Shape	SS	SM
Cutting conditions	B008	

Application	Medium cutting
Grade	T515
Chipbreaker Shape	TM
Cutting conditions	B010

Reference pages: ADQNR/L-Eco: Inserts → **B065 -**



Right hand (R) shown.

Designation	H	B	LF	LH	HF	WF	RE**	Insert	Torque*
ADQNR/L2020K15-A	20	20	125	32	20	25	0.8	DN**1504...	3
ADQNR/L2020K1506-A	20	20	125	32	20	25	0.8	DN**1506...	3
ADQNR/L2525M15-A	25	25	150	36	25	32	0.8	DN**1504...	3
ADQNR/L2525M1506-A	25	25	150	36	25	32	0.8	DN**1506...	3

*Torque: Recommended clamping torque (N-m)

**RE : Standard corner radius

SPARE PARTS

Designation	Clamp	Clamp screw	Spring	Spring pin	Shim	Shim screw	Wrench
ADQNR/L**15-A	ACP4S	ACS-5W	BP-7	SP-2.5	ASD432	CSTB-3.5	T-15F
ADQNR/L**1506-A	ACP4S	ACS-5W	BP-7	SP-2.5	ASD423	CSTB-3.5	T-15F

INSERT SELECTION

Application	Precision finishing	Finishing	Medium cutting	Medium to heavy cutting
	Grade	NS9530	GT9530	T9215
Chipbreaker Shape	TF	TSF	TM	TH
Cutting conditions	B006			

Application	Finishing	Medium cutting	Medium to heavy cutting
	Grade	T6120	T6130
Chipbreaker Shape	SF	SM	SH
Cutting conditions	B008		

Application	Finishing	Medium cutting	Medium to heavy cutting
	Grade	T515	T515
Chipbreaker Shape	All-round	All-round	All-round
Cutting conditions	B010		

Application	Precision finishing	Finishing	Medium cutting
	Grade	DX120	DX140
Chipbreaker Shape	T-DIA	with rake T-DIA	P
Cutting conditions	B012		

Application	Precision finishing	Finishing	Medium cutting
	Grade	BX470	AH8005
Chipbreaker Shape	T-CBN	HRF	HRM
Cutting conditions	B014		

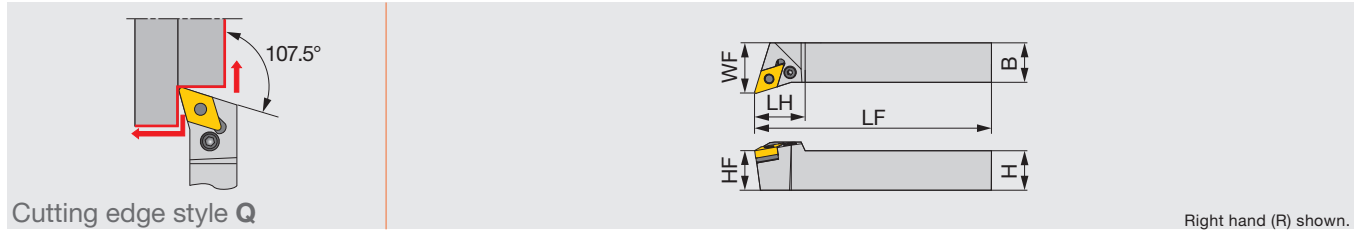
Application	Precision finishing	Finishing
	Grade	BXM10
Chipbreaker Shape	T-CBN	T-CBN
Cutting conditions	B016	

Reference pages: ADQNR/L: Inserts → B065 -, CBN → B172 -, PCD → B192 -



PDQNR/L

Lever-lock toolholder with 107.5° approach angle, for negative 55° rhombic inserts



Right hand (R) shown.

Designation	H	B	LF	LH	HF	WF	RE**	Insert
PDQNR/L2525	25	25	150	32	25	32	0.8	DN**1504...

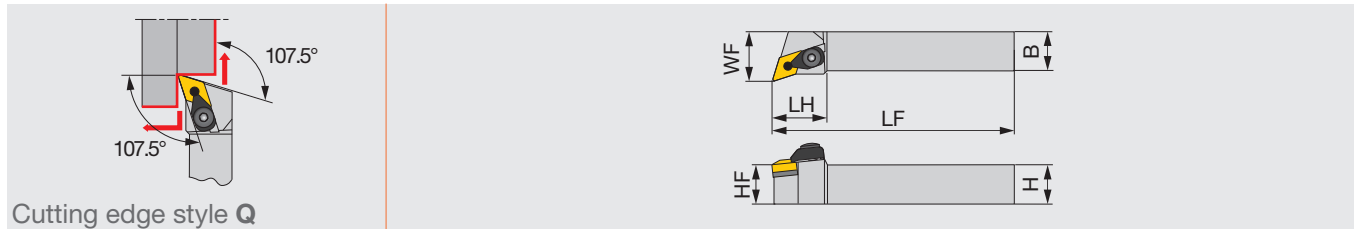
**RE : Standard corner radius

SPARE PARTS

Designation	Shim	Clamping screw	Wrench	Spring pin	Lever
PDQNR/L...	LSD42 D30	LCS4	P-3	LSP4	LCL4

DDQNR/L

"One-Double" toolholder with 107.5° approach angle, for negative 55° rhombic inserts



Designation	H	B	LF	LH	HF	WF	RE**	Insert
DDQNR/L2020K15	20	20	125	35	20	25	0.8	DN**1504...
DDQNR/L2020K1506	20	20	125	35	20	25	0.8	DN**1506...
DDQNR/L2525M15	25	25	150	35	25	32	0.8	DN**1504...
DDQNR/L2525M1506	25	25	150	35	25	32	0.8	DN**1506...
DDQNR/L3225P15	32	25	170	35	32	32	0.8	DN**1504...
DDQNR/L3225P1506	32	25	170	35	32	32	0.8	DN**1506...

Note: Except for 57-type chipbreaker inserts

**RE : Standard corner radius

SPARE PARTS

Designation	Clamp	Lever	Piston	Clamp screw	Shim	Spring	Spring pin	Wrench 1	Wrench 2
DDQNR/L**15	DCPM-43	DLCL43	DPIS43	DLCS43	LSD42	BP-10	LSP4	P-3	P-4
DDQNR/L**1506	DCPM-43	DLCL43	DPIS44	DLCS43	LSD42	BP-10	LSP4	P-3	P-4

INSERT SELECTION

Application	Precision finishing	Finishing	Medium cutting	Medium to heavy cutting
	Grade	NS9530	GT9530	T9215
Chipbreaker Shape	TF	TSF	TM	TH
Cutting conditions	B006			

Application	Finishing	Medium cutting	Medium to heavy cutting
	Grade	T6120	T6130
Chipbreaker Shape	SF	SM	SH
Cutting conditions	B008		

Application	Finishing	Medium cutting	Medium to heavy cutting
	Grade	T515	T515
Chipbreaker Shape	All-round	All-round	All-round
Cutting conditions	B010		

Application	Precision finishing	Finishing	Medium cutting
	Grade	DX120	DX140
Chipbreaker Shape	T-DIA	with rake T-DIA	P
Cutting conditions	B012		

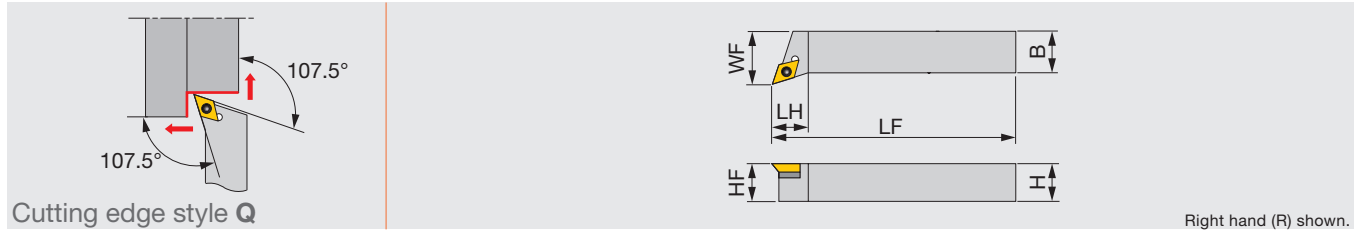
Application	Precision finishing	Finishing	Medium cutting
	Grade	BX470	AH8005
Chipbreaker Shape	T-CBN	HRF	HRM
Cutting conditions	B014		

Application	Precision finishing	Finishing
	Grade	BXM10
Chipbreaker Shape	T-CBN	T-CBN
Cutting conditions	B016	

Reference pages: PDQNR/L, DDQNR/L: Inserts → B065 -, CBN → B172 -, PCD → B192 -

SDQCR/L

Screw-on toolholder with 107.5° approach angle, for positive 55° rhombic inserts



Right hand (R) shown.

Designation	H	B	LF	LH	HF	WF	RE**	Insert
SDQCR/L2020K11	20	20	125	20.5	20	25	0.8	DC**11T3...
SDQCR2525M11	25	25	150	21.5	25	32	0.8	DC**11T3...

**RE : Standard corner radius

SPARE PARTS

Designation	Clamping screw	Shim screw	Shim	Wrench 1	Wrench 2
SDQCR/L...	CSTB-3.5L	DTS5-3.5	SSD32	P-3.5	T-15F

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



INSERT SELECTION

Application	Finishing	Finishing to medium cutting	Medium cutting
	Grade	NS9530	T9215
Chipbreaker Shape	PSS	PS	PM
Cutting conditions	B018		

Application	Precision finishing	Finishing	Finishing to medium cutting	Medium cutting
	Grade	GH330	AH725	AH630
Chipbreaker Shape	W**	PSF	PSS	PM
Cutting conditions	B020			

Application	Finishing to medium cutting
	Grade
Chipbreaker Shape	CM
Cutting conditions	B022

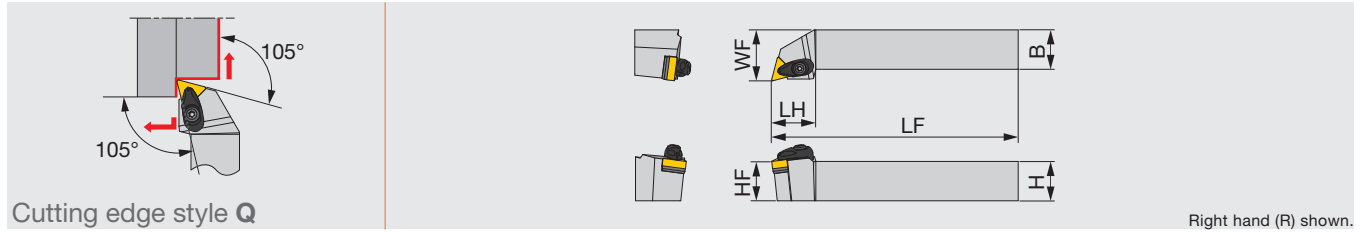
Application	Precision finishing	Finishing	Medium cutting
	Grade	DX120	DX140
Chipbreaker Shape	T-DIA	with rake T-DIA	AL
Cutting conditions	B024		

Application	Finishing	Finishing to medium cutting
	Grade	AH8015
Chipbreaker Shape	PSS	PS
Cutting conditions	B026	

Application	Precision finishing	Finishing
	Grade	BXM10
Chipbreaker Shape	T-CBN	T-CBN
Cutting conditions	B028	

Reference pages: SDQCR/L: Inserts → B119 -, CBN → B182 -, PCD → B194

Double-clamp toolholder with 105° approach angle, for negative 60° triangular inserts



Designation	H	B	LF	LH	HF	WF	RE**	Insert	Torque*
ATQNR/L2020K16-A	20	20	125	28	20	25	0.8	TN**1604...	3
ATQNR/L2525M16-A	25	25	150	28	25	32	0.8	TN**1604...	3

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

Designation	Clamp	Clamp screw	Spring	Spring pin	Shim	Shim screw	Wrench
ATQNR/L**16-A	ACP3S	ACS-5W	BP-7	SP-2.5	AST322	CSTB-3.5	T-15F

INSERT SELECTION

Application	Precision finishing	Finishing	Medium cutting	Medium to heavy cutting
	Grade	NS9530	GT9530	T9215
Chipbreaker Shape	TF	TSF	TM	TH
Images				
Cutting conditions	B006			

Application	Finishing	Medium cutting
	Grade	T6120
Chipbreaker Shape	SF	SM
Images		
Cutting conditions	B008	

Application	Finishing	Medium cutting	Medium to heavy cutting
	Grade	T515	T515
Chipbreaker Shape	All-round	All-round	All-round
Images			
Cutting conditions	B010		

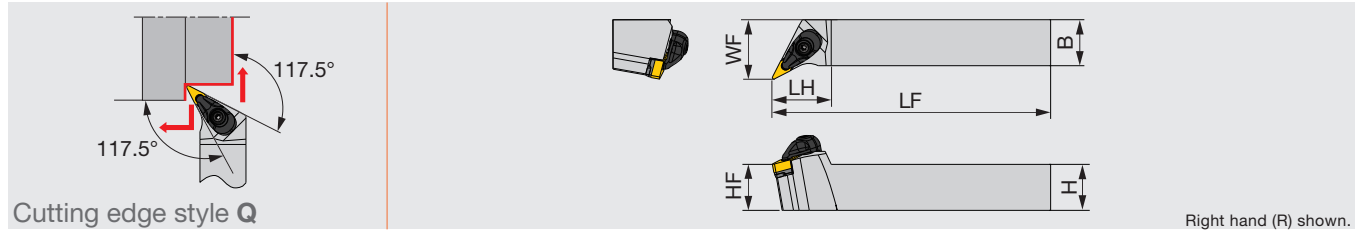
Application	Precision finishing	Finishing	Medium cutting
	Grade	DX120	DX140
Chipbreaker Shape	T-DIA	with rake T-DIA	P
Images			
Cutting conditions	B012		

Application	Precision finishing	Finishing	Medium cutting
	Grade	BX470	AH8005
Chipbreaker Shape	T-CBN	HRF	HRM
Images			
Cutting conditions	B014		

Application	Precision finishing	Finishing
	Grade	BXM10
Chipbreaker Shape	T-CBN	T-CBN
Images		
Cutting conditions	B016	

Reference pages: ATQNR/L: Inserts → B084 -, CBN → B176 -, PCD → B192 -

Double-clamp toolholder with 117.5° approach angle, for negative 35° rhombic inserts

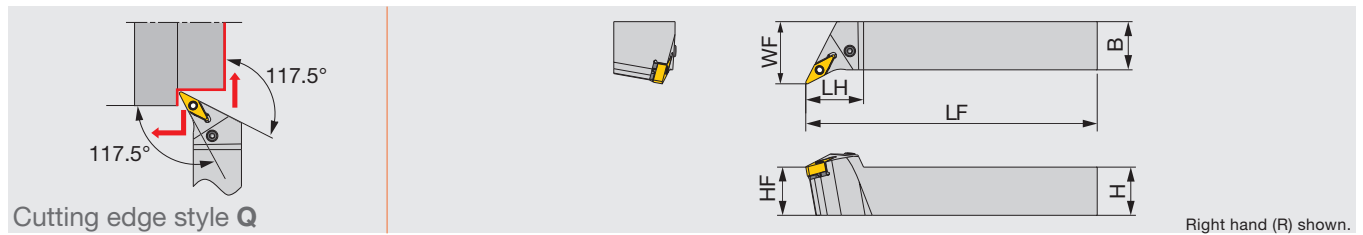


Designation	H	B	LF	LH	HF	WF	RE**	Insert	Torque*
AVQNR/L2020K1204-A	20	20	125	32	20	25	0.8	VN**1204...	3
AVQNR/L2525M1204-A	25	25	150	32	25	32	0.8	VN**1204...	3

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

SPARE PARTS							
Designation	Clamp	Clamp screw	Spring	Spring pin	Shim	Shim screw	Wrench
AVQNR/L**A	ACP3L-E	ACS-5W	BP-7	SP-2.5	ASV222	CSTB-3.0	T-15F

Lever-lock toolholder with 117.5° approach angle, for negative 35° rhombic inserts



Designation	H	B	LF	LH	HF	WF	RE**	Insert	Torque*
PVQNR/L2020K1204	20	20	125	30	20	25	0.8	VN**1204...	2
PVQNR/L2525M1204	25	25	150	30	25	32	0.8	VN**1204...	2

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

SPARE PARTS					
Designation	Shim	Clamping screw	Wrench	Spring pin	Lever
PVQNR/L**1204	LSV212	LCS3V	P-2.5	LSP3	LCL3V

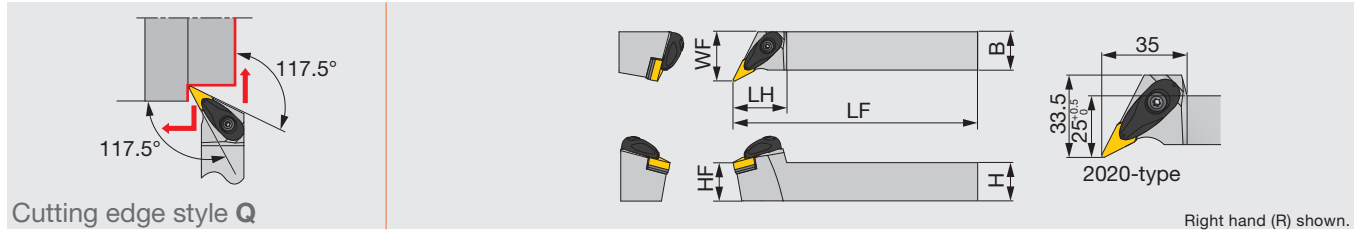
INSERT SELECTION

Application	Finishing	Medium cutting
	Grade	T9215
Chipbreaker Shape		
Cutting conditions	B006	

Application	Finishing	Medium cutting
	Grade	T6120
Chipbreaker Shape		
Cutting conditions	B008	



Double-clamp toolholder with 117.5° approach angle, for negative 35° and 25° rhombic inserts



Designation	H	B	LF	LH	HF	WF	RE**	Insert	Torque*
AVQNR/L2020K16-A	20	20	125	35	20	25	0.8	V/YN**1604...	3
AVQNR/L2525M16-A	25	25	150	35	25	32	0.8	V/YN**1604...	3

*Torque: Recommended clamping torque (N·m)

**RE : Standard corner radius

SPARE PARTS

Designation	Clamp	Clamp screw	Spring	Spring pin	Shim	Shim screw	Wrench
AVQNR/L...	ACP3L	ACS-5W	BP-7	SP-2.5	ASV322	CSTB-3.5	T-15F

INSERT SELECTION

Application	Precision finishing	Finishing	Medium cutting
	Grade	NS9530	GT9530
Chipbreaker Shape	TF	TSF	TM
Cutting conditions	B006		

Application	Finishing	Medium cutting
	Grade	T6120
Chipbreaker Shape	SF	SM
Cutting conditions	B008	

Application	Finishing	Medium cutting	Medium to heavy cutting
	Grade	T515	T515
Chipbreaker Shape	All-round	All-round	All-round
Cutting conditions	B010		

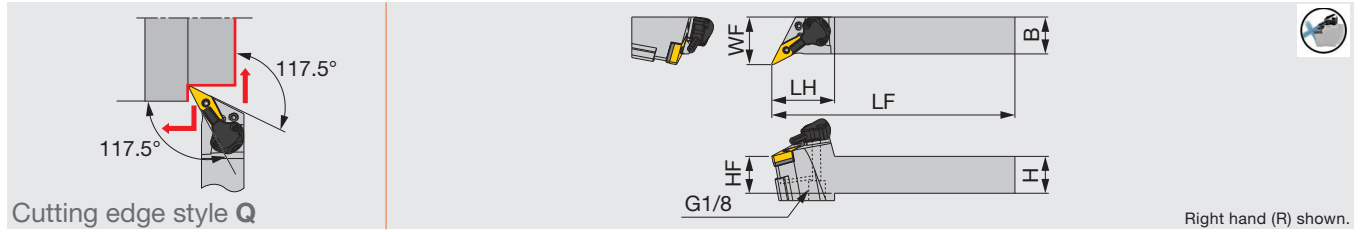
Application	Precision finishing
	Grade
Chipbreaker Shape	T-DIA with rake
Cutting conditions	B012

Application	Precision finishing	Finishing	Medium cutting
	Grade	BX480	AH8005
Chipbreaker Shape	T-CBN	HRF	HRM
Cutting conditions	B014		

Application	Precision finishing	Finishing
	Grade	BXM10
Chipbreaker Shape	T-CBN	T-CBN
Cutting conditions	B016	

Reference pages: AVQNR/L: Inserts → B094 -, B107, CBN → B178, PCD → B192

Lever-lock toolholders with 117.5° approach angle, for negative 35° and 25° rhombic inserts, with high pressure coolant capability



Designation	H	B	LF	LH	HF	WF	RE**	Insert	Torque*
PVQNR/L2020K16-CHP	20	20	125	42.5	20	32	0.8	V/YN**1604...	2
PVQNR/L2525M16-CHP	25	25	150	42.5	25	32	0.8	V/YN**1604...	2

*Torque: Recommended clamping torque (N·m)

**RE : Standard corner radius

SPARE PARTS

Designation	Shim	Clamping screw	Wrench 1	Spring pin	Lever
PVQNR/L**-CHP	LSV317	LCS3V	P-2.5	LSP3	LCL3V

SPARE PARTS

Designation	Coolant unit	Mounting screw	Wrench 2	O-ring	Coolant screw	Wrench 3
PVQNR/L**-CHP	CU-V-CHP	SRM3	T-8F	OR6.4X0.9N	SRM4X4TL360	P-2

INSERT SELECTION

Application	Precision finishing	Finishing	Medium cutting
	Grade	NS9530	GT9530
Chipbreaker Shape	TF	TSF	TM
Cutting conditions	B006		

Application	Finishing	Medium cutting
	Grade	T6120
Chipbreaker Shape	SF	SM
Cutting conditions	B008	

Application	Finishing	Medium cutting	Medium to heavy cutting
	Grade	T515	T515
Chipbreaker Shape	All-round	All-round	All-round
Cutting conditions	B010		

Application	Precision finishing
	Grade
Chipbreaker Shape	T-DIA with rake
Cutting conditions	B012

Application	Precision finishing	Finishing	Medium cutting
	Grade	BX480	AH8005
Chipbreaker Shape	T-CBN	HRF	HRM
Cutting conditions	B014		

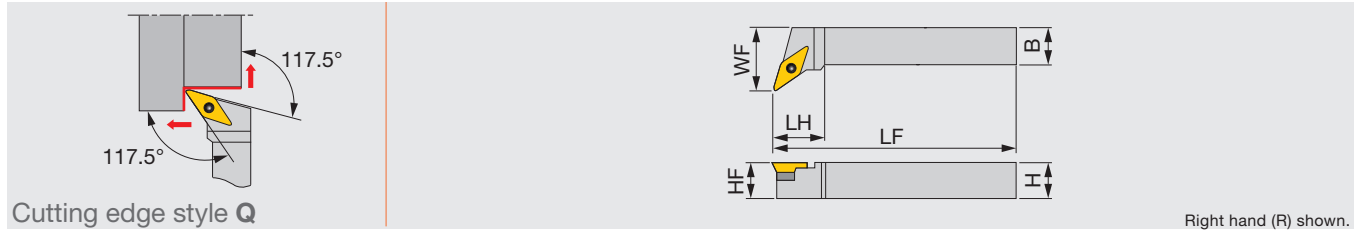
Application	Precision finishing	Finishing
	Grade	BXM10
Chipbreaker Shape	T-CBN	T-CBN
Cutting conditions	B016	

Reference pages: PVQNR/L-CHP: Inserts → **B094 -**, **B107**, CBN → **B178**, PCD → **B192**
Parts for coolant hose → **C134**



SVQCR/L

Screw-on toolholder with 117.5° approach angle, for positive 35° rhombic inserts



Designation	H	B	LF	LH	HF	WF	RE**	Insert
SVQCR/L2020K16	20	20	125	35	20	27	0.8	VC**1604...
SVQCR/L2525M16	25	25	150	35	25	32	0.8	VC**1604...

**RE : Standard corner radius

SPARE PARTS

Designation	Clamping screw	Shim screw	Shim	Wrench 1	Wrench 2
SVQCR/L...	CSTB-3.5L	DTS5-3.5	SSV32	P-3.5	T-15F

INSERT SELECTION

P

Application	Finishing	Finishing to medium cutting
Grade	NS9530	T9215
Chipbreaker Shape	PSS	PS
Cutting conditions	B018	

M

Application	Finishing	Finishing to medium cutting	Medium cutting
Grade	AH725	AH630	T6130
Chipbreaker Shape	PSF	PSS	PM
Cutting conditions	B020		

K

Application	Finishing to medium cutting
Grade	T515
Chipbreaker Shape	CM
Cutting conditions	B022

N

Application	Precision finishing	Finishing	Medium cutting
Grade	DX120	DX140	KS05F
Chipbreaker Shape	T-DIA	with rake T-DIA	AL
Cutting conditions	B024		

S

Application	Finishing	Finishing to medium cutting
Grade	AH8015	AH8015
Chipbreaker Shape	PSS	PS
Cutting conditions	B026	

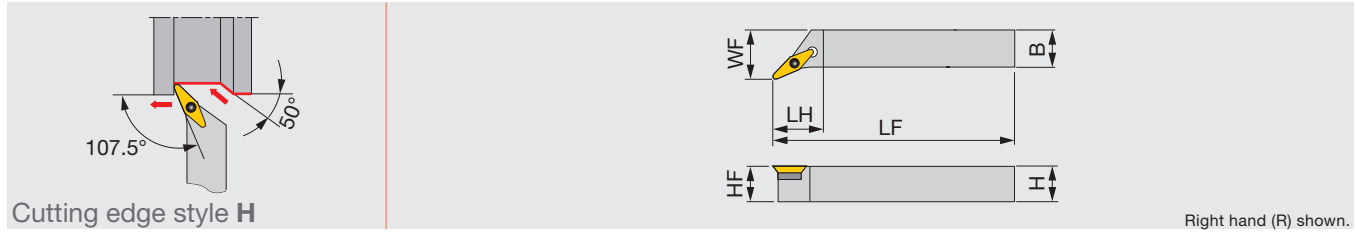
H

Application	Precision finishing	Finishing
Grade	BXM10	BXM20
Chipbreaker Shape	T-CBN	T-CBN
Cutting conditions	B028	

Reference pages: SVQCR/L: Inserts → B153 -, CBN → B189 -, PCD → B194

SVHCR/L

Screw-on toolholder with 107.5° approach angle, for positive 35° rhombic inserts



Designation	H	B	LF	LH	HF	WF	RE**	Insert
SVHCR/L2525M22	25	25	150	33.8	25	32	0.8	VCG*2205...

**RE : Standard corner radius

SPARE PARTS

Designation	Clamping screw	Shim screw	Shim	Wrench 1	Wrench 2
SVHCR/L2525M22	CSTB-4.5L110P	DTS6-4.5	SSV42	P-4.5	T-15F

INSERT SELECTION

K

Application	Finishing to medium cutting
Grade	KS05F
Chipbreaker Shape	AL
Cutting conditions	B022

N

Application	Finishing to medium cutting
Grade	KS05F
Chipbreaker Shape	AL
Cutting conditions	B024

S

Application	Finishing to medium cutting
Grade	KS05F
Chipbreaker Shape	AL
Cutting conditions	B026

Reference pages: SVHCR/L: Inserts → B154

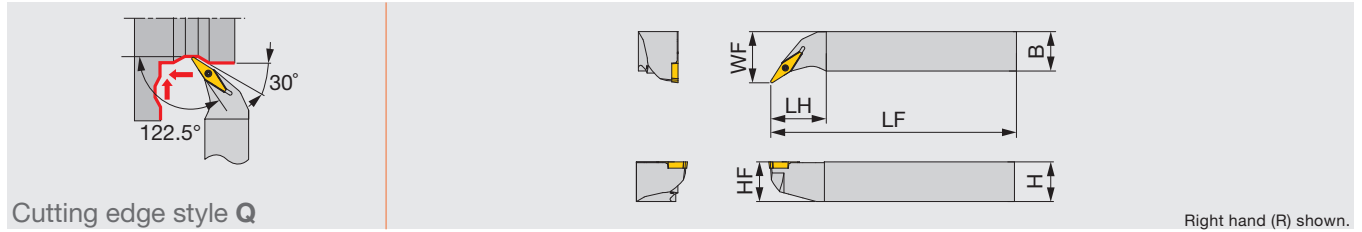
Grade
Insert
Ext. Toolholder
Int. Toolholder
Threading
Grooving
Miniature tool
Milling cutter
Endmill
Drilling tool
Tooling System
User's Guide
Index



Y-PRO SERIES

SYQBR/L

Screw-on toolholder with 122.5° approach angle, for positive 25° rhombic inserts



Designation	H	B	LF	LH	HF	WF	RE**	Insert
SYQBR/L2020K16	20	20	125	35	20	27	0.8	YWMT16T3...
SYQBR/L2525M16	25	25	150	35	25	32	0.8	YWMT16T3...

**RE : Standard corner radius

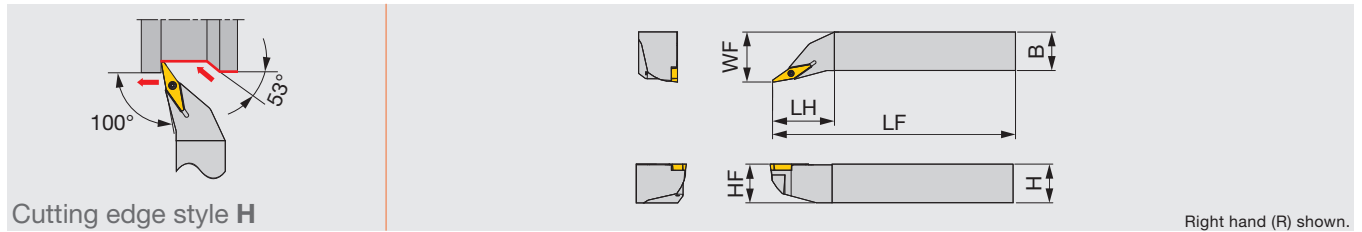
SPARE PARTS

Designation	Clamping screw	Wrench
SYQBR/L...	CSTB-2.5L080	T-8F

Y-PRO SERIES

SYHBR/L

Screw-on toolholder with 100° approach angle, for positive 25° rhombic inserts



Designation	H	B	LF	LH	HF	WF	RE**	Insert
SYHBR/L2020K16	20	20	125	35	20	27	0.8	YWMT16T3...
SYHBR/L2525M16	25	25	150	40	25	32	0.8	YWMT16T3...

**RE : Standard corner radius

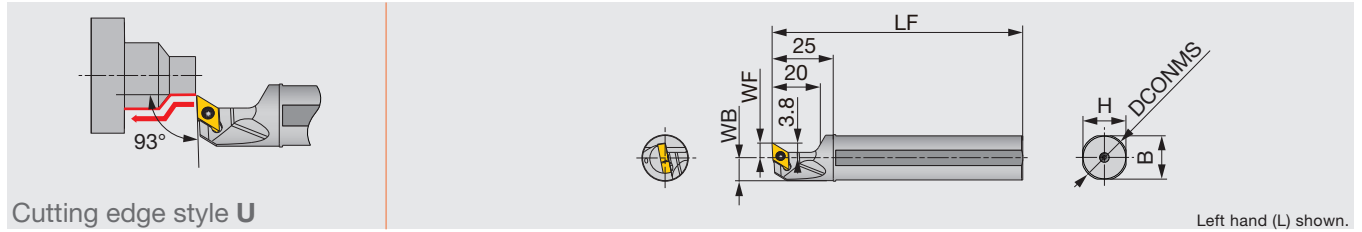
SPARE PARTS

Designation	Clamping screw	Wrench
SYHBR/L...	CSTB-2.5L080	T-8F

INSERT SELECTION

Application	Finishing to medium cutting	Application	Finishing to medium cutting
Grade	T9225	Grade	GT9530
Chipbreaker Shape	ZM	Chipbreaker Shape	ZM
Cutting conditions	B006	Cutting conditions	B010

Reference pages: SYQBR/L, SYHBR/L: Inserts → B160



Left hand (L) shown.

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

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

SPARE PARTS

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

INSERT SELECTION

Swiss lathes

Application	Finishing	Medium cutting
	Grade	SH725
Chipbreaker Shape	JSS	JTS
Cutting conditions	C135	

Application	Finishing	Medium cutting
	Grade	SH725
Chipbreaker Shape	JSS	JTS
Cutting conditions	C135	

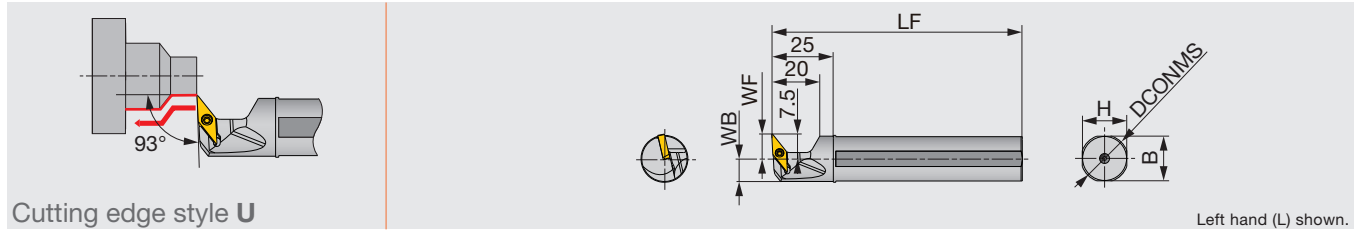
Small CNC lathes

Application	Finishing	Medium cutting
	Grade	AH725
Chipbreaker Shape	SS	TS
Cutting conditions	C135	

Application	Finishing	Medium cutting
	Grade	AH8015
Chipbreaker Shape	SS	TS
Cutting conditions	C135	

Reference pages: JS-SDUXL: Inserts → **B125** -
Standard cutting conditions → **C135**

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



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

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

SPARE PARTS

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

INSERT SELECTION

Swiss lathes

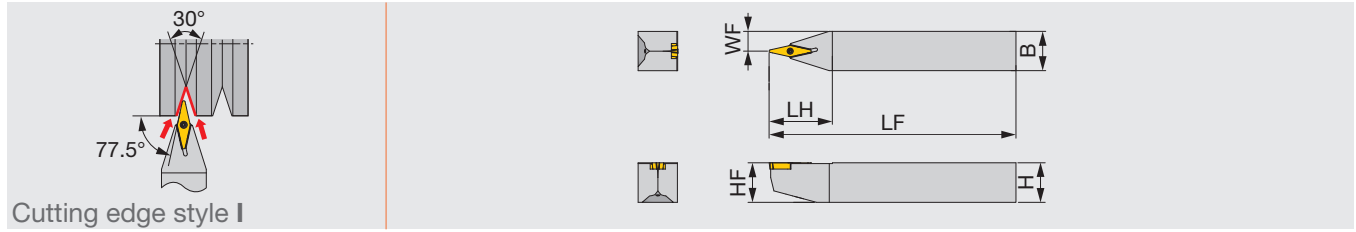
Application	Finishing	Application	Finishing
Grade	SH725	Grade	SH725
Chipbreaker	JRP	Chipbreaker	JRP
Shape		Shape	
Cutting conditions	C135	Cutting conditions	C135

Small CNC lathes

Application	Finishing	Application	Finishing
Grade	SH725	Grade	SH725
Chipbreaker	JRP	Chipbreaker	JRP
Shape		Shape	
Cutting conditions	C135	Cutting conditions	C135

Reference pages: JS-SVUXL: Inserts → **B156**
 Standard cutting conditions → **C135**

Screw-on toolholder with 77.5° approach angle, for positive 25° rhombic inserts



Designation	H	B	LF	LH	HF	WF	RE**	Insert
SYIBN2020K16	20	20	125	32	20	10	0.8	YWMT16T3...
SYIBN2525M16	25	25	150	40	25	12.5	0.8	YWMT16T3...

**RE : Standard corner radius

SPARE PARTS

Designation	Clamping screw	Wrench
SYIBN...	CSTB-2.5L080	T-8F

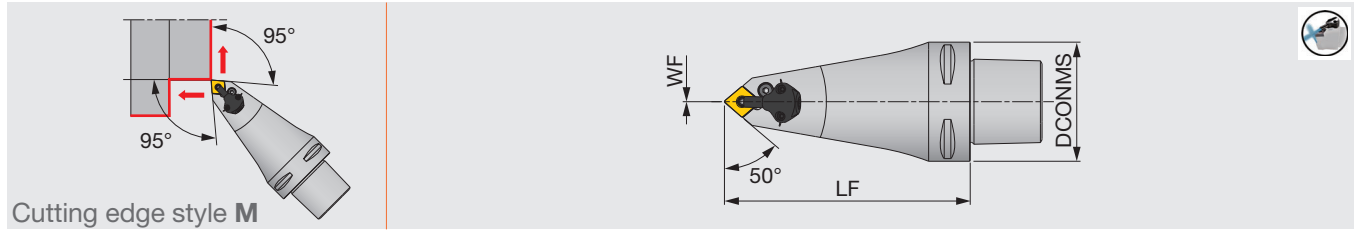
INSERT SELECTION

P	Application	Finishing to medium cutting	K	Application	Finishing to medium cutting
	Grade	T9225		Grade	GT9530
Chipbreaker Shape	ZM	Chipbreaker Shape	ZM		
Cutting conditions	B006	Cutting conditions	B010		

Reference pages: SYIBN: Inserts → **B160**



Lever-lock toolholder with TungCap connection, for negative 80° rhombic inserts, with high pressure coolant capability



Designation	DCONMS	LF	WF	RE	Insert
C6PCMNN00130-12-CHP	63	115	0	0.8	CN/GN**1204...

Applicable for 14 MPa coolant
**RE : Standard corner radius

For external turning only

SPARE PARTS

Designation	Shim	Clamping screw	Wrench 1	Spring pin	Lever
C6PCMNN00130-12-CHP	LSC42	LCS4	P-3	LSP4	LCL4

SPARE PARTS

Designation	Coolant unit	Mounting screw	Wrench 2	O-ring
C6PCMNN00130-12-CHP	CU-CW-CHP	SRM3	T-8F	OR6.4X0.9N

INSERT SELECTION

Application	Precision finishing	Finishing	Medium cutting	Medium to heavy cutting
	Grade	NS9530	GT9530	T9215
Chipbreaker Shape	TF	TSF	TM	TH
Cutting conditions	B006			

Application	Finishing	Medium cutting	Medium to heavy cutting
	Grade	T6120	T6130
Chipbreaker Shape	SF	SM	SH
Cutting conditions	B008		

Application	Finishing	Medium cutting	Medium to heavy cutting
	Grade	T515	T515
Chipbreaker Shape	All-round	All-round	All-round
Cutting conditions	B010		

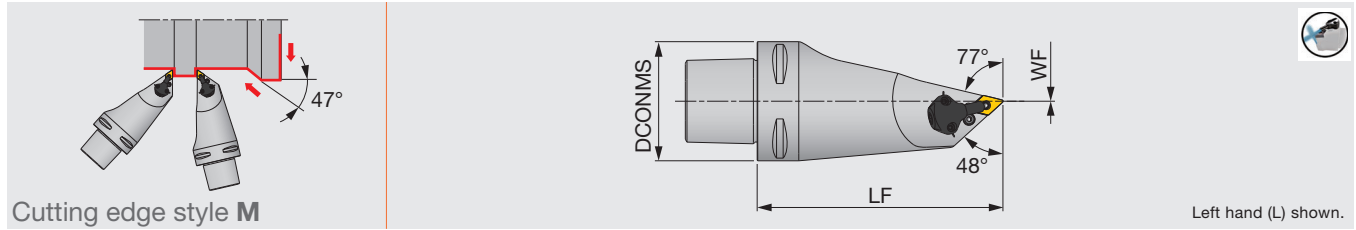
Application	Precision finishing	Finishing	Medium cutting
	Grade	DX120	DX140
Chipbreaker Shape	T-DIA	with rake T-DIA	P
Cutting conditions	B012		

Application	Precision finishing	Finishing	Medium cutting
	Grade	BX470	AH8005
Chipbreaker Shape	T-CBN	HRF	HRM
Cutting conditions	B014		

Application	Precision finishing	Finishing
	Grade	BXM10
Chipbreaker Shape	T-CBN	T-CBN
Cutting conditions	B016	

Reference pages: C-PCMNN-CHP: Inserts → B054 -, CBN → B170 -, PCD → B192 -
Parts for coolant hose → C134

Lever-lock toolholder with TungCap connection, for negative 55° rhombic inserts, with high pressure coolant capability



Designation	DCONMS	LF	WF	RE**	Insert
C6PDMNL00130-1104-CHP	63	130	0	0.8	DN**1104...

Applicable for 14 MPa coolant
**RE : Standard corner radius

For external turning only

SPARE PARTS

Designation	Shim	Clamping screw	Wrench 1	Spring pin	Lever
C6PDMNL00130-1104-CHP	ELSD32	LCS3	P-2.5	LSP3	LCL33L

SPARE PARTS

Designation	Coolant unit	Mounting screw	Wrench 2	O-ring
C6PDMNL00130-1104-CHP	CU-D-CHP	SRM3	T-8F	OR6.4X0.9N

INSERT SELECTION

Application	Finishing	Medium cutting
	Grade	T9215
Chipbreaker Shape	TSF	TM
Cutting conditions	B006	

Application	Finishing	Medium cutting
	Grade	T6120
Chipbreaker Shape	SS	SM
Cutting conditions	B008	

Application	Medium cutting
Grade	T515
Chipbreaker Shape	TM
Cutting conditions	B010

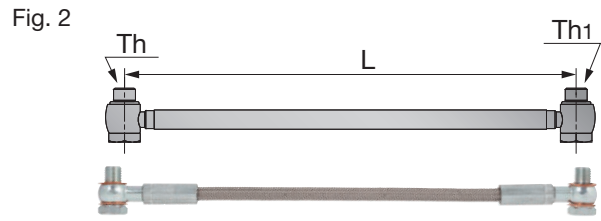
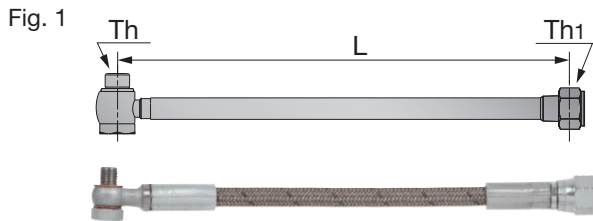
Reference pages: C-PDMNL-CHP: Inserts → **B065** -
Parts for coolant hose → **C134**



Technical Guide

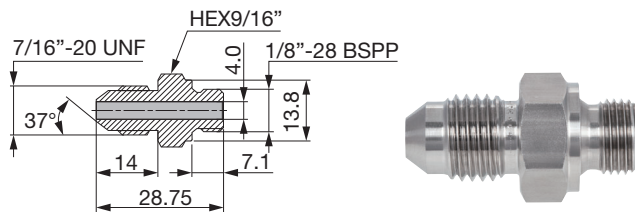
PARTS FOR COOLANT HOSE

Connecting hose



Designation	L	Th	Th1	Max. pressure (Mpa)	Fig.
CHP-HOSE-G1/8-7/16-200BS	200	G1/8"-28 BSPP	7/16"-20 UNF	26	1
CHP-HOSE-G1/8-7/16-250BS	250	G1/8"-28 BSPP	7/16"-20 UNF	26	1
CHP-HOSE-5/16-7/16-200BS	200	5/16"-24UNF	7/16"-20 UNF	20	1
CHP-HOSE-5/16-G1/8-200BS	200	5/16"-24UNF	G1/8"-28 BSPP	20	1
CHP-HOSE-G1/8-G1/8-200BB	200	G1/8"-28 BSPP	G1/8"-28 BSPP	26	2
CHP-HOSE-G1/8-G1/8-250BB	250	G1/8"-28 BSPP	G1/8"-28 BSPP	26	2

Connector



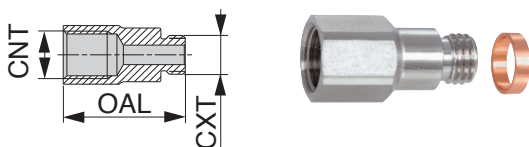
Designation
CHP-NIPPLE-G1/8-7/16UNF

Seal washer



Designation	øD	ød	W
CHP-COPPER-SEAL1/8	15	10	1
CHP-COPPER-SEAL5/16	11.9	8.15	1.35
CHP-COPPER-SEAL5/16-2.5	9.4	8	2.5

Connector for small lathe with seal washer



Designation	CNT	CXT	OAL
CHP-CONNECTOR5/16-G1/8	G1/8"-28 BSPP	5/16"-24 UNF	25
CHP-CONNECTOR-G1/8-R1/8	G1/8"-28 BSPP	R1/8"-28 BSPT	25

STANDARD CUTTING CONDITIONS

FIXRETURN

ISO	Workpiece material	Chipbreaker	Grade	Cutting Speed Vc (m/min)	Depth of cut ap (mm)	Feed f (mm/rev)
P	Steels S45C, SCM415, etc. C45, 18CrMo4, etc.	6RS	T9215	120 - 350	0.5 - 2	0.5 - 1
		6RS	T9225	100 - 300	0.5 - 2	0.5 - 1
		6RS	NS9530	150 - 250	0.5 - 2	0.5 - 1
		6RM	T9215	120 - 350	1 - 3	0.5 - 1
		6RM	T9225	100 - 300	1 - 3	0.5 - 1
		6RM	NS9530	150 - 250	1 - 3	0.5 - 1

Reference pages: SRGCR/L → C085

STANDARD CUTTING CONDITIONS

MINIFORCE TURN

Applications	ISO	Workpiece material	Priority	Chipbreaker	Grade	Cutting speed Vc (m/min)	Depth of cut ap (mm)	Feed f (mm/rev)
Swiss lathes	P	Low carbon steel SS400, etc. E275A, etc. Carbon steel S45C, etc. C45, etc. Low alloy steel SCM415, etc. 18CrMo4, etc. Alloy steel SCM440, etc. 42CrMo4, etc.	First choice	JS	SH725	50 - 180	0.1 - 3	0.03 - 0.1
			Sharpness	JSS	SH725	50 - 180	0.1 - 1.5	0.03 - 0.1
	M	Stainless steel (Austenitic) SUS304, etc. X5CrNi18-9, etc. Stainless steel (Martensitic and ferritic) SUS430, etc. X6Cr17, etc. Stainless steel (Precipitation hardened) SUS630, etc. X5CrNiCuNb16-4, etc.	First choice	JS	SH725	50 - 180	0.1 - 1.25	0.03 - 0.1
			Sharpness	JSS	SH725	50 - 180	0.1 - 1.5	0.03 - 0.1
Small CNC lathes	P	Low carbon steel SS400, etc. E275A, etc. Carbon steel S45C, etc. C45, etc. Low alloy steel SCM415, etc. 18CrMo4, etc. Alloy steel SCM440, etc. 42CrMo4, etc.	First choice	SS	AH725	50 - 180	0.15 - 1.5	0.05 - 0.2
				TS	AH725	50 - 180	0.3 - 2	0.08 - 0.3
			Surface quality	SS	NS9530	50 - 200	0.15 - 1.5	0.05 - 0.2
				TS	NS9530	50 - 200	0.3 - 2	0.08 - 0.3
	Wear resistance	SS	GT9530	50 - 250	0.15 - 1.5	0.05 - 0.2		
		TS	GT9530	50 - 250	0.3 - 2	0.08 - 0.3		
M	Stainless steel (Austenitic) SUS304, etc. X5CrNi18-9, etc. Stainless steel (Martensitic and ferritic) SUS430, etc. X6Cr17, etc. Stainless steel (Precipitation hardened) SUS630, etc. X5CrNiCuNb16-4, etc.	First choice	SS	AH725	50 - 150	0.15 - 1.5	0.05 - 0.2	
		Fracture resistance	TS	AH725	50 - 150	0.3 - 2	0.08 - 0.3	

TURNFEED

For HD holder (High Depth of Cut)

ISO	Insert	Depth of cut ap (mm)	Feed f (mm/rev)	Cutting Speed: Vc (m/min)		
				T9215	T9125	T9225
P	POMG110612-MNW	0.8 - 5.5	0.4 - 1.2	150 - 400	80 - 180	120 - 300
	POMG130612-MNW	1.0 - 7.0	0.4 - 1.3	150 - 400	80 - 180	120 - 300

For HF holder (High Feed)

ISO	Insert	Depth of cut ap (mm)	Feed f (mm/rev)	Cutting Speed: Vc (m/min)		
				T9215	T9125	T9225
P	POMG110612-MNW	1.0 - 2.5	0.5 - 1.5	150 - 400	80 - 180	120 - 300
	POMG130612-MNW	1.0 - 3.0	0.5 - 2.0	150 - 400	80 - 180	120 - 300

TURNFEED

ISO	Workpiece material	Grade	Chipbreaker	Cutting Speed Vc (m/min)	Depth of cut ap (mm)	Feed f (mm/rev)
P	Mild and low carbon steels SS400, SM490, etc. E275A, C15E4, etc. < 180 HB	T9225	ML	100 - 300	0.5 - 2.5	0.5 - 2.5
	Carbon and alloy steels S55C, SCM440, etc. C55, 42CrMo4, etc. < 300HB	T9215	ML	120 - 350	0.5 - 2.5	0.5 - 2.5
M	Stainless steels SUS304, SUS316, etc. X5CrNi18-9, X5CrNiMo17-12-3, etc. < 250 HB	T9225	ML	100 - 300	0.5 - 2.5	0.5 - 2.5
K	Grey and ductile cast irons FC250, FCD400, etc. 250, 400-15S, etc.	AH120	ML	100 - 250	0.5 - 2.5	0.5 - 2.5

Note: When the side cutting edge is used for facing, the maximum feed is limited to within 1.0 mm/rev.

Reference pages: JSWL2XR/L, JSWLXR/L, JSWL2XR/L-CHP, JPWL2XR/L, JSWLXR-F → C031 - C033
 JSDJ2XR/L, JSDJXR/L, JSDJ2XR/L-CHP, JPDJ2XR/L, JSDJXR-F → C039 - C041
 JSVJ2XR/L, JSVJXR/L, JSVJ2XR/L-CHP, JPVJ2XR/L, JSVJXR-F → C056 - C058
 SRGCR/L → C085, PPXOR/L-HD, PPXOR/L-HF → C096, XWXPR/L → C098
 SRDCN → C101, JS-SDUXL, JS-SVUXL → C129 - C130

Technical Guide

STANDARD CUTTING CONDITIONS

TURNTEC

LNMX1204

*Values in red are for facing.

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

LNMX1606

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

LNMX2410

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

DIMPLEFX

ISO	Workpiece material	Grade	Cutting speed Vc (m/min)	Depth of cut ap (mm)	Feed f (mm/rev)
K	Grey cast irons	FX105	700 (300 - 1000)	1 (0.05 - 3)	0.3 (0.05 - 0.6)
	Ductile cast irons	FX105	200 (100 - 300)	1 (0.05 - 3)	0.2 (0.05 - 0.4)

Reference pages: CCLNR/L-RD → C022, CDJNR/L-RD → C046, CDNNN-RD → C065
 CVVNN-RD → C070, TLANR/L → C078, TLBNR/L → C092, CHSNR/L → C105
 CSSNR/L → C108, TLFNR/L → C113