

For Multi-task Machines

HSK TURNING TOOLS

HSK tool series leading the way forward



Tooling system
for turning on
multi-task machines

HSK TOOLS

HSK-T System (ICTM standard)

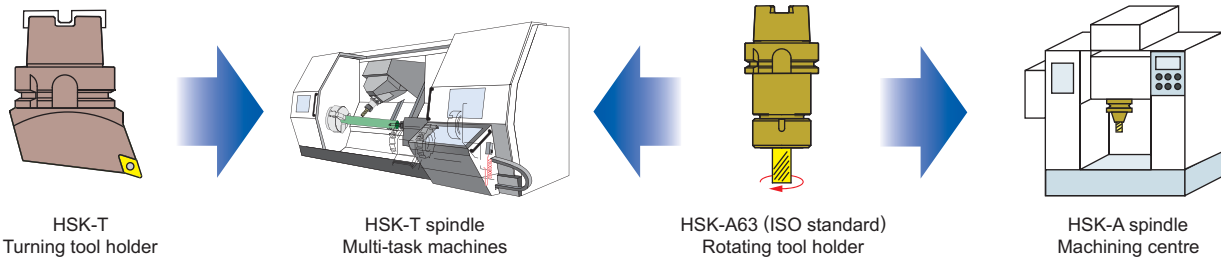
HSK-T is a new HSK system designed for turning on multi-task machines that are compatible with HSK-A type (ISO standard: ISO12164-1:2001). It was jointly developed by a consortium of Japanese manufacturers and is now used worldwide as the ICTM standard. Presently ISO standardization of the HSK-T system is under deliberation.



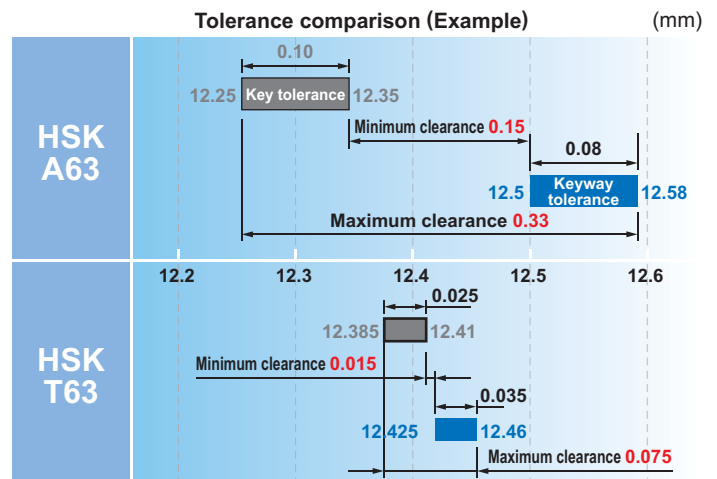
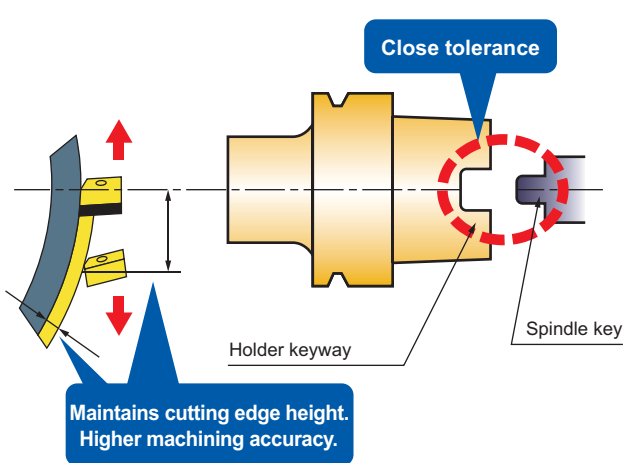
High accuracy cutting edge positioning

The HSK-T type has a closer tolerance between the spindle key and tool holder keyway than the HSK-A type. This results in higher cutting edge positional accuracies. For milling, the conventional HSK-A type tools can be still used.

Compatible with both multi-task machines and machining centres

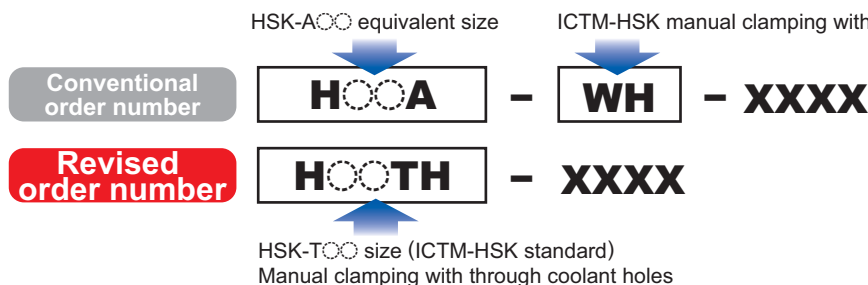


Improved keyway tolerance



From ICTM-HSK to HSK-T

The order numbers of the tool holders will be changed according to the global standardization.

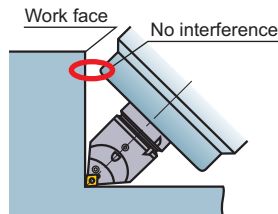


High accuracy and rigidity HSK-T type tooling system developed for use on multi-task machines.

Straight type tools suitable for use on multi-task machines

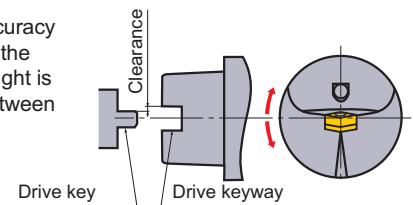
Avoid workpiece interference with improved tool accessibility.

By tilting the machines B spindle (main axis of the tool) at 45 deg. interference between the spindle, holder, workpiece and chuck can be avoided.



Improve centreline height by positioning the cutting edge at the centre of the spindle.

Increased stability and accuracy can be achieved because the cutting edge centreline height is not affected by the gap between the spindle and the key.



New one-action type double clamp series

NEW

The double clamp mechanism offers high rigidity, accuracy, reliability that ensures secure insert clamping. Therefore making it suitable for turning of difficult to machine materials such as stainless and heat resistant alloys.



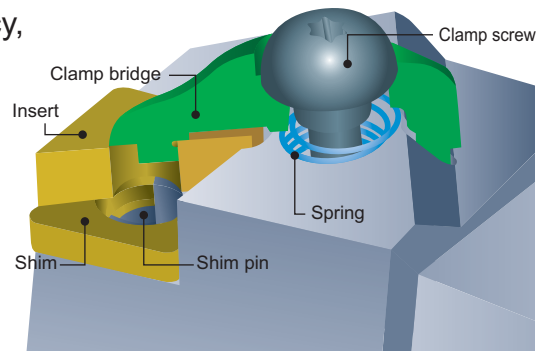
Handed type for turning and facing



Straight type for turning and facing



For turning, facing and boring



3 on 1 tool for process and tool consolidation

NEW

3 turning inserts of the same geometry can be installed on a single tool.

The same type of inserts can be installed for quick change with spare tools.

Different types of inserts can be installed for different applications (rough and semi finishing and finishing)

Inserts in different grade types can be installed to cover various kinds of workpieces.



New HSK-T100 size for large workpieces

NEW

Larger tool holder sizes for high efficiency machining.

Square shank holder type



Boring bar / Drill type

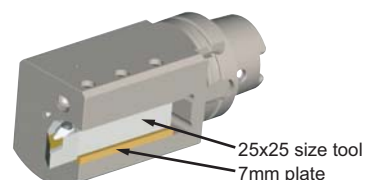


Sleeve




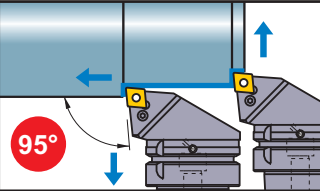

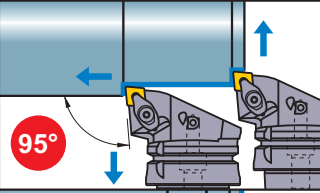

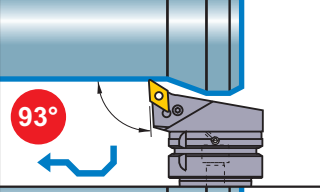

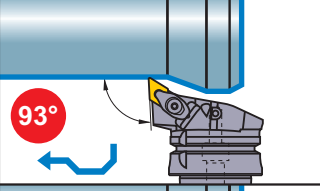

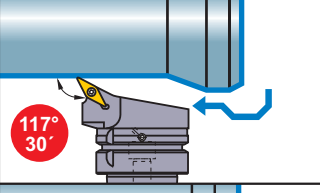

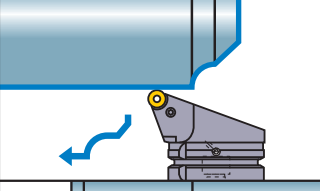

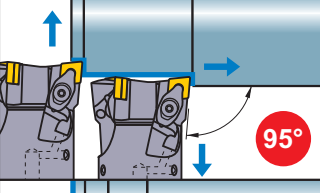

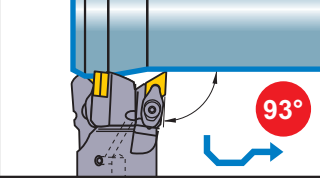
A single tool can be used with different sized tool holders.


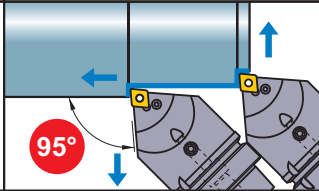

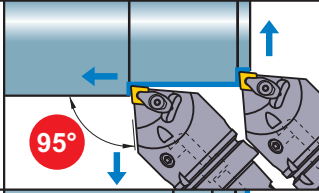

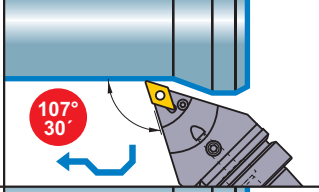
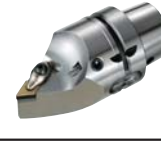
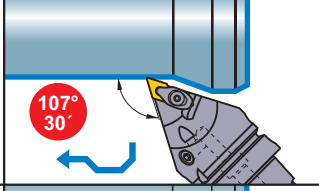

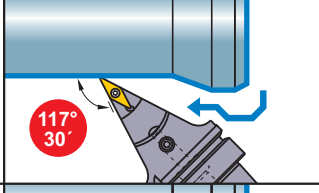

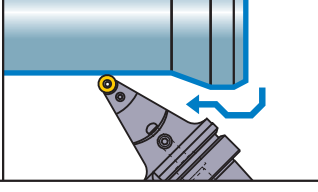
- Available for use with JIS B4126 (ISO 5610) 32x32 and 32x25 tools.
- Possible to fit a 25x25 tool by using a 7mm plate.
- *Please prepare a plate on your own.




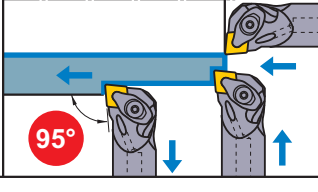
CLASSIFICATION OF HSK TURNING TOOLS


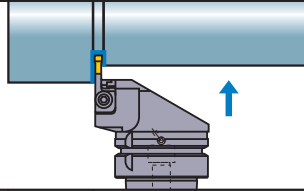

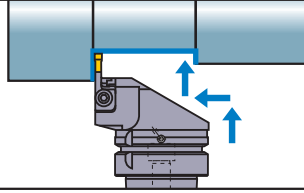

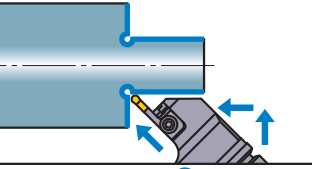

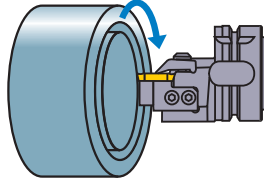

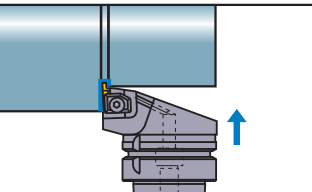
External Turning • Facing • Copying

Order Number	Geometry
H63TH-PCLNR/L-DX12 	 95° ➔P.5
NEW H63TH-DCLNR/L-DX12 	 95° ➔P.5
H63TH-PDJNR/L-DX15 	 93° ➔P.8
NEW H63TH-DDJNR/L-DX15 	 93° ➔P.8
H63TH-SVPBR/L-DX16 	 117° 30' ➔P.12
H63TH-PRGCR/L-DX12 	 ➔P.11
NEW H63TH-DCLNL-L12-3 	 95° ➔P.7
NEW H63TH-DDJNL-L15-3 	 93° ➔P.10


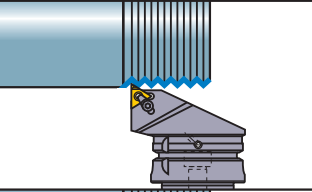

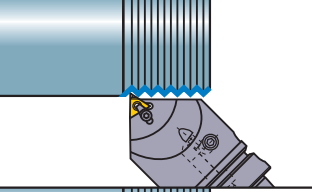

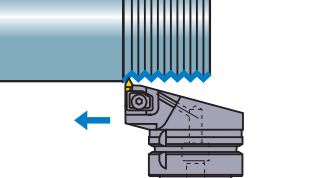
Order Number	Geometry
H63TH-PCMNN-H/L12 	 95° ➔P.6
NEW H63TH-DCMNN-H/L12 	 95° ➔P.6
H63TH-PDNNN-H/L15 	 107° 30' ➔P.9
NEW H63TH-DDNNN-H/L15 	 107° 30' ➔P.9
H63TH-SVVBH-H/L16 	 117° 30' ➔P.12
H63TH-PRDCN-H/L12 	 ➔P.11




External Turning • Facing • Boring

Order Number	Geometry
NEW H63TH-A25KDCLNR/L12 H63TH-A32LDCLNR/L12 	 95° ➔P.7

Grooving	
Order Number	Geometry
H63TH-C○○○○R/L  → P.13	
H63TH-C○○○○R/L H63TH-D○○○○R/L  → P.13	
H63TH-G○○○○NH/L  → P.14	
H63TH-M○○○○R/L H63TH-P○○○○R/L H63TH-N○○○○R/L H63TH-Q○○○○R/L  → P.15, P.16 P.17, P.18	
H63TH-MGHR/L-DX4315 H63TH-MGHR/L-DX4333 H63TH-MGHR/L-DX4323  → P.21	

External Turning Tool Holders	
Order Number	Holder
H63TH-EV2525R/L-112 → P.28	
H100TH-EV3232R/L-180 NEW → P.28	
H63TH-EN2525R/L-115 NEW → P.29	
H100TH-EN3232R/L-130 NEW → P.29	
H63TH-EV2020R/L-105-3 → P.30	

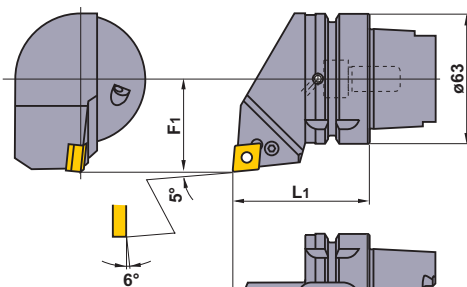
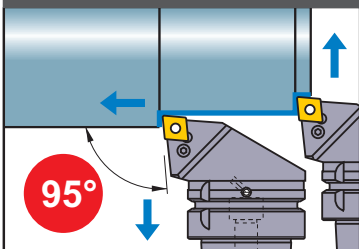
Threading	
Order Number	Geometry
H63TH-MMTER-DX16  → P.23	
H63TH-MMTENR-H/L16  → P.23	
H63TH-MTHR/L-DX43  → P.26	

Boring Bar Holders	
Order Number	Holder
H63TH-B○○○○○ → P.30	
H100TH-B○○○○○ NEW → P.31	
SL32○○-90 (Sleeve) NEW → P.31	

HSK TURNING TOOLS

PCLN

External turning • Facing



Right hand tool holder shown.

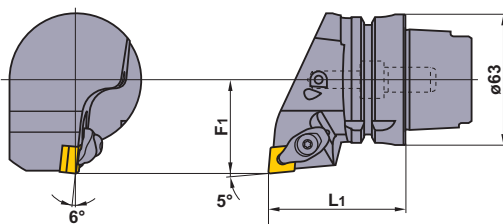
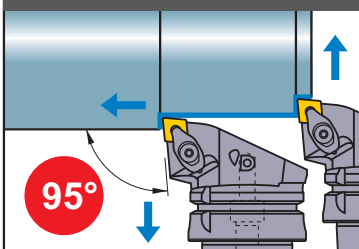
Finish	Light	Medium
FH (12)	SH (12)	MV (12)
Medium MH (12)	Medium Standard (12)	Medium – Semi-Heavy GH (12)
Stainless MS (12)	CBN (12)	

Order Number *1	Stock		Insert Number	Dimensions (mm)		Mass (kg)	Accessories											
	R	L		L1	F1		Shim	Shim Pin	Clamp Lever	Clamp Screw	Coolant Pipe	Wrench	Punch					
H63TH-PCLNR/L-DX12	●	●	CNM CNG NP-CNA	1204	65 45	1.3	LLSCN42	LLP14	LLCL14	LLCS108	HSK-CP18S	HKY30R	LLH4					

*1 Revised order number. For the conventional order number, refer to the corresponding list on page 32.

DCLN NEW

External turning • Facing **DOUBLE CLAMP type**



Right hand tool holder shown.

Finish	Light	Medium
FH (12)	SH (12)	MV (12)
Medium MH (12)	Medium Standard (12)	Medium – Semi-Heavy GH (12)
Stainless MS (12)	CBN (12)	

Order Number	Stock		Insert Number	Dimensions (mm)		Mass (kg)	Accessories											
	R	L		L1	F1		Shim	Shim Pin	Clamp Bridge	Spring	Clamp Screw	Coolant Pipe	Wrench	Punch				
H63TH-DCLNR/L-DX12	●	●	CNM CNG NP-CNA	1204	65 45	1.3	LLSCN42	LLP14	DCK2613	DCS1	DC0621T	HSK-CP18S	TKY20F	LLH4				

Recommended Cutting Conditions

Work Material	Hardness	Cutting Mode	Breaker	Grade	Cutting Speed (m/min)	
P Mild Steel	≤180HB	Finish Cutting	FY	NX3035	260–370	
		Light Cutting	SY	NX3035	235–335	
		Medium Cutting	MS	UE6110	260–440	
	Carbon Steel Alloy Steel	180HB–280HB	Finish Cutting	FH	NX3035	200–280
			Light Cutting	SH	UE6110	210–355
			Medium Cutting	MV	UE6110	190–325
M Stainless Steel	≤200HB	Finish Cutting	FS	NX2525	70–145	
		Light Cutting	SH	US735	95–185	
		Medium Cutting	MS	US735	85–165	
K Cast Iron	Tensile Strength ≤350MPa	Light Cutting	MA	UC5115	160–295	
		Medium Cutting	Standard	UC5115	160–295	
		Semi-Heavy Cutting	Flat Top	UC5115	155–280	

PCMN				External turning • Facing				Finish	Light	Medium			
								FH (12)	SH (12)	MV (12)			
								Medium MH (12)	Medium Standard (12)	Medium Medium-Semi-Heavy GH (12)			
								Stainless MS (12)	CBN (12)				
Order Number	Stock	Insert Number	Dimensions (mm)	Mass (kg)	Shim	Shim Pin	Clamp Lever	Clamp Screw	Plug	Coolant Pipe	Wrench	Punch	
H63TH-PCMNN-H12	●	CNM CNG NP-CNA	1204	100	1.7	LLSCN42	LLP14	LLCL14	LLCS108	HGM-PT1/8	HSK-CP18S	HKY30R	LLH4
-L12	●			140	2.7	LLSCN42	LLP14	LLCL14	LLCS108	HGM-PT1/8	HSK-CP18S	HKY30R	LLH4

*1 Revised order number. For the conventional order number, refer to the corresponding list on page 32.

DCMN NEW				External turning • Facing				DOUBLE CLAMP type				Finish	Light	Medium
												FH (12)	SH (12)	MV (12)
												Medium MH (12)	Medium Standard (12)	Medium Medium-Semi-Heavy GH (12)
												Stainless MS (12)	CBN (12)	
Order Number	Stock	Insert Number	Dimensions (mm)	Mass (kg)	Shim	Shim Pin	Clamp Bridge	Spring	Clamp Screw	Coolant Pipe	Wrench	Punch		
H63TH-DCMNN-H12	●	CNM CNG NP-CNA	1204	100	1.7	LLSCN42	LLP14	DCK2613	DCS1	DC0621T	HSK-CP18S	TKY20F	LLH4	
-L12	●			140	2.7	LLSCN42	LLP14	DCK2613	DCS1	DC0621T	HSK-CP18S	TKY20F	LLH4	

Recommended Cutting Conditions

Work Material	Hardness	Cutting Mode	Breaker	Grade	Cutting Speed (m/min)
P Mild Steel	≤180HB	Finish Cutting	FY	NX3035	260-370
		Light Cutting	SY	NX3035	235-335
		Medium Cutting	MS	UE6110	260-440
	180HB-280HB	Finish Cutting	FH	NX3035	200-280
		Light Cutting	SH	UE6110	210-355
		Medium Cutting	MV	UE6110	190-325
M Stainless Steel	≤200HB	Finish Cutting	FS	NX2525	70-145
		Light Cutting	SH	US735	95-185
		Medium Cutting	MS	US735	85-165
K Cast Iron	Tensile Strength ≤350MPa	Light Cutting	MA	UC5115	160-295
		Medium Cutting	Standard	UC5115	160-295
		Semi-Heavy Cutting	Flat Top	UC5115	155-280

HSK TURNING TOOLS

DCLN NEW External turning • Facing **DOUBLE CLAMP type**

Left hand tool holder only.

Order Number	Stock		Insert Number	Dimensions (mm)		Mass (kg)	Accessories											
	L	R		L1	F1		Shim	Shim Pin	Clamp Bridge	Spring	Clamp Screw	Coolant Pipe	Wrench	Punch				
H63TH-DCLNL-L12-3	●		CNM CNG NP-CN	1204	140 30	2.2	LLSCN42	LLP14	DCK2613	DCS1	DC0621T	HSK-CP18S	TKY20F	LLH4				

DCLN NEW External turning • Facing • Boring **DOUBLE CLAMP type**

Right hand tool holder shown.

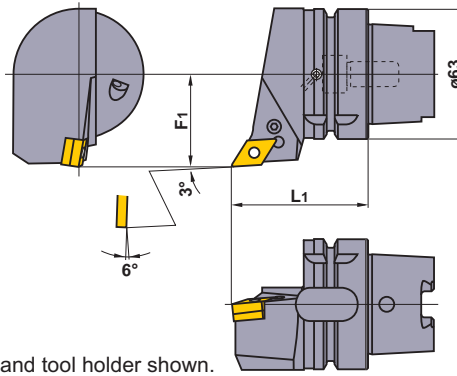
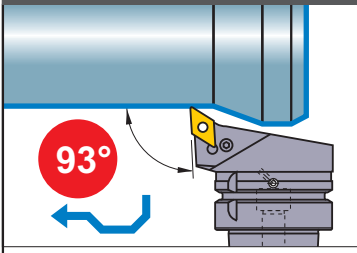
Order Number	Stock		Insert Number	Dimensions (mm)					Min. Cutting Diameter D1 (mm)	Mass (kg)	Accessories											
	R	L		L1	L2	L3	F1	RR°			Shim	Shim Pin	Clamp Bridge	Spring	Clamp Screw	Wrench	Punch					
H63TH-A25KDCLNR/L12	●	●	CNM CNG NP-CN	1204	125	82	84	17	11	32	1.1	LLSCP42	LLP14	DCK2613	DCS1	DC0621T	TKY20F	LLH4				
A32LDCLNR/L12	●	●	NP-CN	1204	140	100	102	22	13	40	1.4	LLSCN42	LLP14	DCK2613	DCS1	DC0621T	TKY20F	LLH4				

Recommended Cutting Conditions

Work Material	Hardness	Cutting Mode	Breaker	Grade	Cutting Speed (m/min)	
P Mild Steel	≤180HB	Finish Cutting	FY	NX3035	260–370	
		Light Cutting	SY	NX3035	235–335	
		Medium Cutting	MS	UE6110	260–440	
	180HB–280HB	Carbon Steel Alloy Steel	Finish Cutting	FH	NX3035	200–280
		Light Cutting	SH	UE6110	210–355	
		Medium Cutting	MV	UE6110	190–325	
M Stainless Steel	≤200HB	Finish Cutting	FS	NX2525	70–145	
		Light Cutting	SH	US735	95–185	
		Medium Cutting	MS	US735	85–165	
K Cast Iron	Tensile Strength ≤350MPa	Light Cutting	MA	UC5115	160–295	
		Medium Cutting	Standard	UC5115	160–295	
		Semi-Heavy Cutting	Flat Top	UC5115	155–280	

PDJN

External turning • Copying



Finish	Light	Medium
FH  (15)	SH  (15)	MV  (15)
Medium MH  (15)	Medium— Semi-Heavy GH  (15)	Stainless MS  (15)
G Class R/L  (15)	CBN  (15)	

Right hand tool holder shown.

Order Number	Stock		Insert Number	Dimensions (mm)		Mass (kg)	*2										
	R	L		L1	F1		Shim	Shim Pin	Clamp Lever	Clamp Screw	Coolant Pipe	Wrench	Punch				
H63TH-PDJNR/L-DX15	●	●	DNM DNG NP-DN	1504	65	45	1.2	LLSDN43 (LLSDN42)	LLP14	LLCL24	LLCS108	HSK-CP18S	HKY30R	LLH4			

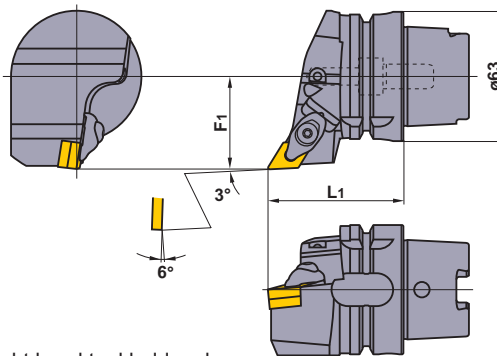
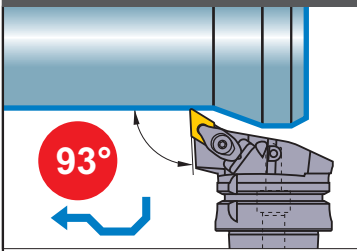
*1 Revised order number. For the conventional order number, refer to the corresponding list on page 32.



*2 Please use shim no. LLSDN42 with 6.35mm thick inserts. When using 6.35mm thick inserts, the shim should be ordered separately.

DDJN

NEW

External turning • DOUBLE CLAMP type Copying



Finish	Light	Medium
FH  (15)	SH  (15)	MV  (15)
Medium MH  (15)	Medium— Semi-Heavy GH  (15)	Stainless MS  (15)
G Class R/L  (15)	CBN  (15)	

Right hand tool holder shown.

Order Number	Stock		Insert Number	Dimensions (mm)		Mass (kg)	*										
	R	L		L1	F1		Shim	Shim Pin	Clamp Bridge	Spring	Clamp Screw	Coolant Pipe	Wrench	Punch			
H63TH-DDJNR/L-DX15	●	●	DNM DNG NP-DN	1504	65	45	1.2	LLSDN43 (LLSDN42)	LLP24	DCK2613	DCS1	DC0621T	HSK-CP18S	TKY20F	LLH4		

* Please use shim no. LLSDN42 with 6.35mm thick inserts. When using 6.35mm thick inserts, the shim should be ordered separately.

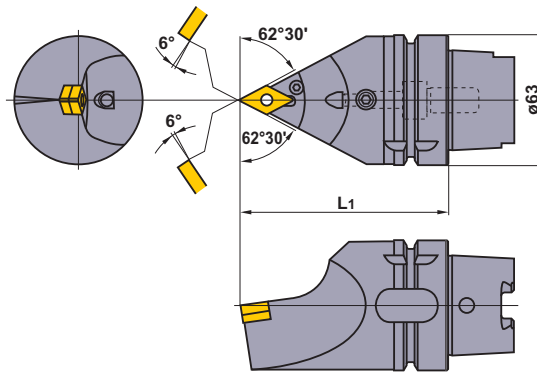
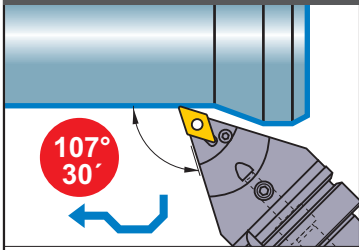
Recommended Cutting Conditions


	Work Material	Hardness	Cutting Mode	Breaker	Grade	Cutting Speed (m/min)
P	Mild Steel	≤180HB	Finish Cutting	FY	NX3035	260—370
			Light Cutting	SY	NX3035	235—335
			Medium Cutting	MS	UE6110	260—440
	Carbon Steel Alloy Steel	180HB—280HB	Finish Cutting	FH	NX3035	200—280
			Light Cutting	SH	UE6110	210—355
			Medium Cutting	MV	UE6110	190—325
M	Stainless Steel	≤200HB	Finish Cutting	FS	NX2525	70—145
			Light Cutting	SH	US735	95—185
			Medium Cutting	MS	US735	85—165
K	Cast Iron	Tensile Strength ≤350MPa	Light Cutting	MA	UC5115	160—295
			Medium Cutting	Standard	UC5115	160—295
			Semi-Heavy Cutting	Flat Top	UC5115	155—280

HSK TURNING TOOLS

PDNN

External turning • Copying



Finish	Light	Medium
FH  (15)	SH  (15)	MV  (15)
Medium MH  (15)	Medium – Semi-Heavy GH  (15)	Stainless MS  (15)
G Class R/L  (15)	CBN  (15)	

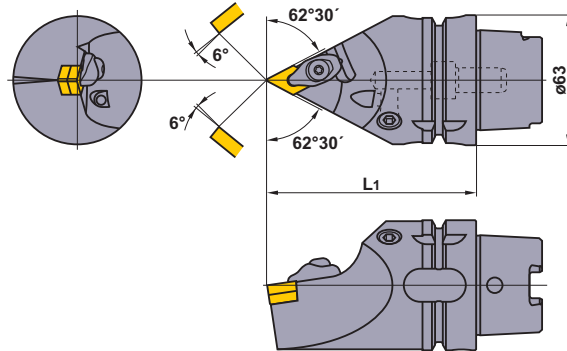
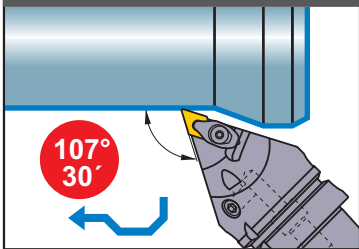
Order Number *1	Stock	Insert Number	Dimensions (mm) L1	Mass (kg)	*2							
					Shim	Shim Pin	Clamp Lever	Clamp Screw	Plug	Coolant Pipe	Wrench	Punch
H63TH-PDNNN-H15	●	DNM DNG NP-DN	100	1.6	LLSDN43 (LLSDN42)	LLP14	LLCL24	LLCS108	HGM-PT1/8	HSK-CP18S	HKY30R	LLH4
-L15	●	NP-DN	140	2.5	LLSDN43 (LLSDN42)	LLP14	LLCL24	LLCS108	HGM-PT1/8	HSK-CP18S	HKY30R	LLH4









*1 Revised order number. For the conventional order number, refer to the corresponding list on page 32.

*2 Please use shim no. LLSDN42 with 6.35mm thick inserts. When using 6.35mm thick inserts, the shim should be ordered separately.

DDNN NEW

External turning • DOUBLE CLAMP type Copying



Finish	Light	Medium
FH  (15)	SH  (15)	MV  (15)
Medium MH  (15)	Medium – Semi-Heavy GH  (15)	Stainless MS  (15)
G Class R/L  (15)	CBN  (15)	

Order Number	Stock	Insert Number	Dimensions (mm) L1	Mass (kg)	*							
					Shim	Shim Pin	Clamp Bridge	Spring	Clamp Screw	Coolant Pipe	Wrench	Punch
H63TH-DDNNN-H15	●	DNM DNG NP-DN	100	1.6	LLSDN43 (LLSDN42)	LLP24	DCK2613	DCS1	DC0621T	HSK-CP18S	TKY20F	LLH4
-L15	●	NP-DN	140	2.5	LLSDN43 (LLSDN42)	LLP24	DCK2613	DCS1	DC0621T	HSK-CP18S	TKY20F	LLH4

* Please use shim no. LLSDN42 with 6.35mm thick inserts. When using 6.35mm thick inserts, the shim should be ordered separately.







Recommended Cutting Conditions

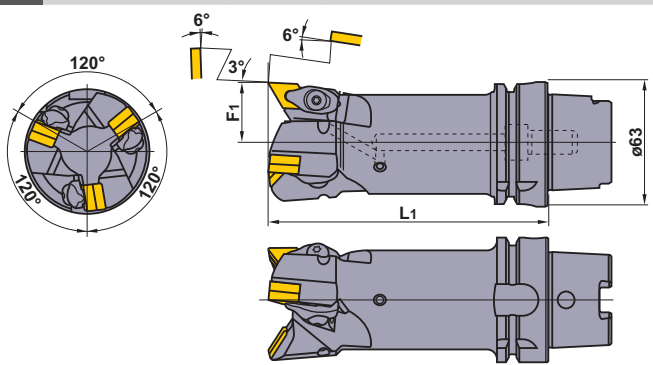
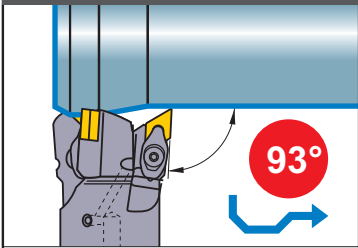
Work Material	Hardness	Cutting Mode	Breaker	Grade	Cutting Speed (m/min)	
P Mild Steel	≤180HB	Finish Cutting	FY	NX3035	260–370	
		Light Cutting	SY	NX3035	235–335	
		Medium Cutting	MS	UE6110	260–440	
	Carbon Steel Alloy Steel	180HB–280HB	Finish Cutting	FH	NX3035	200–280
			Light Cutting	SH	UE6110	210–355
			Medium Cutting	MV	UE6110	190–325
M Stainless Steel	≤200HB	Finish Cutting	FS	NX2525	70–145	
		Light Cutting	SH	US735	95–185	
		Medium Cutting	MS	US735	85–165	
K Cast Iron	Tensile Strength ≤350MPa	Light Cutting	MA	UC5115	160–295	
		Medium Cutting	Standard	UC5115	160–295	
		Semi-Heavy Cutting	Flat Top	UC5115	155–280	

DDJN NEW


External turning • Facing

DOUBLE CLAMP type

Finish	Light
FH  (15)	SH  (15)
Medium	Medium
MV  (15)	MH  (15)
Medium— Semi-Heavy	Stainless
GH  (15)	MS  (15)



Left hand tool holder only.

Order Number	Stock	Insert Number	Dimensions (mm)		Mass (kg)	* 										
	L		L1	F1		Shim	Shim Pin	Clamp Bridge	Spring	Clamp Screw	Coolant Pipe	Wrench	Punch			
H63TH-DDJNL-L15-3	●	DNM DNG NP-DNA	1504	140 30	2.2	LLSDN43 (LLSDN42)	LLP24	DCK2613	DCS1	DC0621T	HSK-CP18S	TKY20F	LLH4			

* Please use shim no. LLSDN42 with 6.35mm thick inserts. When using 6.35mm thick inserts, the shim should be ordered separately.

Recommended Cutting Conditions

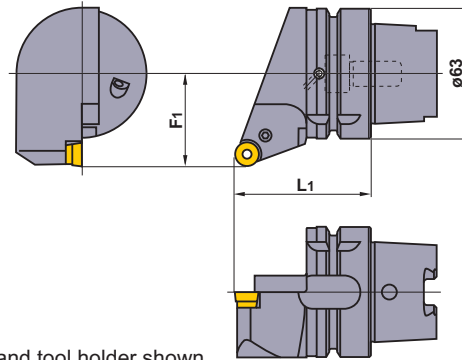
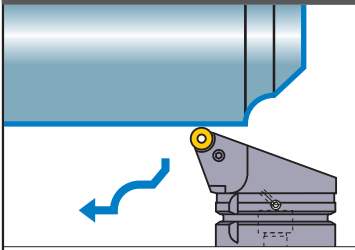
Work Material	Hardness	Cutting Mode	Breaker	Grade	Cutting Speed (m/min)	
P Mild Steel	≤180HB	Finish Cutting	FY	NX3035	260—370	
		Light Cutting	SY	NX3035	235—335	
		Medium Cutting	MS	UE6110	260—440	
	Carbon Steel Alloy Steel	180HB—280HB	Finish Cutting	FH	NX3035	200—280
			Light Cutting	SH	UE6110	210—355
			Medium Cutting	MV	UE6110	190—325
M Stainless Steel	≤200HB	Finish Cutting	FS	NX2525	70—145	
		Light Cutting	SH	US735	95—185	
		Medium Cutting	MS	US735	85—165	
K Cast Iron	Tensile Strength ≤350MPa	Light Cutting	MA	UC5115	160—295	
		Medium Cutting	Standard	UC5115	160—295	
		Semi-Heavy Cutting	Flat Top	UC5115	155—280	

HSK TURNING TOOLS

PRGC

External turning • Facing • Copying

Medium



Right hand tool holder shown.

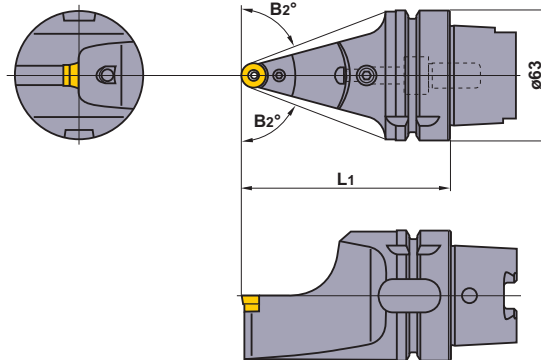
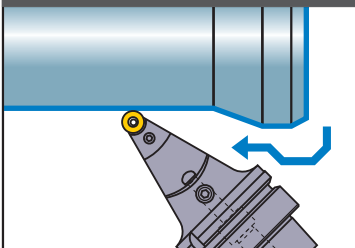
Order Number *1	Stock		Insert Number	Dimensions (mm)		Mass (kg)	Accessories										
	R	L		L1	F1		Shim	Shim Pin	Clamp Lever	Clamp Screw	Coolant Pipe	Wrench	Punch				
H63TH-PRGCR/L-DX12	●	●	RCMX	1204M0	65	45	1.2	LLSRN123	LLP13	LLCL112	LLCS106	HSK-CP18S	HKY25R	LLH3			

*1 Revised order number. For the conventional order number, refer to the corresponding list on page 32.

PRDC

External turning • Facing • Copying

Medium



Order Number *1	Stock		Insert Number	Dimensions (mm)		Mass (kg)	Accessories										
	R	L		L1	B2°		Shim	Shim Pin	Clamp Lever	Clamp Screw	Plug	Coolant Pipe	Wrench	Punch			
H63TH-PRDCN-H12	●	●	RCMX	1204M0	100	69	1.4	LLSRN123	LLP13	LLCL112	LLCS106	HGM-PT1/8	HSK-CP18S	HKY25R	LLH3		
-L12	●	●			140	75	2.3	LLSRN123	LLP13	LLCL112	LLCS106	HGM-PT1/8	HSK-CP18S	HKY25R	LLH3		

*1 Revised order number. For the conventional order number, refer to the corresponding list on page 32.

Recommended Cutting Conditions

	Work Material	Hardness	Cutting Mode	Breaker	Grade	Cutting Speed (m/min)
P	Mild Steel	≤180HB	Medium Cutting	Standard	UE6110	205–350
	Carbon Steel • Alloy Steel	180HB–280HB	Medium Cutting	Standard	UE6110	150–260
M	Stainless Steel	≤200HB	Medium Cutting	Standard	US735	70–130

Order Number		*1 Stock		Insert Number	Dimensions (mm)		Mass (kg)	Shim	Shim Pin	Clamp Screw	Coolant Pipe	Wrench
		R	L		L1	F1						
H63TH-SVPBR/L-DX16		●	●	VBMT VBGT	1604	65 45	1.1	SPSVN32	BCP141	TS35D	HSK-CP18S	TKY15F

*1 Revised order number. For the conventional order number, refer to the corresponding list on page 32.

Order Number		*1 Stock		Insert Number	Dimensions (mm)		Mass (kg)	Shim	Shim Pin	Clamp Screw	Plug	Coolant Pipe	Wrench
		R	L		L1	B2°							
H63TH-SVBN-H16		●	●	VBMT VBGT	1604	100 66°30'	1.3	SPSVN32	BCP141	TS35D	HGM-PT1/8	HSK-CP18S	TKY15F
-L16		●	●	VBMT VBGT	1604	140 72°30'	2.2	SPSVN32	BCP141	TS35D	HGM-PT1/8	HSK-CP18S	TKY15F

*1 Revised order number. For the conventional order number, refer to the corresponding list on page 32.

Recommended Cutting Conditions

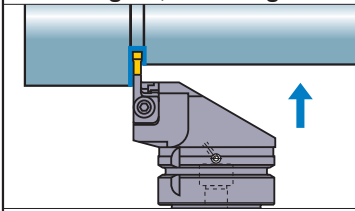
Work Material	Hardness	Cutting Mode	Breaker	Grade	Cutting Speed (m/min)
P Mild Steel	≤180HB	Finish Cutting	F	AP25N	250 (150–300)
		Medium Cutting	MV	UE6020	200 (150–250)
	180HB–280HB	Finish Cutting	F	AP25N	210 (150–260)
		Medium Cutting	MV	UE6020	170 (120–210)
M Stainless Steel	≤200HB	Medium Cutting	MV	US735	100 (70–120)
K Cast Iron	Tensile Strength ≤350MPa	Medium Cutting	MV	UE6020	170 (140–200)

HSK TURNING TOOLS

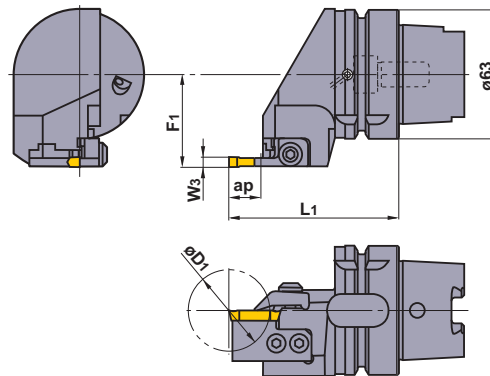
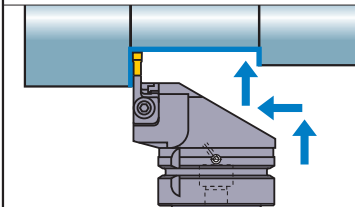
DG

Cutting off • Grooving • Copying

● Cutting off, Grooving



● Cutting off, Grooving, Copying



Right hand tool holder shown.

● Cutting off, Grooving

Pack Order Number	*1 *2 Stock		Component			Groove Width W ₃ (mm)	Max. Groove Depth ap (mm)	Max. Cut Off Diameter D ₁ (mm)	Dimensions (mm)		Mass (kg)	Insert Number	Insert Shape
	R	L	Holder Number	Locator	Clamp Bridge				L ₁	F ₁			
H63TH-C5207R/L	●	●	H63TH-DGHR/L	EB2R/L	DGK2R/L	2	16	40	82.4	45	1.3	DGM20CE	DGM...CE
-C5307R/L	●	●	H63TH-DGHR/L	EB3R/L	DGK3R/L	3	16	40	82.4	45	1.3	DGM30CE DGJ30CE	
-C5407R/L	●	●	H63TH-DGHR/L	EB4R/L	DGK4R/L	4	16	40	82.4	45	1.3	DGJ40CE	DGJ...CE
-C5507R/L	●	●	H63TH-DGHR/L	EB5R/L	DGK5R/L	5	16	40	82.4	45	1.3	DGJ50CE	DGJ...CE
-C5607R/L	●	●	H63TH-DGHR/L	EB6R/L	DGK6R/L	6	16	40	82.4	45	1.3	DGJ60CE	
-C5707R/L	●	●	H63TH-DGHR/L	EB7R/L	DGK7R/L	7	16	40	82.4	45	1.3	DGJ70CE	DGJ...CE
-C5807R/L	●	●	H63TH-DGHR/L	EB8R/L	DGK8R/L	8	16	40	82.4	45	1.3	DGJ80CE	DGJ...CE

● Cutting off, Grooving, Copying

Pack Order Number	*1 *2 Stock		Component			Groove Width W ₃ (mm)	Max. Groove Depth ap (mm)	Max. Cut Off Diameter D ₁ (mm)	Dimensions (mm)		Mass (kg)	Insert Number	Insert Shape
	R	L	Holder Number	Locator	Clamp Bridge				L ₁	F ₁			
H63TH-D5307R/L	●	●	H63TH-DGHR/LS	EB3R/LS	DGK3R/L	3	11	30	77.4	45	1.3	DGM30CT	DGM...CT
-D5407R/L	●	●	H63TH-DGHR/LS	EB4R/LS	DGK4R/L	4	11	30	77.4	45	1.3	DGM40CT	
-D5408R/L	●	●	H63TH-DGHR/LS	EB4R/LX	DGK4R/L	4	11	30	77.4	45	1.3	DGM40CTB	DGM...CTB
*3 -C5507R/L	●	●	H63TH-DGHR/L	EB5R/L	DGK5R/L	5	16	40	82.4	45	1.3	DGM50CT DGJ50CT1	DGJ...CT1
-C5508R/L	●	●	H63TH-DGHR/L	EB5R/LX	DGK5R/L	5	16	40	82.4	45	1.3	DGM50CTB DGM50CTD DGM50CTRL	DGM...CTD DGM...CTRL
-C5608R/L	●	●	H63TH-DGHR/L	EB6R/LX	DGK6R/L	6	16	40	82.4	45	1.3	DGM60CTB	

*1 Revised order number. For the conventional order number, refer to the corresponding list on page 32.

*2 The order pack number includes a holder, locators and clamp screws. (Refer to the list below.) To order the parts separately, please refer to their description.

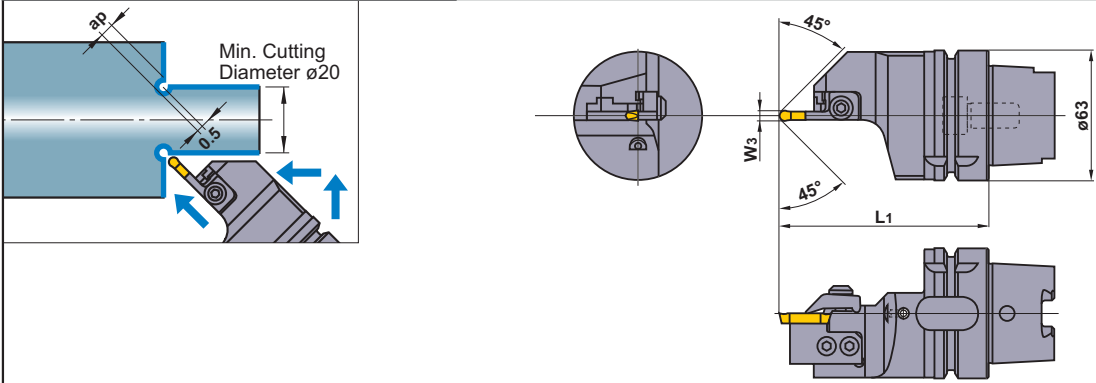
*3 Compatible with standard type holder for cutting off and grooving.

Spare Parts

Holder Number	*1					
		Locator Screw	Clamp Screw	Spring	Coolant Pipe	Wrench
H63TH-DGHR/LS H63TH-DGHR/L		HSC05012	DGS51	MES2	HSK-CP18S	HKY40R

*1 Revised order number. For the conventional order number, refer to the corresponding list on page 32.

● : Inventory maintained.



*1 *2 Pack Order Number	Stock	Component			Groove Width W3 (mm)	Max. Groove Depth ap (mm)	Dimensions (mm) L1	Mass (kg)	Insert Number	Insert Shape
		Holder Number *1	Locator	Clamp Bridge						
H63TH-G5408NH	●	H63TH-DGHN-H4	EB4RX	DGK4R	4	2.5	100	1.4	DGM40CTB	
-G5508NH	●	H63TH-DGHN-H5	EB5RX	DGK5R	5	3	100	1.3	DGM50CTB	
-G5608NH	●	H63TH-DGHN-H6	EB6RX	DGK6R	6	3.5	100	1.3	DGM60CTB	
-G5408NL	●	H63TH-DGHN-L4	EB4RX	DGK4R	4	2.5	140	2.3	DGM40CTB	
-G5508NL	●	H63TH-DGHN-L5	EB5RX	DGK5R	5	3	140	2.3	DGM50CTB	
-G5608NL	●	H63TH-DGHN-L6	EB6RX	DGK6R	6	3.5	140	2.3	DGM60CTB	

*1 Revised order number. For the conventional order number, refer to the corresponding list on page 32.
 *2 The order pack number includes a holder, locators and clamp screws. (Refer to the list below.) To order the parts separately, please refer to their description.

Spare Parts

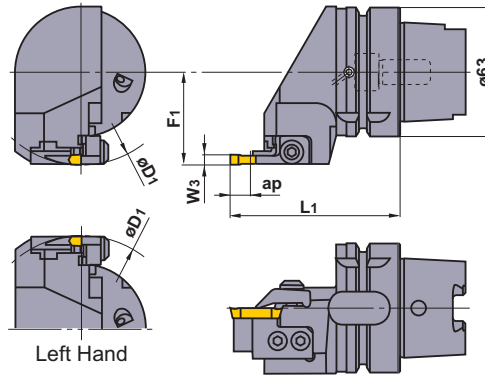
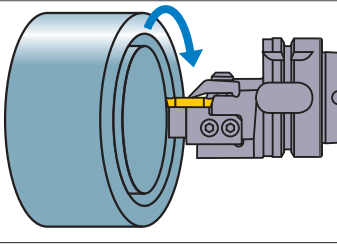
*1 Holder Number						
	Locator Screw	Clamp Screw	Spring	Plug	Coolant Pipe	Wrench
H63TH-DGHN-H4	HSC05010	DGS51	MES2	—	HSK-CP18S	HKY40R
H63TH-DGHN-H5	HSC05012					
H63TH-DGHN-H6	HSC05010					
H63TH-DGHN-L4	HSC05010			HGM-PT1/8		
H63TH-DGHN-L5	HSC05012					
H63TH-DGHN-L6	HSC05012					

*1 Revised order number. For the conventional order number, refer to the corresponding list on page 32.

HSK TURNING TOOLS

DG

Face grooving



Right hand tool holder shown.

Pack Order Number	*1 *2 Stock		Component			Groove Width W3 (mm)	Max. Groove Depth ap (mm)	Range of Cutting Diameter D1 (mm)	Dimensions (mm)		Mass (kg)	Insert Number	Insert Shape
	R	L	*1 Holder Number	Locator	Clamp Bridge				L1	F1			
H63TH-M5300R/L	●	●	H63TH-DGHR/L	FB3R/L0	DGK5R/L	3	6	20-50	82.4	44	1.3	DGJ30CFS	DGJ...CFS DGJ...CF
-M5302R/L	●	●	H63TH-DGHR/L	FB3R/L2	DGK5R/L	3	6	40-100	82.4	44	1.3	DGJ30CF	
-M5304R/L	●	●	H63TH-DGHR/L	FB3R/L4	DGK5R/L	3	6	100-250	82.4	44	1.3	DGJ30CF	
-M5400R/L	●	●	H63TH-DGHR/L	FB4R/L0	DGK5R/L	4	6	20-50	82.4	44.5	1.3	DGJ40CFS	
-M5402R/L	●	●	H63TH-DGHR/L	FB4R/L2	DGK5R/L	4	6	40-100	82.4	44.5	1.3	DGJ40CF	
-M5404R/L	●	●	H63TH-DGHR/L	FB4R/L4	DGK5R/L	4	6	100-250	82.4	44.5	1.3	DGJ40CF	
*3 -M5502R/L	●	●	H63TH-DGHR/L	FB5R/L2	DGK5R/L	5	10	50-100	82.4	45	1.3	DGJ50CF	DGJ...CF
*3 -M5504R/L	●	●	H63TH-DGHR/L	FB5R/L4	DGK5R/L	5	10	100-∞	82.4	45	1.3	DGJ50CF	
*3 -M6502R/L	●	●	H63TH-DGHR/L	FB5R/L2D	DGK5R/L	5	16	50-100	82.4	45	1.3	DGJ50CF	
*3 -M6504R/L	●	●	H63TH-DGHR/L	FB5R/L4D	DGK5R/L	5	16	100-∞	82.4	45	1.3	DGJ50CF	
*3 -M5602R/L	●	●	H63TH-DGHR/L	FB6R/L2	DGK6R/L	6	10	50-100	82.4	45	1.3	DGJ60CF	
*3 -M5604R/L	●	●	H63TH-DGHR/L	FB6R/L4	DGK6R/L	6	10	100-∞	82.4	45	1.3	DGJ60CF	
*3 -M6602R/L	●	●	H63TH-DGHR/L	FB6R/L2D	DGK6R/L	6	16	50-100	82.4	45	1.3	DGJ60CF	
*3 -M6604R/L	●	●	H63TH-DGHR/L	FB6R/L4D	DGK6R/L	6	16	100-∞	82.4	45	1.3	DGJ60CF	
-M5702R/L	●	●	H63TH-DGHR/L	FB7R/L2	DGK7R/L	7	10	50-100	82.4	45	1.3	DGJ70CF	
-M5704R/L	●	●	H63TH-DGHR/L	FB7R/L4	DGK7R/L	7	10	100-∞	82.4	45	1.3	DGJ70CF	
-M6702R/L	●	●	H63TH-DGHR/L	FB7R/L2D	DGK7R/L	7	16	50-100	82.4	45	1.3	DGJ70CF	
-M6704R/L	●	●	H63TH-DGHR/L	FB7R/L4D	DGK7R/L	7	16	100-∞	82.4	45	1.3	DGJ70CF	
-M5802R/L	●	●	H63TH-DGHR/L	FB8R/L2	DGK8R/L	8	10	50-100	82.4	45	1.3	DGJ80CF	
-M5804R/L	●	●	H63TH-DGHR/L	FB8R/L4	DGK8R/L	8	10	100-∞	82.4	45	1.3	DGJ80CF	
-M6802R/L	●	●	H63TH-DGHR/L	FB8R/L2D	DGK8R/L	8	16	50-100	82.4	45	1.3	DGJ80CF	
-M6804R/L	●	●	H63TH-DGHR/L	FB8R/L4D	DGK8R/L	8	16	100-∞	82.4	45	1.3	DGJ80CF	

*1 Revised order number. For the conventional order number, refer to the corresponding list on page 33.

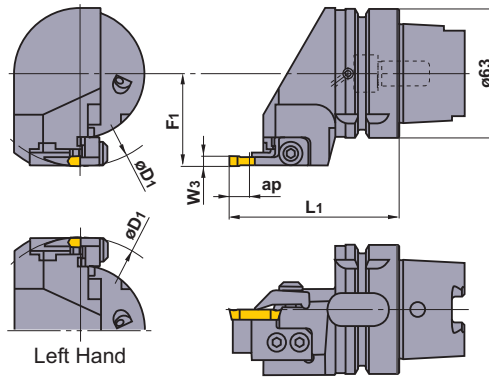
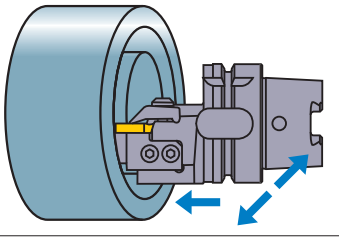
*2 The order pack number includes a holder, locators and clamp screws. (Refer to the list below.) To order the parts separately, please refer to their description.

*3 Compatible with standard type holder for face grooving and copying.

Spare Parts

*1 Holder Number					
	Locator Screw	Clamp Screw	Spring	Coolant Pipe	Wrench
H63TH-DGHR/L	HSC05012	DGS51	MES2	HSK-CP18S	HKY40R

*1 Revised order number. For the conventional order number, refer to the corresponding list on page 33.



Pack Order Number	*1 *2 Stock		Component			Groove Width W ₃ (mm)	Max. Groove Depth ap (mm)	Range of Cutting Diameter D ₁ (mm)	Dimensions (mm)		Mass (kg)	Insert Number	Insert Shape
	R	L	*1 Holder Number	Locator	Clamp Bridge				L ₁	F ₁			
H63TH-P5302R/L	●	●	H63TH-DGHR/LS	FB3R/L2S	DGK3R/L	3	6	40—100	77.4	45	1.3	DGM30CTF	
-P5304R/L	●	●	H63TH-DGHR/LS	FB3R/L4S	DGK3R/L	3	6	100—250	77.4	45	1.3	DGM30CTF	
-P5402R/L	●	●	H63TH-DGHR/LS	FB4R/L2S	DGK4R/L	4	6	40—100	77.4	45	1.3	DGM40CTF	
-P5404R/L	●	●	H63TH-DGHR/LS	FB4R/L4S	DGK4R/L	4	6	100—250	77.4	45	1.3	DGM40CTF	
*3 -M5502R/L	●	●	H63TH-DGHR/L	FB5R/L2	DGK5R/L	5	10	50—100	82.4	45	1.3	DGM50CTF	
*3 -M5504R/L	●	●	H63TH-DGHR/L	FB5R/L4	DGK5R/L	5	10	100—∞	82.4	45	1.3	DGM50CTF	
*3 -M6502R/L	●	●	H63TH-DGHR/L	FB5R/L2D	DGK5R/L	5	16	50—100	82.4	45	1.3	DGM50CTF	
*3 -M6504R/L	●	●	H63TH-DGHR/L	FB5R/L4D	DGK5R/L	5	16	100—∞	82.4	45	1.3	DGM50CTF	
*3 -M5602R/L	●	●	H63TH-DGHR/L	FB6R/L2	DGK6R/L	6	10	50—100	82.4	45	1.3	DGM60CTF	
*3 -M5604R/L	●	●	H63TH-DGHR/L	FB6R/L4	DGK6R/L	6	10	100—∞	82.4	45	1.3	DGM60CTF	
*3 -M6602R/L	●	●	H63TH-DGHR/L	FB6R/L2D	DGK6R/L	6	16	50—100	82.4	45	1.3	DGM60CTF	
*3 -M6604R/L	●	●	H63TH-DGHR/L	FB6R/L4D	DGK6R/L	6	16	100—∞	82.4	45	1.3	DGM60CTF	

*1 Revised order number. For the conventional order number, refer to the corresponding list on page 33.

*2 The order pack number includes a holder, locators and clamp screws. (Refer to the list below.) To order the parts separately, please refer to their description.

*3 Compatible with standard type holder for face grooving.

Spare Parts

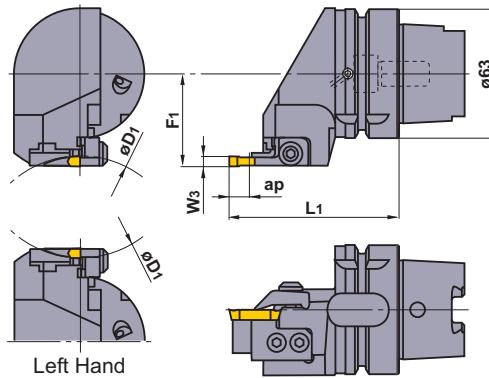
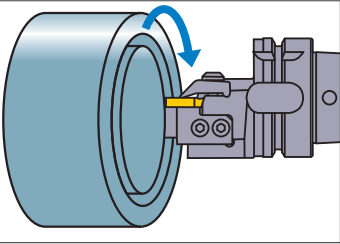
*1 Holder Number					
	Locator Screw	Clamp Screw	Spring	Coolant Pipe	Wrench
H63TH-DGHR/LS	HSC05012	DGS51	MES2	HSK-CP18S	HKY40R
H63TH-DGHR/L					

*1 Revised order number. For the conventional order number, refer to the corresponding list on page 33.

HSK TURNING TOOLS

DG

Facing • Grooving



Right hand tool holder shown.

Pack Order Number	*1 *2 Stock		Component			Groove Width W ₃ (mm)	Max. Groove Depth ap (mm)	Range of Cutting Diameter D ₁ (mm)	Dimensions (mm)		Mass (kg)	Insert Number	Insert Shape
	R	L	*1 Holder Number	Locator	Clamp Bridge				L ₁	F ₁			
H63TH-N5300R/L	●	●	H63TH-DGHR/L	FD3R/L0	DGK5R/L	3	6	20–50	82.4	44	1.3	DGJ30CFS	DGJ...CFS DGJ...CF
-N5302R/L	●	●	H63TH-DGHR/L	FD3R/L2	DGK5R/L	3	6	40–100	82.4	44	1.3	DGJ30CF	
-N5304R/L	●	●	H63TH-DGHR/L	FD3R/L4	DGK5R/L	3	6	100–250	82.4	44	1.3	DGJ30CF	
-N5400R/L	●	●	H63TH-DGHR/L	FD4R/L0	DGK5R/L	4	6	20–50	82.4	44.5	1.3	DGJ40CFS	
-N5402R/L	●	●	H63TH-DGHR/L	FD4R/L2	DGK5R/L	4	6	40–100	82.4	44.5	1.3	DGJ40CF	
-N5404R/L	●	●	H63TH-DGHR/L	FD4R/L4	DGK5R/L	4	6	100–250	82.4	44.5	1.3	DGJ40CF	
*3 -N5502R/L	●	●	H63TH-DGHR/L	FD5R/L2	DGK5R/L	5	10	50–100	82.4	45	1.3	DGJ50CF	DGJ...CF
*3 -N5504R/L	●	●	H63TH-DGHR/L	FD5R/L4	DGK5R/L	5	10	100–∞	82.4	45	1.3	DGJ50CF	
*3 -N6502R/L	●	●	H63TH-DGHR/L	FD5R/L2D	DGK5R/L	5	16	50–100	82.4	45	1.3	DGJ50CF	
*3 -N6504R/L	●	●	H63TH-DGHR/L	FD5R/L4D	DGK5R/L	5	16	100–∞	82.4	45	1.3	DGJ50CF	
*3 -N5602R/L	●	●	H63TH-DGHR/L	FD6R/L2	DGK6R/L	6	10	50–100	82.4	45	1.3	DGJ60CF	
*3 -N5604R/L	●	●	H63TH-DGHR/L	FD6R/L4	DGK6R/L	6	10	100–∞	82.4	45	1.3	DGJ60CF	
*3 -N6602R/L	●	●	H63TH-DGHR/L	FD6R/L2D	DGK6R/L	6	16	50–100	82.4	45	1.3	DGJ60CF	
*3 -N6604R/L	●	●	H63TH-DGHR/L	FD6R/L4D	DGK6R/L	6	16	100–∞	82.4	45	1.3	DGJ60CF	
-N5702R/L	●	●	H63TH-DGHR/L	FD7R/L2	DGK7R/L	7	10	50–100	82.4	45	1.3	DGJ70CF	
-N5704R/L	●	●	H63TH-DGHR/L	FD7R/L4	DGK7R/L	7	10	100–∞	82.4	45	1.3	DGJ70CF	
-N6702R/L	●	●	H63TH-DGHR/L	FD7R/L2D	DGK7R/L	7	16	50–100	82.4	45	1.3	DGJ70CF	
-N6704R/L	●	●	H63TH-DGHR/L	FD7R/L4D	DGK7R/L	7	16	100–∞	82.4	45	1.3	DGJ70CF	
-N5802R/L	●	●	H63TH-DGHR/L	FD8R/L2	DGK8R/L	8	10	50–100	82.4	45	1.3	DGJ80CF	
-N5804R/L	●	●	H63TH-DGHR/L	FD8R/L4	DGK8R/L	8	10	100–∞	82.4	45	1.3	DGJ80CF	
-N6802R/L	●	●	H63TH-DGHR/L	FD8R/L2D	DGK8R/L	8	16	50–100	82.4	45	1.3	DGJ80CF	
-N6804R/L	●	●	H63TH-DGHR/L	FD8R/L4D	DGK8R/L	8	16	100–∞	82.4	45	1.3	DGJ80CF	

*1 Revised order number. For the conventional order number, refer to the corresponding list on page 34.

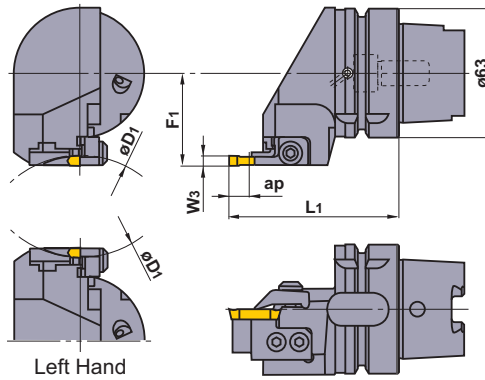
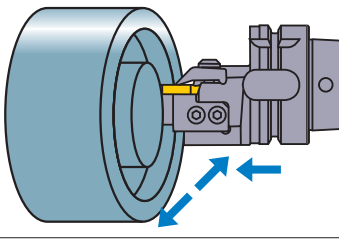
*2 The order pack number includes a holder, locators and clamp screws. (Refer to the list below.) To order the parts separately, please refer to their description.

*3 Compatible with standard type holder for face grooving and copying.

Spare Parts

*1 Holder Number					
	Locator Screw	Clamp Screw	Spring	Coolant Pipe	Wrench
H63TH-DGHR/L	HSC05012	DGS51	MES2	HSK-CP18S	HKY40R

*1 Revised order number. For the conventional order number, refer to the corresponding list on page 34.



Left Hand

Right hand tool holder shown.

Pack Order Number	*1 *2 Stock		Component			Groove Width W3 (mm)	Max. Groove Depth ap (mm)	Range of Cutting Diameter D1 (mm)	Dimensions (mm)		Mass (kg)	Insert Number	Insert Shape
	R	L	*1 Holder Number	Locator	Clamp Bridge				L1	F1			
H63TH-Q5302R/L	●	●	H63TH-DGHR/LS	FD3R/L2S	DGK3R/L	3	6	40—100	77.4	45	1.3	DGM30CTF	
-Q5304R/L	●	●	H63TH-DGHR/LS	FD3R/L4S	DGK3R/L	3	6	100—250	77.4	45	1.3	DGM30CTF	
-Q5402R/L	●	●	H63TH-DGHR/LS	FD4R/L2S	DGK4R/L	4	6	40—100	77.4	45	1.3	DGM40CTF	
-Q5404R/L	●	●	H63TH-DGHR/LS	FD4R/L4S	DGK4R/L	4	6	100—250	77.4	45	1.3	DGM40CTF	
*3 -N5502R/L	●	●	H63TH-DGHR/L	FD5R/L2	DGK5R/L	5	10	50—100	82.4	45	1.3	DGM50CTF	
*3 -N5504R/L	●	●	H63TH-DGHR/L	FD5R/L4	DGK5R/L	5	10	100—∞	82.4	45	1.3	DGM50CTF	
*3 -N6502R/L	●	●	H63TH-DGHR/L	FD5R/L2D	DGK5R/L	5	16	50—100	82.4	45	1.3	DGM50CTF	
*3 -N6504R/L	●	●	H63TH-DGHR/L	FD5R/L4D	DGK5R/L	5	16	100—∞	82.4	45	1.3	DGM50CTF	
*3 -N5602R/L	●	●	H63TH-DGHR/L	FD6R/L2	DGK6R/L	6	10	50—100	82.4	45	1.3	DGM60CTF	
*3 -N5604R/L	●	●	H63TH-DGHR/L	FD6R/L4	DGK6R/L	6	10	100—∞	82.4	45	1.3	DGM60CTF	
*3 -N6602R/L	●	●	H63TH-DGHR/L	FD6R/L2D	DGK6R/L	6	16	50—100	82.4	45	1.3	DGM60CTF	
*3 -N6604R/L	●	●	H63TH-DGHR/L	FD6R/L4D	DGK5R/L	6	16	100—∞	82.4	45	1.3	DGM60CTF	

*1 Revised order number. For the conventional order number, refer to the corresponding list on page 34.

*2 The order pack number includes a holder, locators and clamp screws. (Refer to the list below.) To order the parts separately, please refer to their description.

*3 Compatible with standard type holder for face grooving.

Spare Parts

*1 Holder Number					
	Locator Screw	Clamp Screw	Spring	Coolant Pipe	Wrench
H63TH-DGHR/LS	HSC05012	DGS51	MES2	HSK-CP18S	HKY40R
H63TH-DGHR/L					

*1 Revised order number. For the conventional order number, refer to the corresponding list on page 34.

HSK TURNING TOOLS

Inserts for DG Type

Application	Geometry	Order Number	Stock						Dimensions (mm)											
			Coated			Cermet		Carbide	CBN		W3		L1	S1	Re, R	B4	B6			
			UE6020	US735	VP20MF	UP20M	NX2525	NX55	UT120T	MB820	MB825	Groove Width						Tolerance		
External Grooving	Cutting Off, Grooving CE Type 	DGM...CE (M class)	DGM20CE			●	□	●	▲	●				2	±0.05	25	3	0.2	7°	2°30'
		30CE			●	□	●	▲	●					3	±0.05	25	5	0.2	7°	2°30'
		DGJ...CE (G class)	DGJ30CE			●	□	●	▲	●				3	±0.05	25	5	0.2	2°	2°
		40CE			●	□	●	▲	●					4	±0.05	25	6	0.2	2°	2°
		50CE			●	□	●	▲	●					5	±0.05	25	6	0.2	2°	2°
		60CE			●	□	●	▲	●					6	±0.05	25	6	0.2	2°	2°
	DGJ...CE (G class)	DGJ40CE								●	●		4	±0.05	25	6	0.2	2°	2°	
	50CE									●	●		5	±0.05	25	6	0.2	2°	2°	
	60CE									●	●		6	±0.05	25	6	0.2	2°	2°	
	DGM...CT (M class)	DGM30CT	●	●	●			●	▲				3	±0.05	20	5	0.4	3°	1°30'	
	40CT	●	●	●				●	▲				4	±0.05	20	5	0.4	5°	2°	
	50CT	●	●	●				●	▲				5	±0.05	25	6	0.4	5°	2°	
	DGJ...CT1 (G class)	DGJ50CT1			●	●				●			5	±0.05	25	6	0.2	2°	2°	
	DGM...CTB (M class)	DGM40CTB	●	●									4	±0.05	20	5	2	5°	7°	
	50CTB	●	●										5	±0.05	25	6	2.5	6°	10°	
	60CTB	●	●										6	±0.05	25	6	3	9°	10°	
	DGM...CTD (M class)	DGM50CTD04	●	●									5	±0.05	25	6	0.4	6°	—	
	50CTD08	●	●										5	±0.05	25	6	0.8	6°	—	
DGM...CTR/L... (M class)	DGM50CTR04	●	●									5	±0.05	25	6	0.4	5°	3°		
50CTL04	●	●										5	±0.05	25	6	0.4	5°	3°		

Application	Geometry	Order Number	Stock						Dimensions (mm)						Face Grooving Diameter		
			Coated			Cermat		Carbide	W3		L1	S1	Re	B4		B6	
			UE6020	US735	VP20MF	UP20M	NX2525		NX55	UTI20T							Groove Width
Face Grooving	Grooving CF Type DGJ...CFS/CF (G class) 	DGJ30CFS			●		●	▲	●	3	±0.05	25	3	0.2	15°	2°	ø20-ø50
		30CF			●		●	▲	●	3	±0.05	25	5	0.2	10°	2°	ø40-
		40CFS			●		●	▲	●	4	±0.05	25	3	0.2	15°	2°	ø20-ø50
		40CF			●		●	▲	●	4	±0.05	25	5	0.2	10°	2°	ø40-
	Grooving CF Type DGJ...CF (G class) 	DGJ50CF			●	□	●	▲	●	5	±0.05	25	5	0.2	10°	2°	ø50-
		60CF			●	□	●	▲	●	6	±0.05	25	5	0.2	10°	2°	ø50-
		70CF			●	□	●	▲	●	7	±0.05	25	6	0.2	10°	2°	ø50-
		80CF			●	□	●	▲	●	8	±0.05	25	6	0.2	10°	2°	ø50-
	Grooving, Copying CTF Type DGM...CTF (M class) 	DGM30CTF	●	●						3	±0.05	20	3	0.4	10°	2°	ø40-
		40CTF	●	●						4	±0.05	20	3	0.4	10°	2°	ø50-
		50CTF	●	●						5	±0.05	25	5	0.4	9°	2°	ø40-
		60CTF	●	●						6	±0.05	25	5	0.4	9°	2°	ø50-
Blank Type DG...BE 	* DG35BE						▲	●	3.5	±0.1	25.55	5	0.2	0°	0°	-	
	* 45BE						▲	●	4.5	±0.1	25.55	6	0.2	0°	0°	-	
	* 55BE						▲	●	5.5	±0.1	25.55	6	0.2	0°	0°	-	
	* 65BE						▲	●	6.5	±0.1	25.55	6	0.2	0°	0°	-	
	* 75BE						▲	●	7.5	±0.1	25.55	8	0.2	0°	0°	-	
	* 85BE						▲	●	8.5	±0.1	25.55	8	0.2	0°	0°	-	

* Blank inserts to be ground by customers. Please take care with relief angle grinding.

Recommended Cutting Conditions (For Cutting off · Grooving)

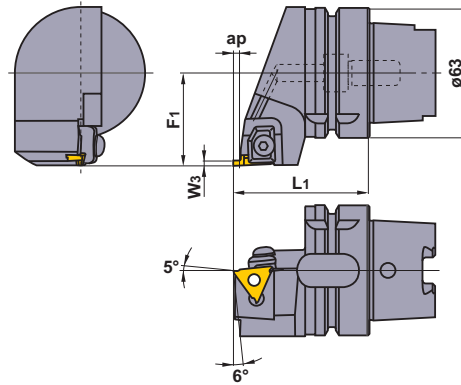
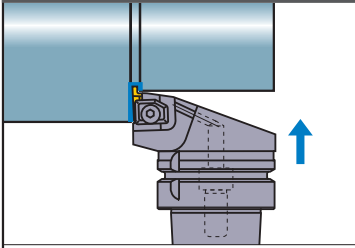
Work Material	Hardness	Grade		Cutting Speed (m/min)	Max. Feed (mm/rev)			
		Continuous	Interrupted		Groove Width W3 (mm)			
					2	3, 4	5, 6	7, 8
P General Steel	≤150HB	NX2525	VP20MF	160 (120-200)	0.1	0.2	0.25	0.3
	150-250HB	UE6020	VP20MF	120 (100-150)	0.1	0.15	0.2	0.25
	≥250HB	UE6020	VP20MF	120 (100-150)	0.08	0.15	0.15	0.2
	≥50HRC	MB820	MB820	100 (80-120)	-	0.06	0.1	-
M Stainless Steel	-	US735	VP20MF	120 (100-140)	0.1	0.15	0.2	0.2
K Cast Iron	-	UE6020	VP20MF	120 (100-140)	0.1	0.2	0.25	0.3

(Note) When face grooving, it is suggested to apply coolant and reduce the feed rate by 15-20%.

HSK TURNING TOOLS

MG

Grooving



Right hand tool holder shown.

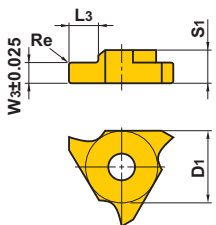
*1 Order Number	Stock		Insert Number	Groove Width W₃ (mm)	Max. Groove Depth ap (mm)	Dimensions (mm)		Mass (kg)					
	R	L				L1	F1						
H63TH-MGHR/L-DX4315	●	●	MGTR/L 43125 43470	1.25	1.2								
				1.45	1.5								
				1.5 ≤ W ₃ ≤ 2.3	3	65	45	1.2	MTK1R/L	HBH06020	MES3	HSK-CP18S	HKY40R
				2.3 < W ₃ ≤ 3.3	4.5								
-DX4323	●	●		2.3 < W ₃ ≤ 3.3	4.5								
-DX4333	●	●		3.3 < W ₃ ≤ 4.7	4.5								

*1 Revised order number. For the conventional order number, refer to the corresponding list on the last page.

Recommended Cutting Conditions

	Work Material	Hardness	Grade	Cutting Speed (m/min)	Feed (mm/rev)
P	Carbon Steel Alloy Steel	180–280HB	VP20MF	120 (100–140)	0.10 (0.03–0.18)
			NX2525	130 (100–160)	0.12 (0.03–0.2)
M	Stainless Steel	≤200HB	VP20MF	120 (100–140)	0.10 (0.03–0.18)
K	Cast Iron	Tensile Strength ≤350MPa	VP20MF	120 (100–140)	0.10 (0.03–0.18)

Inserts for MG Type

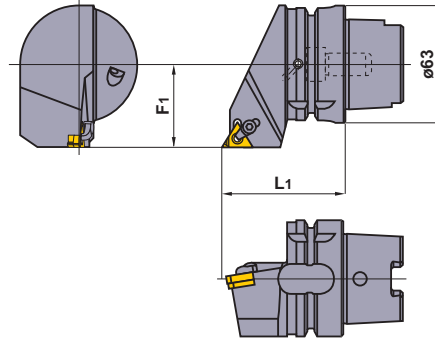
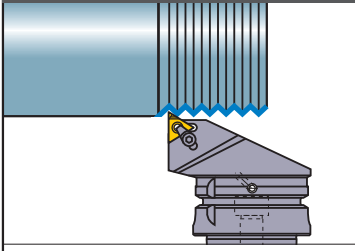
Order Number	Stock								Groove Width W ₃ (mm)	Dimensions (mm)				Geometry
	Coated		Cermet				Carbide			L ₃	D ₁	S ₁	Re	
	VP20MF		NX2525		NX55		UT120T							
	R	L	R	L	R	L	R	L						
MGTR/L43125	●	●	●	□	▲		●	●	1.25	1.2	12.7	4.76	0.2	MGTR/L... 
43145	●	□	□	□	▲		●	□	1.45	1.5	12.7	4.76	0.2	
43150	●	●	●	●	▲	▲	●	●	1.5	3	12.7	4.76	0.2	
43175	●	●	●	□	▲		●	●	1.75	3	12.7	4.76	0.2	
43200	●	●	●	●	▲	▲	●	●	2	3	12.7	4.76	0.2	
43230	●	●	●	●	▲	▲	●	●	2.3	3	12.7	4.76	0.2	
43250	●	●	●	●	▲	▲	●	●	2.5	4.5	12.7	4.76	0.3	
43260	●	□	□				●	●	2.6	4.5	12.7	4.76	0.3	
43270	●	□				▲	●	□	2.7	4.5	12.7	4.76	0.3	
43280	●	●	●	□	▲	▲	●	●	2.8	4.5	12.7	4.76	0.3	
43300	●	●	●	●	▲	▲	●	●	3	4.5	12.7	4.76	0.3	
43320	●	●	□		▲	▲	●	●	3.2	4.5	12.7	4.76	0.3	
43330	●	●	●	□	▲	▲	●	●	3.3	4.5	12.7	4.76	0.3	
43350	●	□	●	□	▲	▲	●	●	3.5	4.5	12.7	4.76	0.3	
43400	●	●	●		▲	▲	●	●	4	4.5	12.7	4.76	0.3	
43420	●	□	□				●	●	4.2	4.5	12.7	4.76	0.4	
43430	●	□	□		▲	▲	●	●	4.3	4.5	12.7	4.76	0.4	
43450	●	●	●	●	▲	▲	●	●	4.5	4.5	12.7	4.76	0.4	
43470	●	□	□	□			●	□	4.7	4.5	12.7	4.76	0.4	

Right hand tool holder shown.

HSK TURNING TOOLS

MMTE

Threading



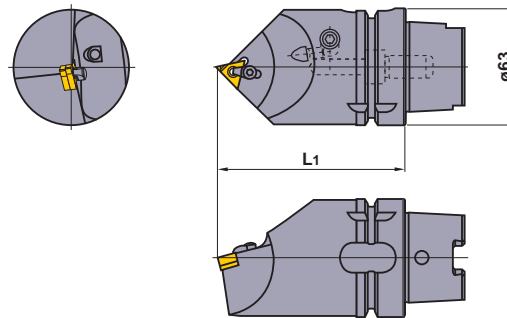
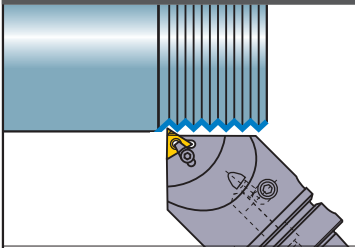
Right hand tool holder only.

Order Number *1	Stock R	Insert Number	Dimensions (mm)		Mass (kg)	Clamp Bridge	Clamp Screw	Stop Ring	Shim	Shim Screw	Coolant Pipe	Wrench
			L1	F1								
H63TH-MMTER-DX16	●	MMT16ER ○○○○○	65	45	1.2	SETK51	SETS51	CR4	CTE32TP15	HFC03008	HSK-CP18S	①TKY15F ②HKY20R

*1 Revised order number. For the conventional order number, refer to the corresponding list on the last page.

MMTEN

Threading



Tool holder for right hand insert only.

Order Number *1	Stock	Insert Number	Dimensions (mm)	Mass (kg)	Clamp Bridge	Clamp Screw	Stop Ring	Shim	Shim Screw	Plug	Coolant Pipe	Wrench
			L1									
H63TH-MMTENR-H16	●	MMT16ER ○○○○○	100	1.7	SETK51	SETS51	CR4	CTE32TP15	HFC03008	HGM-PT1/8	HSK-CP18S	①TKY15F ②HKY20R
-L16	●		140	2.7	SETK51	SETS51	CR4	CTE32TP15	HFC03008	HGM-PT1/8	HSK-CP18S	①TKY15F ②HKY20R

*1 Revised order number. For the conventional order number, refer to the corresponding list on the last page.

*2 For use with B axis tilted at 45 degrees.

Recommended Cutting Conditions

	Work Material	Hardness	Grade	Cutting Speed (m/min)
P	Mild Steel	≤180HB	VP10MF	150 (70–230)
			VP15TF	100 (60–140)
	Carbon Steel Alloy Steel	180–280HB	VP10MF	140 (80–200)
			VP15TF	100 (60–140)
M	Stainless Steel	≤200HB	VP10MF	130 (80–180)
			VP15TF	80 (40–120)
K	Cast Iron	Tensile Strength ≤350MPa	VP10MF	140 (80–200)
			VP15TF	90 (60–120)

● : Inventory maintained. (Note: Inserts packed in 5 piece boxes)

M-class Inserts with 3-D Chip Breakers for MMTE/MMTEN Holder

Type	Order Number	Coated	Pitch		Dimensions (mm)				Total Cutting Depth (mm)	Geometry
		VP15TF	mm	thread/inch	D1	S1	Z1	Z2		
Partial Profile 60°	MMT16ERA60-S	●	0.5–1.5	48–16	9.525	3.44	0.8	0.9	—	Partial form
	16ERG60-S	●	1.75–3.0	14–8	9.525	3.44	1.2	1.7	—	
Partial Profile 55°	MMT16ERA55-S	●		48–16	9.525	3.44	0.8	0.9	—	Partial form
	16ERG55-S	●		14–8	9.525	3.44	1.2	1.7	—	
ISO Metric	MMT16ER100ISO-S	●	1.0		9.525	3.44	0.7	0.7	0.61	Full form
	16ER125ISO-S	●	1.25		9.525	3.44	0.8	0.9	0.77	
	16ER150ISO-S	●	1.5		9.525	3.44	0.8	1.0	0.92	
	16ER175ISO-S	●	1.75		9.525	3.44	0.9	1.2	1.07	
	16ER200ISO-S	●	2.0		9.525	3.44	1.0	1.3	1.23	
	16ER250ISO-S	●	2.5		9.525	3.44	1.1	1.5	1.53	
	16ER300ISO-S	●	3.0		9.525	3.44	1.2	1.6	1.84	
American UN	MMT16ER160UN-S	●		16	9.525	3.44	0.9	1.1	0.97	Full form
	16ER140UN-S	●		14	9.525	3.44	1.0	1.2	1.11	
	16ER120UN-S	●		12	9.525	3.44	1.1	1.4	1.30	
Whitworth for BSW, BSP	MMT16ER190W-S	●		19	9.525	3.44	0.8	1.0	0.86	Full form
	16ER140W-S	●		14	9.525	3.44	1.0	1.2	1.16	
	16ER110W-S	●		11	9.525	3.44	1.1	1.5	1.48	
BSPT	MMT16ER190BSPT-S	●		19	9.525	3.44	0.8	0.9	0.86	Full form
	16ER140BSPT-S	●		14	9.525	3.44	1.0	1.2	1.16	
	16ER110BSPT-S	●		11	9.525	3.44	1.1	1.5	1.48	

Identification

MMT	16	E	R	050	ISO	-	S	M-class inserts with 3-D chip breakers
Designation	Diameter of Inscribed Circle (mm)	Application	Hand of Tool	Pitch		Threading Type		
	16 9.525	E External	R Right	100	1.0mm	A	0.5–1.5mm or 48–16 thread/inch	
				125	1.25mm			
				150	1.5mm	G	1.75–3.0mm or 14–8 thread/inch	
				175	1.75mm			
				200	2.0mm			
				250	2.5mm			
				300	3.0mm			
							60	Partial Profile 60°
							55	Partial Profile 55°
							ISO	ISO Metric
							W	Whitworth for BSW, BSP
							BSPT	BSPT
							UN	American UN

HSK TURNING TOOLS

G-class Ground Inserts for MMTE/MMTEN Holder

Type	Class	Order Number	Coated		Pitch		Dimensions (mm)				Total Cutting Depth (mm)	Geometry
			VP10MF	VP15TF	mm	thread/inch	D1	S1	Z1	Z2		
Partial Profile 60°	I	MMT16ERA60	●	●	0.5—1.5	48—16	9.525	3.44	0.8	0.9	—	
		16ERG60	●	●	1.75—3.0	14—8	9.525	3.44	1.2	1.7	—	
		16ERAG60	●		0.5—3.0	48—8	9.525	3.44	1.2	1.7	—	
Partial Profile 55°	I	MMT16ERA55	●	●		48—16	9.525	3.44	0.8	0.9	—	
		16ERG55	●	●		14—8	9.525	3.44	1.2	1.7	—	
		16ERAG55	●			48—8	9.525	3.44	1.2	1.7	—	
ISO Metric	6g	MMT16ER050ISO	●		0.5		9.525	3.44	0.6	0.4	0.31	
		16ER075ISO	●		0.75		9.525	3.44	0.6	0.6	0.46	
		16ER100ISO	●	●	1.0		9.525	3.44	0.7	0.7	0.61	
		16ER125ISO	●	●	1.25		9.525	3.44	0.8	0.9	0.77	
		16ER150ISO	●	●	1.5		9.525	3.44	0.8	1.0	0.92	
		16ER175ISO	●	●	1.75		9.525	3.44	0.9	1.2	1.07	
		16ER200ISO	●	●	2.0		9.525	3.44	1.0	1.3	1.23	
		16ER250ISO	●	●	2.5		9.525	3.44	1.1	1.5	1.53	
16ER300ISO	●	●	3.0		9.525	3.44	1.2	1.6	1.84			

* For other types of inserts, refer to A340 and A342 pages in C003J general catalogue.

Identification

MMT **16** **E** **R** **050** **ISO**

Designation

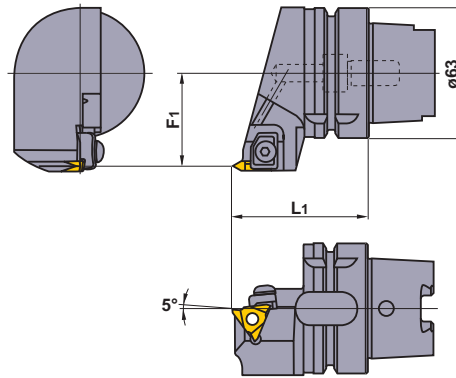
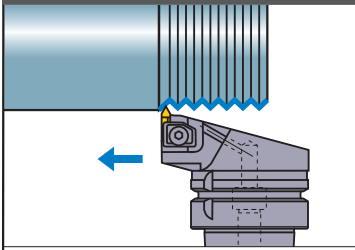
Diameter of Inscribed Circle (mm)
9.525






Application
E External

Hand of Tool
R Right

Pitch		A	G	AG	N
050	0.5mm				
075	0.75mm	0.5—1.5mm or 48—16 thread/inch			
100	1.0mm				
125	1.25mm	1.75—3.0mm or 14—8 thread/inch			
150	1.5mm				
175	1.75mm				
200	2.0mm	0.5—3.0mm or 48—8 thread/inch			
250	2.5mm				
300	3.0mm	3.5—5.0mm or 7—5 thread/inch			
350	3.5mm				
400	4.0mm				
450	4.5mm				
500	5.0mm				

Threading Type	
60	Partial Profile 60°
55	Partial Profile 55°
ISO	ISO Metric
W	Whitworth for BSW, BSP
BSPT	BSPT
UN	American UN
RD	Round DIN 405
TR	ISO Trapezoidal 30°
ACME	American ACME
UNJ	UNJ
APBU	API Buttress Casing
APRD	API Round Casing & Tubing
NPT	NPT
NPTF	NPTF

MT**Threading**

Order Number ^{*1}	Stock		Insert Number	Dimensions (mm)		Mass (kg)	 Clamp Bridge	 Clamp Screw	 Spring	 Coolant Pipe	 Wrench
	R	L		L1	F1						
H63TH-MTHR/L-DX43	●	●	MTTR/L 43○○○○	65	45	1.2	MTK1R/L	HBH06020	MES3	HSK-CP18S	HKY40R

*1 Revised order number. For the conventional order number, refer to the corresponding list on the last page.

Recommended Cutting Conditions

	Work Material	Hardness	Grade	Cutting Speed (m/min)
P	Mild Steel	≤180HB	UP20M	140 (100–180)
			NX55	200 (150–250)
			UTi20T	120 (100–150)
	Carbon Steel Alloy Steel	180HB–280HB	UP20M	120 (100–150)
			NX55	170 (150–200)
			UTi20T	100 (70–120)
M	Stainless Steel	≤200HB	UP20M	120 (80–150)
			UTi20T	100 (70–130)
K	Cast Iron	Tensile Strength ≤350MPa	UP20M	80 (60–100)
			UTi20T	80 (60–100)
			HTi10	100 (70–130)

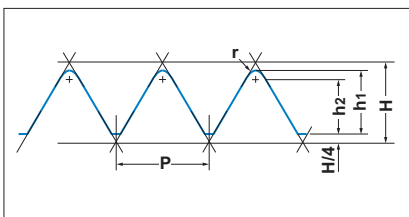
HSK TURNING TOOLS

Inserts for MT Type

Type	Order Number	Class	Material				ISO Pitch mm (thread/inch)	Dimensions (mm)			Geometry
			Coated UP20M	Cermet NX55	Carbide UT120T HT110			D1	S1	Re	
Partial Profile 60°	MTTR436000	G	☐	●	●	☐	-0.8	12.7	4.76	0	 MTTR/L(60°)
	L436000	G	☐	●	●	☐	-0.8	12.7	4.76	0	
	R436001	G	●	●	●	●	1.0-1.75	12.7	4.76	0.1	
	L436001	G	☐	●	●	●	1.0-1.75	12.7	4.76	0.1	
	R436002	G	●	●	●	●	2.0-2.5	12.7	4.76	0.2	
	L436002	G	☐	●	●	●	2.0-2.5	12.7	4.76	0.2	
	R436003	G	☐	●	●	●	3.0-3.5	12.7	4.76	0.3	
	L436003	G	☐	●	●	☐	3.0-3.5	12.7	4.76	0.3	
	R436004	G	☐	●	●	☐	4.0-4.5	12.7	4.76	0.4	
L436004	G	☐	●	●	☐	4.0-4.5	12.7	4.76	0.4		
Partial Profile 55°	MTTR435501	G	☐	●	●	☐	(28-10)	12.7	4.76	0.1	 MTTR/L(55°)
	L435501	G	☐	●	●	☐	(28-10)	12.7	4.76	0.1	
	R435502	G	☐	●	●	☐	(16-8)	12.7	4.76	0.2	
	L435502	G	☐	●	●	☐	(16-8)	12.7	4.76	0.2	
	R435503	G	☐	●	●	☐	(11-8)	12.7	4.76	0.3	
	L435503	G	☐	☐	☐	☐	(11-8)	12.7	4.76	0.3	

Standard of Depth of Cut

- The chart on the right shows the cutting depths when machining external ISO metric screw threads.
- When using cermet grades or cutting stainless steel, please increase the number of passes by 2-3 times.



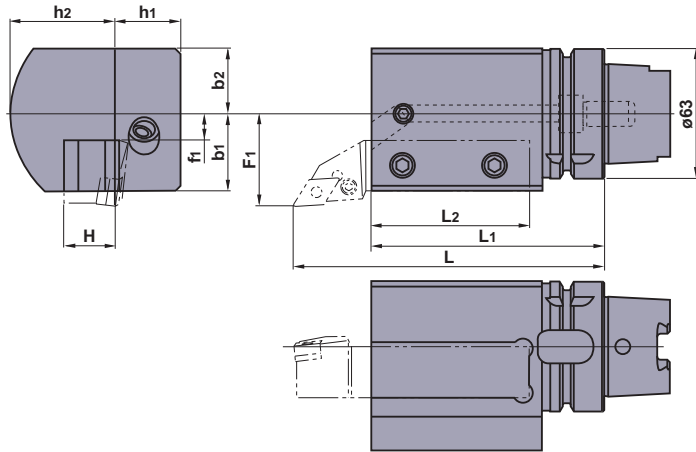
Metric Screw Thread

P (Pitch)	0.75	1.00	1.25	1.50	1.75	2.00	2.50	3.00	3.50	4.00	4.50	
h1	0.46	0.61	0.77	0.92	1.07	1.23	1.53	1.84	2.15	2.45	2.76	
h2	0.35	0.47	0.59	0.70	0.82	0.94	1.17	1.41	1.65	1.87	2.11	
r (Nose Radius)	0.11	0.14	0.18	0.22	0.25	0.29	0.36	0.43	0.50	0.58	0.65	
Number of Passes	1	0.18	0.20	0.20	0.25	0.25	0.25	0.30	0.30	0.35	0.35	0.40
	2	0.13	0.15	0.18	0.20	0.20	0.25	0.25	0.25	0.30	0.30	0.35
	3	0.10	0.10	0.12	0.15	0.20	0.20	0.20	0.25	0.25	0.25	0.30
	4	0.05	0.10	0.12	0.15	0.15	0.15	0.20	0.20	0.20	0.25	0.25
	5		0.06	0.10	0.10	0.12	0.15	0.15	0.20	0.20	0.25	0.25
	6			0.05	0.07	0.10	0.10	0.10	0.15	0.20	0.20	0.20
	7					0.05	0.08	0.10	0.15	0.15	0.20	0.20
	8						0.05	0.10	0.10	0.15	0.15	0.15
	9							0.08	0.10	0.10	0.15	0.15
	10							0.05	0.09	0.10	0.10	0.15
	11								0.05	0.10	0.10	0.10
	12									0.05	0.10	0.10
	13										0.05	0.10
	14											0.06

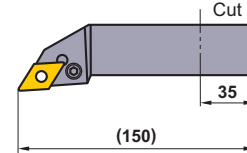
(Note) The first pass causes a high load on the cutting edge.
In order to avoid damage, keep the depth of cut to 0.4-0.5mm maximum.

EXTERNAL TURNING TOOL HOLDERS

External turning • Facing



■ This holder is for 25×25 size tools.
Please shorten the tool as shown below before use.



Right hand tool holder shown.

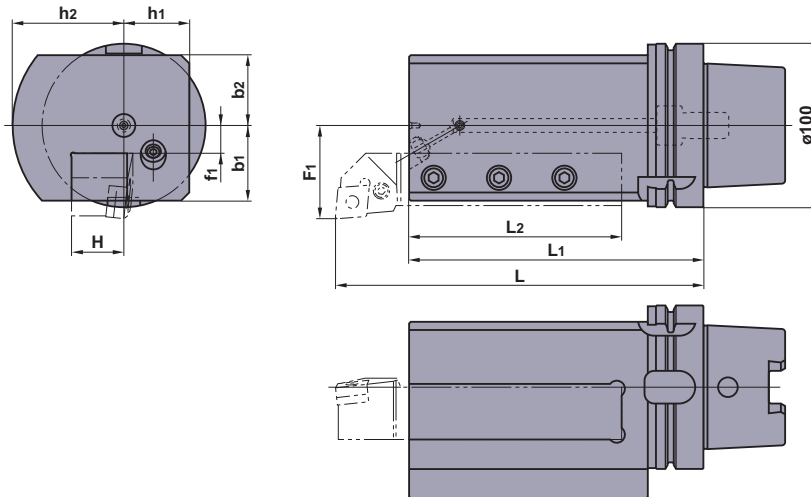
Order Number *1	Stock		Dimensions (mm)										Mass (kg)			
	R	L	L	L1	L2	H	h1	h2	F1	f1	b1	b2				
H63TH-EV2525R/L-112	●	●	150	112	77	25	32	53	45	13	38	32	3.9	HSS12025	HGM-PT1/8	HSK-CP18S

*1 Revised order number. For the conventional order number, refer to the corresponding list on the last page.

EXTERNAL TURNING TOOL HOLDERS

External turning • Facing

NEW



■ This holder is for 32×32 and 32 x 25 size tools.

Right hand tool holder shown.

Order Number	Stock		Dimensions (mm)										Mass (kg)				
	R	L	L	L1	L2	H	h1	h2	F1	f1	b1	b2					
H100TH-EV3232R/L-180	●	●	220	180	130	32	40	68	57	17	46	43	11.7	HSS14035	SNA4	HSS06006	HSK-CP24S

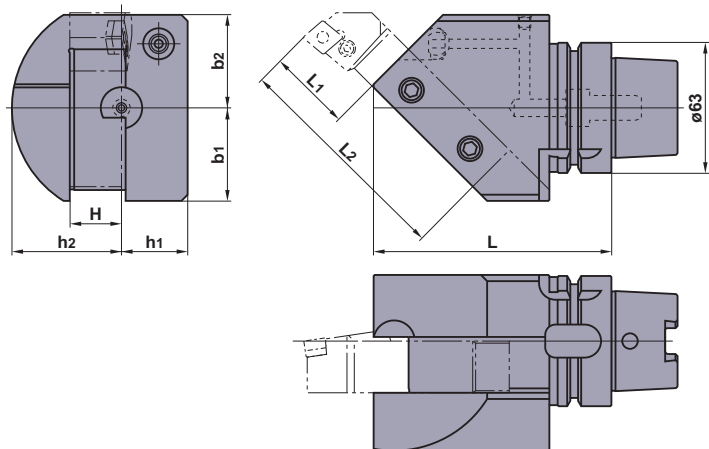
(Note) Possible to fit a 25 x 25 tool by using a 7mm plate.

HSK TURNING TOOLS

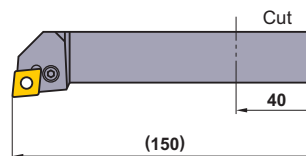
EXTERNAL TURNING TOOL HOLDERS

External turning • Facing


NEW



■ This holder is for 25×25 size tools.
Please shorten the tool as shown below before use.



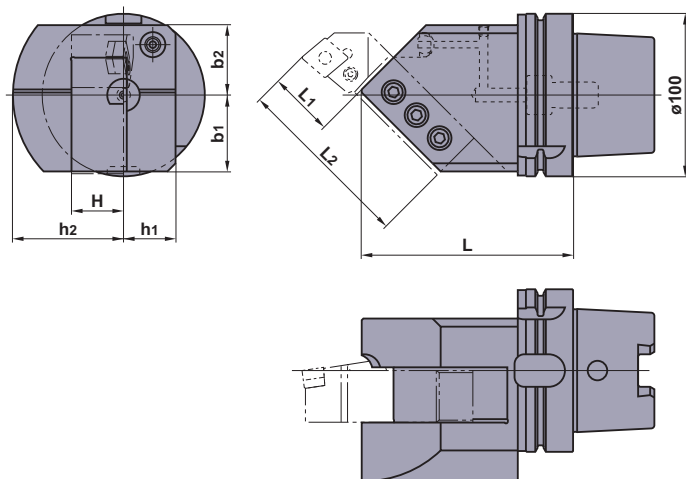
Right hand tool holder shown.

Order Number	Stock		Dimensions (mm)								Mass (kg)				
	R	L	L	L1	L2	H	h1	h2	b1	b2		Clamp Screw	Nozzle Plug	Plug	Coolant Pipe
H63TH-EN2525R/L-115	●	●	115	40	110	25	32	53	45	45	3.7	HSS12030	SNA4	HSS06006	HSK-CP18S

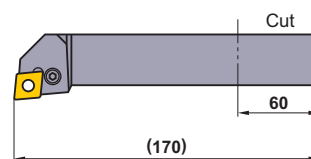
EXTERNAL TURNING TOOL HOLDERS

External turning • Facing


NEW



■ This holder is for 32×32 and 32 x 25 size tools.
Please shorten the tool as shown below before use.



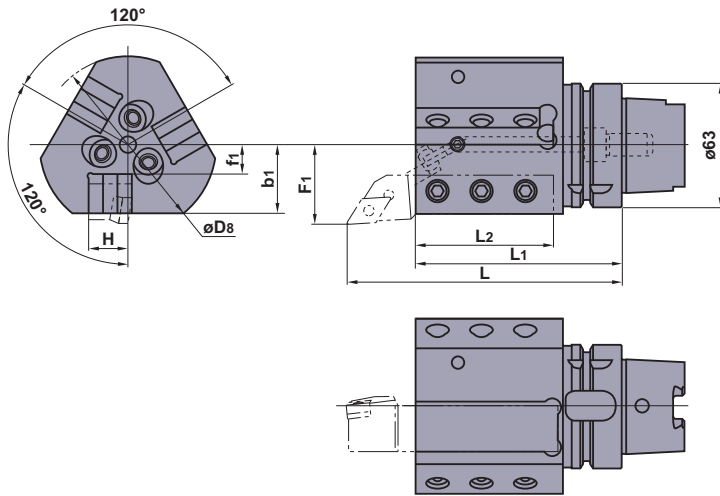
Right hand tool holder shown.

Order Number	Stock		Dimensions (mm)								Mass (kg)				
	R	L	L	L1	L2	H	h1	h2	b1	b2		Clamp Screw	Nozzle Plug	Plug	Coolant Pipe
H100TH-EN3232R/L-130	●	●	130	40	110	32	32	68	47	43	6.6	HSS14030	SNA4	HSS06006	HSK-CP24S

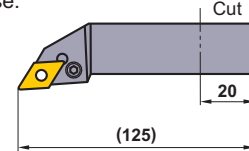
(Note) Possible to fit a 25 x 25 tool by using a 7mm plate.

EXTERNAL TURNING TOOL HOLDERS


External turning • Facing



■ This holder is for 20×20 size tools.
Please shorten the tool as shown below
before use.



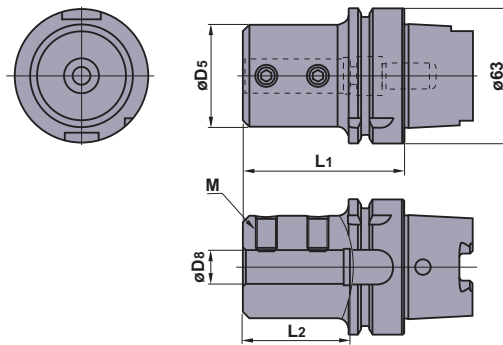
Right hand tool holder shown.


Order Number *1	Stock		Dimensions (mm)								Mass (kg)				
	R	L	L	L1	L2	H	D8	F1	f1	b1		Clamp Screw	Nozzle Plug	Plug	Coolant Pipe
H63TH-EV2020R/L-105-3	●	●	140	105	70	20	90	40	15	35	2.9	HSS12030	HSS05012	HSS06006	HSK-CP18S

*1 Revised order number. For the conventional order number, refer to the corresponding list on the last page.

BORING BAR HOLDERS

Internal turning



Order Number *1	Stock	Dimensions (mm)					Mass (kg)		
		D5	D8	L1	L2	M		Clamp Screw	Coolant Pipe
H63TH-B08-65	●	28	8	65	40	M8	0.9	HSS08010	HSK-CP18S
B10-70	●	35	10	70	45	M8	1.0	HSS08012	
B12-70	●	42	12	70	45	M8	1.1	HSS08012	
B16-75	●	48	16	75	50	M10	1.3	HSS10016	
B20-75	●	52	20	75	50	M10	1.4	HSS10016	
B25-83	●	62	25	83	58	M12	1.7	HSS12016	
B32-87	●	62	32	87	62	M12	1.7	HSS12016	
B40-97	●	65	40	97	72	M16	1.8	HSS16012	

*1 Revised order number. For the conventional order number, refer to the corresponding list on the last page.

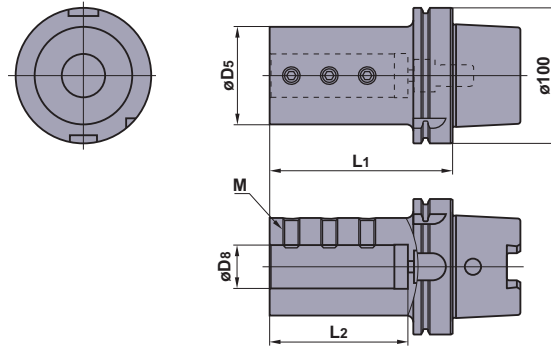
(Note) Please cut the boring bar to adjust the shank length, this also applies to indexable type drills.



HSK TURNING TOOLS

BORING BAR HOLDERS

Internal turning

NEW

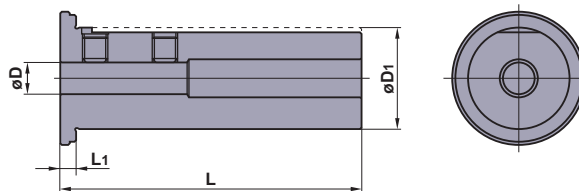



Order Number	Stock	Dimensions (mm)					Mass (kg)	 	
		D5	D8	L1	L2	M		Clamp Screw	Coolant Pipe
H100TH-B25-120	●	62	25	120	88	12	3.9	HSS12016	HSK-CP24S
-B32-135	●	72	32	135	102	12	4.8	HSS12018	
-B40-150	●	82	40	150	117	16	5.9	HSS16020	
-B50-180	●	92	50	180	147	16	7.7	HSS16020	

(Note) Please cut the boring bar to adjust the shank length, this also applies to indexable type drills.

BORING BAR SLEEVES FOR H100TH-B32-135

NEW



Order Number	Stock	Dimensions (mm)				Mass (kg)	
		D	D1	L	L1		Clamp Screw
SL3208-90	●	8	32	95	5	0.6	HSS06008
3210-90	●	10	32	95	5	0.5	HSS08008
3212-90	●	12	32	95	5	0.5	HSS08008
3216-90	●	16	32	95	5	0.5	HSS08006
3220-90	●	20	32	95	5	0.4	HSS08005

(Note) These sleeves are only compatible with H100TH-B32-135 holder.

CORRESPONDING LIST OF CONVENTIONAL ORDER NUMBER WITH REVISED ORDER NUMBER

● The order numbers of the tool holders will be changed according to the global standardization.

Conventional
order number

H₀₀A

-

WH

-

XXXX

Revised
order number

H₀₀TH

-

XXXX

● HSK Tools for External Turning and Facing

Conventional Order Number	Revised Order Number	Page
PCLN (External turning, Facing)		
H63A-WH-PCLNR-DX12	H63TH-PCLNR-DX12	5
H63A-WH-PCLNL-DX12	H63TH-PCLNL-DX12	
PCMN (External turning, Facing)		
H63A-WH-PCMNN-H12	H63TH-PCMNN-H12	6
H63A-WH-PCMNN-L12	H63TH-PCMNN-L12	
PDJN (External turning, Copying)		
H63A-WH-PDJNR-DX15	H63TH-PDJNR-DX15	8
H63A-WH-PDJNL-DX15	H63TH-PDJNL-DX15	
PDNN (External turning, Copying)		
H63A-WH-PDNNN-H15	H63TH-PDNNN-H15	9
H63A-WH-PDNNN-L15	H63TH-PDNNN-L15	
PRGC (External turning, Facing, Copying)		
H63A-WH-PRGCR-DX12	H63TH-PRGCR-DX12	11
H63A-WH-PRGCL-DX12	H63TH-PRGCL-DX12	
PRDC (External turning, Facing, Copying)		
H63A-WH-PRDCN-H12	H63TH-PRDCN-H12	11
H63A-WH-PRDCN-L12	H63TH-PRDCN-L12	
SVPB (Copying)		
H63A-WH-SVPBR-DX16	H63TH-SVPBR-DX16	12
H63A-WH-SVPBL-DX16	H63TH-SVPBL-DX16	
SVVB (Copying)		
H63A-WH-SVVBH-H16	H63TH-SVVBH-H16	12
H63A-WH-SVVBH-L16	H63TH-SVVBH-L16	

● HSK Tools for Grooving

Revised Order Number	Revised Order Number	Page	
DG Pack (Cutting off, Grooving)			
H63A-WH-C5207R	H63TH-C5207R	13	
H63A-WH-C5207L	H63TH-C5207L		
H63A-WH-C5307R	H63TH-C5307R		
H63A-WH-C5307L	H63TH-C5307L		
H63A-WH-C5407R	H63TH-C5407R		
H63A-WH-C5407L	H63TH-C5407L		
H63A-WH-C5507R	H63TH-C5507R		
H63A-WH-C5507L	H63TH-C5507L		
H63A-WH-C5607R	H63TH-C5607R		
H63A-WH-C5607L	H63TH-C5607L		
H63A-WH-C5707R	H63TH-C5707R		
H63A-WH-C5707L	H63TH-C5707L		
H63A-WH-C5807R	H63TH-C5807R		
H63A-WH-C5807L	H63TH-C5807L		
DG Pack (Cutting off, Grooving, Copying)			
H63A-WH-D5307R	H63TH-D5307R		13
H63A-WH-D5307L	H63TH-D5307L		
H63A-WH-D5407R	H63TH-D5407R		
H63A-WH-D5407L	H63TH-D5407L		
H63A-WH-D5408R	H63TH-D5408R		
H63A-WH-D5408L	H63TH-D5408L		
H63A-WH-C5507R	H63TH-C5507R		
H63A-WH-C5507L	H63TH-C5507L		
H63A-WH-C5508R	H63TH-C5508R		
H63A-WH-C5508L	H63TH-C5508L		
H63A-WH-C5608R	H63TH-C5608R		
H63A-WH-C5608L	H63TH-C5608L		
DG Pack (Recessing, Copying)			
H63A-WH-G5408NH	H63TH-G5408NH	14	
H63A-WH-G5508NH	H63TH-G5508NH		
H63A-WH-G5608NH	H63TH-G5608NH		
H63A-WH-G5408NL	H63TH-G5408NL		
H63A-WH-G5508NL	H63TH-G5508NL		
H63A-WH-G5608NL	H63TH-G5608NL		

HSK TURNING TOOLS

CORRESPONDING LIST OF CONVENTIONAL ORDER NUMBER WITH REVISED ORDER NUMBER

● HSK Tools for Grooving

Revised Order Number	Revised Order Number	Page
DG Pack (Face grooving)		
H63A-WH-M5300R	H63TH-M5300R	15
H63A-WH-M5300L	H63TH-M5300L	
H63A-WH-M5302R	H63TH-M5302R	
H63A-WH-M5302L	H63TH-M5302L	
H63A-WH-M5304R	H63TH-M5304R	
H63A-WH-M5304L	H63TH-M5304L	
H63A-WH-M5400R	H63TH-M5400R	
H63A-WH-M5400L	H63TH-M5400L	
H63A-WH-M5402R	H63TH-M5402R	
H63A-WH-M5402L	H63TH-M5402L	
H63A-WH-M5404R	H63TH-M5404R	
H63A-WH-M5404L	H63TH-M5404L	
H63A-WH-M5502R	H63TH-M5502R	
H63A-WH-M5502L	H63TH-M5502L	
H63A-WH-M5504R	H63TH-M5504R	
H63A-WH-M5504L	H63TH-M5504L	
H63A-WH-M6502R	H63TH-M6502R	
H63A-WH-M6502L	H63TH-M6502L	
H63A-WH-M6504R	H63TH-M6504R	
H63A-WH-M6504L	H63TH-M6504L	
H63A-WH-M5602R	H63TH-M5602R	
H63A-WH-M5602L	H63TH-M5602L	
H63A-WH-M5604R	H63TH-M5604R	
H63A-WH-M5604L	H63TH-M5604L	
H63A-WH-M6602R	H63TH-M6602R	
H63A-WH-M6602L	H63TH-M6602L	
H63A-WH-M6604R	H63TH-M6604R	
H63A-WH-M6604L	H63TH-M6604L	
H63A-WH-M5702R	H63TH-M5702R	
H63A-WH-M5702L	H63TH-M5702L	
H63A-WH-M5704R	H63TH-M5704R	
H63A-WH-M5704L	H63TH-M5704L	
H63A-WH-M6702R	H63TH-M6702R	
H63A-WH-M6702L	H63TH-M6702L	
H63A-WH-M6704R	H63TH-M6704R	
H63A-WH-M6704L	H63TH-M6704L	
H63A-WH-M5802R	H63TH-M5802R	
H63A-WH-M5802L	H63TH-M5802L	
H63A-WH-M5804R	H63TH-M5804R	
H63A-WH-M5804L	H63TH-M5804L	
H63A-WH-M6802R	H63TH-M6802R	
H63A-WH-M6802L	H63TH-M6802L	
H63A-WH-M6804R	H63TH-M6804R	
H63A-WH-M6804L	H63TH-M6804L	

Revised Order Number	Revised Order Number	Page
DG Pack (Face grooving, Copying)		
H63A-WH-P5302R	H63TH-P5302R	16
H63A-WH-P5302L	H63TH-P5302L	
H63A-WH-P5304R	H63TH-P5304R	
H63A-WH-P5304L	H63TH-P5304L	
H63A-WH-P5402R	H63TH-P5402R	
H63A-WH-P5402L	H63TH-P5402L	
H63A-WH-P5404R	H63TH-P5404R	
H63A-WH-P5404L	H63TH-P5404L	
H63A-WH-M5502R	H63TH-M5502R	
H63A-WH-M5502L	H63TH-M5502L	
H63A-WH-M5504R	H63TH-M5504R	
H63A-WH-M5504L	H63TH-M5504L	
H63A-WH-M6502R	H63TH-M6502R	
H63A-WH-M6502L	H63TH-M6502L	
H63A-WH-M6504R	H63TH-M6504R	
H63A-WH-M6504L	H63TH-M6504L	
H63A-WH-M5602R	H63TH-M5602R	
H63A-WH-M5602L	H63TH-M5602L	
H63A-WH-M5604R	H63TH-M5604R	
H63A-WH-M5604L	H63TH-M5604L	
H63A-WH-M6602R	H63TH-M6602R	
H63A-WH-M6602L	H63TH-M6602L	
H63A-WH-M6604R	H63TH-M6604R	
H63A-WH-M6604L	H63TH-M6604L	

● HSK Tools for Grooving

Revised Order Number	Revised Order Number	Page
DG Pack (Facing, Grooving)		
H63A-WH-N5300R	H63TH-N5300R	17
H63A-WH-N5300L	H63TH-N5300L	
H63A-WH-N5302R	H63TH-N5302R	
H63A-WH-N5302L	H63TH-N5302L	
H63A-WH-N5304R	H63TH-N5304R	
H63A-WH-N5304L	H63TH-N5304L	
H63A-WH-N5400R	H63TH-N5400R	
H63A-WH-N5400L	H63TH-N5400L	
H63A-WH-N5402R	H63TH-N5402R	
H63A-WH-N5402L	H63TH-N5402L	
H63A-WH-N5404R	H63TH-N5404R	
H63A-WH-N5404L	H63TH-N5404L	
H63A-WH-N5502R	H63TH-N5502R	
H63A-WH-N5502L	H63TH-N5502L	
H63A-WH-N5504R	H63TH-N5504R	
H63A-WH-N5504L	H63TH-N5504L	
H63A-WH-N6502R	H63TH-N6502R	
H63A-WH-N6502L	H63TH-N6502L	
H63A-WH-N6504R	H63TH-N6504R	
H63A-WH-N6504L	H63TH-N6504L	
H63A-WH-N6602R	H63TH-N6602R	
H63A-WH-N6602L	H63TH-N6602L	
H63A-WH-N6604R	H63TH-N6604R	
H63A-WH-N6604L	H63TH-N6604L	
H63A-WH-N5702R	H63TH-N5702R	
H63A-WH-N5702L	H63TH-N5702L	
H63A-WH-N5704R	H63TH-N5704R	
H63A-WH-N5704L	H63TH-N5704L	
H63A-WH-N6702R	H63TH-N6702R	
H63A-WH-N6702L	H63TH-N6702L	
H63A-WH-N6704R	H63TH-N6704R	
H63A-WH-N6704L	H63TH-N6704L	
H63A-WH-N5802R	H63TH-N5802R	
H63A-WH-N5802L	H63TH-N5802L	
H63A-WH-N5804R	H63TH-N5804R	
H63A-WH-N5804L	H63TH-N5804L	
H63A-WH-N6802R	H63TH-N6802R	
H63A-WH-N6802L	H63TH-N6802L	
H63A-WH-N6804R	H63TH-N6804R	
H63A-WH-N6804L	H63TH-N6804L	

Revised Order Number	Revised Order Number	Page	
DG Pack (Face grooving, Copying)			
H63A-WH-Q5302R	H63TH-Q5302R	18	
H63A-WH-Q5302L	H63TH-Q5302L		
H63A-WH-Q5304R	H63TH-Q5304R		
H63A-WH-Q5304L	H63TH-Q5304L		
H63A-WH-Q5402R	H63TH-Q5402R		
H63A-WH-Q5402L	H63TH-Q5402L		
H63A-WH-Q5404R	H63TH-Q5404R		
H63A-WH-Q5404L	H63TH-Q5404L		
H63A-WH-N5502R	H63TH-N5502R		
H63A-WH-N5502L	H63TH-N5502L		
H63A-WH-N5504R	H63TH-N5504R		
H63A-WH-N5504L	H63TH-N5504L		
H63A-WH-N6502R	H63TH-N6502R		
H63A-WH-N6502L	H63TH-N6502L		
H63A-WH-N6504R	H63TH-N6504R		
H63A-WH-N6504L	H63TH-N6504L		
H63A-WH-N5602R	H63TH-N5602R		
H63A-WH-N5602L	H63TH-N5602L		
H63A-WH-N5604R	H63TH-N5604R		
H63A-WH-N5604L	H63TH-N5604L		
H63A-WH-N6602R	H63TH-N6602R		
H63A-WH-N6602L	H63TH-N6602L		
H63A-WH-N6604R	H63TH-N6604R		
H63A-WH-N6604L	H63TH-N6604L		
DG Holder			
H63A-WH-DGHR	H63TH-DGHR		13 18
H63A-WH-DGHL	H63TH-DGHL		
H63A-WH-DGHRS	H63TH-DGHRS		
H63A-WH-DGHLS	H63TH-DGHLS		
H63A-WH-DGHN-H4	H63TH-DGHN-H4		
H63A-WH-DGHN-H5	H63TH-DGHN-H5		
H63A-WH-DGHN-H6	H63TH-DGHN-H6		
H63A-WH-DGHN-L4	H63TH-DGHN-L4		
H63A-WH-DGHN-L5	H63TH-DGHN-L5		
H63A-WH-DGHN-L6	H63TH-DGHN-L6		

HSK TURNING TOOLS

CORRESPONDING LIST OF CONVENTIONAL ORDER NUMBER WITH REVISED ORDER NUMBER

● HSK Tools for Grooving

Revised Order Number	Revised Order Number	Page
MG (Grooving)		
H63A-WH-MGHR-DX4315	H63TH-MGHR-DX4315	21
H63A-WH-MGHL-DX4315	H63TH-MGHL-DX4315	
H63A-WH-MGHR-DX4323	H63TH-MGHR-DX4323	
H63A-WH-MGHL-DX4323	H63TH-MGHL-DX4323	
H63A-WH-MGHR-DX4333	H63TH-MGHR-DX4333	
H63A-WH-MGHL-DX4333	H63TH-MGHL-DX4333	

● HSK Tools for Threading

Revised Order Number	Revised Order Number	Page
MMTE (Threading)		
H63A-WH-MMTER-DX16	H63TH-MMTER-DX16	23
MMTEN (Threading)		
H63A-WH-MMTENR-H16	H63TH-MMTENR-H16	23
H63A-WH-MMTENR-L16	H63TH-MMTENR-L16	
MT (Threading)		
H63A-WH-MTHR-DX43	H63TH-MTHR-DX43	26
H63A-WH-MTHL-DX43	H63TH-MTHL-DX43	

● External Turning Tool Holders

Revised Order Number	Revised Order Number	Page
Square Shank Holders		
H63A-WH-E2525R-112	H63TH-EV2525R-112	28
H63A-WH-E2525L-112	H63TH-EV2525L-112	
H63A-WH-E2020R-105-3	H63TH-EV2020R-105-3	30
H63A-WH-E2020L-105-3	H63TH-EV2020L-105-3	

● Boring Bar Holders

Revised Order Number	Revised Order Number	Page
Boring Bar Holders		
H63A-WH-B08-65	H63TH-B08-65	30
H63A-WH-B10-70	H63TH-B10-70	
H63A-WH-B12-70	H63TH-B12-70	
H63A-WH-B16-75	H63TH-B16-75	
H63A-WH-B20-75	H63TH-B20-75	
H63A-WH-B25-83	H63TH-B25-83	
H63A-WH-B32-87	H63TH-B32-87	
H63A-WH-B40-97	H63TH-B40-97	

For Your Safety

●Don't handle inserts and chips without gloves. ●Please machine within the recommended application range and exchange expired tools with new ones in advance of breakage. ●Please use safety covers and wear safety glasses. ●When using compounded cutting oils, please take fire precautions. ●When attaching inserts or spare parts, please use only the correct wrench or spanner. ●When using rotating tools, please make a trial run to check run-out, vibration and abnormal sounds etc.

MITSUBISHI MATERIALS CORPORATION



The Scope of the Registration:
Design, Development and
Production of Cemented
Carbide Tools and Carbide
Blanks



The Scope of the Registration:
Design, Development and
Production of Cutting Tools,
Wear-resistant Tools, Rock
Drilling Tools, Cemented
Carbide Blanks and Coated
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(Tools specifications subject to change without notice.)