

HOW TO READ THE STANDARD OF SMALL TOOLS

● How this section page is organised

- ① Organised according to the cutting mode of small tools.
(Refer to the inside title on the next page.)
- ② Shown as Turning → External Grooving → External Cutting Off → Threading → Boring.

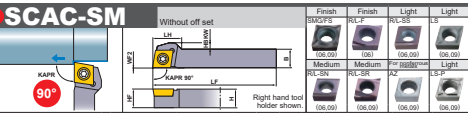
TYPE OF TOOL HOLDER indicates the first four letters of the order number, as well as cutting applications.

APPLICATION

PRODUCT SECTION

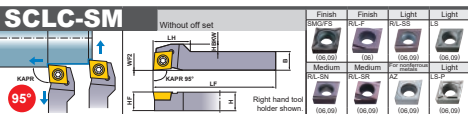
SMALL TOOLS

EXTERNAL FRONT TURNING



Order Number	Stock	Insert Number	Dimensions (mm)										Clamp Screw	Wrench
			H	B	LF	LN	HRW	HF	WF2	WF1	WF2	WF1		
SCACRL0809K06-SM	●●	0902	8	8	125	11	1.6	8	0	TS254	TKY98R			
SCACRL1010K06-SM	●●	0902	10	10	125	—	—	10	0	TS254	TKY98R			
SCACRL1010K09-SM	●●	09T3	10	10	125	16	3.5	10	0	TS43	TKY15R			
SCACRL1212M09-SM	●●	09T3	12	12	150	14	1.5	12	0	TS43	TKY15R			
SCACRL1616M09-SM	●●	09T3	16	16	150	—	—	16	0	TS43	TKY15R			

* Clamp Torque (N·m) : TS254=1.0, TS43=3.5



Order Number	Stock	Insert Number	Dimensions (mm)										Clamp Screw	Wrench
			H	B	LF	LN	HRW	HF	WF2	WF1	WF2	WF1		
SCLCLR0809K06-SM	●●	0902	8	8	125	11	2.1	8	0	TS254	TKY98R			
SCLCLR1010K06-SM	●●	0902	10	10	125	—	—	10	0	TS254	TKY98R			
SCLCLR1010K09-SM	●●	09T3	10	10	125	20	4	10	0	TS43	TKY15R			
SCLCLR1212M09-SM	●●	09T3	12	12	150	18	2	12	0	TS43	TKY15R			
SCLCLR1616M09-SM	●●	09T3	16	16	150	—	—	16	0	TS43	TKY15R			

* Clamp Torque (N·m) : TS254=1.0, TS43=3.5

Note1) The insert photos are only examples. The letters refer to the chip breaker and the dimension refers to the inscribed circle.
Note2) Dimensions shown for insert corner RE 0.2.

● Inventory maintained in Japan.

SCAC-SM type inserts > A140-A147
SCLC-SM type inserts > A140-A147
SBN & PCO inserts > B848-B852, B872

LEGEND FOR STOCK STATUS MARK is shown on the left hand page of each double-page spread.

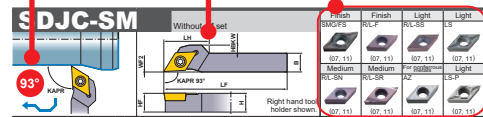
PRODUCT STANDARDS indicates order numbers, stock status (per right/left hand), applicable inserts, dimensions, and spare parts.

REFERENCE PAGE FOR APPLICABLE INSERTS indicates reference pages giving details of inserts that are applicable to the product.

RECOMMENDED CUTTING CONDITIONS for each work material classification, indicates recommended cutting conditions according to the ISO categories for cutting grades, P, M and N.

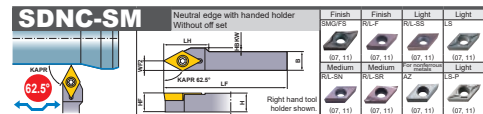
FIGURE SHOWING THE TOOLING APPLICATION uses illustrations and arrows to depict the available machining applications such as external turning, copying, facing, chamfering, threading, and grooving together with cutting edge lead angles.

GEOMETRY
CHIP BREAKER BY CUTTING APPLICATION



Order Number	Stock	Insert Number	Dimensions (mm)										Clamp Screw	Wrench
			H	B	LF	LN	HRW	HF	WF2	WF1	WF2	WF1		
SDJCLR0809K07-SM	●●	0702	8	8	125	16	2	8	0	TS254	TKY98R			
SDJCLR1010K07-SM	●●	0702	10	10	125	—	—	10	0	TS254	TKY98R			
SDJCLR1010K11-SM	●●	11T3	10	10	125	24	4	10	0	TS43	TKY15R			
SDJCLR1212M11-SM	●●	11T3	12	12	150	22	2	12	0	TS43	TKY15R			
SDJCLR1616M11-SM	●●	11T3	16	16	150	—	—	16	0	TS43	TKY15R			

* Clamp Torque (N·m) : TS254=1.0, TS43=3.5



Order Number	Stock	Insert Number	Dimensions (mm)										Clamp Screw	Wrench
			H	B	LF	LN	HRW	HF	WF2	WF1	WF2	WF1		
SDNCLR0809K07-SM	●●	0702	8	8	125	—	—	8	3	TS254	TKY98R			
SDNCLR1010K07-SM	●●	0702	10	10	125	—	—	10	3	TS254	TKY98R			
SDNCLR1010K11-SM	●●	11T3	10	10	125	24	2	10	5	TS43	TKY15R			
SDNCLR1212M11-SM	●●	11T3	12	12	150	—	—	12	5	TS43	TKY15R			
SDNCLR1616M11-SM	●●	11T3	16	16	150	—	—	16	5	TS43	TKY15R			

* Clamp Torque (N·m) : TS254=1.0, TS43=3.5

RECOMMENDED CUTTING CONDITIONS

Work Material	Hardness	Grade	Cutting Speed (m/min)	Feed (mm/rev)
P Carbon Steel - Alloy Steel	180HB-260HB	MS6015/VP15TF	100 (50-150)	0.08 (0.01-0.15)
		MS6015	110 (30-180)	0.08 (0.01-0.15)
		NX2555	150 (50-250)	0.08 (0.01-0.15)
M Stainless Steel	200HB	VP15TF/MP9005/MP9015	80 (50-120)	0.06 (0.02-0.1)
N Non-Ferrous Metal	—	HT10/MT9005	150 (70-230)	0.09 (0.03-0.15)
S Titanium Alloy	—	MT9005	60 (40-80)	0.08 (0.04-0.12)
Heat Resistant Alloy	—	MP9015	50 (20-75)	0.08 (0.04-0.12)

SDJC-SM type inserts > A150-A154
SDNC-SM type inserts > A150-A154
SBN & PCO inserts > B854-B856, B875
SPARE PARTS > Q091
TECHNICAL DATA > R001

● To Order : Please specify

① order number and hand of tool (right/left).

TURNING TOOLS

SMALL TOOLS

OUTLINE OF SMALL TOOLS D002
 CLASSIFICATION..... D004

STANDARD OF SMALL TOOLS

EXTERNAL FRONT TURNING

SCAC-SM D008
 SCLC-SM..... D008
 SDJC-SM..... D009
 SDNC-SM D009
 SVLP-SM D010
 SVJB-SM D010
 SVJC-SM D011
 SVVB-SM..... D011
 SVPP-SM..... D011

EXTERNAL BACK TURNING

BTAH D012
 CTBH D013
 BTVH D014

EXTERNAL GROOVING

GTAH D016
 GTBH..... D016
 GTCH..... D016

EXTERNAL CUTTING OFF

CTAH D018
 CTAH-S..... D018
 CTBH D020
 CTCH D021
 CTDH D022
 CTEH D023

EXTERNAL THREADING

TTAH D024

EXTERNAL FRONT TURNING, COPYING, FACING

SH D026

CAM TYPE TOOL POSTS

CSVH D027

BORING

SBAH..... D030

*Arranged by Alphabetical order

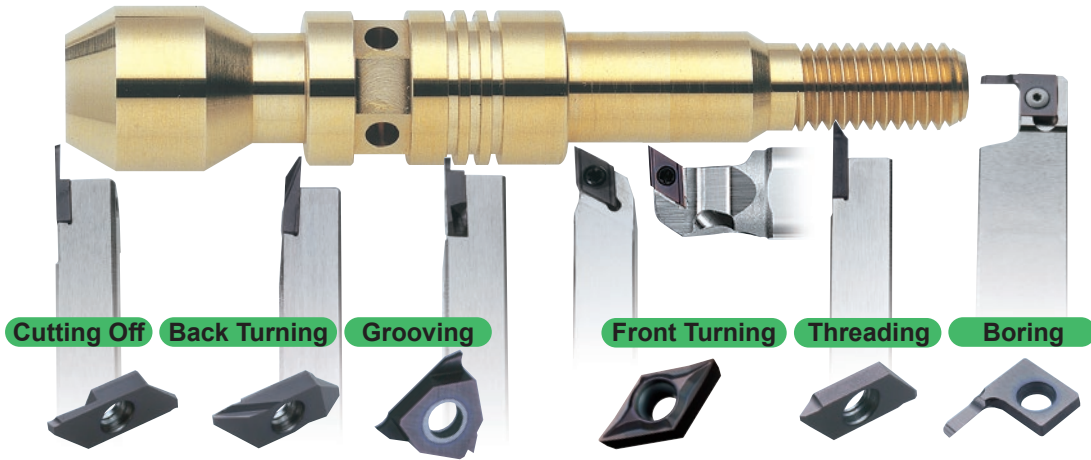
D012 BTAH	D013 CTBH	D030 SBAT INSERTS
D012 BTAT INSERTS	D020 CTBH	D008 SCAC-SM
D013 BTBT INSERTS	D020 CTBT INSERTS	D008 SCLC-SM
D014 BTVH	D021 CTCH	D009 SDJC-SM
D014 BTVT INSERTS	D021 CTCT INSERTS	D009 SDNC-SM
D027 CSVH	D022 CTDH	D026 SH
D028 CSVTBXL INSERTS	D022 CTDH	D010 SVJB-SM
D028 CSVTB INSERTS	D022 CTDH	D011 SVJC-SM
D028 CSVTC INSERTS	D022 CTDH	D010 SVLP-SM
D027 CSVTF INSERTS	D022 CTDH	D011 SVPP-SM
D027 CSVTFXL INSERTS	D022 CTDH	D011 SVVB-SM
D029 CSVTG INSERTS	D022 CTDH	D024 TTAH
D029 CSVTT INSERTS	D022 CTDH	D024 TTAT INSERTS
D018 CTAH	D016 GTAH	
D018 CTAH-S	D016 GTAT INSERTS	
D019 CTAT INSERTS	D016 GTBH	
	D016 GTBT INSERTS	
	D016 GTCH	
	D016 GTCT INSERTS	
	D030 SBAH	



OUTLINE OF SMALL TOOLS

TOOLS FOR GANG TYPE AUTOMATIC LATHES (FOR EXTERNAL TURNING AND BORING)

SMALL TOOLS



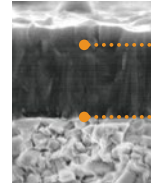
PVD Coated Cemented Carbide Grade for Carbon Steel

MS6015 NEW

Skilled at pure iron, carbon steel and free cutting steel turning and achieving implemented stable finished surfaces and excellent dimensional accuracy.

	MS6015	Conventional
Coating	TiCN multilayer	TiAlN
Hardness (HV)	3,000	2,800
Wear Coefficient (Carbon Steel)	Low	High
Base Material Hardness (HRA)	92.0	92.0
T.R.S (GPa)	2.0	2.0

Ti-C-N Multilayer Coating



Superior wear and welding resistance and demonstrating the best possible results for carbon steel.

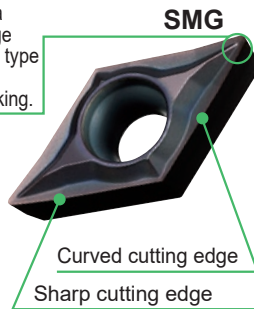
Minute multilayers remarkably improve welding.

● Moulded breaker insert

Nose radii designed with minus tolerance

- Suitable for small parts applications that often require minus tolerance dimensions.
- The order number is shown with the letter "M" that indicates minus tolerance. ex) DCGT11T301M-FS
- The radius value is printed on the side of the insert label for easy recognition.

A combination of a curved cutting edge and the protrusion type breaker promotes efficient chip breaking.



SMG

FS

FS-P

● Tolerance Corner R



E class
RE $_{-0.02}^0$ mm

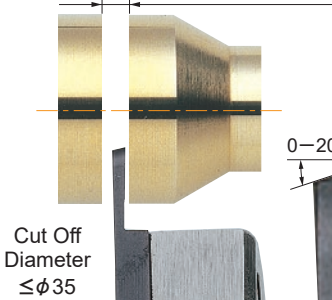


LS

LS-P

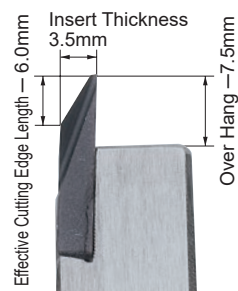
The letter "M" insert
RE $_{-0.05}^0$ mm
(Conventional G-class insert)
RE ± 0.10 mm

● Cutting Off Cutting Edge Width 0.7-3.0mm



Cut Off Diameter $\leq \phi 35$

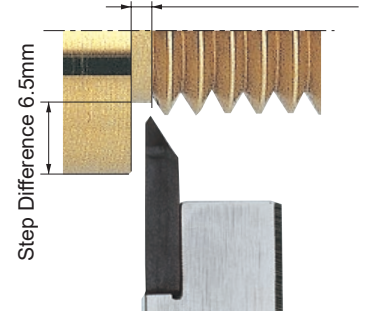
● Back Turning



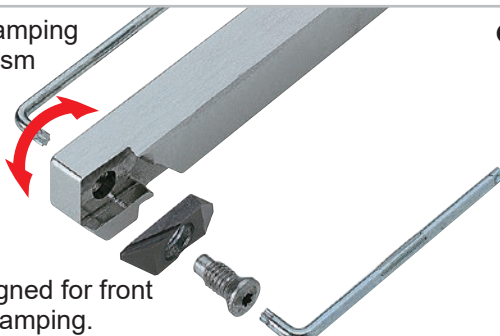
Inserts for Moulded Back Turning
SMB Breaker
NEW



● Threading Can machine to the end face



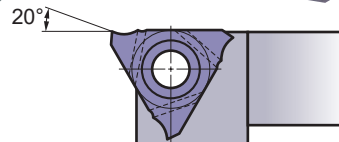
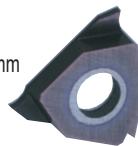
● Back Clamping Mechanism



Screw designed for front and back clamping.

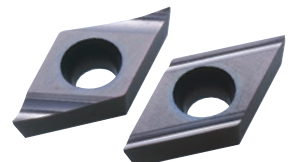
● Grooving

- 3-cornered
- Groove width 0.3-3.0mm
- Traversing possible



● Front Turning

- ISO E class accuracy inserts
- A wide variety of small corner R inserts
- Rake angle 30°



Tools for a very wide range of small parts machining

External Turning	Tools for front turning, back turning, grooving, threading, and cutting off
Internal Turning	Tools for boring, internal grooving and internal threading
Drilling	Drills
End Milling	End Mills

Tools for CNC automatic and small lathes

Types of Tool Posts	Gang type, turret type, cam type (radial pattern type)
Tool Sizes	Square shank: 8–16 mm Round shank : less than $\phi 25.4$

Indexable inserts developed under the concept of "high quality, high efficiency and long tool life."

High Quality	E class tolerance, sharp cutting edge, high accuracy small corner R, smooth surface finish
Long Tool Life	PVD coating MS6015/VP15TF/MP9005/MP9015
High Efficiency	Regrinding not necessary due to the employment of indexable inserts. A wide variety of top cutting edge geometries

TOOLS FOR CAM TYPE AUTOMATIC LATHES

- The most suitable for the use with cam type automatic lathes (radial pattern tool posts)
- The most suitable for machining of small parts with work diameter 5mm or smaller
- Single holder for front turning, back turning, grooving, threading and cutting off operations



D
SMALL TOOLS

INTERNAL TURNING TOOLS

Solid type **MICRO-MINI TWIN Boring Bars**

Boring
Grooving
Threading

Minimum cutting diameter $\phi 2.2$ –

Round Shank

Square Shank

MICRO-DEX Boring Bars

Minimum cutting diameter $\phi 5.0$ –



Minimum cutting diameter $\phi 10.0$ –

DIMPLE BAR

DRILLING TOOLS

Violet Coated Precision Drills

VAPDS/VAPDM (General)
VAPDSSUS/VAPDMSUS (For stainless steel)
VAPDSCB (For counter boring)

Solid Carbide Drill

MVS/MVE

Solid Carbide Flat Bottom Drills

MFE NEW

Solid Carbide Drills for Centreing and Chamfering

DLE NEW

Micro Solid Carbide Drills

MSE Drills
MSE/MSP (Centre Drills)

Solid Gun Drill

Micro Solid Carbide Gun Drill with through coolant holes
MGS

END MILLING TOOLS

Solid Carbide End Mill

MSTAR End Mill Series

Vibration Control End Mills for Machining Difficult-to-Cut Materials

SMART MIRACLE End Mill Series



CLASSIFICATION OF EXTERNAL TURNING TOOLS

GANG TYPE TOOL POSTS

● FRONT TURNING

Name of Tool Holder	Shank Size (mm) (H x W x L)	Geometry
SCAC-SM ↻ D008	8 x 8 x 125 10 x 10 x 125 12 x 12 x 150 16 x 16 x 150	90° KAPR
SCLC-SM ↻ D008	8 x 8 x 125 10 x 10 x 125 12 x 12 x 150 16 x 16 x 150	95° KAPR
SDJC-SM ↻ D009	8 x 8 x 125 10 x 10 x 125 12 x 12 x 150 16 x 16 x 150	93° KAPR
SDNC-SM ↻ D009	8 x 8 x 125 10 x 10 x 125 12 x 12 x 150 16 x 16 x 150	62.5° KAPR
SVLP-SM ↻ D010	10 x 10 x 125 12 x 12 x 150 16 x 16 x 150	95° KAPR
SVJB-SM ↻ D010	10 x 10 x 125 12 x 12 x 150 16 x 16 x 150	93° KAPR
SVJC-SM NEW ↻ D011	10 x 10 x 120 12 x 12 x 120 16 x 16 x 120	93° KAPR
SVPP-SM ↻ D011	10 x 10 x 125 12 x 12 x 150 16 x 16 x 150	117.5° KAPR
SVVB-SM ↻ D011	10 x 10 x 125 12 x 12 x 150 16 x 16 x 150	72.5° KAPR

● BACK TURNING

Name of Tool Holder	Shank Size (mm) (H x W x L)	Geometry
BTAH (Insert Size 2.8, 3.5, 5.0mm) ↻ D012	8 x 10 x 120 10 x 10 x 120 12 x 12 x 120 16 x 16 x 120	
CTBH (Insert Size 4.5, 6.0mm) ↻ D013	10 x 10 x 120 12 x 12 x 120 16 x 16 x 120	
BTVH (Insert Size 7.5mm) ↻ D014	10 x 10 x 120 12 x 12 x 120 16 x 16 x 120	53° KAPR

● THREADING

Name of Tool Holder	Shank Size (mm) (H x W x L)	Geometry
TTAH ↻ D024	8 x 10 x 120 10 x 10 x 120 12 x 12 x 120 16 x 16 x 120	

● GROOVING

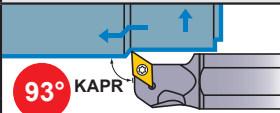
Name of Tool Holder	Shank Size (mm) (H x W x L)	Geometry
GTAH (Groove Width 0.3—3.0mm) ↻ D016	8 x 8 x 80 8 x 8 x 120 10 x 10 x 80 10 x 10 x 120 12 x 12 x 80 12 x 12 x 120 16 x 16 x 120	U Type ↑ E Type ↑ VT Type ↑
GTBH (Groove Width 1.45—3.0mm) ↻ D016	10 x 10 x 80 10 x 10 x 120 12 x 12 x 120 16 x 16 x 120	U Type ↑ E Type ↑ VT Type ↑
GTCH (Groove Width 2.5—3.0mm) ↻ D016	10 x 10 x 80 10 x 10 x 120	U Type ↑ E Type ↑ VT Type ↑

● CUTTING OFF

Name of Tool Holder	Shank Size (mm) (H x W x L)	Geometry
CTAH (Max. Cut Off Diameter 12mm) ↻ D018	8 x 10 x 120 10 x 10 x 120 12 x 12 x 120 16 x 16 x 120	
CTAH-S (Max. Cut Off Diameter 12mm) ↻ D018	10 x 10 x 80	
CTBH (Max. Cut Off Diameter 16mm) ↻ D020	10 x 10 x 120 12 x 12 x 120 16 x 16 x 120	
CTCH (Max. Cut Off Diameter 20mm) ↻ D021	10 x 10 x 120 12 x 12 x 120	
CTDH (Max. Cut Off Diameter 23—35mm) ↻ D022	16 x 16 x 120 16 x 16 x 125	
CTEH (Max. Cut Off Diameter 23—35mm) ↻ D023	16 x 16 x 120 16 x 16 x 125	

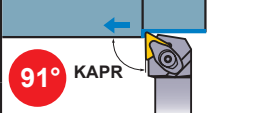
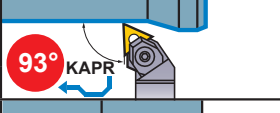
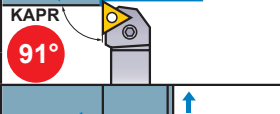


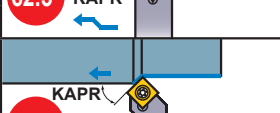
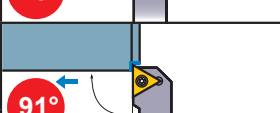
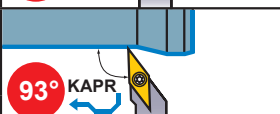


OPPOSITE TOOL POSTS

● DIMPLE SLEEVE HOLDER

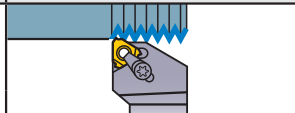
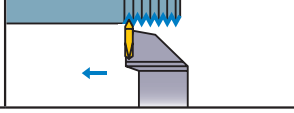
Name of Tool Holder	Shank Size (mm) (Shank Dia. x L)	Geometry
SH (Front Turning, Copying, Facing)	$\phi 15.875 \times 100$ $\phi 19.05 \times 125$ $\phi 20 \times 125$ $\phi 22 \times 125$ $\phi 25.4 \times 150$	
\rightarrow D026		

TURRET TYPE TOOL POSTS

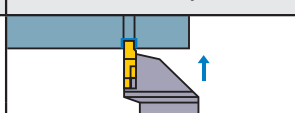
● FRONT TURNING

Name of Tool Holder	Shank Size (mm) (H x W x L)	Geometry
DTGN	16 x 16 x 100 20 x 20 x 125 25 x 25 x 150	
\rightarrow C016		
MTJN	20 x 20 x 125 25 x 25 x 150	
\rightarrow C017		
PTGN	10 x 10 x 70 12 x 12 x 80 16 x 16 x 100 20 x 20 x 125 25 x 25 x 150	
\rightarrow C016		
SCLC	8 x 8 x 60 10 x 10 x 70 12 x 12 x 80 16 x 16 x 100	
\rightarrow C022		
SDJC	10 x 10 x 70 12 x 12 x 80 16 x 16 x 100	
\rightarrow C023		
SDNC	8 x 8 x 60 10 x 10 x 70 12 x 12 x 80 16 x 16 x 100	
\rightarrow C023		
SSSC	12 x 12 x 80 16 x 16 x 100	
\rightarrow C026		
STGC	10 x 10 x 70 12 x 12 x 80 16 x 16 x 100	
\rightarrow C027		
SVJC	10 x 10 x 70 16 x 16 x 100	
\rightarrow C028		
SVVC	16 x 16 x 100	
\rightarrow C028		

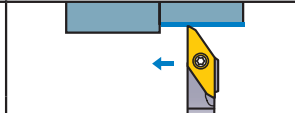
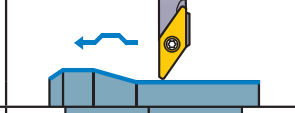
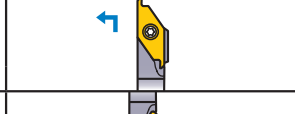
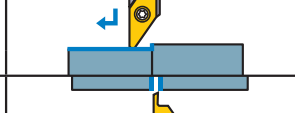
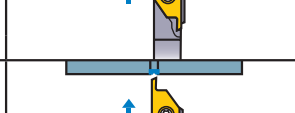
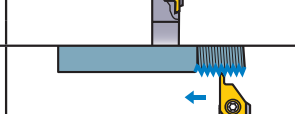

● THREADING

Name of Tool Holder	Shank Size (mm) (H x W x L)	Geometry
MMT	12 x 12 x 100 16 x 16 x 100 20 x 20 x 125 25 x 25 x 150 32 x 32 x 170	
\rightarrow G019		
SMGH	10 x 10 x 70 12 x 12 x 80 16 x 16 x 100	
\rightarrow G026		

● GROOVING

Name of Tool Holder	Shank Size (mm) (H x W x L)	Geometry
SMGH	10 x 10 x 70 12 x 12 x 80 16 x 16 x 100	
\rightarrow F118		

CAM TYPE TOOL POSTS

Name of Tool Holder	Shank Size (mm) (H x W x L)	Geometry
CSVH (Front Turning)	7 x 7 x 140 8 x 8 x 140 9.5 x 9.5 x 140 10 x 10 x 140 12 x 12 x 140	
\rightarrow D027		
CSVH (Front Turning Copying)	7 x 7 x 140 8 x 8 x 140 9.5 x 9.5 x 140 10 x 10 x 140 12 x 12 x 140	
\rightarrow D027		
CSVH (Back Turning)	7 x 7 x 140 8 x 8 x 140 9.5 x 9.5 x 140 10 x 10 x 140 12 x 12 x 140	
\rightarrow D027		
CSVH (Back Turning Copying)	7 x 7 x 140 8 x 8 x 140 9.5 x 9.5 x 140 10 x 10 x 140 12 x 12 x 140	
\rightarrow D027		
CSVH (Cutting Off)	7 x 7 x 140 8 x 8 x 140 9.5 x 9.5 x 140 10 x 10 x 140 12 x 12 x 140	
\rightarrow D027		
CSVH (Grooving)	7 x 7 x 140 8 x 8 x 140 9.5 x 9.5 x 140 10 x 10 x 140 12 x 12 x 140	
\rightarrow D027		
CSVH (Threading)	7 x 7 x 140 8 x 8 x 140 9.5 x 9.5 x 140 10 x 10 x 140 12 x 12 x 140	
\rightarrow D027		

CLASSIFICATION OF INTERNAL TURNING TOOLS (FOR GENERAL USE)

D
SMALL TOOLS

Product Name	Holder
For Gang Type Tool Posts ➔ D030	SBAH  Min. Cutting Diameter : 3mm
MICRO-MINI TWIN Boring Bars (Solid Carbide) ➔ E019	CB CR  Min. Cutting Diameter : 2.2mm
MICRO-MINI Boring Bars (Solid Carbide) ➔ E022	COFR-BLS  Min. Cutting Diameter : 3.2mm
MICRO-DEX Boring Bars (Carbide Shank) ➔ E016	SCLC  Min. Cutting Diameter : 5mm
MICRO-DEX Boring Bars (Carbide Shank) ➔ E017	STUC  Min. Cutting Diameter : 8mm
MICRO-DEX Boring Bars (Carbide Shank) ➔ E016	SWUB  Min. Cutting Diameter : 6mm
F type Bars (Steel Shank) ➔ E027	FSWL1  Min. Cutting Diameter : 5.8mm
F type Bars (Carbide Shank) ➔ E027	FSWL2  Min. Cutting Diameter : 5.8mm
DIMPLE BAR (Steel Shank) (Carbide Shank) ➔ E006	FSCLC/P FSCLC/P-E  Min. Cutting Diameter : 10mm

Product Name	Holder
DIMPLE BAR (Steel Shank) (Carbide Shank) ➔ E008	FSDUC FSDUC-E  Min. Cutting Diameter : 14mm
DIMPLE BAR (Steel Shank) (Carbide Shank) ➔ E009	FSDQC FSDQC-E  Min. Cutting Diameter : 13mm
DIMPLE BAR (Steel Shank) (Carbide Shank) ➔ E007	FSTUP FSTUP-E  Min. Cutting Diameter : 10mm
DIMPLE BAR (Steel Shank) ➔ E011	FSVUB/C  Min. Cutting Diameter : 16mm
DIMPLE BAR (Steel Shank) ➔ E011	FSVPB/C  Min. Cutting Diameter : 16mm
DIMPLE BAR (Steel Shank) ➔ E012	FSVJB/C  Min. Cutting Diameter : 16mm
DIMPLE BAR (Steel Shank) (Carbide Shank) ➔ E010	FSWUB/P FSWUB/P-E  Min. Cutting Diameter : 10mm

CLASSIFICATION OF INTERNAL TURNING TOOLS (GROOVING/THREADING) (END MILLING/DRILLING)



FOR GROOVING AND THREADING

Product Name	Holder
MICRO-MINI TWIN Boring Bars (Solid Type) ➔ F120	CG TYPE(Grooving)  Min. Cutting Diameter : 3mm
MICRO-MINI TWIN Boring Bars (Solid Type) ➔ G033	CT TYPE(Threading)  Min. Cutting Diameter : 3mm
F type Bars (Steel Shank) (Carbide Shank) (Grooving) (Threading) ➔ F124	FSL51 FSL52  Min. Cutting Diameter : 10mm

END MILLS

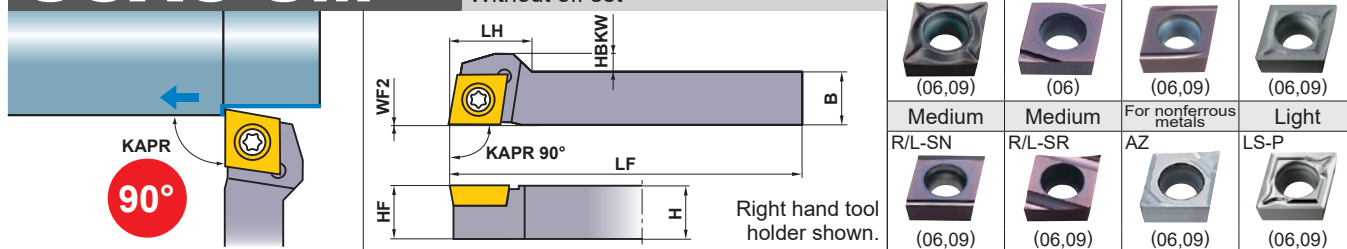
Solid Carbide End Mill series	➔ J024
HSS End Mill series	➔ J044

DRILLS

Product Name	Series Title
NEW Leading Drills ➔ P012	DLE series 
NEW Flat Bottom Drills ➔ P015	MFE series 
DLE series	➔ P012
MFE series	➔ P015
MVX/TAF Drill (Indexable type)	➔ P230
Solid Carbide Drill series	➔ P004
Solid Gun Drill series	➔ P130
HSS Drill series	➔ P008

EXTERNAL FRONT TURNING

SCAC-SM

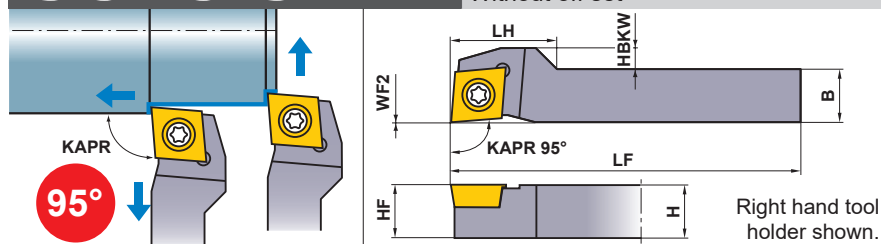


Finish	Finish	Light	Light
SMG/FS (06,09)	R/L-F (06)	R/L-SS (06,09)	LS (06,09)
Medium R/L-SN (06,09)	Medium R/L-SR (06,09)	For nonferrous metals AZ (06,09)	Light LS-P (06,09)

Order Number	Stock		Insert Number	Dimensions (mm)							* Clamp Screw	Wrench	
	R	L		H	B	LF	LH	HBKW	HF	WF2			
SCACR/L0808K06-SM	●	●	CC●B CC●H CC●T CC●W	0602	8	8	125	11	1.6	8	0	TS254	TKY08R
SCACR/L1010K06-SM	●	●		0602	10	10	125	—	—	10	0	TS254	TKY08R
SCACR/L1010K09-SM	●	●		09T3	10	10	125	16	3.5	10	0	TS43	TKY15R
SCACR/L1212M09-SM	●	●		09T3	12	12	150	14	1.5	12	0	TS43	TKY15R
SCACR/L1616M09-SM	●	●		09T3	16	16	150	—	—	16	0	TS43	TKY15R

* Clamp Torque (N · m) : TS254=1.0, TS43=3.5

SCLC-SM



Finish	Finish	Light	Light
SMG/FS (06,09)	R/L-F (06)	R/L-SS (06,09)	LS (06,09)
Medium R/L-SN (06,09)	Medium R/L-SR (06,09)	For nonferrous metals AZ (06,09)	Light LS-P (06,09)

Order Number	Stock		Insert Number	Dimensions (mm)							* Clamp Screw	Wrench	
	R	L		H	B	LF	LH	HBKW	HF	WF2			
SCLCR/L0808K06-SM	●	●	CC●B CC●H CC●T CC●W	0602	8	8	125	11	2.1	8	0	TS254	TKY08R
SCLCR/L1010K06-SM	●	●		0602	10	10	125	—	—	10	0	TS254	TKY08R
SCLCR/L1010K09-SM	●	●		09T3	10	10	125	20	4	10	0	TS43	TKY15R
SCLCR/L1212M09-SM	●	●		09T3	12	12	150	18	2	12	0	TS43	TKY15R
SCLCR/L1616M09-SM	●	●		09T3	16	16	150	—	—	16	0	TS43	TKY15R

* Clamp Torque (N · m) : TS254=1.0, TS43=3.5

Note1) The insert photos are only examples. The letters refer to the chip breaker and the dimension refers to the inscribed circle.

Note2) Dimensions shown for insert corner RE 0.2.

● : Inventory maintained in Japan.

SCAC-SM type inserts	> A140 – A147
SCLC-SM type inserts	> A140 – A147
CBN & PCD inserts	> B049 – B052, B072

SDJC-SM		Without off set									Finish	Finish	Light	Light
											SMG/FS (07, 11)	R/L-F (07, 11)	R/L-SS (07, 11)	LS (07, 11)
Order Number		Stock	Insert Number		Dimensions (mm)									
		R L			H	B	LF	LH	HBKW	HF	WF2	Clamp Screw	Wrench	
SDJCR/L0808K07-SM	●●		DCMT DCMW DCET DCGT DCGW	0702	8	8	125	15	2	8	0	TS254	TKY08R	
SDJCR/L1010K07-SM	●●			0702	10	10	125	—	—	10	0	TS254	TKY08R	
SDJCR/L1010K11-SM	●●			11T3	10	10	125	24	4	10	0	TS43	TKY15R	
SDJCR/L1212M11-SM	●●			11T3	12	12	150	22	2	12	0	TS43	TKY15R	
SDJCR/L1616M11-SM	●●			11T3	16	16	150	—	—	16	0	TS43	TKY15R	

* Clamp Torque (N · m) : TS254=1.0, TS43=3.5

SDNC-SM		Neutral edge with handed holder Without off set									Finish	Finish	Light	Light
											SMG/FS (07, 11)	R/L-F (07, 11)	R/L-SS (07, 11)	LS (07, 11)
Order Number		Stock	Insert Number		Dimensions (mm)									
		R L			H	B	LF	LH	HBKW	HF	WF2	Clamp Screw	Wrench	
SDNCR/L0808K07-SM	●●		DCMT DCMW DCET DCGT DCGW	0702	8	8	125	—	—	8	3	TS254	TKY08R	
SDNCR/L1010K07-SM	●●			0702	10	10	125	—	—	10	3	TS254	TKY08R	
SDNCR/L1010K11-SM	●●			11T3	10	10	125	24	2	10	5	TS43	TKY15R	
SDNCR/L1212M11-SM	●●			11T3	12	12	150	—	—	12	5	TS43	TKY15R	
SDNCR/L1616M11-SM	●●			11T3	16	16	150	—	—	16	5	TS43	TKY15R	

* Clamp Torque (N · m) : TS254=1.0, TS43=3.5

RECOMMENDED CUTTING CONDITIONS

Work Material	Hardness	Grade	Cutting Speed (m/min)	Feed (mm/rev)
P Carbon Steel · Alloy Steel	180HB–280HB	MS6015/VP15TF	100 (50–150)	0.08 (0.01–0.15)
		MS6015	110 (30–180)	0.08 (0.01–0.15)
	Free Cutting Steel	—	NX2525	150 (50–250)
M Stainless Steel	≤200HB	VP15TF/MP9005/MP9015	80 (50–120)	0.06 (0.02–0.1)
N Non-Ferrous Metal	—	HTi10/MT9005	150 (70–230)	0.09 (0.03–0.15)
S Titanium Alloy	—	MT9005	60 (40–80)	0.08 (0.04–0.12)
		MP9015	50 (20–75)	0.08 (0.04–0.12)

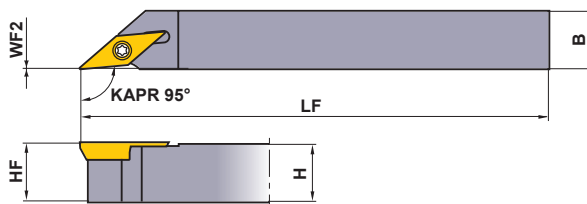
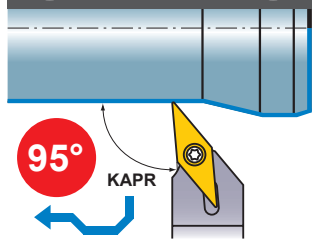
SDJC-SM type inserts > A149–A154
SDNC-SM type inserts > A149–A154

CBN & PCD inserts > B054–B056, B073
SPARE PARTS > Q001
TECHNICAL DATA > R001

EXTERNAL FRONT TURNING

SVLP-SM

Without off set



Right hand tool holder shown.

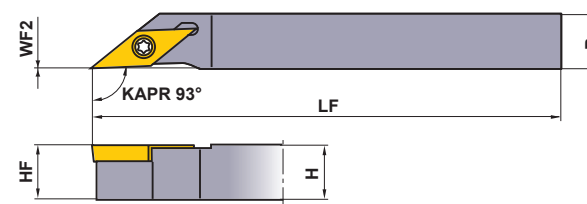
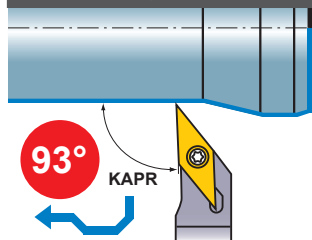


Order Number	Stock		Insert Number	Dimensions (mm)					* Clamp Screw	Wrench	
	R	L		H	B	LF	HF	WF2			
SVLPR/L1010K08-SM	●	●	VPET VPGT	0802	10	10	125	10	0	TS202	TKY06R
SVLPR/L1212M08-SM	●	●		0802	12	12	150	12	0	TS202	TKY06R
SVLPR/L1010K11-SM	●	●		1103	10	10	125	10	0	TS255	TKY08R
SVLPR/L1212M11-SM	●	●		1103	12	12	150	12	0	TS255	TKY08R
SVLPR/L1616M11-SM	●	●		1103	16	16	150	16	0	TS255	TKY08R

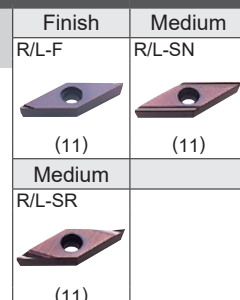
* Clamp Torque (N · m) : TS202=0.6, TS255=1.0

SVJB-SM

Without off set



Right hand tool holder shown.



Order Number	Stock		Insert Number	Dimensions (mm)					* Clamp Screw	Wrench	
	R	L		H	B	LF	HF	WF2			
SVJBR/L1010K11-SM	●	●	VBMT VBET VBGT VBGW	1103	10	10	125	10	0	TS255	TKY08R
SVJBR/L1212M11-SM	●	●		1103	12	12	150	12	0	TS255	TKY08R
SVJBR/L1616M11-SM	●	●		1103	16	16	150	16	0	TS255	TKY08R

* Clamp Torque (N · m) : TS255=1.0

RECOMMENDED CUTTING CONDITIONS

	Work Material	Hardness	Grade	Cutting Speed (m/min)	Feed (mm/rev)
P	Carbon Steel · Alloy Steel	180HB-280HB	MS6015/VP15TF	100 (50-150)	0.08 (0.01-0.15)
	Free Cutting Steel	-	MS6015	110 (30-180)	0.08 (0.01-0.15)
			NX2525	150 (50-250)	0.08 (0.01-0.15)
M	Stainless Steel	≤200HB	VP15TF/MP9005/MP9015	80 (50-120)	0.06 (0.02-0.1)
N	Non-Ferrous Metal	-	HT110/MT9005	150 (70-230)	0.09 (0.03-0.15)
S	Titanium Alloy	-	MT9005	60 (40-80)	0.08 (0.04-0.12)
	Heat Resistant Alloy	-	MP9015	50 (20-75)	0.08 (0.04-0.12)

Note1) The insert photos are only examples. The letters refer to the chip breaker and the dimension refers to the inscribed circle.

Note2) Dimensions shown for insert corner RE 0.2.

● : Inventory maintained in Japan.

SVLP-SM type inserts > A174
 SVJB-SM type inserts > A167-A169
 CBN & PCD inserts > B061, B077

Order Number		Stock		Insert Number		Dimensions (mm)				*		
						H	B	LF	HBKW	HF	WF2	Clamp Screw
SVJCR/L1010JX11-SM	●●	●●	VCMW VCMT VCGT	1103	10	10	120	—	10	0	TS255	TKY08R
SVJCR/L1212JX11-SM	●●	●●		1103	12	12	120	—	12	0	TS255	TKY08R
SVJCR/L1616JX11-SM	●●	●●		1103	16	16	120	—	16	0	TS255	TKY08R
SVJCR/L1010JX13-SM	●●	●●		1303	10	10	120	2	10	0	TS32	TKY08R
SVJCR/L1212JX13-SM	●●	●●		1303	12	12	120	—	12	0	TS32	TKY08R
SVJCR/L1616JX13-SM	●●	●●		1303	16	16	120	—	16	0	TS32	TKY08R

* Clamp Torque (N · m) : TS255=1.0, TS32=1.0

● = NEW

Order Number		Stock		Insert Number		Dimensions (mm)				*			
						H	B	LF	LH	HBKW	HF	WF2	Clamp Screw
SVPPR/L1010K11-SM	●●	●●	VPET VPGT	1103	10	10	125	20	8	10	0	TS255	TKY08R
SVPPR/L1212M11-SM	●●	●●		1103	12	12	150	20	6	12	0	TS255	TKY08R
SVPPR/L1616M11-SM	●●	●●		1103	16	16	150	17	—	16	0	TS255	TKY08R

* Clamp Torque (N · m) : TS255=1.0

Order Number		Stock		Insert Number		Dimensions (mm)				*	
						H	B	LF	HF	WF2	Clamp Screw
SVVBR/L1010K11-SM	●●	●●	VBET VBGT VBMT VBGW	1103	10	10	125	10	3	TS255	TKY08R
SVVBR/L1212M11-SM	●●	●●		1103	12	12	150	12	3	TS255	TKY08R
SVVBR/L1616M11-SM	●●	●●		1103	16	16	150	16	3	TS255	TKY08R

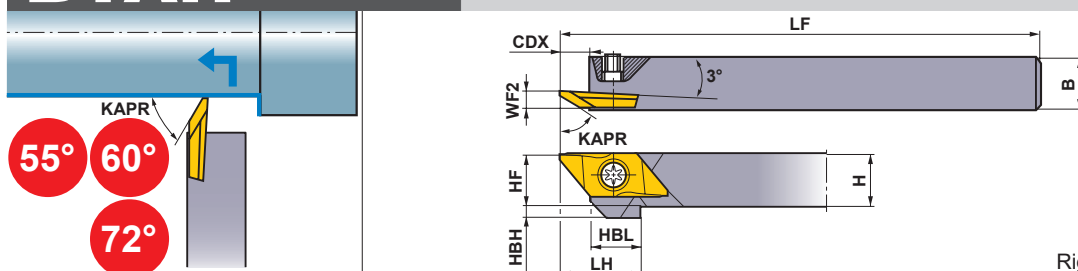
* Clamp Torque (N · m) : TS255=1.0

SVJC-SM type inserts > A170–A172
 SVPP-SM type inserts > A174
 SVVB-SM type inserts > A167–A169

CBN & PCD inserts > B061, B077
 SPARE PARTS > Q001
 TECHNICAL DATA > R001

EXTERNAL BACK TURNING

BTAH



Right hand tool holder shown.

Order Number	Stock		Insert Number	Dimensions (mm)										Clamp Screw *	Wrench		
	R	L		H	B	LF	LH	HF	WF2	HBH	HBL	CDX					
BTAHR/L0810-50	●	●	BTAT	5528	○	R/L-B	8	10	120	15	8	3.5	4	9.5	5.5	NS402W	NKY15S
BTAHR/L1010-50	●	●		6035	○	R/L-B	10	10	120	15	10	3.5	2	9.5	5.5	NS402W	NKY15S
BTAHR/L1212-50	●	●		605000RX			12	12	120	15	12	3.5	—	9.5	5.5	NS403W	NKY15S
BTAHR/L1616-50	●	●		7235	○	R-SMB	16	16	120	15	16	3.5	—	9.5	5.5	NS403W	NKY15S

Note 1) Please use right hand insert for right hand holder and left hand insert for left hand holder.

Note 2) Set the maximum depth of cut at under 60% of the effective cutting edge length (LE).

* Clamp Torque (N · m) : NS402W=1.0, NS403W=1.0

INSERTS

Order Number	Hand	Coated		Dimensions (mm)							LE* (mm)	Geometry
		VP15TF	NEW MS6015	PSIRRL*	RER/L	CF	L	W1	CW	S		
NEW BTAT7235V5R-SMB	R	●		72°	0.05	0.3	20	8	1.4	2.5	3.5	With Breaker
NEW BTAT723501MR-SMB	R	●		72°	0.08	0.3	20	8	1.4	2.5	3.5	
NEW BTAT723502MR-SMB	R	●		72°	0.18	0.3	20	8	1.4	2.5	3.5	
BTAT552800R-B	R	●	●	55°	0	0	20	8	0.5	2.5	2.8	SMB Type (Moulded) B Type (Grinding)
BTAT552800L-B	L	●		55°	0	0	20	8	0.5	2.5	2.8	
BTAT552801R-B	R	●	●	55°	0.1	0	20	8	0.5	2.5	2.8	
BTAT552801L-B	L	●		55°	0.1	0	20	8	0.5	2.5	2.8	
BTAT603500R-B	R	●	●	60°	0	0	20	8	0.5	2.5	3.5	
BTAT603500L-B	L	●		60°	0	0	20	8	0.5	2.5	3.5	
NEW BTAT603501MR-B	R		●	60°	0.08	0	20	8	0.5	2.5	3.5	
BTAT603501R-B	R	●	●	60°	0.1	0	20	8	0.5	2.5	3.5	
BTAT603501L-B	L	●		60°	0.1	0	20	8	0.5	2.5	3.5	
BTAT605000RX	R	●		60°	0	0	20	8	1.25	2.5	5.0	

Note 1) REL, PSIRR dimensions for Right Hand Tool and RER, PSIRL dimensions for Left Hand Tool.

● = NEW

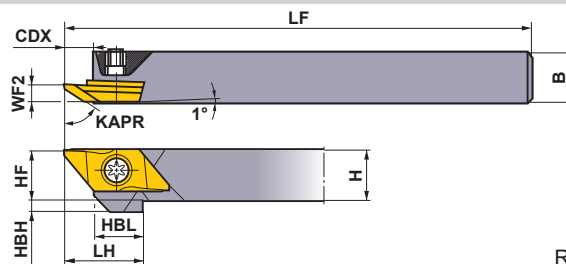
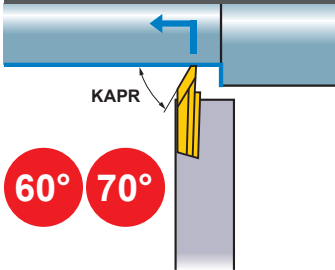
* Numeric value set insert on holder.

RECOMMENDED CUTTING CONDITIONS



	Work Material	Hardness	Grade	Cutting Speed (m/min)	Feed (mm/rev)
P	Carbon Steel · Alloy Steel	180HB–280HB	MS6015/VP15TF	100 (50–150)	0.08 (0.01–0.15)
	Free Cutting Steel	—	MS6015	110 (30–180)	0.08 (0.01–0.15)
M	Stainless Steel	≤200HB	VP15TF	80 (50–120)	0.06 (0.02–0.1)
N	Non-Ferrous Metal	—	MS6015	150 (70–230)	0.09 (0.03–0.15)

● : Inventory maintained in Japan. (5 inserts in one case)

CTBH



Right hand tool holder shown.

Order Number	Stock		Insert Number	Dimensions (mm)									*  				
	R	L		H	B	LF	LH	HF	WF2	HBH	HBL	CDX	Clamp Screw	Wrench			
CTBHR/L1010-160	●	●	BTBT	60450	○	R/L-B	10	10	120	19.5	10	3.4	2	12	7.5	NS402W	NKY15S
CTBHR/L1212-160	●	●		606000	R/L	12	12	120	19.5	12	3.4	—	12	7.5	NS403W	NKY15S	
CTBHR/L1616-160	●	●		7055	○	R-SMB	16	16	120	19.5	16	3.4	—	12	7.5	NS403W	NKY15S

Note 1) Please use right hand insert for right hand holder and left hand insert for left hand holder.

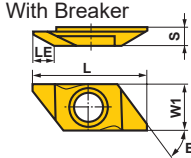
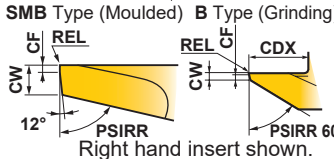
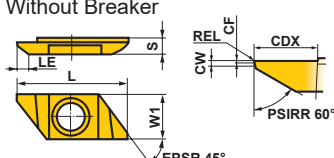
Note 2) Set the maximum depth of cut at under 60% of the effective cutting edge length (LE).

* Clamp Torque (N · m) : NS402W=1.0, NS403W=1.0

D

SMALL TOOLS

INSERTS

Order Number	Hand	Coated		Dimensions (mm)									LE* (mm)	Geometry
		VP15TF	NEW MS6015	PSIRRL*	RER/L	CF	L	W1	CW	S	CDX			
NEW BTBT7055V5R-SMB	R	●		70°	0.05	0.3	25	9.4	1.35	3.5	6.5	5.5	 <p>With Breaker</p>	
NEW BTBT705501MR-SMB	R	●		70°	0.08	0.3	25	9.4	1.35	3.5	6.5	5.5		
NEW BTBT705502MR-SMB	R	●		70°	0.18	0.3	25	9.4	1.35	3.5	6.5	5.5		
BTBT604500R-B	R	●	●	60°	0	0.2	25	9.4	0.7	3.5	5.5	4.5	 <p>SMB Type (Moulded) B Type (Grinding)</p>	
BTBT604500L-B	L	●		60°	0	0.2	25	9.4	0.7	3.5	5.5	4.5		
NEW BTBT604501MR-B	R		●	60°	0.08	0.3	25	9.4	0.7	3.5	5.5	4.5		
BTBT604501R-B	R	●	●	60°	0.1	0.3	25	9.4	0.7	3.5	5.5	4.5		
BTBT604501L-B	L	●		60°	0.1	0.3	25	9.4	0.7	3.5	5.5	4.5		
BTBT606000R	R	●		60°	0	0.2	25	9.4	0.7	3.5	7	6.0	 <p>Without Breaker</p>	
BTBT606000L	L	●		60°	0	0.2	25	9.4	0.7	3.5	7	6.0		

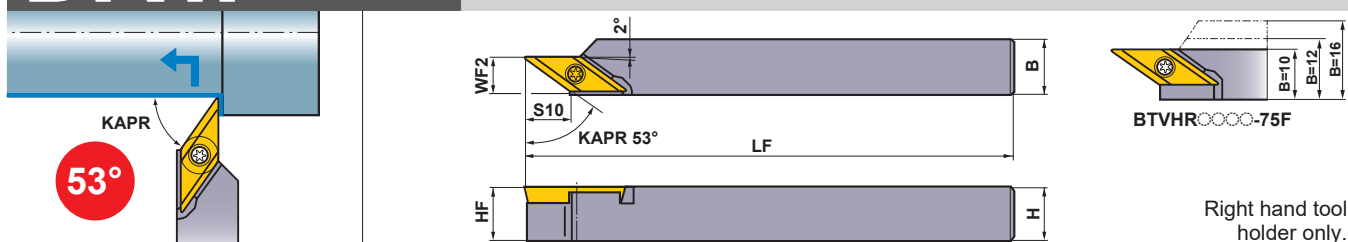
Note 1) REL, PSIRR dimensions for Right Hand Tool and RER, PSIRL dimensions for Left Hand Tool.

* Numeric value set insert on holder.

● = NEW

EXTERNAL BACK TURNING

BTVH



SMALL TOOLS

D

Order Number	Stock	Insert Number	Dimensions (mm)						*	
	R		H	B	LF	HF	WF2	S10	Clamp Screw	Wrench
BTVHR1010-75	●	BTVT 537500R-B	10	10	120	10	7.5	8.5	NS251	NKY15S
BTVHR1212-75	●		12	12	120	12	7.5	8.5	NS251	NKY15S
BTVHR1616-75	●		16	16	120	16	7.5	8.5	NS251	NKY15S
BTVHR1010-75F	●		10	10	120	10	10.0	8.5	NS251	NKY15S
BTVHR1212-75F	●		12	12	120	12	10.0	8.5	NS251	NKY15S
BTVHR1616-75F	●		16	16	120	16	10.0	8.5	NS251	NKY15S

Note 1) Set the maximum depth of cut at under 30% of the effective cutting edge length (LE).

Note 2) For high load machining, F type is recommended.

* Clamp Torque (N · m) : NS251=1.0

INSERTS

Order Number	Hand	Coated	Dimensions (mm)				LE* (mm)	Geometry
		VP15TF	IC	S	REL	CW		
BTVT5375V5R-B	R	●	6.35	3.18	0.05	0.5	7.5	With Breaker
BTVT537501R-B	R	●	6.35	3.18	0.1	0.5	7.5	

* Numeric value set insert on holder.

RECOMMENDED CUTTING CONDITIONS

	Work Material	Hardness	Grade	Cutting Speed (m/min)	Feed (mm/rev)
P	Carbon Steel · Alloy Steel	180HB-280HB	VP15TF	100 (50-150)	0.08 (0.01-0.15)
	Free Cutting Steel	-	VP15TF	110 (30-180)	0.08 (0.01-0.15)
M	Stainless Steel	≤200HB	VP15TF	80 (50-120)	0.06 (0.02-0.1)
N	Non-Ferrous Metal	-	VP15TF	150 (70-230)	0.09 (0.03-0.15)

● : Inventory maintained in Japan. (5 inserts in one case)

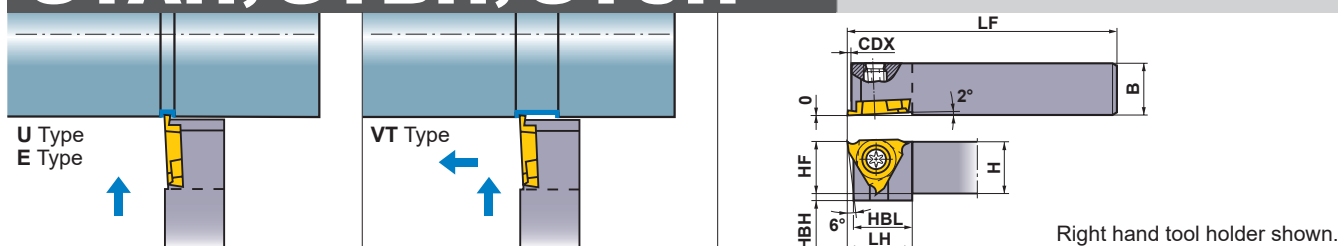
SPARE PARTS > Q001
TECHNICAL DATA > R001

Memo

A series of horizontal dashed lines for writing, spanning the width of the page.

EXTERNAL GROOVING

GTAH, GTBH, GTCH



Right hand tool holder shown.

SMALL TOOLS

D

	Order Number	Stock		Insert Number	Dimensions (mm)							Cutting Width (mm)	*2		
		R	L		H	B	HF	LF	CDX*1	LH	HBH		HBL	Clamp Screw	Wrench
Standard Shank	GTAHR/L0808-20S	●	●	GTAT GTBT *1 GTCT *1	8	8	8	80	2	15	5	12.9	0.3-3.0	NS404W	NKY15S
	GTAHR/L1010-20S	●	●		10	10	10	80	2	15	3	12.9	0.3-3.0	NS404W	NKY15S
	GTAHR/L1212-20S	●	●		12	12	12	80	2	15	1	12.9	0.3-3.0	NS404W	NKY15S
	GTBHR/L1010-30S	●	●	GTBT, GTCT	10	10	10	80	3	15	3	13.4	1.45-3.0	NS404W	NKY15S
	GTCHR/L1010-30S	●	●	GTCT	10	10	10	80	3	15	3	13.4	2.5-3.0	NS404W	NKY15S
Long Shank	GTAHR/L0808-20	●	●	GTAT GTBT *1 GTCT *1	8	8	8	120	2	15	5	12.9	0.3-3.0	NS404W	NKY15S
	GTAHR/L1010-20	●	●		10	10	10	120	2	15	3	12.9	0.3-3.0	NS404W	NKY15S
	GTAHR/L1212-20	●	●		12	12	12	120	2	15	1	12.9	0.3-3.0	NS404W	NKY15S
	GTAHR/L1616-20	●	●		16	16	16	120	2	15	-	12.9	0.3-3.0	NS404W	NKY15S
	GTBHR/L1010-30	●	●	GTBT, GTCT	10	10	10	120	3	15	3	13.4	1.45-3.0	NS404W	NKY15S
	GTBHR/L1212-30	●	●	GTBT, GTCT	12	12	12	120	3	15	1	13.4	1.45-3.0	NS404W	NKY15S
	GTBHR/L1616-30	●	●		16	16	16	120	3	15	-	13.4	1.45-3.0	NS404W	NKY15S
	GTCHR/L1010-30	●	●	GTCT	10	10	10	120	3	15	3	13.4	2.5-3.0	NS404W	NKY15S

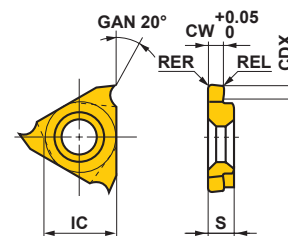
Note 1) Please use right hand insert for right hand holder and left hand insert for left hand holder.

*1 It is not possible to machine depths over CDX dimensions(Max. Groove Depth).

*2 Clamp Torque (N · m) : NS404W=1.0

INSERTS

Order Number	Hand	Coated	Dimensions (mm)					Geometry
		VP15TF	CW	CDX*1	RER/L	IC	S	
GTAT 03006V3R-U	R	●	0.3	0.6	0.03	9.525	3.18	U Type Breaker (General purpose Grooving)
GTAT 03006V3L-U	L	●	0.3	0.6	0.03	9.525	3.18	
GTAT 05012V5R-U	R	●	0.5	1.2	0.05	9.525	3.18	
GTAT 05012V5L-U	L	●	0.5	1.2	0.05	9.525	3.18	
GTAT 07520V5R-U	R	●	0.75	2.0	0.05	9.525	3.18	
GTAT 07520V5L-U	L	●	0.75	2.0	0.05	9.525	3.18	
GTAT 09520V5R-U	R	●	0.95	2.0	0.05	9.525	3.18	
GTAT 09520V5L-U	L	●	0.95	2.0	0.05	9.525	3.18	
GTAT 10020V5R-U	R	●	1.0	2.0	0.05	9.525	3.18	
GTAT 10020V5L-U	L	●	1.0	2.0	0.05	9.525	3.18	
GTAT 10320V5R-U	R	●	1.03	2.0	0.05	9.525	3.18	
GTAT 12520V5R-U	R	●	1.25	2.0	0.05	9.525	3.18	
GTAT 12520V5L-U	L	●	1.25	2.0	0.05	9.525	3.18	
GTBT14530V5R-U	R	●	1.45	3.0	0.05	9.525	3.18	
GTBT14530V5L-U	L	●	1.45	3.0	0.05	9.525	3.18	
GTBT15030V5R-U	R	●	1.5	3.0	0.05	9.525	3.18	
GTBT15030V5L-U	L	●	1.5	3.0	0.05	9.525	3.18	
GTBT17530V5R-U	R	●	1.75	3.0	0.05	9.525	3.18	
GTBT17530V5L-U	L	●	1.75	3.0	0.05	9.525	3.18	
GTBT20030V5R-U	R	●	2.0	3.0	0.05	9.525	3.18	
GTBT20030V5L-U	L	●	2.0	3.0	0.05	9.525	3.18	
GTCT25030V5R-U	R	●	2.5	3.0	0.05	9.525	3.18	
GTCT25030V5L-U	L	●	2.5	3.0	0.05	9.525	3.18	



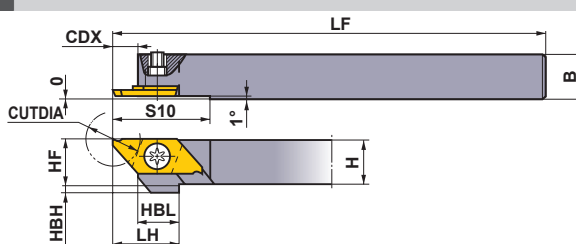
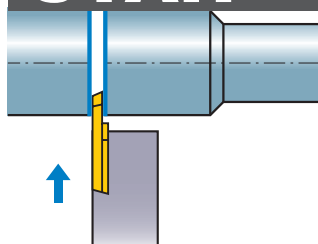
Right hand insert shown.

*1 It is not possible to machine depths over CDX dimensions(Max. Groove Depth).

● : Inventory maintained in Japan. (5 inserts in one case)

EXTERNAL CUTTING OFF

CTAH



Right hand tool holder shown.

Order Number	Stock		Insert Number	Dimensions (mm)									CUTDIA (mm)	*2		
	R	L		H	B	HF	LF	LH	CDX	HBH	HBL	S10		Clamp Screw	Wrench	
CTAHR/L0810-120	●	●	CTAT	○	8	10	8	120	15	5.5	4	9.5	22	12 (8)*1	NS402W	NKY15S
CTAHR/L1010-120	●	●		○	10	10	10	120	15	5.5	2	9.5	22		NS402W	NKY15S
CTAHR/L1212-120	●	●		○	12	12	12	120	15	5.5	—	9.5	22		NS403W	NKY15S
CTAHR/L1616-120	●	●		○	16	16	16	120	15	5.5	—	9.5	22		NS403W	NKY15S

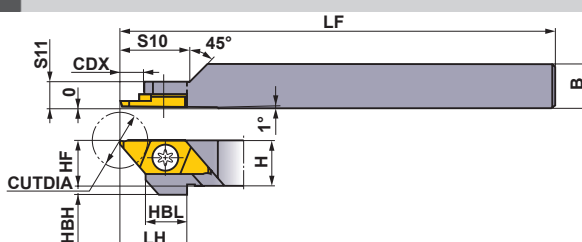
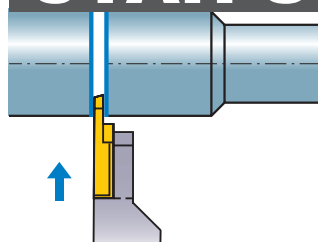
*1 When the width of cutting off (CW) is 0.7mm.

*2 Clamp Torque (N • m) : NS402W=1.0, NS403W=1.0

SMALL TOOLS

D

CTAH-S



Right hand tool holder only.

Order Number	Stock		Insert Number	Dimensions (mm)										CUTDIA (mm)	*2		
	R	L		H	B	HF	LF	LH	CDX	HBH	HBL	S10	S11		Clamp Screw	Wrench	
CTAHR1010-120S	●		CTAT	○	10	10	10	80	15	16	2	9.5	16	5.5	12 (8)*1	NS401	NKY25R

*1 When the width of cutting off (CW) is 0.7mm.

*2 Clamp Torque (N • m) : NS401=3.5

RECOMMENDED CUTTING CONDITIONS

	Work Material	Hardness	Grade	Cutting Speed (m/min)	Feed (mm/rev)
P	Carbon Steel · Alloy Steel	180HB-280HB	MS6015/VP15TF	100 (50-150)	0.05 (0.02-0.09)
	Free Cutting Steel	—	MS6015	110 (30-180)	0.05 (0.01-0.09)
M	Stainless Steel	≤200HB	VP15TF	80 (50-120)	0.03 (0.02-0.05)
N	Non-Ferrous Metal	—	MS6015	150 (70-230)	0.07 (0.03-0.11)

● : Inventory maintained in Japan. (5 inserts in one case)

INSERTS

Holder	Setting Geometry	Breaker	Geometry	Insert Geometry	Order Number	Hand	Coated		Dimensions (mm)								CUTDIA (mm)
							VP15TF	NEW MS6015	CW	CDX	RER/L	L	W1	S	LBB		
Right Hand (R)	16°	With Breaker			CTAT07080V5RR-B	R	●		0.7	4.5	0.05	20	8	2.5	1.5	8	
					CTAT10120V5RR-B	R	●	●	1.0	6.7	0.05	20	8	2.5	1.5	12	
					CTAT15120V5RR-B	R	●	●	1.5	6.7	0.05	20	8	2.5	1.5	12	
					CTAT20120V5RR-B	R	●	●	2.0	6.7	0.05	20	8	2.5	1.5	12	
	16°				CTAT15120V5RR-BX	R	●		1.5	6.7	0.05	20	8	2.5	1.5	12	
					CTAT20120V5RR-BX	R	●		2.0	6.7	0.05	20	8	2.5	1.5	12	
	0°				CTAT10120V5RN-B	N	●	●	1.0	6.7	0.05	20	8	2.5	1.5	12	
					CTAT15120V5RN-B	N	●	●	1.5	6.7	0.05	20	8	2.5	1.5	12	
	0°				CTAT20120V5RN-B	N	●	●	2.0	6.7	0.05	20	8	2.5	1.5	12	
					CTAT15120V5RN-BX	N	●		1.5	6.7	0.05	20	8	2.5	1.5	12	
				CTAT20120V5RN-BX	N	●		2.0	6.7	0.05	20	8	2.5	1.5	12		
	16°			Without Breaker		CTAT10110V5RL-B	L	●		1.0	6.7	0.05	20	8	2.5	1.5	11
		CTAT15110V5RL-B	L		●		1.5	6.7	0.05	20	8	2.5	1.5	11			
		CTAT20110V5RL-B	L		●		2.0	6.7	0.05	20	8	2.5	1.5	11			
20°	Without Breaker		CTAT1012000RR	R	●	●	1.0	6.7	0	20	8	2.5	3.5	12			
			CTAT1512000RR	R	●	●	1.5	6.7	0	20	8	2.5	3.5	12			
			CTAT2012000RR	R	●	●	2.0	6.7	0	20	8	2.5	3.5	12			
Left Hand (L)	16°	With Breaker			CTAT07080V5LL-B	L	●		0.7	4.5	0.05	20	8	2.5	1.5	8	
					CTAT10120V5LL-B	L	●		1.0	6.7	0	20	8	2.5	1.5	12	
					CTAT15120V5LL-B	L	●		1.5	6.7	0	20	8	2.5	1.5	12	
					CTAT20120V5LL-B	L	●		2.0	6.7	0	20	8	2.5	1.5	12	
	0°				CTAT10120V5LN-B	N	●	●	1.0	6.7	0.05	20	8	2.5	1.5	12	
					CTAT15120V5LN-B	N	●	●	1.5	6.7	0.05	20	8	2.5	1.5	12	
					CTAT20120V5LN-B	N	●	●	2.0	6.7	0.05	20	8	2.5	1.5	12	
	16°			Without Breaker		CTAT10110V5LR-B	R	●	●	1.0	6.7	0.05	20	8	2.5	1.5	11
						CTAT15110V5LR-B	R	●	●	1.5	6.7	0.05	20	8	2.5	1.5	11
						CTAT20110V5LR-B	R	●	●	2.0	6.7	0.05	20	8	2.5	1.5	11
	20°			Without Breaker		CTAT1012000LL	L	●		1.0	6.7	0	20	8	2.5	3.5	12
						CTAT1512000LL	L	●		1.5	6.7	0	20	8	2.5	3.5	12
		CTAT2012000LL	L		●		2.0	6.7	0	20	8	2.5	3.5	12			

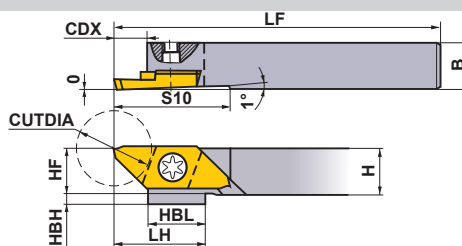
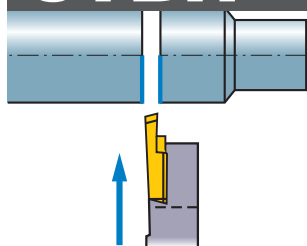
● = NEW

D

SMALL TOOLS

EXTERNAL CUTTING OFF

CTBH



Right hand tool holder shown.

Order Number	Stock		Insert Number	Dimensions (mm)										CUTDIA (mm)	*	
	R	L		H	B	HF	LF	LH	CDX	HBH	HBL	S10	Clamp Screw		Wrench	
CTBHR/L1010-160	●	●	CTBT	10	10	10	120	19.5	7.5	2	9.5	25	16	NS402W	NKY15S	
CTBHR/L1212-160	●	●		12	12	12	120	19.5	7.5	—	9.5	25	16	NS403W	NKY15S	
CTBHR/L1616-160	●	●		16	16	16	120	19.5	7.5	—	9.5	25	16	NS403W	NKY15S	

* Clamp Torque (N · m) : NS402W=1.0, NS403W=1.0

SMALL TOOLS

D

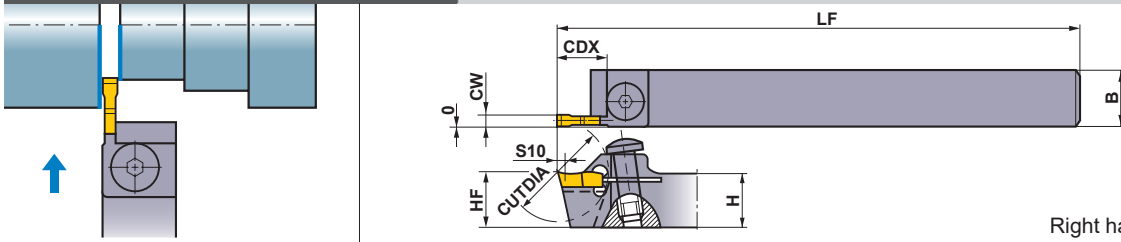
INSERTS

Holder	Setting Geometry	Breaker	Geometry	Insert Geometry	Order Number	Hand	Coated		Dimensions (mm)							CUTDIA (mm)
							VP15TF	NEW MS6015	CW	CDX	RER/L	L	W1	S		
Right Hand (R)					CTBT15160V5RR-B	R	●	●	1.5	9.2	0.05	25	9.4	3.5	16	
					CTBT20160V5RR-B	R	●	●	2.0	9.2	0.05	25	9.4	3.5	16	
Left Hand (L)		With Breaker			CTBT20160V5RN-B	N	●	●	2.0	9.2	0.05	25	9.4	3.5	16	
					CTBT20160V5LL-B	L	●		2.0	9.2	0.05	25	9.4	3.5	16	
					CTBT20160V5LN-B	N	●	●	2.0	9.2	0.05	25	9.4	3.5	16	
					CTBT20145V5LR-B	R	●	●	2.0	9.2	0.05	25	9.4	3.5	14.5	

● = NEW

● : Inventory maintained in Japan. (5 inserts in one case)

CTCH



Right hand tool holder shown.

Order Number	Stock		Insert Number	Dimensions (mm)						CUTDIA (mm)	* ⚙️ Clamp Screw	⚒️ Wrench	
	R	L		H	B	HF	LF	CDX	S10				
CTCHR/L1010-200	●	●	CTCT	2000	10	10	10	120	11	0.5	20	NS501W	HKY25RS
CTCHR/L1212-200	●	●		2000	12	12	12	120	11	0.5	20	NS501W	HKY25RS

* Clamp Torque (N · m) : NS501W=2.2

D

SMALL TOOLS

INSERTS

Breaker	Order Number	Hand	Coated	Dimensions (mm)					CUTDIA (mm)	Geometry
			VP15TF	CW	PSIRR/L	RER/L	L	S		
With Breaker	CTCT22200V5N-B	N	* ●	2.2	0°	0.05	10	4.0	20	
	CTCT2220001N-B	N	* ●	2.2	0°	0.1	10	4.0	20	
	CTCT25200V5N-B	N	* ●	2.5	0°	0.05	10	4.0	20	
	CTCT2520001N-B	N	* ●	2.5	0°	0.1	10	4.0	20	
	CTCT22200V5R-B	R	* ●	2.2	17°	0.05	10	4.0	20	
	CTCT2220001R-B	R	* ●	2.2	17°	0.1	10	4.0	20	
	CTCT25200V5R-B	R	* ●	2.5	17°	0.05	10	4.0	20	
	CTCT2520001R-B	R	* ●	2.5	17°	0.1	10	4.0	20	
	CTCT22200V5L-B	L	* ●	2.2	17°	0.05	10	4.0	20	
	CTCT2220001L-B	L	* ●	2.2	17°	0.1	10	4.0	20	
	CTCT25200V5L-B	L	* ●	2.5	17°	0.05	10	4.0	20	
	CTCT2520001L-B	L	* ●	2.5	17°	0.1	10	4.0	20	

* 10 inserts in one case.

RECOMMENDED CUTTING CONDITIONS

	Work Material	Hardness	Grade	Cutting Speed (m/min)	Feed (mm/rev)
P	Carbon Steel · Alloy Steel	180HB–280HB	MS6015/VP15TF	100 (50–150)	0.05 (0.02–0.09)
	Free Cutting Steel	–	MS6015	110 (30–180)	0.05 (0.01–0.09)
M	Stainless Steel	≤200HB	VP15TF	80 (50–120)	0.03 (0.02–0.05)
N	Non-Ferrous Metal	–	MS6015	150 (70–230)	0.07 (0.03–0.11)

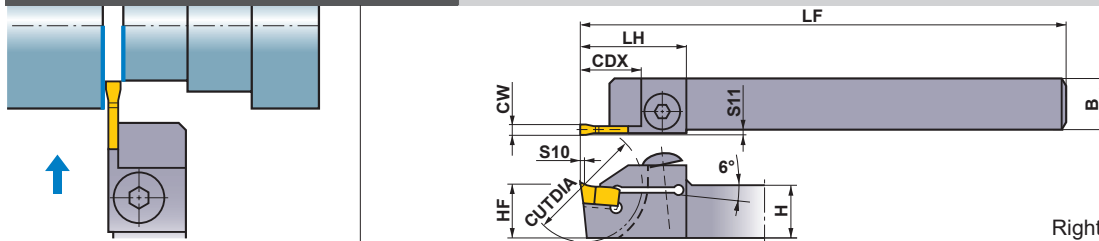
● : Inventory maintained in Japan. (10 inserts in one case)

SPARE PARTS > Q001
TECHNICAL DATA > R001



D021

EXTERNAL CUTTING OFF

CTDH



Right hand tool holder shown.

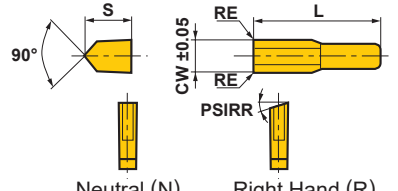
Order Number	Stock		Insert Number	Dimensions (mm)								CUTDIA (mm)	 * Clamp Screw	 Wrench	
	R	L		H	B	HF	LF	LH	CDX	S10	S11				
CTDHR/L1616-230	●		CTDT	2535	16	16	16	125	24	12.2	0.5	0.5	23	HBH06020	HKY40R
CTDHR/L1616-280	●			2535	16	16	16	120	25	15	0.5	0.5	28	NS502W	HKY25R
CTDHR/L1616-350	●	●		2535	16	16	16	125	32	18.5	0.5	0.5	35	HBH06020	HKY40R

* Clamp Torque (N · m) : HBH06020=7.0, NS502W=2.2

SMALL TOOLS

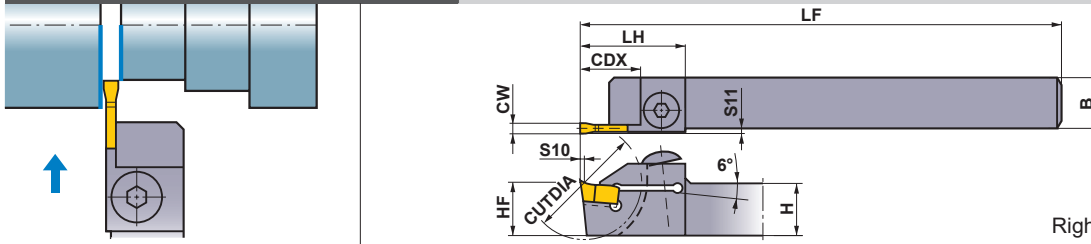
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INSERTS


Breaker	Order Number	Hand	Coated	Dimensions (mm)					CUTDIA (mm)	Geometry
			VP15TF	CW	PSIRR	RE	L	S		
With Breaker	CTDT2535002N-B	N	●	2.5	0°	0.2	12	6.39	23-35	
	CTDT25350V5R-B	R	●	2.5	8°	≤0.05	12	6.39	23-35	
	CTDT25350V5R-BS	R	●	2.5	17°	≤0.05	12	6.39	23-35	
	CTDT2535002R-B	R	●	2.5	8°	0.2	12	6.39	23-35	

● : Inventory maintained in Japan. (10 inserts in one case)

CTEH



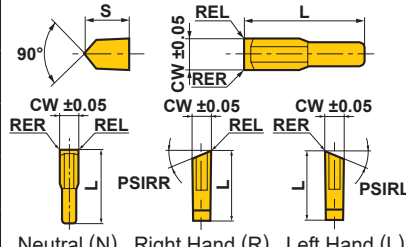
Right hand tool holder shown.

Order Number	Stock		Insert Number	Dimensions (mm)								CUTDIA (mm)	* 		
	R	L		H	B	HF	LF	LH	CDX	S10	S11				
CTEHR/L1616-230	●		CTET	3035	16	16	16	125	24	12.2	0.5	0.5	23	HBH06020	HKY40R
CTEHR/L1616-280	●			3035	16	16	16	120	25	15	0.5	0.5	28	NS502W	HKY25R
CTEHR/L1616-350	●	●		3035	16	16	16	125	32	18.5	0.5	0.5	35	HBH06020	HKY40R

* Clamp Torque (N · m) : HBH06020=7.0, NS502W=2.2

D
SMALL TOOLS

INSERTS

Breaker	Order Number	Hand	Coated	Dimensions (mm)					CUTDIA (mm)	Geometry
			VP15TF	CW	PSIRR/L	RER/L	L	S		
With Breaker	CTET30350V5R-B	R	●	3	8°	≤0.05	12	6.39	23-35	
	CTET30350V5R-BS	R	●	3	17°	≤0.05	12	6.39	23-35	
	CTET3035002N-B	N	●	3	0°	0.2	12	6.39	23-35	
	CTET3035002R-B	R	●	3	8°	0.2	12	6.39	23-35	
	CTET3035002L-B	L	●	3	8°	0.2	12	6.39	23-35	

RECOMMENDED CUTTING CONDITIONS

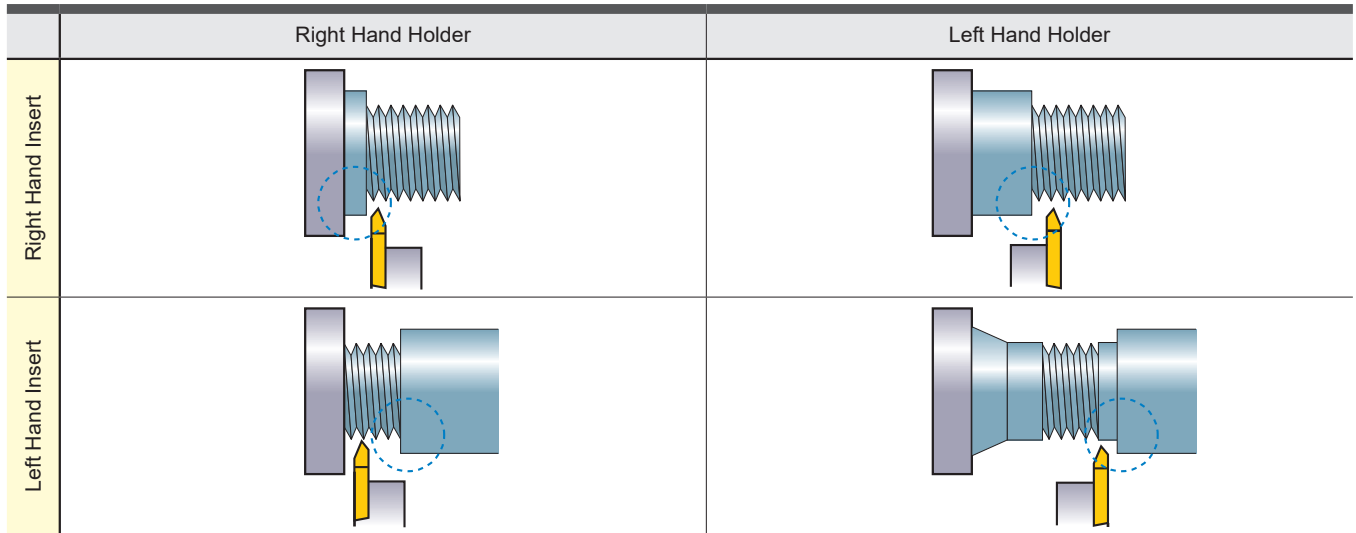
	Work Material	Hardness	Grade	Cutting Speed (m/min)	Feed (mm/rev)
P	Carbon Steel · Alloy Steel	180HB-280HB	VP15TF	100 (50-150)	0.05 (0.02-0.09)
	Free Cutting Steel	-	VP15TF	110 (30-180)	0.05 (0.01-0.09)
M	Stainless Steel	≤200HB	VP15TF	80 (50-120)	0.03 (0.02-0.05)
N	Non-Ferrous Metal	-	VP15TF	150 (70-230)	0.07 (0.03-0.11)

● : Inventory maintained in Japan. (10 inserts in one case)

SPARE PARTS > Q001
TECHNICAL DATA > R001

D023

HOLDER APPLICATION



*The above combinations enable to machine the side of

D
SMALL TOOLS

THREAD RANGE

Application range

Pitch (mm)	Pitch Diameter of Thread (mm)										Number of Passes
	≥ φ1.0	≥ φ1.2	≥ φ1.6	≥ φ2.0	≥ φ2.5	≥ φ3.0	≥ φ4.0	≥ φ5.0	≥ φ6.0	≥ φ7.0	
0.2											2-4
0.25											3-5
0.3											4-6
0.35											5-7
0.4											6-8
0.45											
0.5											
0.6											
0.7											
0.75											
0.8											
1											
1.25											
1.5											

Threading impossible

*Metric Thread (60°)

Pitch(thread/inch)	Pitch Diameter of Thread									Number of Passes
Inch	≥ φ0.060	≥ φ0.073	≥ φ0.086	≥ φ0.099	≥ φ0.112	≥ φ0.164	≥ φ0.190	≥ φ0.250	≥ φ0.313	
mm	≥ φ1.524	≥ φ1.854	≥ φ2.184	≥ φ2.515	≥ φ2.845	≥ φ4.166	≥ φ4.826	≥ φ6.350	≥ φ7.938	
80										3-5
72										4-6
64										5-7
56										6-8
48										
44										
40										
32										
28										
26										
24										
20										
18										
16										

Threading impossible

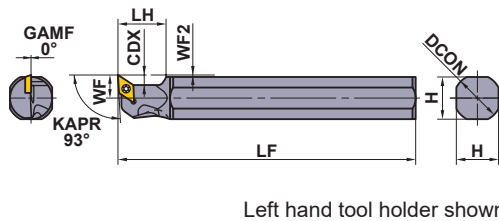
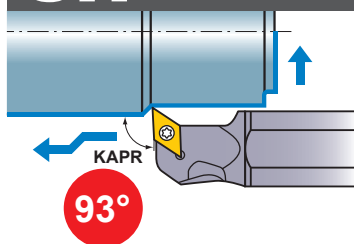
*American UN, Whitworth

SPARE PARTS > Q001
TECHNICAL DATA > R001

D025

EXTERNAL FRONT TURNING, COPYING, FACING (FOR OPPOSITE TOOL POSTS)

SH



Finish	Finish	Light	Light
SMG/FS (07, 11)	R-F (07, 11)	R-SS (07, 11)	LS (07, 11)
Medium R-SN (07, 11)	Medium R-SR (07, 11)	For nonferrous metals AZ (07, 11)	Light LS-P (07, 11)

SMALL TOOLS

D

Order Number	Stock L	Insert Number	Dimensions (mm)									* Clamp Screw	Wrench
			DCON	LF	LH	H	WF	WF2	CDX				
SH16H-FSDUCL07	●	DCMT DCMW DCET DCGT DCGW 0702	15.875	100	20	14	7.75	0.75	4.2	TS254	TKY08R		
SH19K-FSDUCL07	●		19.05	125	20	17	9.25	0.75	4.2	TS254	TKY08R		
SH20K-FSDUCL07	●		20	125	20	18	9.75	0.75	4.2	TS254	TKY08R		
SH22K-FSDUCL07	●		22	125	20	20	10.75	0.75	4.2	TS254	TKY08R		
SH25M-FSDUCL07	●		25.4	150	20	23	12.25	0.75	4.2	TS254	TKY08R		
SH16H-FSDUCL11	●	DCMT DCMW DCET DCGT DCGW 11T3	15.875	100	20	15	7.75	0.75	6.4	TS43	TKY15R		
SH19K-FSDUCL11	●		19.05	125	20	17	9.25	0.75	6.4	TS43	TKY15R		
SH20K-FSDUCL11	●		20	125	20	18	9.75	0.75	6.4	TS43	TKY15R		
SH22K-FSDUCL11	●		22	125	20	20	10.75	0.75	6.4	TS43	TKY15R		
SH25M-FSDUCL11	●		25.4	150	20	23	12.25	0.75	6.4	TS43	TKY15R		

Note 1) When using insert with right and left hand chip breaker, please use right hand insert.

Note 2) The insert photos are only examples. The letters refer to the chip breaker and the dimension refers to the inscribed circle.

* Clamp Torque (N · m) : TS254=1.0, TS43=3.5

RECOMMENDED CUTTING CONDITIONS

	Work Material	Hardness	Grade	Cutting Speed (m/min)	Feed (mm/rev)
P	Carbon Steel · Alloy Steel	180HB–280HB	MS6015/VP15TF	100 (50–150)	0.08 (0.01–0.15)
			MS6015	110 (30–180)	0.08 (0.01–0.15)
	Free Cutting Steel	–	NX2525	150 (50–250)	0.08 (0.01–0.15)
M	Stainless Steel	≤200HB	VP15TF/MP9005/MP9015	80 (50–120)	0.06 (0.02–0.1)
N	Non-Ferrous Metal	–	HTI10/MT9005	150 (70–230)	0.09 (0.03–0.15)
S	Titanium Alloy	–	MT9005	60 (40–80)	0.08 (0.04–0.12)
	Heat Resistant Alloy	–	MP9015	50 (20–75)	0.08 (0.04–0.12)

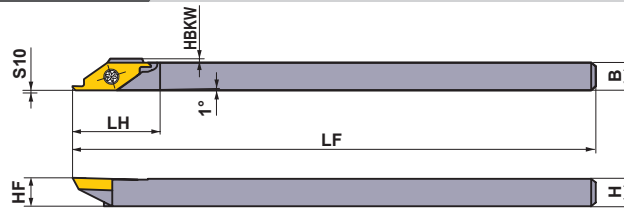
● : Inventory maintained in Japan.

SH type inserts > A149–A154

CBN & PCD inserts > B054–B056, B073

CAM TYPE TOOL POSTS

CSVH



Right hand tool holder shown.

Order Number	Stock		Insert Number	Dimensions (mm)							*1 APMX (mm)	*2		
	R	L		H	B	HF	LF	HBKW	LH	S10		Clamp Screw	Wrench	
CSVHR/L0707	●	●	CSVT		7	7	7	140	0.5	20	0.1	3.0	NS251	NKY15S
CSVHR/L0808	●	●			8	8	8	140	0	20	0.1	3.0	NS251	NKY15S
CSVHR/L0909	●	●			9.5	9.5	9.5	140	0	20	0.1	3.0	NS251	NKY15S
CSVHR/L1010	●	●			10	10	10	140	0	20	0.1	3.0	NS251	NKY15S
CSVHR/L1212	●	●			12	12	12	140	0	20	0.1	3.0	NS251	NKY15S

Note 1) Please use right hand insert for right hand holder and left hand insert for left hand holder.

Note 2) Max. Cutting Depth (APMX) varies depending on the type of insert used.

*1 APMX : Max. Cutting Depth

*2 Clamp Torque (N · m) : NS251=1.0

INSERTS

CSVTF

Front turning

Order Number	Hand	Coated	Dimensions (mm)				APMX (mm) [*]	Geometry
		VP15KZ	IC	S	RER/L	CF		
CSVTF30AR	R	●	6.35	2.38	0	0.3	3.0	<p>Without Breaker</p> <p>With Breaker</p> <p>Right hand insert shown.</p>
CSVTF30AL	L	●	6.35	2.38	0	0.3	3.0	
CSVTF30BR	R	●	6.35	2.38	0	0.3	3.0	
CSVTF30CR	R	●	6.35	2.38	0	0.15	3.0	
CSVTF30DR	R	●	6.35	2.38	0	0.15	3.0	
CSVTF30AR-B	R	●	6.35	2.38	0	0.3	3.0	<p>Without Breaker</p> <p>With Breaker</p> <p>Right hand insert shown.</p>
CSVTF30AL-B	L	●	6.35	2.38	0	0.3	3.0	
CSVTF30BR-B	R	●	6.35	2.38	0	0.3	3.0	
CSVTF30CR-B	R	●	6.35	2.38	0	0.15	3.0	
CSVTF30DR-B	R	●	6.35	2.38	0	0.15	3.0	

* APMX : Max. Cutting Depth

CSVTFXL

Front turning, Copying

Order Number	Hand	Coated	Dimensions (mm)			APMX (mm) [*]	Geometry
		VP15KZ	IC	S	CFD		
CSVTFXL	L	●	6.35	2.38	0.7	3.0	<p>Without Breaker</p>

* APMX : Max. Cutting Depth

● : Inventory maintained in Japan. (5 inserts in one case)

SPARE PARTS > Q001
TECHNICAL DATA > R001

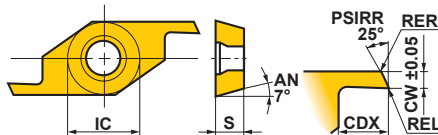
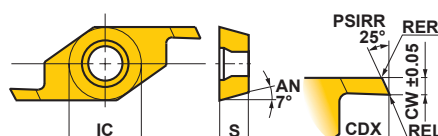
D027

CAM TYPE TOOL POSTS

INSERTS

CSVTC

Cutting off

Order Number	Hand	Coated	Dimensions (mm)					APMX* (mm)	Geometry	
		VP15KZ	IC	S	RER/L	CDX	CW			
CSVTC0640R	R	●	6.35	2.38	0	2.0	0.6	1.5	 <p>Without Breaker</p>	
CSVTC0750R	R	●	6.35	2.38	0	2.5	0.7	2.0		
CSVTC0750L	L	●	6.35	2.38	0	2.5	0.7	2.0		
CSVTC0850R	R	●	6.35	2.38	0	2.5	0.8	2.0		
CSVTC0850L	L	●	6.35	2.38	0	2.5	0.8	2.0		
CSVTC0950R	R	●	6.35	2.38	0	2.5	0.9	2.0		
CSVTC1060R	R	●	6.35	2.38	0	3.0	1.0	2.5		
CSVTC1060L	L	●	6.35	2.38	0	3.0	1.0	2.5		
CSVTC1360R	R	●	6.35	2.38	0	3.0	1.3	2.5		
CSVTC1360L	L	●	6.35	2.38	0	3.0	1.3	2.5		
CSVTC1560R	R	●	6.35	2.38	0	3.0	1.5	2.5		
CSVTC1560L	L	●	6.35	2.38	0	3.0	1.5	2.5		
CSVTC0640R-B	R	●	6.35	2.38	0	2.0	0.6	1.5		 <p>With Breaker</p>
CSVTC0750R-B	R	●	6.35	2.38	0	2.5	0.7	2.0		
CSVTC0850R-B	R	●	6.35	2.38	0	2.5	0.8	2.0		
CSVTC0950R-B	R	●	6.35	2.38	0	2.5	0.9	2.0		
CSVTC1060R-B	R	●	6.35	2.38	0	3.0	1.0	2.5		
CSVTC1360R-B	R	●	6.35	2.38	0	3.0	1.3	2.5		
CSVTC1560R-B	R	●	6.35	2.38	0	3.0	1.5	2.5		
CSVTC1560L-B	L	●	6.35	2.38	0	3.0	1.5	2.5		

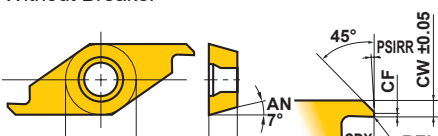
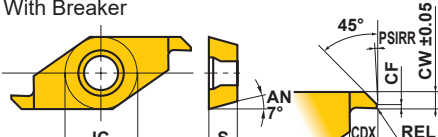
Right hand insert shown.

Right hand insert shown.

* APMX : Max. Cutting Depth

CSVTB

Back turning

Order Number	Hand	Coated	Dimensions (mm)							APMX* (mm)	Geometry	
		VP15KZ	IC	S	RER/L	CDX	CW	CF	PSIRR/L			
CSVTB10AR	R	●	6.35	2.38	0	2.5	1	0.3	5°	2.0	 <p>Without Breaker</p>	
CSVTB10AL	L	●	6.35	2.38	0	2.5	1	0.3	5°	2.0		
CSVTB10BR	R	●	6.35	2.38	0	2.5	1	0.3	2°	2.0		
CSVTB10CR	R	●	6.35	2.38	0	2.5	1	0.15	2°	2.0		
CSVTB10DR	R	●	6.35	2.38	0	2.5	1	0.15	5°	2.0		
CSVTB12AR	R	●	6.35	2.38	0	2.5	1.2	0.3	5°	2.0		
CSVTB14AR	R	●	6.35	2.38	0	2.5	1.4	0.3	5°	2.0		
CSVTB10AR-B	R	●	6.35	2.38	0	2.5	1	0.3	5°	2.0		 <p>With Breaker</p>
CSVTB10BR-B	R	●	6.35	2.38	0	2.5	1	0.3	2°	2.0		
CSVTB10CR-B	R	●	6.35	2.38	0	2.5	1	0.15	2°	2.0		
CSVTB10DR-B	R	●	6.35	2.38	0	2.5	1	0.15	5°	2.0		
CSVTB12AR-B	R	●	6.35	2.38	0	2.5	1.2	0.3	5°	2.0		
CSVTB14AR-B	R	●	6.35	2.38	0	2.5	1.4	0.3	5°	2.0		
CSVTB10AR-B	R	●	6.35	2.38	0	2.5	1	0.3	5°	2.0		
CSVTB10BR-B	R	●	6.35	2.38	0	2.5	1	0.3	2°	2.0		

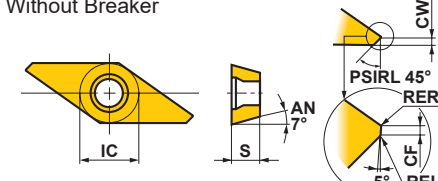
Right hand insert shown.

Right hand insert shown.

* APMX : Max. Cutting Depth

CSVTBXL

Back turning, Copying

Order Number	Hand	Coated	Dimensions (mm)					APMX* (mm)	Geometry
		VP15KZ	IC	S	RER/L	CW	CF		
CSVTBXL	L	●	6.35	2.38	0	0.7	0.035	3.0	 <p>Without Breaker</p>

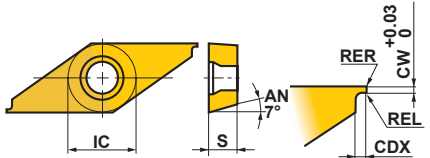
* APMX : Max. Cutting Depth

● : Inventory maintained in Japan. (5 inserts in one case)

D

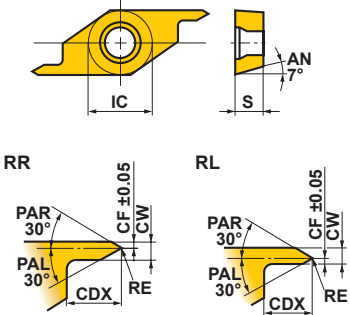
SMALL TOOLS

INSERTS

CSVTG		Grooving							APMX* (mm)	Geometry
Order Number	Hand	Coated	Dimensions (mm)							
		VP15KZ	IC	S	RER/L	CDX	CW			
CSVTG02505R	R	●	6.35	2.38	0	0.5	0.25	0.15		
CSVTG03005R	R	●	6.35	2.38	0	0.5	0.3	0.15		
CSVTG03505R	R	●	6.35	2.38	0	0.5	0.35	0.15		
CSVTG04005R	R	●	6.35	2.38	0	0.5	0.4	0.15		
CSVTG04510R	R	●	6.35	2.38	0	1.0	0.45	0.45		
CSVTG05010R	R	●	6.35	2.38	0	1.0	0.5	0.45		
CSVTG05510R	R	●	6.35	2.38	0	1.0	0.55	0.45		
CSVTG06010R	R	●	6.35	2.38	0	1.0	0.6	0.45		
CSVTG06510R	R	●	6.35	2.38	0	1.0	0.65	0.45		
CSVTG07010R	R	●	6.35	2.38	0	1.0	0.7	0.45		
CSVTG07520R	R	●	6.35	2.38	0	2.0	0.75	1.4		
CSVTG07520L	L	●	6.35	2.38	0	2.0	0.75	1.4		
CSVTG08020R	R	●	6.35	2.38	0	2.0	0.8	1.4		
CSVTG08520R	R	●	6.35	2.38	0	2.0	0.85	1.4		
CSVTG09020R	R	●	6.35	2.38	0	2.0	0.9	1.4		
CSVTG09520R	R	●	6.35	2.38	0	2.0	0.95	1.4		
CSVTG09520L	L	●	6.35	2.38	0	2.0	0.95	1.4		
CSVTG10020R	R	●	6.35	2.38	0	2.0	1.0	1.4		
CSVTG11030R	R	●	6.35	2.38	0	3.0	1.1	2.6		
CSVTG12030R	R	●	6.35	2.38	0	3.0	1.2	2.6		
CSVTG12030L	L	●	6.35	2.38	0	3.0	1.2	2.6		
CSVTG13030R	R	●	6.35	2.38	0	3.0	1.3	2.6		
CSVTG14030R	R	●	6.35	2.38	0	3.0	1.4	2.6		
CSVTG15030R	R	●	6.35	2.38	0	3.0	1.5	2.6		

Right hand insert shown.

* APMX : Max. Cutting Depth

CSVTT		Threading								Geometry
Order Number	Hand	Coated	Pitch (mm)	Dimensions (mm)						
		VP15KZ		IC	S	RE	CDX	CW	CF	
CSVTT60050RR	R	●	0.2—0.5	6.35	2.38	0.03	3.0	1.0	0.35	
CSVTT60050RL	L	●	0.2—0.5	6.35	2.38	0.03	3.0	1.0	0.35	

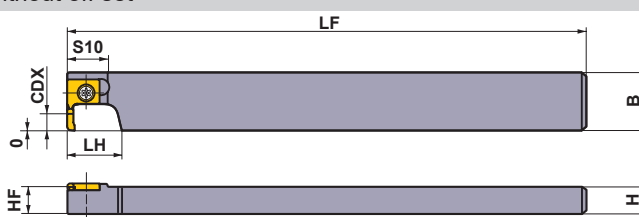
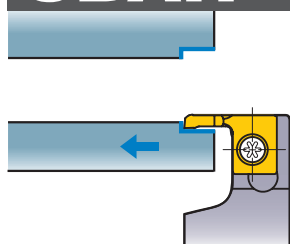
Right hand insert shown.

D
SMALL TOOLS

BORING

SBAH

Without off set



Right hand tool holder only.

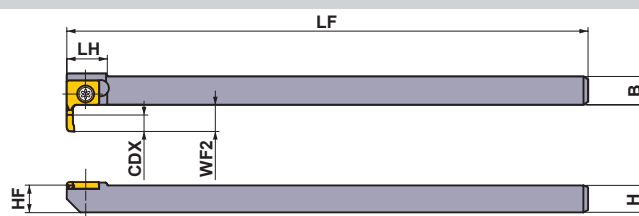
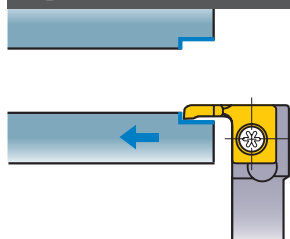
Order Number	Stock	Insert Number	Dimensions (mm)							CDX (mm)	DMIN*1 (mm)	*2	*2
	R		H	B	LF	HF	LH	S10	Clamp Screw				
SBAHR1022	●	SBAT	3080	10	21.5	120	10	17.5	15	8	3	NS402W	NKY15S
SBAHR1222	●		3080	12	21.5	120	12	17.5	15	8	3	NS403W	NKY15S

*1 DMIN : Min. Cutting Diameter

*2 Clamp Torque (N · m) : NS402W=1.0, NS403W=1.0

SBAH

With off set



Right hand tool holder only.

Order Number	Stock	Insert Number	Dimensions (mm)							CDX (mm)	DMIN*1 (mm)	*2	*2
	R		H	B	LF	HF	WF2	LH	Clamp Screw				
SBAHR1010	●	SBAT	3080	10	10	120	10	10	15	8	3	NS402W	NKY15S

*1 DMIN : Min. Cutting Diameter

*2 Clamp Torque (N · m) : NS402W=1.0

INSERTS

Breaker	Order Number	Coated	Dimensions (mm)								DMIN* (mm)	Geometry
		VP15KZ	PSIRL	RER	CDX	L	W1	S	CW	S10		
Without Breaker	SBAT308000L	●	5°	0	8.0	18.5	12.0	2.50	1.25	9.0	3	
	SBAT3080V5L	●	5°	0.05	8.0	18.5	12.0	2.50	1.25	9.0	3	
With Breaker	SBAT308000L-B	●	5°	0	8.0	18.5	12.0	2.50	1.25	9.0	3	
	SBAT3080V5L-B	●	5°	0.05	8.0	18.5	12.0	2.50	1.25	9.0	3	

* DMIN : Min. Cutting Diameter

● : Inventory maintained in Japan. (5 inserts in one case)

SPARE PARTS > Q001
TECHNICAL DATA > R001

Memo

A series of horizontal dashed lines for writing, spanning the width of the page.