

HOW TO READ THE STANDARD OF HSK-T TOOLS

● How this section page is organised

① Organised by application. (Refer to the index on the next page.)

PRODUCT TYPE

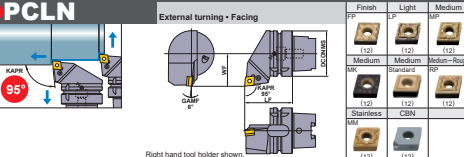
indicates the first four letters of the order number, as well as cutting applications.

TITLE OF PRODUCT SERIES PRODUCT SECTION

HSK-T TOOLS

FOR MULTI-TASK MACHINES

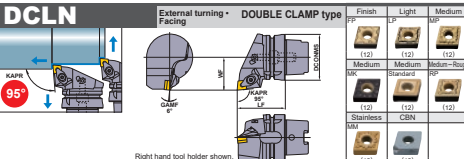
PCLN



Order Number	Stock	Insert Number	Dimensions (mm)			WT (kg)	Shim	Shim Pin	Clamp Lever	Clamp Screw	Wrench
			DCOMNS	LF	WF						
H63TH-PCLNR/L-DX12	●	CNCA CNOG CNM	1204	100	1.7	63	LLSCN42	LLP14	LLCL14	LLCS108	HKY30R

*1 Clamp Torque (N·m) : LLC3108-3
*2 WT : Tool Weight
Note 1) Dimensions shown for insert corner RE 0.8.

DCLN



Order Number	Stock	Insert Number	Dimensions (mm)			WT (kg)	Shim	Shim Pin	Clamp Bridge	Spring	Clamp Screw	Wrench
			DCOMNS	LF	WF							
H63TH-DCLNR/L-DX12	●	CNCA CNOG CNM	1204	100	1.7	63	LLSCN42	LLP14	DCK2613	DCS1	DC0621T	TKY20F

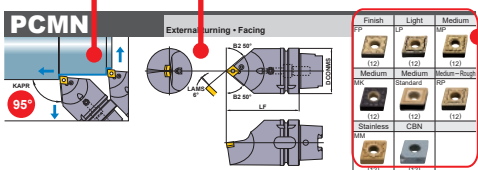
*1 Clamp Torque (N·m) : DC0621T-5.0
*2 WT : Tool Weight
Note 1) Dimensions shown for insert corner RE 0.8.

● : Inventory maintained in Japan.

PCLN type inserts > A100-A106
DCLN type inserts > A100-A106
CBN & PCD inserts > B028-B031, B065
SPECIAL CUTTING CONDITIONS > A876

FIGURE SHOWING THE TOOLING APPLICATION uses illustrations and arrows to depict available machining applications along with cutting edge lead angles.

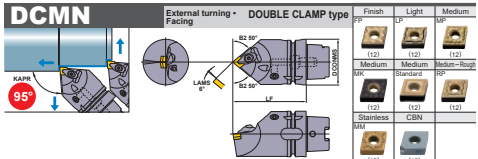
GEOMETRY CHIP BREAKER BY CUTTING APPLICATION



Order Number	Stock	Insert Number	Dimensions (mm)			WT (kg)	Shim	Shim Pin	Clamp Lever	Clamp Screw	Plug	Wrench
			DCOMNS	LF	WF							
H63TH-PCMNN-H12	●	CNCA CNOG CNM	1204	100	1.7	63	LLSCN42	LLP14	LLCL14	LLCS108	HGM-P118	HKY30R
H63TH-PCMNN-L12	●	CNCA CNOG CNM	1204	140	2.7	63	LLSCN42	LLP14	LLCL14	LLCS108	HGM-P118	HKY30R

*1 Clamp Torque (N·m) : LLC3108-3
*2 WT : Tool Weight
Note 1) Dimensions shown for insert corner RE 0.8.

DCMN



Order Number	Stock	Insert Number	Dimensions (mm)			WT (kg)	Shim	Shim Pin	Clamp Bridge	Spring	Clamp Screw	Wrench
			DCOMNS	LF	WF							
H63TH-DCMNN-H12	●	CNCA CNOG CNM	1204	100	1.7	63	LLSCN42	LLP14	DCK2613	DCS1	DC0621T	TKY20F
H63TH-DCMNN-L12	●	CNCA CNOG CNM	1204	140	2.7	63	LLSCN42	LLP14	DCK2613	DCS1	DC0621T	TKY20F

*1 Clamp Torque (N·m) : DC0621T-5.0
*2 WT : Tool Weight
Note 1) Dimensions shown for insert corner RE 0.8.

PCMN type inserts > A100-A106
DCLN type inserts > A100-A106
CBN & PCD inserts > B028-B031, B065

SUGGESTED CUTTING CONDITIONS > A876
SPARE PARTS > Q001
TECHNICAL DATA > R001

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

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

PAGE REFERENCE ·SPARE PARTS ·TECHNICAL DATA indicates reference pages, including the above, on the right hand page of each double-page spread.

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

● To Order : Please specify
① order number and hand of tool (right/left).

HSK-T TOOLS

OVERVIEW OF HSK-T TOOLS.....	H002
CLASSIFICATION OF HSK-T TOOLS	H004
HSK-T TOOL STANDARDS	
EXTERNAL TURNING • FACING	
CN [○] ○ [○] INSERTS TOOL HOLDERS	H006
DN [○] ○ [○] INSERTS TOOL HOLDERS	H011
EXTERNAL TURNING • FACING • BORING	
CN [○] ○ [○] INSERTS TOOL HOLDERS	H008
EXTERNAL TURNING • COPYING	
DN [○] ○ [○] INSERTS TOOL HOLDERS	H009
EXTERNAL TURNING • FACING • COPYING	
RC [○] ○ [○] INSERTS TOOL HOLDERS	H012
FACING • COPYING	
VB [○] ○ [○] INSERTS TOOL HOLDERS	H013
GROOVING	
MG INSERTS TOOL HOLDERS	H014
THREADING	
MMT INSERTS TOOL HOLDERS.....	H016
MT INSERTS TOOL HOLDERS.....	H017
EXTERNAL TURNING TOOL HOLDERS	
H019	H019
BORING BAR HOLDERS	
H021	H021
BORING BAR SLEEVES	
H022	H022

*Arranged by Alphabetical order

H022 H100TH-B[○]○[○]○[○]
 H020 H100TH-EN3232R/L-130
 H019 H100TH-EV3232R/L-180
 H008 H63TH-A[○]○[○]○[○]DCLNR/L12
 H021 H63TH-B[○]○[○]○[○]
 H008 H63TH-DCLNL-L12-3
 H006 H63TH-DCLNR/L-DX12
 H007 H63TH-DCMNN-H/L12
 H011 H63TH-DDJNL-L15-3
 H009 H63TH-DDJNR/L-DX15
 H010 H63TH-DDNNN-H/L15
 H020 H63TH-EN2525R/L-115
 H021 H63TH-EV2020R/L-105-3
 H019 H63TH-EV2525R/L-112

H014 H63TH-MGHR/L-DX43[○]○[○]
 H016 H63TH-MMTENR-H/L16
 H016 H63TH-MMTER-DX16
 H017 H63TH-MTHR/L-DX43
 H006 H63TH-PCLNR/L-DX12
 H007 H63TH-PCMNN-H/L12
 H009 H63TH-PDJNR/L-DX15
 H010 H63TH-PDNNN-H/L15
 H012 H63TH-PRDCN-H/L12
 H012 H63TH-PRGCR/L-DX12
 H013 H63TH-SVPBR/L-DX16
 H013 H63TH-SVVBH-H/L16
 H022 SL32[○]○[○]-90



Tooling system
for turning on
multi-task machines

HSK TOOLS

HSK-T System

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). The HSK system was developed by a consortium of 17 Japanese manufacturers and registered in ISO standard (ISO12164-3:2008) under the name HSK-T type in 2008 and JIS standard (JIS B6064-3) in 2013.

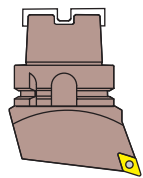


High accuracy cutting edge positioning

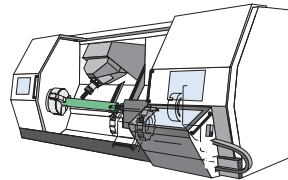
The HSK-T type has a closer tolerance between the spindle key and tool holder keyway than the HSK-A type. This results in higher cutting edge positional accuracies. For milling, the conventional HSK-A type tools can be still used.

Compatible with both multi-task machines and machining centres

HSK-T TOOLS



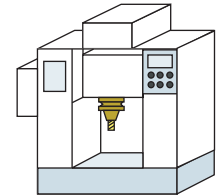
HSK-T
Turning tool holder



HSK-T spindle
Multi-task machines



HSK-A
Rotating tool holder



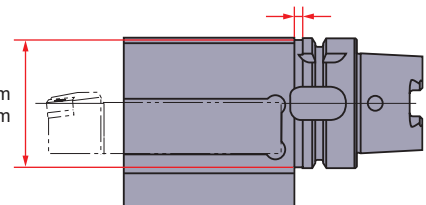
HSK-A spindle
Machining centre

*Note

Short neck length from the flange with thick body of the HSK-T turning tool as shown in the figure at the left. Because there are machines which cannot be mounted depending on the ATC specifications of the multi-task machine (HSK-A type), please check beforehand. Also be careful of interference of the magazine with adjacent tools.

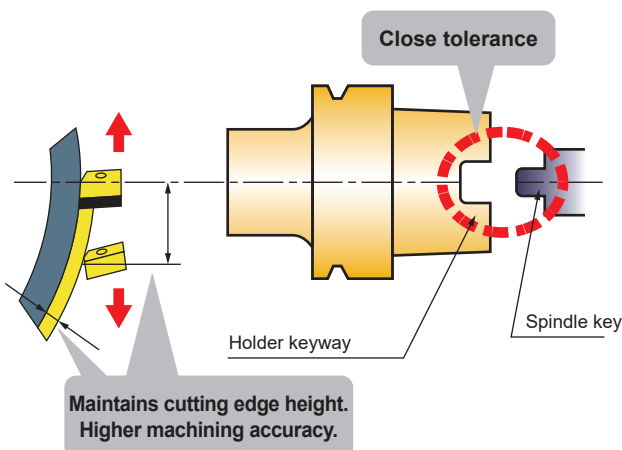
Neck length
HSK-T63 Min.4mm
HSK-T100 Min.5mm

Neck thickness
HSK-T63 Max.62mm
HSK-T100 Max.99mm



HSK-T turning tool standard (Example)

Improved keyway tolerance



Tolerance comparison (Example)

(mm)

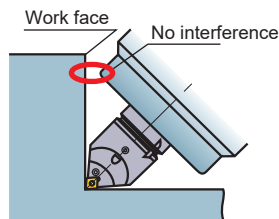
	12.2	12.3	12.4	12.5	12.6
HSK A63		12.25	12.35		
			0.10 Key tolerance		
			0.15 Minimum clearance	0.08	
				12.25 Keyway tolerance	12.58
			0.33 Maximum clearance		
HSK T63			12.385	12.41	
			0.025		
			0.015 Minimum clearance	0.035	
				12.425	12.46
				0.075 Maximum clearance	

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

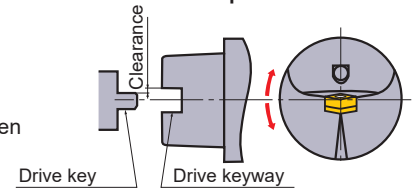
Avoid workpiece interference with improved tool accessibility.

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

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



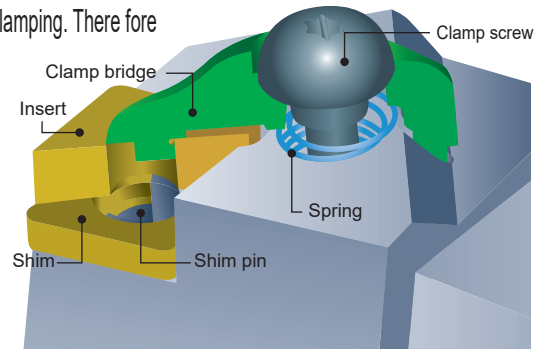
Handed type for turning and facing



Straight type for turning and facing



For turning, facing and boring



H
HSK-T TOOLS

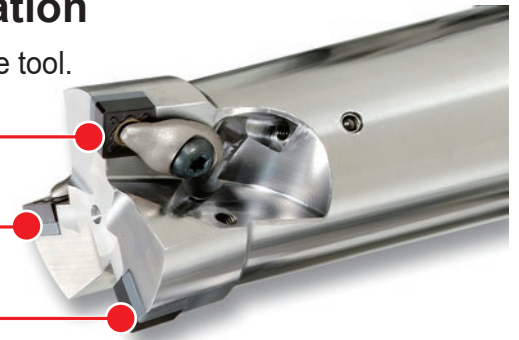
3 on 1 tool for process and tool consolidation

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 (roughing, semi finishing and finishing)

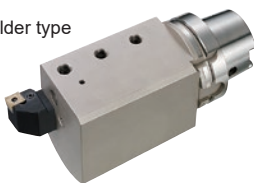
Inserts in different grade types can be installed to cover various kinds of workpieces.



New HSK-T100 size for large workpieces

Larger tool holder sizes for high efficiency machining.

Square shank holder type



Boring bar / Drill type

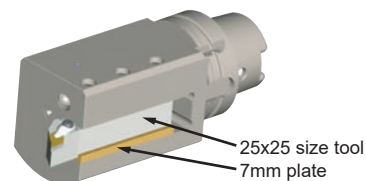


Sleeve




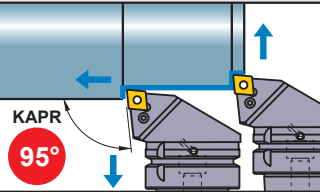

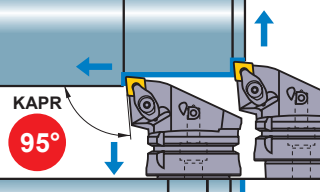

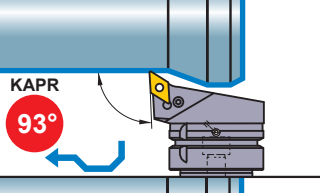

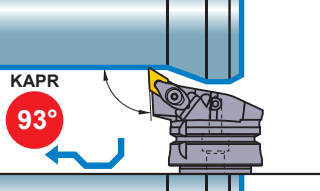

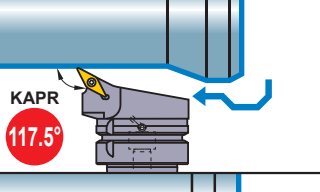

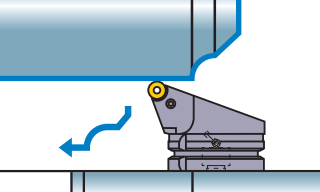

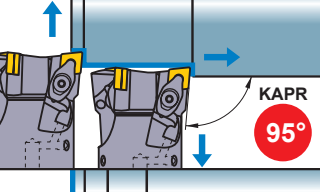

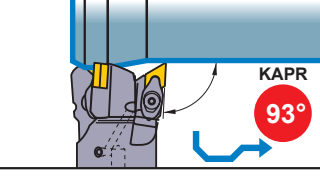
A single tool can be used with different sized tool holders.


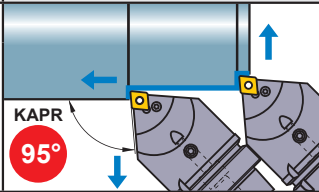

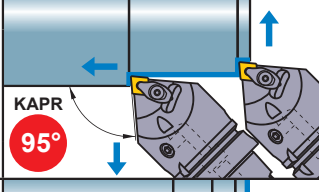

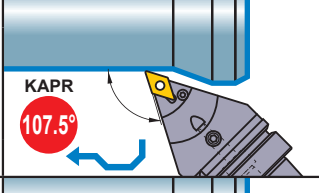

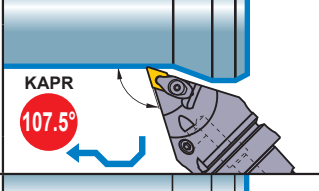

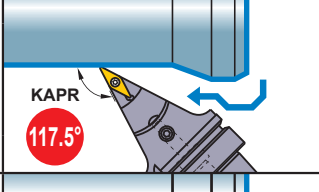

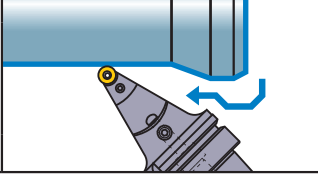
- Available for use with JIS B4126 (ISO 5610) 32x32 and 32x25 tools.
- Possible to fit a 25x25 tool by using a 7mm plate.
- *Please prepare a plate on your own.




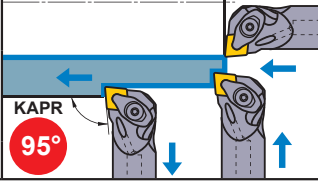
CLASSIFICATION OF HSK-T TOOLS

EXTERNAL TURNING • FACING • COPYING

Order Number	Cutting Mode
H63TH-PCLNR/L-DX12  ↻ H006	 KAPR 95°
H63TH-DCLNR/L-DX12  ↻ H006	 KAPR 95°
H63TH-PDJNR/L-DX15  ↻ H009	 KAPR 93°
H63TH-DDJNR/L-DX15  ↻ H009	 KAPR 93°
H63TH-SVPBR/L-DX16  ↻ H013	 KAPR 117.5°
H63TH-PRGCR/L-DX12  ↻ H012	 KAPR 95°
H63TH-DCLNL-L12-3  ↻ H008	 KAPR 95°
H63TH-DDJNL-L15-3  ↻ H011	 KAPR 93°

Order Number	Cutting Mode
H63TH-PCMNN-H/L12  ↻ H007	 KAPR 95°
H63TH-DCMNN-H/L12  ↻ H007	 KAPR 95°
H63TH-PDNNN-H/L15  ↻ H010	 KAPR 107.5°
H63TH-DDNNN-H/L15  ↻ H010	 KAPR 107.5°
H63TH-SVVBH-H/L16  ↻ H013	 KAPR 117.5°
H63TH-PRDCN-H/L12  ↻ H012	 KAPR 95°


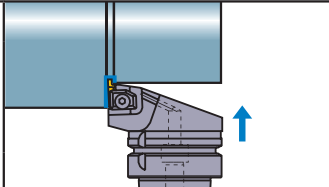

EXTERNAL TURNING • FACING • BORING

Order Number	Cutting Mode
H63TH-A25KDCLNR/L12 H63TH-A32LDCLNR/L12  ↻ H008	 KAPR 95°


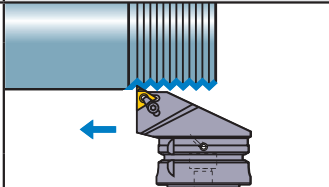


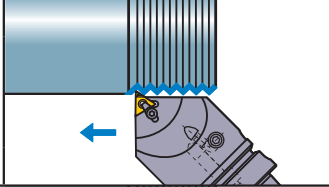


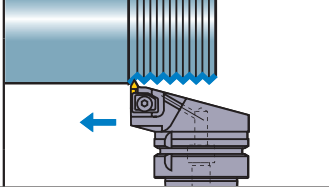

HSK-T TOOLS

H






GROOVING

Order Number	Cutting Mode
H63TH-MGHR/L-DX43    H014	







THREADING

Order Number	Cutting Mode
H63TH-MMTER-DX16    H016	
H63TH-MMTENR-H/L16    H016	
H63TH-MTHR/L-DX43    H017	

EXTERNAL TURNING TOOL HOLDERS

Order Number	Holder
H63TH-EV2525R/L-112   H019	
H100TH-EV3232R/L-180   H019	
H63TH-EN2525R/L-115  *1  H020	
H100TH-EN3232R/L-130  *1  H020	
H63TH-EV2020R/L-105-3   H021	

BORING BAR HOLDERS

Order Number	Holder
H63TH-B   H021	
H100TH-B   H022	
SL32-90 (Sleeve)  *2  H022	

Note 1) The HSK63A shank type has a built-in coolant pipe for installation.

*1 Mitsubishi Materials is licensed for production and distribution of these tools from MORI SEIKI CO., LTD under Patent No.3720202.

*2 The SL32-90 sleeve is only for use with H100TH-B32-135.

H

HSK-T TOOLS

FOR MULTI-TASK MACHINES

PCLN

External turning • Facing

Right hand tool holder shown.

Order Number	Stock		Insert Number	Dimensions (mm)			*2 WT (kg)				*1		
	R	L		DCONMS	LF	WF		Shim	Shim Pin	Clamp Lever	Clamp Screw	Wrench	
H63TH-PCLNR/L-DX12	●	●	CN○A CN○G CN○M	1204	63	65	45	1.3	LLSCN42	LLP14	LLCL14	LLCS108	HKY30R

*1 Clamp Torque (N • m) : LLCS108=3.3

*2 WT : Tool Weight

Note 1) Dimensions shown for insert corner RE 0.8.

DCLN

External turning • Facing **DOUBLE CLAMP type**

Right hand tool holder shown.

Order Number	Stock		Insert Number	Dimensions (mm)			*2 WT (kg)					*1		
	R	L		DCONMS	LF	WF		Shim	Shim Pin	Clamp Bridge	Spring	Clamp Screw	Wrench	
H63TH-DCLNR/L-DX12	●	●	CN○A CN○G CN○M	1204	63	65	45	1.3	LLSCN42	LLP14	DCK2613	DCS1	DC0621T	TKY20F

*1 Clamp Torque (N • m) : DC0621T=5.0

*2 WT : Tool Weight









Note 1) Dimensions shown for insert corner RE 0.8.







PCLN type inserts	> A100 – A106
DCLN type inserts	> A100 – A106
CBN & PCD inserts	> B028 – B031, B068
RECOMMENDED CUTTING CONDITIONS	> A076

● : Inventory maintained in Japan.

PCMN

External turning • Facing

Finish	Light	Medium
FP  (12)	LP  (12)	MP  (12)
Medium MK  (12)	Medium Standard  (12)	Medium-Rough RP  (12)
Stainless MM  (12)	CBN  (12)	

Order Number	Stock	Insert Number	Dimensions (mm)		*2 WT (kg)							
			DCONMS	LF		Shim	Shim Pin	Clamp Lever	Clamp Screw	Plug	Wrench	
H63TH-PCMNN-H12	●	CN \circ A CN \circ G CN \circ M	1204 \circ	63	100	1.7	LLSCN42	LLP14	LLCL14	LLCS108	HGM-PT1/8	HKY30R
H63TH-PCMNN-L12	●			63	140	2.7	LLSCN42	LLP14	LLCL14	LLCS108	HGM-PT1/8	HKY30R









*1 Clamp Torque (N • m) : LLCS108=3.3







*2 WT : Tool Weight

Note 1) Dimensions shown for insert corner RE 0.8.

DCMNN

External turning • DOUBLE CLAMP type Facing

Finish	Light	Medium
FP  (12)	LP  (12)	MP  (12)
Medium MK  (12)	Medium Standard  (12)	Medium-Rough RP  (12)
Stainless MM  (12)	CBN  (12)	

Order Number	Stock	Insert Number	Dimensions (mm)		*2 WT (kg)							
			DCONMS	LF		Shim	Shim Pin	Clamp Bridge	Spring	Clamp Screw	Wrench	
H63TH-DCMNN-H12	●	CN \circ A CN \circ G CN \circ M	1204 \circ	63	100	1.7	LLSCN42	LLP14	DCK2613	DCS1	DC0621T	TKY20F
H63TH-DCMNN-L12	●			63	140	2.7	LLSCN42	LLP14	DCK2613	DCS1	DC0621T	TKY20F

*1 Clamp Torque (N • m) : DC0621T=5.0

*2 WT : Tool Weight

Note 1) Dimensions shown for insert corner RE 0.8.

PCMN type inserts > A100–A106
 DCMN type inserts > A100–A106
 CBN & PCD inserts > B028–B031, B068

RECOMMENDED CUTTING CONDITIONS > A076
 SPARE PARTS > Q001
 TECHNICAL DATA > R001

H

HSK-T TOOLS

H007

FOR MULTI-TASK MACHINES

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

Finish	Light	Medium
FP (12)	LP (12)	MP (12)
Medium MK (12)	Medium Standard (12)	Medium-Rough RP (12)
Stainless MM (12)	CBN (12)	

Left hand tool holder only.

Order Number	Stock		Insert Number	Dimensions (mm)			*2 WT (kg)	Shim	Shim Pin	Clamp Bridge	Spring	Clamp Screw *1	Wrench	
	L			DCONMS	LF	WF								
H63TH-DCLNL-L12-3	●		CN○A CN○G CN○M	1204○○	63	140	30	2.2	LLSCN42	LLP14	DCK2613	DCS1	DC0621T	TKY20F

*1 Clamp Torque (N • m) : DC0621T=5.0

*2 WT : Tool Weight

Note 1) Dimensions shown for insert corner RE 0.8.

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

Finish	Light	Medium
FP (12)	LP (12)	MP (12)
Medium MK (12)	Medium Standard (12)	Medium-Rough RP (12)
Stainless MM (12)	CBN (12)	

Right hand tool holder shown.

Order Number	Stock		Insert Number	Dimensions (mm)					*2 WT (kg)	DMIN (mm)	Shim	Shim Pin	Clamp Bridge	Spring	Clamp Screw *1	Wrench	
	R	L		DCONMS	LF	LU	WF	GAMF									
H63TH-A25KDCLNR/L12	●	●	CN○A CN○G CN○M	1204○○	63	125	82	17	11°	32	1.1	LLSCP42	LLP14	DCK2613	DCS1	DC0621T	TKY20F
H63TH-A32LDCLNR/L12	●	●	CN○A CN○G CN○M	1204○○	63	140	100	22	13°	40	1.4	LLSCN42	LLP14	DCK2613	DCS1	DC0621T	TKY20F

*1 Clamp Torque (N • m) : DC0621T=5.0

*2 WT : Tool Weight

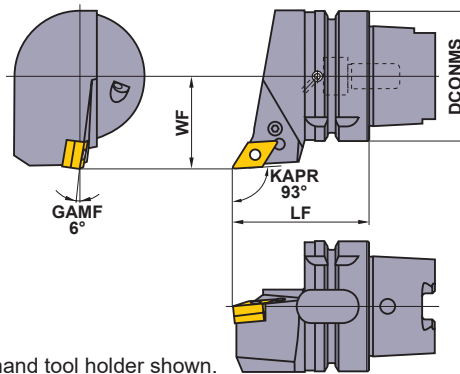
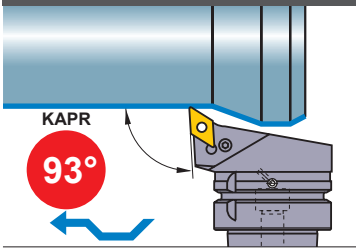
Note 1) Dimensions shown for insert corner RE 0.8.

● : Inventory maintained in Japan.









DCLN type inserts > A100 – A106
 CBN & PCD inserts > B028 – B031, B068
 RECOMMENDED CUTTING CONDITIONS > A076

PDJN

External turning • Copying



Right hand tool holder shown.

Finish	Light	Medium
FP  (15)	LP  (15)	MP  (15)
Medium MK  (15)	Medium – Rough RP  (15)	Stainless MM  (15)
G Class R/L  (15)	CBN  (15)	

Order Number	Stock		Insert Number	Dimensions (mm)			*3 WT (kg)	*2					
	R	L		DCONMS	LF	WF		Shim	Shim Pin	Clamp Lever	Clamp Screw	Wrench	
H63TH-PDJNR/L-DX15	●	●	DNOA DNOG DNOM DNMX	1504	63	65	45	1.2	LLSDN43 (LLSDN42)	LLP14	LLCL24	LLCS108	HKY30R

*1 Clamp Torque (N • m) : LLCS108=3.3

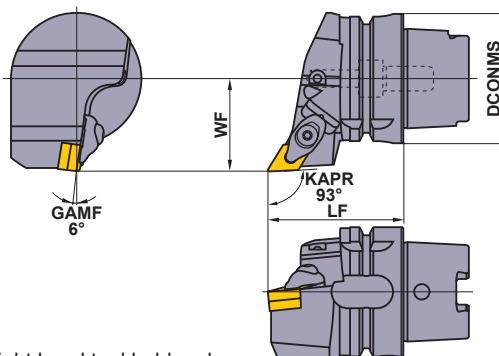
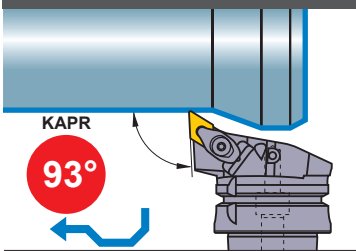
*2 Please use shim no. LLSDN42 with 6.35mm thick inserts. When using 6.35mm thick inserts, the shim should be ordered separately.

*3 WT : Tool Weight









Note 1) Dimensions shown for insert corner RE 0.8.

DDJN

External turning • DOUBLE CLAMP type



Right hand tool holder shown.

Finish	Light	Medium
FP  (15)	LP  (15)	MP  (15)
Medium MK  (15)	Medium – Rough RP  (15)	Stainless MM  (15)
G Class R/L  (15)	CBN  (15)	

Order Number	Stock		Insert Number	Dimensions (mm)			*3 WT (kg)	*2						
	R	L		DCONMS	LF	WF		Shim	Shim Pin	Clamp Bridge	Spring	Clamp Screw	Wrench	
H63TH-DDJNR/L-DX15	●	●	DNOA DNOG DNOM DNMX	1504	63	65	45	1.2	LLSDN43 (LLSDN42)	LLP24	DCK2613	DCS1	DC0621T	TKY20F

*1 Clamp Torque (N • m) : DC0621T=5.0

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

*3 WT : Tool Weight

Note 1) Dimensions shown for insert corner RE 0.8.

PDJN type inserts	> A107 – A113
DDJN type inserts	> A107 – A113
CBN & PCD inserts	> B032 – B036, B068

RECOMMENDED CUTTING CONDITIONS	> A076
SPARE PARTS	> Q001
TECHNICAL DATA	> R001

H

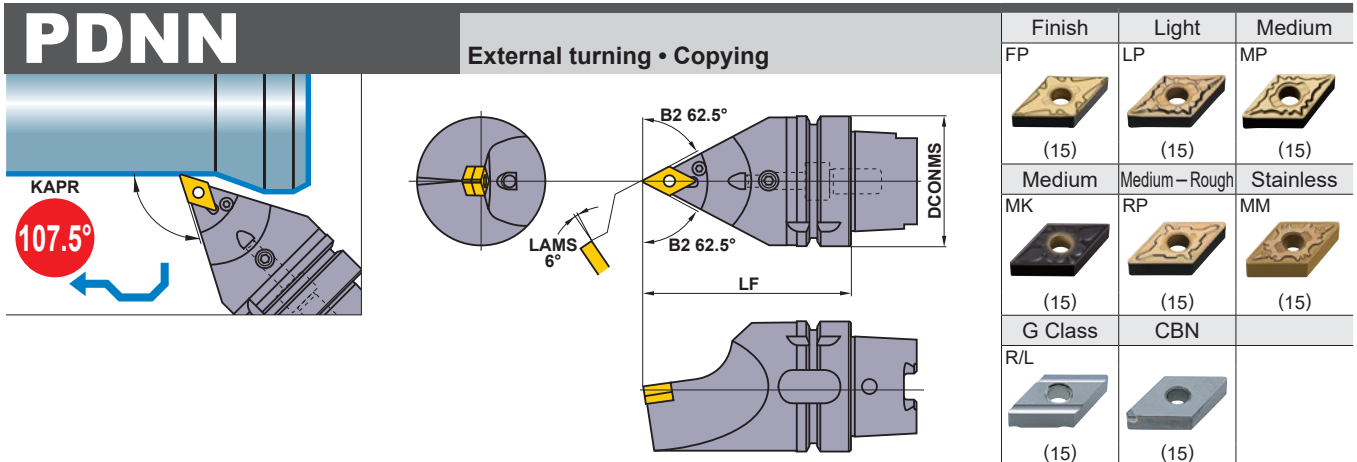
HSK-T TOOLS

H009

FOR MULTI-TASK MACHINES

PDNN

External turning • Copying



Finish	Light	Medium
FP (15)	LP (15)	MP (15)
Medium MK (15)	Medium-Rough RP (15)	Stainless MM (15)
G Class R/L (15)	CBN (15)	

Order Number	Stock	Insert Number	Dimensions (mm)		*3 WT (kg)	*2						
			DCONMS	LF		Shim	Shim Pin	Clamp Lever	Clamp Screw	Plug	Wrench	
H63TH-PDNNN-H15	●	DN \odot A DN \odot G DN \odot M	1504 \odot	63	100	1.6	LLSDN43 (LLSDN42)	LLP14	LLCL24	LLCS108	HGM-PT1/8	HKY30R
H63TH-PDNNN-L15	●			63	140	2.5	LLSDN43 (LLSDN42)	LLP14	LLCL24	LLCS108	HGM-PT1/8	HKY30R

*1 Clamp Torque (N • m) : LLCS108=3.3

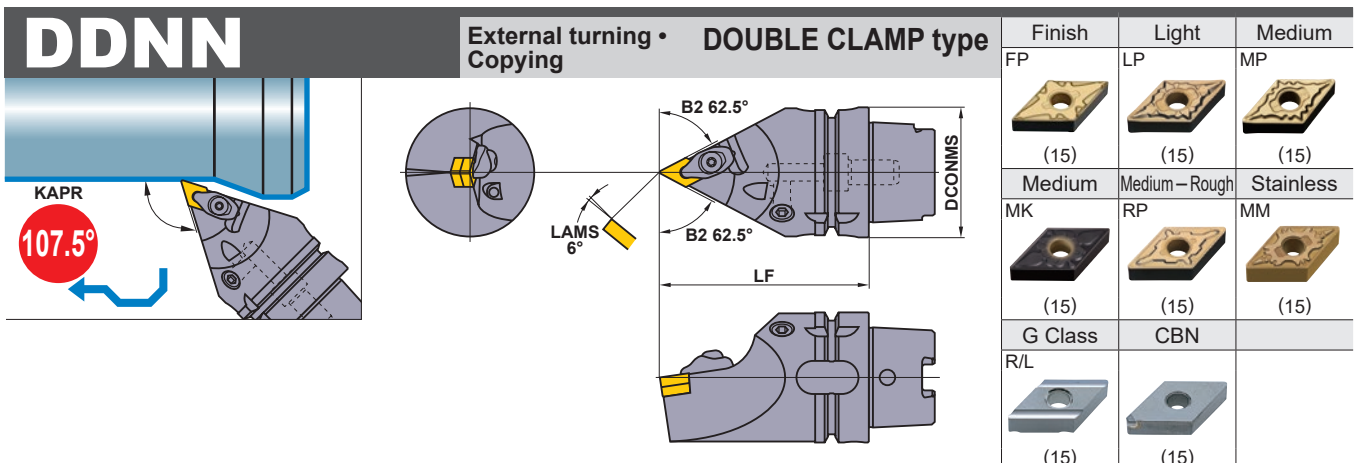
*2 Please use shim no. LLSDN42 with 6.35mm thick inserts. When using 6.35mm thick inserts, the shim should be ordered separately.

*3 WT : Tool Weight

Note 1) Dimensions shown for insert corner RE 0.8.

DDNN

External turning • Copying **DOUBLE CLAMP type**



Finish	Light	Medium
FP (15)	LP (15)	MP (15)
Medium MK (15)	Medium-Rough RP (15)	Stainless MM (15)
G Class R/L (15)	CBN (15)	

Order Number	Stock	Insert Number	Dimensions (mm)		*3 WT (kg)	*2						
			DCONMS	LF		Shim	Shim Pin	Clamp Bridge	Spring	Clamp Screw	Wrench	
H63TH-DDNNN-H15	●	DN \odot A DN \odot G DN \odot M	1504 \odot	63	100	1.6	LLSDN43 (LLSDN42)	LLP24	DCK2613	DCS1	DC0621T	TKY20F
H63TH-DDNNN-L15	●			63	140	2.5	LLSDN43 (LLSDN42)	LLP24	DCK2613	DCS1	DC0621T	TKY20F

*1 Clamp Torque (N • m) : DC0621T=5.0

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

*3 WT : Tool Weight

Note 1) Dimensions shown for insert corner RE 0.8.







● : Inventory maintained in Japan.

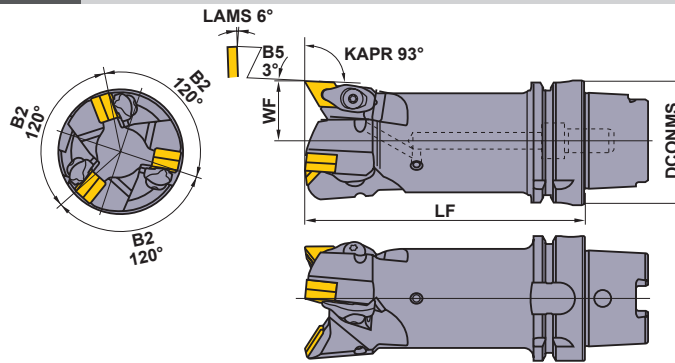
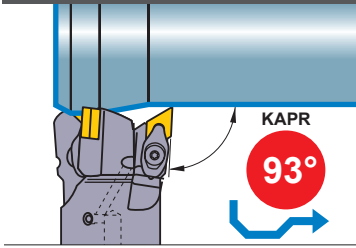
PDNN type inserts	> A107-A113
DDNN type inserts	> A107-A113
CBN & PCD inserts	> B032-B036, B068
RECOMMENDED CUTTING CONDITIONS	> A076

DDJN

External turning • Facing

DOUBLE CLAMP type

Finish	Light
FP  (15)	LP  (15)
Medium MP  (15)	Medium MK  (15)
Medium – Rough RP  (15)	Stainless MM  (15)



Left hand tool holder only.

Order Number	Stock L	Insert Number	Dimensions (mm)			*3 WT (kg)	*2														
			DCONMS	LF	WF		Shim	Shim Pin	Clamp Bridge	Spring	Clamp Screw	Wrench									
H63TH-DDJNL-L15-3	●	<table border="1"> <tr> <td>DN</td> <td>A</td> </tr> <tr> <td>DN</td> <td>G</td> </tr> <tr> <td>DN</td> <td>M</td> </tr> <tr> <td>DN</td> <td>MX</td> </tr> </table>	DN	A	DN	G	DN	M	DN	MX	1504	63	140	30	2.2	LLSDN43 (LLSDN42)	LLP24	DCK2613	DCS1	DC0621T	TKY20F
DN	A																				
DN	G																				
DN	M																				
DN	MX																				

*1 Clamp Torque (N • m) : DC0621T=5.0

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

*3 WT : Tool Weight

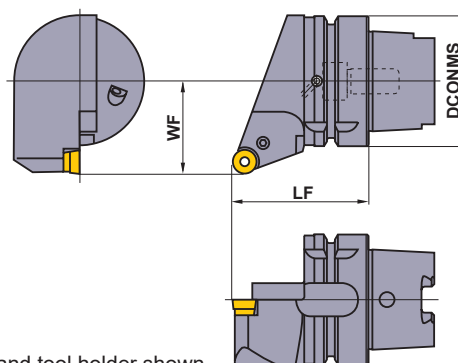
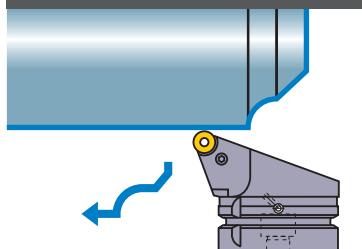
Note 1) Dimensions shown for insert corner RE 0.8.

FOR MULTI-TASK MACHINES

PRGC

External turning • Facing • Copying

Medium



Right hand tool holder shown.

Order Number	Stock		Insert Number	Dimensions (mm)			*2 WT (kg)	*1				
	R	L		DCONMS	LF	WF		Shim	Shim Pin	Clamp Lever	Clamp Screw	Wrench
H63TH-PRGCR/L-DX12	●	●	RCMX 1204M0	63	65	45	1.2	LLSRN123	LLP13	LLCL112	LLCS106	HKY25R

*1 Clamp Torque (N • m) : LLCS106=2.2

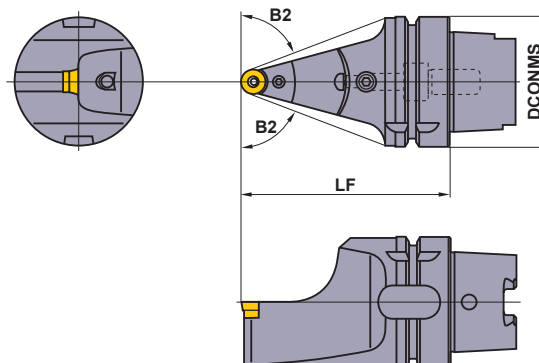
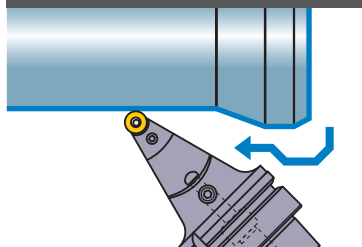
*2 WT : Tool Weight

HSK-T TOOLS

PRDC

External turning • Facing • Copying

Medium



Order Number	Stock		Insert Number	Dimensions (mm)			*2 WT (kg)	*1					
	R	L		DCONMS	LF	B2		Shim	Shim Pin	Clamp Lever	Clamp Screw	Plug	Wrench
H63TH-PRDCN-H12	●	●	RCMX 1204M0	63	100	69°	1.4	LLSRN123	LLP13	LLCL112	LLCS106	HGM-PT1/8	HKY25R
H63TH-PRDCN-L12	●	●		63	140	75°	2.3	LLSRN123	LLP13	LLCL112	LLCS106	HGM-PT1/8	HKY25R

*1 Clamp Torque (N • m) : LLCS106=2.2

*2 WT : Tool Weight

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—350HB	Medium Cutting	Standard	UE6110	150—260
M	Stainless Steel	≤200HB	Medium Cutting	Standard	US735	70—130

● : Inventory maintained in Japan.

PRGC type inserts > A156
PRDC type inserts > A156

SVPB

Facing • Copying

Right hand tool holder shown.

Finish		Light	
R/L-F	SV		
(16)	(16)		
Medium		Medium	
MV	MP		
(16)	(16)		
CBN			
(16)			

Order Number	Stock		Insert Number	Dimensions (mm)				*2 WT (kg)			*1		
	R	L		DCONMS	LF	WF	WF2		Shim	Shim Pin	Clamp Screw	Wrench	
H63TH-SVPBR/L-DX16	●	●	VB[○]T VB[○]W	1604	63	65	45	3.8	1.1	SPSVN32	BCP141	TS35D	TKY15F

*1 Clamp Torque (N • m) : TS35D=3.5

*2 WT : Tool Weight

Note 1) Dimensions shown for insert corner RE 0.8.

SVVB

Facing • Copying

Finish		Light	
R/L-F	SV		
(16)	(16)		
Medium		Medium	
MV	MP		
(16)	(16)		
CBN			
(16)			

Order Number	Stock		Insert Number	Dimensions (mm)			*2 WT (kg)			*1			
	R	L		DCONMS	LF	B2		Shim	Shim Pin	Clamp Screw	Plug	Wrench	
H63TH-SVVBH-H16	●	●	VB[○]T VB[○]W	1604	63	100	66.5°	1.3	SPSVN32	BCP141	TS35D	HGM-PT1/8	TKY15F
H63TH-SVVBH-L16	●	●	VB[○]T VB[○]W	1604	63	140	72.5°	2.2	SPSVN32	BCP141	TS35D	HGM-PT1/8	TKY15F

*1 Clamp Torque (N • m) : TS35D=3.5

*2 WT : Tool Weight

Note 1) Dimensions shown for insert corner RE 0.8.

RECOMMENDED CUTTING CONDITIONS

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

SVPB type inserts > A167 – A169

SVVB type inserts > A167 – A169

CBN inserts > B061

SPARE PARTS > Q001

TECHNICAL DATA > R001

H

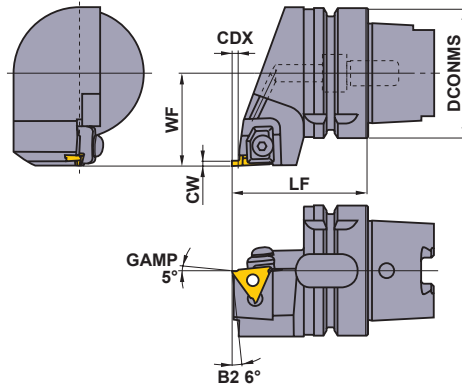
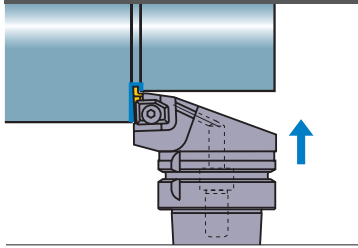
HSK-T TOOLS

H013

FOR MULTI-TASK MACHINES

MG

Grooving



Right hand tool holder shown.

Order Number	Stock		Insert Number	Dimensions (mm)				*2 WT (kg)	*1			
	R	L		CW	CDX	LF	WF		Clamp Bridge	Clamp Screw	Spring	Wrench
H63TH-MGHR/L-DX4315	●	●	MGTR/L 43125 I 43470	1.25	1.2	65	45	1.2	MTK1R/L	HBH06020	MES3	HKY40R
				1.45	1.5	65	45	1.2				
H63TH-MGHR/L-DX4323	●	●	MGTR/L 43125 I 43470	1.5 ≤ CW ≤ 2.3	3	65	45	1.2	MTK1R/L	HBH06020	MES3	HKY40R
H63TH-MGHR/L-DX4333	●	●		2.3 < CW ≤ 3.3	4.5	65	45	1.2				
	●	●		3.3 < CW ≤ 4.7	4.5	65	45	1.2				

*1 Clamp Torque (N · m) : HBH06020=7.0

*2 WT : Tool Weight

H

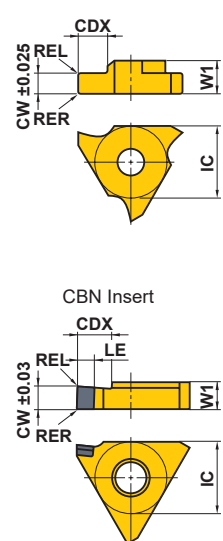
HSK-T TOOLS

RECOMMENDED CUTTING CONDITIONS

	Work Material	Hardness	Grade	Cutting Speed (m/min)	Feed (mm/rev)
P	Carbon Steel Alloy Steel	180–350HB	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	Gray Cast Iron	Tensile Strength ≤ 350MPa	VP20MF	120 (100–140)	0.10 (0.03–0.18)

● : Inventory maintained in Japan. □ : Non stock, produced to order only.
(10 inserts in one case) (CBN inserts are available in 1 piece in one case.)

INSERTS FOR MG TYPE

Order Number	Stock							Dimensions (mm)					Geometry		
	Coated		Cermet		Carbide		CBN		CW	CDX	IC	W1		RER/L	LE
	VP20MF		NX2525		UTi20T		MB8025								
	R	L	R	L	R	L	R								
MGTR/L43125	●	●	●	□	●	●	●	1.25	1.2	12.7	4.76	0.2	2.7	MGTR/L... 	
MGTR/L43145	●	□	□	□	●	□	●	1.45	1.5	12.7	4.76	0.2	—		
MGTR/L43150	●	●	●	●	●	●	●	1.5	3	12.7	4.76	0.2	2.7		
MGTR/L43175	●	●	●	□	●	●	●	1.75	3	12.7	4.76	0.2	—		
MGTR/L43200	●	●	●	●	●	●	●	2	3	12.7	4.76	0.2	2.7		
MGTR/L43230	●	●	●	●	●	●	●	2.3	3	12.7	4.76	0.2	—		
MGTR/L43250	●	●	●	●	●	●	●	2.5	4.5	12.7	4.76	0.3	2.7		
MGTR/L43260	●	□	□	□	●	●	●	2.6	4.5	12.7	4.76	0.3	—		
MGTR/L43270	●	□	□	□	●	□	□	2.7	4.5	12.7	4.76	0.3	—		
MGTR/L43280	●	●	□	□	●	●	●	2.8	4.5	12.7	4.76	0.3	—		
MGTR/L43300	●	●	●	●	●	●	●	3	4.5	12.7	4.76	0.3	2.7		
MGTR/L43320	●	□	□	□	●	●	●	3.2	4.5	12.7	4.76	0.3	—		
MGTR/L43330	●	●	□	□	●	●	●	3.3	4.5	12.7	4.76	0.3	—		
MGTR/L43350	●	□	●	□	●	●	●	3.5	4.5	12.7	4.76	0.3	2.7		
MGTR/L43400	●	●	●	□	●	●	●	4	4.5	12.7	4.76	0.3	2.7		
MGTR/L43420	●	□	□	□	●	□	□	4.2	4.5	12.7	4.76	0.4	—		
MGTR/L43430	●	□	□	□	●	●	□	4.3	4.5	12.7	4.76	0.4	—		
MGTR/L43450	●	●	●	●	●	●	□	4.5	4.5	12.7	4.76	0.4	—		
MGTR/L43470	●	□	□	□	●	□	□	4.7	4.5	12.7	4.76	0.4	—		

Right hand insert shown.

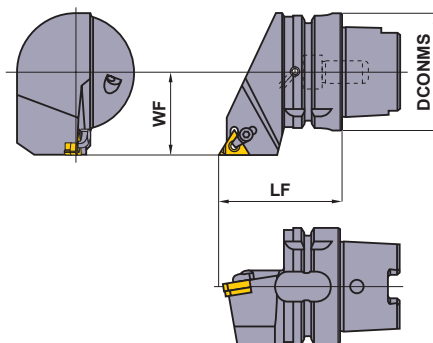
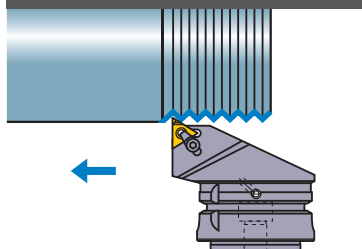
H

HSK-T TOOLS

FOR MULTI-TASK MACHINES

MMTE

Threading



Right hand tool holder only.

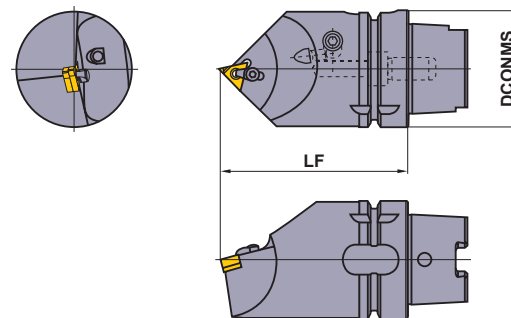
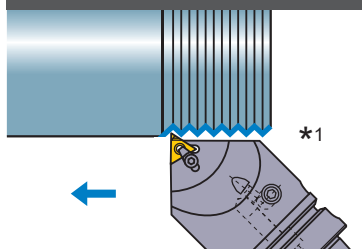
Order Number	Stock	Insert Number	Dimensions (mm)			*2 WT (kg)		*1			*1	
			DCONMS	LF	WF							
H63TH-MMTER-DX16	●	MMT16ER	63	65	45	1.2	SETK51	SETS51	CR4	CTE32TP15	HFC03008	TKY15F HKY20R

*1 Clamp Torque (N • m) : SETS51=3.5, HFC03008=1.5

*2 WT : Tool Weight

MMTEN

Threading



Tool holder for right hand insert only.

Order Number	Stock	Insert Number	Dimensions (mm)			*3 WT (kg)		*2			*2		
			DCONMS	LF									
H63TH-MMTENR-H16	●	MMT16ER	63	100		1.7	SETK51	SETS51	CR4	CTE32TP15	HFC03008	HGM-PT1/8	TKY15F HKY20R
H63TH-MMTENR-L16	●	MMT16ER	63	140		2.7	SETK51	SETS51	CR4	CTE32TP15	HFC03008	HGM-PT1/8	TKY15F HKY20R

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

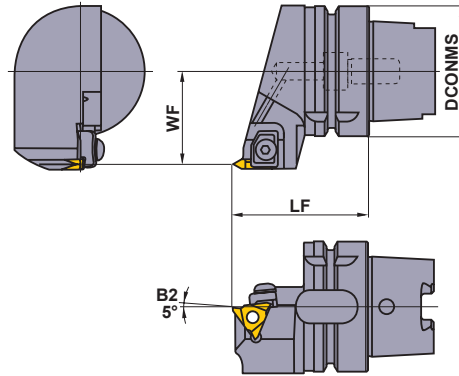
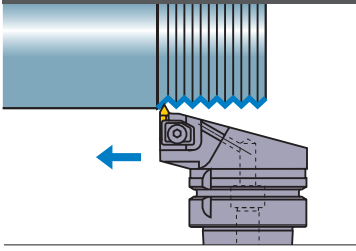
*2 Clamp Torque (N • m) : SETS51=3.5, HFC03008=1.5

*3 WT : Tool Weight

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	180–350HB	VP10MF	140 (80–200)
			VP15TF	100 (60–140)
M	Stainless Steel	≤200HB	VP10MF	130 (80–180)
			VP15TF	80 (40–120)
K	Gray Cast Iron	Tensile Strength≤350MPa	VP10MF	140 (80–200)
			VP15TF	90 (60–120)

● : Inventory maintained in Japan.

MT**Threading**

Right hand tool holder shown.

Order Number	Stock		Insert Number	Dimensions (mm)			*2 WT (kg)		*1		
	R	L		DCONMS	LF	WF		Clamp Bridge	Clamp Screw	Spring	Wrench
H63TH-MTHR/L-DX43	●	●	MTTR/L 43○○○○	63	65	45	1.2	MTK1R/L	HBH06020	MES3	HKY40R

*1 Clamp Torque (N • m) : HBH06020=7.0

*2 WT : Tool Weight

H

HSK-T TOOLS

RECOMMENDED CUTTING CONDITIONS





	Work Material	Hardness	Grade	Cutting Speed (m/min)
P	Mild Steel	≤180HB	UP20M	140 (100–180)
			NX2525	200 (150–250)
			UTi20T	120 (100–150)
	Carbon Steel Alloy Steel	180HB–350HB	UP20M	120 (100–150)
			NX2525	170 (150–200)
			UTi20T	100 (70–120)
M	Stainless Steel	≤200HB	UP20M	120 (80–150)
			UTi20T	100 (70–130)
K	Gray Cast Iron	Tensile Strength≤350MPa	UP20M	80 (60–100)
			UTi20T	80 (60–100)
			HTi10	100 (70–130)

APPLICABLE INSERT	> H018
SPARE PARTS	> Q001
TECHNICAL DATA	> R001

H017

FOR MULTI-TASK MACHINES

INSERTS FOR MT TYPE

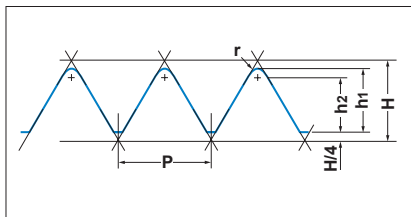
Type	Order Number	Class	Coated		Cermet		Carbide		ISO Pitch mm (thread/inch)	Dimensions (mm)			Geometry
			UP20M	NX2525	UT120T	HT110	IC	W1		RE			
General • 60°	MTTR436000	G	●	●	●	●			-0.8	12.7	4.76	0	MTTR/L(60°) (G Class)   Right hand insert shown.
	MTTR436001	G	●	●	●	●			1.0-1.75	12.7	4.76	0.1	
	MTTL436001	G	●		●	●			1.0-1.75	12.7	4.76	0.1	
	MTTR436002	G	●	●	●	●			2.0-2.5	12.7	4.76	0.2	
	MTTL436002	G	●	●	●	●			2.0-2.5	12.7	4.76	0.2	
	MTTR436003	G	□	●	●	●	●		3.0-3.5	12.7	4.76	0.3	
	MTTL436003	G		●	●	●			3.0-3.5	12.7	4.76	0.3	
MTTR436004	G		●	●	●			4.0-4.5	12.7	4.76	0.4		
General • 55°	MTTR435501	G		●	●				(28-10)	12.7	4.76	0.1	MTTR/L(55°) (G Class)   Right hand insert shown.
	MTTR435502	G		●	●				(16-8)	12.7	4.76	0.2	
	MTTR435503	G		●	●				(11-8)	12.7	4.76	0.3	

H

HSK-T TOOLS

STANDARD DEPTH OF CUT

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



METRIC THREAD

Unit : mm

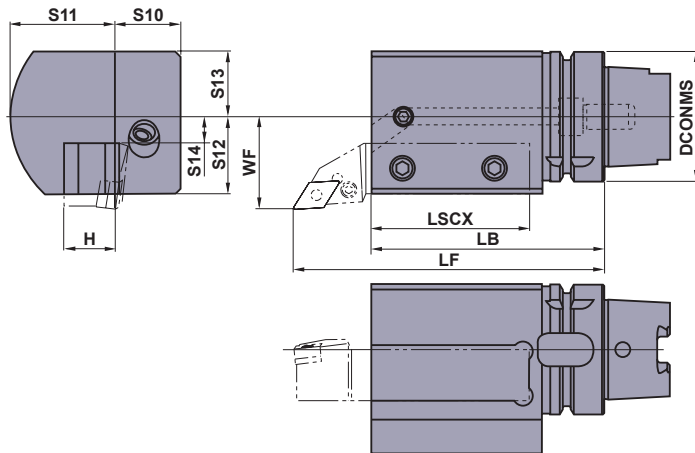
P (Pitch)	0.75	1.00	1.25	1.50	1.75	2.00	2.50	3.00	3.50	4.00	4.50	
h1	0.46	0.61	0.77	0.92	1.07	1.23	1.53	1.84	2.15	2.45	2.76	
h2	0.35	0.47	0.59	0.70	0.82	0.94	1.17	1.41	1.65	1.87	2.11	
r (Corner Radius)	0.11	0.14	0.18	0.22	0.25	0.29	0.36	0.43	0.50	0.58	0.65	
Number of Passes	1	0.18	0.20	0.20	0.25	0.25	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 1) 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.

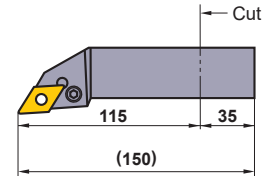
● : Inventory maintained in Japan. □ : Non stock, produced to order only.
 (10 inserts in one case)

EXTERNAL TURNING TOOL HOLDERS



External turning • Facing



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



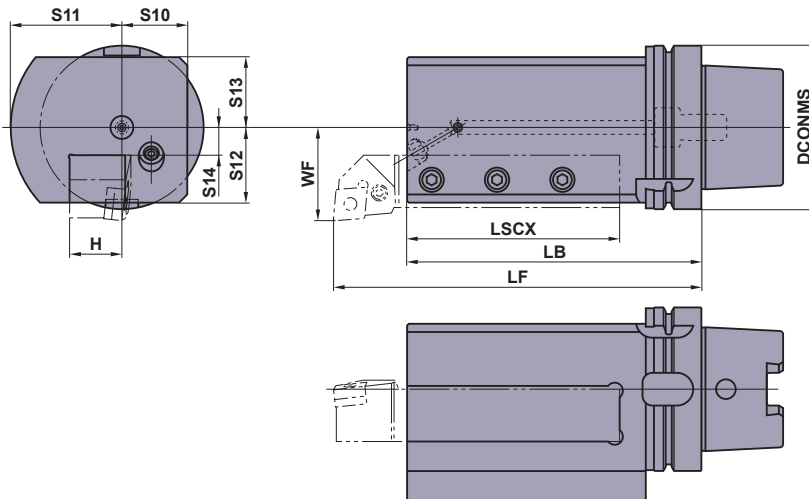
Right hand tool holder shown.

Order Number	Stock		Dimensions (mm)										* WT (kg)	 Clamp Screw	 Plug	
	R	L	DCONMS	LF	LB	LSCX	H	S10	S11	WF	S14	S12				S13
H63TH-EV2525R/L-112	●	●	63	150	112	77	25	32	53	45	13	38	32	3.9	HSS12025	HGM-PT1/8

* WT : Tool Weight



EXTERNAL TURNING TOOL HOLDERS

External turning • Facing



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

Right hand tool holder shown.

Order Number	Stock		Dimensions (mm)										* WT (kg)	 Clamp Screw	 Plug	
	R	L	DCONMS	LF	LB	LSCX	H	S10	S11	WF	S14	S12				S13
H100TH-EV3232R/L-180	●	●	100	220	180	130	32	40	68	57	17	46	43	11.7	HSS14035	HSS06006

* WT : Tool Weight

Note 1) Possible to fit a 25 x 25 tool by using a 7mm plate.

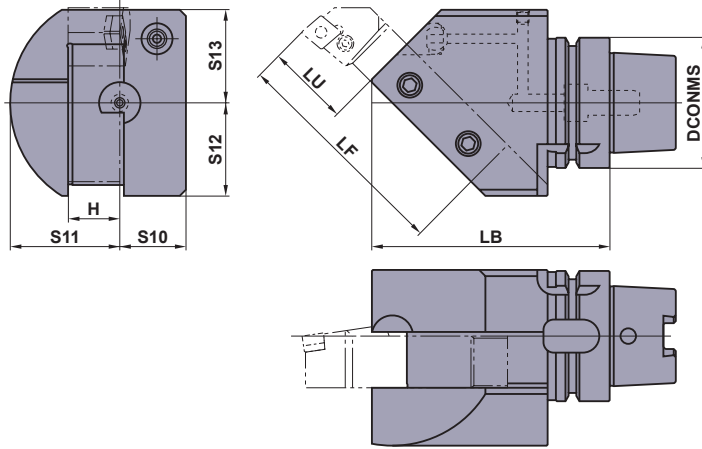
H

HSK-T TOOLS

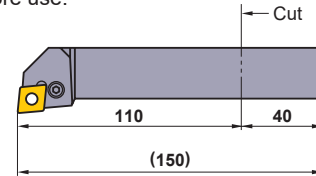
FOR MULTI-TASK MACHINES

EXTERNAL TURNING TOOL HOLDERS

External turning • Facing





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



Mitsubishi Materials is licensed for production and distribution of these tools from MORI SEIKI CO., LTD under Patent No.3720202.

Right hand tool holder shown.

Order Number	Stock		Dimensions (mm)									* WT (kg)	 Clamp Screw	 Plug
	R	L	DCONMS	LB	LU	LF	H	S10	S11	S12	S13			
H63TH-EN2525R/L-115	●	●	63	115	40	110	25	32	53	45	45	3.7	HSS12030	HSS06006

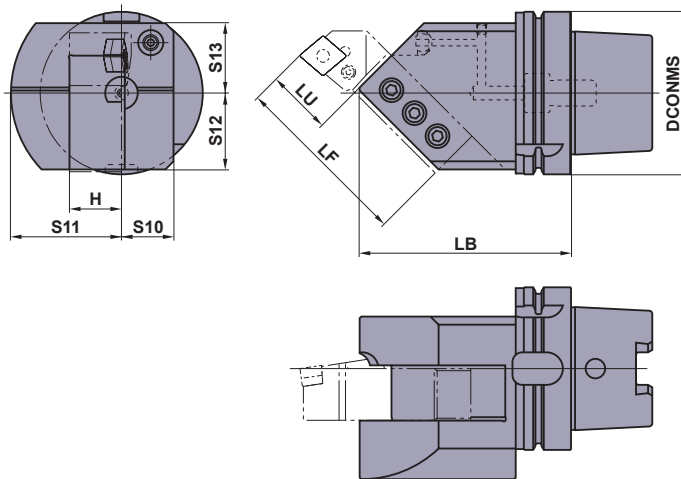
* WT : Tool Weight

H

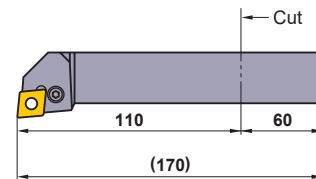
HSK-T TOOLS

EXTERNAL TURNING TOOL HOLDERS

External turning • Facing





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



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Right hand tool holder shown.

Order Number	Stock		Dimensions (mm)									* WT (kg)	 Clamp Screw	 Plug
	R	L	DCONMS	LB	LU	LF	H	S10	S11	S12	S13			
H100TH-EN3232R/L-130	●	●	100	130	40	110	32	32	68	47	43	6.6	HSS14030	HSS06006

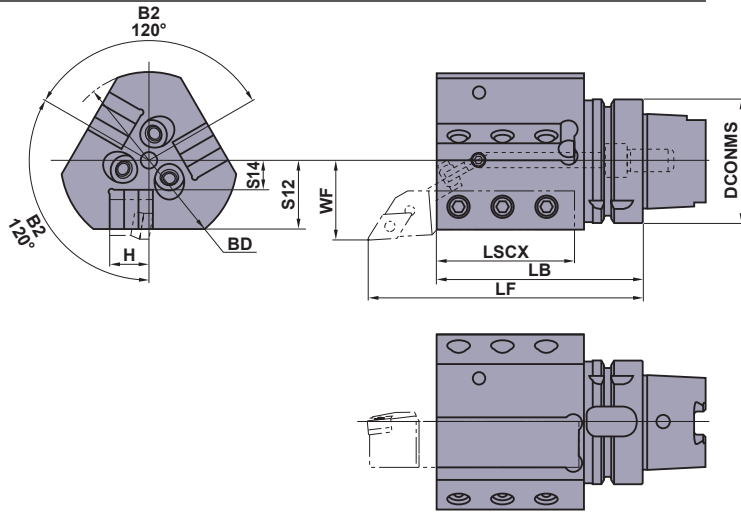
* WT : Tool Weight

Note 1) Possible to fit a 25 x 25 tool by using a 7mm plate.

● : Inventory maintained in Japan.

EXTERNAL TURNING TOOL HOLDERS

External turning • Facing



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

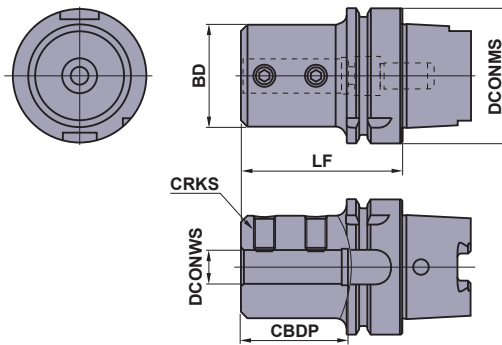
Right hand tool holder shown.

Order Number	Stock		Dimensions (mm)								WT* (kg)	 			
	R	L	DCONMS	LF	LB	LSCX	H	BD	WF	S14		S12	Clamp Screw	Nozzle Plug	Plug
H63TH-EV2020R/L-105-3	●	●	63	140	105	70	20	90	40	15	35	2.9	HSS12030	HSS05012	HSS06006

* WT : Tool Weight

BORING BAR HOLDERS

Boring



Order Number	Stock	Dimensions (mm)						WT* (kg)	 Clamp Screw
		DCONMS	BD	DCONWS	LF	CBDP	CRKS		
H63TH-B08-65	●	63	28	8	65	40	M8	0.9	HSS08010
H63TH-B10-70	●	63	35	10	70	45	M8	1.0	HSS08012
H63TH-B12-70	●	63	42	12	70	45	M8	1.1	HSS08012
H63TH-B16-75	●	63	48	16	75	50	M10	1.3	HSS10016
H63TH-B20-75	●	63	52	20	75	50	M10	1.4	HSS10016
H63TH-B25-83	●	63	62	25	83	58	M12	1.7	HSS12016
H63TH-B32-87	●	63	62	32	87	62	M12	1.7	HSS12016
H63TH-B40-97	●	63	65	40	97	72	M16	1.8	HSS16012

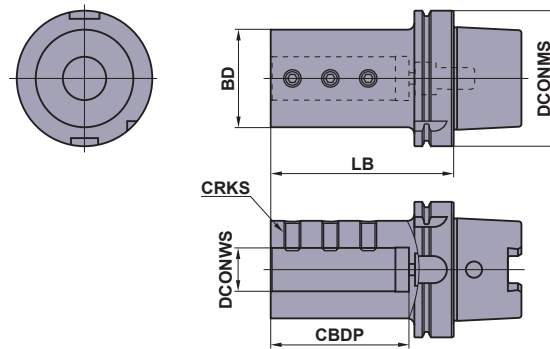
* WT : Tool Weight


Note 1) Please shorten a boring bar to the required shank length. This holder is for boring bars and indexable type drills.

FOR MULTI-TASK MACHINES

BORING BAR HOLDERS

Boring



Order Number	Stock	Dimensions (mm)						WT* (kg)	 Clamp Screw
		DCONMS	BD	DCONWS	LB	CBDP	CRKS		
H100TH-B25-120	●	100	62	25	120	88	M12	3.9	HSS12016
H100TH-B32-135	●	100	72	32	135	102	M12	4.8	HSS12018
H100TH-B40-150	●	100	82	40	150	117	M16	5.9	HSS16020
H100TH-B50-180	●	100	92	50	180	147	M16	7.7	HSS16020

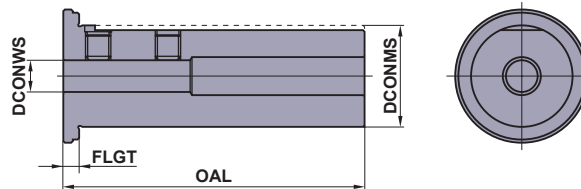
* WT : Tool Weight


Note 1) Please shorten a boring bar to the required shank length. This holder is for boring bars and indexable type drills.

H

HSK-T TOOLS

BORING BAR SLEEVES FOR H100TH-B32-135



Order Number	Stock	Dimensions (mm)				WT* (kg)	 Clamp Screw
		DCONWS	DCONMS	OAL	FLGT		
SL3208-90	●	8	32	95	5	0.6	HSS06008
SL3210-90	●	10	32	95	5	0.5	HSS08008
SL3212-90	●	12	32	95	5	0.5	HSS08008
SL3216-90	●	16	32	95	5	0.5	HSS08006
SL3220-90	●	20	32	95	5	0.4	HSS08005

* WT : Tool Weight

Note 1) These sleeves are only compatible with H100TH-B32-135 holder.

● : Inventory maintained in Japan.

SPARE PARTS > Q001
TECHNICAL DATA > R001