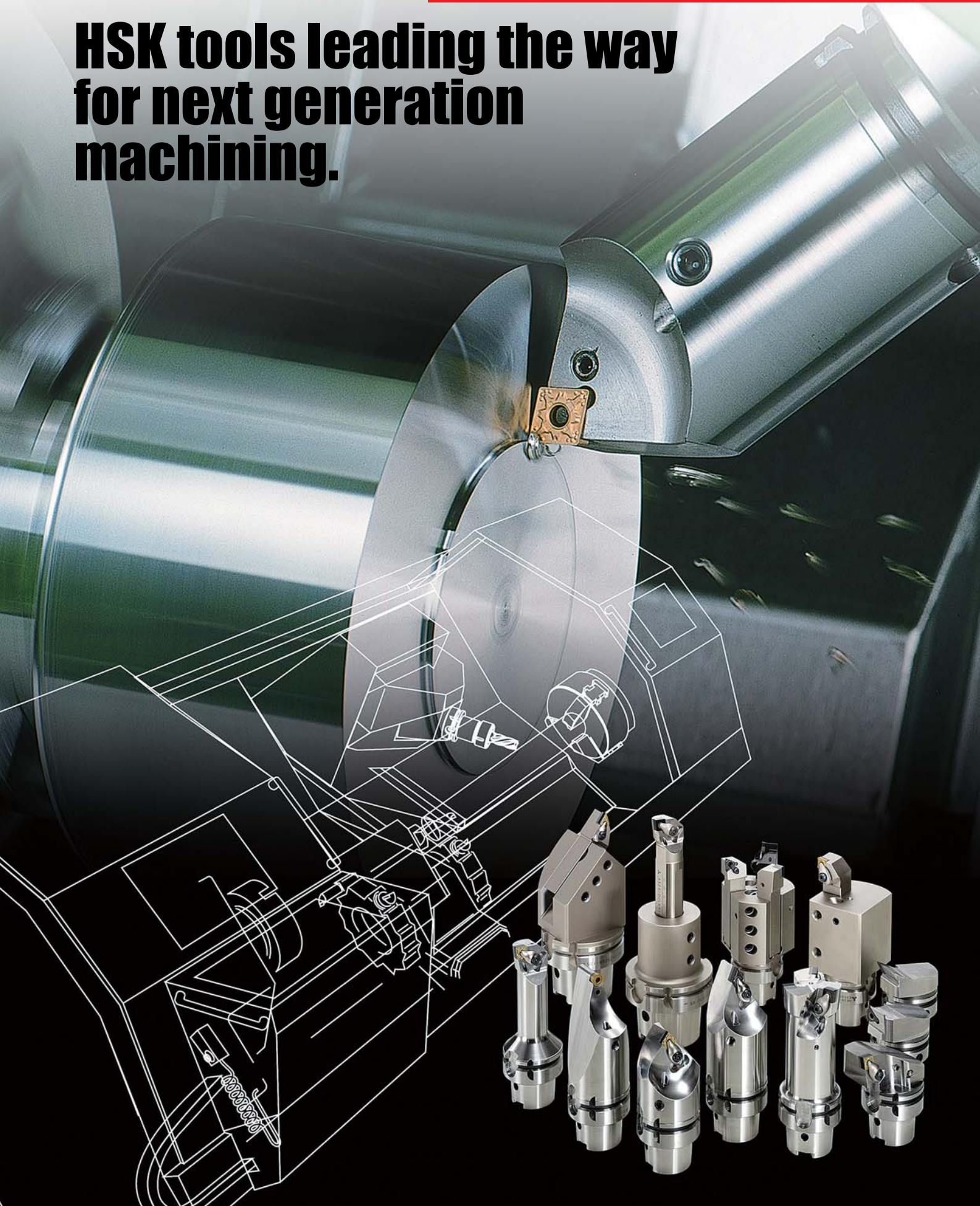


HSK tools leading the way for next generation machining.



HOW TO READ THE STANDARD OF HSK-T TOOLS

●How this section page is organised

- ① Organised by product series.
(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

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

GEOMETRY

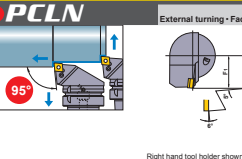
CHIP BREAKER BY CUTTING APPLICATION

HSK-T TOOLS

HSK-T SYSTEM

PCLN

External turning • Facing

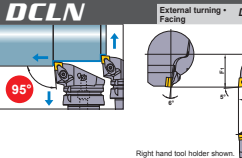


Order Number	Stock	Insert Number	Dimension (mm)	Material	Shim	Shim Pin	Clamp Lever	Clamp Screw	Coat Pipe	Wrench	
R/L		L1	F1	(kg)							
H5TH-PCLNR/L-DX12	●	CNM1 CNG0 NRCN-A	1204	100	1.7	LLSCN42	LLP14	LLCL14	LLCS108	HGM-PT18 HSK-CP185	HKY30R

* Clamp Torque (N • m) : LLCS108=3.0

DCLN

External turning • **DOUBLE CLAMP type**

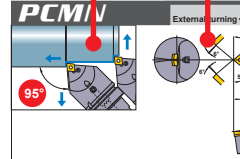


Order Number	Stock	Insert Number	Dimension (mm)	Material	Shim	Shim Pin	Clamp Bracket	Spring	Clamp Screw	Coat Pipe	Wrench	
R/L		L1	F1	(kg)								
H5TH-DCLNR/L-DX12	●	CNM1 CNG0 NRCN-A	1204	100	1.7	LLSCN42	LLP14	DCCK213	DCS1	DC0621T	HSK-CP185	TKY20F

* Clamp Torque (N • m) : DC0621T=5.0

PCMN

External turning • Facing

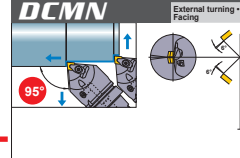


Order Number	Stock	Insert Number	Dimension (mm)	Material	Shim	Shim Pin	Clamp Lever	Clamp Screw	Coat Pipe	Wrench	
R/L		L1	F1	(kg)							
H5TH-PCMNN-H12	●	CNM1 CNG0 NRCN-A	1204	100	1.7	LLSCN42	LLP14	LLCL14	LLCS108	HGM-PT18 HSK-CP185	HKY30R

* Clamp Torque (N • m) : LLCS108=3.0

DCMN

External turning • **DOUBLE CLAMP type**



Order Number	Stock	Insert Number	Dimension (mm)	Material	Shim	Shim Pin	Clamp Bracket	Spring	Clamp Screw	Coat Pipe	Wrench	
R/L		L1	F1	(kg)								
H5TH-DCMNN-H12	●	CNM1 CNG0 NRCN-A	1204	100	1.7	LLSCN42	LLP14	DCCK213	DCS1	DC0621T	HSK-CP185	TKY20F

* Clamp Torque (N • m) : DC0621T=5.0

RECOMMENDED CUTTING CONDITIONS

Work Material	Hardness	Cutting Mode	Breaker	Grade	Cutting Speed (m/min)
Mild Steel	≤180HB	Finish Cutting	FY	NX3035	260-370
		Light Cutting	BY	NX3035	235-335
		Medium Cutting	MS	UE8110	200-440
Carbon Steel Alloy Steel	180HB-350HB	Finish Cutting	FH	NX3035	200-280
		Light Cutting	SH	UE8110	210-355
		Medium Cutting	MP	UE8110	190-355
Stainless Steel	5,200HB	Finish Cutting	FH	UB735	105-200
		Light Cutting	SH	UB735	95-185
		Medium Cutting	MS	UB735	85-165
Cast Iron	Tensile Strength ≤350MPa	Light Cutting	MA	UC9115	160-295
		Medium Cutting	Standard	UC9115	160-295
		Semi-Heavy Cutting	Flat Top	UC9115	155-280

RECOMMENDED CUTTING CONDITIONS

Work Material	Hardness	Cutting Mode	Breaker	Grade	Cutting Speed (m/min)
Mild Steel	≤180HB	Finish Cutting	FY	NX3035	260-370
		Light Cutting	BY	NX3035	235-335
		Medium Cutting	MS	UE8110	200-440
Carbon Steel Alloy Steel	180HB-350HB	Finish Cutting	FH	NX3035	200-280
		Light Cutting	SH	UE8110	210-355
		Medium Cutting	MP	UE8110	190-355
Stainless Steel	5,200HB	Finish Cutting	FH	UB735	105-200
		Light Cutting	SH	UB735	95-185
		Medium Cutting	MS	UB735	85-165
Cast Iron	Tensile Strength ≤350MPa	Light Cutting	MA	UC9115	160-295
		Medium Cutting	Standard	UC9115	160-295
		Semi-Heavy Cutting	Flat Top	UC9115	155-280

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 for details of inserts that are applicable to the product.

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

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

●To Order: Please specify order number and hand of the 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 $\odot\odot$ INSERTS TOOL HOLDERS	H006
DN $\odot\odot$ INSERTS TOOL HOLDERS	H011
EXTERNAL TURNING • FACING • BORING	
CN $\odot\odot$ INSERTS TOOL HOLDERS	H008
EXTERNAL TURNING • COPYING	
DN $\odot\odot$ INSERTS TOOL HOLDERS	H009
EXTERNAL TURNING • FACING • COPYING	
RC $\odot\odot$ INSERTS TOOL HOLDERS	H012
FACING • COPYING	
VB $\odot\odot$ INSERTS TOOL HOLDERS	H013
CUTTING OFF • GROOVING • COPYING	
DG INSERTS TOOL HOLDERS	H014
RECESSING • COPYING	
DG INSERTS TOOL HOLDERS	H015
FACE GROOVING	
DG INSERTS TOOL HOLDERS	H016, H018
FACE GROOVING • COPYING	
DG INSERTS TOOL HOLDERS	H017, H019
GROOVING	
MG INSERTS TOOL HOLDERS	H022
THREADING	
MMT INSERTS TOOL HOLDERS	H024
MT INSERTS TOOL HOLDERS	H025
EXTERNAL TURNING TOOL HOLDERS	
BORING BAR HOLDERS	H029
BORING BAR SLEEVES	H030

*Alphabetical order index

H030	H100TH-B $\odot\odot\odot\odot$	H017	H63TH-M $\odot\odot\odot\odot$ R/L (DG Pack)
H028	H100TH-EN3232R/L-130	H022	H63TH-MGHR/L-DX43 $\odot\odot$
H027	H100TH-EV3232R/L-180	H024	H63TH-MMTENR-H/L16
H008	H63TH-A $\odot\odot\odot$ DCLNR/L12	H024	H63TH-MMTER-DX16
H029	H63TH-B $\odot\odot\odot\odot$	H025	H63TH-MTHR/L-DX43
H014	H63TH-C $\odot\odot\odot\odot$ R/L (DG Pack)	H018	H63TH-N $\odot\odot\odot\odot$ R/L (DG Pack)
H014	H63TH-D $\odot\odot\odot\odot$ R/L (DG Pack)	H017	H63TH-P $\odot\odot\odot\odot$ R/L (DG Pack)
H008	H63TH-DCLNL-L12-3	H006	H63TH-PCLNR/L-DX12
H006	H63TH-DCLNR/L-DX12	H007	H63TH-PCMNN-H/L12
H007	H63TH-DCMNN-H/L12	H009	H63TH-PDJNR/L-DX15
H011	H63TH-DDJNL-L15-3	H010	H63TH-PDNNN-H/L15
H009	H63TH-DDJNR/L-DX15	H012	H63TH-PRDCN-H/L12
H010	H63TH-DDNNN-H/L15	H012	H63TH-PRGCR/L-DX12
H028	H63TH-EN2525R/L-115	H019	H63TH-Q $\odot\odot\odot\odot$ R/L (DG Pack)
H029	H63TH-EV2020R/L-105-3	H013	H63TH-SVPBR/L-DX16
H027	H63TH-EV2525R/L-112	H013	H63TH-SVBN-H/L16
H015	H63TH-G $\odot\odot\odot\odot$ NH/L (DG Pack)	H030	SL32 $\odot\odot$ -90
H016	H63TH-M $\odot\odot\odot\odot$ R/L (DG Pack)		

Tooling system
for turning on
multi-task machines

HSK-T TOOLS

HSK-T System (ICTM standard)

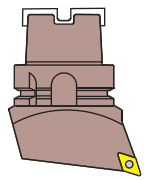
HSK-T is a new HSK system designed for turning on multi-task machines that are compatible with HSK-A type (ISO standard: ISO12164-1:2001). It was jointly developed by a consortium of Japanese manufacturers and is now used worldwide as the ICTM standard. The HSK-T type was registered in the ISO standard in 2008. (ISO12164-3:2008)



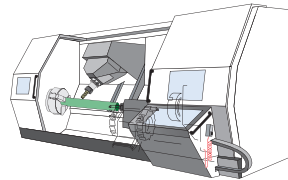
High accuracy cutting edge positioning

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 accuracy. For milling, the conventional HSK-A type tools can be still used.

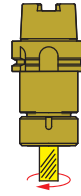
Compatible with both multi-task machines and machining centres



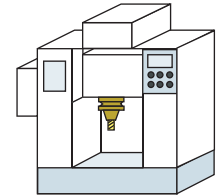
HSK-T (ISO standard)
Turning tool holder



HSK-T spindle
Multi-task machines



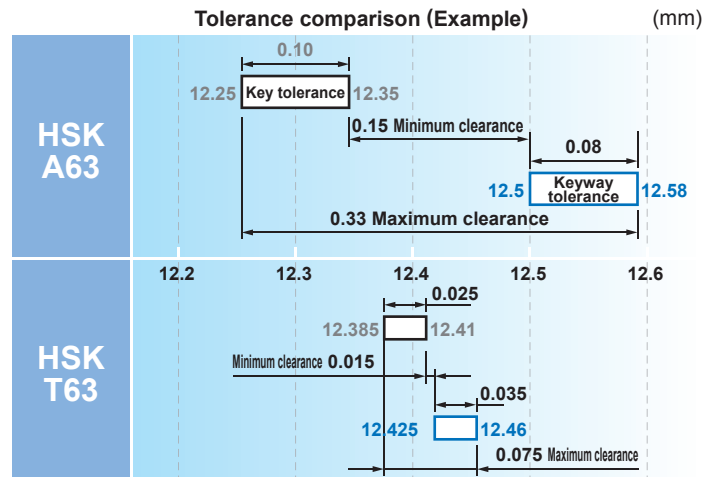
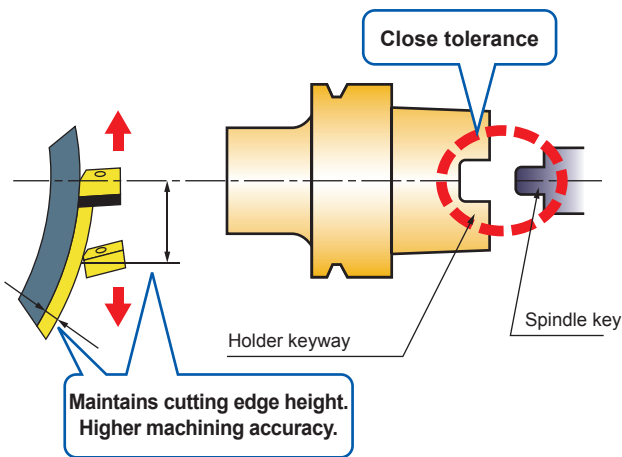
HSK-A63 (ISO standard)
Rotating tool holder



HSK-A spindle
Machining centre

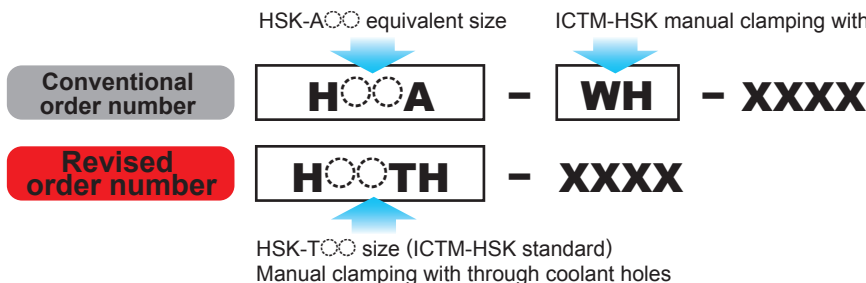
OVERVIEW OF HSK-T TOOLS

Improved keyway tolerance



From ICTM-HSK to HSK-T

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

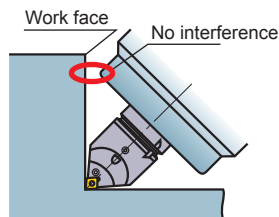


High accuracy and rigidity HSK-T type tooling system developed for use on multi-task machines.

Straight type tools suitable for use on multi-task machines

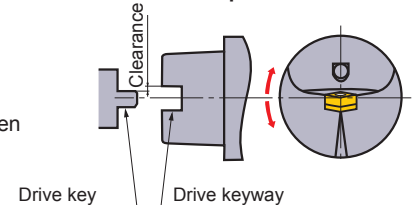
Avoid workpiece interference with improved tool accessibility.

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



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

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



New one-action type double clamp series

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



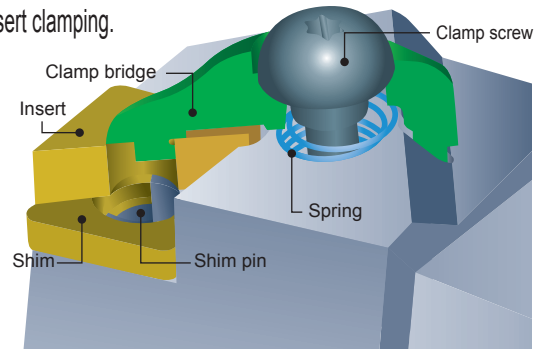
Handed type for turning and facing



Straight type for turning and facing



For turning, facing and boring



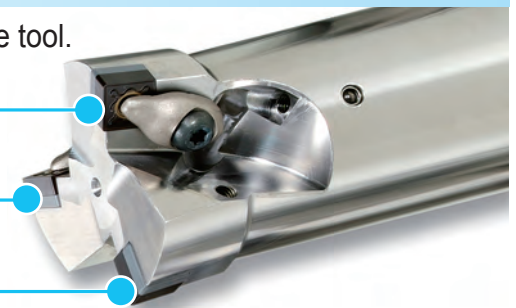
3 on 1 tool for process and tool consolidation

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)

Different grade inserts 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

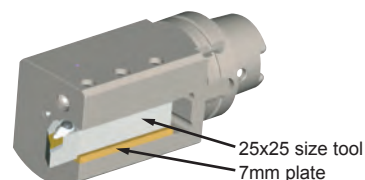


Sleeve




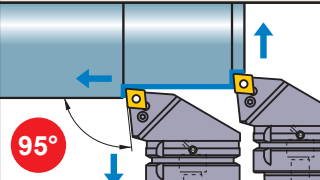

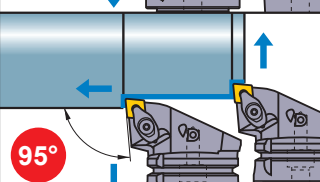

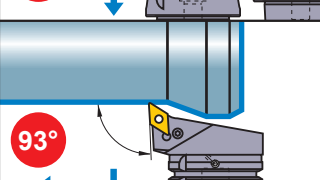

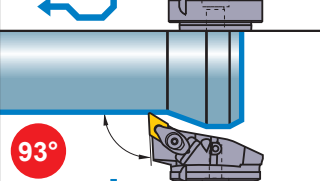

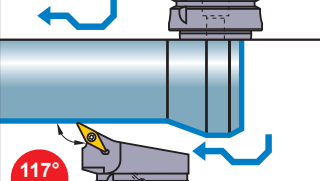

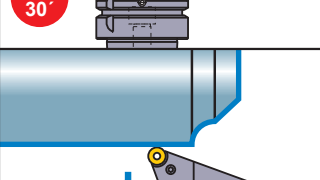

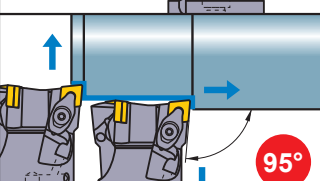

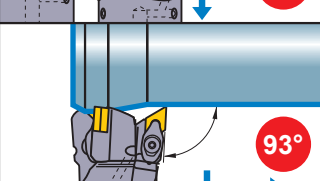
A single tool can be used with different sized tool holders.


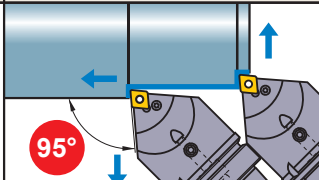

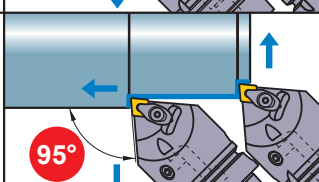

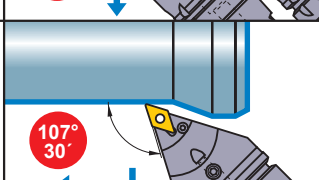

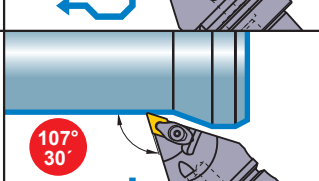

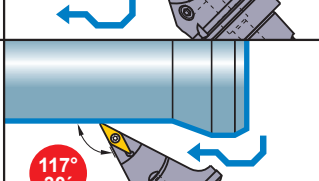

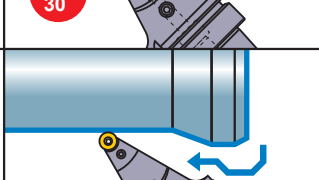
- Available for use with JIS B4126 (ISO 5610) 32x32 and 32x25 tools.
- Possible to fit a 25x25 tool by using a 7mm plate.
- *Plate not supplied.




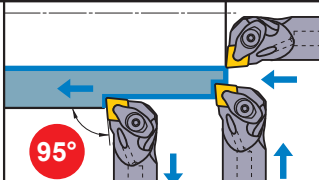
CLASSIFICATION OF HSK-T TOOLS

EXTERNAL TURNING • FACING • COPYING


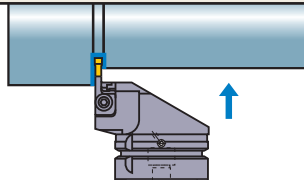

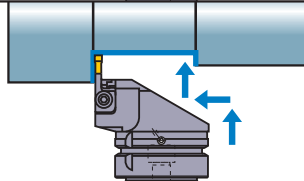

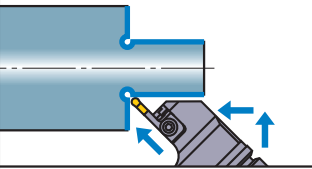

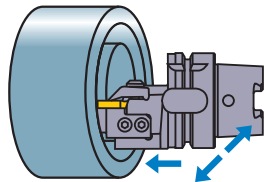

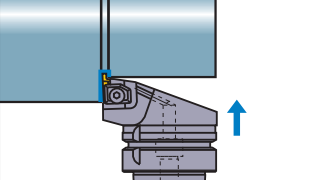
Order Number	Geometry
H63TH-PCLNR/L-DX12  H006	
H63TH-DCLNR/L-DX12  H006	
H63TH-PDJNR/L-DX15  H009	
H63TH-DDJNR/L-DX15  H009	
H63TH-SVPBR/L-DX16  H013	
H63TH-PRGCR/L-DX12  H012	
H63TH-DCLNL-L12-3  H008	
H63TH-DDJNL-L15-3  H011	

Order Number	Geometry
H63TH-PCMNN-H/L12  H007	
H63TH-DCMNN-H/L12  H007	
H63TH-PDNNN-H/L15  H010	
H63TH-DDNNN-H/L15  H010	
H63TH-SVVBH-H/L16  H013	
H63TH-PRDCN-H/L12  H012	






EXTERNAL TURNING • FACING • BORING

Order Number	Geometry
H63TH-A25KDCLNR/L12 H63TH-A32LDCLNR/L12  H008	


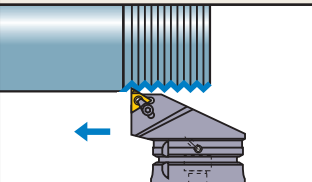

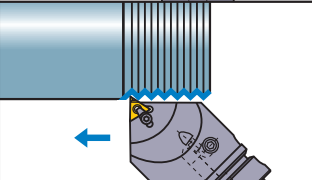

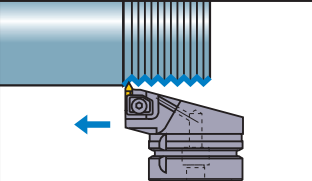
GROOVING

Order Number	Geometry
H63TH-C○○○○R/L  ↪ H014	
H63TH-C/D○○○○R/L  ↪ H014	
H63TH-G○○○○NH/L  ↪ H015	
H63TH-M/N/P/Q○○○○R/L  ↪ H016–H019	
H63TH-MGHR/L-DX43○○  ↪ H022	

EXTERNAL TURNING TOOL HOLDERS

Order Number	Holder
H63TH-EV2525R/L-112 ↪ H027	
H100TH-EV3232R/L-180 ↪ H027	
H63TH-EN2525R/L-115 *1 ↪ H028	
H100TH-EN3232R/L-130 *1 ↪ H028	
H63TH-EV2020R/L-105-3 ↪ H029	

THREADING

Order Number	Geometry
H63TH-MMTER-DX16  ↪ H024	
H63TH-MMTENR-H/L16  ↪ H024	
H63TH-MTHR/L-DX43  ↪ H025	

BORING BAR HOLDERS

Order Number	Holder
H63TH-B○○○○ ↪ H029	
H100TH-B○○○○ ↪ H030	
SL32○○-90 (Sleeve) *2 ↪ H030	

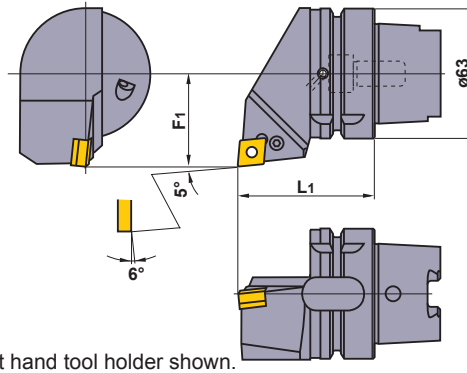
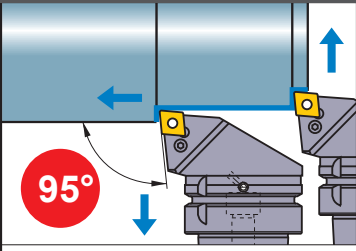
*1 Mitsubishi Materials is licensed for production and distribution of these tools from MORI SEIKI CO., LTD under Patent No.3720202.

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









HSK-T SYSTEM







PCLN

External turning • Facing



Right hand tool holder shown.

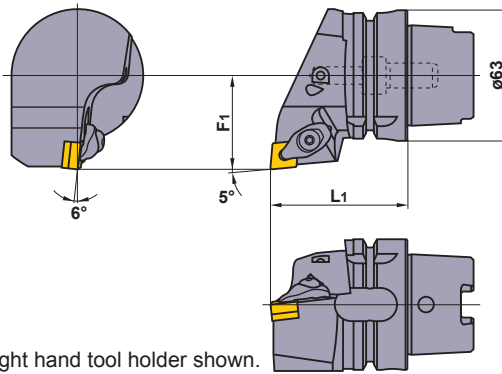
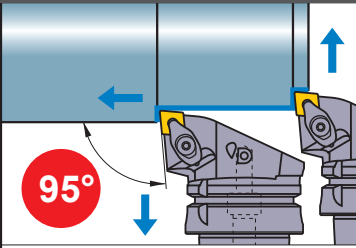
Finish	Light	Medium
FH  (12)	SH  (12)	MP  (12)
Medium MH  (12)	Medium Standard  (12)	Medium - Semi-Heavy GH  (12)
Stainless MS  (12)	CBN  (12)	

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









* Clamp Torque (N • m) : LLCS108=3.3








DCLN

External turning • Facing **DOUBLE CLAMP type**



Right hand tool holder shown.

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

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

* Clamp Torque (N • m) : DC0621T=5.0

RECOMMENDED CUTTING CONDITIONS

	Work Material	Hardness	Cutting Mode	Breaker	Grade	Cutting Speed (m/min)
P	Mild Steel	≤180HB	Finish Cutting	FY	NX3035	260-370
			Light Cutting	SY	NX3035	235-335
			Medium Cutting	MS	UE6110	260-440
	Carbon Steel Alloy Steel	180HB-350HB	Finish Cutting	FH	NX3035	200-280
			Light Cutting	SH	UE6110	210-355
			Medium Cutting	MP	UE6110	190-325
M	Stainless Steel	≤200HB	Finish Cutting	FH	US735	105-200
			Light Cutting	SH	US735	95-185
			Medium Cutting	MS	US735	85-165
K	Cast Iron	Tensile Strength ≤350MPa	Light Cutting	MA	UC5115	160-295
			Medium Cutting	Standard	UC5115	160-295
			Semi-Heavy Cutting	Flat Top	UC5115	155-280

● : Inventory maintained.

CBN & PCD inserts **B018, B019, B042**

PCLN type inserts **A058-A067**

DCLN type inserts **A058-A067**

PCMN		External turning • Facing				Finish	Light	Medium				
						FH (12)	SH (12)	MP (12)				
						Medium MH (12)	Medium Standard (12)	Medium Medium – Semi-Heavy GH (12)				
						Stainless MS (12)	CBN (12)					
						Order Number	Stock	Insert Number	Dimensions (mm) L1	Mass (kg)	Shim	Shim Pin
H63TH-PCMNN-H12	●	CNM CNG NP-CNA	1204	100	1.7	LLSCN42	LLP14	LLCL14	LLCS108	HGM-PT1/8	HSK-CP18S	HKY30R
-L12	●			140	2.7	LLSCN42	LLP14	LLCL14	LLCS108	HGM-PT1/8	HSK-CP18S	HKY30R

* Clamp Torque (N • m) : LLCS108=3.3

DCMN		External turning • Facing				DOUBLE CLAMP type			Finish	Light	Medium	
									FH (12)	SH (12)	MP (12)	
									Medium MH (12)	Medium Standard (12)	Medium Medium – Semi-Heavy GH (12)	
									Stainless MS (12)	CBN (12)		
									Order Number	Stock	Insert Number	Dimensions (mm) L1
H63TH-DCMNN-H12	●	CNM CNG NP-CNA	1204	100	1.7	LLSCN42	LLP14	DCK2613	DCS1	DC0621T	HSK-CP18S	TKY20F
-L12	●			140	2.7	LLSCN42	LLP14	DCK2613	DCS1	DC0621T	HSK-CP18S	TKY20F

* Clamp Torque (N • m) : DC0621T=5.0

RECOMMENDED CUTTING CONDITIONS

Work Material	Hardness	Cutting Mode	Breaker	Grade	Cutting Speed (m/min)	
P Mild Steel	≤180HB	Finish Cutting	FY	NX3035	260–370	
		Light Cutting	SY	NX3035	235–335	
		Medium Cutting	MS	UE6110	260–440	
	180HB–350HB	Carbon Steel Alloy Steel	Finish Cutting	FH	NX3035	200–280
		Light Cutting	SH	UE6110	210–355	
		Medium Cutting	MP	UE6110	190–325	
M Stainless Steel	≤200HB	Finish Cutting	FH	US735	105–200	
		Light Cutting	SH	US735	95–185	
		Medium Cutting	MS	US735	85–165	
K Cast Iron	Tensile Strength ≤350MPa	Light Cutting	MA	UC5115	160–295	
		Medium Cutting	Standard	UC5115	160–295	
		Semi-Heavy Cutting	Flat Top	UC5115	155–280	

CBN & PCD inserts
B018, B019, B042

PCMN type inserts
A058–A067

DCMN type inserts
A058–A067

SPARE PARTS
N001

TECHNICAL DATA
P001

HSK-T TOOLS

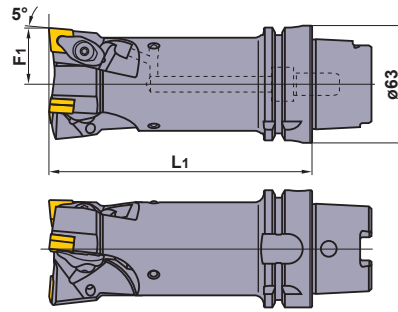
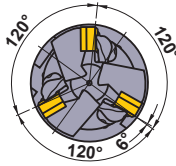
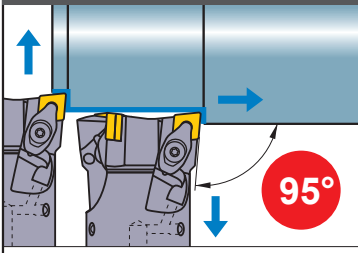
HSK-T SYSTEM

H007









HSK-T SYSTEM

DCLN

External turning • Facing **DOUBLE CLAMP type**



Left hand tool holder only.

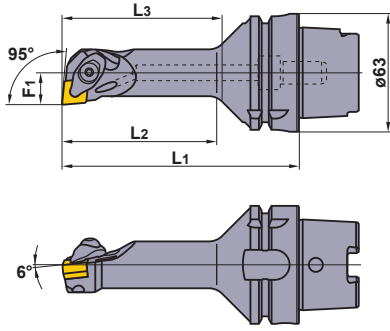
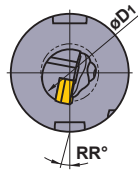
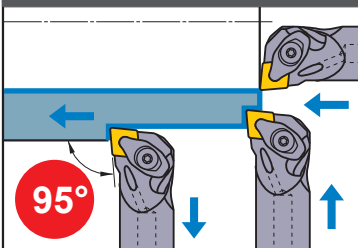
Finish	Light	Medium
FH  (12)	SH  (12)	MP  (12)
Medium MH  (12)	Medium Standard GH  (12)	Medium - Semi-Heavy GH  (12)
Stainless MS  (12)	CBN  (12)	

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









* Clamp Torque (N • m) : DC0621T=5.0

DCLN

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



Right hand tool holder shown.

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

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

* Clamp Torque (N • m) : DC0621T=5.0

RECOMMENDED CUTTING CONDITIONS

	Work Material	Hardness	Cutting Mode	Breaker	Grade	Cutting Speed (m/min)
P	Mild Steel	≤180HB	Finish Cutting	FY	NX3035	260—370
			Light Cutting	SY	NX3035	235—335
			Medium Cutting	MS	UE6110	260—440
	Carbon Steel Alloy Steel	180HB—350HB	Finish Cutting	FH	NX3035	200—280
			Light Cutting	SH	UE6110	210—355
			Medium Cutting	MP	UE6110	190—325
M	Stainless Steel	≤200HB	Finish Cutting	FH	US735	105—200
			Light Cutting	SH	US735	95—185
			Medium Cutting	MS	US735	85—165
K	Cast Iron	Tensile Strength ≤350MPa	Light Cutting	MA	UC5115	160—295
			Medium Cutting	Standard	UC5115	160—295
			Semi-Heavy Cutting	Flat Top	UC5115	155—280

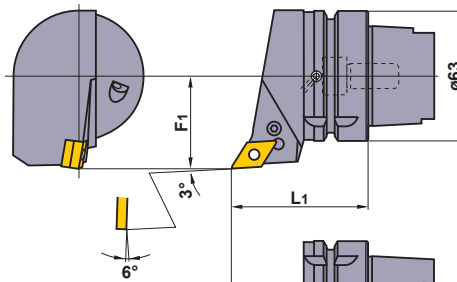
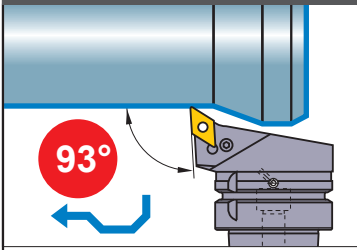
● : Inventory maintained.

CBN & PCD inserts
B018, B019, B042

DCLN type inserts
A058—A067

PDJN

External turning • Copying



Right hand tool holder shown.

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

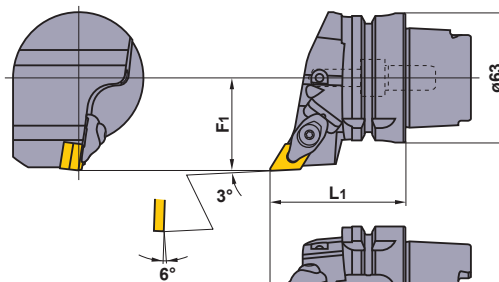
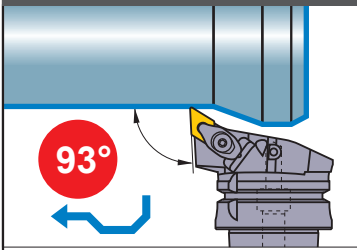
Order Number	Stock		Insert Number	Dimensions (mm)		Mass (kg)	*2					
	R	L		L1	F1		Shim	Shim Pin	Clamp Lever	Clamp Screw	Coolant Pipe	Wrench
H63TH-PDJNR/L-DX15	●	●	DNM DNG NP-DN	1504	65 45	1.2	LLSDN43 (LLSDN42)	LLP14	LLCL24	LLCS108	HSK-CP18S	HKY30R

*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 orderd separately.

DDJN

External turning • Copying **DOUBLE CLAMP type**



Right hand tool holder shown.

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

Order Number	Stock		Insert Number	Dimensions (mm)		Mass (kg)	*2						
	R	L		L1	F1		Shim	Shim Pin	Clamp Bridge	Spring	Clamp Screw	Coolant Pipe	Wrench
H63TH-DDJNR/L-DX15	●	●	DNM DNG NP-DN	1504	65 45	1.2	LLSDN43 (LLSDN42)	LLP24	DCK2613	DCS1	DC0621T	HSK-CP18S	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 orderd separately.

RECOMMENDED CUTTING CONDITIONS

Work Material	Hardness	Cutting Mode	Breaker	Grade	Cutting Speed (m/min)	
P Mild Steel	≤180HB	Finish Cutting	FY	NX3035	260-370	
		Light Cutting	SY	NX3035	235-335	
		Medium Cutting	MS	UE6110	260-440	
	Carbon Steel Alloy Steel	180HB-350HB	Finish Cutting	FH	NX3035	200-280
			Light Cutting	SH	UE6110	210-355
			Medium Cutting	MP	UE6110	190-325
M Stainless Steel	≤200HB	Finish Cutting	FH	US735	105-200	
		Light Cutting	SH	US735	95-185	
		Medium Cutting	MS	US735	85-165	
K Cast Iron	Tensile Strength ≤350MPa	Light Cutting	MA	UC5115	160-295	
		Medium Cutting	Standard	UC5115	160-295	
		Semi-Heavy Cutting	Flat Top	UC5115	155-280	

CBN & PCD inserts
B020, B021, B042

PDJN type inserts
A068-A072

DDJN type inserts
A068-A072

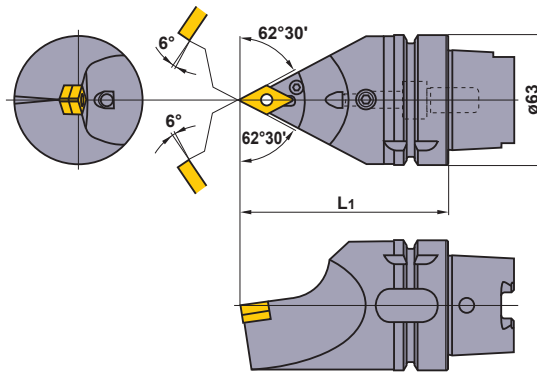
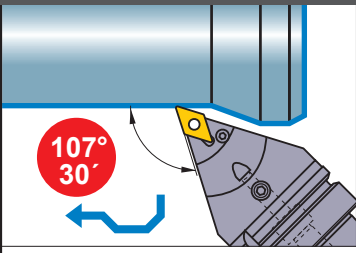
SPARE PARTS
N001









TECHNICAL DATA
P001

HSK-T SYSTEM

PDNN

External turning • Copying



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

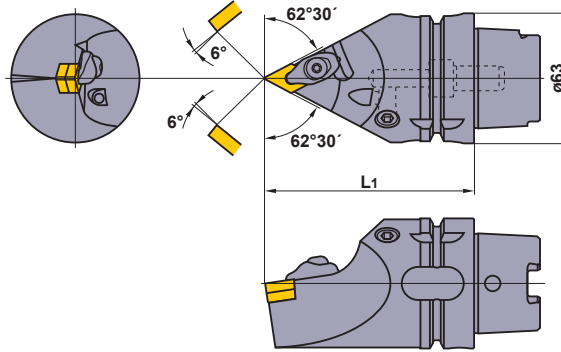
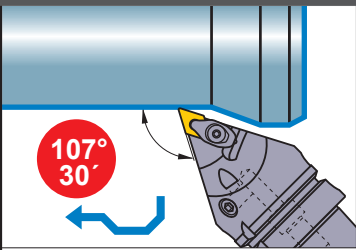
Order Number	Stock	Insert Number	Dimensions (mm)	Mass	*2							
					L1	(kg)	Shim	Shim Pin	Clamp Lever	Clamp Screw	Plug	Coolant Pipe
H63TH-PDNNN-H15 -L15	●	DNM DNG NP-DN	1504	100	1.6	LLSDN43 (LLSDN42)	LLP14	LLCL24	LLCS108	HGM-PT1/8	HSK-CP18S	HKY30R
	●			140	2.5	LLSDN43 (LLSDN42)	LLP14	LLCL24	LLCS108	HGM-PT1/8	HSK-CP18S	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.

DDNN

External turning • Copying **DOUBLE CLAMP type**



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

Order Number	Stock	Insert Number	Dimensions (mm)	Mass	*2							
					L1	(kg)	Shim	Shim Pin	Clamp Bridge	Spring	Clamp Screw	Coolant Pipe
H63TH-DDNNN-H15 -L15	●	DNM DNG NP-DN	1504	100	1.6	LLSDN43 (LLSDN42)	LLP24	DCK2613	DCS1	DC0621T	HSK-CP18S	TKY20F
	●			140	2.5	LLSDN43 (LLSDN42)	LLP24	DCK2613	DCS1	DC0621T	HSK-CP18S	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.

RECOMMENDED CUTTING CONDITIONS

	Work Material	Hardness	Cutting Mode	Breaker	Grade	Cutting Speed (m/min)
P	Mild Steel	≤180HB	Finish Cutting	FY	NX3035	260—370
			Light Cutting	SY	NX3035	235—335
			Medium Cutting	MS	UE6110	260—440
	Carbon Steel Alloy Steel	180HB—350HB	Finish Cutting	FH	NX3035	200—280
			Light Cutting	SH	UE6110	210—355
			Medium Cutting	MP	UE6110	190—325
M	Stainless Steel	≤200HB	Finish Cutting	FH	US735	105—200
			Light Cutting	SH	US735	95—185
			Medium Cutting	MS	US735	85—165
K	Cast Iron	Tensile Strength ≤350MPa	Light Cutting	MA	UC5115	160—295
			Medium Cutting	Standard	UC5115	160—295
			Semi-Heavy Cutting	Flat Top	UC5115	155—280

● : Inventory maintained.

CBN & PCD inserts
B020, B021, B042




PDNN type inserts
A068—A072

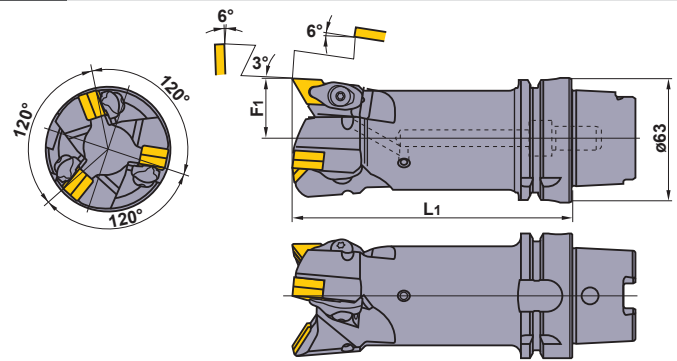
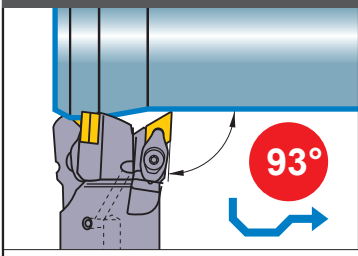
DDNN type inserts
A068—A072

DDJN

External turning • Facing

DOUBLE CLAMP type

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



Left hand tool holder only.

Order Number	Stock	Insert Number	Dimensions (mm)		Mass (kg)	*2						
	L		L1	F1		Shim	Shim Pin	Clamp Bridge	Spring	Clamp Screw	Coolant Pipe	Wrench
H63TH-DDJNL-L15-3	●	DNM DNG NP-DN/A	1504	140 30	2.2	LLSDN43 (LLSDN42)	LLP24	DCK2613	DCS1	DC0621T	HSK-CP18S	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.

RECOMMENDED CUTTING CONDITIONS

Work Material	Hardness	Cutting Mode	Breaker	Grade	Cutting Speed (m/min)	
P Mild Steel	≤180HB	Finish Cutting	FY	NX3035	260–370	
		Light Cutting	SY	NX3035	235–335	
		Medium Cutting	MS	UE6110	260–440	
	Carbon Steel Alloy Steel	180HB–350HB	Finish Cutting	FH	NX3035	200–280
			Light Cutting	SH	UE6110	210–355
			Medium Cutting	MP	UE6110	190–325
M Stainless Steel	≤200HB	Finish Cutting	FH	US735	105–200	
		Light Cutting	SH	US735	95–185	
		Medium Cutting	MS	US735	85–165	
K Cast Iron	Tensile Strength ≤350MPa	Light Cutting	MA	UC5115	160–295	
		Medium Cutting	Standard	UC5115	160–295	
		Semi-Heavy Cutting	Flat Top	UC5115	155–280	

CBN & PCD inserts
B020, B021, B042

DDJN type inserts
A068–A072

SPARE PARTS
N001

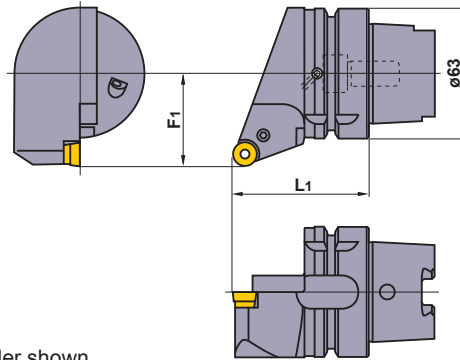
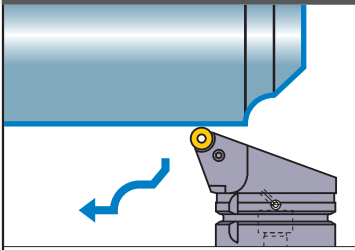
TECHNICAL DATA
P001

HSK-T SYSTEM

PRGC

External turning • Facing • Copying

Medium



Right hand tool holder shown.

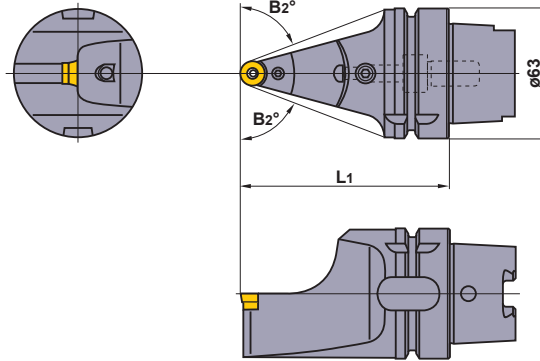
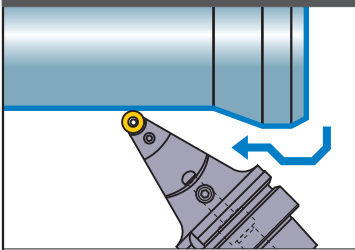
Order Number	Stock		Insert Number	Dimensions (mm)		Mass (kg)	Shim	Shim Pin	Clamp Lever	Clamp Screw *	Coolant Pipe	Wrench
	R	L		L1	F1							
H63TH-PRGCR/L-DX12	●	●	RCMX 1204M0	65	45	1.2	LLSRN123	LLP13	LLCL112	LLCS106	HSK-CP18S	HKY25R

* Clamp Torque (N • m) : LLCS106=2.2

PRDC

External turning • Facing • Copying

Medium



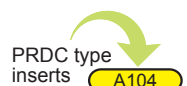
Order Number	Stock		Insert Number	Dimensions (mm)		Mass (kg)	Shim	Shim Pin	Clamp Lever	Clamp Screw *	Plug	Coolant Pipe	Wrench
	L1	B2°											
H63TH-PRDCN-H12	●	●	RCMX 1204M0	100	69	1.4	LLSRN123	LLP13	LLCL112	LLCS106	HGM-PT1/8	HSK-CP18S	HKY25R
-L12	●	●		140	75	2.3	LLSRN123	LLP13	LLCL112	LLCS106	HGM-PT1/8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

* Clamp Torque (N • m) : LLCS106=2.2

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.



SVPB

Facing • Copying

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

Finish

R/L-F

(16)

Light

SV

(16)

Medium

MV

(16)

Medium

Standard

(16)

CBN

(16)

Right hand tool holder shown.

* Clamp Torque (N • m) : TS35D=3.5

SVVB

Facing • Copying

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

Finish

R/L-F

(16)

Light

SV

(16)

Medium

MV

(16)

Medium

Standard

(16)

CBN

(16)

* Clamp Torque (N • m) : TS35D=3.5

RECOMMENDED CUTTING CONDITIONS

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

CBN inserts
B035

SVPB type inserts
A112

SVVB type inserts
A112

SPARE PARTS
N001

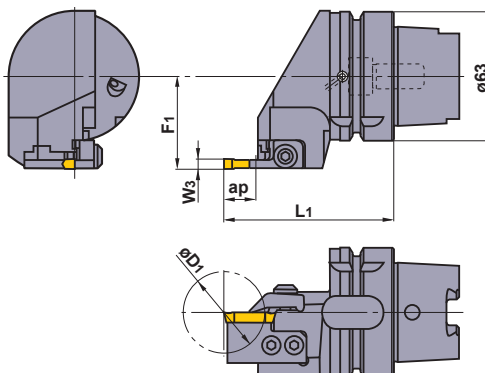
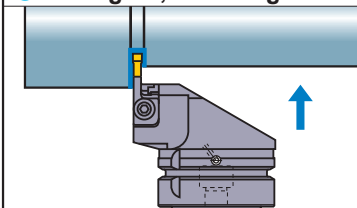
TECHNICAL DATA
P001

HSK-T SYSTEM

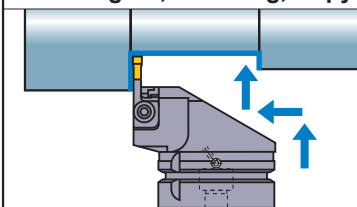
DG

Cutting off • Grooving • Copying

● Cutting off, Grooving



● Cutting off, Grooving, Copying



Right hand tool holder shown.

● Cutting off, Grooving

Pack Order Number *1	Stock		Component			Groove Width W3	Max. Groove Depth ap	Max. Cut Off Diameter D1	Dimensions (mm)		Mass (kg)	Insert Number	Insert Shape
	R	L	Holder Number	Locator	Clamp Bridge				L1	F1			
H63TH-C5207R/L	★	★	H63TH-DGHR/L	EB2R/L	DGK2R/L	2	16	40	82.4	45	1.3	DGM20CE	DGM...CE
-C5307R/L	★	★	H63TH-DGHR/L	EB3R/L	DGK3R/L	3	16	40	82.4	45	1.3	DGM30CE DGJ30CE	
-C5407R/L	★	★	H63TH-DGHR/L	EB4R/L	DGK4R/L	4	16	40	82.4	45	1.3	DGJ40CE	DGJ...CE
-C5507R/L	★	★	H63TH-DGHR/L	EB5R/L	DGK5R/L	5	16	40	82.4	45	1.3	DGJ50CE	DGJ...CE
-C5607R/L	★	★	H63TH-DGHR/L	EB6R/L	DGK6R/L	6	16	40	82.4	45	1.3	DGJ60CE	
-C5707R/L	★	★	H63TH-DGHR/L	EB7R/L	DGK7R/L	7	16	40	82.4	45	1.3	DGJ70CE	DGJ...CE
-C5807R/L	★	★	H63TH-DGHR/L	EB8R/L	DGK8R/L	8	16	40	82.4	45	1.3	DGJ80CE	DGJ...CE

● Cutting off, Grooving, Copying

Pack Order Number *1	Stock		Component			Groove Width W1	Max. Groove Depth ap	Max. Cut Off Diameter D1	Dimensions (mm)		Mass (kg)	Insert Number	Insert Shape
	R	L	Holder Number	Locator	Clamp Bridge				L1	F1			
H63TH-D5307R/L	★	★	H63TH-DGHR/LS	EB3R/LS	DGK3R/L	3	11	30	77.4	45	1.3	DGM30CT	DGM...CT
-D5407R/L	★	★	H63TH-DGHR/LS	EB4R/LS	DGK4R/L	4	11	30	77.4	45	1.3	DGM40CT	
-D5408R/L	★	★	H63TH-DGHR/LS	EB4R/LX	DGK4R/L	4	11	30	77.4	45	1.3	DGM40CTB	DGM...CTB
*2 -C5507R/L	★	★	H63TH-DGHR/L	EB5R/L	DGK5R/L	5	16	40	82.4	45	1.3	DGM50CT DGJ50CT1	DGJ...CT1
-C5508R/L	★	★	H63TH-DGHR/L	EB5R/LX	DGK5R/L	5	16	40	82.4	45	1.3	DGM50CTB DGM50CTD DGM50CTR/L	DGM...CTD DGM...CTR/L
-C5608R/L	★	★	H63TH-DGHR/L	EB6R/LX	DGK6R/L	6	16	40	82.4	45	1.3	DGM60CTB	

*1 The order pack number includes a holder, locators and clamp screws. (Refer to the list below.)

To order the parts separately, please refer to their description.

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

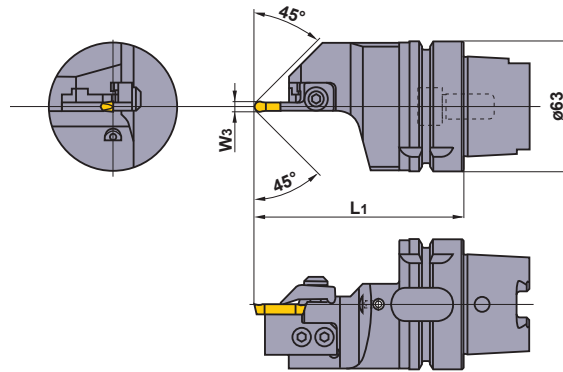
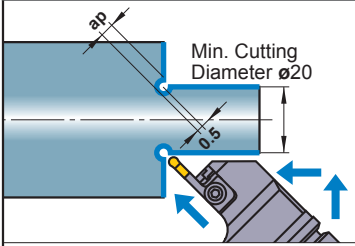
SPARE PARTS

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

* Clamp Torque (N • m) : DGS51=7.0

★ : Inventory maintained in Japan.

DG type inserts H020, H021



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

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

SPARE PARTS

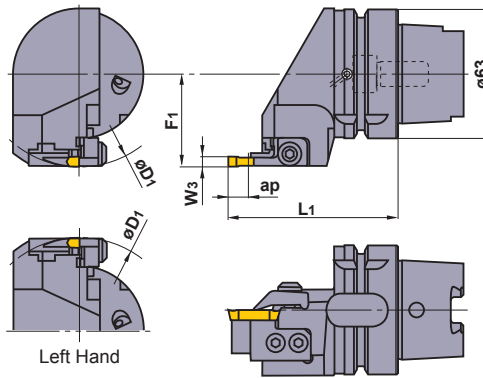
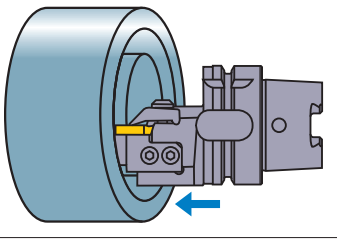
Holder Number		*				
	Locator Screw	Clamp Screw	Spring	Plug	Coolant Pipe	Wrench
H63TH-DGHN-H4	HSC05010	DGS51	MES2	—	HSK-CP18S	HKY40R
-DGHN-H5	HSC05012					
-DGHN-H6	HSC05010					
-DGHN-L4	HSC05010			HGM-PT1/8		
-DGHN-L5	HSC05012					
-DGHN-L6						

* Clamp Torque (N • m) : DGS51=7.0

HSK-T SYSTEM

DG

Face grooving



Right hand tool holder shown.

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

*1 The order pack number includes a holder, locators and clamp screws. (Refer to the list below.)

To order the parts separately, please refer to their description.

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

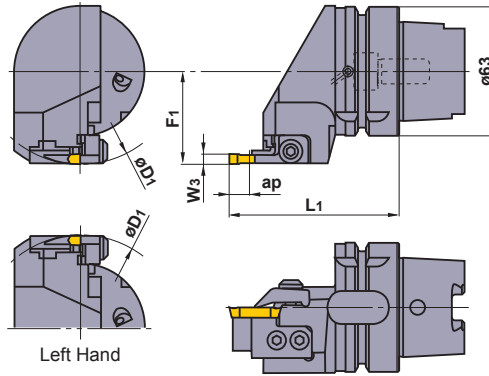
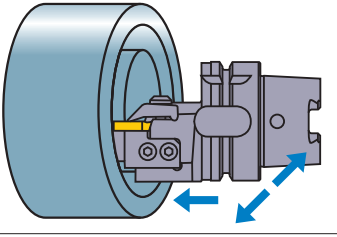
SPARE PARTS

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

* Clamp Torque (N · m) : DGS51=7.0

★ : Inventory maintained in Japan.

DG type inserts H020, H021

DG**Face grooving • Copying**

Left Hand

Right hand tool holder shown.

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

*1 The order pack number includes a holder, locators and clamp screws. (Refer to the list below.)

To order the parts separately, please refer to their description.

*2 Compatible with standard type holder for face grooving.

SPARE PARTS

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

* Clamp Torque (N • m) : DGS51=7.0

CUTTING
CONDITIONS

H021

SPARE PARTS



N001

TECHNICAL
DATA

P001

HSK-T
TOOLS

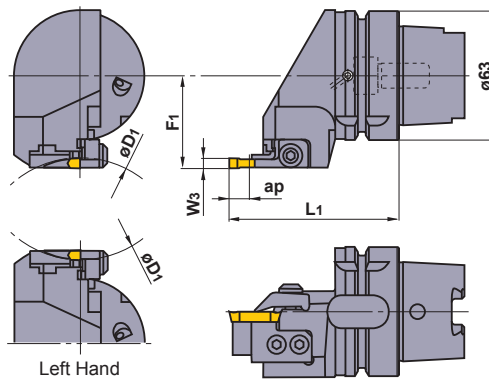
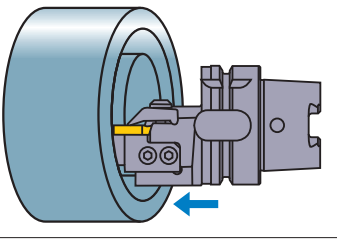
HSK-T SYSTEM

H017

HSK-T SYSTEM

DG

Facing • Grooving



Right hand tool holder shown.

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

*1 The order pack number includes a holder, locators and clamp screws. (Refer to the list below.)

To order the parts separately, please refer to their description.

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

SPARE PARTS

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

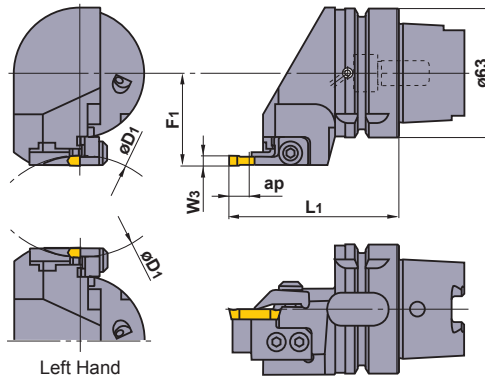
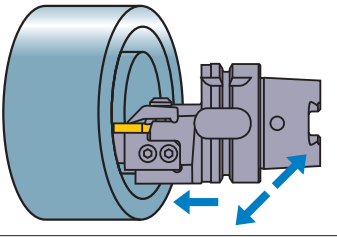
* Clamp Torque (N • m) : DGS51=7.0

★ : Inventory maintained in Japan.

DG type inserts H020, H021

DG

Face grooving • Copying



Right hand tool holder shown.

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

*1 The order pack number includes a holder, locators and clamp screws. (Refer to the list below.)

To order the parts separately, please refer to their description.

*2 Compatible with standard type holder for face grooving.

SPARE PARTS

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

* Clamp Torque (N • m) : DGS51=7.0

CUTTING CONDITIONS
H021

SPARE PARTS
N001

TECHNICAL DATA
P001

HSK-T TOOLS

HSK-T SYSTEM

HSK-T SYSTEM

INSERTS FOR DG TYPE

Application	Geometry	Order Number	Stock						Dimensions (mm)										
			Coated			Cermet		Carbide	CBN	W ₃		L ₁	S ₁	Re, R	B ₄	B ₆			
			UE6020	US735	VP20MF	UP20M	NX2525	UT120T	MB825	Groove Width	Tolerance								
Cutting Off, Grooving CE Type	DGM...CE (M class) 	DGM20CE	<input type="checkbox"/>	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>				2	±0.05	25	3	0.2	7°	2°30'		
		30CE	<input type="checkbox"/>	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>				3	±0.05	25	5	0.2	7°	2°30'	
	DGJ...CE (G class) 	DGJ30CE			<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>				3	±0.05	25	5	0.2	2°	2°	
		40CE			<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>				4	±0.05	25	6	0.2	2°	2°	
		50CE			<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>				5	±0.05	25	6	0.2	2°	2°	
		60CE			<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>				6	±0.05	25	6	0.2	2°	2°	
		70CE			<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>				7	±0.05	25	8	0.2	2°	2°	
		80CE			<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>				8	±0.05	25	8	0.2	2°	2°	
	DGJ...CE (G class) 	DGJ40CE								★		4	±0.05	25	6	0.2	2°	2°	
		50CE								★		5	±0.05	25	6	0.2	2°	2°	
		60CE								★		6	±0.05	25	6	0.2	2°	2°	
	External Grooving	DGM...CT (M class) 	DGM30CT	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>			3	±0.05	20	5	0.4	3°	1°30'	
			40CT	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>			4	±0.05	20	5	0.4	5°	2°
			50CT	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>			5	±0.05	25	6	0.4	5°	2°
		DGJ...CT1 (G class) 	DGJ50CT1			<input checked="" type="checkbox"/>	★				★		5	±0.05	25	6	0.2	2°	2°
DGM...CTB (M class) 		DGM40CTB	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>								4	±0.05	20	5	2	5°	7°	
		50CTB	★	<input checked="" type="checkbox"/>								5	±0.05	25	6	2.5	6°	10°	
		60CTB	★	<input checked="" type="checkbox"/>								6	±0.05	25	6	3	9°	10°	
DGM...CTD (M class) 		DGM50CTD04	★	★								5	±0.05	25	6	0.4	6°	—	
		50CTD08	★	★								5	±0.05	25	6	0.8	6°	—	
DGM...CTR/L... (M class) 		DGM50CTR04	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>								5	±0.05	25	6	0.4	5°	3°	
	50CTL04	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>								5	±0.05	25	6	0.4	5°	3°		

● : Inventory maintained. ★ : Inventory maintained in Japan.
 : Non stock, produced to order only.

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

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

RECOMMENDED CUTTING CONDITIONS ● For Cutting off • Grooving

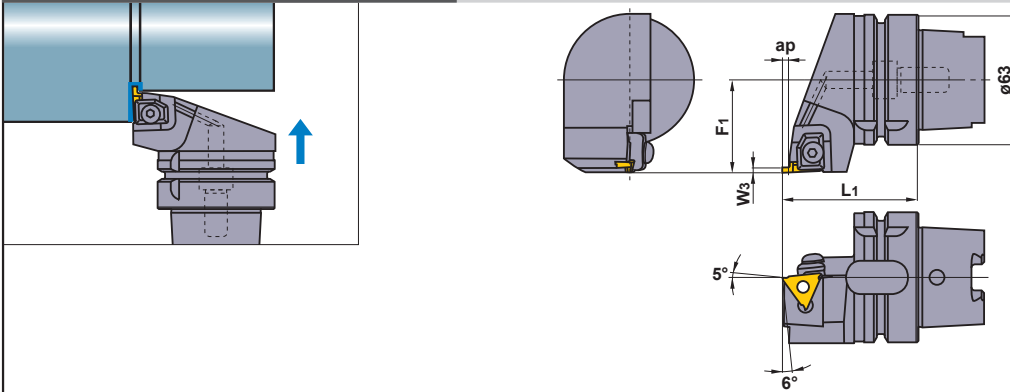
Work Material	Hardness	Grade		Cutting Speed (m/min)	Max. Feed (mm/rev)			
		Continuous	Interrupted		Groove Width (mm)			
					2	3, 4	5, 6	7, 8
P General Steel	≤150HB	NX2525	VP20MF	160 (120-200)	0.1	0.2	0.25	0.3
	150-250HB	UE6020	VP20MF	120 (100-150)	0.1	0.15	0.2	0.25
	≥250HB	UE6020	VP20MF	120 (100-150)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

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

HSK-T SYSTEM

MG

Grooving



Right hand tool holder shown.

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

* Clamp Torque (N • m) : HBH06020=7.0



HSK-T SYSTEM

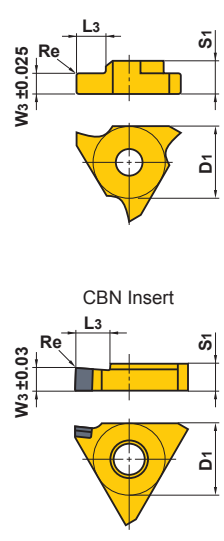
RECOMMENDED CUTTING CONDITIONS

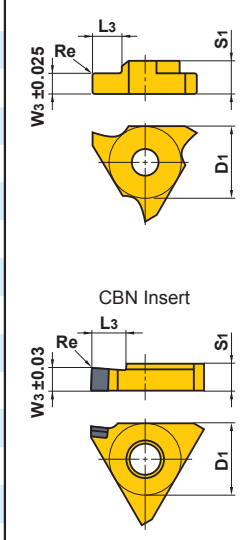
	Work Material	Hardness	Grade	Cutting Speed (m/min)	Feed (mm/rev)
P	Carbon Steel Alloy Steel	180–350HB	VP20MF	120 (100–140)	0.10 (0.03–0.18)
			NX2525	130 (100–160)	0.12 (0.03–0.2)
M	Stainless Steel	≤200HB	VP20MF	120 (100–140)	0.10 (0.03–0.18)
K	Cast Iron	Tensile Strength ≤350MPa	VP20MF	120 (100–140)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

● : Inventory maintained. ★ : Inventory maintained in Japan.

□ : Non stock, produced to order only. ▲ : Inventory maintained. To be replaced by new products.

INSERTS

Order Number	Stock										Groove Width W ₃	Dimensions (mm)				Geometry
	Coated		Cermet				Carbide		CBN			L ₃	D ₁	S ₁	Re	
	VP20MF		NX2525		NX55		UT120T		MB8025							
	R	L	R	L	R	L	R	L	R	L						
MGTR/L43125	★	★	★	□	▲		●	●	★		1.25	1.2	12.7	4.76	0.2	MGTR/L... 
43145	★	□	□	□			●	□			1.45	1.5	12.7	4.76	0.2	
43150	★	★	★	●	▲	▲	●	●	★		1.5	3	12.7	4.76	0.2	
43175	★	★	★	□	▲		●	●			1.75	3	12.7	4.76	0.2	
43200	★	★	★	●	▲	▲	●	●	★		2	3	12.7	4.76	0.2	
43230	★	★	●	★	▲	▲	●	●			2.3	3	12.7	4.76	0.2	
43250	★	★	★	★	▲	▲	●	●	★		2.5	4.5	12.7	4.76	0.3	
43260	★	□	□				●	●			2.6	4.5	12.7	4.76	0.3	
43270	★	□			▲		●	□			2.7	4.5	12.7	4.76	0.3	
43280	★	★	★	□	▲	▲	●	●			2.8	4.5	12.7	4.76	0.3	
43300	★	★	★	★	▲	▲	●	●	★		3	4.5	12.7	4.76	0.3	
43320	★	★	□		▲	▲	●	●			3.2	4.5	12.7	4.76	0.3	
43330	★	★	★	□		▲	●	●			3.3	4.5	12.7	4.76	0.3	
43350	★	□	★	□	▲	▲	●	●	★		3.5	4.5	12.7	4.76	0.3	
43400	★	★	★		▲		●	●	★		4	4.5	12.7	4.76	0.3	
43420	★	□	□				★	●			4.2	4.5	12.7	4.76	0.4	
43430	★	□	□		▲	▲	●	★			4.3	4.5	12.7	4.76	0.4	
43450	★	★	●	★	▲	▲	●	●			4.5	4.5	12.7	4.76	0.4	
43470	★	□	□	□			●	□			4.7	4.5	12.7	4.76	0.4	

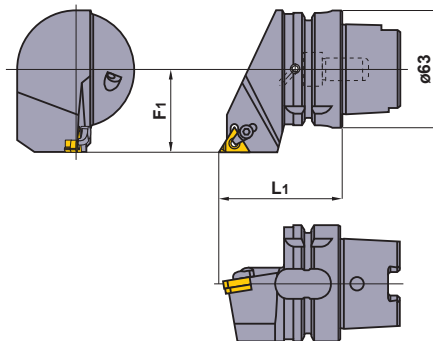
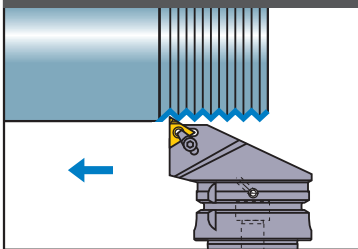


Right hand insert shown.

HSK-T SYSTEM

MMTE

Threading



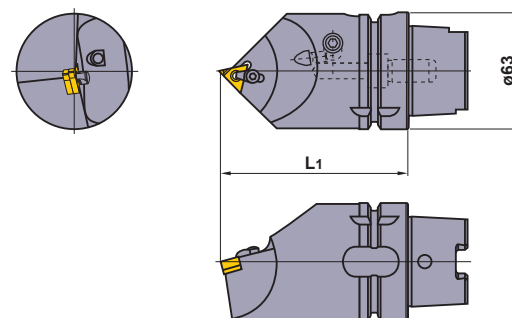
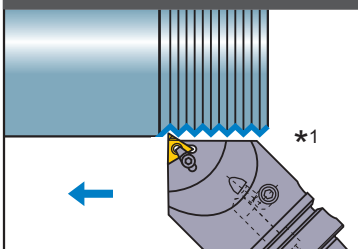
Right hand tool holder only.

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

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

MMTEN

Threading

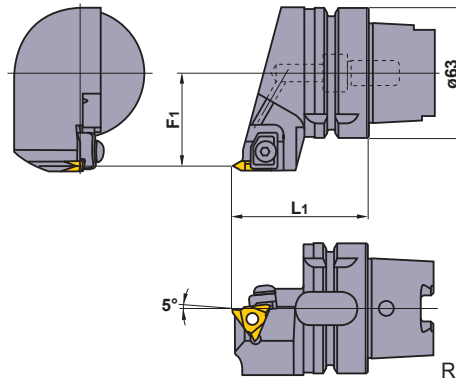
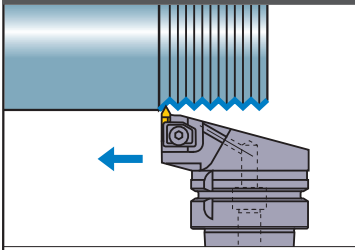


Tool holder for right hand insert only.

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

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

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

MT**Threading**

Right hand tool holder shown.

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

* Clamp Torque (N • m) : HBH06020=7.0

HSK-T
TOOLS

HSK-T SYSTEM

RECOMMENDED CUTTING CONDITIONS

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

SPARE PARTS

N001

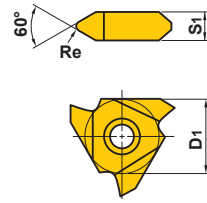
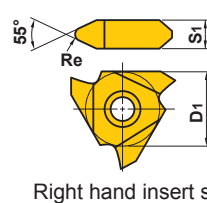
TECHNICAL
DATA

P001

H025

HSK-T SYSTEM

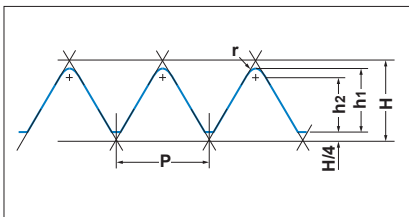
INSERTS

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

STANDARD OF DEPTH OF CUT ● METRIC SCREW THREAD

Unit : mm

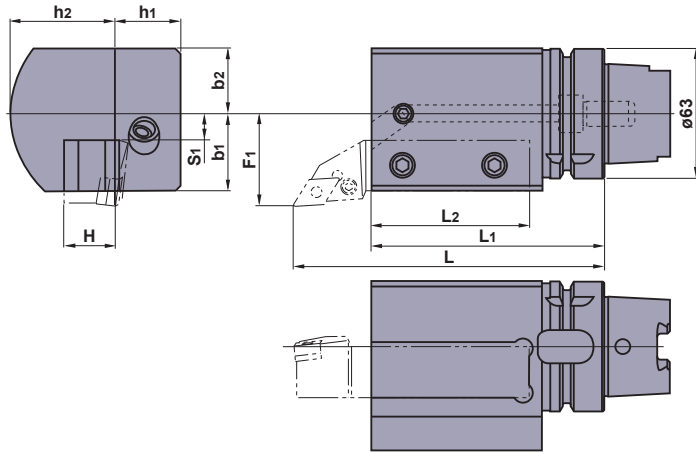
- The chart on the right shows the cutting depths when machining external ISO metric screw threads.
- When using cermet grades or cutting stainless steel, please increase the number of passes by 2-3 times.



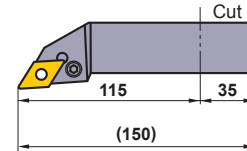
P (Pitch)	0.75	1.00	1.25	1.50	1.75	2.00	2.50	3.00	3.50	4.00	4.50	
h1	0.46	0.61	0.77	0.92	1.07	1.23	1.53	1.84	2.15	2.45	2.76	
h2	0.35	0.47	0.59	0.70	0.82	0.94	1.17	1.41	1.65	1.87	2.11	
r (Nose Radius)	0.11	0.14	0.18	0.22	0.25	0.29	0.36	0.43	0.50	0.58	0.65	
Number of Passes	1	0.18	0.20	0.20	0.25	0.25	0.30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

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

EXTERNAL TURNING TOOL HOLDERS External turning • Facing



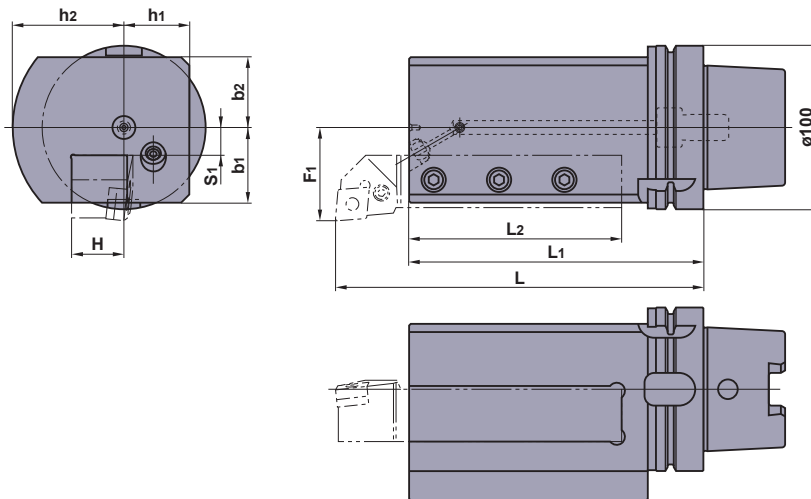
■ This holder is for 25×25 size tools.
Please shorten the tool as shown below before use.



Right hand tool holder shown.

Order Number	Stock		Dimensions (mm)										Mass (kg)			
	R	L	L	L1	L2	H	h1	h2	F1	S1	b1	b2				
H63TH-EV2525R/L-112	★	★	150	112	77	25	32	53	45	13	38	32	3.9	HSS12025	HGM-PT1/8	HSK-CP18S

EXTERNAL TURNING TOOL HOLDERS External turning • Facing



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

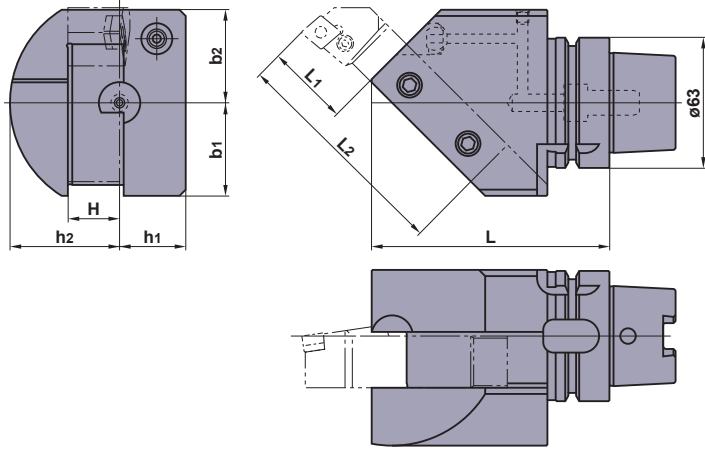
Right hand tool holder shown.

Order Number	Stock		Dimensions (mm)										Mass (kg)				
	R	L	L	L1	L2	H	h1	h2	F1	S1	b1	b2					
H100TH-EV3232R/L-180	★	★	220	180	130	32	40	68	57	17	46	43	11.7	HSS14035	SNA4	HSS06006	HSK-CP24S

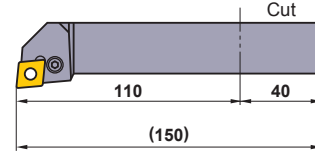
(Note) Can be used with 32 x 32 and 32 x 25 tool holders. Possible to fit a 25 x 25 tool by using a 7mm plate.

HSK-T SYSTEM

EXTERNAL TURNING TOOL HOLDERS External turning • Facing







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

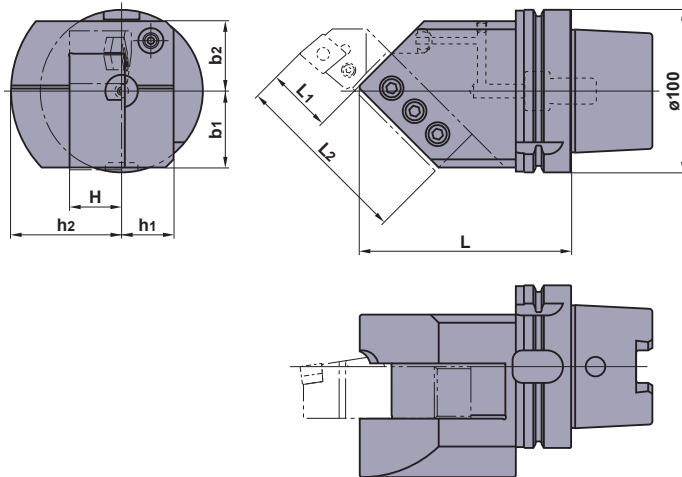


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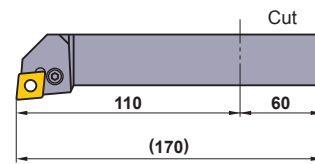
Right hand tool holder shown.

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

EXTERNAL TURNING TOOL HOLDERS External turning • Facing







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



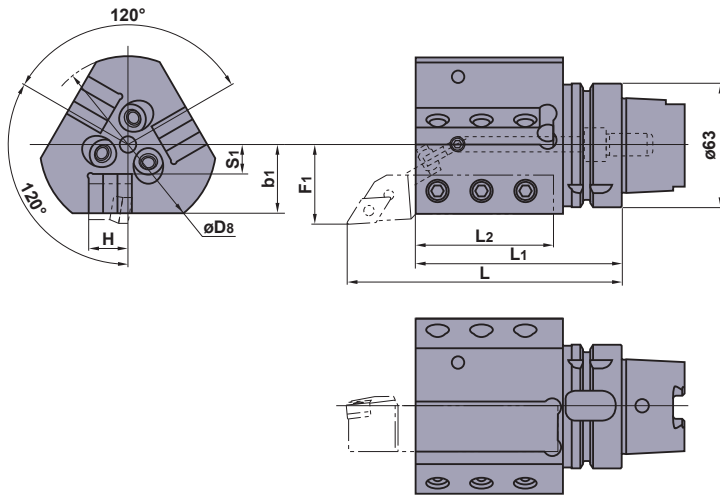
Mitsubishi Materials is licensed for production and distribution of these tools from MORI SEIKI CO., LTD under Patent No.3720202.

Right hand tool holder shown.

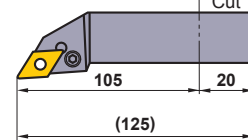
Order Number	Stock		Dimensions (mm)								Mass (kg)	 Clamp Screw	 Nozzle Plug	 Plug	 Coolant Pipe
	R	L	L	L1	L2	H	h1	h2	b1	b2					
H100TH-EN3232R/L-130	★	★	130	40	110	32	32	68	47	43	6.6	HSS14030	SNA4	HSS06006	HSK-CP24S

(Note) Can be used with 32 x 32 and 32 x 25 tool holders. Possible to fit a 25 x 25 tool by using a 7mm plate.





EXTERNAL TURNING TOOL HOLDERS External turning • Facing



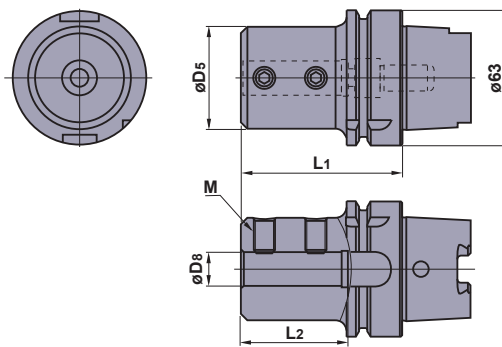
■ This holder is for 20×20 size tools.
Please shorten the tool as shown below
before use.





Right hand tool holder shown.

Order Number	Stock		Dimensions (mm)								Mass (kg)	   			
	R	L	L	L1	L2	H	D8	F1	S1	b1		Clamp Screw	Nozzle Plug	Plug	Coolant Pipe
H63TH-EV2020R/L-105-3	★	★	140	105	70	20	90	40	15	35	2.9	HSS12030	HSS05012	HSS06006	HSK-CP18S

BORING BAR HOLDERS Boring

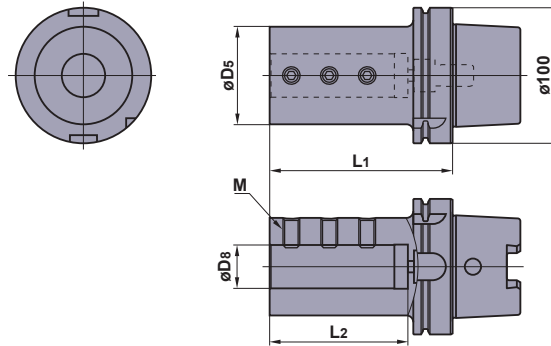




Order Number	Stock	Dimensions (mm)					Mass (kg)	 	
		D5	D8	L1	L2	M		Clamp Screw	Coolant Pipe
H63TH-B08-65	★	28	8	65	40	M8	0.9	HSS08010	HSK-CP18S
-B10-70	★	35	10	70	45	M8	1.0	HSS08012	
-B12-70	★	42	12	70	45	M8	1.1	HSS08012	
-B16-75	★	48	16	75	50	M10	1.3	HSS10016	
-B20-75	★	52	20	75	50	M10	1.4	HSS10016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

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

HSK-T SYSTEM

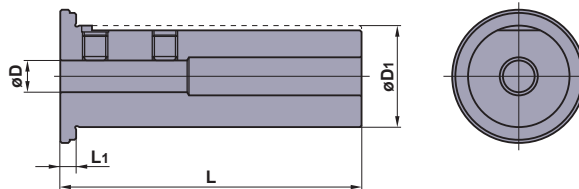
BORING BAR HOLDERS Boring




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

(Note) Available for use with a sleeve for small round-shank tool installation.

BORING BAR SLEEVES FOR H100TH-B32-135



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

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

Memo

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