
BORING BARS FOR SMALL PARTS MACHINING

COMPATIBLE WITH SWISS-TYPE AUTOMATIC LATHES



BORING BARS FOR SMALL PARTS MACHINING

OVERALL LENGTH COMPATIBLE WITH SWISS-TYPE AUTOMATIC LATHES



SCREW-ON TYPE

Carbide shank:
80 mm, 90 mm, 140 mm, 180 mm

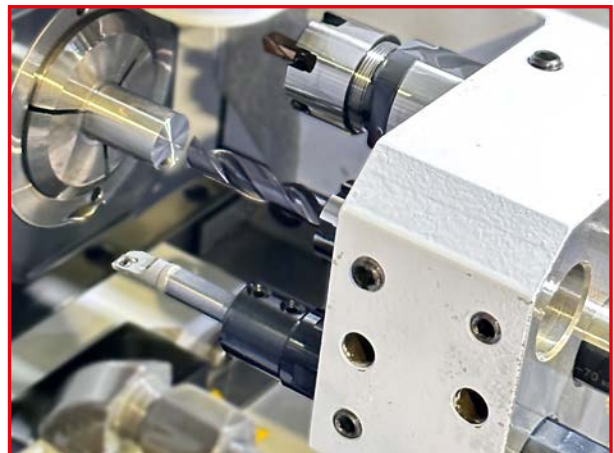
Steel shank:
90 mm, 150 mm

WITH COOLANT HOLE

Some items with small diameter carbide shanks do not have a coolant hole.
Please check the series list on page 3.

NO NEED TO SHORTEN THE SHANK

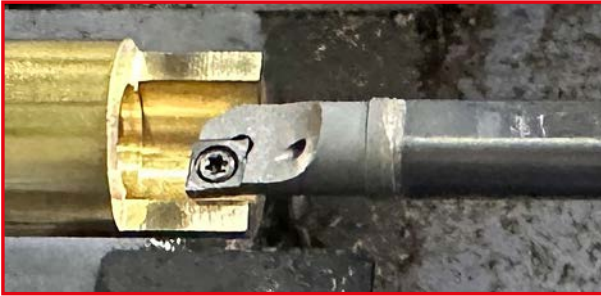
The length of the tools are compatible with Swiss-type automatic lathes, therefore no need to cut the shank to prevent interference.



THROUGH COOLANT CARBIDE SHANK WITH MINIMUM MACHINING DIAMETER OF 9 MM

The boring bar with a minimum machining diameter of 9 mm provides a large clearance and enables excellent chip evacuation.

CLEARANCE COMPARISON: HOLE DIAMETER 11 MM



Boring Bar for machining small parts
Minimum machining diameter of 9 mm



Dimple Bar
Minimum machining diameter of 10 mm

IDENTIFICATION

1. Shank material	4. Clamp structure	5. Insert shape	6. Cutting angle KAPR	7. Insert clearance
C Carbide shank	S Screw-on	C RHOMBIC 80°	U 93°	B 5° POSITIVE
S Steel shank		D RHOMBIC 55°	L 95°	C 7° POSITIVE
		T TRIANGULAR 60°	Q 107.5°	P 11° POSITIVE
		V RHOMBIC 35°	P 117.5°	
		W TRIGON		

2. Min. machining Diameter
DMIN (mm)

3. Shank diameter
DCONMS (mm)

1 **C**

2 **18**

-

3 **16**

4 **S**

5 **C**

6 **L**

7 **C**

8 **R**

9 **09**

-

10 **180**

-

11 **C**

8. Hand of tool	9. Cutting edge length symbol and inscribed circle	10. Tool length (mm)	11. Coolant hole
R Right Hand	Inscribed circle (mm) 3.97 4.76 5.56 6.35 7.94 9.525	080 80	C With coolant hole
L Left Hand	RHOMBIC 80° 03 04 — 06 08 09	090 90	
	RHOMBIC 55° — — — 07 — 11	140 140	
	TRIANGULAR 60° 06 08 09 11 — 16	150 150	
	RHOMBIC 35° — 08 — 11 — 16	180 180	
	TRIGON 02 L3 — 04 — 06	200 200	

SELECTION STANDARD

Insert shape	Holder type	KAPR	Shank material	Tool length	DMIN	DCONMS	Economical	Cutting edge strength	Profile turning	Internal coolant	Deep boring (L/D>6)	Holder	Insert
RHOMBIC 80° Normal clearance 7°	SCLC	95°	Carbide	80, 90	5 – 8	4 – 7		⊙			⊙	5	23
			Carbide	90, 140, 180	9 – 34	8 – 32		⊙	⊙	⊙	6		
			Steel	90, 150	14 – 34	12 – 32		⊙	⊙	7			
RHOMBIC 80° Normal clearance 11°	SCLP	95°	Carbide	140, 180	12 – 30	10 – 25		⊙		⊙	⊙	8	31
			Steel	90, 150	14 – 30	12 – 25		⊙	⊙	9			
TRIANGULAR 60° Normal clearance 7°	STUC	93°	Carbide	90	7 – 8	6 – 7	⊙				⊙	10	40
			Carbide	90, 140, 180	9 – 32	8 – 25	⊙		⊙	⊙	11		
			Steel	90, 150	14 – 40	12 – 32	⊙		⊙	12			
TRIANGULAR 60° Normal clearance 11°	STUP	93°	Carbide	90, 140, 180	10 – 34	8 – 25	⊙			⊙	⊙	13	43
			Steel	90, 150	14 – 34	12 – 25	⊙		⊙	14			
RHOMBIC 55° Normal clearance 7°	SDUC	93°	Carbide	140, 180	14 – 32	10 – 25			⊙	⊙	⊙	15	34
			Steel	150	16 – 32	12 – 25			⊙	⊙	16		
RHOMBIC 55° Normal clearance 7°	SDQC	107.5°	Carbide	140, 180	13 – 30	10 – 25			⊙	⊙	⊙	17	34
			Steel	90, 150	16 – 30	12 – 25			⊙	⊙	18		
TRIGON Normal clearance 7°	SWUC	93°	Carbide	80, 90	6 – 8	5 – 7	⊙	⊙			⊙	19	51
			Carbide	90, 140, 180	10 – 22	8 – 20	⊙	⊙		⊙	⊙	20	
			Steel	90, 150	14 – 22	12 – 20	⊙	⊙		⊙	21		

INSTRUCTIONS FOR THE USE OF CPGT, TPGX / TPMX TYPE INSERTS

Boring bars for machining small parts can use the inserts listed in the table below by changing the clamp screws.

Insert type

Clamp screw

CPGT0802⊙ (Ø7.94)

TS3

CPGT0903⊙ (Ø9.525)

TS4

Insert type

Clamp screw

TPGX0802⊙ (Ø4.76)

CS200T

TPGX/TPMX0902⊙ (Ø5.56)

CS250T

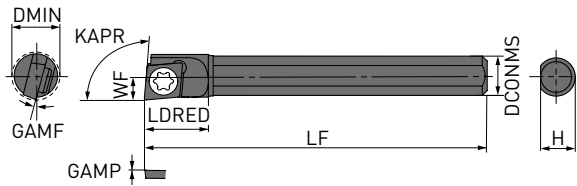
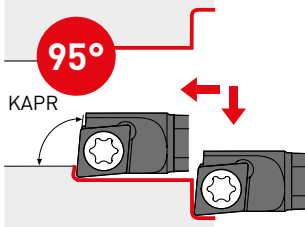
TPGX/TPMX1103⊙ (Ø9.525)

CS300890T

1. If the screw is too long the shorten is necessary.

C-SCLC

CARBIDE SHANK BORING BAR WITHOUT COOLANT HOLE



Right hand tool holder shown.

CC⁰⁰-Inserts



(03,04)

PCBN/PCD



(03,04)

Order number	Stock	Hand	DMIN	DCONMS	LF	LDRED	WF	H	GAMF	GAMP	Insert number
C05-04SCLCR03-080	●	R	5	4	80	7	2.5	3.7	15°	0°	CC ⁰⁰
C05-04SCLCL03-080	●	L	5	4	80	7	2.5	3.7	15°	0°	
C06-05SCLCR03-080	●	R	6	5	80	9	3.0	4.7	13°	0°	
C06-05SCLCL03-080	●	L	6	5	80	9	3.0	4.7	13°	0°	
C07-06SCLCR04-090	●	R	7	6	90	9	3.5	5.7	13°	0°	
C07-06SCLCL04-090	●	L	7	6	90	9	3.5	5.7	13°	0°	
C08-07SCLCR04-090	●	R	8	7	90	10	4.0	6.7	11°	0°	
C08-07SCLCL04-090	●	L	8	7	90	10	4.0	6.7	11°	0°	

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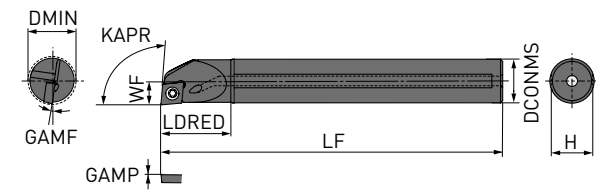
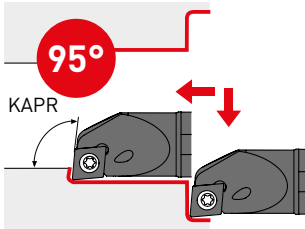
SPARE PARTS

Boring bar type	Clamp screw *	Wrench
CC ⁰⁰ -SCLCR/L03	TS16	TKY06F
CC ⁰⁰ -SCLCR/L04	TS21	TKY06F

* Clamp Torque (Nm) : TS16 = 0.6, TS21 = 0.6

C-SCLC-C

CARBIDE SHANK BORING BAR WITH COOLANT HOLE



Right hand tool holder shown.

CC⁰⁰-Inserts



Order number	Stock	Hand	DMIN	DCONMS	LF	LDRED	WF	H	GAMF	GAMP	Insert number
C09-08SCLCR04-090-C	●	R	9	8	90	14	4.5	7	10°	0°	04T0 ⁰⁰
C10-08SCLCR04-090-C	●	R	10	8	90	14	5.0	7	9°	0°	04T0 ⁰⁰
C10-08SCLCR06-140-C	●	R	10	8	140	14	5.0	7	9°	0°	0602 ⁰⁰
C10-08SCLCL06-140-C	●	L	10	8	140	14	5.0	7	9°	0°	0602 ⁰⁰
C12-10SCLCR06-140-C	●	R	12	10	140	18	6.0	9	12°	0°	0602 ⁰⁰
C12-10SCLCL06-140-C	●	L	12	10	140	18	6.0	9	12°	0°	0602 ⁰⁰
C14-12SCLCR06-140-C	●	R	14	12	140	23	7.0	11	10°	0°	CC ⁰⁰ 0602 ⁰⁰
C14-12SCLCL06-140-C	●	L	14	12	140	23	7.0	11	10°	0°	0602 ⁰⁰
C18-16SCLCR09-180-C	●	R	18	16	180	28	9.0	15	10°	0°	09T3 ⁰⁰
C18-16SCLCL09-180-C	●	L	18	16	180	28	9.0	15	10°	0°	09T3 ⁰⁰
C22-20SCLCR09-180-C	●	R	22	20	180	32	11.0	19	8°	0°	09T3 ⁰⁰
C27-25SCLCR09-180-C	★	R	27	25	180	38	13.5	24	6°	0°	09T3 ⁰⁰
C34-32SCLCR09-180-C	★	R	34	32	180	48	17.0	31	4°	0°	09T3 ⁰⁰

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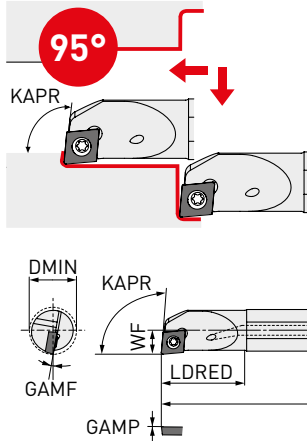
SPARE PARTS

Boring bar type	Clamp screw *	Wrench
C ⁰⁰ - ⁰⁰ SCLCR04	TS21	TKY06F
C ⁰⁰ - ⁰⁰ SCLCR/L06	TS25	TKY08F
C ⁰⁰ - ⁰⁰ SCLCR/L09	TS4	TKY15F

* Clamp Torque (Nm): TS21 = 0.6, TS25 = 1.0, TS4 = 3.5

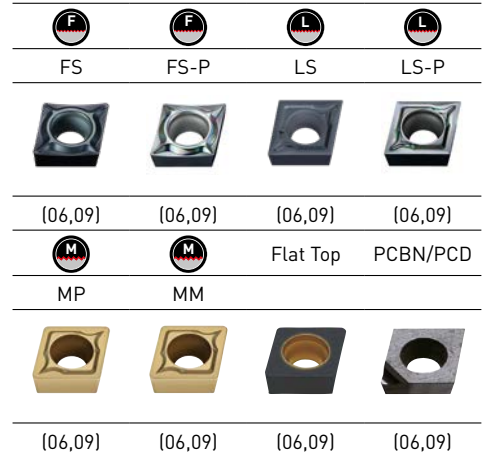
S-SCLC-C

STEEL SHANK BORING BAR WITH COOLANT HOLE



Right hand tool holder shown.

CC^{○○}-Inserts



Order number	Stock	Hand	DMIN	DCONMS	LF	LDRED	WF	H	GAMF	GAMP	Insert number
S14-12SCLCR06-090-C	●	R	14	12	90	24	7.0	11	10°	0°	0602 ^{○○}
S14-12SCLCL06-090-C	●	L	14	12	90	24	7.0	11	10°	0°	0602 ^{○○}
S18-16SCLCR09-150-C	●	R	18	16	150	30	9.0	15	10°	0°	09T3 ^{○○}
S18-16SCLCL09-150-C	●	L	18	16	150	30	9.0	15	10°	0°	09T3 ^{○○}
S22-20SCLCR09-150-C	●	R	22	20	150	36	11.0	19	8°	0°	09T3 ^{○○}
S22-20SCLCL09-150-C	●	L	22	20	150	36	11.0	19	8°	0°	CC ^{○○} 09T3 ^{○○}
S27-25SCLCR09-150-C	●	R	27	25	150	46	13.5	24	6°	0°	09T3 ^{○○}
S27-25SCLCL09-150-C	●	L	27	25	150	46	13.5	24	6°	0°	09T3 ^{○○}
S34-32SCLCR09-150-C	●	R	34	32	150	58	17.0	31	4°	0°	09T3 ^{○○}
S34-32SCLCL09-150-C	★	L	34	32	150	58	17.0	31	4°	0°	09T3 ^{○○}

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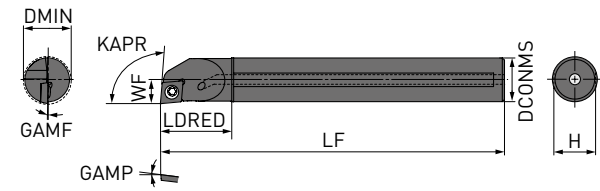
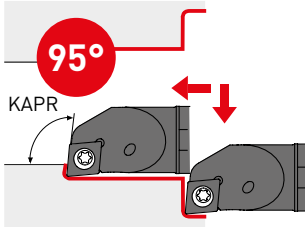
SPARE PARTS

Boring bar type	Clamp screw *	Wrench
S14-12SCLCR/L06	TS25	TKY08F
S ^{○○○○} SCLCR/L09	TS4	TKY15F

* Clamp Torque (Nm) : TS25 = 1.0, TS4 = 3.5

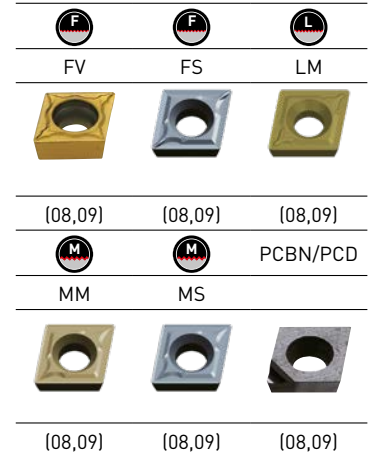
C-SCLP-C

CARBIDE SHANK BORING BAR WITH COOLANT HOLE



Right hand tool holder shown.

CP^{○○}-Inserts



Order number	Stock	Hand	DMIN	DCONMS	LF	LDRED	WF	H	GAMF	GAMP	Insert number
C12-10SCLPR08-140-C	●	R	12	10	140	18	6.0	9	5°	5°	CP ^{○○}
C12-10SCLPL08-140-C	●	L	12	10	140	18	6.0	9	5°	5°	
C14-12SCLPR08-140-C	●	R	14	12	140	23	7.0	11	4°	5°	
C14-12SCLPL08-140-C	●	L	14	12	140	23	7.0	11	4°	5°	
C16-12SCLPR09-140-C	●	R	16	12	140	23	8.0	11	4°	5°	
C16-12SCLPL09-140-C	●	L	16	12	140	23	8.0	11	4°	5°	
C18-16SCLPR09-180-C	●	R	18	16	180	28	9.0	15	3.5°	5°	
C18-16SCLPL09-180-C	●	L	18	16	180	28	9.0	15	3.5°	5°	
C22-20SCLPR09-180-C	●	R	22	20	180	32	11.0	19	2°	5°	
C22-20SCLPL09-180-C	●	L	22	20	180	32	11.0	19	2°	5°	
C27-25SCLPR09-180-C	★	R	27	25	180	38	13.5	24	0°	5°	
C30-25SCLPR09-180-C	★	R	30	25	180	38	15.0	24	0°	5°	

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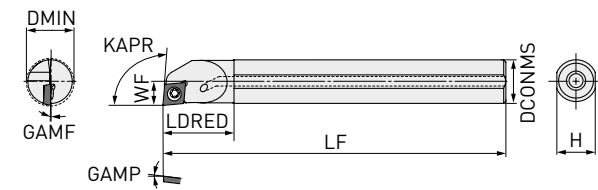
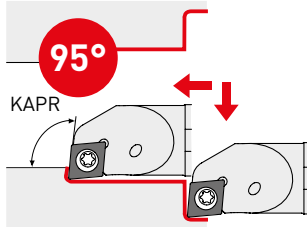
SPARE PARTS

Boring bar type	Clamp screw *	Wrench
C ^{○○} - ^{○○} SCLPR/L08	TS3D	TKY10F
C ^{○○} - ^{○○} SCLPR/L09	TS4D	TKY15F

* Clamp Torque (Nm) : TS3D = 2.5, TS4D = 3.5
By changing the clamp screw, it is possible to use the inserts listed page 3 for details.

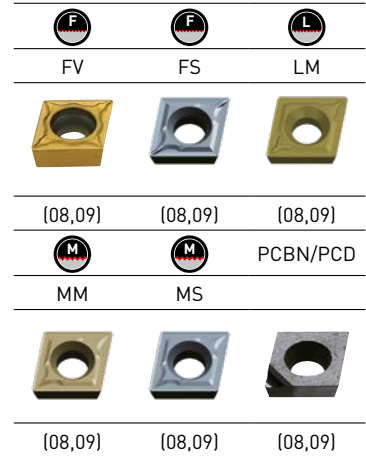
S-SCLP-C

STEEL SHANK BORING BAR WITH COOLANT HOLE



Right hand tool holder shown.

CP^{○○}-Inserts



Order number	Stock	Hand	DMIN	DCONMS	LF	LDRED	WF	H	GAMF	GAMP	Insert number
S14-12SCLPR08-090-C	●	R	14	12	90	24	7.0	11	4°	5°	CP ^{○○}
S14-12SCLPL08-090-C	●	L	14	12	90	24	7.0	11	4°	5°	
S16-12SCLPR09-090-C	★	R	16	12	90	24	8.0	11	4°	5°	
S16-12SCLPL09-090-C	★	L	16	12	90	24	8.0	11	4°	5°	
S18-16SCLPR09-150-C	★	R	18	16	150	30	9.0	15	3.5°	5°	
S18-16SCLPL09-150-C	★	L	18	16	150	30	9.0	15	3.5°	5°	
S22-20SCLPR09-150-C	★	R	22	20	150	36	11.0	19	2°	5°	
S22-20SCLPL09-150-C	★	L	22	20	150	36	11.0	19	2°	5°	
S27-25SCLPR09-150-C	★	R	27	25	150	46	13.5	24	0°	5°	
S27-25SCLPL09-150-C	★	L	27	25	150	46	13.5	24	0°	5°	
S30-25SCLPR09-150-C	●	R	30	25	150	46	15.0	24	0°	5°	
S30-25SCLPL09-150-C	★	L	30	25	150	46	15.0	24	0°	5°	

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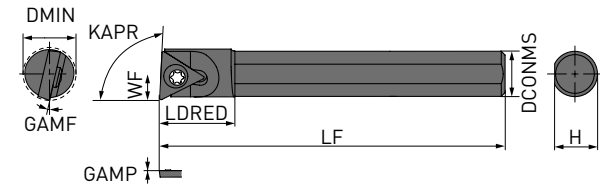
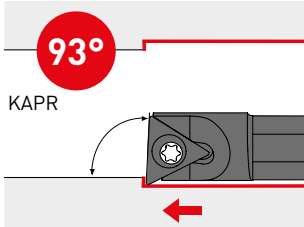
SPARE PARTS

Boring bar type	Clamp screw *	Wrench
S14-12SCLPR/L08	TS3D	TKY10F
S ^{○○○○} SCLPR/L09	TS4D	TKY15F

* Clamp Torque (Nm) : TS3D = 2.5, TS4D = 3.5
By changing the clamp screw, it is possible to use the inserts listed page 3 for details.

C-STUC

CARBIDE SHANK BORING BAR WITHOUT COOLANT HOLE



Right hand tool holder shown.

TC $\odot\odot$ -Inserts



Order number	Stock	Hand	DMIN	DCONMS	LF	LDRED	WF	H	GAMF	GAMP	Insert number
C07-06STUCR06-090	●	R	7	6	90	10	3.5	5.7	13°	0°	TC $\odot\odot$
C07-06STUCL06-090	●	L	7	6	90	10	3.5	5.7	13°	0°	
C08-07STUCR06-090	●	R	8	7	90	10	4.0	6.7	12°	0°	TC $\odot\odot$
C08-07STUCL06-090	●	L	8	7	90	10	4.0	6.7	12°	0°	

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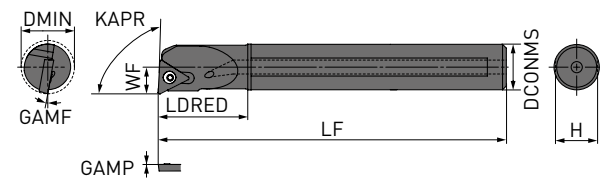
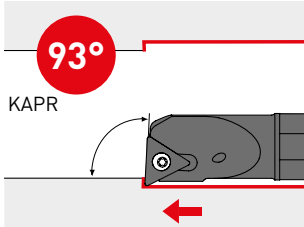
SPARE PARTS

Boring bar type	Clamp screw *	Wrench
C $\odot\odot\odot$ STUCR/L06	TS2C	TKY06F

* Clamp Torque (Nm) : TS2C = 0.6

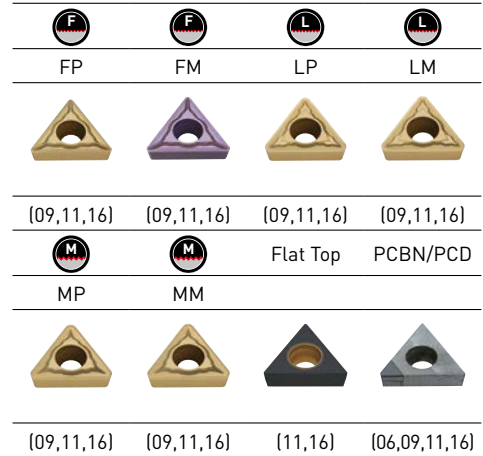
C-STUC-C

CARBIDE SHANK BORING BAR WITH COOLANT HOLE



Right hand tool holder shown.

TC^{○○}-Inserts



Order number	Stock	Hand	DMIN	DCONMS	LF	LDRED	WF	H	GAMF	GAMP	Insert number
C09-08STUCR06-090-C	●	R	9	8	90	14	4.5	7	11°	0°	0601 ^{○○}
C10-08STUCR09-090-C	●	R	10	8	90	14	5.0	7	14°	0°	0902 ^{○○}
C10-08STUCL09-090-C	●	L	10	8	90	14	5.0	7	14°	0°	0902 ^{○○}
C12-10STUCR09-140-C	●	R	12	10	140	18	6.2	9	12°	0°	0902 ^{○○}
C12-10STUCL09-140-C	●	L	12	10	140	18	6.2	9	12°	0°	0902 ^{○○}
C14-12STUCR09-140-C	●	R	14	12	140	23	7.2	11	10°	0°	0902 ^{○○}
C14-12STUCL09-140-C	●	L	14	12	140	23	7.2	11	10°	0°	0902 ^{○○}
C18-16STUCR11-180-C	●	R	18	16	180	28	9.2	15	8°	0°	TC ^{○○} 1102 ^{○○}
C18-16STUCL11-180-C	●	L	18	16	180	28	9.2	15	8°	0°	1102 ^{○○}
C22-20STUCR11-180-C	●	R	22	20	180	32	11.2	19	6°	0°	1102 ^{○○}
C22-20STUCL11-180-C	●	L	22	20	180	32	11.2	19	6°	0°	1102 ^{○○}
C27-20STUCR11-180-C	●	R	27	20	180	32	13.5	19	5°	0°	1102 ^{○○}
C27-20STUCL11-180-C	●	L	27	20	180	32	13.5	19	5°	0°	1102 ^{○○}
C32-25STUCR16-180-C	●	R	32	25	180	38	17.0	24	5°	0°	16T3 ^{○○}
C32-25STUCL16-180-C	★	L	32	25	180	38	17.0	24	5°	0°	16T3 ^{○○}

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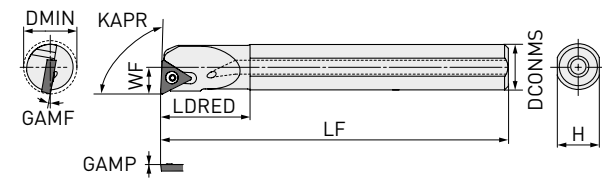
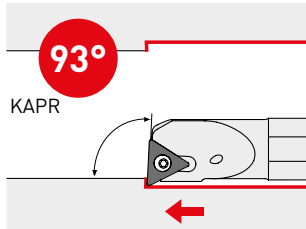
SPARE PARTS

Boring bar type	Clamp screw *	Wrench
C09-08STUCR06	TS2C	TKY06F
C ^{○○} - ^{○○} STUCR/L09	TS22	TKY06F
C ^{○○} - ^{○○} STUCR/L11	TS25	TKY08F
C32-25STUCR/L16	TS4	TKY15F

* Clamp Torque (Nm) : TS2C = 0.6, TS22 = 0.6, TS25 = 1.0, TS4 = 3.5

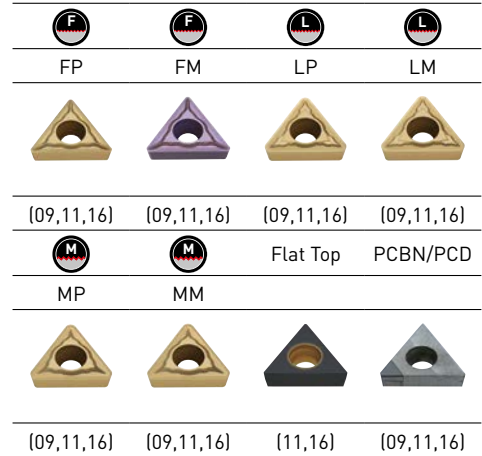
S-STUC-C

STEEL SHANK BORING BAR WITH COOLANT HOLE



Right hand tool holder shown.

TC^{○○}-Inserts



Order number	Stock	Hand	DMIN	DCONMS	LF	LDRED	WF	H	GAMF	GAMP	Insert number
S14-12STUCR09-090-C	●	R	14	12	90	24	7.2	11	10°	0°	0902 ^{○○}
S14-12STUCL09-090-C	●	L	14	12	90	24	7.2	11	10°	0°	0902 ^{○○}
S18-16STUCR11-150-C	●	R	18	16	150	30	9.2	15	8°	0°	1102 ^{○○}
S18-16STUCL11-150-C	●	L	18	16	150	30	9.2	15	8°	0°	1102 ^{○○}
S22-20STUCR11-150-C	●	R	22	20	150	36	11.2	19	6°	0°	1102 ^{○○}
S22-20STUCL11-150-C	●	L	22	20	150	36	11.2	19	6°	0°	1102 ^{○○}
S27-20STUCR11-150-C	●	R	27	20	150	36	13.5	19	5°	0°	TC ^{○○} 1102 ^{○○}
S27-20STUCL11-150-C	●	L	27	20	150	36	13.5	19	5°	0°	1102 ^{○○}
S32-25STUCR16-150-C	●	R	32	25	150	46	17.0	24	5°	0°	16T3 ^{○○}
S32-25STUCL16-150-C	●	L	32	25	150	46	17.0	24	5°	0°	16T3 ^{○○}
S40-32STUCR16-150-C	★	R	40	32	150	58	22.0	31	3°	0°	16T3 ^{○○}
S40-32STUCL16-150-C	★	L	40	32	150	58	22.0	31	3°	0°	16T3 ^{○○}

1/1



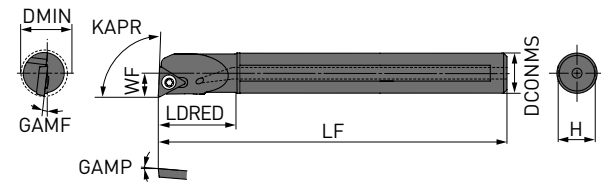
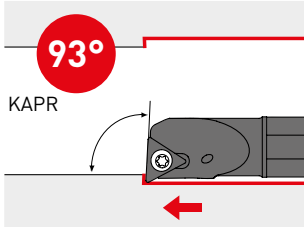
SPARE PARTS

Boring bar type	Clamp screw *	Wrench
S14-12STUCR/L09	TS22	TKY06F
S ^{○○} - ^{○○} STUCR/L11	TS25	TKY08F
S ^{○○} - ^{○○} STUCR/L16	TS4	TKY15F

* Clamp Torque (Nm) : TS22 = 0.6, TS25 = 1.0, TS4 = 3.5

C-STUP-C

CARBIDE SHANK BORING BAR WITH COOLANT HOLE



Right hand tool holder shown.

TP^{○○}-Inserts



Order number	Stock	Hand	DMIN	DCONMS	LF	LDRED	WF	H	GAMF	GAMP	Insert number
C10-08STUPR08-090-C	●	R	10	8	90	14	5.0	7	10°	5°	0802 ^{○○}
C10-08STUPL08-090-C	●	L	10	8	90	14	5.0	7	10°	5°	0802 ^{○○}
C12-10STUPR09-140-C	●	R	12	10	140	18	6.2	9	8°	5°	0902 ^{○○}
C12-10STUPL09-140-C	●	L	12	10	140	18	6.2	9	8°	5°	0902 ^{○○}
C14-12STUPR09-140-C	●	R	14	12	140	23	7.2	11	7°	5°	0902 ^{○○}
C14-12STUPL09-140-C	●	L	14	12	140	23	7.2	11	7°	5°	0902 ^{○○}
C18-16STUPR11-180-C	●	R	18	16	180	28	9.2	15	3.5°	5°	1103 ^{○○}
C18-16STUPL11-180-C	★	L	18	16	180	28	9.2	15	3.5°	5°	TP ^{○○} 1103 ^{○○}
C22-20STUPR11-180-C	●	R	22	20	180	32	11.2	19	2°	5°	1103 ^{○○}
C22-20STUPL11-180-C	★	L	22	20	180	32	11.2	19	2°	5°	1103 ^{○○}
C27-25STUPR11-180-C	★	R	27	25	180	38	13.7	24	0°	5°	1103 ^{○○}
C27-25STUPL11-180-C	★	L	27	25	180	38	13.7	24	0°	5°	1103 ^{○○}
C34-25STUPR11-180-C	★	R	34	25	180	38	17.2	24	0°	5°	1103 ^{○○}
C34-25STUPL11-180-C	★	L	34	25	180	38	17.2	24	0°	5°	1103 ^{○○}

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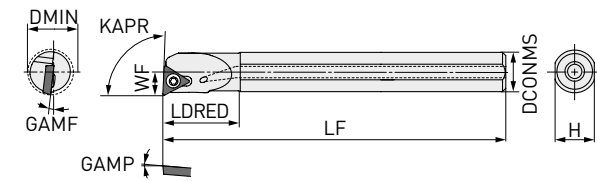
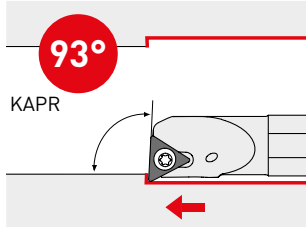
SPARE PARTS

Boring bar type	Clamp screw *	Wrench
C10-08STUPR/L08	TS2D	TKY06F
C ^{○○} - ^{○○} STUPR/L09	TS25D	TKY08F
C ^{○○} - ^{○○} STUPR/L11	TS31D	TKY10F

* Clamp Torque (Nm): TS2D = 0.6, TS25D = 1.6, TS31D = 2.5
By changing the clamp screw, it is possible to use the inserts listed page 3 for details.

S-STUP-C

STEEL SHANK BORING BAR WITH COOLANT HOLE



Right hand tool holder shown.

TP^{○○}-Inserts



Order number	Stock	Hand	DMIN	DCONMS	LF	LDRED	WF	H	GAMF	GAMP	Insert number
S14-12STUPR09-090-C	●	R	14	12	90	24	7.2	11	7°	5°	TP ^{○○}
S14-12STUPL09-090-C	●	L	14	12	90	24	7.2	11	7°	5°	
S18-16STUPR11-150-C	●	R	18	16	150	30	9.2	15	3.5°	5°	
S18-16STUPL11-150-C	●	L	18	16	150	30	9.2	15	3.5°	5°	
S22-20STUPR11-150-C	★	R	22	20	150	36	11.2	19	2°	5°	
S22-20STUPL11-150-C	★	L	22	20	150	36	11.2	19	2°	5°	
S27-25STUPR11-150-C	★	R	27	25	150	46	13.7	24	0°	5°	
S27-25STUPL11-150-C	★	L	27	25	150	46	13.7	24	0°	5°	
S34-25STUPR11-150-C	★	R	34	25	150	46	17.2	24	0°	5°	
S34-25STUPL11-150-C	★	L	34	25	150	46	17.2	24	0°	5°	

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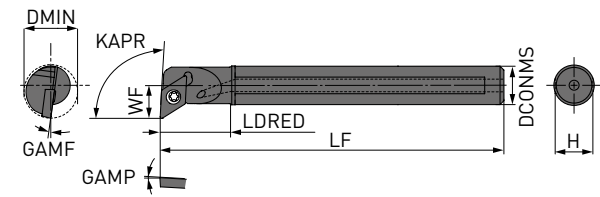
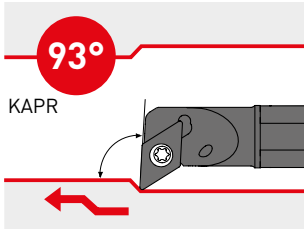
SPARE PARTS

Boring bar type	Clamp screw *	Wrench
S14-12STUPR/L09	TS25D	TKY08F
S ^{○○} - ^{○○} STUPR/L11	TS31D	TKY10F

* Clamp Torque (Nm) : TS25D = 1.6, TS31D = 2.5
By changing the clamp screw, it is possible to use the inserts listed page 3 for details.

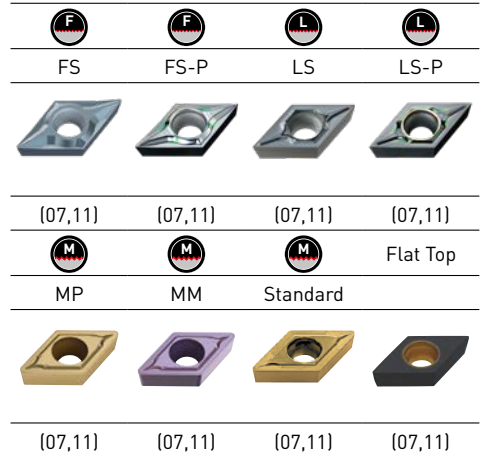
C-SDUC-C

CARBIDE SHANK BORING BAR WITH COOLANT HOLE



Right hand tool holder shown.

DC $\odot\odot$ -Inserts



Order number	Stock	Hand	DMIN	DCONMS	LF	LDRED	WF	H	GAMF	GAMP	Insert number
C14-10SDUCR07-140-C	●	R	14	10	140	18	8.7	9	7.5°	3°	DC $\odot\odot$
C14-10SDUCL07-140-C	●	L	14	10	140	18	8.7	9	7.5°	3°	
C16-12SDUCR07-180-C	●	R	16	12	180	23	9.7	11	6.5°	3°	
C16-12SDUCL07-180-C	●	L	16	12	180	23	9.7	11	6.5°	3°	
C20-16SDUCR07-180-C	●	R	20	16	180	28	11.7	15	5°	3°	
C20-16SDUCL07-180-C	●	L	20	16	180	28	11.7	15	5°	3°	
C23-16SDUCR07-180-C	●	R	23	16	180	28	14.5	15	5°	3°	
C23-16SDUCL07-180-C	●	L	23	16	180	28	14.5	15	5°	3°	
C27-20SDUCR11-180-C	●	R	27	20	180	32	16.5	19	5°	3°	
C27-20SDUCL11-180-C	●	L	27	20	180	32	16.5	19	5°	3°	
C32-25SDUCR11-180-C	●	R	32	25	180	38	19.0	24	5°	3°	
C32-25SDUCL11-180-C	★	L	32	25	180	38	19.0	24	5°	3°	

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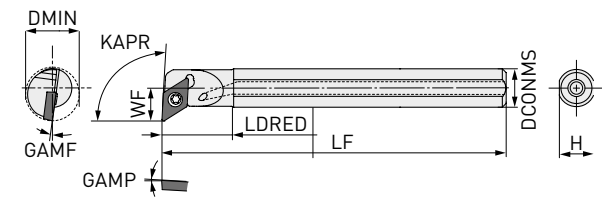
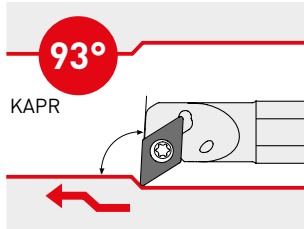
SPARE PARTS

Boring bar type	Clamp screw *	Wrench
C $\odot\odot\odot$ SDUCR/L07	TS25	TKY08F
C $\odot\odot\odot$ SDUCR/L11	TS4	TKY15F

* Clamp Torque (Nm) : TS25 = 1.0, TS4 = 3.5

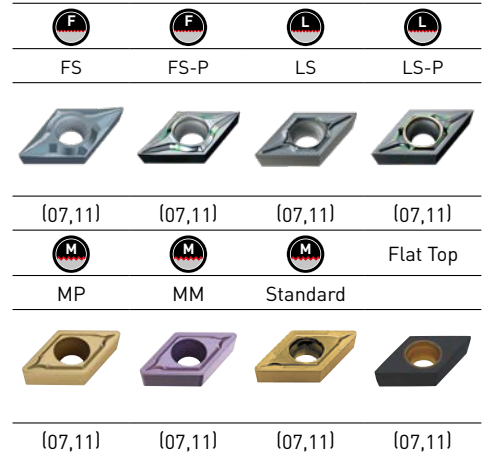
S-SDUC-C

STEEL SHANK BORING BAR WITH COOLANT HOLE



Right hand tool holder shown.

DC $\odot\odot$ -Inserts



Order number	Stock	Hand	DMIN	DCONMS	LF	LDRED	WF	H	GAMF	GAMP	Insert number
S16-12SDUCR07-150-C	●	R	16	12	150	21	9.7	11	6.5°	3°	DC $\odot\odot$
S16-12SDUCL07-150-C	●	L	16	12	150	21	9.7	11	6.5°	3°	
S20-16SDUCR07-150-C	●	R	20	16	150	21	11.7	15	5°	3°	
S20-16SDUCL07-150-C	●	L	20	16	150	21	11.7	15	5°	3°	
S23-16SDUCR07-150-C	●	R	23	16	150	21	14.5	15	5°	3°	
S23-16SDUCL07-150-C	●	L	23	16	150	21	14.5	15	5°	3°	
S27-20SDUCR11-150-C	●	R	27	20	150	23	16.5	19	5°	3°	
S27-20SDUCL11-150-C	●	L	27	20	150	23	16.5	19	5°	3°	
S32-25SDUCR11-150-C	●	R	32	25	150	24	19.0	24	5°	3°	
S32-25SDUCL11-150-C	●	L	32	25	150	24	19.0	24	5°	3°	

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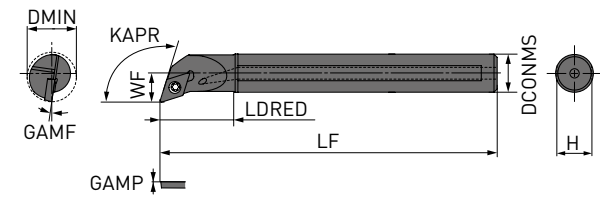
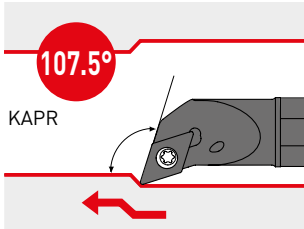
SPARE PARTS

Boring bar type	Clamp screw *	Wrench
S $\odot\odot\odot$ SDUCR/L07	TS25	TKY08F
S $\odot\odot\odot$ SDUCR/L11	TS4	TKY15F

* Clamp Torque (Nm) : TS25 = 1.0, TS4 = 3.5

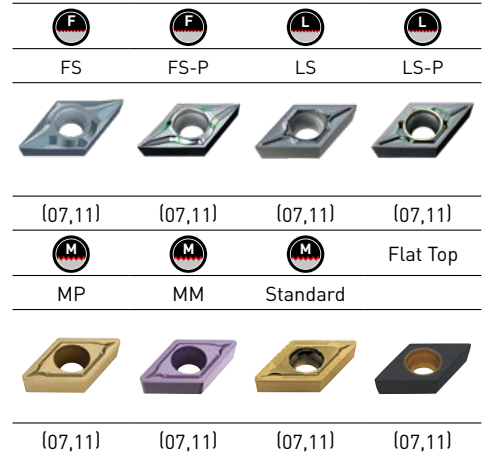
C-SDQC-C

CARBIDE SHANK BORING BAR WITH COOLANT HOLE



Right hand tool holder shown.

DC $\odot\odot$ -Inserts



Order number	Stock	Hand	DMIN	DCONMS	LF	LDRED	WF	H	GAMF	GAMP	Insert number
C13-10SDQCR07-140-C	●	R	13	10	140	18	7.5	9	10°	0°	DC $\odot\odot$
C13-10SDQCL07-140-C	●	L	13	10	140	18	7.5	9	10°	0°	
C16-12SDQCR07-140-C	●	R	16	12	140	23	9.25	11	8°	0°	
C16-12SDQCL07-140-C	●	L	16	12	140	23	9.25	11	8°	0°	
C20-16SDQCR07-180-C	●	R	20	16	180	28	11.3	15	6°	0°	
C20-16SDQCL07-180-C	●	L	20	16	180	28	11.3	15	6°	0°	
C23-16SDQCR07-180-C	●	R	23	16	180	28	12.8	15	5°	0°	
C23-16SDQCL07-180-C	●	L	23	16	180	28	12.8	15	5°	0°	
C25-20SDQCR11-180-C	●	R	25	20	180	32	14.4	19	5°	0°	
C25-20SDQCL11-180-C	●	L	25	20	180	32	14.4	19	5°	0°	
C30-25SDQCR11-180-C	★	R	30	25	180	38	16.9	24	4°	0°	
C30-25SDQCL11-180-C	★	L	30	25	180	38	16.9	24	4°	0°	

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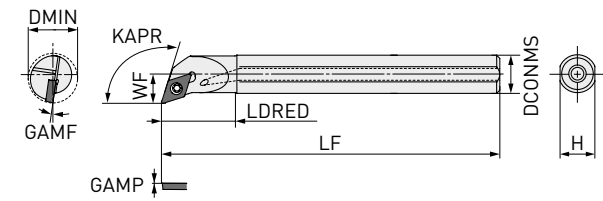
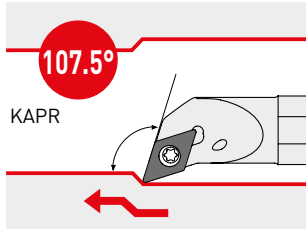
SPARE PARTS

Boring bar type	Clamp screw *	Wrench
C $\odot\odot\odot$ SDQCR/L07	TS25	TKY08F
C $\odot\odot\odot$ SDQCR/L11	TS4	TKY15F

* Clamp Torque (Nm) : TS25 = 1.0, TS4 = 3.5

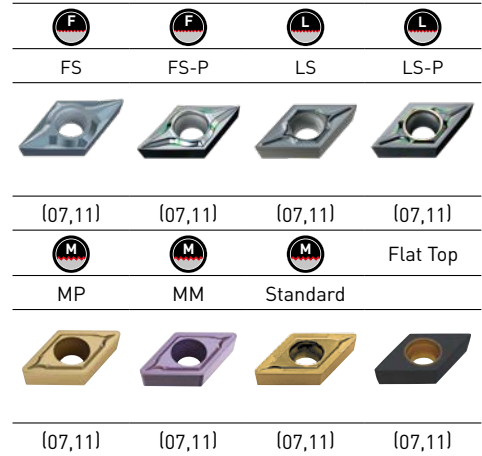
S-SDQC-C

STEEL SHANK BORING BAR WITH COOLANT HOLE



Right hand tool holder shown.

DC $\circ\circ$ -Inserts



Order number	Stock	Hand	DMIN	DCONMS	LF	LDRED	WF	H	GAMF	GAMP	Insert number	
S16-12SDQCR07-090-C	●	R	16	12	90	22	9.25	11	8°	0°	DC $\circ\circ$	0702 $\circ\circ$
S16-12SDQCL07-090-C	●	L	16	12	90	22	9.25	11	8°	0°		0702 $\circ\circ$
S20-16SDQCR07-150-C	●	R	20	16	150	25	11.3	15	6°	0°		0702 $\circ\circ$
S20-16SDQCL07-150-C	●	L	20	16	150	25	11.3	15	6°	0°		0702 $\circ\circ$
S23-16SDQCR07-150-C	●	R	23	16	150	25	12.8	15	5°	0°		0702 $\circ\circ$
S23-16SDQCL07-150-C	●	L	23	16	150	25	12.8	15	5°	0°		0702 $\circ\circ$
S25-20SDQCR11-150-C	●	R	25	20	150	31	14.4	19	5°	0°		11T3 $\circ\circ$
S25-20SDQCL11-150-C	●	L	25	20	150	31	14.4	19	5°	0°		11T3 $\circ\circ$
S30-25SDQCR11-150-C	●	R	30	25	150	38	16.9	24	4°	0°		11T3 $\circ\circ$
S30-25SDQCL11-150-C	●	L	30	25	150	38	16.9	24	4°	0°		11T3 $\circ\circ$

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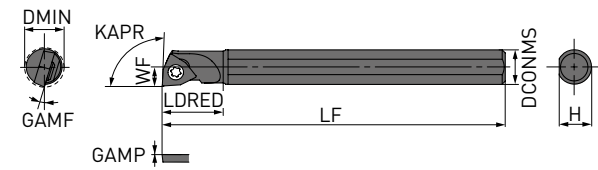
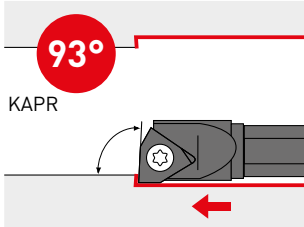
SPARE PARTS

Boring bar type	Clamp screw *	Wrench
S $\circ\circ\circ$ SDQCR/L07	TS25	TKY08F
S $\circ\circ\circ$ SDQCR/L11	TS4	TKY15F

* Clamp Torque (Nm) : TS25 = 1.0, TS4 = 3.5

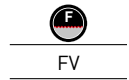
C-SWUC

CARBIDE SHANK BORING BAR WITHOUT COOLANT HOLE



Right hand tool holder shown.

WC[⊙] Inserts



(02,L3)

PCBN/PCD





[L3]

Order number	Stock	Hand	DMIN	DCONMS	LF	LDRED	WF	H	GAMF	GAMP	Insert number
C06-05SWUCR02-080	●	R	6	5	80	9	3.0	4.7	17°	0°	WC [⊙]
C06-05SWUCL02-080	●	L	6	5	80	9	3.0	4.7	17°	0°	
C08-07SWUCRL3-090	●	R	8	7	90	10	4.0	6.7	15°	0°	L302 [⊙]
C08-07SWUCLL3-090	●	L	8	7	90	10	4.0	6.7	15°	0°	

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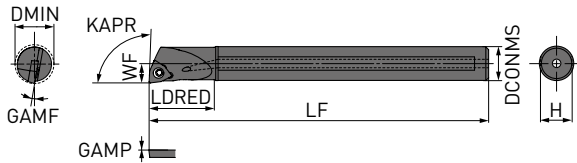
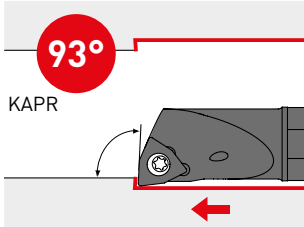
SPARE PARTS

Boring bar type	 Clamp screw *	 Wrench
C06-05SWUCR/L02	TS21	TKY06F
C08-07SWUCR/LL3	TS2	TKY06F

* Clamp Torque (Nm) : TS21 = 0.6, TS2 = 0.6

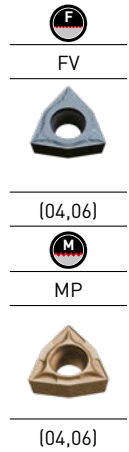
C-SWUC-C

CARBIDE SHANK BORING BAR WITH COOLANT HOLE



Right hand tool holder shown.

WC^{○○}-Inserts



Order number	Stock	Hand	DMIN	DCONMS	LF	LDRED	WF	H	GAMF	GAMP	Insert number
C10-08SWUCR04-090-C	●	R	10	8	90	14	5.0	7	15°	0°	0402 ^{○○}
C10-08SWUCL04-090-C	●	L	10	8	90	14	5.0	7	15°	0°	0402 ^{○○}
C12-10SWUCR04-090-C	●	R	12	10	90	18	6.0	9	12°	0°	0402 ^{○○}
C12-10SWUCL04-090-C	●	L	12	10	90	18	6.0	9	12°	0°	0402 ^{○○}
C14-12SWUCR04-140-C	●	R	14	12	140	23	7.0	11	10°	0°	0402 ^{○○}
C14-12SWUCL04-140-C	●	L	14	12	140	23	7.0	11	10°	0°	0402 ^{○○}
C16-12SWUCR06-140-C	●	R	16	12	140	23	8.0	11	12°	0°	WC ^{○○} 06T3 ^{○○}
C16-12SWUCL06-140-C	●	L	16	12	140	23	8.0	11	12°	0°	06T3 ^{○○}
C18-16SWUCR06-140-C	●	R	18	16	140	28	9.0	15	10°	0°	06T3 ^{○○}
C18-16SWUCL06-140-C	●	L	18	16	140	28	9.0	15	10°	0°	06T3 ^{○○}
C22-20SWUCR06-180-C	●	R	22	20	180	32	11.0	19	7°	0°	06T3 ^{○○}
C22-20SWUCL06-180-C	●	L	22	20	180	32	11.0	19	7°	0°	06T3 ^{○○}

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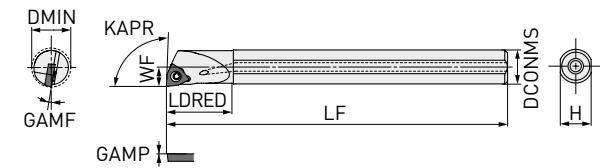
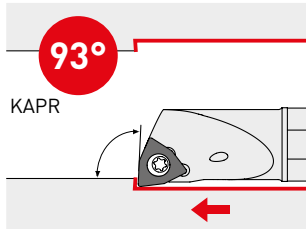
SPARE PARTS

Boring bar type	Clamp screw *	Wrench
C ^{○○} - ^{○○} SWUCR/L04	TS25	TKY08F
C ^{○○} - ^{○○} SWUCR/L06	TS4	TKY15F

* Clamp Torque (Nm) : TS25 = 1.0, TS4 = 3.5

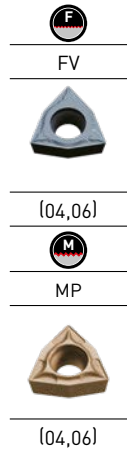
S-SWUC-C

STEEL SHANK BORING BAR WITH COOLANT HOLE



Right hand tool holder shown.

WC^{○○}-Inserts



Order number	Stock	Hand	DMIN	DCONMS	LF	LDRED	WF	H	GAMF	GAMP	Insert number
S14-12SWUCR04-090-C	●	R	14	12	90	24	7.0	11	10°	0°	WC ^{○○}
S14-12SWUCL04-090-C	●	L	14	12	90	24	7.0	11	10°	0°	
S16-12SWUCR06-090-C	●	R	16	12	90	24	8.0	11	12°	0°	
S16-12SWUCL06-090-C	●	L	16	12	90	24	8.0	11	12°	0°	
S18-16SWUCR06-090-C	●	R	18	16	90	30	9.0	15	10°	0°	
S18-16SWUCL06-090-C	●	L	18	16	90	30	9.0	15	10°	0°	
S22-20SWUCR06-150-C	●	R	22	20	150	36	11.0	19	7°	0°	
S22-20SWUCL06-150-C	●	L	22	20	150	36	11.0	19	7°	0°	

1/1




SPARE PARTS

Boring bar type	Clamp screw *	Wrench
S14-12SWUCR/L04	TS25	TKY08F
S ^{○○○○} SWUCR/L06	TS4	TKY15F

* Clamp Torque (Nm) : TS25 = 1.0, TS4 = 3.5

RECOMMENDED CUTTING CONDITIONS

Material	Hardness	Cutting mode		Grade	Vc	f	ap		
P Pure iron Free cutting steel	—	Finish	R/L-F	MS6015	150 (50 – 250)	0.01 – 0.15	0.1 – 0.4		
		Light	LS-P	MS6015	150 (50 – 250)	0.01 – 0.15	0.3 – 2.2		
		Light	R/L-SS	MS6015	150 (50 – 250)	0.01 – 0.15	0.2 – 0.8		
		Medium	R/L-SN	MS6015	150 (50 – 250)	0.01 – 0.15	0.1 – 0.4		
		Medium	SMG	MS6015	150 (50 – 250)	0.01 – 0.15	0.1 – 1.5		
Carbon steel Alloy steel	180 – 280 HB	Finish	R/L-F	MS6015	100 (50 – 150)	0.01 – 0.15	0.1 – 0.4		
		Light	LS-P	MS6015	100 (50 – 150)	0.01 – 0.15	0.3 – 2.2		
		Light	R/L-SS	MS6015	100 (50 – 150)	0.01 – 0.15	0.2 – 0.8		
		Medium	R/L-SN	MS6015	100 (50 – 150)	0.01 – 0.15	0.1 – 0.4		
		Medium	SMG	MS6015	100 (50 – 150)	0.01 – 0.15	0.1 – 1.5		
M Austenitic Stainless steel	—	Finish	FS-P	MS7025	60 (40 – 100)	0.01 – 0.08	0.2 – 0.5		
		Finish	FS-P	MS9025	100 (60 – 150)	0.04 – 0.15	0.2 – 0.5		
		Finish	R/L-F	MS7025	60 (40 – 100)	0.01 – 0.08	0.1 – 0.4		
		Finish	R-SRF	MS9025	100 (60 – 150)	0.04 – 0.15	0.1 – 0.4		
		Light	LS-P	MS7025	60 (40 – 100)	0.01 – 0.08	0.3 – 2.2		
		Light	LS-P	MS9025	100 (60 – 150)	0.05 – 0.15	0.3 – 2.2		
		Medium	R-SN	MS7025	60 (40 – 100)	0.01 – 0.08	0.1 – 3.8		
		Medium	R-SN	MS9025	100 (60 – 150)	0.05 – 0.15	0.1 – 3.8		
		Ferritic and martensitic stainless steel	—	Finish	FS-P	MS7025	60 (40 – 100)	0.01 – 0.08	0.2 – 0.5
				Finish	R-SRF	MS7025	60 (40 – 100)	0.01 – 0.08	0.1 – 0.4
				Light	LS-P	MS7025	60 (40 – 100)	0.01 – 0.08	0.3 – 2.2
				Light	R-SN	MS7025	60 (40 – 100)	0.01 – 0.08	0.1 – 3.8
		Soft magnetic stainless steel [X105CrMo17 / 1.4125, X42Cr13 / 1.2083, etc.]	230 HBW	Finish	FS-P	MS7025	80 (40 – 160)	0.02 – 0.08	0.2 – 1.4
				Finish	FS-P	MS9025	100 (50 – 180)	0.04 – 0.12	0.2 – 1.4
Finish	R-SRF			MS7025	80 (40 – 160)	0.03 – 0.08	0.1 – 0.4		
Finish	R-SRF			MS9025	100 (50 – 180)	0.05 – 0.12	0.1 – 0.4		
Light	LS-P			MS7025	80 (40 – 160)	0.02 – 0.10	0.3 – 2.2		
Light	LS-P			MS9025	100 (50 – 180)	0.04 – 0.15	0.3 – 2.2		
Medium	R-SN			MS7025	80 (40 – 160)	0.01 – 0.10	0.1 – 3.8		
Medium	R-SN			MS9025	100 (50 – 180)	0.01 – 0.10	0.1 – 3.8		
Precipitation hardened stainless steel [17-4PH / 1.4542, 17-7PH / X7CrNi-A117-7 / X5CrNi-CuNb17-4, etc.]	< 450 HB	Finish	FS-P	MS7025	60 (40 – 80)	0.01 – 0.10	0.1 – 1.0		
		Finish	FS-P	MS9025	70 (50 – 100)	0.03 – 0.15	0.1 – 1.0		
		Finish	R-SRF	MS7025	60 (40 – 80)	0.01 – 0.10	0.1 – 0.4		
		Finish	R-SRF	MS9025	70 (50 – 100)	0.03 – 0.15	0.1 – 0.4		
		Light	LS-P	MS7025	60 (40 – 80)	0.04 – 0.10	0.2 – 2.2		
		Light	LS-P	MS9025	70 (50 – 100)	0.04 – 0.15	0.2 – 2.2		
		Medium	R-SN	MS7025	60 (40 – 80)	0.03 – 0.10	0.3 – 2.2		
		Medium	R-SN	MS9025	70 (50 – 100)	0.04 – 0.15	0.2 – 2.2		
K Grey cast iron	Tensile strength < 350MPa	Finish	Flat Top	MC5115	225 (150 – 300)	0.04 – 0.15	0.1 – 0.5		
		Finish	Flat Top	HTi10	100 (50 – 150)	0.04 – 0.15	0.1 – 0.5		
		Light	Flat Top	MC5115	225 (150 – 300)	0.04 – 0.15	0.2 – 1.0		
		Light	Flat Top	HTi10	100 (50 – 150)	0.04 – 0.15	0.2 – 1.0		
		Medium	Flat Top	MC5115	225 (150 – 300)	0.04 – 0.15	0.1 – 2.0		
		Medium	Flat Top	HTi10	100 (50 – 150)	0.04 – 0.15	0.1 – 2.0		
S Heat resistant alloy (Heat resistant stainless steel, etc.)	—	Finish	FS-P	MS9025	80 (40 – 140)	0.04 – 0.12	0.2 – 1.0		
		Finish	R-SRF	MS9025	80 (40 – 140)	0.05 – 0.12	0.1 – 0.4		
		Light	LS-P	MS9025	80 (40 – 140)	0.04 – 0.15	0.3 – 2.2		
		Medium	R-SN	MS9025	80 (40 – 140)	0.01 – 0.10	0.1 – 3.8		

1/1

1. If chatter vibration occurs, adjust the cutting conditions and perform machining.
2. If the tool overhang amount is L/D = 5 or more for carbide shank or L/D = 3 or more for steel shank, please reduce the cutting speed by 10% to 20%.
3. Regarding the feed rate and depth of cut for breakers not listed in the table, please refer to the general catalogue C010J page A058 of for 7° positive and page A066 for 11° positive. For cutting speed, please refer to the grade introduction page A034.



CC TYPE INSERTS, 80° WITH HOLE




Order number	RE	Coated																			Coated Cermet	Cermet	Carbide				Shape													
		MS6015	MC6115	MC6125	MC6015*	MC6025*	UE6105*	UE6110*	UE6020*	MS7025	MC7015	MC7025	MP7035	US7020	US735	MC5105	MC5115	MC5125	MS9025	MP9005	MP9015	MP9025	VP10RT	VP15TF	VP30RT	UP20M		MP3025	AP25N	VP25N	VP45N	NX2525	NX3035	MT9005	RT9010	UT120T	HT105T	HT110	TF15	
CCMW060202	0.2																																						●	Flat Top
CCMW060204	0.4															●	●	★																		●	●			
CCMW060208	0.8														★	●	★																							
CCMW09T304	0.4														●	●	●																				●			
CCMW09T308	0.8														●	●	●																			●	●			
CCMW09T312	1.2														★	●	★																							
CCGW060200	0.0																																				★	Flat Top		
CCGW0602V5	0.05																																				●			
CCGW060201	0.1																																				★			
CCGW060202	0.2																																				★			
CCGW060204	0.4																																				★			
CCGW060208	0.8																																				★			
CCGW09T300	0.0																																				●	★		
CCGW09T3V5	0.05																																				●			
CCGW09T301	0.1																																				★			
CCGW09T302	0.2																																				★			
CCGW09T304	0.4																																				★			
CCGW060202E	0.2																																							
CCGW060204E	0.4																																							
CCGW060208E	0.8																																							

*1 To be replaced by new products.
 (10 inserts in one case)

● : Stable Cutting [1st recommendation] ● : General Cutting [1st recommendation] ✖ : Unstable Cutting [1st recommendation]
 ○ : Stable Cutting [2nd recommendation] Ⓞ : General Cutting [2nd recommendation] ✖ : Unstable Cutting [2nd recommendation]
 ● / ★ = Expansion
 ● : Inventory maintained. ★ : Inventory maintained in Japan.



CP TYPE INSERTS, 80° WITH HOLE






		Coated															Coated Cermet	Cermet	Carbide																										
		MS6015	MC6115	MC6125	MC6015*1	MC6025*1	UE6105*1	UE6110*1	UE6020*1	MS7025	MC7015	MC7025	MP7035	US7020	US735	MC5105	MC5115	MC5125	MS9025	MP9005	MP9015	MP9025	VP10RT	VP15TF	VP30RT	UP20M	MP3025	AP25N	VP25N	VP45N	NX2525	NX3035	MT9005	RT9010	UT120T	HT105T	HT110	TF15	Shape						
Order number	RE																																												
CPMH080202-LP	0.2		●																																						LP				
CPMH080204-LP	0.4		●																																										
CPMH090302-LP	0.2		●																																						Light cutting				
CPMH090304-LP	0.4		★																																						LM				
CPMH090308-LP	0.8		★																																						Light cutting				
CPMH080204-LM	0.4									●	●														●																LM				
CPMH080208-LM	0.8									●	●													●																		Light cutting			
CPMH090304-LM	0.4									●	●												●																			Light cutting			
CPMH090308-LM	0.8									●	●												●																			LS			
CPMH080204-LS	0.4																						●																			Light cutting			
CPMH080208-LS	0.8																						●																			SV			
CPMH090304-LS	0.4																						●																			Standard			
CPMH090308-LS	0.8																						●																			Light cutting			
CPMH080202-SV	0.2				●		●							●									●				★	★	●	★													SV		
CPMH080204-SV	0.4				●		●							●									●				★	★	●	★														Standard	
CPMH090302-SV	0.2				●		●							●									●				★	★	●	★														Light cutting	
CPMH090304-SV	0.4				●		●							●									●				★	★	●	★														Standard	
CPMH090308-SV	0.8				●		●							●									●				★	★	●	★														Medium cutting	
CPMH080204	0.4		★	●																																							Standard		
CPMH080208	0.8		★	●																																								Medium cutting	
CPMH090304	0.4		★	●																																									Standard
CPMH090308	0.8		★	●																																									Medium cutting
CPMX080204	0.4						★																			★																		Standard	
CPMX080208	0.8						★																			★																			Standard
CPMX090304	0.4						★																			★			★									★							Medium cutting
CPMX090308	0.8						★	★																		★				★									★						Medium cutting

*1 To be replaced by new products.
 (10 inserts in one case)

- : Stable Cutting [1st recommendation]
- : Stable Cutting [2nd recommendation]
- / ★ = Expansion
- : Inventory maintained. ★: Inventory maintained in Japan.
- : General Cutting [1st recommendation]
- : General Cutting [2nd recommendation]
- ✦: Unstable Cutting [1st recommendation]
- ✧: Unstable Cutting [2nd recommendation]

CP TYPE INSERTS, 80° WITH HOLE



		Coated																Coated Cermet	Cermet	Carbide																					
Order number	RE	MS6015	MC6115	MC6125	MC6015*	MC6025*	UE6105*	UE6110*	UE6020*	MS7025	MC7015	MC7025	MP7035	US7020	US735	MC5105	MC5115	MC5125	MS9025	MP9005	MP9015	MP9025	VP10RT	VP15TF	VP30RT	UP20M	MP3025	AP25N	VP25N	VP45N	NX2525	NX3035	MT9005	RT9010	UT120T	HT105T	HT110	TF15	Shape		
CPMH080204-MM	0.4									●	●														●															MM	
CPMH080208-MM	0.8									●	●														●																
CPMH090304-MM	0.4									●	●													●																	
CPMH090308-MM	0.8									●	●												●																		Medium cutting
CPMH080204-MK	0.4															●	●	●																						MK	
CPMH080208-MK	0.8															●	●	●																							
CPMH090304-MK	0.4															●	●	●																							Medium cutting
CPMH090308-MK	0.8															●	●	●																							Medium cutting
CPMH080204-MS	0.4																					●																		MS	
CPMH080208-MS	0.8																					●																			
CPMH090304-MS	0.4																					●																			Medium cutting
CPMH090308-MS	0.8																					●																			Medium cutting
CPMH080204-MV	0.4	●	●	●						●	●		★									●			★	●	●	●	★												MV
CPMH080208-MV	0.8	●	●	●						●	●		★									●			★	●	●	●	★												
CPMH090304-MV	0.4	●	●	●						●	●		★									●			★	●	●	●	★												Medium cutting
CPMH090308-MV	0.8	●	●	●						●	●		★									●			★	●	●	●	★												Medium cutting
CPMB080202	0.2																																					★		Flat Top	
CPMB080204	0.4																																					★			
CPMB080208	0.8																																					★			
CPMB090302	0.2																																					★			
CPMB090304	0.4																																					★			
CPMB090308	0.8																																					★			

*1 To be replaced by new products.
 (10 inserts in one case)

- : Stable Cutting [1st recommendation]
- : Stable Cutting [2nd recommendation]
- / ★ = Expansion
- : Inventory maintained. ★: Inventory maintained in Japan.
- : General Cutting [1st recommendation]
- : General Cutting [2nd recommendation]
- ✦: Unstable Cutting [1st recommendation]
- ✧: Unstable Cutting [2nd recommendation]

DC TYPE INSERTS, 55° WITH HOLE



	P Steel	M Stainless steel	K Cast iron	N Non-ferrous metal	S Heat resistant alloy, titanium alloy
●					
○					
✖					
⊕					

Order number	RE	Coated																	Coated Cermet			Cermet				Carbide					Shape									
		MS6015	MC6115	MC6125	MC6015*	MC6025*	UE6105*	UE6110*	UE6020*	MS7025	MC7015	MC7025	MP7035	US7020	US735	MC5105	MC5115	MC5125	MS9025	MP9005	MP9015	MP9025	VP10RT	VP15TF	VP30RT	UP20M	MP3025	AP25N	VP25N	VP45N		NX2525	NX3035	MT9005	RT9010	UT120T	HT105T	HT110	TF15	
DCGT070201M-SMG	0.1*	●																																				SMG		
DCGT070202M-SMG	0.2*	●																						●																
DCGT070204M-SMG	0.4*	●																					●																	
DCGT11T301M-SMG	0.1*	●																					●																	
DCGT11T302M-SMG	0.2*	●																					●																	Medium cutting
DCGT11T304M-SMG	0.4*	●																				●																		
DCGT0702V3R-SN	0.03																						●																R/L-SN	
DCGT070201R-SN	0.1																						●																	
DCGT070202R-SN	0.2																						●																	
DCGT070202L-SN	0.2																						●																	
DCGT11T3V3R-SN	0.03																						★																	
DCGT11T3V3L-SN	0.03																						★																	
DCGT11T301R-SN	0.1																						●																	
DCGT11T301L-SN	0.1																						●																	
DCGT11T302R-SN	0.2																						●																	
DCGT11T302L-SN	0.2																						●																	
DCGT11T304R-SN	0.4																						●																	
DCGT11T304L-SN	0.4																						●																	
DCGT070201MR-SN	0.1*	●							●													●																		
DCGT070201ML-SN	0.1*	●						★														★																		
DCGT070202MR-SN	0.2*	●						●														●																		
DCGT070202ML-SN	0.2*	●						★														★																		
DCGT070204MR-SN	0.4*	●						●														●																		
DCGT11T301MR-SN	0.1*	●						●														●																		
DCGT11T301ML-SN	0.1*	●						★														★																		
DCGT11T302MR-SN	0.2*	●						●														●																		
DCGT11T302ML-SN	0.2*	●						★														★																		
DCGT11T304MR-SN	0.4*	●						●														●																		
DCGT11T304ML-SN	0.4*	●						★														★																		

*1 To be replaced by new products.
*2 Indicates the maximum value of the corner R.
(10 inserts in one case)















- : Stable Cutting [1st recommendation]
- : Stable Cutting [2nd recommendation]
- ✖: General Cutting [1st recommendation]
- ⊕: General Cutting [2nd recommendation]
- ✖: Unstable Cutting [1st recommendation]
- ⊕: Unstable Cutting [2nd recommendation]

● / ★ = Expansion

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



VB TYPE INSERTS, 35° WITH HOLE








		Coated																Coated Cermet			Cermet			Carbide																							
Order number	RE	MS6015	MC6115	MC6125	MC6015*1	MC6025*1	UE6105*1	UE6110*1	UE6020*1	MS7025	MC7015	MC7025	MP7035	US7020	US735	MC5105	MC5115	MC5125	MS9025	MP9005	MP9015	MP9025	VP10RT	VP15TF	VP30RT	UP20M	MP3025	AP25N	VP25N	VP45N	NX2525	NX3035	MT9005	RT9010	UT120T	HT105T	HT110	TF15	Shape								
VBMT110302-LS	0.2																																										LS				
VBMT110304-LS	0.4																																														
VBMT110308-LS	0.8																																														
VBMT160404-LS	0.4																																														
VBMT160408-LS	0.8																																														
VBMT160412-LS	1.2																																											Light cutting			
VBMT110304-SV	0.4							●																																			SV				
VBMT110308-SV	0.8							★																																							
VBMT160404-SV	0.4							●																																							
VBMT160408-SV	0.8							●																																					Light cutting		
VBMT160404-MP	0.4	●	●	●	●	●																					●			★															MP		
VBMT160408-MP	0.8	●	●	●	●	●																					★			★																	
VBMT160404-MM	0.4										●	●																																	MM		
VBMT160408-MM	0.8										●	●																																			
VBMT160404-MK	0.4																★	●	★																											MK	
VBMT160408-MK	0.8																★	●	★																												
VBMT160402-MS	0.2																																													MS	
VBMT160404-MS	0.4																																														
VBMT160408-MS	0.8																																														
VBMT160412-MS	1.2																																													Medium cutting	
VBMT160404	0.4							●																																						Standard	
VBMT160408	0.8							●																																							
VBMT110304-MV	0.4	●		●		●						●	●															●	●	●	★	●	★														MV
VBMT110308-MV	0.8	●		●		●							★																★	●	★	●	★														
VBMT160404-MV	0.4	●		●		●						●	●																●	●	●	★	●	★													
VBMT160408-MV	0.8	★		●		●							●	●															●	●	★	●	★														Medium cutting

*1 To be replaced by new products.
(10 inserts in one case)

- : Stable Cutting [1st recommendation]
- : Stable Cutting [2nd recommendation]
- / ★ = Expansion
- : Inventory maintained. ★: Inventory maintained in Japan.
- : General Cutting [1st recommendation]
- : General Cutting [2nd recommendation]
- ✦: Unstable Cutting [1st recommendation]
- ✧: Unstable Cutting [2nd recommendation]

INSERTS FOR OTHER TYPES OF BORING BARS

POSITIVE WITH HOLE

		Coated																Coated Cermet			Cermet			Carbide																		
		MS6015	MC6115	MC6125	MC6015*1	MC6025*1	UE6105*1	UE6110*1	UE6020*1	MS7025	MC7015	MC7025	MP7035	US7020	US735	MC5105	MC5115	MC5125	MS9025	MP9005	MP9015	MP9025	VP10RT	VP15TF	VP30RT	UP20M	MP3025	AP25N	VP25N	VP45N	NX2525	NX3035	MT9005	RT9010	UT120T	HT105T	HT110	TF15	Shape			
Order number	RE																																									
CCMT120404-MM	0.4										●	●											●																		MM	
CCMT120408-MM	0.8									●	●	●											●																			
CCMT120412-MM	1.2									●	●	★										●																			Medium cutting	
TCGW080201	0.1																																					★		Flat Top		
TCGW080202	0.2																																					★				
TPMH160304-FV	0.4	★				★															●	★	●			★			★		★	★							FV			
TPMH160302-LM	0.2									●	●												●																	Finish cutting		
TPMH160304-LM	0.4									●	●												●																	LM		
TPMH160308-LM	0.8									●	●												●																			
TPMH160302-LS	0.2																					●																	Light cutting			
TPMH160304-LS	0.4																					●																	LS			
TPMH160308-LS	0.8																					●																				
VCMT160404-FM	0.4																						●	●															Light cutting			
VCMT160408-FM	0.8																						★	●															FM			
VCMT160404-FS	0.4																					●																	Finish cutting			
VCMT160408-FS	0.8																					●																	FS			
VCMT160404-FS	0.4																					●																				
VCMT160408-FS	0.8																					●																	Finish cutting			
VCMT160404-FS	0.4																					●																	FS-P			
VCMT160408-FS	0.8																					●																				
VCMT110301M-FS-P	0.1*2									●												●			●														Finish cutting			
VCMT110302M-FS-P	0.2*2									●												●			●																	

*1 To be replaced by new products.
 *2 Indicates the maximum value of the corner R.
 (10 inserts in one case)

●: Stable Cutting [1st recommendation] ●: General Cutting [1st recommendation] ✖: Unstable Cutting [1st recommendation]
 ○: Stable Cutting [2nd recommendation] ⊕: General Cutting [2nd recommendation] ⊖: Unstable Cutting [2nd recommendation]

● / ★ = Expansion

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

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