BORING BARS FOR SMALL PARTS MACHINING

COMPATIBLE WITH SWISS-TYPE AUTOMATIC LATHES

MITSUBISHI MATERIALS

BORING BARS FOR SMALL PARTS MACHINING

OVERALL LENGTH COMPATIBLE WITH SWISS-TYPE AUTOMATIC LATHES

SCREW-ON TYPE

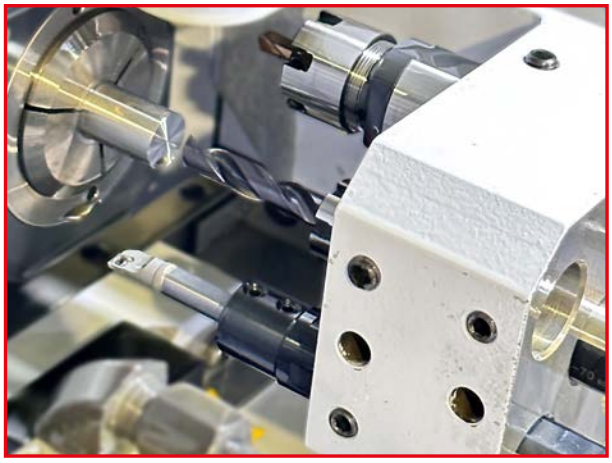
CARBIDE SHANK:
80 mm, 90 mm, 140 mm, 180 mm

HARD STEEL SHANK*:
70 mm, 80 mm, 90 mm
* The shank material has excellent resistance to damage caused by chip evacuation.

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.

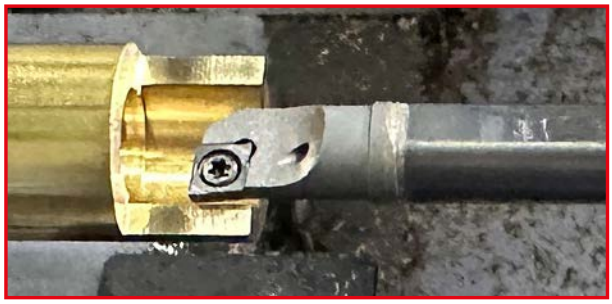
NO NEED TO SHORTEN THE SHANK
The length of the tools are compatible with Swiss-type automatic lathes, therefore no need to cut the shank to prevent interference.



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	
C	Carbide shank
H	Hard steel shank
S	Steel shank

4. Clamp structure	
S	Screw-on

5. Insert shape	
C	RHOMBIC 80°
D	RHOMBIC 55°
T	TRIANGULAR 60°
V	RHOMBIC 35°
W	TRIGON

6. Cutting angle KAPR	
U	93°
L	95°
Q	107.5°
P	117.5°
J	142°

7. Insert clearance	
B	5° POSITIVE
C	7° POSITIVE
P	11° POSITIVE

2. Min. machining Diameter **DMIN (mm)**

3. Shank diameter **DCONMS (mm)**

1	2		3	4	5	6	7	8	9		10		11
C	18	-	16	S	C	L	C	R	09	-	180	-	C

8. Hand of tool	
R	Right hand
L	Left hand

9. Cutting edge length symbol and inscribed circle						
Inscribed circle (mm)	3.97	4.76	5.56	6.35	7.94	9.525
RHOMBIC 80°	03	04	—	06	08	09
RHOMBIC 55°	—	—	—	07	—	11
TRIANGULAR 60°	06	08	09	11	—	16
RHOMBIC 35°	—	08	—	11	—	16
TRIGON	02	L3	—	04	—	06

10. Tool length (mm)	
070	70
080	80
090	90
140	140
150	150
180	180
200	200
250	250

11. Coolant hole	
C	With coolant hole

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	39
			Carbide	90, 140, 180	9 – 34	8 – 32		◎		◎	◎	6	
			Hard Steel	70,80,90	5 – 10	4 – 8		◎				7	
			Hard Steel	90	12	10		◎		◎		8	
			Steel	90, 150	14 – 34	12 – 32		◎		◎		9	
RHOMBIC 80° **Normal clearance 11°**	SCLP	95°	Carbide	140, 180	12 – 30	10 – 25		◎		◎	◎	10	47
			Hard Steel	90	12	10		◎		◎		11	
			Steel	90, 150	14 – 30	12 – 25		◎		◎		12	
TRIANGULAR 60° **Normal clearance 7°**	STUC	93°	Carbide	90	7 – 8	6 – 7	◎				◎	13	56
			Carbide	90, 140, 180	9 – 32	8 – 25	◎			◎	◎	14	
			Hard Steel	80	7 – 10	6 – 8	◎					15	
			Hard Steel	90	12	10	◎			◎		16	
			Steel	90, 150	14 – 40	12 – 32	◎			◎		17	
TRIANGULAR 60° **Normal clearance 11°**	STUP	93°	Carbide	90, 140, 180	10 – 34	8 – 25	◎			◎	◎	18	59
			Hard Steel	80	10	8	◎					19	
			Hard Steel	90	12	10	◎			◎		20	
			Steel	90, 150	14 – 34	12 – 25	◎			◎		21	
RHOMBIC 55° **Normal clearance 7°**	SDUC	93°	Carbide	140, 180	14 – 32	10 – 25			◎	◎	◎	22	50
			Hard Steel	90	14	10			◎	◎		23	
			Steel	150	16 – 32	12 – 25			◎	◎		24	
RHOMBIC 55° **Normal clearance 7°**	SDQC	107.5°	Carbide	140, 180	13 – 30	10 – 25			◎	◎	◎	25	50
				90	13	10			◎	◎		26	
			Steel	90, 150	16 – 30	12 – 25			◎	◎		27	
RHOMBIC 35° **Normal clearance 7°**	SVUC	93°	Carbide	140	16	12			◎	◎		28	65
			Steel	90	16	12			◎	◎		29	
	SVPC	117.5°	Carbide	140	16	10			◎	◎		30	
			Hard Steel	90	16	10			◎	◎		31	
	SVJC	142°	Steel	90, 150	16 – 20	12 – 16			◎	◎		33	
RHOMBIC 35° **Normal clearance 5°**	SVUB	93°	Carbide	180	20 – 34	16 – 25			◎	◎		28	62
			Steel	150, 200	20 – 40	16 – 32			◎	◎		29	
	SVPB	117.5°	Carbide	180	20 – 34	12 – 25			◎	◎		30	
			Steel	150, 200	20 – 40	12 – 32			◎	◎		32	
	SVJB	142°	Steel	150, 200, 250	25 – 50	20 – 40			◎	◎		33	
TRIGON **Normal clearance 7°**	SWUC	93°	Carbide	80, 90	6 – 8	5 – 7	◎	◎			◎	34	67
			Carbide	90, 140, 180	10 – 22	8 – 20	◎	◎		◎	◎	35	
			Hard Steel	70,80	6 – 10	5 – 8	◎	◎				36	
			Hard Steel	80	12	10	◎	◎		◎		37	
			Steel	90, 150	14 – 22	12 – 20	◎	◎		◎		38	

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.

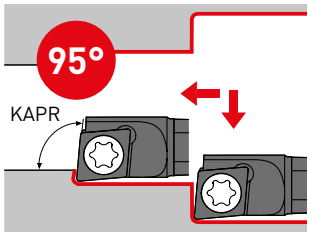
Insert type	Clamp screw
CPGT0802○○ (Ø7.94)	TS3
CPGT0903○○ (Ø9.525)	TS4

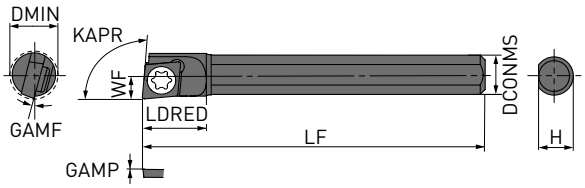
Insert type	Clamp screw
TPGX0802○○ (Ø4.76)	CS200T
TPGX/TPMX0902○○ (Ø5.56)	CS250T
TPGX/TPMX1103○○ (Ø9.525)	CS300890T

1. Shortening is necessary if the screw is too long.

C-SCLC

CARBIDE SHANK BORING BAR WITHOUT COOLANT HOLE





Right hand tool holder shown.

CC○○-Inserts

L-F

(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○○	03S1○○
C05-04SCLCL03-080	●	L	5	4	80	7	2.5	3.7	15°	0°		03S1○○
C06-05SCLCR03-080	●	R	6	5	80	9	3.0	4.7	13°	0°		03S1○○
C06-05SCLCL03-080	●	L	6	5	80	9	3.0	4.7	13°	0°		03S1○○
C07-06SCLCR04-090	●	R	7	6	90	9	3.5	5.7	13°	0°		04T0○○
C07-06SCLCL04-090	●	L	7	6	90	9	3.5	5.7	13°	0°		04T0○○
C08-07SCLCR04-090	●	R	8	7	90	10	4.0	6.7	11°	0°		04T0○○
C08-07SCLCL04-090	●	L	8	7	90	10	4.0	6.7	11°	0°		04T0○○

71 Vc

SPARE PARTS

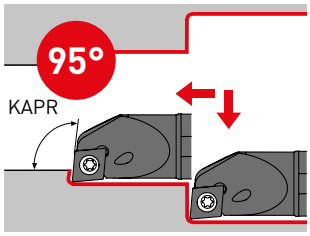
Boring bar type	Clamp screw *	Wrench
C○○-○○SCLCR/L03	TS16	TKY06F
C○○-○○SCLCR/L04	TS21	TKY06F

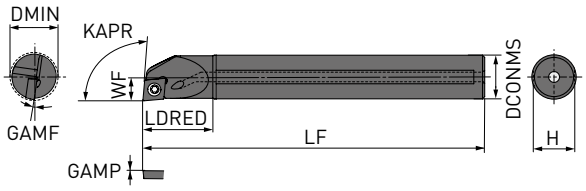
* Clamp torque (Nm): TS16 = 0.6, TS21 = 0.6

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

C-SCLC-C

CARBIDE SHANK BORING BAR WITH COOLANT HOLE





Right hand tool holder shown.

CC○○-Inserts

FS	FS-P	LS	LS-P
			
(06,09)	(06,09)	(06,09)	(06,09)

MP	MM	Flat Top	PCBN/PCD
			
(06,09)	(06,09)	(06,09)	(04,06,09)

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○○
C10-08SCLCR04-090-C	●	R	10	8	90	14	5.0	7	9°	0°		04T0○○
C10-08SCLCR06-140-C	●	R	10	8	140	14	5.0	7	9°	0°		0602○○
C10-08SCLCL06-140-C	●	L	10	8	140	14	5.0	7	9°	0°		0602○○
C12-10SCLCR06-140-C	●	R	12	10	140	18	6.0	9	12°	0°		0602○○
C12-10SCLCL06-140-C	●	L	12	10	140	18	6.0	9	12°	0°		0602○○
C14-12SCLCR06-140-C	●	R	14	12	140	23	7.0	11	10°	0°	CC○○	0602○○
C14-12SCLCL06-140-C	●	L	14	12	140	23	7.0	11	10°	0°		0602○○
C18-16SCLCR09-180-C	●	R	18	16	180	28	9.0	15	10°	0°		09T3○○
C18-16SCLCL09-180-C	●	L	18	16	180	28	9.0	15	10°	0°		09T3○○
C22-20SCLCR09-180-C	●	R	22	20	180	32	11.0	19	8°	0°		09T3○○
C27-25SCLCR09-180-C	★	R	27	25	180	38	13.5	24	6°	0°		09T3○○
C34-32SCLCR09-180-C	★	R	34	32	180	48	17.0	31	4°	0°		09T3○○

71 Vc

SPARE PARTS

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

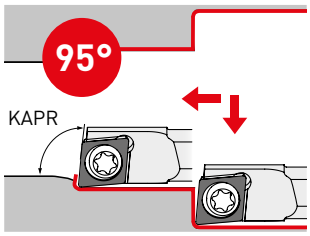
* Clamp torque (Nm): TS21 = 0.6, TS25 = 1.0, TS4 = 3.5

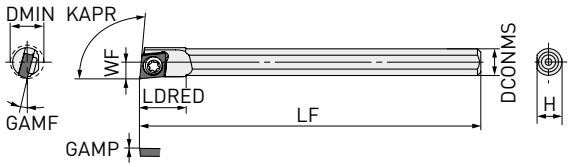
● : Inventory maintained. ★ : Inventory maintained in Japan.

NEW

H-SCLC

HARD STEEL SHANK WITHOUT COOLANT HOLE





Right hand tool holder shown.

CC○○-Inserts

F	F
FP	FS
	
(06)	(06)
F	PCBN/PCD
R/L-F	
	
(03,04)	(03,04)

Order number	Stock	Hand	DMIN	DCONMS	LF	LDRED	WF	H	GAMF	GAMP	Insert number	
H05-04SCLCR03-070	●	R	5	4	70	7	2.5	3.7	15°	0°		03S1○○
H05-04SCLCL03-070	●	L	5	4	70	7	2.5	3.7	15°	0°		03S1○○
H055-04SCLCR03-070	●	R	5.5	4	70	7	2.95	3.7	15°	0°		03S1○○
H06-05SCLCR03-070	●	R	6	5	70	9	3.0	4.7	13°	0°		03S1○○
H06-05SCLCL03-070	●	L	6	5	70	9	3.0	4.7	13°	0°		03S1○○
H07-06SCLCR04-080	●	R	7	6	80	10	3.5	5.7	13°	0°		04T0○○
H07-06SCLCL04-080	●	L	7	6	80	10	3.5	5.7	13°	0°	CC○○	04T0○○
H08-07SCLCR04-080	●	R	8	7	80	11	4.0	6.7	11°	0°		04T0○○
H08-07SCLCL04-080	●	L	8	7	80	11	4.0	6.7	11°	0°		04T0○○
H09-08SCLCR04-080	●	R	9	8	80	16	4.5	7.7	10°	0°		04T0○○
H10-08SCLCR04-080	●	R	10	8	80	16	5.0	7.7	9°	0°		04T0○○
H10-08SCLCR06-090	●	R	10	8	90	16	5.0	7.7	14°	0°		0602○○
H10-08SCLCL06-090	●	L	10	8	90	16	5.0	7.7	14°	0°		0602○○

71 Vc

SPARE PARTS

Boring bar type	Clamp screw *	Wrench
H○○-○○SCLCR/L03	TS16	TKY06F
H○○-○○SCLCR/L04	TS21	TKY06F
H○○-○○SCLCR/L06	TS25	TKY08F

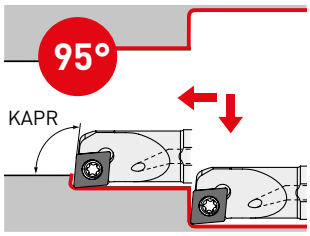
* Clamp torque (Nm): TS16 = 0.6, TS21 = 0.6, TS25 = 1.0

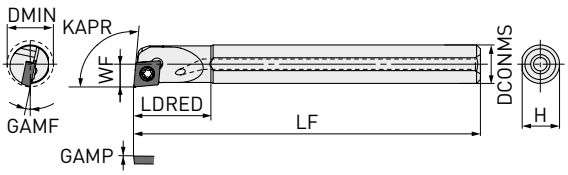
● : Inventory maintained. ★ : Inventory maintained in Japan.

NEW

H-SCLC-C

HARD STEEL SHANK WITH COOLANT HOLE





Right hand tool holder shown.

CC○○-Inserts

F	F
FP	FS
	
(06)	(06)
L	PCBN/PCD
R/L-F	
	
(06)	(06)

Order number	Stock	Hand	DMIN	DCONMS	LF	LDRED	WF	H	GAMF	GAMP	Insert number	
H12-10SCLCR06-090-C	●	R	12	10	90	20	6.0	9.7	12°	0°	CC○○	0602○○
H12-10SCLCL06-090-C	●	L	12	10	90	20	6.0	9.7	12°	0°		0602○○

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71 Vc

SPARE PARTS

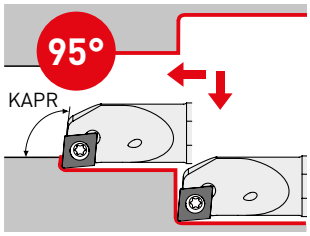
Boring bar type		
	Clamp screw *	Wrench
H○○-○○SCLCR/L06	TS25	TKY08F

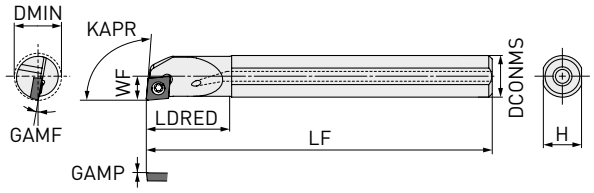
* Clamp torque (Nm): TS25 = 1.0

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

S-SCLC-C

STEEL SHANK BORING BAR WITH COOLANT HOLE





Right hand tool holder shown.

CC○○-Inserts

FS	FS-P	LS	LS-P
			
(06,09)	(06,09)	(06,09)	(06,09)

MP	MM	Flat Top	PCBN/PCD
			
(06,09)	(06,09)	(06,09)	(06,09)

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°	CC○○	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°		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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71 Vc

SPARE PARTS

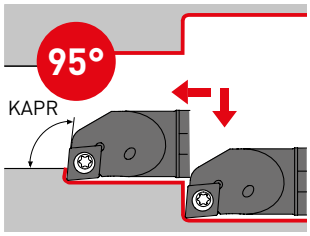
Boring bar type	Clamp screw *	Wrench
S14-12SCLCR/L06	TS25	TKY08F
S○○-○○SCLCR/L09	TS4	TKY15F

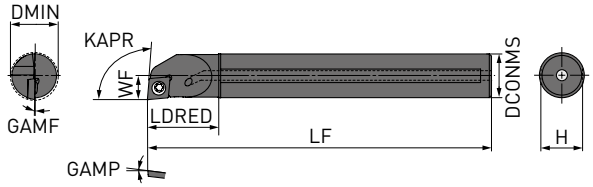
* Clamp torque (Nm): TS25 = 1.0, TS4 = 3.5

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

C-SCLP-C

CARBIDE SHANK BORING BAR WITH COOLANT HOLE





Right hand tool holder shown.

CP○○-Inserts

FV	FS	LM
		
(08,09)	(08,09)	(08,09)

MM	MS	PCBN/PCD
		
(08,09)	(08,09)	(08,09)

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○○	0802○○
C12-10SCLPL08-140-C	●	L	12	10	140	18	6.0	9	5°	5°		0802○○
C14-12SCLPR08-140-C	●	R	14	12	140	23	7.0	11	4°	5°		0802○○
C14-12SCLPL08-140-C	●	L	14	12	140	23	7.0	11	4°	5°		0802○○
C16-12SCLPR09-140-C	●	R	16	12	140	23	8.0	11	4°	5°		0903○○
C16-12SCLPL09-140-C	●	L	16	12	140	23	8.0	11	4°	5°		0903○○
C18-16SCLPR09-180-C	●	R	18	16	180	28	9.0	15	3.5°	5°		0903○○
C18-16SCLPL09-180-C	●	L	18	16	180	28	9.0	15	3.5°	5°		0903○○
C22-20SCLPR09-180-C	●	R	22	20	180	32	11.0	19	2°	5°		0903○○
C22-20SCLPL09-180-C	●	L	22	20	180	32	11.0	19	2°	5°		0903○○
C27-25SCLPR09-180-C	★	R	27	25	180	38	13.5	24	0°	5°		0903○○
C30-25SCLPR09-180-C	★	R	30	25	180	38	15.0	24	0°	5°		0903○○

71 Vc

SPARE PARTS

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

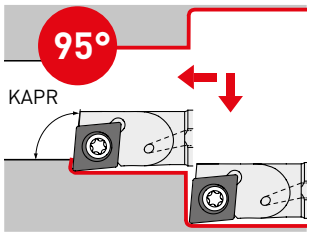
* Clamp torque (Nm): TS3D = 2.5, TS4D = 3.5
By changing the clamp screw, it is possible to use the inserts listed page 3 for details.

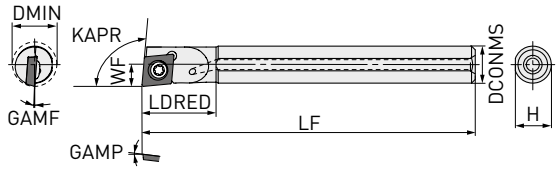
● : Inventory maintained. ★ : Inventory maintained in Japan.

NEW

H-SCLP-C

HARD STEEL SHANK WITH COOLANT HOLE





Right hand tool holder shown.

CP○○-Inserts

FP	FM	LP	LM
			
(08)	(08)	(08)	(08)
MP	MM	Flat Top	PCBN/PCD
			
(08)	(08)	(08)	(08)

Order number	Stock	Hand	DMIN	DCONMS	LF	LDRED	WF	H	GAMF	GAMP	Insert number	
H12-10SCLPR08-090-C	●	R	12	10	90	20	6.0	9.7	5°	5°	CP○○	0802○○
H12-10SCLPL08-090-C	●	L	12	10	90	20	6.0	9.7	5°	5°		0802○○

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71 Vc

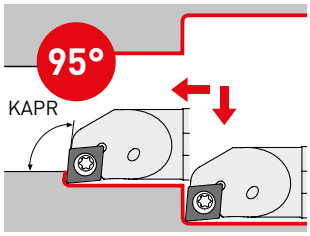
SPARE PARTS

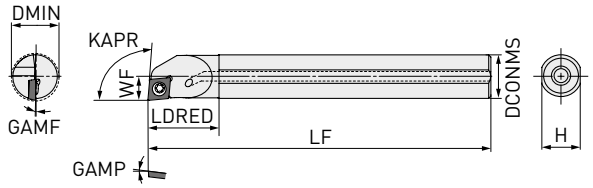
Boring bar type	Clamp screw *	Wrench
H12-10SCLPR/L08	TS3D	TKY10F

* Clamp torque (Nm): TS3D = 2.5

S-SCLP-C

STEEL SHANK BORING BAR WITH COOLANT HOLE





Right hand tool holder shown.

CP○○-Inserts

F	F	L
FV	FS	LM
		
(08,09)	(08,09)	(08,09)
M	M	PCBN/PCD
MM	MS	
		
(08,09)	(08,09)	(08,09)

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○○	0802○○
S14-12SCLPL08-090-C	●	L	14	12	90	24	7.0	11	4°	5°		0802○○
S16-12SCLPR09-090-C	★	R	16	12	90	24	8.0	11	4°	5°		0903○○
S16-12SCLPL09-090-C	★	L	16	12	90	24	8.0	11	4°	5°		0903○○
S18-16SCLPR09-150-C	★	R	18	16	150	30	9.0	15	3.5°	5°		0903○○
S18-16SCLPL09-150-C	★	L	18	16	150	30	9.0	15	3.5°	5°		0903○○
S22-20SCLPR09-150-C	★	R	22	20	150	36	11.0	19	2°	5°		0903○○
S22-20SCLPL09-150-C	★	L	22	20	150	36	11.0	19	2°	5°		0903○○
S27-25SCLPR09-150-C	★	R	27	25	150	46	13.5	24	0°	5°		0903○○
S27-25SCLPL09-150-C	★	L	27	25	150	46	13.5	24	0°	5°		0903○○
S30-25SCLPR09-150-C	●	R	30	25	150	46	15.0	24	0°	5°		0903○○
S30-25SCLPL09-150-C	★	L	30	25	150	46	15.0	24	0°	5°		0903○○

71 Vc

SPARE PARTS

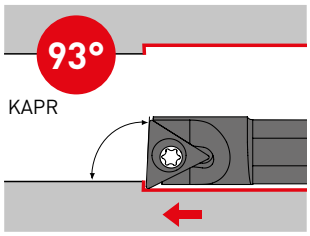
Boring bar type	Clamp screw *	Wrench
S14-12SCLPR/L08	TS3D	TKY10F
S○○-○○SCLPR/L09	TS4D	TKY15F

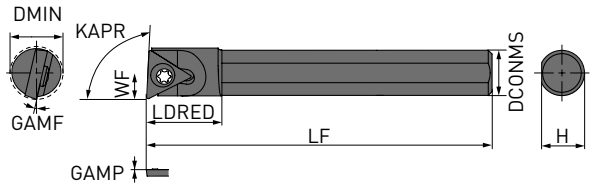
* Clamp torque (Nm): TS3D = 2.5, TS4D = 3.5
By changing the clamp screw, it is possible to use the inserts listed page 3 for details.

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

C-STUC

CARBIDE SHANK BORING BAR WITHOUT COOLANT HOLE





Right hand tool holder shown.

TC○○-Inserts

R/L-F

(06)

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○○	0601○○
C07-06STUCL06-090	●	L	7	6	90	10	3.5	5.7	13°	0°		0601○○
C08-07STUCR06-090	●	R	8	7	90	10	4.0	6.7	12°	0°		0601○○
C08-07STUCL06-090	●	L	8	7	90	10	4.0	6.7	12°	0°		0601○○

1/1

71 Vc

SPARE PARTS

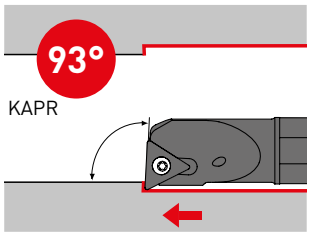
Boring bar type	Clamp screw *	Wrench
C○○-○○STUCR/L06	TS2C	TKY06F

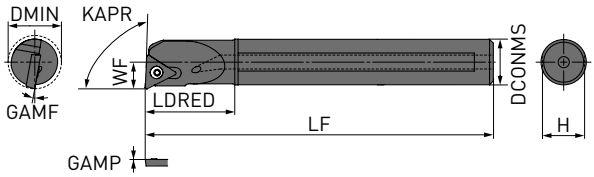
* Clamp torque (Nm): TS2C = 0.6

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

C-STUC-C

CARBIDE SHANK BORING BAR WITH COOLANT HOLE





Right hand tool holder shown.

TC○○-Inserts

FP	FM	LP	LM
			
(09,11,16)	(09,11,16)	(09,11,16)	(09,11,16)
MP	**MM**	Flat Top	PCBN/PCD
			
(09,11,16)	(09,11,16)	(11,16)	(06,09,11,16)

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○○

71 Vc

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

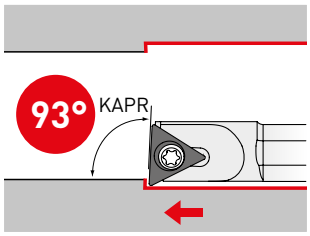
* Clamp torque (Nm): TS2C = 0.6, TS22 = 0.6, TS25 = 1.0, TS4 = 3.5

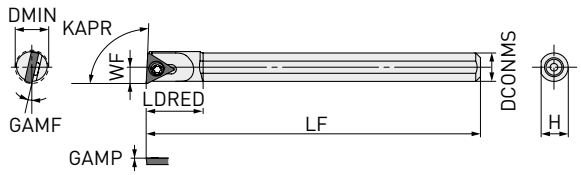
● : Inventory maintained. ★ : Inventory maintained in Japan.

NEW

H-STUC

HARD STEEL SHANK WITHOUT COOLANT HOLE





Right hand tool holder shown.

TC○○-Inserts

F	F
FP	R/L-F
	
(09)	(06)
L	M
LP	MK
	
(09)	(09)

Order number	Stock	Hand	DMIN	DCONMS	LF	LDRED	WF	H	GAMF	GAMP	Insert number	
H07-06STUCR06-080	●	R	7	6	80	12	3.5	5.7	13°	0°		0601○○
H07-06STUCL06-080	●	L	7	6	80	12	3.5	5.7	13°	0°		0601○○
H08-07STUCR06-080	●	R	8	7	80	12	4.0	6.7	12°	0°		0601○○
H08-07STUCL06-080	●	L	8	7	80	12	4.0	6.7	12°	0°	TC○○	0601○○
H09-08STUCR06-080	●	R	9	8	80	16	4.5	7.7	11°	0°		0601○○
H10-08STUCR09-080	●	R	10	8	80	16	5.0	7.7	14°	0°		0902○○
H10-08STUCL09-080	●	L	10	8	80	16	5.0	7.7	14°	0°		0902○○

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71 Vc

SPARE PARTS

Boring bar type	Clamp screw *	Wrench
H○○-○○STUCR/L06	TS2C	TKY06F
H○○-○○STUCR/L09	TS22	TKY06F

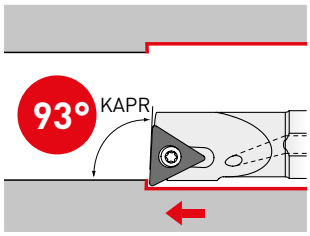
* Clamp torque (Nm): TS2C = 0.6, TS22 = 0.6

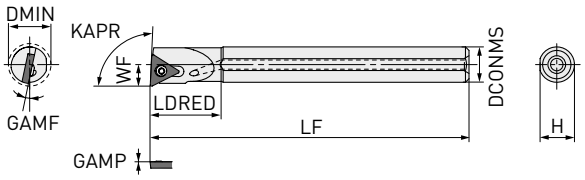
● : Inventory maintained. ★ : Inventory maintained in Japan.

NEW

H-STUC-C

HARD STEEL SHANK WITH COOLANT HOLE





Right hand tool holder shown.

TC○○-Inserts

F	F
FP	FM
	
(09)	(09)
L	M
LP	MK
	
(09)	(09)

Order number	Stock	Hand	DMIN	DCONMS	LF	LDRED	WF	H	GAMF	GAMP	Insert number	
H12-10STUCR09-090-C	●	R	12	10	90	20	6.2	9.7	12°	0°	TC○○	0902○○
H12-10STUCL09-090-C	●	L	12	10	90	20	6.2	9.7	12°	0°		0902○○

1/1

71 Vc

SPARE PARTS

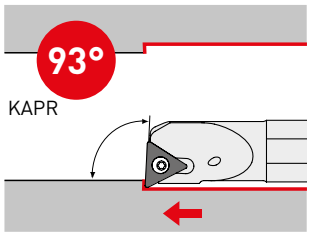
Boring bar type	Clamp screw *	Wrench
H○○-○○STUCR/L09	TS22	TKY06F

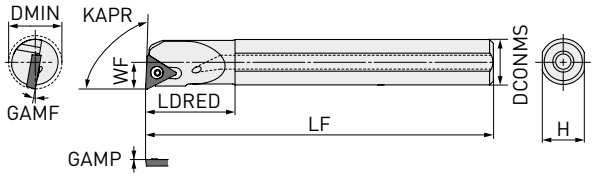
* Clamp torque (Nm): TS22 = 0.6

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

S-STUC-C

STEEL SHANK BORING BAR WITH COOLANT HOLE





Right hand tool holder shown.

TC○○-Inserts

FP	FM	LP	LM
			
(09,11,16)	(09,11,16)	(09,11,16)	(09,11,16)

MP	MM	Flat Top	PCBN/PCD
			
(09,11,16)	(09,11,16)	(11,16)	(09,11,16)

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°	TC○○	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°		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

71 Vc

SPARE PARTS

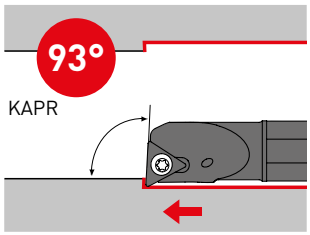
Boring bar type	Clamp screw *	Wrench
S14-12STUCR/L09	TS22	TKY06F
S○○-○○STUCR/L11	TS25	TKY08F
S○○-○○STUCR/L16	TS4	TKY15F

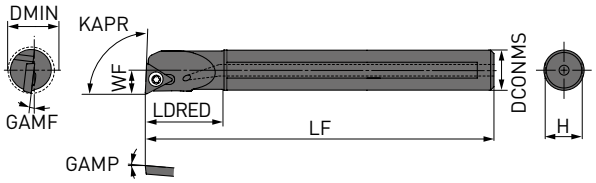
* Clamp torque (Nm): TS22 = 0.6, TS25 = 1.0, TS4 = 3.5

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

C-STUP-C

CARBIDE SHANK BORING BAR WITH COOLANT HOLE





Right hand tool holder shown.

TP○○-Inserts

FS	FV
	
(09,11)	(08,09,11)

PCBN/PCD

LP	
	
(08,09,11)	(09,11)

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°	TP○○	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°		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○○

71 Vc

SPARE PARTS

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

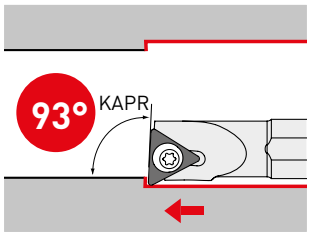
* Clamp torque (Nm): TS2D = 0.6, TS25D = 1.6, TS31D = 2.5
By changing the clamp screw, it is possible to use the inserts listed page 3 for details.

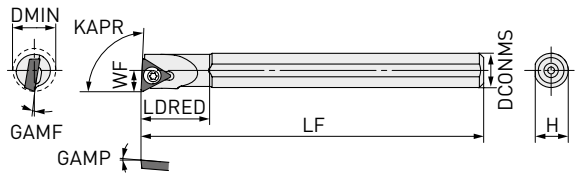
● : Inventory maintained. ★ : Inventory maintained in Japan.

NEW

H-STUP

HARD STEEL SHANK WITHOUT COOLANT HOLE





Right hand tool holder shown.

TP○○-Inserts

FS	FV
	
(08)	(08)
Flat Top	
LP	
	
(08)	(08)

Order number	Stock	Hand	DMIN	DCONMS	LF	LDRED	WF	H	GAMF	GAMP	Insert number	
H10-08STUPR08-080	●	R	10	8	80	16	5.0	7.7	10°	5°	TP○○	0802○○
H10-08STUPL08-080	●	L	10	8	80	16	5.0	7.7	10°	5°		0802○○

1/1

71 Vc

SPARE PARTS

Boring bar type	Clamp screw *	Wrench
H10-08STUPR/L08	TS2D	TKY06F

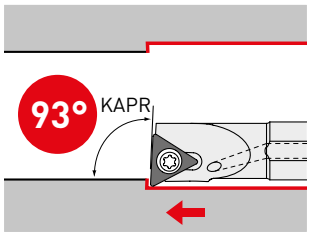
* Clamp torque (Nm): TS2D = 0.6

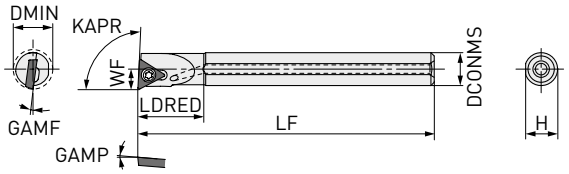
● : Inventory maintained. ★ : Inventory maintained in Japan.

NEW

H-STUP-C

HARD STEEL SHANK WITH COOLANT HOLE





Right hand tool holder shown.

TP○○-Inserts

FS	FV
	
(09)	(09)
Flat Top	
LP	
	
(09)	(09)

Order number	Stock	Hand	DMIN	DCONMS	LF	LDRED	WF	H	GAMF	GAMP	Insert number	
H12-10STUPR09-090-C	●	R	12	10	90	20	6.2	9.7	8°	5°	TP○○	0902○○
H12-10STUPL09-090-C	●	L	12	10	90	20	6.2	9.7	8°	5°		0902○○

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71 Vc

SPARE PARTS

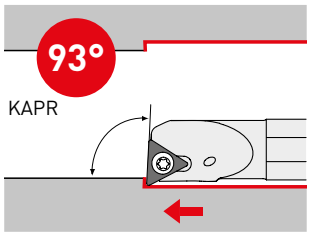
Boring bar type	Clamp screw *	Wrench
H12-10STUPR/L09	TS25D	TKY08F

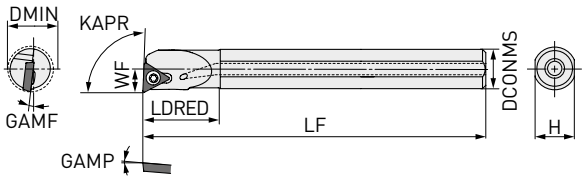
* Clamp torque (Nm): TS25D = 1.6

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

S-STUP-C

STEEL SHANK BORING BAR WITH COOLANT HOLE





Right hand tool holder shown.

TP○○-Inserts

FS	FV
	
(09,11)	(08,09,11)
PCBN/PCD	
LP	
	
(08,09,11)	(09,11)

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○○	0902○○
S14-12STUPL09-090-C	●	L	14	12	90	24	7.2	11	7°	5°		0902○○
S18-16STUPR11-150-C	●	R	18	16	150	30	9.2	15	3.5°	5°		1103○○
S18-16STUPL11-150-C	●	L	18	16	150	30	9.2	15	3.5°	5°		1103○○
S22-20STUPR11-150-C	★	R	22	20	150	36	11.2	19	2°	5°		1103○○
S22-20STUPL11-150-C	★	L	22	20	150	36	11.2	19	2°	5°		1103○○
S27-25STUPR11-150-C	★	R	27	25	150	46	13.7	24	0°	5°		1103○○
S27-25STUPL11-150-C	★	L	27	25	150	46	13.7	24	0°	5°		1103○○
S34-25STUPR11-150-C	★	R	34	25	150	46	17.2	24	0°	5°		1103○○
S34-25STUPL11-150-C	★	L	34	25	150	46	17.2	24	0°	5°		1103○○

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71 Vc

SPARE PARTS

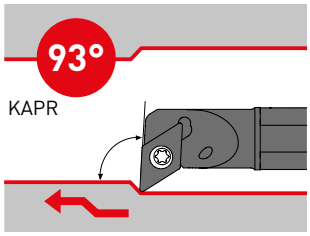
Boring bar type	Clamp screw *	Wrench
S14-12STUPR/L09	TS25D	TKY08F
S○○-○○STUPR/L11	TS31D	TKY10F

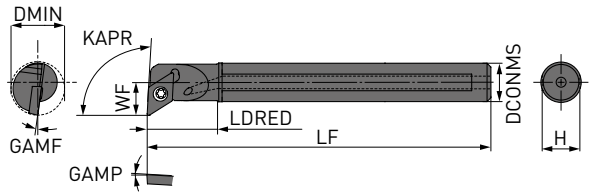
* Clamp torque (Nm): TS25D = 1.6, TS31D = 2.5
By changing the clamp screw, it is possible to use the inserts listed page 3 for details.

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

C-SDUC-C

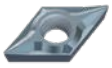
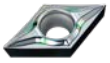
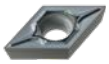
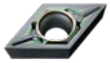
CARBIDE SHANK BORING BAR WITH COOLANT HOLE

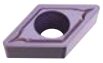
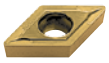
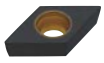




Right hand tool holder shown.

DC○○-Inserts

F	F	L	L
FS	FS-P	LS	LS-P
			
(07,11)	(07,11)	(07,11)	(07,11)

M	M	M	Flat Top
MP	MM	Standard	
			
(07,11)	(07,11)	(07,11)	(07,11)

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○○	0702○○
C14-10SDUCL07-140-C	●	L	14	10	140	18	8.7	9	7.5°	3°		0702○○
C16-12SDUCR07-180-C	●	R	16	12	180	23	9.7	11	6.5°	3°		0702○○
C16-12SDUCL07-180-C	●	L	16	12	180	23	9.7	11	6.5°	3°		0702○○
C20-16SDUCR07-180-C	●	R	20	16	180	28	11.7	15	5°	3°		0702○○
C20-16SDUCL07-180-C	●	L	20	16	180	28	11.7	15	5°	3°		0702○○
C23-16SDUCR07-180-C	●	R	23	16	180	28	14.5	15	5°	3°		0702○○
C23-16SDUCL07-180-C	●	L	23	16	180	28	14.5	15	5°	3°		0702○○
C27-20SDUCR11-180-C	●	R	27	20	180	32	16.5	19	5°	3°		11T3○○
C27-20SDUCL11-180-C	●	L	27	20	180	32	16.5	19	5°	3°		11T3○○
C32-25SDUCR11-180-C	●	R	32	25	180	38	19.0	24	5°	3°		11T3○○
C32-25SDUCL11-180-C	★	L	32	25	180	38	19.0	24	5°	3°		11T3○○

71 Vc

SPARE PARTS

Boring bar type	Clamp screw *	Wrench
C○○-○○SDUCR/L07	TS25	TKY08F
C○○-○○SDUCR/L11	TS4	TKY15F

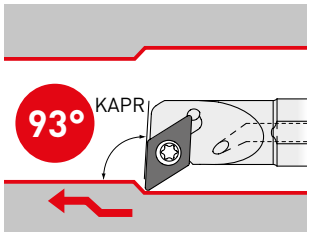
* Clamp torque (Nm): TS25 = 1.0, TS4 = 3.5

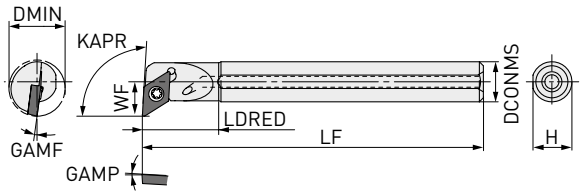
● : Inventory maintained. ★ : Inventory maintained in Japan.

NEW

H-SDUC-C

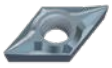
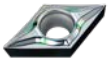
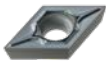
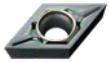
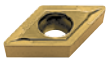
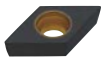
HARD STEEL SHANK WITH COOLANT HOLE





Right hand tool holder shown.

DC○○-Inserts

FS	FS-P	LS	LS-P
			
(07)	(07)	(07)	(07)
MP	MM	Standard	Flat Top
			
(07)	(07)	(07)	(07)

Order number	Stock	Hand	DMIN	DCONMS	LF	LDRED	WF	H	GAMF	GAMP	Insert number	
H14-10SDUCR07-090-C	●	R	14	10	90	19	8.7	9.7	7.5°	3°	DC○○	0702○○
H14-10SDUCL07-090-C	●	L	14	10	90	19	8.7	9.7	7.5°	3°		0702○○

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71 Vc

SPARE PARTS

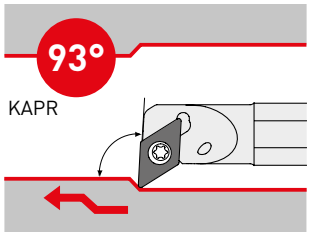
Boring bar type	Clamp screw *	Wrench
H14-10SDUCR/L07	TS25	TKY08F

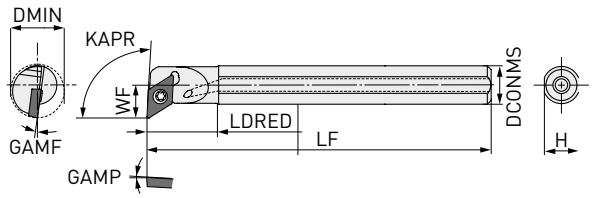
* Clamp torque (Nm): TS25 = 1.0

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

S-SDUC-C

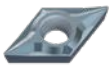
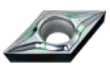
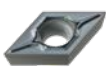
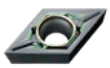
STEEL SHANK BORING BAR WITH COOLANT HOLE

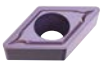
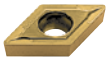
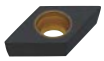




Right hand tool holder shown.

DC○○-Inserts

F	F	L	L
FS	FS-P	LS	LS-P
			
(07,11)	(07,11)	(07,11)	(07,11)

M	M	M	Flat Top
MP	MM	Standard	
			
(07,11)	(07,11)	(07,11)	(07,11)

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○○	0702○○
S16-12SDUCL07-150-C	●	L	16	12	150	21	9.7	11	6.5°	3°		0702○○
S20-16SDUCR07-150-C	●	R	20	16	150	21	11.7	15	5°	3°		0702○○
S20-16SDUCL07-150-C	●	L	20	16	150	21	11.7	15	5°	3°		0702○○
S23-16SDUCR07-150-C	●	R	23	16	150	21	14.5	15	5°	3°		0702○○
S23-16SDUCL07-150-C	●	L	23	16	150	21	14.5	15	5°	3°		0702○○
S27-20SDUCR11-150-C	●	R	27	20	150	23	16.5	19	5°	3°		11T3○○
S27-20SDUCL11-150-C	●	L	27	20	150	23	16.5	19	5°	3°		11T3○○
S32-25SDUCR11-150-C	●	R	32	25	150	24	19.0	24	5°	3°		11T3○○
S32-25SDUCL11-150-C	●	L	32	25	150	24	19.0	24	5°	3°		11T3○○

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71 Vc

SPARE PARTS

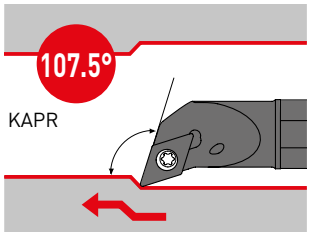
Boring bar type	Clamp screw *	Wrench
S○○-○○SDUCR/L07	TS25	TKY08F
S○○-○○SDUCR/L11	TS4	TKY15F

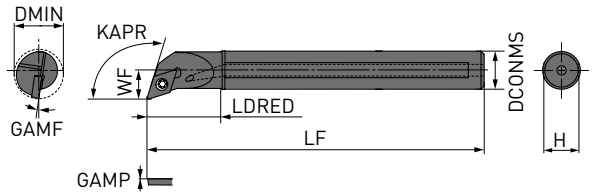
* Clamp torque (Nm): TS25 = 1.0, TS4 = 3.5

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

C-SDQC-C

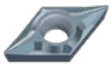
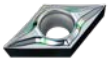
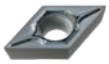
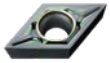
CARBIDE SHANK BORING BAR WITH COOLANT HOLE

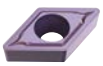
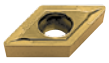
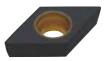




Right hand tool holder shown.

DC○○-Inserts

FS	FS-P	LS	LS-P
			
(07,11)	(07,11)	(07,11)	(07,11)

MP	MM	Standard	Flat Top
			
(07,11)	(07,11)	(07,11)	(07,11)

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○○	0702○○
C13-10SDQCL07-140-C	●	L	13	10	140	18	7.5	9	10°	0°		0702○○
C16-12SDQCR07-140-C	●	R	16	12	140	23	9.25	11	8°	0°		0702○○
C16-12SDQCL07-140-C	●	L	16	12	140	23	9.25	11	8°	0°		0702○○
C20-16SDQCR07-180-C	●	R	20	16	180	28	11.3	15	6°	0°		0702○○
C20-16SDQCL07-180-C	●	L	20	16	180	28	11.3	15	6°	0°		0702○○
C23-16SDQCR07-180-C	●	R	23	16	180	28	12.8	15	5°	0°		0702○○
C23-16SDQCL07-180-C	●	L	23	16	180	28	12.8	15	5°	0°		0702○○
C25-20SDQCR11-180-C	●	R	25	20	180	32	14.4	19	5°	0°		11T3○○
C25-20SDQCL11-180-C	●	L	25	20	180	32	14.4	19	5°	0°		11T3○○
C30-25SDQCR11-180-C	★	R	30	25	180	38	16.9	24	4°	0°		11T3○○
C30-25SDQCL11-180-C	★	L	30	25	180	38	16.9	24	4°	0°		11T3○○

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71 Vc

SPARE PARTS

Boring bar type	Clamp screw *	Wrench
C○○-○○SDQCR/L07	TS25	TKY08F
C○○-○○SDQCR/L11	TS4	TKY15F

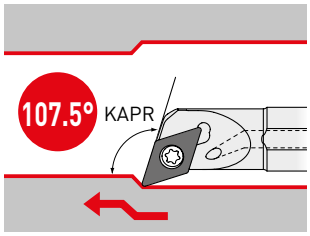
* Clamp torque (Nm): TS25 = 1.0, TS4 = 3.5

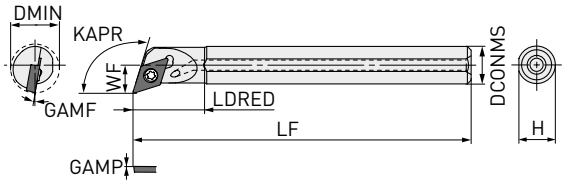
● : Inventory maintained. ★ : Inventory maintained in Japan.

NEW

H-SDQC-C

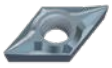
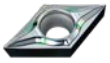
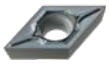
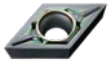
HARD STEEL SHANK WITH COOLANT HOLE

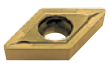
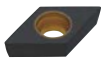




Right hand tool holder shown.

DC○○-Inserts

FS	FS-P	LS	LS-P
			
(07)	(07)	(07)	(07)

MP	MM	Standard	Flat Top
			
(07)	(07)	(07)	(07)

Order number	Stock	Hand	DMIN	DCONMS	LF	LDRED	WF	H	GAMF	GAMP	Insert number	
H13-10SDQCR07-090-C	●	R	13	10	90	19	7.5	9.7	10.0°	0°	DC○○	0702○○
H13-10SDQCL07-090-C	●	L	13	10	90	19	7.5	9.7	10.0°	0°		0702○○

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71 Vc

SPARE PARTS

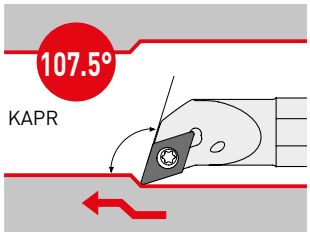
Boring bar type	Clamp screw *	Wrench
H13-10SDQCR/L07	TS25	TKY08F

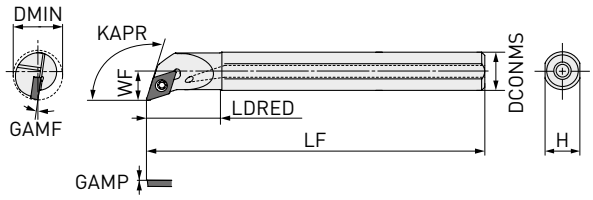
* Clamp torque (Nm): TS25 = 1.0

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

S-SDQC-C

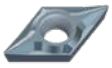
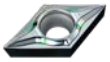
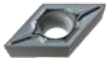
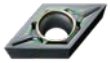
STEEL SHANK BORING BAR WITH COOLANT HOLE

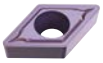
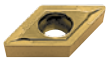
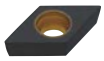




Right hand tool holder shown.

DC○○-Inserts

FS	FS-P	LS	LS-P
			
(07,11)	(07,11)	(07,11)	(07,11)

MP	MM	Standard	Flat Top
			
(07,11)	(07,11)	(07,11)	(07,11)

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○○	0702○○
S16-12SDQCL07-090-C	●	L	16	12	90	22	9.25	11	8°	0°		0702○○
S20-16SDQCR07-150-C	●	R	20	16	150	25	11.3	15	6°	0°		0702○○
S20-16SDQCL07-150-C	●	L	20	16	150	25	11.3	15	6°	0°		0702○○
S23-16SDQCR07-150-C	●	R	23	16	150	25	12.8	15	5°	0°		0702○○
S23-16SDQCL07-150-C	●	L	23	16	150	25	12.8	15	5°	0°		0702○○
S25-20SDQCR11-150-C	●	R	25	20	150	31	14.4	19	5°	0°		11T3○○
S25-20SDQCL11-150-C	●	L	25	20	150	31	14.4	19	5°	0°		11T3○○
S30-25SDQCR11-150-C	●	R	30	25	150	38	16.9	24	4°	0°		11T3○○
S30-25SDQCL11-150-C	●	L	30	25	150	38	16.9	24	4°	0°		11T3○○

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71 Vc

SPARE PARTS

Boring bar type	Clamp screw *	Wrench
S○○-○○SDQCR/L07	TS25	TKY08F
S○○-○○SDQCR/L11	TS4	TKY15F

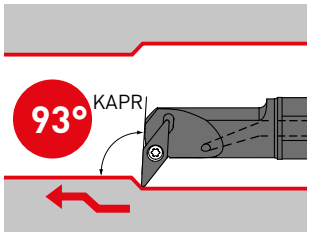
* Clamp torque (Nm): TS25 = 1.0, TS4 = 3.5

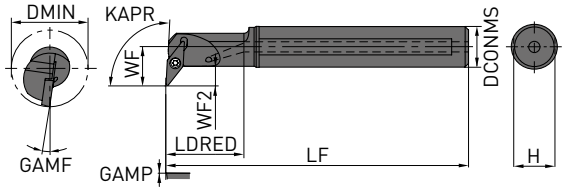
● : Inventory maintained. ★ : Inventory maintained in Japan.

NEW

C-SVUC/B-C

CARBIDE SHANK BORING BAR WITH COOLANT HOLE





Right hand tool holder shown.

VC/VB○○-Inserts

FP	FM	LP	LM
			
(11,16)	(08,11,16)	(08,11,16)	(08,11,16)

MP	MM	Standard	PCBN/PCD
			
(16)	(16)	(16)	(11,16)

Order number	Stock	Hand	DMIN	DCONMS	LF	LDRED	WF	WF2	H	GAMF	GAMP	Insert number	
C16-12SVUCR08-140-C	●	R	16	12	140	23	11.5	5.6	11	8°	0°	VC○○	0802○○
C20-16SVUBR11-180-C	●	R	20	16	180	28	16.0	8.1	15	8°	0°		1103○○
C20-16SVUBL11-180-C	●	L	20	16	180	28	16.0	8.1	15	8°	0°		1103○○
C25-20SVUBR11-180-C	●	R	25	20	180	32	18.0	8.1	19	7°	0°	VB○○	1103○○
C30-20SVUBR11-180-C	●	R	30	20	180	32	18.0	8.1	19	6°	0°		1103○○
C34-25SVUBR16-180-C	●	R	34	25	180	38	20.5	8.4	24	13°	0°		1604○○

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SPARE PARTS

Boring bar type	Clamp screw *	Wrench
C16-12SVUCR08	TS202	TKY06F
C○○-○○SVUBR/L11	TS255	TKY08F
C34-25SVUBR16	TS35D	TKY15F

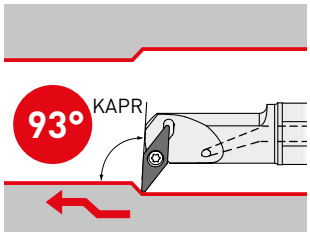
* Clamp torque (Nm): TS202 = 0.6, TS255 = 1.0, TS35D = 3.5

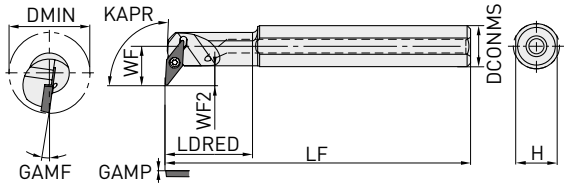
● : Inventory maintained. ★ : Inventory maintained in Japan.

NEW

S-SVUC/B-C

STEEL SHANK BORING BAR WITH COOLANT HOLE





Right hand tool holder shown.

VC/VB○○-Inserts

FP	FM	LP	LM
			
(11,16)	(08,11,16)	(08,11,16)	(08,11,16)

MP	MM	Standard	PCBN/PCD
			
(16)	(16)	(16)	(11,16)

Order number	Stock	Hand	DMIN	DCONMS	LF	LDRED	WF	WF2	H	GAMF	GAMP	Insert number	
S16-12SVUCR08-090-C	●	R	16	12	90	25.5	11.5	5.6	11	8°	0°	VC○○	0802○○
S20-16SVUBR11-150-C	●	R	20	16	150	32.5	16.0	8.1	15	8°	0°	VB○○	1103○○
S20-16SVUBL11-150-C	●	L	20	16	150	32.5	16.0	8.1	15	8°	0°		1103○○
S25-20SVUBR11-150-C	●	R	25	20	150	40.5	18.0	8.1	19	7°	0°		1103○○
S30-20SVUBR11-150-C	●	R	30	20	150	40.5	18.0	8.1	19	6°	0°		1103○○
S34-25SVUBR16-150-C	●	R	34	25	150	40.0	20.5	8.4	24	13°	0°		1604○○
S40-32SVUBR16-200-C	●	R	40	32	200	84.0	28.0	12.4	31	9°	0°		1604○○

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71 Vc

SPARE PARTS

Boring bar type	Clamp screw *	Wrench
S16-12SVUCR08	TS202	TKY06F
S○○-○○SVUBR/L11	TS255	TKY08F
S○○-○○SVUBR16	TS35D	TKY15F

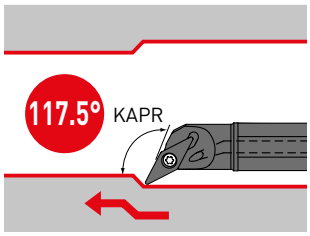
* Clamp torque (Nm): TS202 = 0.6, TS255 = 1.0, TS35D = 3.5

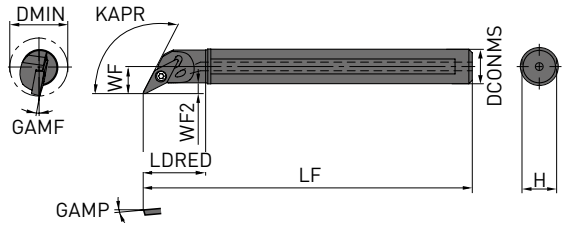
● : Inventory maintained. ★ : Inventory maintained in Japan.

NEW

C-SVPC/B-C

STEEL SHANK BORING BAR WITH COOLANT HOLE





Right hand tool holder shown.

VC/VB○○-Inserts

F	F	L	L
FP	FM	LP	LM
			
(11,16)	(08,11,16)	(08,11,16)	(08,11,16)

M	M	M	
MP	MM	Standard	PCBN/PCD
			
(16)	(16)	(16)	(11,16)

Order number	Stock	Hand	DMIN	DCONMS	LF	LDRED	WF	WF2	H	GAMF	GAMP	Insert number	
C16-10SVPCR08-140-C	●	R	16	10	140	18	8.0	3.1	9	8°	-5°	VC○○	0802○○
C16-10SVPCL08-140-C	●	L	16	10	140	18	8.0	3.1	9	8°	-5°		0802○○
C20-12SVPBR11-180-C	●	R	20	12	180	23	10.0	4.1	11	8°	-5°	VB○○	1103○○
C20-12SVPBL11-180-C	●	L	20	12	180	23	10.0	4.1	11	8°	-5°		1103○○
C25-16SVPBR11-180-C	●	R	25	16	180	28	12.5	4.6	15	6°	-5°		1103○○
C25-16SVPBL11-180-C	●	L	25	16	180	28	12.5	4.6	15	6°	-5°		1103○○
C30-20SVPBR11-180-C	●	R	30	20	180	32	15.0	5.1	19	5°	-5°		1103○○
C34-25SVPBR16-180-C	●	R	34	25	180	38	17.0	4.9	24	13°	-5°		1604○○

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71 Vc

SPARE PARTS

Boring bar type	Clamp screw *	Wrench
C16-10SVPCR/L08	TS202	TKY06F
C○○-○○SVPBR/L11	TS255	TKY08F
C34-25SVPBR16	TS35D	TKY15F

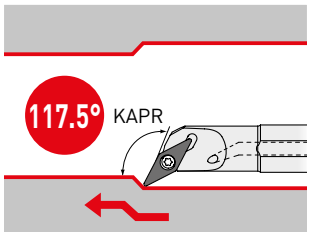
* Clamp torque (Nm): TS202 = 0.6, TS255 = 1.0, TS35D = 3.5

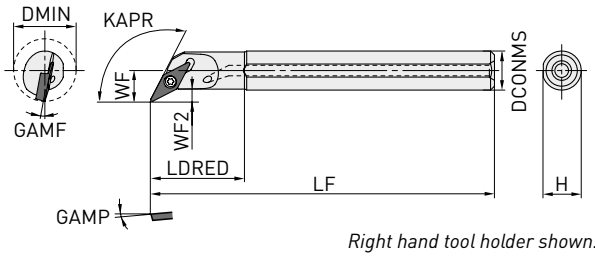
● : Inventory maintained. ★ : Inventory maintained in Japan.

NEW

H-SVPC-C

HARD STEEL SHANK WITH COOLANT HOLE





Right hand tool holder shown.

VC○○-Inserts

F	
FM	
	
(08)	
L	L
LP	LM
	
(08)	(08)

Order number	Stock	Hand	DMIN	DCONMS	LF	LDRED	WF	WF2	H	GAMF	GAMP	Insert number	
H16-10SVPCR08-090-C	●	R	16	10	90	24	8.0	3.1	9.7	8.0°	-5°	VC○○	0802○○

1/1

71 Vc

SPARE PARTS

Boring bar type		
	Clamp screw *	Wrench
H16-10SVPCR08	TS202	TKY06F

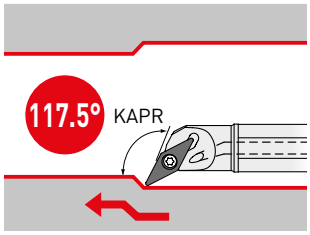
* Clamp torque (Nm): TS202 = 0.6

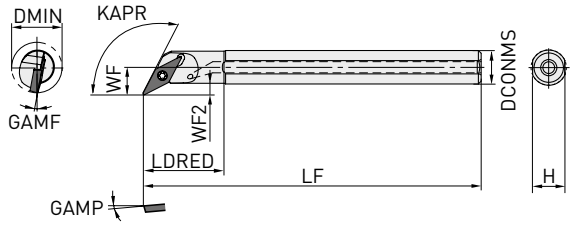
● : Inventory maintained. ★ : Inventory maintained in Japan.

NEW

S-SVPB-C

STEEL SHANK BORING BAR WITH COOLANT HOLE





Right hand tool holder shown.

VB○○-Inserts

F	F	L	L
FP	FM	LP	LM
			
(11,16)	(08,11,16)	(08,11,16)	(08,11,16)
M	**M**	**M**	PCBN/PCD
MP	MM	Standard	
			
(16)	(16)	(16)	(11,16)

Order number	Stock	Hand	DMIN	DCONMS	LF	LDRED	WF	WF2	H	GAMF	GAMP	Insert number	
S20-12SVPBR11-150-C	●	R	20	12	150	29	10.0	4.1	11	8°	-5°		1103○○
S20-12SVPBL11-150-C	●	L	20	12	150	29	10.0	4.1	11	8°	-5°		1103○○
S25-16SVPBR11-150-C	●	R	25	16	150	35	12.5	4.6	15	6°	-5°		1103○○
S25-16SVPBL11-150-C	●	L	25	16	150	35	12.5	4.6	15	6°	-5°	VB○○	1103○○
S30-20SVPBR11-150-C	●	R	30	20	150	41	15.0	5.1	19	5°	-5°		1103○○
S34-25SVPBR16-150-C	●	R	34	25	150	51	17.0	4.9	24	13°	-5°		1604○○
S40-32SVPBR16-200-C	●	R	40	32	200	54	22.0	6.4	31	9°	-5°		1604○○

1/1

71 Vc

SPARE PARTS

Boring bar type	Clamp screw *	Wrench
S○○-○○SVPBR/L11	TS255	TKY08F
S○○-○○SVPBR16	TS35D	TKY15F

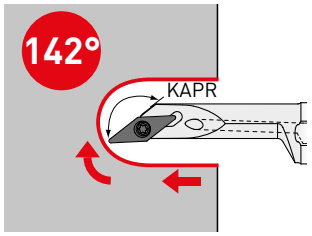
* Clamp torque (Nm): TS255 = 1.0, TS35D = 3.5

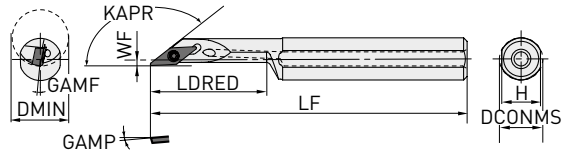
● : Inventory maintained. ★ : Inventory maintained in Japan.

NEW

S-SVJC/B-C

STEEL SHANK BORING BAR WITH COOLANT HOLE





Right hand tool holder shown.

VC/VB○○-Inserts

F	F	L	L
FP	FM	LP	LM
			
(11,16)	(08,11,16)	(08,11,16)	(08,11,16)

M	M	M	
MP	MM	Standard	PCBN/PCD
			
(16)	(16)	(16)	(11,16)

Order number	Stock	Hand	DMIN	DCONMS	LF	LDRED	WF	H	GAMF	GAMP	Insert number	
S16-12SVJCR08-090-C	●	R	16	12	90	33	2.0	11	6°	-5°	VC○○	0802○○
S20-16SVJCR08-150-C	●	R	20	16	150	43	2.0	15	5°	-5°		0802○○
S25-20SVJBR11-150-C	●	R	25	20	150	48	2.0	19	6°	-5°	VB○○	1103○○
S30-25SVJBR11-150-C	●	R	30	25	150	58	3.5	24	5°	-5°		1103○○
S40-32SVJBR16-200-C	●	R	40	32	200	74	3.5	31	8°	-5°		1604○○
S50-40SVJBR16-250-C	●	R	50	40	250	91	4.5	39	7°	-5°		1604○○

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SPARE PARTS

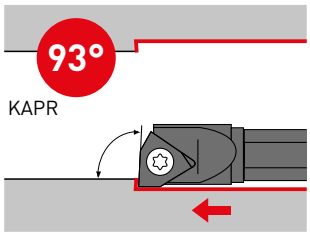
Boring bar type	Clamp screw *	Wrench
S○○-○○SVJCR08	TS202	TKY06F
S○○-○○SVJBR11	TS255	TKY08F
S○○-○○SVJBR16	TS35D	TKY15F

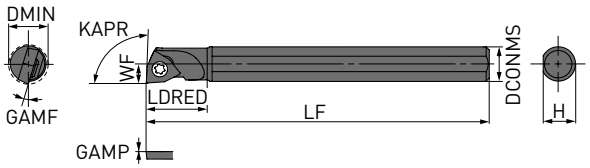
* Clamp torque (Nm): TS202 = 0.6, TS255 = 1.0, TS35D = 3.5

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

C-SWUC

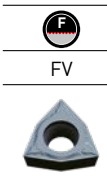
CARBIDE SHANK BORING BAR WITHOUT COOLANT HOLE





Right hand tool holder shown.

WC○○-Inserts



FV

(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○○	0201○○
C06-05SWUCL02-080	●	L	6	5	80	9	3.0	4.7	17°	0°		0201○○
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°		L302○○

1/1

71 Vc

SPARE PARTS

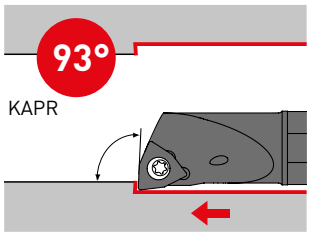
Boring bar type	Clamp screw *	Wrench
C06-05SWUCR/L02	TS21	TKY06F
C08-07SWUCR/LL3	TS2	TKY06F

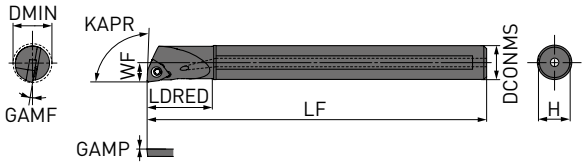
* Clamp torque (Nm): TS21 = 0.6, TS2 = 0.6

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

C-SWUC-C

CARBIDE SHANK BORING BAR WITH COOLANT HOLE





Right hand tool holder shown.

WC○○-Inserts

F

FV

(04,06)

M

MP

(04,06)

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°	WC○○	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°		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○○

71 Vc

SPARE PARTS

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

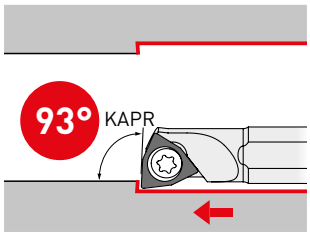
* Clamp torque (Nm): TS25 = 1.0, TS4 = 3.5

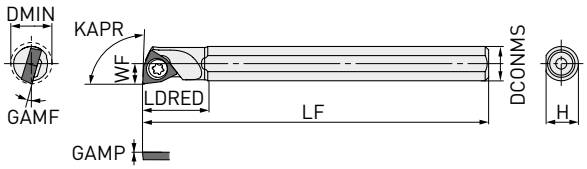
● : Inventory maintained. ★ : Inventory maintained in Japan.

NEW

H-SWUC

HARD STEEL SHANK WITHOUT COOLANT HOLE





Right hand tool holder shown.

WC○○-Inserts

F	M
FV	MP
	
(02,L3,04)	(02,L3,04)
M	PCBN/PCD
Standard	
	
(02,L3,04)	(L3)

Order number	Stock	Hand	DMIN	DCONMS	LF	LDRED	WF	H	GAMF	GAMP	Insert number	
H06-05SWUCR02-070	●	R	6	5	70	9	3.0	4.7	17°	0°	WC○○	0201○○
H06-05SWUCL02-070	●	L	6	5	70	9	3.0	4.7	17°	0°		0201○○
H08-07SWUCRL3-080	●	R	8	7	80	11	4.0	6.7	15°	0°		L302○○
H08-07SWUCLL3-080	●	L	8	7	80	11	4.0	6.7	15°	0°		L302○○
H10-08SWUCR04-080	●	R	10	8	80	16	5.0	7.7	15°	0°		0402○○
H10-08SWUCL04-080	●	L	10	8	80	16	5.0	7.7	15°	0°		0402○○

1/1

71 Vc

SPARE PARTS

Boring bar type	Clamp screw *	Wrench
H06-05SWUCR/L02	TS21	TKY06F
H08-07SWUCR/LL3	TS2	TKY06F
H10-08SWUCR/L04	TS25	TKY08F

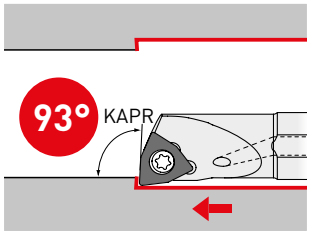
* Clamp torque (Nm): TS21 = 0.6, TS2 = 0.6, TS25 = 1.0

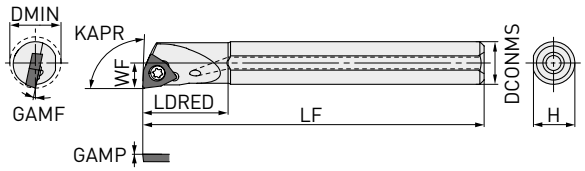
● : Inventory maintained. ★ : Inventory maintained in Japan.

NEW

H-SWUC-C

HARD STEEL SHANK WITH COOLANT HOLE





Right hand tool holder shown.

WC○○-Inserts

F	
FV	
	
(04)	
M	M
MP	Standard
	
(04)	(04)

Order number	Stock	Hand	DMIN	DCONMS	LF	LDRED	WF	H	GAMF	GAMP	Insert number	
H12-10SWUCR04-080-C	●	R	12	10	80	20	6.0	9.7	12°	0°	WC○○	0402○○
H12-10SWUCL04-080-C	●	L	12	10	80	20	6.0	9.7	12°	0°		0402○○

1/1

71 Vc

SPARE PARTS

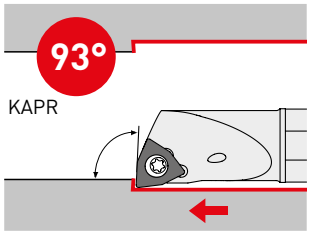
Boring bar type		
	Clamp screw *	Wrench
H12-10SWUCR/L04	TS25	TKY08F

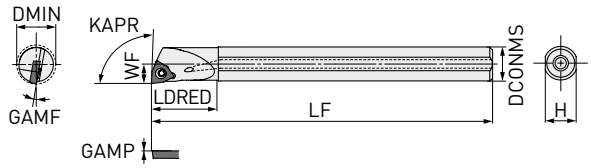
* Clamp torque (Nm): TS25 = 1.0

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

S-SWUC-C

STEEL SHANK BORING BAR WITH COOLANT HOLE





Right hand tool holder shown.

WC○○-Inserts

F

FV

(04,06)

M

MP

(04,06)

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○○	0402○○
S14-12SWUCL04-090-C	●	L	14	12	90	24	7.0	11	10°	0°		0402○○
S16-12SWUCR06-090-C	●	R	16	12	90	24	8.0	11	12°	0°		06T3○○
S16-12SWUCL06-090-C	●	L	16	12	90	24	8.0	11	12°	0°		06T3○○
S18-16SWUCR06-090-C	●	R	18	16	90	30	9.0	15	10°	0°		06T3○○
S18-16SWUCL06-090-C	●	L	18	16	90	30	9.0	15	10°	0°		06T3○○
S22-20SWUCR06-150-C	●	R	22	20	150	36	11.0	19	7°	0°		06T3○○
S22-20SWUCL06-150-C	●	L	22	20	150	36	11.0	19	7°	0°		06T3○○

71 Vc

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

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

CC TYPE INSERTS

80° WITH HOLE

		Coated																						Coated Cermet				Cermet		Carbide					
		MS6015	MC6115	MC6125	MC6135	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	UTi20T	HT105T	HTi10	TF15
P	Steel	◐	●	◐	✣	◶	❁	○	◶	❁														❁	✣	❁	◐	○	○	◶	○	◶			❁			○
M	Stainless steel										◐	●	◐	✣	○	✣				◐			◶	❁	✣	❁		○	○		○				❁			
K	Cast iron																◐	◐	✣				◶	❁				○	○		○				❁	○	◶	○
N	Non-ferrous metal																																				◶	○
S	Heat resistant alloy, Titanium alloy																			◐	●	◐	✣	◶	❁								●	◐			◶	

Order number	RE																																					Shape
CCMT060202-FP	0.2		●	●	★	●	●																				●											FP
CCMT060204-FP	0.4		●	●	★	●	●																				●											
CCMT09T302-FP	0.2		●	●	★	●	●																				●											
CCMT09T304-FP	0.4		●	●	★	●	●																				●											
CCMT09T308-FP	0.8		●	●	★	●	●																				●											Finish cutting
CCMT060202-FM	0.2																							●														FM
CCMT060204-FM	0.4																							●														
CCMT09T302-FM	0.2																							●														
CCMT09T304-FM	0.4																							●														
CCMT09T308-FM	0.8																							●														Finish cutting
CCMT060202-FS	0.2																						●															FS
CCMT060204-FS	0.4																						●														
CCMT09T302-FS	0.2																						●														
CCMT09T304-FS	0.4																						●														
CCMT09T308-FS	0.8																						●														Finish cutting
CCGT060201M-FS	0.1*2																			●	●	●			●													FS
CCGT060202M-FS	0.2*2																			●	●	●			●													
CCGT060204M-FS	0.4*2																						●		●													
CCGT09T301M-FS	0.1*2																			●	●	●			●													
CCGT09T302M-FS	0.2*2																			●	●	●			●													
CCGT09T304M-FS	0.4*2																			●	●	●			●													Finish cutting
CCGT060201M-FS-P	0.1*2										●									●					●									●					FS-P
CCGT060202M-FS-P	0.2*2										●									●					●									●					
CCGT060204M-FS-P	0.4*2										●									●					●													
CCGT09T301M-FS-P	0.1*2										●									●					●									●					
CCGT09T302M-FS-P	0.2*2										●									●					●									●					
CCGT09T304M-FS-P	0.4*2										●									●					●									●					Finish cutting
CCMT060202-FV	0.2			●	★																			●														FV
CCMT060204-FV	0.4			●	★																			●														
CCMT09T302-FV	0.2			●	★																																	
CCMT09T304-FV	0.4			●	★																																	
CCMT09T308-FV	0.8			●	★																																	Finish cutting
CCGT0602V5-FJ	0.05																						●															FJ
CCGT060201-FJ	0.1																						●															
CCGT060202-FJ	0.2																						●															
CCGT09T3V5-FJ	0.05																						●															
CCGT09T301-FJ	0.1																						●											●					
CCGT09T302-FJ	0.2																						●											●					
CCGT09T304-FJ	0.4																						●											●					Finish cutting

*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.

CC TYPE INSERTS, 80° WITH HOLE

		Coated																						Coated Cermet				Cermet		Carbide					
		MS6015	MC6115	MC6125	MC6135	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	HTI05T	HTI10	TF15
P	Steel	◔	●	◔	✣	◶	❁	○	◶	❁										◔				❁	✣	❁	◔	○	○	◶	○	◶			❁			○
M	Stainless steel										◔	●	◔	✣	○	✣				◔				◶	❁	✣	❁		○	○		○			❁			
K	Cast iron																◔	◔	✣					◶	❁				○	○		○				❁	○	◶	○
N	Non-ferrous metal																															◶	○				◶	○
S	Heat resistant alloy, Titanium alloy																			◔	●	◔	✣	◶	❁									●	◔			◶	

Order number	RE																																					Shape
CCGT060202-AZ	0.2																																				●	AZ
CCGT060204-AZ	0.4																																				●	
CCGT09T302-AZ	0.2																																				●	
CCGT09T304-AZ	0.4																																				●	Medium cutting ~ Finish cutting
CCGT09T308-AZ	0.8																																				●	
*3 CCGT03S1V3L-F	0.03																							●														R/L-F
*3 CCGT03S101L-F	0.1																							●														
*3 CCGT03S102L-F	0.2																							●				●										
*3 CCGT03S104L-F	0.4																							●				★										
*3 CCGT04T0V3L-F	0.03																							●														
*3 CCGT04T001L-F	0.1																							●														
*3 CCGT04T002L-F	0.2																							●				●										
*3 CCGT04T004L-F	0.4																							●				●										
*3 CCGT03S101MR-F	0.1*2	●																																				
*3 CCGT03S101ML-F	0.1*2	●																																				
*3 CCGT03S102MR-F	0.2*2	●																																				
*3 CCGT03S102ML-F	0.2*2	●																																				
*3 CCGT03S104MR-F	0.4*2	●																																				
*3 CCGT03S104ML-F	0.4*2	●																																				
*3 CCGT04T001MR-F	0.1*2	●																																				
*3 CCGT04T001ML-F	0.1*2	●																																				
*3 CCGT04T002MR-F	0.2*2	●																																				
*3 CCGT04T002ML-F	0.2*2	●																																				
*3 CCGT04T004MR-F	0.4*2	●																																				
*3 CCGT04T004ML-F	0.4*2	●																																				Finish cutting
CCGH060202R-F	0.2																							●													★	R/L-F
CCGH060202L-F	0.2																							●													★	
CCGH060204R-F	0.4																							●													★	
CCGH060204L-F	0.4																							●													★	
CCGH060202MR-F	0.2*2	●																																				
CCGH060202ML-F	0.2*2	●																																				
CCGH060204MR-F	0.4*2	●																																				
CCGH060204ML-F	0.4*2	●																																				Finish cutting
CCMT060202-LP	0.2		●	●	★																																	LP
CCMT060204-LP	0.4		●	●	★	●	●																					●										
CCMT09T302-LP	0.2		●	●	●																																	
CCMT060208-LP	0.8		●	●	★	●	●																					★										
CCMT09T304-LP	0.4		●	●	★	●	●																					●										
CCMT09T308-LP	0.8		●	●	★	●	●																					★										Light cutting

2/8

*1 To be replaced by new products.
*2 Indicates the maximum value of the corner R.
*3 Diameter of inscribed circle is special.

●: 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.

CC TYPE INSERTS, 80° WITH HOLE

		Coated																						Coated Cermet				Cermet		Carbide					
Order number	RE	MS6015	MC6115	MC6125	MC6135	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	HTi10	TF15	Shape
P Steel																																							
M Stainless steel																																							
K Cast iron																																							
N Non-ferrous metal																																							
S Heat resistant alloy, Titanium alloy																																							
CCMT060202-LM	0.2										●	●																											LM
CCMT060204-LM	0.4										●	●	●												●														
CCMT060208-LM	0.8											●	★												●														
CCMT09T302-LM	0.2										●	●																											
CCMT09T304-LM	0.4										●	●	●												●														
CCMT09T308-LM	0.8										●	●	●												●														Light cutting
CCMT060202-LS	0.2																			●	●	●												●					LS
CCMT060204-LS	0.4																			●	●	●												●					
CCMT09T302-LS	0.2																			●	●	●												●					
CCMT09T304-LS	0.4																			●	●	●												●					
CCMT09T308-LS	0.8																			●	●	●												●					Light cutting
CCGT060201M-LS	0.1*2																			●	●	●			●														LS
CCGT060202M-LS	0.2*2																			●	●	●			●														
CCGT060204M-LS	0.4*2																						●		●														
CCGT09T301M-LS	0.1*2																			●	●	●			●														
CCGT09T302M-LS	0.2*2																			●	●	●			●														
CCGT09T304M-LS	0.4*2																			●	●	●			●														Light cutting
CCGT0602V5M-LS-P	0.05*2																			●																			LS-P
CCGT060201M-LS-P	0.1*2	●									●									●														●					
CCGT060202M-LS-P	0.2*2	●									●									●														●					
CCGT060204M-LS-P	0.4*2										●									●																			
CCGT09T301M-LS-P	0.1*2	●									●									●														●					
CCGT09T302M-LS-P	0.2*2	●									●									●														●					
CCGT09T304M-LS-P	0.4*2	●									●									●														●					Light cutting
CCET060201MR-SRF	0.1																			●																			R/L-SRF
CCET060201ML-SRF	0.1																			●																			
CCET060202MR-SRF	0.2																			●																			
CCET060202ML-SRF	0.2																			●																			
CCET060204MR-SRF	0.4																			●																			
CCET060204ML-SRF	0.4																			●																			
CCET09T301MR-SRF	0.1																			●																			
CCET09T301ML-SRF	0.1																			●																			
CCET09T302MR-SRF	0.2																			●																			
CCET09T302ML-SRF	0.2																			●																			
CCET09T304MR-SRF	0.4																			●																			
CCET09T304ML-SRF	0.4																			●																			Light cutting
CCMH060202-SV	0.2						●							★	●										●			★											SV
CCMH060204-SV	0.4						●							★	●										●			●											
																																							Light cutting

3/8

*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.

CC TYPE INSERTS, 80° WITH HOLE

		Coated																						Coated Cermet				Cermet		Carbide						
		MS6015	MC6115	MC6125	MC6135	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	UTI20T	HTI05T	HTI10	TF15
P	Steel	◔	●	◔	✣	◶	❁	○	◶	❁													❁	✣	❁		◔	○	○	◶	○	◶			❁			○
M	Stainless steel										◔	●	◔	✣	○	✣				◔			◶	❁	✣	❁		○	○		○				❁			
K	Cast iron																◔	◔	✣				◶	❁				○	○		○							
N	Non-ferrous metal																																			◶	○
S	Heat resistant alloy, Titanium alloy																			◔	●	◔	✣	◶	❁								●	◔			◶	

Order number	RE																																					Shape
CCMT060202-SW	0.2		●	●	★	●	●								★								●				●											SW*
CCMT060204-SW	0.4		●	●	★	●	●								★		●						●				●											
CCMT060208-SW	0.8		●	●	●																		●															
CCMT09T302-SW	0.2		●	●	★	●	●								★		●						●				●											
CCMT09T304-SW	0.4		●	●	★	●	●								●		●						●				●											Light cutting (Wiper)
CCMT09T308-SW	0.8		●	●	●																		●															
CCGT0602V3R-SS	0.03																							★														R/L-SS
CCGT0602V3L-SS	0.03																							★														
CCGT060201R-SS	0.1																							★														
CCGT060201L-SS	0.1																							★														
CCGT060202R-SS	0.2																							★														
CCGT060202L-SS	0.2																							●														
CCGT09T3V3R-SS	0.03																							★														
CCGT09T3V3L-SS	0.03																							★														
CCGT09T301R-SS	0.1																							●														
CCGT09T301L-SS	0.1																							★														
CCGT09T302R-SS	0.2																							●														
CCGT09T302L-SS	0.2																							●														
CCGT060201MR-SS	0.1*2	●																																				
CCGT060201ML-SS	0.1*2	●																																				
CCGT060202MR-SS	0.2*2	●																																				
CCGT060202ML-SS	0.2*2	●																																				
CCGT09T301MR-SS	0.1*2	●																																				
CCGT09T301ML-SS	0.1*2	●																																				
CCGT09T302MR-SS	0.2*2	●																																				
CCGT09T302ML-SS	0.2*2	●																																				
CCGT09T304MR-SS	0.4*2	●																																				
CCGT09T304ML-SS	0.4*2	●																																				Light cutting
CCMT060202-MP	0.2		●	●	★																																	MP
CCMT060204-MP	0.4		●	●	★	●	●																				●											
CCMT060208-MP	0.8		●	●	★	●	●																				★											
CCMT09T302-MP	0.2		●	●	★																																	
CCMT09T304-MP	0.4		●	●	★	●	●																				●											
CCMT09T308-MP	0.8		●	●	★	●	●																				★											Medium cutting
CCMT060202-MM	0.2										●	●																										MM
CCMT060204-MM	0.4										●	●	●											●														
CCMT060208-MM	0.8											●	●											●														
CCMT09T302-MM	0.2										●	●																										
CCMT09T304-MM	0.4										●	●	●											●														
CCMT09T308-MM	0.8										●	●	●											●	●													Medium cutting

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*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.

CC TYPE INSERTS, 80° WITH HOLE

		Coated																						Coated Cermet				Cermet		Carbide					
		MS6015	MC6115	MC6125	MC6135	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
Order number	RE																																					Shape
CCMT060202-MK	0.2																●	●	●																			MK
CCMT060204-MK	0.4																●	●	●																			
CCMT060208-MK	0.8																●	●	★																			
CCMT09T302-MK	0.2																●	●	●																			
CCMT09T304-MK	0.4																●	●	●																			
CCMT09T308-MK	0.8																●	●	●																			Medium cutting
CCMT060202-MS	0.2																			●	●	●												●					MS
CCMT060204-MS	0.4																			●	●	●												●					
CCMT060208-MS	0.8																			●	●	●												●					
CCMT09T302-MS	0.2																			●	●	●																	
CCMT09T304-MS	0.4																			●	●	●												●					
CCMT09T308-MS	0.8																			●	●	●												●					Medium cutting
CCMT060202	0.2														●												●								●				Standard
CCMT060204	0.4														●									●	★		●								●		★		
CCMT060208	0.8														●									●											●				
CCMT09T302	0.2														●												●								★				
CCMT09T304	0.4														●									●	★		●								●		★		
CCMT09T308	0.8														★	●								●	★		●								●				Medium cutting
CCMH060202-MV	0.2			●	★		●								★	●								●			●												MV
CCMH060204-MV	0.4			●	★		●								●	●		★						●			●												
																																							Medium cutting
CCMT060204-MW	0.4		●	●	★	●	●								★												●												MW
CCMT060208-MW	0.8		●	●	★	●	●								★												★												
CCMT09T304-MW	0.4		●	●	★	●	●								●												●												
CCMT09T308-MW	0.8		●	●	★	●	●								●												●												Medium cutting (Wiper)
CCET0602V3R-SR	0.03*2																							★													★	R/L-SR
CCET0602V3L-SR	0.03*2																							●													★	
CCET060201R-SR	0.1*2																							★													★	
CCET060201L-SR	0.1*2																							★													★	
CCET060202R-SR	0.2*2																							★													★	
CCET060202L-SR	0.2*2																							●													★	
CCET060204R-SR	0.4*2																							★													★	
CCET060204L-SR	0.4*2																							●													★	
CCET09T3V3R-SR	0.03*2																							★													★	
CCET09T3V3L-SR	0.03*2																							●													★	
CCET09T301R-SR	0.1*2																							●													★	
CCET09T301L-SR	0.1*2																							●													★	
CCET09T302R-SR	0.2*2																							★													★	
CCET09T302L-SR	0.2*2																							●													★	
CCET09T304R-SR	0.4*2																							●													★	
CCET09T304L-SR	0.4*2																							●													★	Medium cutting

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*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.

CC TYPE INSERTS, 80° WITH HOLE

		Coated																					Coated Cermet				Cermet		Carbide					
P	Steel	◐	●	◐	✤	◶	❁	○	◶	❁											❁	✤	❁	◐	○	○	◶	○	◶			❁		○
M	Stainless steel										◐	●	◐	✤	○	✤				◐			◶	❁	✤	❁		○	○	○			❁		
K	Cast iron																◐	◐	✤				◶	❁			○	○	○			❁	○	◶	○
N	Non-ferrous metal																																◶	○
S	Heat resistant alloy, Titanium alloy																			◐	●	◐	✤	◶	❁					●	◐		◶	

Order number	RE	MS6015	MC6115	MC6125	MC6135	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	HTi05T	HTi10	TF15	Shape
CCGT060201M-SMG	0.1*2	●																																					SMG
CCGT060202M-SMG	0.2*2	●																						●															
CCGT060204M-SMG	0.4*2	●																						●															
CCGT09T301M-SMG	0.1*2	●																																					
CCGT09T302M-SMG	0.2*2	●																																					
CCGT09T304M-SMG	0.4*2	●																																					Medium cutting
CCGT0602V3R-SN	0.03																							●															R/L-SN
CCGT060201R-SN	0.1																							★															
CCGT060201L-SN	0.1																							★															
CCGT060202R-SN	0.2																							●															
CCGT060202L-SN	0.2																							●															
CCGT09T3V3R-SN	0.03																							★															
CCGT09T3V3L-SN	0.03																							★															
CCGT09T301R-SN	0.1																							●															
CCGT09T301L-SN	0.1																							★															
CCGT09T302R-SN	0.2																							●															
CCGT09T302L-SN	0.2																							●															
CCGT09T304R-SN	0.4																							●															
CCGT09T304L-SN	0.4																							●															
CCGT060201MR-SN	0.1*2	●									●									●																			
CCGT060201ML-SN	0.1*2	●																																					
CCGT060202MR-SN	0.2*2	●									●									●																			
CCGT060202ML-SN	0.2*2	●																																					
CCGT09T301MR-SN	0.1*2	●									●									●																			
CCGT09T301ML-SN	0.1*2	●																																					
CCGT09T302MR-SN	0.2*2	●									●									●																			
CCGT09T302ML-SN	0.2*2	●																																					
CCGT09T304MR-SN	0.4*2	●									●									●																			
CCGT09T304ML-SN	0.4*2	●																																					Medium cutting

*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.

CC TYPE INSERTS, 80° WITH HOLE

		Coated																					Coated Cermet				Cermet		Carbide					
		MS6015	MC6115	MC6125	MC6135	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	HTi05T	HTi10	TF15
P	Steel	◐	●	◐	✣	◶	❁	○	◶	❁	◐	●	◐	✣	○	✣								❁	✣	❁	❁	◐	○	○	◶	○	◶			❁			○
M	Stainless steel										◐	●	◐	✣	○	✣				◐			◶	❁	✣	❁		○	○		○				❁			
K	Cast iron																◐	◐	✣				◶	❁				○	○		○				❁	○	◶	○
N	Non-ferrous metal																																				◶	○
S	Heat resistant alloy, Titanium alloy																			●	◐	●	✣	◶	❁								●	◐			◶	

Order number	RE	Shape
CCET060200R-SN	0.0*2	R/L-SN
CCET060200L-SN	0.0*2	
CCET0602V3R-SN	0.03*2	
CCET0602V3L-SN	0.03*2	
CCET060201R-SN	0.1*2	
CCET060201L-SN	0.1*2	
CCET060202R-SN	0.2*2	
CCET060202L-SN	0.2*2	
CCET060204R-SN	0.4*2	
CCET060204L-SN	0.4*2	
CCET09T300R-SN	0.0*2	
CCET09T300L-SN	0.0*2	
CCET09T3V3R-SN	0.03*2	
CCET09T3V3L-SN	0.03*2	
CCET09T301R-SN	0.1*2	
CCET09T301L-SN	0.1*2	
CCET09T302R-SN	0.2*2	
CCET09T302L-SN	0.2*2	
CCET09T304R-SN	0.4*2	
CCET09T304L-SN	0.4*2	Medium cutting
CCET0602V3RW-SN	0.03*2	R/LW-SN
CCET0602V3LW-SN	0.03*2	
CCET09T3V3RW-SN	0.03*2	
CCET09T3V3LW-SN	0.03*2	Medium cutting (Wiper)

*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.

CC TYPE INSERTS, 80° WITH HOLE

		Coated																				Coated Cermet				Cermet		Carbide					
P	Steel	◕	●	◕	✣	◶	❁	○	◶	❁										❁	✣	❁	◕	○	○	◶	○	◶			❁		○
M	Stainless steel										◕	●	◕	✣	○	✣				◕			❁	✣	❁		○	○	○			❁		
K	Cast iron																●	◕	✣			◶	❁			○	○		○		❁	○	◶	○
N	Non-ferrous metal																															◶	○
S	Heat resistant alloy, Titanium alloy																●	●	◕	✣	◶	❁						●	◕			◶	
Order number	**RE**	MS6015	MC6115	MC6125	MC6135	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	UTi20T	HTi05T	HTi10	TF15	**Shape**
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)
○: 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.

CP TYPE INSERTS

80° WITH HOLE

		Coated																						Coated Cermet				Cermet		Carbide					
	Order number	RE	MS6015	MC6115	MC6125	MC6135	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	UTi20T	HTi05T	HTi10	TF15	Shape
P	Steel		●	●	●	✣	◔	❁	○	◔	❁														❁	✣	❁	◔	○	○	◔	○	◔			❁			○	
M	Stainless steel											●	●	●	✣	○	✣				●			◔	❁	✣	❁		○	○		○				❁				
K	Cast iron																	●	●	✣				◔	❁				○	○		○				❁	○	◔	○	
N	Non-ferrous metal																																					◔	○	
S	Heat resistant alloy, Titanium alloy																				●	●	●	✣	◔	❁								●	●			◔			
	CPMH080202-FP	0.2			●	●																																		FP
	CPMH080204-FP	0.4			●	●																																		
	CPMH090302-FP	0.2			●	●																																		
	CPMH090304-FP	0.4			●	●																																		
	CPMH090308-FP	0.8			●	●																																		Finish cutting
	CPMH080202-FM	0.2																								●														FM
	CPMH080204-FM	0.4																								●														
	CPMH090302-FM	0.2																								●														
	CPMH090304-FM	0.4																								●														
	CPMH090308-FM	0.8																								●														Finish cutting
	CPMH080202-FS	0.2																						●																FS
	CPMH080204-FS	0.4																						●																
	CPMH090302-FS	0.2																						●																
	CPMH090304-FS	0.4																						●																
	CPMH090308-FS	0.8																						●																Finish cutting
	CPMH080202-FV	0.2			★	★					★														●			★				★	★							FV
	CPMH080204-FV	0.4			●	★					●													●	●	●		★				●	★							
	CPMH090302-FV	0.2			★	★					★														●			★				★	★							
	CPMH090304-FV	0.4			●	★					●													●	●	●		★				★	★							
	CPMH090308-FV	0.8			●	★					★													●	●	●		★				★	★							Finish cutting
	CPGT080202	0.2																																				●		Standard
	CPGT080204	0.4																																				●		
	CPGT090302	0.2																																				★		
	CPGT090304	0.4																																				●		
																																							Finish cutting
	CPMH080204R-F	0.4																								●			★			★						★		R/L-F
	CPMH080204L-F	0.4																								●			★			★						★		
	CPMH090304R-F	0.4																								●			★			★						★		
	CPMH090304L-F	0.4																								●			★			★						★		
																																							Finish cutting
	CPGT080204R-F	0.4																														★				★				R/L-F
	CPGT080204L-F	0.4																														★				★				
	CPGT090302R-F	0.2																														★								
	CPGT090302L-F	0.2																														★				★				
	CPGT090304R-F	0.4																														★				★				
	CPGT090304L-F	0.4																														★				★				Finish cutting

1/3

*1 To be replaced by new products.
(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.

CP TYPE INSERTS, 80° WITH HOLE

		Coated																						Coated Cermet				Cermet		Carbide					
		MS6015	MC6115	MC6125	MC6135	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	UTI20T	HTI05T	HTI10	TF15
P	Steel	◐	●	◐	✣	◶	✣	○	◶	✣														✣	✣	✣	◐	○	○	◶	○	◶			✣			○
M	Stainless steel										◐	●	◐	✣	○	✣				◐			◶	✣	✣	✣		○	○		○				✣			
K	Cast iron																◐	◐	✣				◶	✣				○	○		○				✣	○	◶	○
N	Non-ferrous metal																															◶	○					
S	Heat resistant alloy, Titanium alloy																			◐	●	◐	✣	◶	✣								◐	◐			◶		

Order number	RE	Shape
CPMH080202-LP	0.2	LP
CPMH080204-LP	0.4	
CPMH080208-LP	0.8	
CPMH090302-LP	0.2	
CPMH090304-LP	0.4	
CPMH090308-LP	0.8	Light cutting
CPMH080204-LM	0.4	LM
CPMH080208-LM	0.8	
CPMH090304-LM	0.4	
CPMH090308-LM	0.8	
		Light cutting
CPMH080204-LS	0.4	LS
CPMH080208-LS	0.8	
CPMH090304-LS	0.4	
CPMH090308-LS	0.8	
		Light cutting
CPMH080202-SV	0.2	SV
CPMH080204-SV	0.4	
CPMH090302-SV	0.2	
CPMH090304-SV	0.4	
CPMH090308-SV	0.8	Light cutting
CPMH080204	0.4	Standard
CPMH080208	0.8	
CPMH090304	0.4	
CPMH090308	0.8	
		Medium cutting
CPMX080204	0.4	Standard
CPMX080208	0.8	
CPMX090304	0.4	
CPMX090308	0.8	
		Medium cutting

2/3

*1 To be replaced by new products.
(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.

CP TYPE INSERTS, 80° WITH HOLE

		Coated																						Coated Cermet				Cermet		Carbide					
		MS6015	MC6115	MC6125	MC6135	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	UTI20T	HTI05T	HTI10	TF15
P	Steel	◔	●	◔	✣	◶	❁	○	◶	❁													❁	✣	❁		◔	○	○	◶	○	◶			❁			○
M	Stainless steel										◔	●	◔	✣	○	✣				◔			◶	❁	✣	❁		○	○		○				❁			
K	Cast iron																◔	◔	✣				◶	❁				○	○		○				❁	○	◶	○
N	Non-ferrous metal																																				◶	○
S	Heat resistant alloy, Titanium alloy																			◔	●	◔	✣	◶	❁								●	◔			◶	

Order number	RE	Shape
CPMH080204-MP	0.4	MP
CPMH080208-MP	0.8	
CPMH090304-MP	0.4	
CPMH090308-MP	0.8	
		Medium cutting
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	
CPMH090308-MK	0.8	
		Medium cutting
CPMH080204-MS	0.4	MS
CPMH080208-MS	0.8	
CPMH090304-MS	0.4	
CPMH090308-MS	0.8	
		Medium cutting
CPMH080204-MV	0.4	MV
CPMH080208-MV	0.8	
CPMH090304-MV	0.4	
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	

3/3

*1 To be replaced by new products.
(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.

DC TYPE INSERTS

55° WITH HOLE

		Coated																						Coated Cermet				Cermet		Carbide					
		MS6015	MC6115	MC6125	MC6135	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	UTI20T	HT105T	HTI10	TF15
P	Steel	◐	●	◐	✣	◔	❁	○	◔	❁														❁	✣	❁	◐	○	○	◔	○	◔			❁			○
M	Stainless steel										◐	●	◐	✣	○	✣				◐			◔	❁	✣	❁		○	○		○				❁			
K	Cast iron																◐	◐	✣				◔	❁				○	○		○				❁	○	◔	❁	○
N	Non-ferrous metal																																				◔	○
S	Heat resistant alloy, Titanium alloy																			◐	●	◐	✣	◔	❁								●	◐			◔	

Order number	RE																																					Shape
DCMT070202-FP	0.2		●	●	★	●	●		●																		●				●							FP
DCMT070204-FP	0.4		●	●	★	●	●		●																		●				●							
DCMT11T302-FP	0.2		●	●	★	●	●		●																		●				●							
DCMT11T304-FP	0.4		●	●	★	●	●		●																		●				●							
DCMT11T308-FP	0.8		●	●	★	●	●		●																		●				●							Finish cutting
DCMT070202-FM	0.2																							●	●													FM
DCMT070204-FM	0.4																							●	●													
DCMT11T302-FM	0.2																							●	●													
DCMT11T304-FM	0.4																							●	●													
DCMT11T308-FM	0.8																							●	●													Finish cutting
DCMT070202-FS	0.2																						●															FS
DCMT070204-FS	0.4																						●															
DCMT11T302-FS	0.2																						●															
DCMT11T304-FS	0.4																						●															
DCMT11T308-FS	0.8																						●															Finish cutting
DCGT070201M-FS	0.1*2																			●	●	●				●												FS
DCGT070202M-FS	0.2*2																			●	●	●				●												
DCGT070204M-FS	0.4*2																			●	●	●				●												
DCGT11T301M-FS	0.1*2																			●	●	●				●												
DCGT11T302M-FS	0.2*2																			●	●	●				●												
DCGT11T304M-FS	0.4*2																			●	●	●				●												Finish cutting
DCGT070201M-FS-P	0.1*2										●									●						●								●					FS-P
DCGT070202M-FS-P	0.2*2										●									●						●								●					
DCGT070204M-FS-P	0.4*2										●									●						●								●					
DCGT11T301M-FS-P	0.1*2										●									●						●								●					
DCGT11T302M-FS-P	0.2*2										●									●						●								●					
DCGT11T304M-FS-P	0.4*2										●									●						●								●					Finish cutting
DCMT070202-FV	0.2		●	●	★				●	●													●	●	●			●				●	●						FV
DCMT070204-FV	0.4		●	●	★				●	●													●	●	●			●				●	●						
DCMT070208-FV	0.8			●	★					★														●								★	★						
DCMT11T302-FV	0.2			●	★					●														●								●	★						
DCMT11T304-FV	0.4		●	●	★				●	●													●	●	●			●				●	●						
DCMT11T308-FV	0.8		●	●	★				●	●													●	●	●			●				●	★						Finish cutting
DCGT070202-AZ	0.2																																				●	AZ
DCGT070204-AZ	0.4																																				●	
DCGT11T302-AZ	0.2																																				●	
DCGT11T304-AZ	0.4																									★												●	Medium cutting ~
DCGT11T308-AZ	0.8																									★												●	Finish cutting

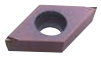
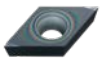
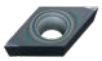
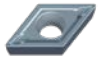
*1 To be replaced by new products.
*2 Indicates the maximum value of the corner R.
(10 inserts in one case)

●: 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.

DC TYPE INSERTS, 55° WITH HOLE

		Coated																						Coated Cermet				Cermet		Carbide					
		MS6015	MC6115	MC6125	MC6135	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	HTI05T	HTI10	TF15
P	Steel	◔	●	◔	✣	◶	❁	○	◶	❁														❁	✣	❁	◔	○	○	◶	○	◶			❁			○
M	Stainless steel										◔	●	◔	✣	○	✣				◔			◶	❁	✣	❁		○	○		○				❁			
K	Cast iron																◔	◔	✣				◶	❁				○	○		○				❁	○	◶	○
N	Non-ferrous metal																																				◶	○
S	Heat resistant alloy, Titanium alloy																			◔	●	◔	✣	◶	❁								●	◔			◶	

Order number	RE																																					Shape
DCGT070202R-F	0.2																							●			★			●						★	R/L-F
DCGT070202L-F	0.2																							●			★			●						★	
DCGT070204R-F	0.4																							●			★			●						★	
DCGT070204L-F	0.4																							●			★			●						★	
DCGT11T302R-F	0.2																							●			★			●						★	
DCGT11T302L-F	0.2																							●			★			●						★	
DCGT11T304R-F	0.4																							●			★			●						★	
DCGT11T304L-F	0.4																							●			★			●						★	Finish cutting
DCGT11T301MR-SRF	0.1*2										●									●																		R-SRF
DCGT11T302MR-SRF	0.2*2										●									●																		
DCGT11T304MR-SRF	0.4*2										●									●																		
																																						Finish cutting
DCET070201MR-SRF	0.1*2																			●																		R/L-SRF
DCET070201ML-SRF	0.1*2																			●																		
DCET070202MR-SRF	0.2*2																			●																		
DCET070202ML-SRF	0.2*2																			●																		
DCET070204MR-SRF	0.4*2																			●																		
DCET070204ML-SRF	0.4*2																			●																		
DCET11T301ML-SRF	0.1*2																			●																		
DCET11T302ML-SRF	0.2*2																			●																		
DCET11T304ML-SRF	0.4*2																			●																		Finish cutting
DCMT070202-LP	0.2		●	●	★																																	LP
DCMT070204-LP	0.4		●	●	★	●	●		●																		★			●							
DCMT070208-LP	0.8		●	●	★	●	●		★																		★			★							
DCMT11T302-LP	0.2		●	●	★																																
DCMT11T304-LP	0.4		●	●	★	●	●		●																		●			●							
DCMT11T308-LP	0.8		●	●	★	●	●		●																		●			★							Light cutting
DCMT070202-LM	0.2											●	●												●													LM
DCMT070204-LM	0.4											●	●	●											●	●												
DCMT070208-LM	0.8											●	●	●											★	●												
DCMT11T302-LM	0.2											●	●													●												
DCMT11T304-LM	0.4											★	●	●											●	●												
DCMT11T308-LM	0.8											●	●	●											●	●												Light cutting
DCMT070202-LS	0.2																				●	●	●											●					LS
DCMT070204-LS	0.4																				●	●	●											●					
DCMT070208-LS	0.8																						●																
DCMT11T302-LS	0.2																				●	●	●											●					
DCMT11T304-LS	0.4																				●	●	●											●					
DCMT11T308-LS	0.8																				●	●	●											●					Light cutting

*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.

DC TYPE INSERTS, 55° WITH HOLE

		Coated																				Coated Cermet				Cermet		Carbide						
Order number	RE	MS6015	MC6115	MC6125	MC6135	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	HTi10	TF15	Shape
DCGT070201M-LS	0.1*2																			●	●	●			●													LS
DCGT070202M-LS	0.2*2																			●	●	●			●													
DCGT070204M-LS	0.4*2																			●	●	●			●													
DCGT11T301M-LS	0.1*2																			●	●	●			●													
DCGT11T302M-LS	0.2*2																			●	●	●			●													
DCGT11T304M-LS	0.4*2																			●	●	●			●													Light cutting
DCGT0702V5M-LS-P	0.05*2																			●																		LS-P
DCGT070201M-LS-P	0.1*2	●									●									●													●					
DCGT070202M-LS-P	0.2*2	●									●									●													●					
DCGT070204M-LS-P	0.4*2	●									●									●													●					
DCGT11T301M-LS-P	0.1*2	●									●									●													●					
DCGT11T302M-LS-P	0.2*2	●									●									●													●					
DCGT11T304M-LS-P	0.4*2	●									●									●													●					Light cutting
DCMT070202-SV	0.2							★	●					★	●										●					★	●	●						SV
DCMT070204-SV	0.4							●	●					★	●										●					●	●	●						
DCMT070208-SV	0.8							●	●					★	●										●					★	●	★						
DCMT11T302-SV	0.2							●	●					★	●										●					●	●	●						
DCMT11T304-SV	0.4							●	●					★	●										●					●	●	●						
DCMT11T308-SV	0.8							●	●					★	●										●					●	●	★						Light cutting
DCMX070202-SW	0.2		●	●	●																		●															SW
DCMX070204-SW	0.4		●	●	●																		●															
DCMX070208-SW	0.8		●	●	●																		●															
DCMX11T302-SW	0.2		●	●	●																		●															
DCMX11T304-SW	0.4		●	●	●																		●															
DCMX11T308-SW	0.8		●	●	●																		●															Light cutting
DCGT0702V3R-SS	0.03																								★													R/L-SS
DCGT0702V3L-SS	0.03																								★													
DCGT070201R-SS	0.1																								★													
DCGT070201L-SS	0.1																								●													
DCGT070202R-SS	0.2																								★													
DCGT070202L-SS	0.2																								★													
DCGT11T3V3R-SS	0.03																								●													
DCGT11T301R-SS	0.1																								●													
DCGT11T302R-SS	0.2																								●													
DCGT070201MR-SS	0.1*2	●																																				
DCGT070201ML-SS	0.1*2	●																																				
DCGT070202MR-SS	0.2*2	●																																				
DCGT070202ML-SS	0.2*2	●																																				
DCGT11T301MR-SS	0.1*2	●																																				
DCGT11T301ML-SS	0.1*2	●																																				
DCGT11T302MR-SS	0.2*2	●																																				
DCGT11T302ML-SS	0.2*2	●																																				
DCGT11T304MR-SS	0.4*2	●																																				
DCGT11T304ML-SS	0.4*2	●																																				Light cutting

*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.

DC TYPE INSERTS, 55° WITH HOLE

		Coated																						Coated Cermet				Cermet		Carbide					
Order number	RE	MS6015	MC6115	MC6125	MC6135	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	HTI05T	HTI10	TF15	Shape
DCMT070202-MP	0.2		●	●	★																																		MP
DCMT070204-MP	0.4		●	●	★	●	●		●																		●				★								
DCMT070208-MP	0.8		●	●	★	●	●		★																		★				★								
DCMT11T302-MP	0.2		●	●	★																																		
DCMT11T304-MP	0.4		●	●	★	●	●		●																		●				●								
DCMT11T308-MP	0.8		●	●	★	●	●		●																		●				★								
DCMT11T312-MP	1.2		●	●																																			Medium cutting
DCMT070202-MM	0.2											●	●													●													MM
DCMT070204-MM	0.4											●	●	●											●	●													
DCMT070208-MM	0.8											●	●	★											●	●													
DCMT11T302-MM	0.2											●	●													●													
DCMT11T304-MM	0.4											●	●	●											●	●													
DCMT11T308-MM	0.8											●	●	●											●	●													Medium cutting
DCMT070202-MK	0.2																●	●	●																					MK
DCMT070204-MK	0.4																★	●	★																				
DCMT070208-MK	0.8																★	●	★																				
DCMT11T302-MK	0.2																●	●	●																				
DCMT11T304-MK	0.4																●	●	●																				
DCMT11T308-MK	0.8																●	●	●																				Medium cutting
DCMT070202-MS	0.2																						●																MS
DCMT070204-MS	0.4																			●	●	●												●					
DCMT070208-MS	0.8																			●	●	●												●					
DCMT11T302-MS	0.2																						●																
DCMT11T304-MS	0.4																			●	●	●												●					
DCMT11T308-MS	0.8																			●	●	●												●					
DCMT11T312-MS	1.2																			●	●	●												●					Medium cutting
DCMT070202	0.2								●	●				★	●													●	●			●	●		●				Standard
DCMT070204	0.4							●	●	●				★	●										●				●	●			●	●		●				
DCMT070208	0.8								★					●														●	★			●	●						
DCMT11T302	0.2								●	●				●														●	●			●	●		●		★		
DCMT11T304	0.4							●	●	●				●											●			●	●			●	●		●		★		
DCMT11T308	0.8							●	●	●				●											●		★	●	★			●	●		●		★		
DCMT11T312	1.2								★					★																		★							Medium cutting
DCMT070202-MV	0.2		●	●	★		●		●	●				●	●										●			●	●		●	★						MV
DCMT070204-MV	0.4		●	●	★		●		●	●				●	●		●								●			●	●		★	●	★						
DCMT070208-MV	0.8		●	●	★		●		●	●				★	●		●								●			●	●		★	★	★						
DCMT11T302-MV	0.2		●	●	★		●		●	●				●	●										●			●	●		●	●	●						
DCMT11T304-MV	0.4		●	●	★		●		●	●				●	●		●							★	●			●	●		●	●	●						
DCMT11T308-MV	0.8		●	★	★		●		●	●				●	●		●								●			●	●		●	●	●						Medium cutting

4/6

*1 To be replaced by new products.
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(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.

DC TYPE INSERTS, 55° WITH HOLE

		Coated																				Coated Cermet				Cermet		Carbide					
		MS6015	MC6115	MC6125	MC6135	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	HTi05T	HTi10	TF15
P	Steel	◔	●	◔	✣	◶	❁	○	◶	❁														❁	✣	❁	◔	○	○	◶	○	◶			❁			○
M	Stainless steel										◔	●	◔	✣	○	✣				◔				◶	❁	✣	❁		○	○		○				❁			
K	Cast iron																◔	◔	✣					◶	❁				○	○		○				❁	○	◶	○
N	Non-ferrous metal																																				◶	○
S	Heat resistant alloy, Titanium alloy																			◔	●	◔	✣	◶	❁								●	◔				◶	

Order number	RE																																						Shape
DCET0702V3R-SR	0.03*2																							★							★						★		R/L-SR
DCET0702V3L-SR	0.03*2																							★							★						★		
DCET070201R-SR	0.1*2																							★							★						★		
DCET070201L-SR	0.1*2																							★							★						★		
DCET070202R-SR	0.2*2																							★							★						★		
DCET070202L-SR	0.2*2																							★							★						★		
DCET070204R-SR	0.4*2																							★							★						★		
DCET070204L-SR	0.4*2																							★							★						★		
DCET11T3V3R-SR	0.03*2																							●							★						★		
DCET11T3V3L-SR	0.03*2																							★							★						★		
DCET11T301R-SR	0.1*2																							★							★						★		
DCET11T301L-SR	0.1*2																							★							★						★		
DCET11T302R-SR	0.2*2																							●							★						★		
DCET11T302L-SR	0.2*2																							★							★						★		
DCET11T304R-SR	0.4*2																							●							★						★		
DCET11T304L-SR	0.4*2																							●							★						★		Medium cutting
DCGT070201M-SMG	0.1*2	●																																					SMG
DCGT070202M-SMG	0.2*2	●																						●															
DCGT070204M-SMG	0.4*2	●																						●															
DCGT11T301M-SMG	0.1*2	●																																					
DCGT11T302M-SMG	0.2*2	●																						●															
DCGT11T304M-SMG	0.4*2	●																						●															Medium cutting
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*2	●									●									●																				
DCGT070201ML-SN	0.1*2	●									★									★																				
DCGT070202MR-SN	0.2*2	●									●									●																				
DCGT070202ML-SN	0.2*2	●									★									★																				
DCGT070204MR-SN	0.4*2										●									●																				
DCGT11T301MR-SN	0.1*2	●									●									●																				
DCGT11T301ML-SN	0.1*2	●									★									★																				
DCGT11T302MR-SN	0.2*2	●									●									●																				
DCGT11T302ML-SN	0.2*2	●									★									★																				
DCGT11T304MR-SN	0.4*2	●									●									●																				
DCGT11T304ML-SN	0.4*2	●									★									★																				Medium cutting

5/6

*1 To be replaced by new products.
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(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.

DC TYPE INSERTS, 55° WITH HOLE

		Coated																				Coated Cermet				Cermet	Carbide						
		MS6015	MC6115	MC6125	MC6135	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	UTI20T	HTI05T	HTI10	TF15
P	Steel	◔	●	◔	✣	◷	❁	○	◷	❁														❁	✣	❁	◔	○	○	◷	○	◷			❁			○
M	Stainless steel										◔	●	◔	✣	○	✣				◔				◷	❁	✣	❁		○	○		○				❁			
K	Cast iron																◔	◔	✣					◷	❁				○	○		○				❁	○	◷	○
N	Non-ferrous metal																																				◷	○
S	Heat resistant alloy, Titanium alloy																			◔	●	◔	✣	◷	❁								●	◔				◷	

Order number	RE																																						Shape
DCET070200R-SN	0.0*2																							●							★						★		R/L-SN
DCET070200L-SN	0.0*2																							★							★						★		
DCET0702V3R-SN	0.03*2																							●							★						★		
DCET0702V3L-SN	0.03*2																							★							★						★		
DCET070201R-SN	0.1*2																							●							★						★		
DCET070201L-SN	0.1*2																							●							★						★		
DCET070202R-SN	0.2*2																							●							★						★		
DCET070202L-SN	0.2*2																							●							★						★		
DCET070204R-SN	0.4*2																							★							★						★		
DCET070204L-SN	0.4*2																							●							★						★		
DCET11T300R-SN	0.0*2																							★							★						★		
DCET11T300L-SN	0.0*2																							★							★						★		
DCET11T3V3R-SN	0.03*2																							●							★						★		
DCET11T3V3L-SN	0.03*2																							★							★						★		
DCET11T301R-SN	0.1*2																							●							★						★		
DCET11T301L-SN	0.1*2																							●							★						★		
DCET11T302R-SN	0.2*2																							●							★						★		
DCET11T302L-SN	0.2*2																							●							★						★		
DCET11T304R-SN	0.4*2																							●							★						★		
DCET11T304L-SN	0.4*2																							●							★						★		Medium cutting
DCET0702V3RW-SN	0.03*2																							●															R/LW-SN
DCET0702V3LW-SN	0.03*2																							★															
DCET11T3V3RW-SN	0.03*2																							●															
DCET11T3V3LW-SN	0.03*2																							★															Medium cutting (Wiper)
DCMW070204	0.4																●	★	★												★				★	★	●		Flat Top
DCMW11T304	0.4																●	●	★												★				★		●		
DCMW11T308	0.8																●	●	●												★					★	●		
DCGW070200	0.0																														★								Flat Top
DCGW0702V5	0.05																														★						★		
DCGW070201	0.1																																				★		
DCGW070202	0.2																																				★		
DCGW11T300	0.0																														★						★		
DCGW11T3V5	0.05																														●								
DCGW11T301	0.1																																				★		
DCGW11T302	0.2																							★													★		
DCGW11T304	0.4																							★							●						★		

6/6

*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.

TC TYPE INSERTS

60° WITH HOLE

		Coated																						Coated Cermet				Cermet		Carbide					
	Order number	RE	MS6015	MC6115	MC6125	MC6135	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	UTi20T	HT105T	HTi10	TF15	Shape
P	Steel		◕	●	◕	✣	◶	❁	○	◶	❁														❁	✣	❁	◕	○	○	◶	○	◶		❁				○	
M	Stainless steel											◕	●	◕	✣	○	✣				◕			◶	❁	✣	❁		○	○		○			❁					
K	Cast iron																	◕	●	✣				◶	❁				○	○		○			❁		○	◶	○	
N	Non-ferrous metal																																					◶	○	
S	Heat resistant alloy, Titanium alloy																				◕	●	◕	✣	◶	❁								●	◕			◶		
	TCMT090202-FP	0.2		●	★	★	●	●		★																		★				★								FP
	TCMT090204-FP	0.4		●	●	★	●	●		★																		●				●								
	TCMT110202-FP	0.2		●	★	★	●	●		★																		●				★								
	TCMT110204-FP	0.4		●	●	★	●	●		●																		●				★								
	TCMT16T304-FP	0.4		●	●	★	●	●		●																		●				●								Finish cutting
	TCMT090202-FM	0.2																							★															FM
	TCMT090204-FM	0.4																							●															
	TCMT110202-FM	0.2																							●															
	TCMT110204-FM	0.4																							●															
	TCMT16T304-FM	0.4																							●															Finish cutting
	TCMT110204-FV	0.4			●	★				●																			●		●	●	●							FV
	TCMT16T304-FV	0.4			●	★				●						★													●		★	●	●							
																																								Finish cutting
	TCGT110202-AZ	0.2																																				●		AZ
	TCGT110204-AZ	0.4																																				●		
	TCGT110208-AZ	0.8																																				●		
	TCGT16T302-AZ	0.2																																				●		
	TCGT16T304-AZ	0.4																																				●		Medium cutting – Finish cutting
	TCGT16T308-AZ	0.8																																				●		
	TCGT0601V3L-F	0.03																							★								★							R/L-F
	TCGT060101L-F	0.1																							●								●							
	TCGT060102R-F	0.2																							★								★			★		★		
	TCGT060102L-F	0.2																							●								●			★		★		
	TCGT060104R-F	0.4																							★								●			★		★		
	TCGT060104L-F	0.4																							●								●			★		★		
	TCGT060101MR-F	0.1*2	●																																					
	TCGT060101ML-F	0.1*2	●																																					
	TCGT060102MR-F	0.2*2	●																																					
	TCGT060102ML-F	0.2*2	●																																					
	TCGT060104MR-F	0.4*2	●																																					
	TCGT060104ML-F	0.4*2	●																																					Finish cutting
	TCMT090204-LP	0.4		●	●	★	●	●		★																		●				★								LP
	TCMT090208-LP	0.8		●	★	★	●	●		★																		★				★								
	TCMT110202-LP	0.2		●	●	●																																		
	TCMT110204-LP	0.4		●	●	★	●	●		★																		★				●								
	TCMT110208-LP	0.8		●	●	★	●	●		★																		★				★								
	TCMT16T304-LP	0.4		●	●	★	●	●		★																		●				★								
	TCMT16T308-LP	0.8		●	●	★	●	●		★																		★				★								Light cutting

1/3

*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.

TC TYPE INSERTS, 60° WITH HOLE

		Coated																						Coated Cermet				Cermet		Carbide						
	Order number	RE	MS6015	MC6115	MC6125	MC6135	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	UTI20T	HTI05T	HTI10	TF15	Shape
P	Steel		◔	●	◔	✣	◶	❁	○	◶	❁														❁	✣	❁	◔	○	○	◶	○	◶			❁			○	
M	Stainless steel											◔	●	◔	✣	○	✣				◔			◶	❁	✣	❁		○	○		○				❁				
K	Cast iron																	◔	◔	✣				◶	❁				○	○		○				❁	○	◶	○	
N	Non-ferrous metal																																					◶	○	
S	Heat resistant alloy, Titanium alloy																				◔	●	◔	✣	◶	❁								●	◔				◶		
	TCMT090204-LM	0.4												●	★										●															LM
	TCMT090208-LM	0.8												★	★										★															
	TCMT110204-LM	0.4												●	●										●															
	TCMT110208-LM	0.8												●	●										●															
	TCMT16T304-LM	0.4												●	★										●															
	TCMT16T308-LM	0.8												●	★										●															Light cutting
	TCMT110202-LK	0.2																●	●	●																			LK
	TCMT110204-LK	0.4																●	●	●																			
	TCMT110208-LK	0.8																●	●	●																			
																																							Light cutting
	TCMT090202-LS	0.2																			●	●	●											●					LS
	TCMT110202-LS	0.2																			●	●	●											●					
																																							Light cutting
	TCMX090204-SW	0.4		●	●	●																		●															SW
	TCMX110204-SW	0.4		●	●	●																		●															
																																							Light cutting (Wiper)
	TCMT090204-MP	0.4		●	★	★	●	●		★																		★			★							MP
	TCMT090208-MP	0.8		●	★	★	●	●		★																		★			★							
	TCMT110202-MP	0.2		●	●	★																																
	TCMT110204-MP	0.4		●	★	★	●	●		●																		●			★							
	TCMT110208-MP	0.8		●	★	★	●	●		★																		★			★							
	TCMT16T304-MP	0.4		●	●	★	●	●		●																		★			★							
	TCMT16T308-MP	0.8		●	●	★	●	●		●																		●			●							
	TCMT16T312-MP	1.2		●	●	★	●	●		★																		★			★							Medium cutting
	TCMT090204-MM	0.4												●	★										●															MM
	TCMT090208-MM	0.8												★	★										★															
	TCMT110204-MM	0.4												●	●										●															
	TCMT110208-MM	0.8												●	★										●															
	TCMT16T304-MM	0.4												●	●										●															
	TCMT16T308-MM	0.8												●	●										●															
	TCMT16T312-MM	1.2												●	●										●															Medium cutting
	TCMT110204-MK	0.4																★	●	★																			MK
	TCMT110208-MK	0.8																★	●	★																			
	TCMT16T304-MK	0.4																●	●	★																			
	TCMT16T308-MK	0.8																●	●	●																			
	TCMT16T312-MK	1.2																●	●	●																			Medium cutting

*1 To be replaced by new products.
(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.

TC TYPE INSERTS, 60° WITH HOLE

		Coated																					Coated Cermet				Cermet		Carbide					
Order number	RE	MS6015	MC6115	MC6125	MC6135	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	HTI05T	HTI10	TF15	Shape
TCMT090204-MS	0.4																			●	●	●											●						MS
TCMT090208-MS	0.8																			●	●	●											●						
TCMT110204-MS	0.4																			●	●	●																	
TCMT110208-MS	0.8																			●	●	●																	
TCMT16T304-MS	0.4																			●	●	●											●						
TCMT16T308-MS	0.8																			●	●	●											●						
TCMT16T312-MS	1.2																			●	●	●											●						Medium cutting
TCMT090204	0.4							●	★					★	★												★	●			●	●		●					Standard
TCMT110202	0.2							●	★						●									★		★	★	★			●	●		★				
TCMT110204	0.4							★	●	●					●									●			●	★			●	●		●				
TCMT110208	0.8							★	●	★				★	★									★			●											
TCMT16T304	0.4							●	●	●					●									★		★	●	★			●	●		●				
TCMT16T308	0.8							●	●	●					●									●			●	★			●	●		●				
TCMT16T312	1.2							●																															Medium cutting
TCMW110204	0.4																●	●	★																		●		Flat Top
TCMW16T304	0.4																●	●	●																		●		
TCMW16T308	0.8																●	●	●																★		●		
TCMW16T312	1.2																●	●	★																				
TCGW110201	0.1																																				★		Flat Top
TCGW110202	0.2																																				★		
TCGW110204	0.4																																				★		
TCGW110208	0.8																																						
TCGW110204E	0.4																																						
TCGW110208E	0.8																																						

*1 To be replaced by new products.
(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.

TP TYPE INSERTS

60° WITH HOLE

		Coated																						Coated Cermet				Cermet		Carbide					
		MS6015	MC6115	MC6125	MC6135	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	UTi20T	HT105T	HTi10	TF15
Order number	RE																																					Shape
TPMH090202-FP	0.2		●	●	●																																	FP
TPMH090204-FP	0.4		●	●	●																																	
TPMH110302-FP	0.2		●	●	●																																	
TPMH110304-FP	0.4		●	●	●																																	
TPMH110308-FP	0.8		●	●	●																																	Finish cutting
TPMH090202-FM	0.2																							●														FM
TPMH090204-FM	0.4																							●														
TPMH110302-FM	0.2																							●														
TPMH110304-FM	0.4																							●														
TPMH110308-FM	0.8																							●														Finish cutting
TPMH080202-FV	0.2			★	★					●														●			★				★	★						FV
TPMH080204-FV	0.4			★	★					●														●			★				★	★						
TPMH090202-FV	0.2			★	★					★												●		●	●		●				●	★						
TPMH090204-FV	0.4			●	★					●												●		●	●		★				★	★						
TPMH110302-FV	0.2			★	★					★														●			●				★	★						
TPMH110304-FV	0.4		●	●	★					●												●		●	●		●				★	★						
TPMH110308-FV	0.8		●	●	★					★												●		★	●		★				●	★						Finish cutting
TPMH090202-FS	0.2																					●																FS
TPMH090204-FS	0.4																					●																
TPMH110302-FS	0.2																					●																
TPMH110304-FS	0.4																					●																
TPMH110308-FS	0.8																					●																Finish cutting
TPGH080202R-FS	0.2																								●			★			★						★	R/L-FS
TPGH080202L-FS	0.2																								●		★	●			★						★	
TPGH080204R-FS	0.4																								●			★			★						★	
TPGH080204L-FS	0.4																								●		★	●			★						★	
TPGH090202R-FS	0.2																								●			★			★						★	
TPGH090202L-FS	0.2																								●		★	●			★						★	
TPGH090204R-FS	0.4																								●			★			★						★	
TPGH090204L-FS	0.4																								●		●	★			★						★	
TPGH110302R-FS	0.2																								●			★			●						★	
TPGH110302L-FS	0.2																								●		★	●			★						★	
TPGH110304R-FS	0.4																								●			★			★						★	
TPGH110304L-FS	0.4																								●		●	●			●						★	Finish cutting

1/3

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(10 inserts in one case)

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○: Stable cutting (2nd recommendation)
◕: General cutting (1st recommendation)
◔: General cutting (2nd recommendation)
✣: Unstable cutting (1st recommendation)
❁: Unstable cutting (2nd recommendation)

● / ★ = Expansion

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TP TYPE INSERTS, 60° WITH HOLE

		Coated																						Coated Cermet				Cermet		Carbide					
		MS6015	MC6115	MC6125	MC6135	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
P	Steel	◔	●	◔	✣	◶	✣	○	◶	✣														✣	✣	✣	◔	○	○	◶	○	◶			✣			○
M	Stainless steel										◔	●	◔	✣	○	✣				◔				◶	✣	✣	✣		○	○		○			✣			
K	Cast iron																◔	◔	✣					◶	✣				○	○		○			✣	○	◶	○
N	Non-ferrous metal																																				◶	○
S	Heat resistant alloy, Titanium alloy																			◔	●	◔	✣	◶	✣								●	◔			◶	

Order number	RE	Shape
TPGX080202R	0.2	R/L
TPGX080202L	0.2	
TPGX080204R	0.4	
TPGX080204L	0.4	
TPGX090202R	0.2	
TPGX090202L	0.2	
TPGX090204R	0.4	
TPGX090204L	0.4	
TPGX090208R	0.8	
TPGX090208L	0.8	
TPGX110302L	0.2	
TPGX110304R	0.4	
TPGX110304L	0.4	
TPGX110308R	0.8	
TPGX110308L	0.8	Finish cutting
TPMX090204L	0.4	L
TPMX110304L	0.4	
		Finish cutting
TPMH080202-LP	0.2	LP
TPMH080204-LP	0.4	
TPMH090202-LP	0.2	
TPMH090204-LP	0.4	
TPMH110302-LP	0.2	
TPMH110304-LP	0.4	
TPMH110308-LP	0.8	Light cutting
TPMH090202-LM	0.2	LM
TPMH090204-LM	0.4	
TPMH110302-LM	0.2	
TPMH110304-LM	0.4	
TPMH110308-LM	0.8	Light cutting
TPMH110302-LK	0.2	LK
TPMH110304-LK	0.4	
TPMH110308-LK	0.8	
		Light cutting

2/3

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(10 inserts in one case)

●: Stable cutting (1st recommendation)
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◔: General cutting (1st recommendation)
◶: General cutting (2nd recommendation)
✣: Unstable cutting (1st recommendation)
✣: Unstable cutting (2nd recommendation)

● / ★ = Expansion

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

TP TYPE INSERTS, 60° WITH HOLE

		Coated																					Coated Cermet				Cermet		Carbide					
Order number	RE	MS6015	MC6115	MC6125	MC6135	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	UTI20T	HTI05T	HTI10	TF15	Shape
TPMH090202-LS	0.2																					●																LS
TPMH090204-LS	0.4																					●																
TPMH110302-LS	0.2																					●																
TPMH110304-LS	0.4																					●																
TPMH110308-LS	0.8																					●																Light cutting
TPMH080202-SV	0.2						●		★						★ ★									●			★		★	● ★							SV
TPMH080204-SV	0.4						●		●						★ ●									●			★		★	● ★							
TPMH090202-SV	0.2						●		●						★ ●									●			★		★	★ ★							
TPMH090204-SV	0.4						●		●						★ ●									●			★		●	● ★							
TPMH110302-SV	0.2						●		●						★ ●									★			★		★	★ ★							
TPMH110304-SV	0.4						●		●						★ ●									●			★		★	● ●							
TPMH110308-SV	0.8						●		●						★ ★									★			★		●	★ ★							Light cutting
TPMX090202-SW	0.2	●	●	●																		●																SW
TPMX090204-SW	0.4	●	●	●																		●																
TPMX090208-SW	0.8	●	●	●																		●																
TPMX110302-SW	0.2	●	●	●																		●																
TPMX110304-SW	0.4	●	●	●																		●																
TPMX110308-SW	0.8	●	●	●																		●																Light cutting (Wiper)
TPMX110304	0.4																										★				★ ★			★				Standard
TPMX110308	0.8																										★				★ ★							
																																						Medium cutting
TPMH080202-MV	0.2			●	★		●		●						★ ●									★			★ ★		★	★ ★							MV
TPMH080204-MV	0.4			●	★		●		●						● ●		●							●			★ ★		★	● ★							
TPMH090202-MV	0.2			●	★		●		●						★ ●									●			★ ★		★	● ★							
TPMH090204-MV	0.4			●	★		●		●						● ●		★							●			★ ●		★	● ★							
TPMH090208-MV	0.8			●	★		●		●								★							●			★			★							
TPMH110302-MV	0.2			●	★		●		●						★ ★									★			★ ★		★	● ★							
TPMH110304-MV	0.4			●	★		●		●						● ●		★							●			★ ★		★	● ★							
TPMH110308-MV	0.8			●	★		●		●						★ ●		★							●			★ ★		★	★ ★							Medium cutting
TPGX080202	0.2																																	★	●			Flat Top
TPGX080204	0.4																									★					●			★	●			
TPGX080208	0.8																														★			★	★			
TPGX090202	0.2																																	★	●			
TPGX090204	0.4																									★					●			●	●			
TPGX090208	0.8																									★					●			★ ★	★			
TPGX110302	0.2																																	★	●			
TPGX110304	0.4																									★					●			● ★	●			
TPGX110308	0.8																									★					●			★ ★	●			

3/3

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(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

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	MC6135	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	UTI20T	HT105T	HTI10	TF15	
VBMT110302-FP	0.2	●	●	★	●	●		●																			●				●							FP
VBMT110304-FP	0.4	●	●	★	●	●		●																			●				●							
VBMT110308-FP	0.8	●	★	★	●	●		★																			★				★							
VBMT160404-FP	0.4	●	●	★	●	●		●																			●				●							
VBMT160408-FP	0.8	●	●	★	●	●		●																			●				●							
VBMT160412-FP	1.2	●	●	●																																		Finish cutting
VBMT110302-FM	0.2																							●	●													FM
VBMT110304-FM	0.4																							●	●													
VBMT110308-FM	0.8																							★	●													
VBMT160404-FM	0.4																							●	●													
VBMT160408-FM	0.8																							★	●													
VBMT160412-FM	1.2																								●													Finish cutting
VBMT110302-FS	0.2																						●															FS
VBMT110304-FS	0.4																						●															
VBMT110308-FS	0.8																						●															
VBMT160404-FS	0.4																						●															
VBMT160408-FS	0.8																						●															
VBMT160412-FS	1.2																						●															Finish cutting
VBGT110301M-FS-P	0.1																			●																		FS-P
VBGT110302M-FS-P	0.2																			●																		
VBGT110304M-FS-P	0.4																			●																		
VBGT160401M-FS-P	0.1																			●																		
VBGT160402M-FS-P	0.2																			●																		
VBGT160404M-FS-P	0.4																			●																		
VBGT160408M-FS-P	0.8																			●																		Finish cutting
VBMT110304-FV	0.4		●	●	★					●													●		●	●					●	★						FV
VBMT110308-FV	0.8			●	★					★															●							★	★						
VBMT160404-FV	0.4		●	●	★					●													●		●	●					●	★						
VBMT160408-FV	0.8		●	●	★					●													●		●	●					★	★						
																																						Finish cutting
VBGT110302R-F	0.2																								●			★	★			★					★		R/L-F
VBGT110302L-F	0.2																								●			●	★			★					★		
VBGT110304R-F	0.4																								●				★			★					★		
VBGT110304L-F	0.4																								●				★			★					★		
VBGT160402R-F	0.2																								●				★			★					★		
VBGT160402L-F	0.2																								●				★			★					★		
VBGT160404R-F	0.4																								●				★			★					★		
VBGT160404L-F	0.4																								●				★			★					★		Finish cutting

1/3

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(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

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	MC6135	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	UTI20T	HTI05T	HTI10	TF15	
VBMT110304-LP	0.4	●	●	★	●	●		★																			●				★								LP
VBMT110308-LP	0.8	●	●	★	●	●		●																			★				●								
VBMT160404-LP	0.4	●	●	★	●	●		●																			●				●								
VBMT160408-LP	0.8	●	●	★	●	●		●																			●				●								
VBMT160412-LP	1.2	●	●	●																																			Light cutting
VBMT110304-LM	0.4											●	●	●										●	●														LM
VBMT110308-LM	0.8											●	★	★										●	●														
VBMT160404-LM	0.4											●	●	●										●															
VBMT160408-LM	0.8											●	●	★										●															
VBMT160412-LM	1.2											●	●																										Light cutting
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	●	●	★	●	●		●																			★				★								
																																							Medium cutting
VBMT160404-MM	0.4												●	●										●															MM
VBMT160408-MM	0.8												●	●										●															
																																							Medium cutting
VBMT160404-MK	0.4																★	●	★																				MK
VBMT160408-MK	0.8																★	●	★																				
																																							Medium cutting
VBMT160402-MS	0.2																			●	●	●											●						MS
VBMT160404-MS	0.4																			●	●	●											●						
VBMT160408-MS	0.8																			●	●	●											●						
VBMT160412-MS	1.2																			●	●	●											●						
																																							Medium cutting

*1 To be replaced by new products.
(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	MC6135	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	HTI05T	HTI10	TF15	Shape
VBMT160404	0.4								●																													Standard
VBMT160408	0.8								●																													
																																						Medium cutting
VBMT110304-MV	0.4			●	★		●			●					●	●		●							●			●	●	★	●	★						MV
VBMT110308-MV	0.8			●	★		●			●					★	★		●							●			★	●	★	●	★						
VBMT160404-MV	0.4			●	★		●	●	●	●					●	●		●							●			●	●	●	●	●						
VBMT160408-MV	0.8			★	★		●	●	●	●					★	●		●							●			●	●	★	●	★						
																																						Medium cutting
VBET1103V3R-SR	0.03*2																							★							★						★	R/L-SR
VBET1103V3L-SR	0.03*2																							★							★						★	
VBET110301R-SR	0.1*2																							●							★						★	
VBET110301L-SR	0.1*2																							●							★						★	
VBET110302R-SR	0.2*2																							●							★						★	
VBET110302L-SR	0.2*2																							★							★						★	
VBET110304R-SR	0.4*2																							●							★						★	
VBET110304L-SR	0.4*2																							★							★						★	Medium cutting
VBET110300R-SN	0.0*2																							●							★						★	R/L-SN
VBET110300L-SN	0.0*2																							★							★						★	
VBET1103V3R-SN	0.03*2																							●							★						★	
VBET1103V3L-SN	0.03*2																							●							★						★	
VBET110301R-SN	0.1*2																							●							★						★	
VBET110301L-SN	0.1*2																							●							★						★	
VBET110302R-SN	0.2*2																							●							★						★	
VBET110302L-SN	0.2*2																							●							★						★	
VBET110304R-SN	0.4*2																							●							★						●	
VBET110304L-SN	0.4*2																							★							★						★	Medium cutting
VBET1103V3RW-SN	0.03*2																							●														R/LW-SN
VBET1103V3LW-SN	0.03*2																							★														
																																						Medium cutting (Wiper)
VBMW160408	0.8																★	★	★																			Flat Top
																																						

3/3

*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.

VC TYPE INSERTS

35° WITH HOLE

		Coated																						Coated Cermet				Cermet		Carbide						
		MS6015	MC6115	MC6125	MC6135	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	UTi20T	HT05T	HTi10	TF15
P	Steel	◐	●	◐	✣	◶	❁	○	◶	❁										◐				❁	✣	❁	◐	○	○	◶	○	◶		❁				○
M	Stainless steel										◐	●	◐	✣	○	✣				◐			◶	❁	✣	❁		○	○		○			❁				
K	Cast iron																◐	◐	✣				◶	❁				○	○		○			❁	○	◶		○
N	Non-ferrous metal																																			◶		○
S	Heat resistant alloy, Titanium alloy																			◐	●	◐	✣	◶	❁									●	◐		◶	

Order number	RE	Shape
VCMT080202-FP	0.2	FP
VCMT080204-FP	0.4	 Finish cutting
VCMT080202-FM	0.2	FM
VCMT080204-FM	0.4	 Finish cutting
VCMT080202-FV	0.2	FV
VCMT080204-FV	0.4	 Finish cutting
VCMT080202-FS	0.2	FS
VCMT080204-FS	0.4	 Finish cutting
VCMT080202-LP	0.2	LP
VCMT080204-LP	0.4	 Light cutting
VCMT080202-LM	0.2	LM
VCMT080204-LM	0.4	 Light cutting
VCMT080202-LS	0.2	LS
VCMT080204-LS	0.4	 Light cutting

1/2

*1 To be replaced by new products.
(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.

VC TYPE INSERTS, 35° WITH HOLE

		Coated																				Coated Cermet				Cermet		Carbide					
		MS6015	MC6115	MC6125	MC6135	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	UTI20T	HTI05T	HTI10	TF15
P	Steel	◔	●	◔	✣	◶	❁	○	◶	❁	◔	●	◔	✣	○	✣	◔	●	✣	◔				❁	✣	❁	◔	○	○	◶	○	◶			❁			○
M	Stainless steel										◔	●	◔	✣	○	✣				◔			◶	❁	✣	❁		○	○		○				❁			
K	Cast iron																◔	●	✣				◶	❁				○	○		○				❁	○	◶	○
N	Non-ferrous metal																																			◶	○
S	Heat resistant alloy, Titanium alloy																			●	◔	●	✣	◶	❁								●	◔			◶	

Order number	RE	Shape
VCET080202MR-SRF	0.2*2	R/L-SRF
VCET080202ML-SRF	0.2*2	
VCET080204MR-SRF	0.4*2	
VCET080204ML-SRF	0.4*2	
VCET110301MR-SRF	0.1*2	
VCET110301ML-SRF	0.1*2	
VCET110302MR-SRF	0.2*2	
VCET110302ML-SRF	0.2*2	
VCET110304MR-SRF	0.4*2	
VCET110304ML-SRF	0.4*2	Finish cutting
VCGT080202R-F	0.2	R/L-F
VCGT080202L-F	0.2	
VCGT080204R-F	0.4	
VCGT080204L-F	0.4	
		Finish cutting
VCMT080202-SV	0.2	SV
VCMT080204-SV	0.4	
		Light cutting
VCMT080202-MV	0.2	MV
VCMT080204-MV	0.4	
		Medium cutting

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)
○: 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.

WC TYPE INSERTS

80° WITH HOLE

		Coated																						Coated Cermet			Cermet		Carbide					
		MS6015	MC6115	MC6125	MC6135	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	UTi20T	HTi05T	HTi10	TF15	
P	Steel	◐	●	◐	✣	◶	❁	○	◶	❁										◐				❁	✣	❁	◐	○	○	◶	○	◶			❁			○	
M	Stainless steel										◐	●	◐	✣	○	✣				◐			◶	❁	✣	❁		○	○		○				❁				
K	Cast iron																◐	◐	✣				◶	❁				○	○		○				❁	○	◶	○	
N	Non-ferrous metal																																				◶	○	
S	Heat resistant alloy, Titanium alloy																			◐	●	◐	✣	◶	❁								●	◐			◶		

Order number	RE																																						Shape
WCGT020102R	0.2																														●						★		R/L
WCGT020102L	0.2																														●						●		
WCGT020104R	0.4																														★						★		
WCGT020104L	0.4																														●						●		
WCGTL30202L	0.2																														●						★		
WCGTL30204L	0.4																														●						★		Finish cutting
WCMT020102-FV	0.2			●																			●		●														FV
WCMT020104-FV	0.4			●																			●		●														
WCMTL30202-FV	0.2			●																			●		●														
WCMTL30204-FV	0.4			●																			●		●														
WCMT040202-FV	0.2			●																			●		●														
WCMT040204-FV	0.4			●																			●		●														
WCMT06T302-FV	0.2			●																			●		●														
WCMT06T304-FV	0.4			●																			●		●														Finish cutting
WCMT020102-MP	0.2		★	★	★																																		Standard
WCMT020104-MP	0.4		★	★	★																																		
WCMTL30202-MP	0.2		★	★																																			
WCMTL30204-MP	0.4		★	★																																			
WCMT040202-MP	0.2		★	★	★																																		
WCMT040204-MP	0.4		★	★	★																																		
WCMT040208-MP	0.8			★	★																																		
WCMT06T304-MP	0.4		★	★	★																																		
WCMT06T308-MP	0.8		★	★	★																																		Medium cutting
WCMT020102	0.2								★	★						●										★	●	★			●	●			●				Standard
WCMT020104	0.4								★	★						●											●	★			●	●			●				
WCMTL30202	0.2								★							●											★	★			●	●			●				
WCMTL30204	0.4								★							●											●	★			●	●			●				
WCMT040202	0.2								★	★						●											●	★			●	●			●				
WCMT040204	0.4								★	★						●											●	★			●	★			●				
WCMT040208	0.7									★																														
WCMT06T304	0.4								★	★						●											●	★			●	●			●				
WCMT06T308	0.8								★	★						●											★	★			●	★			●				Medium cutting

1/1

*1 To be replaced by new products.
(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.

INSERTS FOR OTHER TYPES OF BORING BARS

POSITIVE WITH HOLE

		Coated																				Coated Cermet				Cermet		Carbide					
		MS6015	MC6115	MC6125	MC6135	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	UTI20T	HTI05T	HTI10	TF15
P	Steel	◉	●	◉	❖	◔	❁	○	◔	❁														❁	❖	❁	◉	○	○	◔	○	◔		❁			○
M	Stainless steel										◉	●	◉	❖	○	❖				◉			◔	❁	❖	❁		○	○		○			❁				
K	Cast iron																◉	◉	❖				◔	❁				○	○		○				❁	○	◔	○
N	Non-ferrous metal																																				◔	○
S	Heat resistant alloy, Titanium alloy																			◉	●	◉	❖	◔	❁								●	◉			◔	

Order number	RE	Shape
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
		Finish cutting
TPMH160302-LM	0.2	LM
TPMH160304-LM	0.4	
TPMH160308-LM	0.8	
		Light cutting
TPMH160302-LS	0.2	LS
TPMH160304-LS	0.4	
TPMH160308-LS	0.8	
		Light cutting
VCMT160404-FM	0.4	FM
VCMT160408-FM	0.8	
		Finish cutting
VCMT160404-FS	0.4	FS
VCMT160408-FS	0.8	
		Finish cutting
VCGT110301M-FS-P	0.1*2	FS-P
VCGT110302M-FS-P	0.2*2	
		Finish cutting

1/2

*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)
○: 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.

INSERTS FOR OTHER TYPES OF BORING BARS, POSITIVE WITH HOLE

		Coated																				Coated Cermet				Cermet		Carbide					
		MS6015	MC6115	MC6125	MC6135	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	HTI05T	HTI10	TF15
P	Steel	◐	●	◐	✣	◔	❁	○	◔	❁														❁	✣	❁	◐	○	○	◔	○	◔			❁			○
M	Stainless steel										◐	●	◐	✣	○	✣				◐			◔	❁	✣	❁		○	○		○				❁			
K	Cast iron																◐	◐	✣				◔	❁				○	○		○				❁	○	◔	○
N	Non-ferrous metal																																				◔	○
S	Heat resistant alloy, Titanium alloy																			◐	●	◐	✣	◔	❁								●	◐			◔	

Order number	RE	Shape
VPET1103V3R-SRF	0.03	R/L-SRF
VPET1103V3L-SRF	0.03	
		
		Finish cutting
VPET080201MR-SRF	0.1*2	R/L-SRF
VPET080201ML-SRF	0.1*2	
VPET080202MR-SRF	0.2*2	
VPET080202ML-SRF	0.2*2	
VPET110301MR-SRF	0.1*2	
VPET110301ML-SRF	0.1*2	
VPET110302MR-SRF	0.2*2	
VPET110302ML-SRF	0.2*2	Finish cutting

*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.

INSERTS FOR OTHER TYPES OF BORING BARS

POSITIVE WITHOUT HOLE

		Coated																				Coated Cermet			Cermet		Carbide					
		MS6015	MC6115	MC6125	MC6135	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	UTI20T	HTI05T	HTI10	TF15
P	Steel	◕	●	◕	✣	◔	❁	○	◔	❁														❁	✣	❁	◕	○	○	◔	○	◔			❁			○
M	Stainless steel										◕	●	◕	✣	○	✣				◕			◔	❁	✣	❁		○	○		○				❁			
K	Cast iron																●	◕	✣				◔	❁				○	○		○				❁	○	◔	○
N	Non-ferrous metal																																				◔	○
S	Heat resistant alloy, Titanium alloy																			●	◕	●	✣	◔	❁								●	◕			◔	

Order number	RE	Shape
TPMR110304-LM	0.4	LM
TPMR110308-LM	0.8	
TPMR160304-LM	0.4	
TPMR160308-LM	0.8	
		Light cutting
TPMR110304-MM	0.4	MM
TPMR110308-MM	0.8	
TPMR160304-MM	0.4	
TPMR160308-MM	0.8	
		Medium cutting

1/1

*1 To be replaced by new products.
(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.

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 teel	—	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

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1. If chatter or 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.

RECOMMENDED CUTTING CONDITIONS

MC6100 SERIES – 5°, 7° POSITIVE INSERTS (FOR EXTERNAL TURNING)

	Material	Hardness	Cutting mode		Priority	Grade		Vc	f	ap
P	Mild steel	≤180HB	●	F	1	MC6115	FP	295 – 570	0.04 – 0.20	0.20 – 0.90
			●	F	2	MC6115	FV	295 – 570	0.04 – 0.20	0.20 – 0.90
			●	L	1	MC6115	LP	295 – 570	0.06 – 0.25	0.20 – 1.00
			●	L	2	MC6115	SW	295 – 570	0.06 – 0.24	0.20 – 1.50
			●	M	1	MC6115	MP	245 – 475	0.08 – 0.30	0.30 – 2.00
			●	M	2	MC6115	MV	245 – 475	0.08 – 0.30	0.30 – 2.00
			●	M	3	MC6115	MW	245 – 475	0.10 – 0.35	0.80 – 2.50
			✤	F	1	MC6125	FP	320 – 505	0.04 – 0.20	0.20 – 0.90
			✤	F	2	MC6135	FP	265 – 400	0.04 – 0.20	0.20 – 0.90
			✤	L	1	MC6125	LP	320 – 505	0.06 – 0.25	0.20 – 1.00
			✤	L	2	MC6135	LP	265 – 400	0.06 – 0.25	0.20 – 1.00
			✤	L	3	MC6125	SW	320 – 505	0.06 – 0.24	0.20 – 1.50
			✤	M	1	MC6125	MP	270 – 420	0.08 – 0.30	0.30 – 2.00
			✤	M	2	MC6135	MP	220 – 330	0.08 – 0.30	0.30 – 2.00
			✤	M	3	MC6125	MV	270 – 420	0.08 – 0.30	0.30 – 2.00
			✤	M	4	MC6125	MW	270 – 420	0.10 – 0.35	0.80 – 2.50
	Carbon steel Alloy steel	180 – 280HB	●	F	1	MC6115	FP	220 – 420	0.04 – 0.20	0.20 – 0.90
			●	F	2	MC6125	FP	240 – 370	0.04 – 0.20	0.20 – 0.90
			●	F	3	MC6115	FV	220 – 420	0.04 – 0.20	0.20 – 0.90
			●	L	1	MC6115	LP	220 – 420	0.06 – 0.25	0.20 – 1.00
			●	L	2	MC6125	LP	240 – 370	0.06 – 0.25	0.20 – 1.00
			●	M	1	MC6125	MP	200 – 310	0.08 – 0.30	0.30 – 2.00
			●	M	2	MC6115	MP	180 – 350	0.08 – 0.30	0.30 – 2.00
			●	M	3	MC6125	MV	200 – 310	0.08 – 0.30	0.30 – 2.00
			●	M	4	MC6115	MV	180 – 350	0.08 – 0.30	0.30 – 2.00
			●	M	5	MC6115	MW	180 – 350	0.10 – 0.35	0.80 – 2.50
			✤	F	1	MC6125	FP	240 – 370	0.04 – 0.20	0.20 – 0.90
			✤	F	2	MC6135	FP	195 – 295	0.04 – 0.20	0.20 – 0.90
			✤	F	3	MC6125	FV	240 – 370	0.04 – 0.20	0.20 – 0.90
			✤	L	1	MC6125	LP	240 – 370	0.06 – 0.25	0.20 – 1.00
			✤	L	2	MC6135	LP	195 – 295	0.06 – 0.25	0.20 – 1.00
			✤	L	3	MC6125	SW	240 – 370	0.06 – 0.24	0.20 – 1.50
			✤	M	1	MC6125	MP	200 – 310	0.08 – 0.30	0.30 – 2.00
			✤	M	2	MC6135	MP	160 – 245	0.08 – 0.30	0.30 – 2.00
			✤	M	3	MC6125	MV	200 – 310	0.08 – 0.30	0.30 – 2.00
	Carbon steel Alloy steel	280 – 350HB	●	F	1	MC6115	FP	155 – 295	0.04 – 0.20	0.20 – 0.90
			●	F	2	MC6115	FV	155 – 295	0.04 – 0.20	0.20 – 0.90
			●	L	1	MC6115	LP	155 – 295	0.06 – 0.25	0.20 – 1.00
			●	M	1	MC6115	MP	130 – 245	0.08 – 0.30	0.30 – 2.00
			●	M	2	MC6115	MV	130 – 245	0.08 – 0.30	0.30 – 2.00
			✤	F	1	MC6125	FP	170 – 265	0.04 – 0.20	0.20 – 0.90
			✤	F	2	MC6135	FP	135 – 210	0.04 – 0.20	0.20 – 0.90
			✤	L	1	MC6125	LP	170 – 265	0.06 – 0.25	0.20 – 1.00
			✤	L	2	MC6135	LP	135 – 210	0.06 – 0.25	0.20 – 1.00
			✤	M	1	MC6125	MP	140 – 220	0.08 – 0.30	0.30 – 2.00
			✤	M	2	MC6135	MP	115 – 175	0.08 – 0.30	0.30 – 2.00
			✤	M	3	MC6125	MV	140 – 220	0.08 – 0.30	0.30 – 2.00

1. Recommended cutting conditions for 5° / 7° / 11° positive inserts are provided as a guideline only.
   Verify the recommended conditions for each boring bar as cutting conditions for internal machining will vary depending on the length of overhang.

Cutting conditions : ● : Stable cutting ● : General cutting ✤ : Unstable cutting

RECOMMENDED CUTTING CONDITIONS

MC6100 SERIES – 11° POSITIVE INSERTS (FOR EXTERNAL TURNING)

	Material	Hardness	Cutting mode		Priority	Grade		Vc	f	ap
P	Mild steel	≤180HB	●	F	1	MC6125	FP	320 – 505	0.04 – 0.20	0.20 – 0.90
			●	F	2	MC6125	FV	320 – 505	0.04 – 0.20	0.20 – 0.90
			●	L	1	MC6125	LP	320 – 505	0.06 – 0.25	0.20 – 1.00
			●	L	2	MC6115	R-Std	245 – 475	0.08 – 0.30	0.30 – 2.00
			●	M	1	MC6125	MP	270 – 420	0.08 – 0.30	0.30 – 2.00
			●	M	2	MC6115	MP	245 – 475	0.08 – 0.30	0.30 – 2.00
			●	M	3	MC6125	MV	270 – 420	0.08 – 0.30	0.30 – 2.00
			●	M	4	MC6115	MV	245 – 475	0.08 – 0.30	0.30 – 2.00
			✣	L	1	MC6125	LP	320 – 505	0.06 – 0.25	0.20 – 1.00
			✣	L	2	MC6135	LP	265 – 400	0.06 – 0.25	0.20 – 1.00
			✣	M	1	MC6125	MP	270 – 420	0.08 – 0.30	0.30 – 2.00
			✣	M	2	MC6135	MP	220 – 330	0.08 – 0.30	0.30 – 2.00
			✣	M	3	MC6125	MV	270 – 420	0.08 – 0.30	0.30 – 2.00
			✣	M	4	MC6135	MV	220 – 330	0.08 – 0.30	0.30 – 2.00
	Carbon steel Alloy steel	180 – 280HB	●	F	1	MC6125	FP	240 – 370	0.04 – 0.20	0.20 – 0.90
			●	F	2	MC6125	FV	240 – 370	0.04 – 0.20	0.20 – 0.90
			●	L	1	MC6125	LP	240 – 370	0.06 – 0.25	0.20 – 1.00
			●	L	2	MC6115	LP	220 – 420	0.06 – 0.25	0.20 – 1.00
			●	M	1	MC6125	MP	200 – 310	0.08 – 0.30	0.30 – 2.00
			●	M	2	MC6125	MV	200 – 310	0.08 – 0.30	0.30 – 2.00
			●	M	3	MC6115	R-Std	180 – 350	0.08 – 0.30	0.30 – 2.00
			●	M	4	MC6125	R-Std	200 – 310	0.08 – 0.30	0.30 – 2.00
			✣	L	1	MC6125	LP	240 – 370	0.06 – 0.25	0.20 – 1.00
			✣	L	2	MC6135	LP	195 – 295	0.06 – 0.25	0.20 – 1.00
			✣	M	1	MC6125	MP	200 – 310	0.08 – 0.30	0.30 – 2.00
			✣	M	2	MC6135	MP	160 – 245	0.08 – 0.30	0.30 – 2.00
			✣	M	3	MC6125	MV	200 – 310	0.08 – 0.30	0.30 – 2.00
			✣	M	4	MC6135	MV	160 – 245	0.08 – 0.30	0.30 – 2.00

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1. Recommended cutting conditions for 5° / 7° / 11° positive inserts are provided as a guideline only.
   Verify the recommended conditions for each boring bar as cutting conditions for internal machining will vary depending on the length of overhang.

Cutting conditions : ● : Stable cutting ● : General cutting ✣ : Unstable cutting

RECOMMENDED CUTTING CONDITIONS

MC5100 SERIES – 5°, 7° POSITIVE INSERTS (FOR EXTERNAL TURNING)

	Material	Properties	Cutting mode	Grade	Vc
K	Gray cast iron	Tensile strength ≤350MPa	●	MC5115	190 – 350
			◐	MC5115	140 – 270
			✣	MC5115	80 – 150
	Ductile cast iron	Tensile strength ≤450MPa	●	MC5115	170 – 320
			◐	MC5115	130 – 250
			✣	MC5125	60 – 130
		Tensile strength ≤800MPa	●	MC5115	125 – 240
			◐	MC5115	105 – 200
			✣	MC5125	55 – 115

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MC5100 SERIES – 11° POSITIVE INSERTS (FOR EXTERNAL TURNING)

	Material	Properties	Cutting mode	Grade	Vc
K	Gray cast iron	Tensile strength ≤350MPa	●	MC5115	150 – 300
			◐	MC5115	140 – 270
			✣	MC5115	80 – 150
	Ductile cast iron	Tensile strength ≤450MPa	●	MC5115	170 – 320
			◐	MC5115	130 – 250
			✣	MC5125	60 – 130
		Tensile strength ≤800MPa	●	MC5115	125 – 240
			◐	MC5115	105 – 200
			✣	MC5125	55 – 115

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Cutting area		f	ap
Light cutting	LK	0.06 – 0.25	0.2 – 1.0
	SW	0.06 – 0.24	0.2 – 1.5
Medium cutting	MK	0.08 – 0.30	0.3 – 2.0
	MV	0.08 – 0.30	0.3 – 2.0
	Standard	0.08 – 0.30	0.3 – 2.0
	MW	0.10 – 0.35	0.8 – 2.5
Heavy cutting	Flat Top	0.08 – 0.30	0.3 – 2.0

Cutting conditions : ● : Stable cutting ◐ : General cutting ✣ : Unstable cutting

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