

HOW TO READ THE STANDARD OF EXTERNAL TURNING TOOLS

●How this section page is organised

- ① Organised according to turning insert shape.
(Refer to the index on the next page.)

TYPE OF TOOL HOLDER

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

TITLE OF PRODUCT BY INSERT TYPE

PRODUCT SECTION

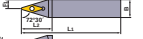
EXTERNAL TURNING TOOLS

VN INSERTS TOOL HOLDERS

DVNN		External turning, Copying		DOUBLE CLAMP type		Finish		Light		Medium		Medium			
						FH		LP		MP		MP			
72° 30'						(16)		(16)		(16)		(16)			
						Medium		Stainless		G Class		CBN			
						Standard		MS		RL		(16)			
						(16)		(16)		(16)		(16)			
Order Number	Stock	Insert Number	Dimensions (mm)												
DVNN2020K16	●	VNMA VNMA VNMA VNMA	1604	20	20	125	38	20	10	DC50N2	LLP13	DC3113	DC52	DC520T	TKY15F
2525M16	●	VNMA VNMA VNMA VNMA	1604	25	25	150	38	25	12.5	DC50N2	LLP13	DC3113	DC52	DC520T	TKY15F

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▲ Clamp Torque (N·m) : DC520T=3.5

PVVN		External turning, Copying		MP type		Finish		Light		Medium		Medium			
															
72° 30'						(P1)		(UP)		(MP)		(MP)			
						Medium		Stainless		G Class		CBN			
						Standard		MS		RL		CBN			
						(16)		(16)		(16)		(16)			
Order Number	Stock	Insert Number	Dimensions (mm)								Shim	Lock Pin	Lock Screw	Stop Ring	Wrench
PVNN2020K16	●	VNMA VNMA VNMA VNMA	1604	20	20	125	38	20	10	PV321	P115	HSP05008C	E03	HKY25R	
2525M16	●	VNMA VNMA VNMA VNMA	1604	25	25	150	38	25	12.5	PV322	P115	HSP05008C	E03	HKY25R	

▲ Clamp Torque (N·m) : HSP05008C=2.5

(Note) Insert photo, letters show chip breaker style, figures show insert dimensions.

● : Inventory maintained.
* : Inventory maintained in Japan.

DVNN type inserts > A11E-A11F
PVNN type inserts > A11E-A11F

CBN & PCD inserts > B030, B050
SOMERSED CUTTING CONDITIONS > A870

LEGEND FOR STOCK STATUS MARK

is shown on the left hand page of each double-page spread.

PRODUCT STANDARDS

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

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

GEOMETRY

CHIP BREAKER BY CUTTING APPLICATION

DVPN		Facing, Copying		DOUBLE CLAMP type		Finish		Light		Medium		Medium				
		(16)		(16)		Medium		Stainless		G Class		CBN				
		Standard		MS		RL		(16)		(16)		(16)				
		(16)		(16)		(16)		(16)		(16)		(16)				
Order Number	Stock	Insert Number	Dimensions (mm)								Insert	Shim	Shim Pin	Lock Pin	Lock Screw	Wrench
			H1	B	L1	L2	H2	F5	Shim	Shim Pin	Lock Pin	Lock Screw	Wrench			
DVNNRL2020K16	●	VNMA VNMA VNMA VNMA	1604	20	20	125	32	20	25	DC50N2	LLP13	DC3113	DC52	DC520T	TKY15F	
2525M16	●	VNMA VNMA VNMA VNMA	1604	25	25	150	32	25	32	DC50N2	LLP13	DC3113	DC52	DC520T	TKY15F	

▲ Clamp Torque (N·m) : DC520T=3.5

PVPN		Facing, Copying		MP type		Finish		Light		Medium		Medium					
117° 30'		27° 30'		Right hand tool holder right hand shown.		P1		UP		MP		MP					
(16)		(16)		(16)		Standard		Stainless		G Class		CBN					
(16)		(16)		(16)		RL		(16)		(16)		(16)					
(16)		(16)		(16)		(16)		(16)		(16)		(16)					
Order Number	Stock	Insert Number	Dimensions (mm)				H1	B	L1	L2	H2	F5	Shim	Lock Pin	Lock Screw	Stop Ring	Wrench
PVNNRL2020K16	●	VNMA VNMA VNMA VNMA	1604	20	20	125	32	20	25	PV321	P115	HSP05008C	E03	HKY25R			
2525M16	●	VNMA VNMA VNMA VNMA	1604	25	25	150	32	25	32	PV322	P115	HSP05008C	E03	HKY25R			

▲ Clamp Torque (N·m) : HSP05008C=2.5

PAGE REFERENCE

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