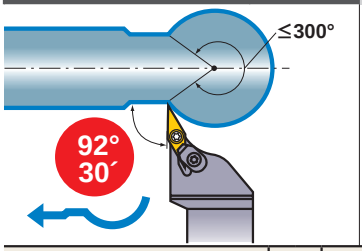
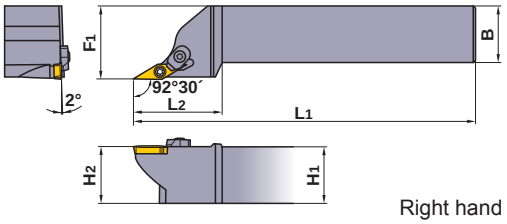
SXZC

External turning, Copying — ***Profile Holder***

Finish: SVX





(15)

Right hand tool holder shown.

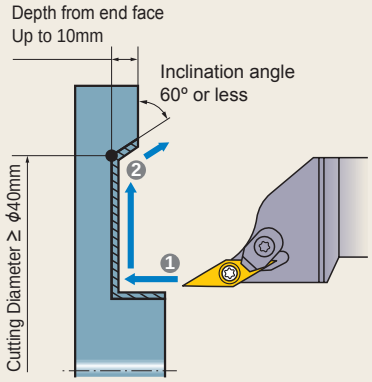
Order Number	Stock R	Stock L	Insert Number		Dimensions (mm) H1	B	L1	L2	H2	F1	Clamp Screw *	Clamp Bridge	Clamp Bridge Screw *	Spring	Insert Wrench	Wrench (Clamp bridge)
SXZCR/L1616H15	●	●	XCMT	1503○○-SVX	16	16	100	35	16	20	TS255	AMS3	AJS3010T10	ASS2	TKY08F	TKY10F
2020K15	●	●	XCMT	1503○○-SVX	20	20	125	35	20	25	TS255	AMS3	AJS3010T10	ASS2	TKY08F	TKY10F
2525M15	●	●	XCMT	1503○○-SVX	25	25	150	40	25	32	TS255	AMS3	AJS3010T10	ASS2	TKF08F	TKF10F

∗ Clamp Torque (N • m) : TS255=1.0, AJS3010T10=2.5

NOTE

Notes when end face copying

Pay special attention to the following when face copying.



●Machining of an outer diameter (Step ①)

- To prevent burr formation, the depth of cut should be below half the nose radius.

●Machining of an inclination (Step ②)

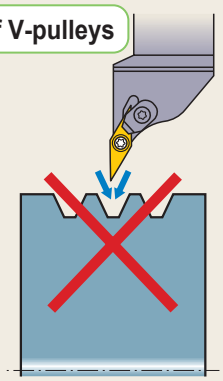
- To reduce the contact length of chips, the depth of cut should be below half the nose radius.
- To prevent interference between the tool and the workpiece, the cutting diameter should be 40mm or larger, inclination angle 60° or less and depth from the end face up to 10mm.

●When changing inserts

- When indexing the inserts, it is recommended to preset the cutting edge position to maintain machining accuracy.

Not possible

Machining of V-pulleys



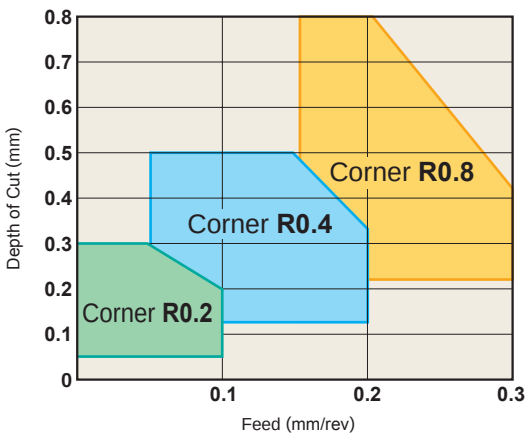
When machining V-pulleys, use a VNMG insert.

RECOMMENDED CUTTING CONDITIONS

	Work Material	Hardness	Grade	Cutting Speed (m/min)
P	Mild Steel	≤180HB	**UE6020**	150−350
	Carbon Steel, Alloy Steel	150HB−250HB	**UE6020**	100−250
M	Stainless Steel	≤200HB	**VP15TF**	100 (70−120)

(Note) The above cutting conditions are general guidelines.
Adjustments maybe necessary depending on machine rigidity, workpiece geometry and clamping.

APPLICABLE RANGE



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

● : **Inventory maintained.**