

VD^{DS} INSERTS TOOL HOLDERS

SVJD

External turning, Copying

AL type

Finish

R/L



(16)

PCD

R/L-F



(16)

Right hand tool holder shown.

EXTERNAL TURNING

Order Number	Stock		Insert Number		Dimensions (mm)					 *		
	R	L			H1	B	L1	L3	H2	F1	Clamp Screw	Wrench
SVJDR/L1616H16	●	●	VDGX	1603 ^{DS}	16	16	100	30	16	20	FC400890T	TKY10F
2020K16	●	●		1603 ^{DS}	20	20	125	30	20	25	FC400890T	TKY10F
2525M16	●	●		1603 ^{DS}	25	25	150	30	25	32	FC400890T	TKY10F

★ Clamp Torque (N • m) : FC400890T=2.5

RECOMMENDED CUTTING CONDITIONS

	Work Material	Grade	Cutting Speed (m/min)	Feed (mm/rev)	Depth of Cut (mm)
N	Aluminium Alloy	HTi10	400	0.05—0.3	0.2—3.0
		MD220	800	0.05—0.3	0.2—0.5

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

SVJD type inserts > A155

PCD inserts > B055

SPARE PARTS > M001

TECHNICAL DATA > N001