

HOW TO READ THE STANDARD OF SMALL TOOLS

●How this section page is organised

- ①Organised according to the cutting mode of small tools.
(Refer to the inside title on the next page.)
- ②Shown as Turning → External Grooving → External Cutting Off → Threading → Boring.

TYPE OF TOOL HOLDER

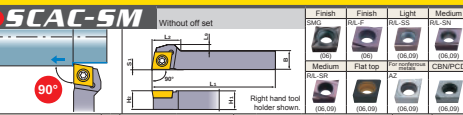
indicates the first four letters of the order number, as well as cutting applications.

APPLICATION

PRODUCT SECTION

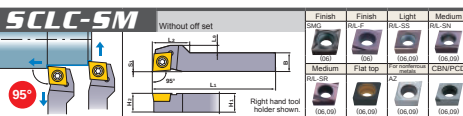
SMALL TOOLS

EXTERNAL FRONT TURNING



Order Number	Stock	Insert Number	Dimensions (mm)	Finish	Finish	Light	Medium
SCACRL0808K06-SM	+	060200	8 8 125 11 1.6 8 0	TS254	TKY08R		
1010K06-SM	+	060200	10 10 125 - - 10 0	TS254	TKY08R		
1010K09-SM	+	09T300	10 10 125 16 3.5 10 0	TS43	TKY15R		
1212W09-SM	+	09T300	12 12 150 14 1.5 12 0	TS43	TKY15R		
1616W09-SM	+	09T300	16 16 150 - - 16 0	TS43	TKY15R		

* Clamp Torque (N·m) : TS254=1.0, TS43=3.5



Order Number	Stock	Insert Number	Dimensions (mm)	Finish	Finish	Light	Medium
SCLCRL0808K06-SM	+	060200	8 8 125 11 2.1 8 0	TS254	TKY08R		
1010K06-SM	+	060200	10 10 125 - - 10 0	TS254	TKY08R		
1010K09-SM	+	09T300	10 10 125 20 4 10 0	TS43	TKY15R		
1212W09-SM	+	09T300	12 12 150 18 2 12 0	TS43	TKY15R		
1616W09-SM	+	09T300	16 16 150 - - 16 0	TS43	TKY15R		

* Clamp Torque (N·m) : TS254=1.0, TS43=3.5

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

* : Inventory maintained in Japan.

SCAC-SM type inserts > A127-A132
SCLC-SM type inserts > A127-A132
CBN & PCD inserts > B034, B035, B051

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.

REFERENCE PAGE FOR APPLICABLE INSERTS

indicates reference pages giving details of inserts that are applicable to the product.

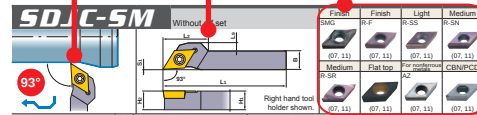
RECOMMENDED CUTTING CONDITIONS

for each work material classification, indicates recommended cutting conditions according to the ISO categories for cutting grades, P, M, K and N.

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

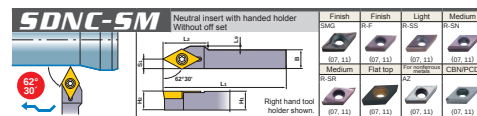
GEOMETRY

CHIP BREAKER BY CUTTING APPLICATION



Order Number	Stock	Insert Number	Dimensions (mm)	Finish	Finish	Light	Medium
SDJCRL0808K07-SM	+	070200	8 8 125 15 2 8 0	TS254	TKY08R		
1010K07-SM	+	070200	10 10 125 - - 10 0	TS254	TKY08R		
1010K11-SM	+	11T300	10 10 125 24 4 10 0	TS43	TKY15R		
1212W11-SM	+	11T300	12 12 150 22 2 12 0	TS43	TKY15R		
1616W11-SM	+	11T300	16 16 150 - - 16 0	TS43	TKY15R		

* Clamp Torque (N·m) : TS254=1.0, TS43=3.5



Order Number	Stock	Insert Number	Dimensions (mm)	Finish	Finish	Light	Medium
SDNCRL0808K07-SM	+	070200	8 8 125 - - 8 3	TS254	TKY08R		
1010K07-SM	+	070200	10 10 125 - - 10 3	TS254	TKY08R		
1010K11-SM	+	11T300	10 10 125 24 2 10 5	TS43	TKY15R		
1212W11-SM	+	11T300	12 12 150 - - 12 5	TS43	TKY15R		
1616W11-SM	+	11T300	16 16 150 - - 16 5	TS43	TKY15R		

* Clamp Torque (N·m) : TS254=1.0, TS43=3.5

RECOMMENDED CUTTING CONDITIONS

Work Material	Hardness	Grade	Cutting Speed (m/min)	Feed (mm/rev)
Carbon Steel	180HB-200HB	VP15TF	100 (50-150)	0.08 (0.01-0.15)
Alloy Steel	110 (50-160)	VP15TF	110 (50-160)	0.08 (0.01-0.15)
Free Cutting Steel	-	NK32S	150 (50-250)	0.08 (0.01-0.15)
Stainless Steel	<200HB	VP15TF	80 (50-120)	0.06 (0.02-0.1)
Non-Ferrous Metal	-	HT10B	150 (70-230)	0.09 (0.03-0.15)

SDJC-SM type inserts > A134-A138
SDNC-SM type inserts > A134-A138
CBN & PCD inserts > B037, B038, B052

PAGE REFERENCE

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