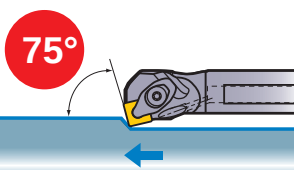
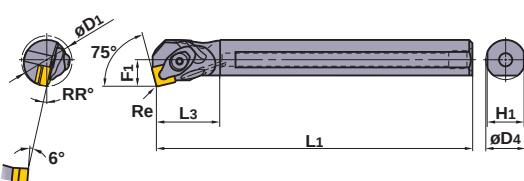
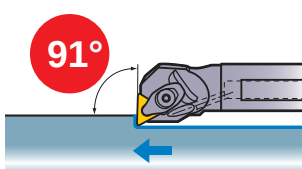
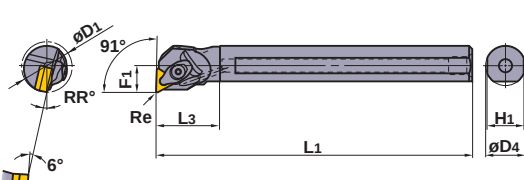


DSKN		With coolant hole SN $\circ$ inserts										Finish		Light		Medium		Medium	
																			
												(12)		(12)		(12)		(12)	
												Medium		Stainless		G Class		CBN	
												Standard		MM		R/L			
Right hand tool holder shown.												(12)		(12)		(12)		(12)	
Order Number	Stock	Insert Number	Dimensions (mm)							Min. Cutting Diameter D1	Standard Corner Radius Re								
			D4	L1	L3	F1	H1	RR°											
A25R-DSKNR/L12	★ ★	SNMA SNMG SNMM SNGA SNGG	1204 $\circ$	25	200	40	17	23	13	32	0.8	LLSSP42	LLP14	DCK2613	DCS1	DC0621T	TKY20F		
A32S-DSKNR/L12	★ ★	SNMA SNMG SNMM SNGA SNGG	1204 $\circ$	32	250	50	22	30	13	40	0.8	LLSSN42	LLP14	DCK2613	DCS1	DC0621T	TKY20F		

★ Clamp Torque (N • m) : DC0621T=5.0

DTFN		With coolant hole TN $\circ$ inserts										Finish		Light		Medium		Medium	
																			
												(16)		(16)		(16)		(16)	
												Medium		Stainless		G Class		CBN	
												Standard		MM		R/L			
Right hand tool holder shown.												(16)		(16)		(16)		(16)	
Order Number	Stock		Insert Number	Dimensions (mm)							Min. Cutting Diameter D1	Standard Corner Radius Re							
	R	L		D4	L1	L3	F1	H1	RR°										
A25R-DTFNR/L16	★	★	TNMA TNMG TNMM TNGA TNGG	1604 $\circ$	25	200	40	17	23	13	32	0.8	LLSTP32	LLP23	DCK2211	DCS2	DC0520T	TKY15F	
A32S-DTFNR/L16	★	★	TNMA TNMG TNMM TNGA TNGG	1604 $\circ$	32	250	50	22	30	13	40	0.8	LLSTN32	LLP23	DCK2211	DCS2	DC0520T	TKY15F	

★ Clamp Torque (N • m) : DC0520T=3.5

RECOMMENDED CUTTING CONDITIONS

Work Material	Hardness	Cutting Mode	l/d ≤ 3			l/d = 3—4		
			Cutting Speed (m/min)	Feed (mm/rev)	Depth of Cut (mm)	Cutting Speed (m/min)	Feed (mm/rev)	Depth of Cut (mm)
P Carbon Steel Alloy Steel	180—350HB	Medium	110 (80—140)	0.25 (0.1—0.4)	—5.0	110 (80—140)	0.2 (0.1—0.3)	—4.0
M Stainless Steel	≤200HB	Medium	80 (60—100)	0.2 (0.1—0.3)	—4.0	70 (50—100)	0.15 (0.1—0.25)	—3.0
K Cast Iron	Tensile Strength ≤350MPa	Medium	80 (60—100)	0.25 (0.1—0.4)	—5.0	80 (60—100)	0.2 (0.1—0.3)	—4.0

SN $\circ$ type inserts > A105—A109

TN $\circ$ type inserts > A110—A115

CBN & PCD inserts > B027—B029, B049

SPARE PARTS > M001

TECHNICAL DATA > N001