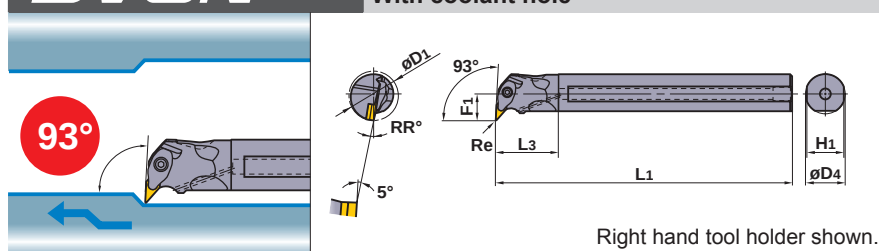


BORING BARS

DOUBLE CLAMP DIMPLE BAR

DVUN

With coolant hole VN $\circ\circ$ inserts



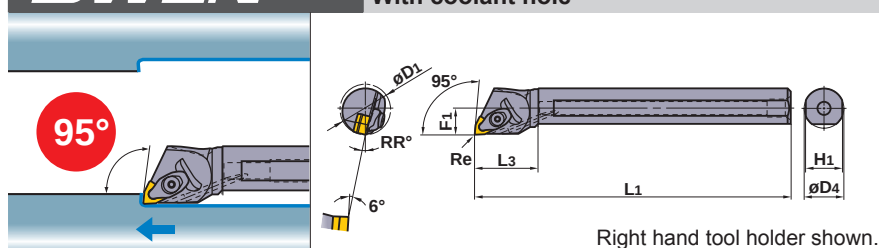
Finish	Light	Medium	Medium
FH	LP	MP	MK
(16)	(16)	(16)	(16)
Medium	Stainless	G Class	CBN
Standard	MM	R/L	
(16)	(16)	(16)	(16)

Order Number	Stock		Insert Number	Dimensions (mm)							Min. Cutting Diameter D1	Standard Corner Radius Re						
	R	L		D4	L1	L3	F1	H1	RR°				Shim	Shim Pin	Clamp Bridge	Spring	Clamp Screw	Wrench
A40T-DVUNR/L16	★	★	VNMA VNMG VNGA	1604 $\circ\circ$	40	300	63	27	37	9	50	0.8	DCSVN32	LLP13	DCK3113	DCS2	DC0520T	TKY15F

★ Clamp Torque (N • m) : DC0520T=3.5

DWLN

With coolant hole WN $\circ\circ$ inserts



Finish	Light	Medium	Medium
FH	LP	MP	MK
(08)	(08)	(06,08)	(08)
Medium	Medium—Rough	Stainless	
Standard	RP	MM	
(08)	(08)	(06,08)	

Order Number	Stock		Insert Number	Dimensions (mm)							Min. Cutting Diameter D1	Standard Corner Radius Re						
	R	L		D4	L1	L3	F1	H1	RR°				Shim	Shim Pin	Clamp Bridge	Spring	Clamp Screw	Wrench
A25R-DWLNR/L06	★	★	WNMG	0604 $\circ\circ$	25	200	40	17	23	13	32	0.8	LLSWP32	LLP23	DCK2211	DCS2	DC0520T	TKY15F
A25R-DWLNR/L08	★	★		0804 $\circ\circ$	25	200	40	17	23	13	32	0.8	LLSWP42	LLP14	DCK2613	DCS1	DC0621T	TKY20F
A32S-DWLNR/L08	★	★	WNMA WNMG	0804 $\circ\circ$	32	250	50	22	30	13	40	0.8	LLSWN42	LLP14	DCK2613	DCS1	DC0621T	TKY20F
A40T-DWLNR/L08	★	★		0804 $\circ\circ$	40	300	63	27	37	10	50	0.8	LLSWN42	LLP14	DCK2613	DCS1	DC0621T	TKY20F

★ Clamp Torque (N • m) : DC0520T=3.5, DC0621T=5.0

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

(Note 1) Insert photo, letters show chip breaker style, figures show insert dimensions.

(Note 2) When using inserts with right or left hand chip breakers, please use left hand inserts for right hand holders and right hand inserts for left hand holders.

● : Inventory maintained. ★ : Inventory maintained in Japan.

VN $\circ\circ$ type inserts > A116—A118

WN $\circ\circ$ type inserts > A119—A123

CBN & PCD inserts > B030, B031, B050