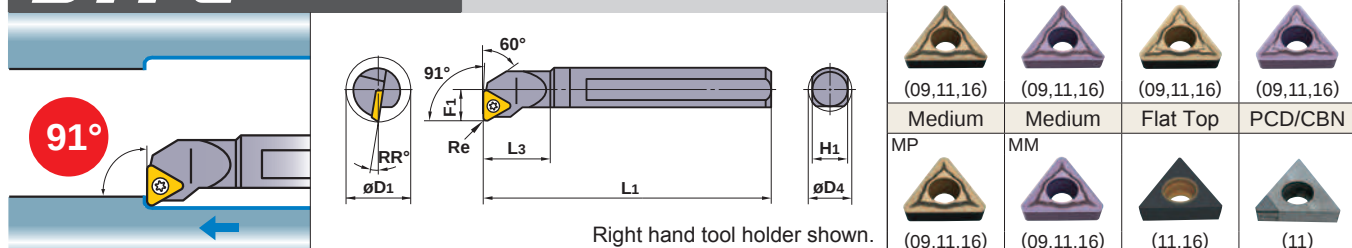


S TYPE BORING BARS

- ISO standard.
- 7° positive insert.
- Screw-on type.
- l/d is 3 to 5 times the diameter (up to 7 times with the carbide shank).

STFC

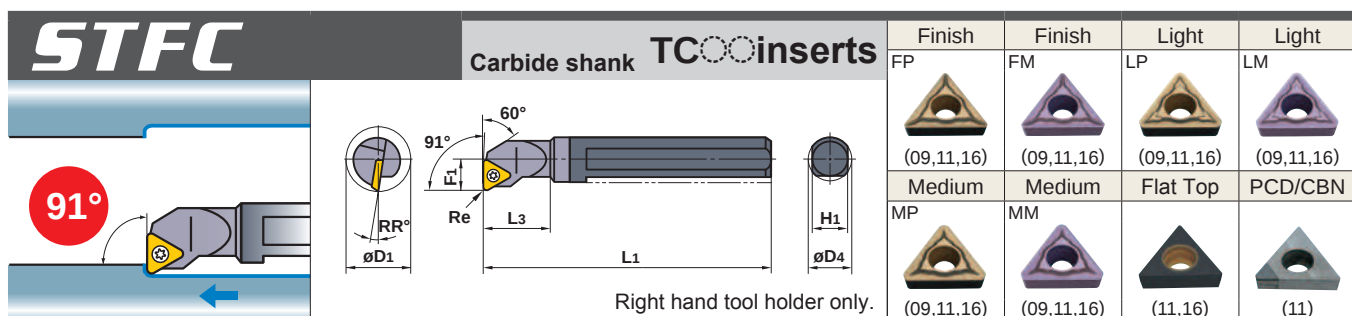
TC[○]inserts



Right hand tool holder shown.

Order Number	Stock		Insert Number	Dimensions (mm)						Min. Cutting Diameter	Standard Corner Radius	 *		
	R	L		D4	L1	L3	F1	H1	RR°					D1
S08FSTFCR/L09	●	●	TCMT	0902	8	80	12	6	7	15	11	0.4	TS22	TKY06F
S10HSTFCR/L11	●	●	TCMW TCMT	1102	10	100	16	7	9	13	13	0.4	TS25	TKY08F
S12KSTFCR/L11	●	●		1102	12	125	20	9	11	10	16	0.4	TS25	TKY08F
S16MSTFCR/L11	●	●		1102	16	150	25	11	14	7	20	0.4	TS25	TKY08F
S20QSTFCR/L16	●	●		16T3	20	180	32	13	18	7	25	0.8	TS4	TKY15F
S25RSTFCR/L16	●	●		16T3	25	200	40	17	23	5	32	0.8	TS4	TKY15F
S32SSTFCR/L16	●	●		16T3	32	250	50	22	30	5	40	0.8	TS4	TKY15F

* Clamp Torque (N • m) : TS22=0.6, TS25=1.0, TS4=3.5



Right hand tool holder only.

Order Number	Stock	Insert Number		Dimensions (mm)						Min. Cutting Diameter	Standard Corner Radius		
	R			D4	L1	L3	F1	H1	RR°			D1	Re
C08HSTFCR09	●	TCMT	0902	8	100	12	6	7	15	11	0.4	TS22	TKY06F
C10KSTFCR11	●	TCMW TCMT	1102	10	125	16	7	9	13	13	0.4	TS25	TKY08F
C12MSTFCR11	●		1102	12	150	20	9	11	10	16	0.4	TS25	TKY08F
C16RSTFCR11	●		1102	16	200	25	11	14	7	20	0.4	TS25	TKY08F
C20SSTFCR16	●		16T3	20	250	32	13	18	7	25	0.8	TS4	TKY15F
C25TSTFCR16	●		16T3	25	300	40	17	23	5	32	0.8	TS4	TKY15F

* Clamp Torque (N • m) : TS22=0.6, TS25=1.0, TS4=3.5

RECOMMENDED CUTTING CONDITIONS

Steel Shank			l/d ≤ 3			l/d = 3 - 4 (Shank Diameter ≥ 25mm)		
Carbide Shank			l/d ≤ 5			l/d = 6 - 7		
Work Material	Hardness	Cutting Mode	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	Light Cutting	130 (90-160)	0.1 (0.05-0.15)	0.2	120 (80-150)	0.1 (0.05-0.15)	0.2
		Medium Cutting	90 (60-120)	0.25 (0.15-0.35)	-3.0	80 (50-110)	0.15 (0.1-0.2)	-1.5
M Stainless Steel	≤200HB	Light Cutting	140 (100-180)	0.1 (0.05-0.15)	0.2	140 (100-180)	0.1 (0.05-0.15)	0.2
		Medium Cutting	70 (50-90)	0.2 (0.15-0.25)	-2.0	60 (40-80)	0.15 (0.1-0.2)	-1.0
N Aluminium Alloy	—	Light Cutting	300 (200-400)	0.1 (0.05-0.15)	0.2	300 (200-400)	0.1 (0.05-0.15)	0.2
		Medium Cutting	200 (150-250)	0.1 (0.05-0.15)	-2.0	200 (150-250)	0.1 (0.05-0.15)	-1.5

TC[○] type inserts > A144, A145

CBN & PCD inserts > B039, B053

SPARE PARTS > M001

TECHNICAL DATA > N001