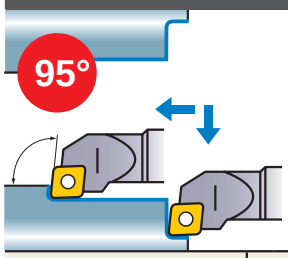
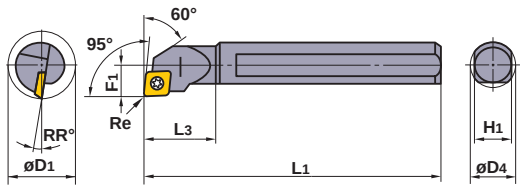
SCLC — CC○○inserts





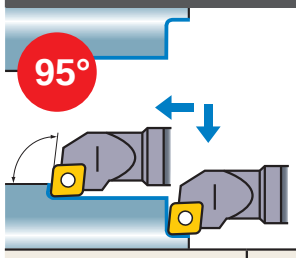
Right hand tool holder shown.

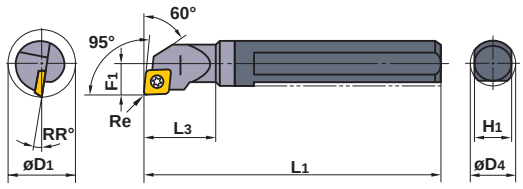
Finish	Finish	Light	Light
FP	FM	LP	LM
			
(06,09)	(06,09)	(06,09)	(06,09)
Medium	Medium	Flat Top	PCD/CBN
MP	MM		
			
(06,09,12)	(06,09,12)	(06,09,12)	(06,09,12)

Order Number	Stock		Insert Number		Dimensions (mm)						Min. Cutting Diameter	Standard Corner Radius	*	
	R	L			D4	L1	L3	F1	H1	RR°	D1	Re	Clamp Screw	Wrench
S08FSCLCR/L06	●	●	CCMH CCMT CCET CCGT CCMW CCGW NP-CCGW	0602○○	8	80	12	6	7	15	11	0.4	TS25	TKY08F
S10HSCLCR/L06	●	●		0602○○	10	100	16	7	9	13	13	0.4	TS25	TKY08F
S12KSCLCR/L06	●	●		0602○○	12	125	20	9	11	10	16	0.4	TS25	TKY08F
S16MSCLCR/L09	●	●		09T3○○	16	150	25	11	14	7	20	0.8	TS4	TKY15F
S20QSCLCR/L09	●	●		09T3○○	20	180	32	13	18	7	25	0.8	TS4	TKY15F
S25RSCLCR/L12	●	●		1204○○	25	200	40	17	23	5	32	0.8	TS5	TKY25F
S32SSCLCR/L12	●	●		1204○○	32	250	50	22	30	5	40	0.8	TS5	TKY25F
S40TSCLCR/L12	●	●		1204○○	40	300	63	27	37	5	50	0.8	TS5	TKY25F

* Clamp Torque (N • m) : TS25=1.0, TS4=3.5, TS5=7.5

SCLC — Carbide shank CC○○inserts





Right hand tool holder only.

Finish	Finish	Light	Light
FP	FM	LP	LM
			
(06,09)	(06,09)	(06,09)	(06,09)
Medium	Medium	Flat Top	PCD/CBN
MP	MM		
			
(06,09,12)	(06,09,12)	(06,09,12)	(06,09,12)

Order Number	Stock	Insert Number		Dimensions (mm)						Min. Cutting Diameter	Standard Corner Radius	*	
	R			D4	L1	L3	F1	H1	RR°	D1	Re	Clamp Screw	Wrench
C08HSCLCR06	●	CCMH CCMT CCET CCGT CCMW CCGW NP-CCGW	0602○○	8	100	12	6	7	15	11	0.4	TS25	TKY08F
C10KSCLCR06	●		0602○○	10	125	16	7	9	13	13	0.4	TS25	TKY08F
C12MSCLCR06	●		0602○○	12	150	20	9	11	10	16	0.4	TS25	TKY08F
C16RSCLCR09	●		09T3○○	16	200	25	11	14	7	20	0.8	TS4	TKY15F
C20SSCLCR09	●		09T3○○	20	250	32	13	18	7	25	0.8	TS4	TKY15F

* Clamp Torque (N • m) : 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

BORING

CC○○ type inserts ➤ A127—A132
CBN & PCD inserts ➤ B034, B035, B051
SPARE PARTS ➤ M001
TECHNICAL DATA ➤ N001