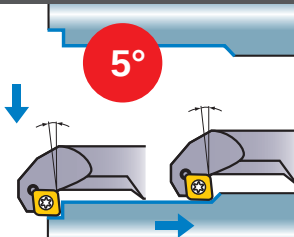
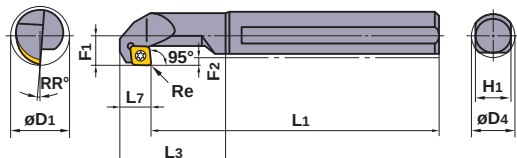


SCZC		CC ^o inserts										Finish		Finish		Light		Light	
												FP	FM	LP	LM				
																			
												(06,09)	(06,09)	(06,09)	(06,09)				
												Medium	Medium	Flat Top	PCD/CBN				
		Right hand tool holder shown.										MP	MM						
																			
												(06,09)	(06,09)	(06,09)	(06,09)				
Order Number	Stock		Insert Number	Dimensions (mm)								Min. Cutting Diameter	Standard Corner Radius	 *					
	R	L		D4	L1	L3	L7	F1	F2	H1	RR°					D1	Re	Clamp Screw	Wrench
S16MSCZCR/L06	●	●	CCMH CCMT CCCT CCGT CCMW CCGW	0602 ^o	16	150	36	11	11	3	14	10	20	0.4	TS25	TKY08F			
S20QSCZCR/L09	●	●		09T3 ^o	20	180	50	18	13	3	18	7	25	0.8	TS4	TKY15F			

(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 right hand inserts for right hand holders and left hand inserts for left hand holders.

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

RECOMMENDED CUTTING CONDITIONS

Work Material	Hardness	Cutting Mode	l/d ≤ 3			l/d = 3 - 4 (Shank Diameter ≥ 25mm)		
			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

CC^o type inserts > A127—A132

CBN & PCD inserts > B034, B035, B051

SPARE PARTS > M001

TECHNICAL DATA > N001