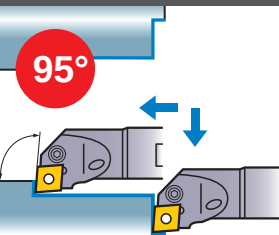
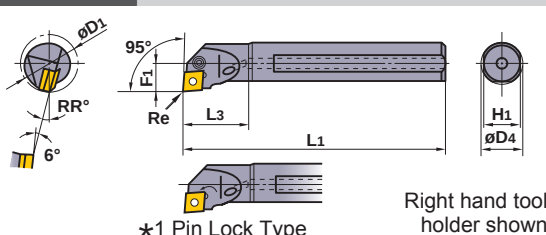


PDUN		With coolant hole DN $\circ$ inserts										Finish		Light	Medium	Medium							
 93°		 *1 Pin Lock Type Right hand tool holder shown.										FH	LP	MP	MH								
												(15)	(15)	(15)	(15)								
												Medium	Stainless	G Class	CBN								
												Standard	MM	R/L									
												(11,15)	(15)	(15)	(15)								
Order Number	Stock	Insert Number		Dimensions (mm)									Min. Cutting Diameter D1	Standard Corner Radius Re				*2			*2		
R	L			D4	L1	L3	F1	F2	H1	RR°													
A20QPDUNR/L11	●●	DNMA DNMG DNMX DNMM DNGA DNGG	1104 $\circ$	20	180	32	15	6.4	18	13	26	0.8	—	—	LLCL23S	LLCS125	HKY20R	HGM-PT1/8	—	—	—		
A25RPDUNR/L11	●●		1104 $\circ$	25	200	40	17	6.9	23	15	32	0.8	LLSDN32	LLP13	LLCL23	LLCS106	HKY25R	HGM-PT1/4	—	—	—		
*1 A25RPDUNR/L15	●●		1504 $\circ$	25	200	40	17	6.9	23	13	32	0.8	MLDP42	—	—	—	HKY15R HKY30R	HGM-PT1/4	HP43	P210AM	HSS03005		
A32SPDUNR/L11	●●		1104 $\circ$	32	250	50	22	8.4	30	13	44	0.8	LLSDN32	LLP13	LLCL23	LLCS106	HKY25R	HGM-PT3/8	—	—	—		
A32SPDUNR/L15	●●		1504 $\circ$	32	250	50	22	8.4	30	13	44	0.8	LLSDN42	LLP14	LLCL24	LLCS108S	HKY30R	HGM-PT3/8	—	—	—		
A40TPDUNR/L15	●●		1504 $\circ$	40	300	63	27	9.4	37	10	54	0.8	LLSDN42	LLP14	LLCL24	LLCS108S	HKY30R	HGM-PT3/8	—	—	—		
A50UPDUNR/L15	●●		1504 $\circ$	50	350	80	35	12.4	47	9	70	0.8	LLSDN42	LLP14	LLCL24	LLCS108S	HKY30R	HGM-PT3/8	—	—	—		

*2 Clamp Torque (N • m) : LLCS125=1.5, LLCS106=2.2, LLCS108S=3.3, HP43=3.3

PCLN		With coolant hole CN $\circ$ inserts										Finish		Light		Light		Medium				
																						
												(12)	(12)	(12)	(12)							
												Medium	Medium	Stainless	CBN							
												MH	Standard	MM								
												(12)	(09,12)	(12)	(12)							
Order Number	Stock		Insert Number	Dimensions (mm)							Min. Cutting Diameter D1	Standard Corner Radius Re										
	R	L		D4	L1	L3	F1	H1	RR°													
A16MPCLNR/L09	●	●	CNMA CNMG CNMM CNGG	09T3 $\circ$	16	150	25	11	14	15	20	0.8	—	—	LLCL13S	LLCS105	HKY20R	HGM-PT1/8	—	—	—	
*1 A20QPCNLNR/L09	●	●		09T3 $\circ$	20	180	32	13	18	13	25	0.8	—	—	—	—	HKY25R HKY15R	HGM-PT1/8	HP3T	P208AM	HSS03005	
A20QPCNLNR/L09N	●	★		09T3 $\circ$	20	180	32	13	18	13	25	0.8	—	—	LLCL13S	LLCS105	HKY20R	HGM-PT1/8	—	—	—	
A25RPCLNR/L09	●	●		09T3 $\circ$	25	200	40	17	23	13	32	0.8	—	—	LLCL13S	LLCS105	HKY20R	HGM-PT1/4	—	—	—	
*1 A25RPCLNR/L12	●	●		1204 $\circ$	25	200	40	17	23	13	32	0.8	MLCP42	—	—	—	—	HKY30R HKY15R	HGM-PT1/4	HP43	P210AM	HSS03005
A32SPCLNR/L12	●	●		1204 $\circ$	32	250	50	22	30	13	44	0.8	LLSCN42	LLP14	LLCL14	LLCS108S	HKY30R	HGM-PT3/8	—	—	—	
A40TPCLNR/L12	●	●		1204 $\circ$	40	300	63	27	37	10	54	0.8	LLSCN42	LLP14	LLCL14	LLCS108S	HKY30R	HGM-PT3/8	—	—	—	
A50UPCLNR12	●	●		1204 $\circ$	50	350	80	35	47	10	63	0.8	LLSCP42	LLP14	LLCL14	LLCS108S	HKY30R	HGM-PT3/8	—	—	—	

*2 Clamp Torque (N • m) : LLCS105=1.5, LLCS106=2.2, LLCS108S=3.3, HP3T=2.2, HP43=3.3

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 Cutting	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 Cutting	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 Cutting	80 (60—100)	0.25 (0.1—0.4)	—5.0	80 (60—100)	0.2 (0.1—0.3)	—4.0

DN $\circ$ type inserts > A098—A103

CN $\circ$ type inserts > A092—A097

CBN & PCD inserts > B022—B025, B048

SPARE PARTS > M001

TECHNICAL DATA > N001