

PDZN		With coolant hole										DN		Inserts		Finish		Light	Medium	Medium				
												FH	LP	MP	MH									
												(15)	(15)	(15)	(15)									
												Medium	Stainless	G Class	CBN									
												Standard	MM	R/L										
		*1 Pin Lock Type Right hand tool holder shown.										(15)	(15)	(15)	(15)									
Order Number	Stock		Insert Number	Dimensions (mm)										Min. Cutting Diameter	Standard Corner Radius									
	R	L		D4	L1	L3	F1	F2	H1	RR°	D1	Re	Shim											
*1 A25RPDZNR/L15	●	●	DNMA	1504	25	200	65	17	6.7	23	13	32	0.8	MLDP42	—	—	—	HKY15R HKY30R	HGM-PT1/4	HP43	P210AM	HSS03005		
A32SPDZNR/L15	●	●	DNMG	1504	32	250	75	22	8.2	30	13	40	0.8	LLSDN42	LLP14	LLCL24	LLCS108S	HKY30R	HGM-PT3/8	—	—	—		
A40TPDZNR/L15	●	●	DNMX	1504	40	300	88	27	9.2	37	10	50	0.8	LLSDN42	LLP14	LLCL24	LLCS108S	HKY30R	HGM-PT3/8	—	—	—		
A50UPDZNR/L15	●	●	DNMM	1504	50	350	105	35	12.2	47	9	63	0.8	LLSDN42	LLP14	LLCL24	LLCS108S	HKY30R	HGM-PT3/8	—	—	—		
	●	●	DNGA	1504																				
	●	●	DNGG	1504																				

(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.

*2 Clamp Torque (N • m) : LLCS108S=3.3, 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 type inserts > A098—A103

CBN & PCD inserts > B024, B025, B048

SPARE PARTS > M001

TECHNICAL DATA > N001