

HOW TO READ THE STANDARD OF EXTERNAL TURNING TOOLS

- How this section page is organized
- ① Organized according to turning insert shape.
(Refer to the index on the next page.)

TYPE OF TOOL HOLDER indicates the first four letters of the order number, as well as cutting applications.

TITLE OF PRODUCT BY INSERT TYPE

PRODUCT SECTION

FIGURE SHOWING THE TOOLING APPLICATION uses illustrations and arrows to depict the available machining applications such as external turning, copying, facing, and chamfering together with cutting edge lead angles.

GEOMETRY

CHIP BREAKER BY CUTTING APPLICATION

EXTERNAL TURNING TOOLS

VN INSERTS TOOL HOLDERS

MVLN Facing

Multiple Clamp Type M Holder

Medium

95°

Right hand tool holder shown.

Order Number	ANSI Number	Stock	Insert Number	Dimensions (inch)	Shim	Shim Pin	Clamp Bridge	Clamp Screw	#2
				H B LF LH HF WF					
MVLNRL-164C	MVLNRL164C	●	VNMG	43	1.000 1.000 5.000 1.500 1.000 1.750	IVSN433	NL46	CL30	XNS510
MVLNRL-164D	MVLNRL164D	●							
MVLNRL-204D	MVLNRL204D	●			1.250 1.250 6.000 1.500 1.250 2.000				
MVLNRL-244D	MVLNRL244D	●			1.500 1.500 6.000 1.500 1.500 2.250				

*1 (Cpt.) See page M012 for different radius.
*2 Clamp Torque (lbf-in) : XNS510=70

EXTERNAL TURNING TOOLS

DWLN External turning Facing

DOUBLE CLAMP Type

Finish Light Medium Medium

Medium Medium Medium Medium

Standard Medium Medium Medium Medium

95°

Right hand tool holder shown.

Order Number	ANSI Number	Stock	Insert Number	Dimensions (inch)	Shim	Shim Pin	Clamp Bridge	Clamp Screw	#2
				H B LF LH HF WF					
DWLNRL-123	DWLNRL123B	●	LSWN3	33	750 750 4.500 1.000 750 1.000	LLP250C0K271	DC320	DC0507T	TKY15F
DWLNRL-163	DWLNRL163D	●	VNMA		1.000 1.000 6.000 1.000 1.000 1.250				
DWLNRL-124	DWLNRL124B	●	VNMG		750 750 4.500 1.250 750 1.000				
DWLNRL-164	DWLNRL164D	●	VNMA	43	1.000 1.000 6.000 1.250 1.000 1.250	LSWN42	LLP140C0K13DC31	DC0621T	TKY20F
DWLNRL-204	DWLNRL204D	●			1.250 1.250 6.000 1.250 1.250 1.500				

*1 Please use shim no. LL5WN33 with 1.25inch thick insert. When using 1.25inch thick inserts, the shim must be ordered separately.
*2 Clamp Torque (lbf-in) : DC0507=31, DC0621T=44

EXTERNAL TURNING TOOLS

MWLN External turning Facing

Multiple Clamp Type M Holder

Finish Light Medium Medium

Medium Medium Medium Medium

Standard Medium Medium Medium Medium

95°

Right hand tool holder shown.

Order Number	ANSI Number	Stock	Insert Number	Dimensions (inch)	Shim	Shim Pin	Clamp Bridge	Clamp Screw	#2
				H B LF LH HF WF					
MWLNRL-1232	MWLNRL1232B	●			750 750 4.500 1.000 750 1.000				
MWLNRL-1632	MWLNRL1632D	●			1.000 1.000 6.000 1.000 1.000 1.250				
MWLNRL-1233	MWLNRL1233B	●			750 750 4.500 1.000 750 1.000				
MWLNRL-1633	MWLNRL1633D	●			1.000 1.000 6.000 1.000 1.000 1.250				
MWLNRL-124B	MWLNRL124B	●	VNMA		750 750 4.500 1.250 750 1.000				
MWLNRL-164D	MWLNRL164D	●	VNMG		1.000 1.000 6.000 1.250 1.000 1.250				
MWLNRL-204D	MWLNRL204D	●	VNMA	43	1.250 1.250 6.000 1.250 1.250 1.500				
MWLNRL-854D	MWLNRL854D	●			1.250 1.000 6.000 1.250 1.250 1.250				
MWLNRL-165D	MWLNRL165D	●			1.000 1.000 6.000 1.250 1.000 1.250				
MWLNRL-205D	MWLNRL205D	●			1.250 1.250 6.000 1.370 1.250 1.500				
MWLNRL-245E	MWLNRL245E	●			1.500 1.500 7.000 1.370 1.500 2.000				

* Clamp Torque (lbf-in) : XNS36=30, XNS48=45, XNS59=70

● : USA Stock □ : Made to Order

Legend for stock status mark is shown on the left hand page of each double-page spread.

PRODUCT STANDARDS indicates order numbers, stock status (per right/left hand), applicable inserts, dimensions, and spare parts.

REFERENCE PAGE FOR APPLICABLE INSERTS indicates reference pages giving details of inserts that are applicable to the product.

PAGE REFERENCE · SPARE PARTS · TECHNICAL DATA indicates reference pages, including the above, on the right hand page of each double-page spread.

● To Order : Please specify order number and hand of tool (right/left).

TURNING TOOLS

EXTERNAL TURNING TOOLS

CLASSIFICATION..... C002

IDENTIFICATION..... C004

METHOD OF HOLDING C005

STANDARD HOLDERS

CN[○] INSERTS TOOL HOLDERS..... C006

DN[○] INSERTS TOOL HOLDERS..... C010

RN[○] INSERTS TOOL HOLDERS..... C013

SN[○] INSERTS TOOL HOLDERS..... C014

TN[○] INSERTS TOOL HOLDERS..... C018

VN[○] INSERTS TOOL HOLDERS..... C024

WN[○] INSERTS TOOL HOLDERS..... C027

VB[○] INSERTS TOOL HOLDERS..... C028

CC[○] INSERTS TOOL HOLDERS..... C030

DC[○] INSERTS TOOL HOLDERS..... C031

RC[○] INSERTS TOOL HOLDERS..... C033

SC[○] INSERTS TOOL HOLDERS..... C034

TC[○] INSERTS TOOL HOLDERS..... C035

VC[○] INSERTS TOOL HOLDERS..... C036

WC[○] INSERTS TOOL HOLDERS..... C037

XC[○] INSERTS TOOL HOLDERS..... C038

RP[○] INSERTS TOOL HOLDERS..... C040

●AL HOLDER (FOR ALUMINUM TURNING)

DE[○] INSERTS TOOL HOLDERS C041

TE[○] INSERTS TOOL HOLDERS C042

VD[○] INSERTS TOOL HOLDERS C043

*Arranged by Alphabetical order

C006	DCLN	C010	MDJN	C032	SDXC
C008	DCRN	C011	MDPN	C033	SRDC
C010	DDJN	C013	MRGN	C040	SRDP
C011	DDPN	C016	MSDN	C033	SRGC
C012	DDQN	C017	MSKN	C034	SSBC
C013	DRGN	C014	MSRN	C034	SSSC
C016	DSDN	C015	MSSN	C035	STFC
C017	DSKN	C020	MTAN	C042	STFE
C014	DSRN	C021	MTCN	C035	STGC
C015	DSSN	C021	MTEN	C042	STGE
C022	DTCN	C023	MTFN	C029	SVHB
C022	DTFN	C019	MTGN	C028	SVJB
C018	DTGN	C018	MTJN	C036	SVJC
C024	DVJN	C020	MTRN	C043	SVJD
C025	DVPN	C024	MVJN	C036	SVPC
C025	DVVN	C026	MVLN	C043	SVPD
C027	DWLN	C027	MWLN	C028	SVVB
C009	MCFN	C030	SCLC	C037	SWLC
C008	MCGN	C031	SDJC	C038	SXZC
C007	MCLN	C041	SDJE		
C009	MCRN	C031	SDNC		



C001

CLASSIFICATION

Tool Holder	Features	External Turning Facing	External Turning Copying				External Turning		
		KAPR= 95°	KAPR= 93°	KAPR= 62.5° 72.5°		KAPR= 90°—91°			
DOUBLE CLAMP Holder 	● Double clamp type. ● Holds inserts securely. ● Excellent cutting edge tolerance. ● Economical negative insert. ● Recommended with CBN grade insert								
		DCLN ↻ C006	DWLN ↻ C027	DDJN ↻ C010	DVJN ↻ C024	DDPN ↻ C011	DVVN ↻ C025	DTGN ↻ C018	
M Holder 	● Negative rake clamp and locking pin tool holders. ● Insert is securely held by a shim pin and clamp bridge. ● Index operation is easy to perform. ● (Opt.) Single clamp available as clamp on or pin lock holder.								
		MCLN ↻ C007	MWLN ↻ C027	MDJN ↻ C010	MTJN ↻ C018	MVJN ↻ C024	MDPN ↻ C011	MCGN ↻ C008	MTGN ↻ C019
SP Holder 	● Small shank tool holder system using a 5°, 7° and 11° positive inserts retained by screw-on system.								
		SCLC ↻ C030	SWLC ↻ C037	SDJC ↻ C031	SVJC ↻ C036	SVJB ↻ C028	SDNC ↻ C031	SVVB ↻ C028	STGC ↻ C035
PROFILE Holder 	● 25° rhombic insert for profiling and face relief. ● Machine 300° of a sphere. ● Machine face relief to 60° angle. ● The cycle time can be reduced due to only one holder.								
AL Holder 	● Shank size .625 square thru 1.000 square with screw-on method. ● Suitable for finishing aluminum or non-ferrous metals and for chatter control on small diameters.								
			SDJE ↻ C041	SVJD ↻ C043			STGE ↻ C042		

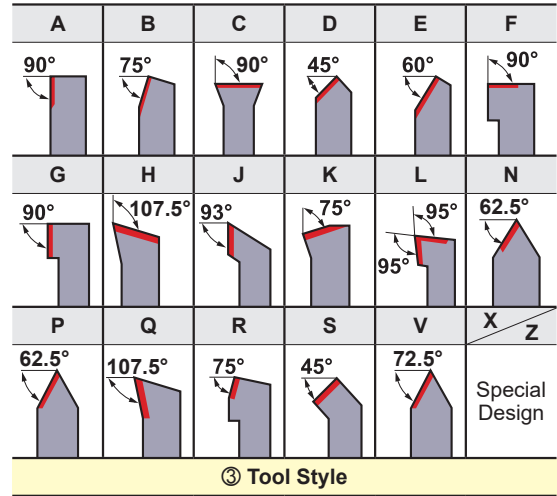
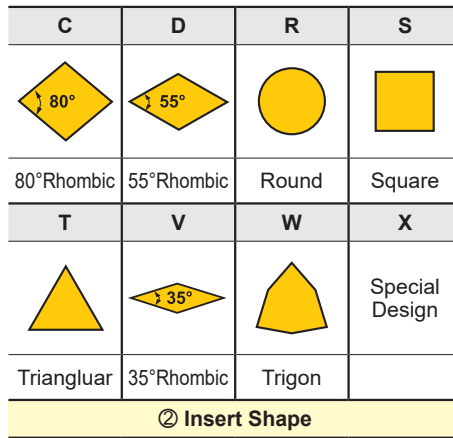
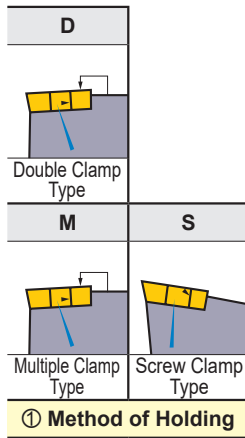
Note 1) ◎ : 1st recommendation. ○ : 2nd recommendation.

IDENTIFICATION

■ DOUBLE CLAMP Holder, M Holder, SP Holder, PROFILE Holder, AL Holder

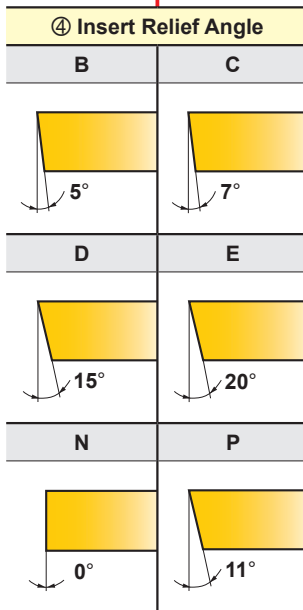
EXTERNAL TURNING TOOLS

C



M **C** **L** **N** **R** - **16** **5** **D**

① ② ③ ④ ⑤ ⑥ ⑦ ⑧

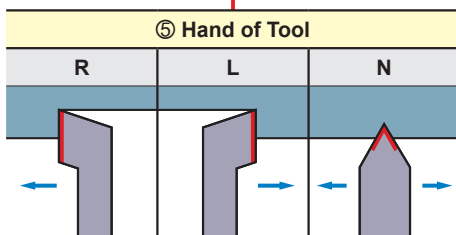
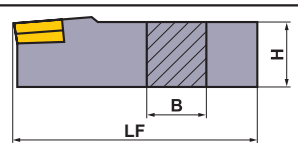


⑥ Tool Size [Height (H) and Width (B)] (inch)								
	06	08	10	12	16	20	24	85
H	.375	.500	.625	.750	1.000	1.250	1.500	1.250
B	.375	.500	.625	.750	1.000	1.250	1.500	1.000

The diagram shows a side view of a tool. The total length is labeled LF. The height is labeled H. The width is labeled B. A yellow rectangular feature is shown on the top left corner of the tool.

In case of B=H, the number will represent the number of sixteenths of B and H.

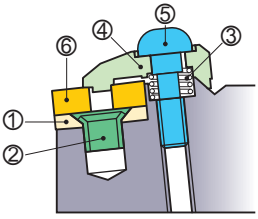
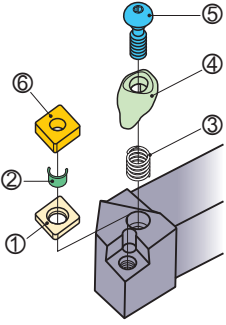
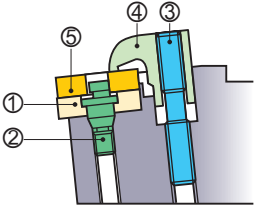
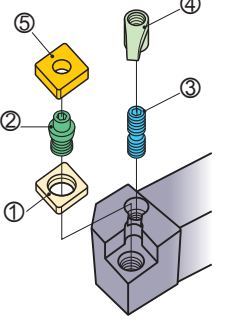
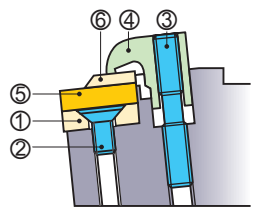
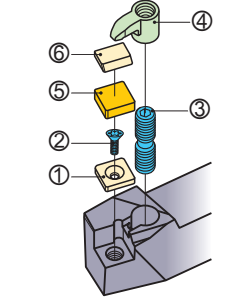
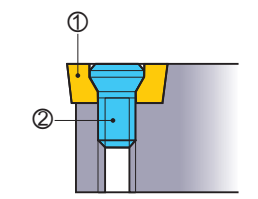
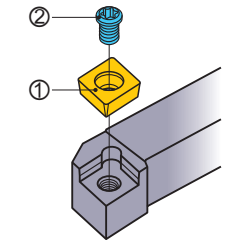
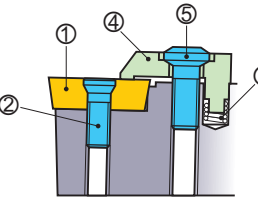
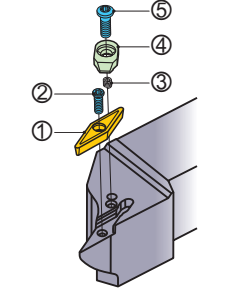
In case of B≠H, the first digit represents the number of eighths of B, and the second digit represents the number of quarters of H.



⑦ Insert Size										
Inscribed Circle of Insert (inch)	.156	.187	.219	.250	.313	.375	.500	.625	.750	1.000
	1.2	1.5	1.8	2	2.5	3	4	5	6	
 						3	4	5	6	8
	1.2	1.5		2		3	4	5		
80° 	1.2	1.5		2	2.5	3	4	5	6	
55° 				2		3	4	5		
35° 		1.5		2		3	4			

⑧ Tool Length (LF) (inch)					
A	B	C	D	E	X
4.000	4.500	5.000	6.000	7.000	< 4.000

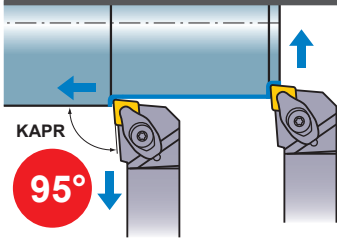
METHOD OF HOLDING

Type	Structure
Double Clamp (DOUBLE CLAMP) Holder	  ① Shim ② Shim Pin ③ Spring ④ Clamp Bridge ⑤ Clamp Screw ⑥ Insert
Multiple Clamp For insert with hole (M Holder)	  ① Shim ② Shim Pin ③ Clamp Screw ④ Clamp Bridge ⑤ Insert
Multiple Clamp For insert without hole (Opt.) (M Holder)	  ① Shim ② Shim Screw ③ Clamp Screw ④ Clamp Bridge ⑤ Insert ⑥ Chipbreaker
Screw Clamp (SP Holder) (AL Holder) (SR Holder)	  ① Insert ② Insert Screw
Double Clamp with Screw and Clamp Bridge (PROFILE Holder)	  ① Insert ② Insert Screw ③ Spring ④ Clamp Bridge ⑤ Clamp Screw

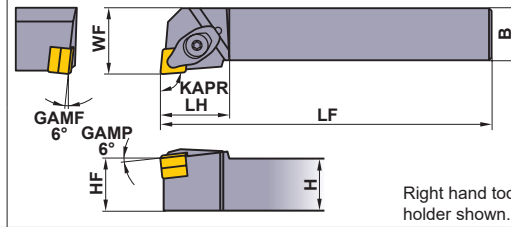
EXTERNAL TURNING TOOLS

CN INSERTS TOOL HOLDERS

DCLN



External turning DOUBLE CLAMP Type Facing



Finish	Light	Medium	Medium
FP	LP	MP	MK
 (4)	 (4)	 (4)	 (4)
Medium	Medium to Rough	Stainless	CBN
Standard	RP	MM	
 (3,4)	 (4)	 (4)	 (4)

C

EXTERNAL TURNING TOOLS

Order Number	ANSI Number	Stock		Insert Number	Dimensions (inch)						Shim	Shim Pin	Clamp Bridge	Spring	Clamp Screw ^{*2}	Wrench
		R	L		H	B	LF	LH	HF	WF						
DCLNR/L-123	DCLNR/L123B	●	●	32	.750	.750	4.500	1.000	.750	1.000	LLSCN33 (LLSCN32) ^{*1}	LLP23	DCK2211	DCS2	DC0520T	TKY15F
DCLNR/L-163	DCLNR/L163D	●	●		1.000	1.000	6.000	1.000	1.000	1.250						
DCLNR/L-124	DCLNR/L124B	●	●	43	.750	.750	4.500	1.250	.750	1.000	LLSCN42	LLP14	DCK2613	DCS1	DC0621T	TKY20F
DCLNR/L-164	DCLNR/L164D	●	●		1.000	1.000	6.000	1.250	1.000	1.250						
DCLNR/L-204	DCLNR/L204D	●	●		1.250	1.250	6.000	1.250	1.250	1.500						
DCLNR/L-244	DCLNR/L244D	●	●		1.500	1.500	6.000	1.250	1.500	2.000						

*1 Please use shim no.LLSCN32 with .187inch thick insert. When using .187inch thick inserts, the shim must be ordered separately.

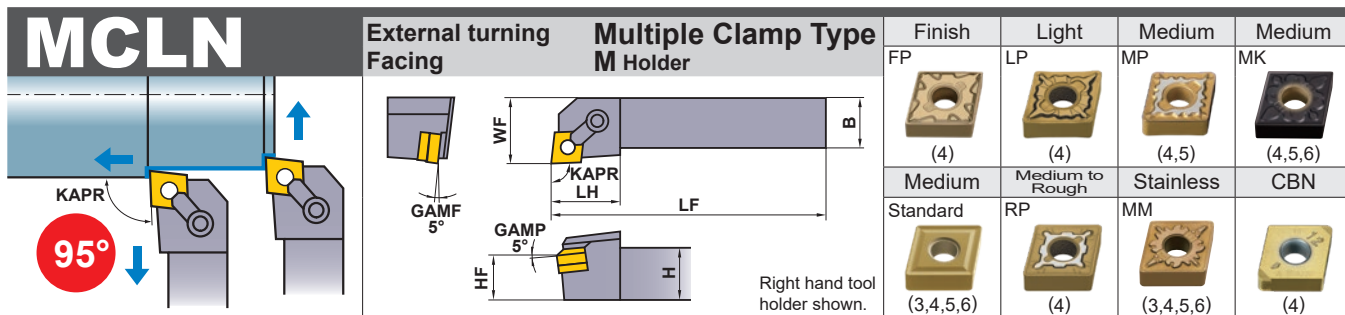
*2 Clamp Torque (lbf-in) : DC0520T=31, DC0621T=44

Note 1) Insert photo is an example. Letters show chip breaker style, figures show inscribed circle.

C006

● : USA Stock

DCLN type inserts	➤ A106–A113
CBN & PCD inserts	➤ B022–B024, B049
CUTTING CONDITIONS	➤ A080, B008



Order Number	ANSI Number	Stock		Insert Number		Dimensions (inch)						Shim	Shim Pin	Clamp Bridge	Clamp Screw
		R	L			H	B	LF	LH	HF	WF				
MCLNR/L-123	MCLNR/L123B	●	●		32	.750	.750	4.500	1.000	.750	1.000	ICSN332	NL34L	CL6	XNS37
MCLNR/L-163	MCLNR/L163C	●	●		1.000	1.000	5.000	1.000	1.000	1.250					
MCLNR/L-124B	MCLNR/L124B	●	●		.750	.750	4.500	1.250	.750	1.000					
MCLNR/L-164C	MCLNR/L164C	●	●		1.000	1.000	5.000	1.250	1.000	1.250					
MCLNR/L-164D	MCLNR/L164D	●	●		43 ^{*2}	1.000	1.000	6.000	1.250	1.000	1.250	ICSN433 ^{*1}	NL46	CL20	XNS48
MCLNR/L-204D	MCLNR/L204D	●	●			1.250	1.250	6.000	1.250	1.250	1.500				
MCLNR/L-244D	MCLNR/L244D	●	●			1.500	1.500	6.000	1.250	1.500	2.000				
MCLNR/L-244E	MCLNR/L244E	●	●			1.500	1.500	7.000	1.250	1.500	2.000				
MCLNR/L-854D	MCLNR/L854D	●	●	CNMA CNMG CNMM CNGA CNGG CNGM	54	1.250	1.000	6.000	1.250	1.250	1.250	ICSN533	NL58	CL12	XNS510
MCLNR/L-165C	MCLNR/L165C	●	●			1.000	1.000	5.000	1.375	1.000	1.250				
MCLNR/L-165D	MCLNR/L165D	●	●			1.000	1.000	6.000	1.375	1.000	1.250				
MCLNR/L-205D	MCLNR/L205D	●	●			1.250	1.250	6.000	1.375	1.250	1.500				
MCLNR/L-166C	MCLNR/L166C	●	●		64	1.000	1.000	5.000	1.500	1.000	1.250	ICSN633	NL68	CL12	
MCLNR/L-166D	MCLNR/L166D	●	●			1.000	1.000	6.000	1.500	1.000	1.250				
MCLNR/L-206D	MCLNR/L206D	●	●			1.250	1.250	6.000	1.500	1.250	1.500				
MCLNR/L-246D	MCLNR/L246D	●	●			1.500	1.500	6.000	1.500	1.500	2.000				
MCLNR/L-246E	MCLNR/L246E	●	●			1.500	1.500	7.000	1.500	1.500	2.000				
MCLNR/L-856D	MCLNR/L856D	●	●			1.250	1.000	6.000	1.500	1.250	1.250				

*1 (Opt.) See page M012 for different radius.

*3 Clamp Torque (lbf-in) : XNS36=30, XNS48=45, XNS510=70

*2 For inserts without hole, remove shim pin and add below.

Shim Screw	Chipbreaker
S46	CBC4

MCLN type inserts > A106–A113
 CBN & PCD inserts > B022–B024, B049
 CUTTING CONDITIONS > A080, B008

SPARE PARTS > M001
 TECHNICAL DATA > N001

EXTERNAL TURNING TOOLS

CN INSERTS TOOL HOLDERS

MCGN		External turning		Multiple Clamp Type M Holder						Finish		Light		Medium		Medium		
										Medium Standard (4,5,6)		Medium to Rough RP (4,5,6)		Stainless MM (4,5,6)		CBN (4)		
Order Number	ANSI Number	Stock	Insert Number		Dimensions (inch)						Shim	Shim Pin	Clamp Bridge	*3				
					H	B	LF	LH	HF	WF				Clamp Screw				
MCGNR/L-124	MCGNR/L124B	● □	CNMA CNMG CNMM CNGA CNGG CNGM	43 ^{*2}	.750	.750	4.500	1.250	.750	1.000	ICSN433 ^{*1}	NL46	CL20	XNS48				
MCGNR/L-164C	MCGNR/L164C	□ ●			1.000	1.000	5.000	1.250	1.000	1.250								
MCGNR/L-164D	MCGNR/L164D	● ●			1.000	1.000	6.000	1.250	1.000	1.250								
MCGNR/L-165D	MCGNR/L165D	● ●	54	54 ^{*2}	1.000	1.000	6.000	1.375	1.000	1.250	ICSN533	NL58	CL12	XNS510				
MCGNR/L-166D	MCGNR/L166D	● ●			64 ^{*2}	1.000	1.000	6.000	1.625	1.000	1.250	ICSN633	NL68	CL12	XNS510			
*1 (Opt.) See page M012 for different radius.																	*2 For inserts without hole, remove shim pin and add below.	
*3 Clamp Torque (lbf-in) : XNS48=45, XNS510=70																		
Shim Screw												Chipbreaker						
S46												CBC4						

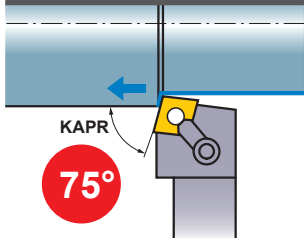
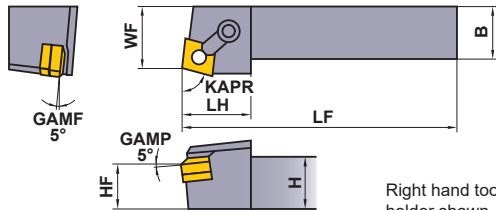
DCRN		DOUBLE CLAMP Type										Finish		Light		Medium		Medium	
												FP (4)		LP (4)		MP (4)		MK (4)	
												Medium Standard (4)		Medium to Rough RP (4)		Stainless MM (4)			
Order Number	ANSI Number	Stock		Insert Number	Dimensions (inch)						Shim	Shim Pin	Clamp Bridge	Spring	Clamp Screw	* Wrench			
		R	L		H	B	LF	LH	HF	WF									
DCRNR/L-124	DCRNR/L124B	●	●	CNMA CNMG CNMM CNGA CNGG CNGM	43	.750	.750	4.500	1.250	.750	.888	LLSCN42	LLP14	DCK2613	DCS1	DC0621T	TKY20F		
DCRNR/L-164	DCRNR/L164D	●	●			1.000	1.000	6.000	1.250	1.000	1.128								

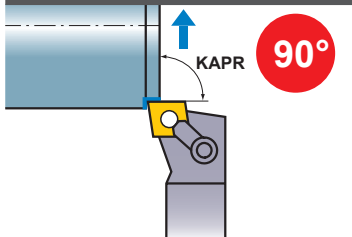
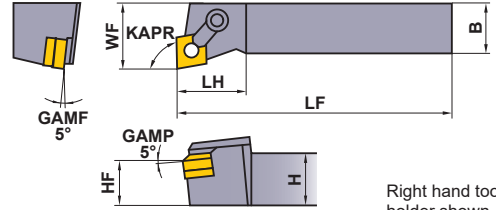
* Clamp Torque (lbf-in) : DC0621T=44

Note 1) Insert photo is an example. Letters show chip breaker style, figures show inscribed circle.

● : USA Stock □ : Made to Order

MCGN type inserts	➢ A106–A113
DCRN type inserts	➢ A106–A113
CBN & PCD inserts	➢ B022–B024, B049
CUTTING CONDITIONS	➢ A080, B008

MCRN		Multiple Clamp Type M Holder										Finish		Light		Medium		Medium	
												 (4)		 (4)		 (4,5)		 (4,5,6)	
		Right hand tool holder shown.										Medium Standard		Medium to Rough RP		Stainless MM			
												(4,5,6)		(4)		(4,5)			
Order Number	ANSI Number	Stock		Insert Number	Dimensions (inch)						Shim	Shim Pin	Clamp Bridge	Clamp Screw					
		R	L		H	B	LF	LH	HF	WF									
MCRNR/L-124B	MCRNR/L124B	●	□	CNMA CNMG CNMM CNGG	43 ^{*2}	.750	.750	4.500	1.250	.750	.750	ICSN433 ^{*1}	NL46	CL9	XNS48				
MCRNR/L-164C	MCRNR/L164C	●	●			1.000	1.000	5.000	1.250	1.000	1.250								
MCRNR/L-164D	MCRNR/L164D	●	●			1.000	1.000	6.000	1.250	1.000	1.250								
MCRNR/L-165D	MCRNR/L165D	●	□	CNGG	54 [○]	1.000	1.000	6.000	1.375	1.000	1.250	ICSN533	NL58	CL9	XNS510				
MCRNR/L-166D	MCRNR/L166D	□	●		64 [○]	1.000	1.000	6.000	1.500	1.000	1.250	ICSN633	NL68	CL12					
*1 (Opt.) See page M012 for different radius.																*2 For inserts without hole, remove shim pin and add below			
*3 Clamp Torque (lbf-in) : XNS48=45, XNS510=70																			
												Shim Screw		Chipbreaker					
												S46		CBC4					

MCFN		Multiple Clamp Type M Holder										Finish	Light	Medium	Medium
		Facing										FP  (4)	LP  (4)	MP  (4,5)	MK  (4,5,6)
												Medium Standard  (4,5,6)	Medium to Rough RP  (4)	Stainless MM  (4,5)	CBN  (4)
Order Number	ANSI Number	Stock	Insert Number		Dimensions (inch)						Shim	Shim Pin	Clamp Bridge	Clamp Screw	
		R L			H	B	LF	LH	HF	WF					
MCFNR/L-124	MCFNR/L124B	● ●	CNMA CNMG CNMM CNGG	43 ^{*2}	.750	.750	4.500	1.250	.750	1.000	ICSN433 ^{*1}	NL46	CL20	XNS48	
MCFNR/L-164C	MCFNR/L164C	● ●			1.000	1.000	5.000	1.250	1.000	1.250					
MCFNR/L-164D	MCFNR/L164D	● ●			1.000	1.000	6.000	1.250	1.000	1.250					
MCFNR/L-165D	MCFNR/L165D	● ●	CNGG	54 [○]	1.000	1.000	6.000	1.375	1.000	1.250	ICSN533	NL58	CL12	XNS510	
MCFNR/L-166D	MCFNR/L166D	● ●		64 [○]	1.000	1.000	6.000	1.500	1.000	1.250	ICSN633	NL68	CL9		
*1 (Opt.) See page M012 for different radius.															
*2 For inserts without hole, remove shim pin and add below															
												Shim Screw		Chipbreaker	
												S46		CBC4	

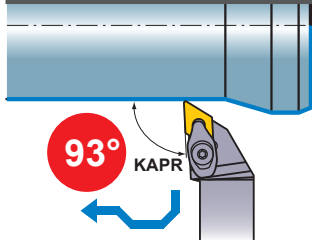
MCRN type inserts > A106-A113
MCFN type inserts > A106-A113
CBN & PCD inserts > B049

CUTTING CONDITIONS > A080, B008
SPARE PARTS > M001
TECHNICAL DATA > N001

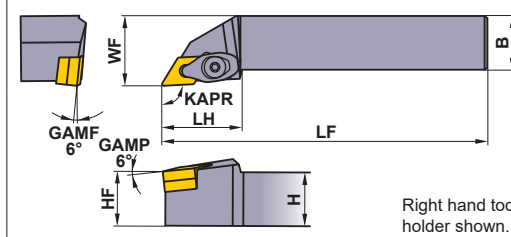
EXTERNAL TURNING TOOLS

DDJN INSERTS TOOL HOLDERS

DDJN



External turning DOUBLE CLAMP Type Copying



Finish	Light	Medium	Medium
FP	LP	MP	MK
			
(4)	(4)	(4)	(4)
Medium to Rough	Stainless	G Class	CBN
RP	MM	R/L	
			
(4)	(4)	(4)	(4)

C

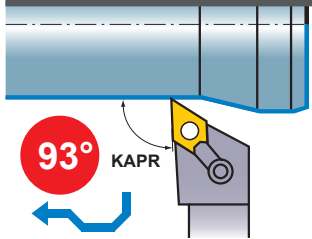
EXTERNAL TURNING TOOLS

Order Number	ANSI Number	Stock		Insert Number	Dimensions (inch)						Shim	Shim Pin	Clamp Bridge	Spring	Clamp Screw	Wrench
		R	L		H	B	LF	LH	HF	WF						
DDJNR/L-123	DDJNR/L123B	●	●	33	.750	.750	4.500	1.188	.750	1.000	LLSDN32	LLP23	DCK2211	DCS2	DC0520T	TKY15F
DDJNR/L-163	DDJNR/L163D	●	●		1.000	1.000	6.000	1.188	1.000	1.250						
DDJNR/L-124	DDJNR/L124B	●	●	43	.750	.750	4.500	1.375	.750	1.000	*1 LLSDN43 (LLSDN42)	*1 LLP24 (LLP14)	DCK2613	DCS1	DC0621T	TKY20F
DDJNR/L-164	DDJNR/L164D	●	●		1.000	1.000	6.000	1.375	1.000	1.250						
DDJNR/L-204	DDJNR/L204D	●	●		1.250	1.250	6.000	1.375	1.250	1.500						
DDJNR/L-244	DDJNR/L244D	●	●		1.500	1.500	6.000	1.500	1.500	2.000						

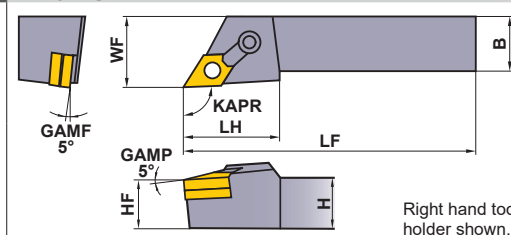
*1 Please use shim no.LLSDN42 and shim pin LLP14 with .25inch thick insert. When using .25inch thick inserts, the shim and shim pin must be ordered separately.

*2 Clamp Torque (lbf-in) : DC0520T=31, DC0621T=44

MDJN



External turning Multiple Clamp Type M Holder Copying



Finish	Light	Medium	Medium
FP	LP	MP	MK
			
(4)	(4)	(4)	(4)
Medium to Rough	Stainless	G Class	CBN
RP	MM	R/L	
			
(4)	(4)	(4)	(4)

Order Number	ANSI Number	Stock		Insert Number	Dimensions (inch)						Shim	Shim Pin	Clamp Bridge	Clamp Screw
		R	L		H	B	LF	LH	HF	WF				
MDJNR/L-123	MDJNR/L123B	●	●	33	.750	.750	4.500	1.250	.750	1.000	IDSN322	NL34L	CL7	XNS36
MDJNR/L-163	MDJNR/L163C	●	●		1.000	1.000	5.000	1.250	1.000	1.250				
MDJNR/L-124B	MDJNR/L124B	●	●	43	.750	.750	4.500	1.250	.750	1.000	IDSN433	NL46	CL7	XNS36
MDJNR/L-164C	MDJNR/L164C	●	●		1.000	1.000	5.000	1.250	1.000	1.250				
MDJNR/L-164D	MDJNR/L164D	●	●		1.000	1.000	6.000	1.250	1.000	1.250	IDSN433	NL46	CL20	XNS48
MDJNR/L-204D	MDJNR/L204D	●	●		1.250	1.250	6.000	1.250	1.250	1.500				
MDJNR/L-244D	MDJNR/L244D	●	●	54	1.500	1.500	6.000	1.250	1.500	2.000	*1 IDSN533	NL58	CL12	XNS510
MDJNR/L-165D	MDJNR/L165D	●	●		1.000	1.000	6.000	1.750	1.000	1.250				
MDJNR/L-205D	MDJNR/L205D	●	●		1.250	1.250	6.000	1.750	1.250	1.500				

*1 (Opt.) See page M012 for different thickness.

*2 Clamp Torque (lbf-in) : XNS36=30, XNS48=45, XNS510=70

Note 1) Insert photo is an example. Letters show chip breaker style, figures show inscribed circle.

● : USA Stock

DDJN type inserts > A114-A121

MDJN type inserts > A114-A121

CUTTING CONDITIONS > A080, B008

CBN & PCD inserts > B025-B028, B049

DDPN		External turning DOUBLE CLAMP Type Copying								Finish		Light	Medium	Medium		
										FP	LP	MP	MK			
										(4)	(4)	(4)	(4)			
										Medium to Rough	Stainless	G Class	CBN			
										RP	MM	R/L				
										(4)	(4)	(4)	(4)			
Order Number	ANSI Number	Stock	Insert Number	Dimensions (inch)						Shim	Shim Pin	Clamp Bridge	Spring	Clamp Screw	Wrench	
				H	B	LF	LH	HF	WF							
DDPNN-164	DDPNN164D	●	DNMA DNMG DNMM DNGA DNGG DNGM	43	1.000	1.000	6.000	1.500	1.000	.500	LLSDN43 (LLSDN42)	LLP24 (LLP14)	DCCK2613	DCS1	DC0621T	TKY20F

*1 Please use shim no.LLSDN42 and shim pin LLP14 with .25inch thick insert. When using .25inch thick inserts, the shim and shim pin must be ordered separately.

*2 Clamp Torque (lbf-in) : DC0621T=44

MDPN		External turning Copying		Multiple Clamp Type M Holder							Finish		Light		Medium		Medium	
											FP	LP	MP	MK				
											(4)	(4)	(4)	(4)				
											Medium to Rough	Stainless	G Class	CBN				
											RP	MM	R/L					
											(4)	(4)	(4)	(4)				
Order Number	ANSI Number	Stock	Insert Number	Dimensions (inch)							Shim	Shim Pin	Clamp Bridge	Clamp Screw				
				H	B	LF	LH	HF	WF									
MDPNN-164D	MDPNN164D	●	DNMA DNMG DNMM DNGA DNGG DNGM	43	1.000	1.000	6.000	1.750	1.000	.500	IDSN433	NL46	CL12	XNS510				
MDPNN-165D	MDPNN165D	●	DNMA DNMG DNMM DNGA DNGG DNGM	54 ^{*1}	1.000	1.000	6.000	2.000	1.000	.500	IDSN533 ^{*1}	NL58						

*1 (Opt.) See page M012 for different thickness.

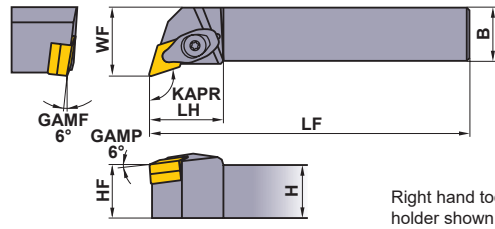
*2 Clamp Torque (lbf-in) : XNS510=70

DDPN type inserts	➤ A114-A121
MDPN type inserts	➤ A114-A121
CBN & PCD inserts	➤ B025-B028, B049

CUTTING CONDITIONS	➤ A080, B008
SPARE PARTS	➤ M001
TECHNICAL DATA	➤ N001

DN INSERTS TOOL HOLDERS

External turning DOUBLE CLAMP Type Copying

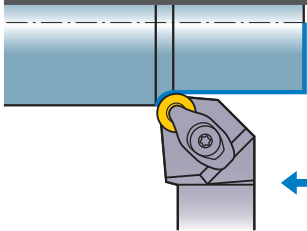
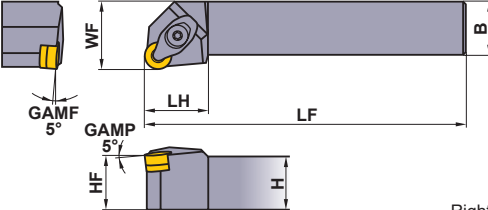
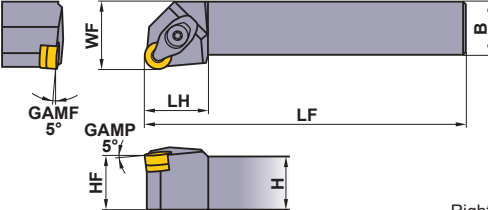


Right hand tool holder shown.

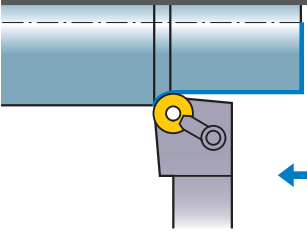
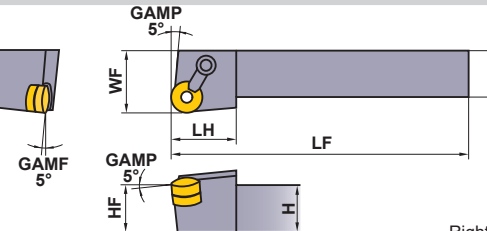
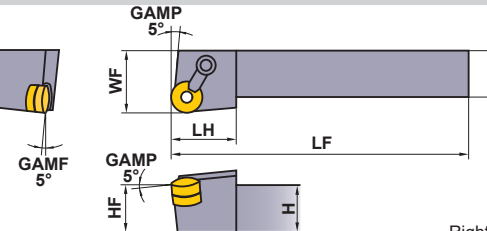
EXTERNAL TURNING TOOLS

DDQN type inserts	➤ A114–A121
CBN & PCD inserts	➤ B025–B028, B049
CUTTING CONDITIONS	➤ A080, B008

RN INSERTS TOOL HOLDERS

DRGN		External turning Copying										DOUBLE CLAMP Type						Medium Standard	
																		 (4)	
																		 (4)	
												Right hand tool holder shown.							
Order Number	ANSI Number	Stock		Insert Number		Dimensions (inch)					Shim	Shim Pin	Clamp Bridge	Spring	Clamp Screw	Wrench			
		R	L			H	B	LF	LH	HF							WF		
DRGNR/L-124	DRGNR/L124B	●	●	RNMG	43	.750	.750	4.500	1.188	.750	1.000								
DRGNR/L-164	DRGNR/L164D	●	●			1.000	1.000	6.000	1.188	1.000	1.250	LLSRN42	LLP14	DCK2613	DCS1	DC0621T	TKY20F		
DRGNR/L-204	DRGNR/L204D	●	●			1.250	1.250	6.000	1.188	1.250	1.500								

* Clamp Torque (lbf-in) : DC0621T=44

MRGN		External turning Copying		Multiple Clamp Type M Holder										Medium Standard
														 (3,4,6)
														 (4)
Order Number	ANSI Number	Stock	Insert Number	Dimensions (inch)						Shim	Shim Pin	Clamp Bridge	*3	
		R L		H	B	LF	LH	HF	WF				Clamp Screw	
MRGNR/L-123B	MRGNR/L123B	● ●	RNMG 32	.750	.750	4.500	.875	.750	1.000	IRSN32	NL34	CL6	XNS36	
MRGNR/L-163	MRGNR/L163D	□ □		1.000	1.000	6.000	.875	1.000	1.250					
MRGNR/L-124B	MRGNR/L124B	● ●		.750	.750	4.500	1.250	.750	1.000					
MRGNR/L-164C	MRGNR/L164C	● ●	RNMG 43	1.000	1.000	5.000	1.250	1.000	1.250	IRSN43	NL46	CL9	XNS59	
MRGNR/L-164D	MRGNR/L164D	● ●		1.000	1.000	6.000	1.250	1.000	1.250					
MRGNR/L-204D	MRGNR/L204D	● □		1.250	1.250	6.000	1.250	1.250	1.500					
MRGNR/L-206D	MRGNR/L206D	● □	RNMG 64	1.250	1.250	6.000	1.375	1.250	1.500	IRSN63	NL68	CL12	XNS58	
MRGNR/L-246	MRGNR/L246E	□ □		1.500	1.500	7.000	1.375	1.500	2.000					

*1 (Opt.) See page M012 for different thickness.

*3 Clamp Torque (lbf-in) : XNS36=30, XNS58=70, XNS59=70

*2 For inserts without hole, remove shim pin and add below.

Shim Screw	Chipbreaker
S46	CBR4

DRGN type inserts > A122
MRGN type inserts > A122

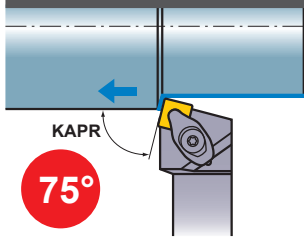
CUTTING CONDITIONS > A080
SPARE PARTS > M001
TECHNICAL DATA > N001

C013

EXTERNAL TURNING TOOLS

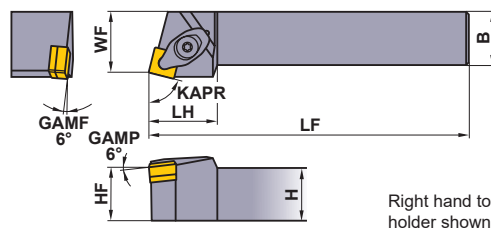
SN INSERTS TOOL HOLDERS

DSRN



DOUBLE CLAMP Type

External turning



Right hand tool holder shown.

Finish	Light	Medium	Medium
FP  (4)	LP  (4)	MP  (4)	MK  (4)
Medium to Rough RP  (4)	Stainless MM  (4)	G Class R/L  (4)	CBN  (4)

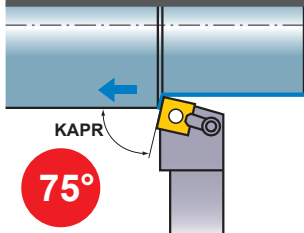
C

EXTERNAL TURNING TOOLS

Order Number	ANSI Number	Stock		Insert Number	Dimensions (inch)						Shim	Shim Pin	Clamp Bridge	Spring	Clamp Screw	Wrench
		R	L		H	B	LF	LH	HF	WF						
DSRNR/L-124	DSRNR/L124B	●	●	43	.750	.750	4.500	1.250	.750	.878	LLSSN42	LLP14	DCK2613	DCS1	DC0621T	TKY20F
DSRNR/L-164	DSRNR/L164D	●	●		1.000	1.000	6.000	1.250	1.000	1.128						

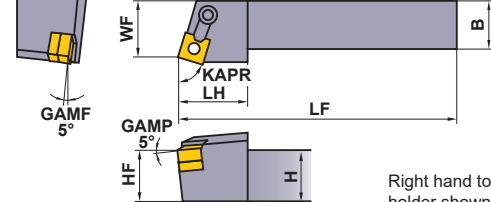
* Clamp Torque (lbf-in) : DC0621T=44

MSRN



Multiple Clamp Type M Holder

External turning



Right hand tool holder shown.

Finish	Light	Medium	Medium
FP  (3,4)	LP  (4)	MP  (4)	MK  (4,6)
Medium to Rough RP  (4)	Stainless MM  (4,5)	G Class R/L  (4)	CBN  (4)

Order Number	ANSI Number	Stock		Insert Number	Dimensions (inch)						Shim	Shim Pin	Clamp Bridge	Clamp Screw
		R	L		H	B	LF	LH	HF	WF				
MSRNR/L-83	MSRNR/L083B	●	●	32	.500	.500	4.500	1.000	.500	.660	ISSN322 ^{*1}	NL34	CL6	XNS36
MSRNR/L-103	MSRNR/L103B	●	●		.625	.625	4.500	1.000	.625	.785				
MSRNR/L-123	MSRNR/L123B	●	●		.750	.750	4.500	1.000	.750	.910				
MSRNR/L-124B	MSRNR/L124B	●	●	43	.750	.750	4.500	1.250	.750	.880	ISSN433 ^{*1}	NL46	CL9	XNS59
MSRNR/L-164C	MSRNR/L164C	●	●		1.000	1.000	5.000	1.250	1.000	1.130				
MSRNR/L-164D	MSRNR/L164D	●	●		1.000	1.000	6.000	1.250	1.000	1.130				
MSRNR/L-165C	MSRNR/L165C	●	●	54	1.000	1.000	5.000	1.375	1.000	1.103	ISSN533	NL58	CL12	XNS510
MSRNR/L-165D	MSRNR/L165D	●	●		1.000	1.000	6.000	1.375	1.000	1.103				
MSRNR/L-205D	MSRNR/L205D	●	●		1.250	1.250	6.000	1.375	1.250	1.353				
MSRNR/L-166	MSRNR/L166D	●	●	64	1.000	1.000	6.000	1.500	1.000	1.071	ISSN633 ^{*1}	NL68	CL12	XNS510
MSRNR/L-206D	MSRNR/L206D	●	●		1.250	1.250	6.000	1.500	1.250	1.315				
MSRNR/L-246D	MSRNR/L246D	●	●		1.500	1.500	6.000	1.500	1.500	1.821				
MSRNR/L-246E	MSRNR/L246E	●	●		1.500	1.500	7.000	1.500	1.500	1.821				
MSRNR/L-248	MSRNR/L248E	●	●	86	1.500	1.500	7.000	1.625	1.500	1.768	ISSN846	NL810	CL24	XNS610

*1 (Opt.) See page M012 for different thickness or radius.

*2 For inserts without hole, remove shim pin and add below.

*3 Clamp Torque (lbf-in) : XNS36=30, XNS59=70, XNS510=70, XNS610=135

Insert	Shim Screw	Chipbreaker
SN [○] N3 [○]	S34	CBS3
SN [○] N4 [○]	S46	CBS4

Note 1) Insert photo is an example. Letters show chip breaker style, figures show inscribed circle.

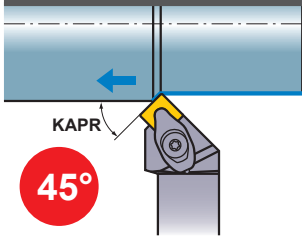
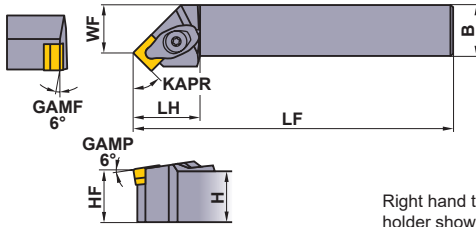
● : USA Stock □ : Made to Order

DSRN type inserts > A123-A129

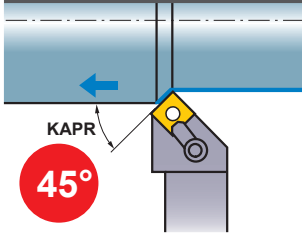
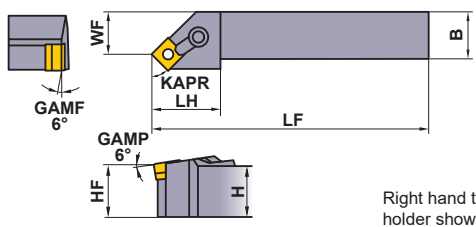
MSRN type inserts > A123-A129

CBN & PCD inserts > B029, B050

CUTTING CONDITIONS > A080, B008

DSSN		External turning DOUBLE CLAMP Type Chamfering										Finish		Light		Medium		Medium	
 45°		 Right hand tool holder shown.										FP	LP	MP	MK				
		 (4)	 (4)	 (4)	 (4)														
		Medium to Rough	Stainless	G Class	CBN														
		RP	MM	R/L															
												 (4)	 (4)	 (4)	 (4)				
Order Number	ANSI Number	Stock	Insert Number		Dimensions (inch)						Shim	Shim Pin	Clamp Bridge	Spring	Clamp Screw	* Wrench			
		R L			H	B	LF	LH	HF	WF									
DSSNR/L-124	DSSNR/L124B	● ●		43	.750	.750	4.500	1.250	.750	.659	LLSSN42	LLP14	DCK2613	DCS1	DC0621T	TKY20F			
DSSNR/L-164	DSSNR/L164D	● ●			1.000	1.000	6.000	1.250	1.000	.909									

* Clamp Torque (lbf-in) : DC0621T=44

MSSN		External turning Chamfering		Multiple Clamp Type M Holder							Finish		Light		Medium		Medium	
												FP	LP	MP	MH			
												(3,4)	(4)	(4)	(4,6)			
												Medium to Rough	Stainless	G Class	CBN			
												RP	MM	R/L				
												(4)	(4,5)	(4)	(4)			
Order Number	ANSI Number	Stock	Insert Number	Dimensions (inch)							Shim	Shim Pin	Clamp Bridge	Clamp Screw	*3			
				H	B	LF	LH	HF	WF									
MSSNR/L-83	MSSNR/L083B	● ●	SNMA SNMG SNMM SNGA SNGG	32 ^{*1*2}	.500	.500	4.500	1.000	.500	.404	ISSN322 ^{*1}	NL34	CL6	XNS36				
MSSNR/L-124B	MSSNR/L124B	● ●		43 ^{*1*2}	.750	.750	4.500	1.250	.750	.675	ISSN433 ^{*1}	NL46	CL9	XNS59				
MSSNR/L-164C	MSSNR/L164C	□ □			1.000	1.000	5.000	1.250	1.000	.925								
MSSNR/L-164D	MSSNR/L164D	● ●			1.000	1.000	6.000	1.250	1.000	.925								
MSSNR/L-205D	MSSNR/L205D	□ □		54 [*]	1.250	1.250	6.000	1.375	1.250	1.097	ISSN533	NL58	CL12	XNS510				
MSSNR/L-206D	MSSNR/L206D	□ ●		64 ^{*1}	1.250	1.250	6.000	1.500	1.250	1.011	ISSN633 ^{*1}	NL68	CL12	XNS510				

*1 (Opt.) See page M012 for different thickness or radius.

*2 For inserts without hole, remove shim pin and add below.

*3 Clamp Torque (lbf-in) : XNS36=30, XNS59=70, XNS510=70

Insert	Shim Screw	Chipbreaker
SN [○] N3 ^{○○}	S34	CBS3D
SN [○] N4 ^{○○}	S46	CBS4D

DSSN type inserts > A123—A129

MSSN type inserts > A123—A129

CBN & PCD inserts > B029, B050

CUTTING CONDITIONS > A080, B008

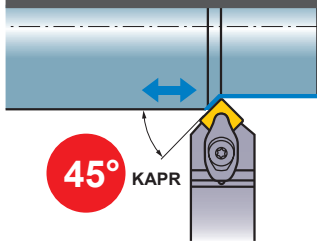
SPARE PARTS > M001

TECHNICAL DATA > N001

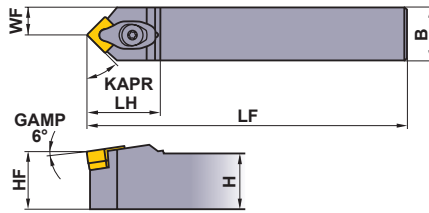
EXTERNAL TURNING TOOLS

SN INSERTS TOOL HOLDERS

DSDN



External turning DOUBLE CLAMP Type Chamfering

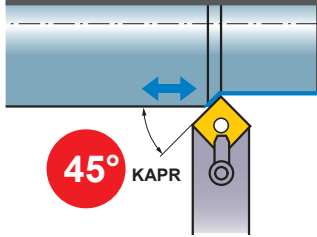


Finish	Light	Medium	Medium
FP  (4)	LP  (4)	MP  (4)	MK  (4)
Medium to Rough RP  (4)	Stainless MM  (4)	G Class R/L  (4)	CBN  (4)

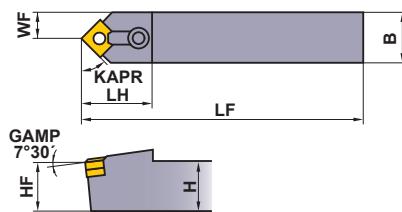
Order Number	ANSI Number	Stock	Insert Number	Dimensions (inch)						Shim	Shim Pin	Clamp Bridge	Spring	Clamp Screw	Wrench
				H	B	LF	LH	HF	WF						
DSDNN-124	DSDNN124B	●	SNMA SNMG SNMM SNGA SNGG 43	.750	.750	4.500	1.375	.750	.375	LLSSN42	LLP14	DCK2613	DCS1	DC0621T	TKY20F
DSDNN-164	DSDNN164D	●		1.000	1.000	6.000	1.375	1.000	.500						

* Clamp Torque (lbf-in) : DC0621T=44

MSDN



External turning Multiple Clamp Type M Holder Chamfering



Finish	Light	Medium	Medium
FP  (3,4)	LP  (4)	MP  (4)	MK  (4,5,6)
Medium to Rough GH  (4,5,6)	Stainless MM  (3,4,5,6)	G Class R/L  (4)	CBN  (4)

Order Number	ANSI Number	Stock	Insert Number		Dimensions (inch)						Shim	Shim Pin	Clamp Bridge	*3 Clamp Screw
					H	B	LF	LH	HF	WF				
MSDNN-83	MSDNN083B	●	SNMA SNMG SNMM SNGA SNGG	32 ^{*1*2}	.500	.500	4.500	1.000	.500	.250	ISSN322 ^{*1}	NL34	CL6	XNS36
MSDNN-103	MSDNN103B	□			.625	.625	4.500	1.000	.625	.313				
MSDNN-123	MSDNN123B	●			.750	.750	4.500	1.000	.750	.375				
MSDNN-124	MSDNN124B	●		43 ^{*1*2}	.750	.750	4.500	1.375	.750	.375	ISSN433 ^{*1}	NL46	CL9	XNS59
MSDNN-164	MSDNN164D	●			1.000	1.000	6.000	1.375	1.000	.500				
MSDNN-165	MSDNN165D	●		54 ^{*1}	1.000	1.000	6.000	1.625	1.000	.500	ISSN533	NL58	CL12	XNS510
MSDNN-166	MSDNN166D	●			1.000	1.000	6.000	1.750	1.000	.500				
MSDNN-206	MSDNN206E	●		64 ^{*1}	1.250	1.250	7.000	1.750	1.250	.625	ISSN633 ^{*1}	NL68	CL12	XNS510

*1 (Opt.) See page M012 for different thickness or radius.

*3 Clamp Torque (lbf-in) : XNS36=30, XNS59=70, XNS510=70

*2 For inserts without hole, remove shim pin and add below.

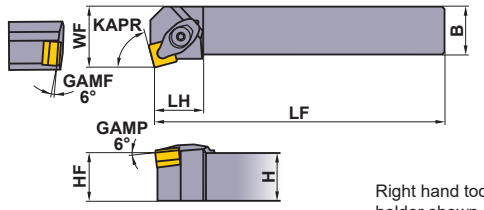
Insert	Shim Screw	Chipbreaker
SN [○] N3 [○]	S34	CBS3D
SN [○] N4 [○]	S46	CBS4D

Note 1) Insert photo is an example. Letters show chip breaker style, figures show inscribed circle.

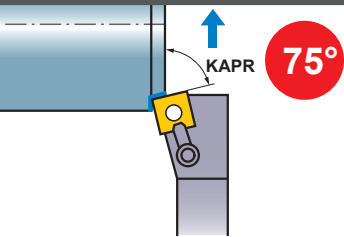
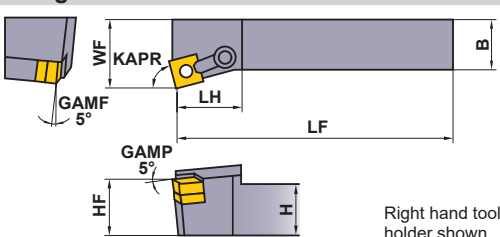
● : USA Stock □ : Made to Order

DSDN type inserts > A123-A129
MSDN type inserts > A123-A129

CBN & PCD inserts > B029, B050
CUTTING CONDITIONS > A080, B008

DSKN		DOUBLE CLAMP Type										Finish		Light		Medium		Medium	
		Facing										FP	LP	MP	MK				
												 (4)	 (4)	 (4)	 (4)				
												Medium to Rough	Stainless	G Class	CBN				
												RP	MM	R/L					
												 (4)	 (4)	 (4)	 (4)				
Order Number	ANSI Number	Stock	Insert Number		Dimensions (inch)						Shim	Shim Pin	Clamp Bridge	Spring	* Clamp Screw	Wrench			
		R			L	H	B	LF	LH	HF	WF								
DSKNR/L-124	DSKNR/L124B	●	●	43 ⁰	.750	.750	4.500	1.000	.750	1.000	LLSSN42	LLP14	DCK2613	DCS1	DC0621T	TKY20F			
DSKNR/L-164	DSKNR/L164D	●	●		1.000	1.000	6.000	1.000	1.000	1.250									

* Clamp Torque (lbf-in) : DC0621T=44

MSKN		Multiple Clamp Type M Holder										Finish		Light		Medium		Medium	
												FP	LP	MP	MK				
												 (3,4)	 (4)	 (4)	 (4,5,6)				
												Medium to Rough	Stainless	G Class	CBN				
												RP	MM	R/L					
												 (4)	 (3,4,5,6)	 (4)	 (4)				
Order Number	ANSI Number	Stock		Insert Number	Dimensions (inch)						Shim	Shim Pin	Clamp Bridge	Clamp Screw					
		R	L		H	B	LF	LH	HF	WF									
MSKNR/L-83	MSKNR/L083B	●	●	SNMA SNMG SNMM SNGA SNGG	32 ^{*1*2}	.500	.500	4.500	1.000	.500	.625	ISSN322 ^{*1}	NL34	CL6	XNS36				
MSKNR/L-103	MSKNR/L103B	●	●			.625	.625	4.500	1.000	.625	.750								
MSKNR/L-123	MSKNR/L123B	●	●			.750	.750	4.500	1.000	.750	.875								
MSKNR/L-124B	MSKNR/L124B	●	●		43 ^{*1*2}	.750	.750	4.500	1.250	.750	1.000	ISSN433 ^{*1}	NL46	CL9	XNS59				
MSKNR/L-164D	MSKNR/L164D	●	●			1.000	1.000	6.000	1.000	1.000	1.250								
MSKNR/L-165D	MSKNR/L165D	●	●			1.000	1.000	6.000	1.375	1.000	1.250								
MSKNR/L-205D	MSKNR/L205D	●	●		54 ^{*1}	1.250	1.250	6.000	1.375	1.250	1.500	ISSN533	NL58	CL12	XNS510				
MSKNR/L-206D	MSKNR/L206D	●	●			1.250	1.250	6.000	1.500	1.250	1.500								
					64 ^{*1}	1.250	1.250	6.000	1.500	1.250	1.500	ISSN633	NL68	CL12	XNS510				

*1 (Opt.) See page M012 for different thickness or radius.

*2 For inserts without hole, remove shim pin and add below.

*3 Clamp Torque (lbf-in) : XNS36=30, XNS59=70, XNS510=70

Insert	Shim Screw	Chipbreaker
SN [○] N3 ^{○○}	S34	CBS3
SN [○] N4 ^{○○}	S46	CBS4

DSKN type inserts > A123—A129

MSKN type inserts > A123—A129

CBN & PCD inserts > B029, B050

CUTTING CONDITIONS > A080, B008

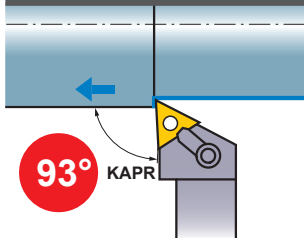
SPARE PARTS > M001

TECHNICAL DATA > N001

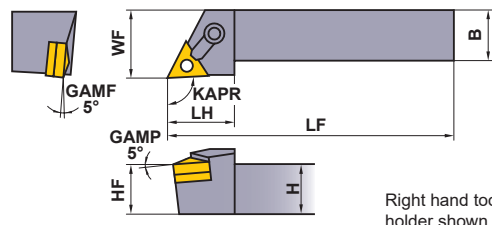
EXTERNAL TURNING TOOLS

TN INSERTS TOOL HOLDERS

MTJN



External turning Multiple Clamp Type M Holder



Right hand tool holder shown.

Finish	Light	Medium	Medium
FP  (3)	LP  (3)	MP  (3,4)	MK  (3,4)
Medium to Rough RP  (3)	Stainless MM  (3,4)	G Class R/L  (3,4)	CBN  (3)

C

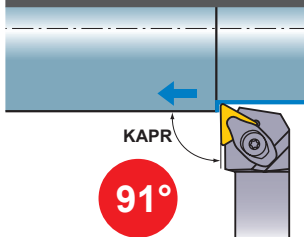
EXTERNAL TURNING TOOLS

Order Number	ANSI Number	Stock		Insert Number	Dimensions (inch)						Shim	Shim Pin	Clamp Bridge	Clamp Screw	*3
		R	L		H	B	LF	LH	HF	WF					
MTJNR/L-123X	MTJNR/L123B	●	●	33 [○] *1	.750	.750	4.500	1.000	.750	1.000	ITSN323 ^{*1}	NL34L	CL6	XNS36	
MTJNR/L-163X	MTJNR/L163D	●	●		1.000	1.000	6.000	1.000	1.000	1.250					
MTJNR/L-164	MTJNR/L164D	●	●		1.000	1.000	6.000	1.250	1.000	1.250					
MTJNR/L-204	MTJNR/L204D	●	●		1.250	1.250	6.000	1.250	1.250	1.500	ITSN433 ^{*1}	NL46	CL9	XNS510	
MTJNR/L-854	MTJNR/L854D	●	●	43 [○] *1	1.250	1.000	6.000	1.250	1.250	1.250					
MTJNR/L-165	MTJNR/L165D	●	●		1.000	1.000	6.000	1.500	1.000	1.250					
MTJNR/L-205	MTJNR/L205D	●	●	54 [○] *1	1.250	1.250	6.000	1.500	1.250	1.500	ITSN533 ^{*1}	NL58	CL9	XNS510	
MTJNR/L-245	MTJNR/L245E	●	●		1.500	1.500	7.000	1.500	1.500	2.000					
MTJNR/L-246	MTJNR/L246E	●	□	66 [○] *1	1.500	1.500	7.000	1.625	1.500	2.000	ITSN636 ^{*1}	NL68L	CL12	XNS510	

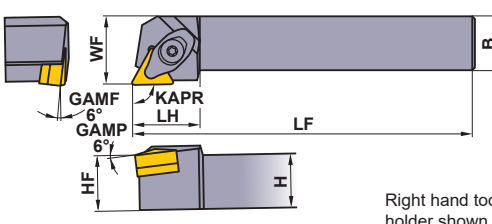
*1 (Opt.) See page M012 for different thickness or radius.

*2 Clamp Torque (lbf-in) : XNS36=30, XNS510=70

DTGN



External turning DOUBLE CLAMP Type



Right hand tool holder shown.

Finish	Light	Medium	Medium
FP  (3)	LP  (3)	MP  (3,4)	MK  (3)
Medium to Rough RP  (3,4)	Stainless MM  (3,4)	G Class R/L  (3,4)	CBN  (3)

Order Number	ANSI Number	Stock		Insert Number	Dimensions (inch)						Shim	Shim Pin	Clamp Bridge	Spring	Clamp Screw	*2	Wrench
		R	L		H	B	LF	LH	HF	WF							
DTGNR/L-123	DTGNR/L123B	●	●	33 [○]	.750	.750	4.500	1.000	.750	1.000	LLSTN32 ^{*1} (LLSTN33)	LLP23	DCK2211	DCS2	DC0520T	TKY15F	
DTGNR/L-163	DTGNR/L163D	●	●		1.000	1.000	6.000	1.000	1.000	1.250							
DTGNR/L-164	DTGNR/L164D	●	●	43 [○]	1.000	1.000	6.000	1.250	1.000	1.250	LLSTN42	LLP14	DCK2613	DCS1	DC0621T	TKY20F	
DTGNR/L-204	DTGNR/L204D	●	●		1.250	1.250	6.000	1.250	1.250	1.500							
DTGNR/L-244	DTGNR/L244D	●	●		1.500	1.500	6.000	1.250	1.500	2.000							

*1 Please use shim no.LLSTN33 with .125inch thick insert. When using .125inch thick inserts, the shim must be ordered separately.

*2 Clamp Torque (lbf-in) : DC0520T=31, DC0621T=44

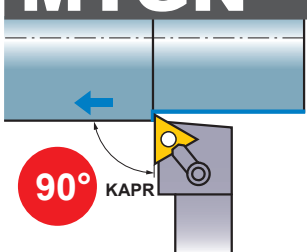
Note 1) Insert photo is an example. Letters show chip breaker style, figures show inscribed circle.

● : USA Stock □ : Made to Order

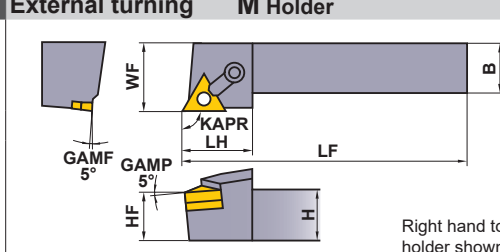
MTJN type inserts > A130-A137
DTGN type inserts > A130-A137

CBN & PCD inserts > B030, B031, B050
CUTTING CONDITIONS > A080, B008

MTGN



Multiple Clamp Type M Holder



Right hand tool holder shown.

Finish	Light	Medium	Medium
FP  (3)	LP  (3)	MP  (3,4)	MK  (3,4)
Medium to Rough RP  (3)	Stainless MM  (3,4)	G Class R/L  (3,4)	CBN  (3)

Order Number	ANSI Number	Stock		Insert Number	Dimensions (inch)						Shim	Shim Pin	Clamp Bridge	Clamp Screw
		R	L		H	B	LF	LH	HF	WF				
MTGNR/L-123BX	MTGNR/L123B	●	●	33 ^{*1*2}	.750	.750	4.500	1.000	.750	1.000	ITSN322 ^{*1}	NL34L	CL6	XNS36
MTGNR/L-163CX	MTGNR/L163C	●	●		1.000	1.000	5.000	1.000	1.000	1.250				
MTGNR/L-163DX	MTGNR/L163D	□	●		1.000	1.000	6.000	1.000	1.000	1.250				
MTGNR/L-164C	MTGNR/L164C	●	●	43 ^{*1}	1.000	1.000	5.000	1.375	1.000	1.250	ITSN433 ^{*1}	NL46	CL9	XNS510
MTGNR/L-164D	MTGNR/L164D	●	●		1.000	1.000	6.000	1.375	1.000	1.250				
MTGNR/L-204D	MTGNR/L204D	□	●		1.250	1.250	6.000	1.375	1.250	1.500				
MTGNR/L-244D	MTGNR/L244D	●	●		1.500	1.500	6.000	1.375	1.500	2.000				
MTGNR/L-244E	MTGNR/L244E	●	●	TNMA TNMG TNMM TNGA TNGG	1.500	1.500	7.000	1.375	1.500	2.000	ITSN533 ^{*1}	NL58	CL9	XNS510
MTGNR/L-854D	MTGNR/L854D	●	●		1.250	1.000	6.000	1.375	1.250	1.250				
MTGNR/L-165C	MTGNR/L165C	□	□		1.000	1.000	5.000	1.500	1.000	1.250				
MTGNR/L-165D	MTGNR/L165D	●	●		1.000	1.000	6.000	1.500	1.000	1.250				
MTGNR/L-205D	MTGNR/L205D	●	□		1.250	1.250	6.000	1.500	1.250	1.500				
MTGNR/L-245D	MTGNR/L245D	□	●		1.500	1.500	6.000	1.375	1.500	2.000				
MTGNR/L-245E	MTGNR/L245E	□	●		1.500	1.500	7.000	1.500	1.500	2.000				
MTGNR-855D	MTGNR855D	●	●		1.250	1.000	6.000	1.500	1.250	1.250				
MTGNR/L-246D	MTGNR/L246D	●	●		1.500	1.500	6.000	1.500	1.500	2.000	ITSN636 ^{*1}	NL68L	CL12	XNS510
MTGNR/L-246E	MTGNR/L246E	●	●		1.500	1.500	7.000	1.750	1.500	2.000				

*1 (Opt.) See page M012 for different thickness or radius.

*3 Clamp Torque (lbf-in) : XNS36=30, XNS510=70

*2 For inserts without hole, remove shim pin and add below.

Shim Screw	Chipbreaker
S34	CBT3

EXTERNAL TURNING TOOLS

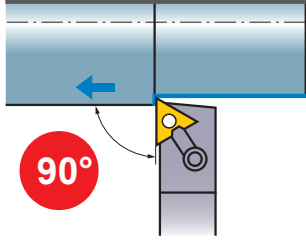
MTGN type inserts > A130-A137
 CBN & PCD inserts > B030, B031, B050
 CUTTING CONDITIONS > A080, B008

SPARE PARTS > M001
 TECHNICAL DATA > N001

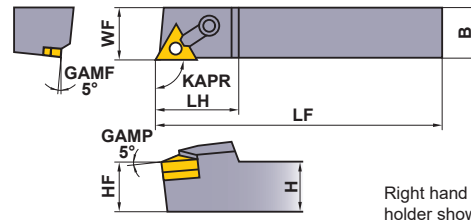
EXTERNAL TURNING TOOLS

TN INSERTS TOOL HOLDERS

MTAN



External turning Multiple Clamp Type M Holder



Finish	Light	Medium	Medium
FP	LP	MP	MK
			
(3)	(3)	(3,4)	(3,4)
Medium to Rough	Stainless	G Class	CBN
RP	MM	R/L	
			
(3)	(3,4)	(3,4)	(3)

C

EXTERNAL TURNING TOOLS

Order Number	ANSI Number	Stock		Insert Number	Dimensions (inch)						Shim	Shim Pin	Clamp Bridge	Clamp Screw
		R	L		H	B	LF	LH	HF	WF				
MTANR-102	MTANR102B	●		22	.625	.625	4.500	.875	.625	.625	—	NL23	CL19	XNS36
MTANR/L-103X	MTANR/L103B	●	□	33	.625	.625	4.500	1.000	.625	.625	ITSN323*	NL34L	CL6	XNS36
MTANR/L-123X	MTANR/L123B	●	□		.750	.750	4.500	1.000	.750	.750				
MTANR/L-163X	MTANR/L163D	●	●		1.000	1.000	6.000	1.000	1.000	1.000				
MTANR/L-164	MTANR/L164D	●	●		1.000	1.000	6.000	1.375	1.000	1.000				
MTANR/L-204	MTANR/L204E	●	●	43	1.250	1.250	7.000	1.375	1.250	1.250	ITSN433*	NL46	CL9	XNS59
MTANR-864	MTANR864E	□		54	1.500	1.000	7.000	1.375	1.500	1.000				
MTANR-165	MTANR165D	●			1.000	1.000	6.000	1.500	1.000	1.000				
MTANR-205	MTANR205E	●			1.250	1.250	7.000	1.500	1.250	1.250				
MTANR-246	MTANR246E	●		66	1.500	1.500	7.000	1.750	1.500	1.500	ITSN636*	NL68L	CL12	XNS510

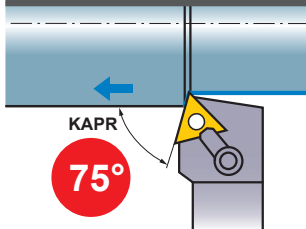
*1 (Opt.) See page M012 for different thickness or radius.

*3 Clamp Torque (lbf-in) : XNS36=30, XNS59=70, XNS510=70

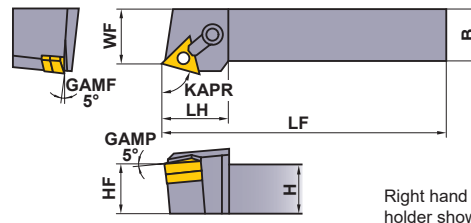
*2 For inserts without hole, remove shim pin and add below.

Shim Screw	Chipbreaker
S34	CBT3

MTRN



External turning Multiple Clamp Type M Holder



Finish	Light	Medium	Medium
FP	LP	MP	MK
			
(3)	(3)	(3,4)	(3,4)
Medium to Rough	Stainless	G Class	CBN
RP	MM	R/L	
			
(3)	(3,4)	(3,4)	(3)

Order Number	ANSI Number	Stock		Insert Number	Dimensions (inch)						Shim	Shim Pin	Clamp Bridge	Clamp Screw
		R	L		H	B	LF	LH	HF	WF				
MTRNR/L-123X	MTRNR/L123B	□	□	33	.750	.750	4.500	1.250	.750	.855	ITSN323*	NL34L	CL20	XNS47
MTRNR/L-164	MTRNR/L164D	●	□	43	1.000	1.000	6.000	1.375	1.000	1.048				

*1 (Opt.) See page M012 for different thickness or radius.

*3 Clamp Torque (lbf-in) : XNS47=45, XNS510=70

*2 For inserts without hole, remove shim pin and add below.

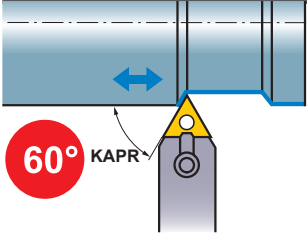
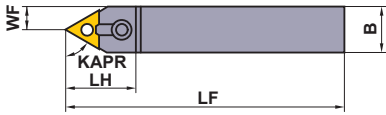
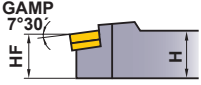
Shim Screw	Chipbreaker
S34	CBT3

Note 1) Insert photo is an example. Letters show chip breaker style, figures show inscribed circle.

● : USA Stock □ : Made to Order

MTAN type inserts > A130-A137
MTRN type inserts > A130-A137

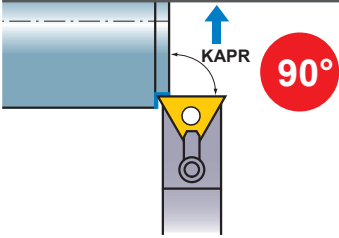
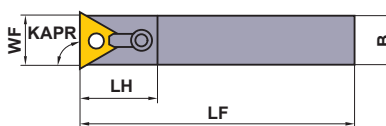
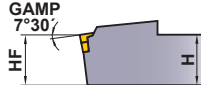
CBN & PCD inserts > B030, B031, B050
CUTTING CONDITIONS > A080, B008

MTEN		External turning Chamfering	Multiple Clamp Type M Holder		Finish	Light	Medium	Medium
					 (3)	 (3)	 (3,4)	 (3,4)
					Medium to Rough RP	Stainless MM	G Class R/L	CBN (3)

Order Number	ANSI Number	Stock	Insert Number		Dimensions (inch)						Shim	Shim Pin	Clamp Bridge	*2 Clamp Screw
					H	B	LF	LH	HF	WF				
MTENN-82	MTENN082B	●	TNMA TNMG TNMM TNGA TNGG	22 [○]	.500	.500	4.500	1.000	.500	.250	—	NL23	CL6	XNS36
MTENN-103X	MTENN103B	●		33 ^{○*1}	.625	.625	4.500	1.125	.625	.313	ITSN323 ^{*1}	NL34L	CL6	XNS36
MTENN-123X	MTENN123B	●			.750	.750	4.500	1.125	.750	.375				
MTENN-164	MTENN164D	●			1.000	1.000	6.000	1.500	1.000	.500	ITSN433 ^{*1}	NL46	CL9	XNS59
MTENN-854	MTENN854D	□		43 ^{○*1}	1.250	1.000	6.000	1.500	1.250	.500				
MTENN-864	MTENN864E	●			1.500	1.000	7.000	1.500	1.500	.500	ITSN533 ^{*1}	NL58	CL9	XNS510
MTENN-205	MTENN205E	●		54 ^{○*1}	1.250	1.250	7.000	1.625	1.250	.625				
MTENN-865	MTENN865E	●			1.500	1.000	7.000	1.625	1.500	.500				

*1 (Opt.) See page M012 for different thickness or radius.

*2 Clamp Torque (lbf-in) : XNS36=30, XNS59=70, XNS510=70

MTCN		Facing	Multiple Clamp Type M Holder		Finish	Light	Medium	Medium
					 (3)	 (3)	 (3,4)	 (3,4)
					Medium to Rough RP	Stainless MM	G Class R/L	CBN (3)

Order Number	ANSI Number	Stock	Insert Number		Dimensions (inch)						Shim	Shim Pin	Clamp Bridge	*3 Clamp Screw
					H	B	LF	LH	HF	WF				
MTCNN-83X	MTCNN083B	□	TNMA TNMG TNMM TNGA TNGG	33 ^{*1*2}	.500	.500	4.500	1.000	.500	Central to "B"	ITSN323 ^{*1}	NL34L	CL7	XNS36
MTCNN-443X	MTCNN443F	□			1.000	.500	8.000	1.000	1.000					
MTCNN-124	MTCNN124B	●		43 ^{*1}	.750	.750	4.500	1.375	.750		ITSN433 ^{*1}	NL46	CL12	XNS59
MTCNN-644	MTCNN644F	□			1.000	.750	8.000	1.375	1.000					
MTCNN-664	MTCNN664F	□			1.500	.750	8.000	1.375	1.500					

*1 (Opt.) See page M012 for different thickness or radius.

*3 Clamp Torque (lbf-in) : XNS36=30, XNS59=70

*2 For inserts without hole, remove shim pin and add below.

Shim Screw	S34	Chipbreaker	CBT3
------------	-----	-------------	------

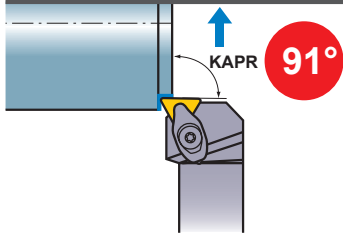
MTEN type inserts > A130-A137
MTCN type inserts > A130-A137
CBN & PCD inserts > B030, B031, B050
CUTTING CONDITIONS > A080, B008

SPARE PARTS > M001
TECHNICAL DATA > N001

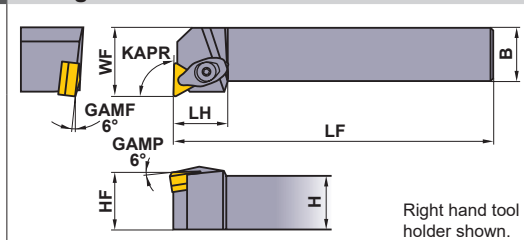
EXTERNAL TURNING TOOLS

TN INSERTS TOOL HOLDERS

DTFN



DOUBLE CLAMP Type



Right hand tool holder shown.

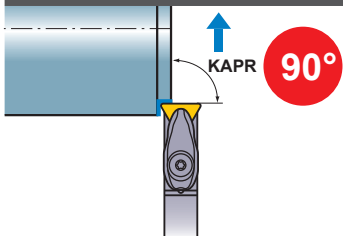
Finish	Light	Medium	Medium
FP  (3)	LP  (3)	MP  (3,4)	MK  (3,4)
Medium to Rough RP  (3)	Stainless MM  (3,4)	G Class R/L  (3,4)	CBN  (3)

Order Number	ANSI Number	Stock		Insert Number	Dimensions (inch)						Shim	Shim Pin	Clamp Bridge	Spring	Clamp Screw	Wrench
		R	L		H	B	LF	LH	HF	WF						
DTFNR/L-123	DTFNR/L123B	●	●	33	.750	.750	4.500	1.000	.750	1.000	*1 LLSTN32 (LLSTN33)	LLP23	DCK2211	DCS2	DC0520T	TKY15F
DTFNR/L-163	DTFNR/L163D	●	●		1.000	1.000	6.000	1.000	1.000	1.250						
DTFNR/L-164	DTFNR/L164D	●	●	43	1.000	1.000	6.000	1.219	1.000	1.250	LLSTN42	LLP14	DCK2613	DCS1	DC0621T	TKY20F
DTFNR/L-204	DTFNR/L204D	●	●		1.250	1.250	6.000	1.219	1.250	1.500						

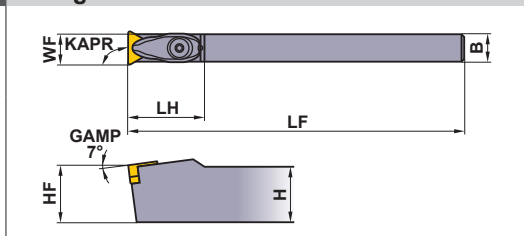
*1 Please use shim no.LLSTN33 with .125inch thick insert. When using .125inch thick inserts, the shim must be ordered separately.

*2 Clamp Torque (lbf-in) : DC0520T=31, DC0621T=44

DTCN



DOUBLE CLAMP Type



Finish	Light	Medium	Medium
FP  (3)	LP  (3)	MP  (3)	MK  (3)
Medium to Rough RP  (3)	Stainless MM  (3)	G Class R/L  (3)	CBN  (3)

Order Number	ANSI Number	Stock		Insert Number	Dimensions (inch)						Shim	Shim Pin	Clamp Bridge	Spring	Clamp Screw	Wrench
		R	L		H	B	LF	LH	HF	WF						
DTCNN-433	DTCNN433B	●	●	33	.750	.500	4.500	1.375	.750	.539	*1 LLSTN32 (LLSTN33)	LLP23	DCK3113	DCS2	DC0520T	TKY15F
DTCNN-443	DTCNN443D	●	●		1.000	.500	6.000	1.375	1.000	.539						

*1 Please use shim no.LLSTN33 with .125inch thick insert. When using .125inch thick inserts, the shim must be ordered separately.

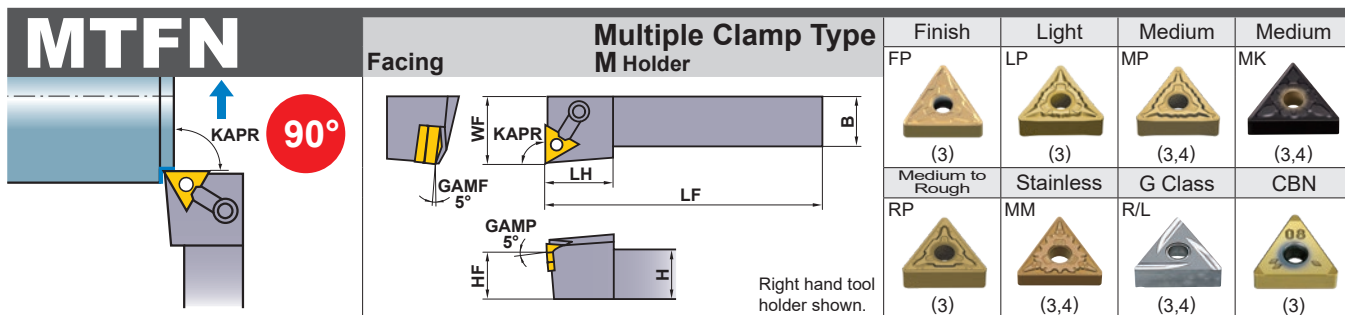
*2 Clamp Torque (lbf-in) : DC0520T=31

Note 1) Insert photo is an example. Letters show chip breaker style, figures show inscribed circle.

● : USA Stock □ : Made to Order

DTFN type inserts > A130-A137
DTCN type inserts > A130-A137

CBN & PCD inserts > B030, B031, B050
CUTTING CONDITIONS > A080, B008



Order Number	ANSI Number	Stock		Insert Number		Dimensions (inch)						Shim	Shim Pin	Clamp Bridge	Clamp Screw
		R	L			H	B	LF	LH	HF	WF				
MTFNR/L-82	MTFNR/L082B	☐	☐	TNMA TNMG TNMM TNGA TNGG	22 [⌀]	.500	.500	4.500	.875	.500	.750	—	NL23	CL19	XNS36
MTFNR/L-103X	MTFNR/L103B	☐	☐		33 ^{*1*2} ⌀	.625	.625	4.500	1.000	.625	.875	ITSN323 ^{*1}	NL34L	CL6	XNS36
MTFNR/L-123BX	MTFNR/L123B	☒	☒			.750	.750	4.500	1.000	.750	1.000				
MTFNR/L-163CX	MTFNR/L163C	☒	☒			1.000	1.000	5.000	1.000	1.000	1.250				
MTFNR/L-163DX	MTFNR/L163D	☐	☐		1.000	1.000	6.000	1.000	1.000	1.250	ITSN433 ^{*1}	NL46	CL9	XNS510	
MTFNR/L-164C	MTFNR/L164C	☒	☒		43 ^{*1} ⌀	1.000	1.000	5.000	1.250	1.000					1.250
MTFNR/L-164D	MTFNR/L164D	☒	☒			1.000	1.000	6.000	1.250	1.000					1.250
MTFNR/L-204D	MTFNR/L204D	☒	☒		54 ^{*1} ⌀	1.250	1.250	6.000	1.250	1.250	1.500	ITSN533 ^{*1}	NL58	CL12	XNS510
MTFNL-165C	MTFNL165C	☒	☒			1.000	1.000	5.000	1.375	1.000	1.250				
MTFNR/L-165D	MTFNR/L165D	☒	☒			1.000	1.000	6.000	1.375	1.000	1.250				
MTFNR/L-205D	MTFNR/L205D	☒	☒		66 ^{*1} ⌀	1.250	1.250	6.000	1.375	1.250	1.500	ITSN636 ^{*1}	NL68L	CL12	XNS510
MTFNR/L-855D	MTFNR/L855D	☒	☒			1.250	1.000	6.000	1.375	1.250	1.250				
MTFNR/L-246D	MTFNR/L246D	☒	☒			1.500	1.500	6.000	1.500	1.500	2.000				
MTFNR/L-246E	MTFNR/L246E	☒	☒		1.500	1.500	7.000	1.500	1.500	2.000					

*1 (Opt.) See page M012 for different thickness or radius.

*3 Clamp Torque (lbf-in) : XNS36=30, XNS510=70

*2 For inserts without hole, remove shim pin and add below.

Shim Screw	Chipbreaker
S34	CBT3

EXTERNAL TURNING TOOLS

MTFN type inserts > A130-A137
 CBN & PCD inserts > B030, B031, B050
 CUTTING CONDITIONS > A080, B008

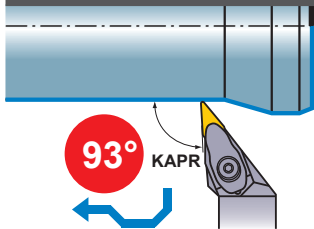
SPARE PARTS > M001
 TECHNICAL DATA > N001

C023

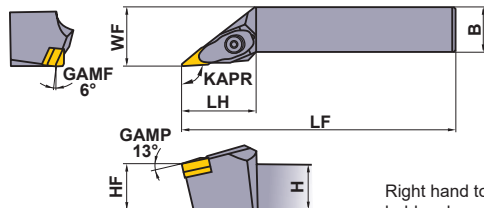
EXTERNAL TURNING TOOLS

VN INSERTS TOOL HOLDERS

DVJN



External turning DOUBLE CLAMP Type Copying



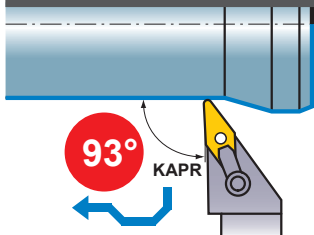
Right hand tool holder shown.

Finish	Light	Medium	Medium
FP	LP	MP	MK
			
(3)	(3)	(3)	(3)
Medium	Stainless	G Class	CBN
Standard	MM	R/L	
			
(3)	(3)	(3)	(3)

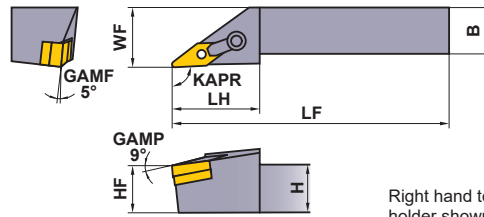
Order Number	ANSI Number	Stock		Insert Number	Dimensions (inch)						Shim	Shim Pin	Clamp Bridge	Spring	Clamp Screw	Wrench
		R	L		H	B	LF	LH	HF	WF						
DVJNR/L-123	DVJNR/L123B	●	●	VNGA	33	.750	.750	4.500	1.625	.750	1.000					
DVJNR/L-163	DVJNR/L163D	●	●	VNMG		1.000	1.000	6.000	1.625	1.000	1.250	DCSVN32	LLP13	DCCK3113	DCS2	DC0520T
		●	●	VNGM												TKY15F
		●	●	VNGG												
DVJNR/L-203	DVJNR/L203D	●	●	VNMM		1.250	1.250	6.000	1.625	1.250	1.500					

* Clamp Torque (lbf-in) : DC0520T=31

MVJN



External turning Multiple Clamp Type Copying M Holder



Right hand tool holder shown.

Finish	Light	Medium	Medium
FP	LP	MP	MK
			
(3)	(3)	(3)	(3)
Medium	Stainless	G Class	CBN
Standard	MM	R/L	
			
(3)	(3)	(3)	(3)

Order Number	ANSI Number	Stock		Insert Number		Dimensions (inch)					Shim	Shim Pin	Clamp Bridge	Clamp Screw	
		R	L			H	B	LF	LH	HF					WF
MVJNR/L-123B	MVJNR/L123B	●	●	VNGA VNMG VNGM VNGG VNMM	33	.750	.750	4.500	1.750	.750	1.000	IVSN322	NL34L	CL30	XNS510
MVJNR/L-163C	MVJNR/L163C	●	●			1.000	1.000	5.000	1.750	1.000	1.250				
MVJNR/L-163D	MVJNR/L163D	●	●			1.000	1.000	6.000	1.750	1.000	1.250				
MVJNR/L-203D	MVJNR/L203D	□	□			1.250	1.250	6.000	1.750	1.250	1.500				
MVJNR/L-164C	MVJNR/L164C	□	●		43	1.000	1.000	5.000	2.125	1.000	1.250	IVSN433 ^{*1}	NL46	CL30	XNS510
MVJNR/L-164D	MVJNR/L164D	●	●			1.000	1.000	6.000	2.125	1.000	1.250				
MVJNR/L-204D	MVJNR/L204D	□	□			1.250	1.250	6.000	2.125	1.250	1.500				

*1 (Opt.) See page M012 for different radius.

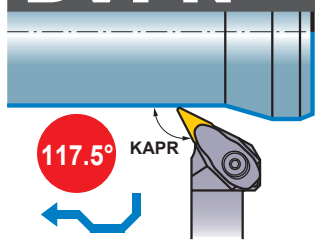
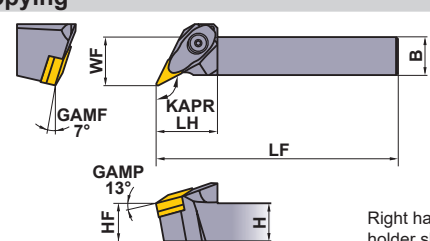
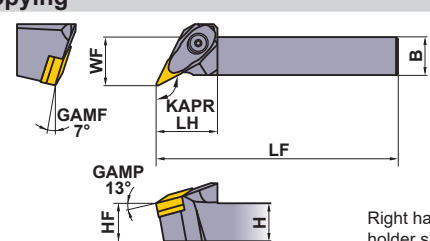
*2 Clamp Torque (lbf-in) : XNS510=70

Note 1) Insert photo is an example. Letters show chip breaker style, figures show inscribed circle.

● : USA Stock □ : Made to Order

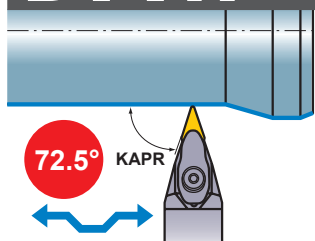
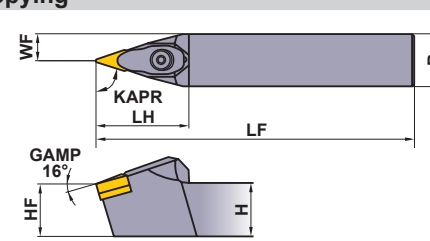
DVJN type inserts > A138-A141
MVJN type inserts > A138-A141

CBN & PCD inserts > B032, B033, B051
CUTTING CONDITIONS > A080, B008

DVPN		Facing Copying		DOUBLE CLAMP Type							Finish	Light	Medium	Medium			
											FP	LP	MP	MK			
											(3)	(3)	(3)	(3)			
											Medium	Stainless	G Class	CBN			
											Standard	MM	R/L				
											(3)	(3)	(3)	(3)			
Order Number	ANSI Number	Stock		Insert Number	Dimensions (inch)						Shim	Shim Pin	Clamp Bridge	Spring	Clamp Screw	* Wrench	
DVPNR/L-123	DVPNR/L123B	●	●	VNGA VNMG VNGM VNGG VNMM	33	.750	.750	4.500	1.250	.750	1.000	DCSVN32	LLP13	DCK3113	DCS2	DC0520T	TKY15F
DVPNR/L-163	DVPNR/L163D	●	●	VNGA VNMG VNGM VNGG VNMM	33	1.000	1.000	6.000	1.250	1.000	1.250						

* Clamp Torque (lbf-in) : DC0520T=31

* Clamp Torque (lbf-in) : DC0520T=31

DVVN		External turning DOUBLE CLAMP Type Copying										Finish		Light		Medium		Medium	
												FP	LP	MP	MK				
												(3)		(3)		(3)		(3)	
												Medium		Stainless		G Class		CBN	
												Standard		MM		R/L			
										(3)		(3)		(3)		(3)			
Order Number	ANSI Number	Stock	Insert Number	Dimensions (inch)								Shim	Shim Pin	Clamp Bridge	Spring	Clamp Screw	* Wrench		
				H	B	LF	LH	HF	WF										
DVVNN-123	DVVNN123B	●●	33 ⁰	.750	.750	4.500	1.750	.750	.375	DCSVN32	LLP13	DCK3113	DCS2	DC0520T	TKY15F				
DVVNN-163	DVVNN163D	●●		1.000	1.000	6.000	1.750	1.000	.500										

* Clamp Torque (lbf-in) : DC0520T=31

DVPN type inserts > A138—A141
 DVVN type inserts > A138—A141
 CBN & PCD inserts > B032, B033, B051

CUTTING CONDITIONS > A080, B008
 SPARE PARTS > M001
 TECHNICAL DATA > N001

EXTERNAL TURNING TOOLS

VN INSERTS TOOL HOLDERS

MVLN

Facing

Multiple Clamp Type
M Holder

Medium
MJ

(4)

Right hand tool holder shown.

C

EXTERNAL TURNING TOOLS

Order Number	ANSI Number	Stock		Insert Number	Dimensions (inch)						Shim	Shim Pin	Clamp Bridge	Clamp Screw
		R	L		H	B	LF	LH	HF	WF				
MVLNR/L-164C	MVLNR/L164C	●	●	VNGM 43	1.000	1.000	5.000	1.500	1.000	1.750	IVSN433 ^{*1}	NL46	CL30	XNS510
MVLNR/L-164D	MVLNR/L164D	●	●		1.000	1.000	6.000	1.500	1.000	1.750				
MVLNR/L-204D	MVLNR/L204D	●	●		1.250	1.250	6.000	1.500	1.250	2.000				
MVLNR-244D	MVLNR244D	□			1.500	1.500	6.000	1.500	1.500	2.250				

*1 (Opt.) See page M012 for different radius.

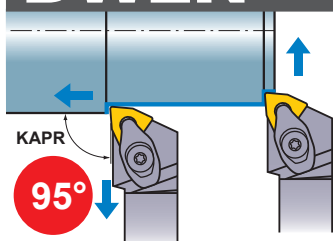
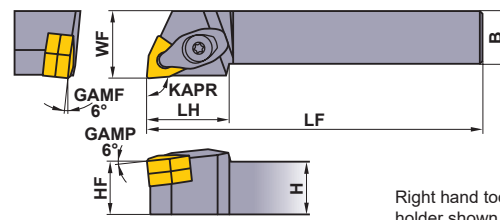
*2 Clamp Torque (lbf-in) : XNS510=70

Note 1) Insert photo is an example. Letters show chip breaker style, figures show inscribed circle.

● : USA Stock □ : Made to Order

MVLN type inserts ➤ A140
CUTTING CONDITIONS ➤ A080

WN INSERTS TOOL HOLDERS

DWLN		External turning DOUBLE CLAMP Type Facing										Finish		Light		Medium		Medium	
												FP		LP		MP		MK	
												(4)		(4)		(3,4)		(4)	
												Medium		Medium to Rough		Stainless		CBN	
												Standard		RP		MM			
												(4)		(4)		(3,4)		(4)	

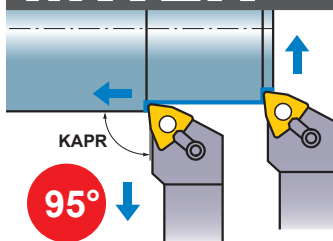
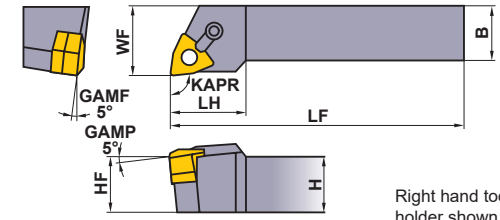
Order Number	ANSI Number	Stock		Insert Number	Dimensions (inch)						Shim	Shim Pin	Clamp Bridge	Spring	Clamp Screw	Wrench
		R	L		H	B	LF	LH	HF	WF						
DWLN/L-123	DWLN/L123B	●	●	33	.750	.750	4.500	1.000	.750	1.000	LLSWN32 ^{*1} (LLSWN33)	LLP23	DCK2211	DCS2	DC0520T	TKY15F
DWLN/L-163	DWLN/L163D	●	●		1.000	1.000	6.000	1.000	1.000	1.250						
DWLN/L-124	DWLN/L124B	●	●		.750	.750	4.500	1.250	.750	1.000						
DWLN/L-164	DWLN/L164D	●	●	43	1.000	1.000	6.000	1.250	1.000	1.250	LLSWN42	LLP14	DCK2613	DCS1	DC0621T	TKY20F
DWLN/L-204	DWLN/L204D	●	●		1.250	1.250	6.000	1.250	1.250	1.500						

^{*1} Please use shim no.LLSWN33 with .125inch thick insert. When using .125inch thick inserts, the shim must be ordered separately.

^{*2} Clamp Torque (lbf-in) : DC0520T=31, DC0621T=44

*1 Please use shim no.LLSWN33 with .125inch thick insert. When using .125inch thick inserts, the shim must be ordered separately.

*2 Clamp Torque (lbf-in) : DC0520T=31, DC0621T=44

MWLN		External turning Facing		Multiple Clamp Type M Holder							Finish	Light	Medium	Medium		
													 (4)	 (4)	 (3,4)	 (4)
									Medium	Medium to Rough	Stainless	CBN				
									Standard	RP	MM					
									 (4)	 (4)	 (3,4)	 (4)				
Order Number	ANSI Number	Stock		Insert Number	Dimensions (inch)						Shim	Shim Pin	Clamp Bridge	Clamp Screw		
		R	L		H	B	LF	LH	HF	WF						
MWLN/L-1232	MWLN/L1232B	●	●	33	.750	.750	4.500	1.000	.750	1.000	IWSN322	NL34L	CL6	XNS36		
MWLN/L-1632	MWLN/L1632D	●	●		1.000	1.000	6.000	1.000	1.000	1.250						
MWLN/L-1233	MWLN/L1233B	●	●		.750	.750	4.500	1.000	.750	1.000						
MWLN/L-1633	MWLN/L1633D	●	●		1.000	1.000	6.000	1.000	1.000	1.250						
MWLN/L-124B	MWLN/L124B	●	●	43	.750	.750	4.500	1.250	.750	1.000	IWSN433	NL46	CL9	XNS59		
MWLN/L-164D	MWLN/L164D	●	●		1.000	1.000	6.000	1.250	1.000	1.250			CL20	XNS48		
MWLN/L-204D	MWLN/L204D	●	●		1.250	1.250	6.000	1.250	1.250	1.500			CL9	XNS59		
MWLN/L-854D	MWLN/L854D	●	●		1.250	1.000	6.000	1.250	1.250	1.250						
MWLN/L-165D	MWLN/L165D	●	●	54	1.000	1.000	6.000	1.250	1.000	1.250	IWSN533	NL58	CL9	XNS59		
MWLN/L-205D	MWLN/L205D	●	●		1.250	1.250	6.000	1.370	1.250	1.500						
MWLN/L-245E	MWLN/L245E	●	●		1.500	1.500	7.000	1.370	1.500	2.000						

* Clamp Torque (lbf-in) : XNS36=30, XNS48=45, XNS59=70

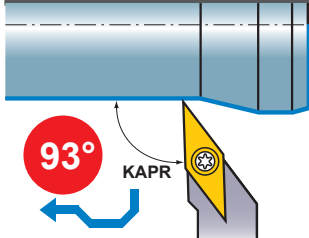
DWLN type inserts > A142-A147
MWLN type inserts > A142-A147
CBN inserts > B034

CUTTING CONDITIONS > A080, B008
SPARE PARTS > M001
TECHNICAL DATA > N001

EXTERNAL TURNING TOOLS

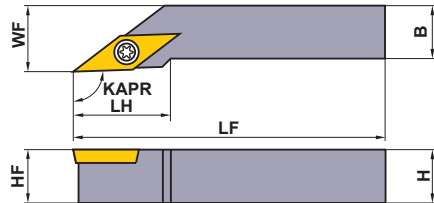
VB INSERTS TOOL HOLDERS

SVJB



External turning
Copying

Screw Clamp Type
SP Holder



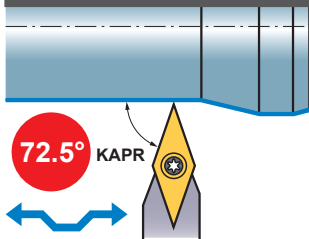
Right hand tool holder shown.

Finish	Finish	Light	Light
FP	FM	LP	LM
			
(2,3)	(2,3)	(2,3)	(2,3)
Medium	Medium	Medium	CBN
MP	MM	Standard	
			
(3)	(3)	(3)	(2,3)

Order Number	ANSI Number	Stock		Insert Number		Dimensions (inch)						Clamp Screw	Wrench
		R	L			H	B	LF	LH	HF	WF		
SVJBR/L-062	SVJBR/L062X	●	●	VBGT VBMT VBET VBGW	22 ³	.375	.375	2.500	.875	.375	.500	TS25	TKY08F
SVJBR/L-082	SVJBR/L082X	●	●			.500	.500	3.500	.875	.500	.625		
SVJBR/L-102	SVJBR/L102A	●	●			.625	.625	4.000	.875	.625	.750		
SVJBR/L-123	SVJBR/L123B	●	●	33 ³	33 ³	.750	.750	4.500	1.250	.750	1.000	TS4	TKY15F
SVJBR/L-163	SVJBR/L163D	●	●			1.000	1.000	6.000	1.250	1.000	1.250		

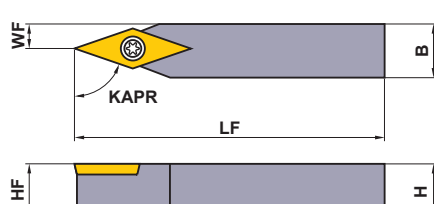
* Clamp Torque (lbf-in) : TS25=8.9, TS4=31

SVVB



External turning
Copying

Screw Clamp Type
SP Holder



Finish	Finish	Light	Light
FP	FM	LP	LM
			
(2,3)	(2,3)	(2,3)	(2,3)
Medium	Medium	Medium	CBN
MP	MM	Standard	
			
(3)	(3)	(3)	(2,3)

Order Number	ANSI Number	Stock		Insert Number	Dimensions (inch)						Clamp Screw	Wrench
		R	L		H	B	LF	HF	WF			
SVVBN-062	SVVBN062X	●	●	VBGT VBMT VBET VBGW	22	.375	.375	2.500	.375	.188	TS25	TKY08F
SVVBN-082	SVVBN082X	●	●			.500	.500	3.000	.500	.250		
SVVBN-102	SVVBN102A	●	●			.625	.625	4.000	.625	.313		
SVVBN-122	SVVBN122B	●	●	33	33	.750	.750	4.500	.750	.375	TS4	TKY15F
SVVBN-123	SVVBN123B	●	●			.750	.750	4.500	.750	.375		
SVVBN-163	SVVBN163D	●	●			1.000	1.000	6.000	1.000	.500		

* Clamp Torque (lbf-in) : TS25=8.9, TS4=31

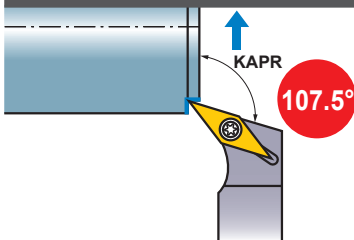
Note 1) Insert photo is an example. Letters show chip breaker style, figures show inscribed circle.

● : USA Stock

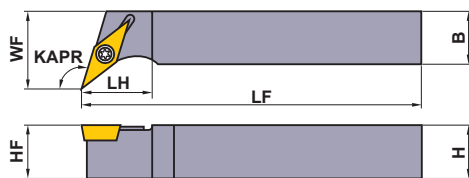
SVJB type inserts > A186-A189
SVVB type inserts > A186-A189

CBN & PCD inserts > B045, B058
CUTTING CONDITIONS > A093, B008

SVHB



Facing Screw Clamp Type SP Holder



Right hand tool holder shown.

Finish	Finish	Light	Light
FP	FM	LP	LM
			
(2,3)	(2,3)	(2,3)	(2,3)
Medium	Medium	Medium	CBN
MP	MM	Standard	
			
(3)	(3)	(3)	(2,3)

Order Number	ANSI Number	Stock		Insert Number	Dimensions (inch)						Clamp Screw	Wrench	
		R	L		H	B	LF	LH	HF	WF			
SVHBR/L-062	SVHBR/L062X	●	●	VBGT VBM VBET VBGW	22°	.375	.375	2.500	.875	.375	.500	TS25	TKY08F
SVHBR/L-082	SVHBR/L082X	●	●			.500	.500	3.500	.875	.500	.625		
SVHBR/L-102	SVHBR/L102A	●	●			.625	.625	4.000	.875	.625	.750		
SVHBR/L-123	SVHBR/L123B	●	●	33°		.750	.750	4.500	1.250	.750	1.000	TS4	TKY15F
SVHBR/L-163	SVHBR/L163D	●	●			1.000	1.000	6.000	1.250	1.000	1.250		

* Clamp Torque (lbf-in) : TS25=8.9, TS4=31

EXTERNAL TURNING TOOLS

SVHB type inserts > A186-A189
 CBN & PCD inserts > B045, B058
 CUTTING CONDITIONS > A093, B008

SPARE PARTS > M001
 TECHNICAL DATA > N001

C029

EXTERNAL TURNING TOOLS

CC INSERTS TOOL HOLDERS

SCLC

External turning Facing

Screw Clamp Type SP Holder

Right hand tool holder shown.

Finish	Light	Medium	Stainless
FP (2,3)	LP (2,3)	MP (2,3)	FM (2,3)
Stainless	Stainless	Flat Top	PCD/CBN
LM (2,3,4)	MM (2,3,4)	 (2,3,4)	 (2,3,4)

Order Number	ANSI Number	Stock		Insert Number	Dimensions (inch)						Shim	Shim Screw	* Clamp Screw	Wrench	
		R	L		H	B	LF	LH	HF	WF					
SCLCR/L-062	SCLCR/L062X	●	●	CCGB 21.5	.375	.375	2.500	.350	.375	.500	—	—	TS25	TKY08F	
SCLCR/L-083	SCLCR/L083X	●	●	CCET 32.5	.500	.500	3.500	.540	.500	.625			TS43	TKY15F	
SCLCR/L-104	SCLCR/L104A	●	●	CCMT 43	.625	.625	4.000	.660	.625	.750			TS5	TKY25F	
SCLCR/L-124	SCLCR/L124B	●	●	CCMW	.750	.750	4.500	.660	.750	.875	SPSCN42	JSS7	TS53		
SCLCR/L-164	SCLCR/L164D	●	●	CCGW CCMH	1.000	1.000	6.000	1.000	1.000	1.250					

* Clamp Torque (lbf-in) : TS25=8.9, TS43=31, TS5=66, TS53=66

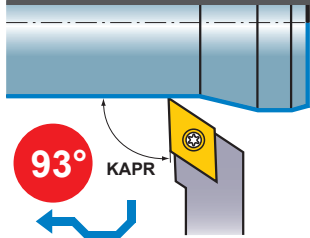
Note 1) Insert photo is an example. Letters show chip breaker style, figures show inscribed circle.

● : USA Stock

SCLC type inserts > A152–A161
 CBN & PCD inserts > B037, B038, B053
 CUTTING CONDITIONS > A093, B008

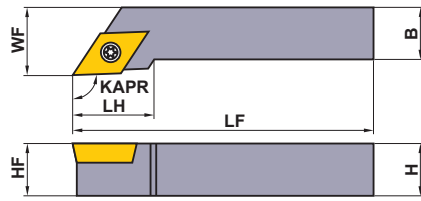
DC INSERTS TOOL HOLDERS

SDJC

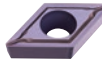
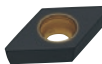


External turning
Copying

Screw Clamp Type
SP Holder



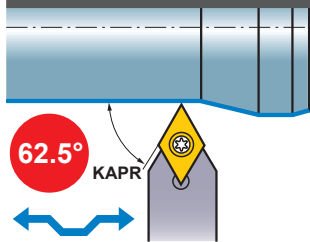
Right hand tool holder shown.

Finish	Light	Medium	Stainless
FP  (2,3)	LP  (2,3)	MP  (2,3)	FM  (2,3)
Stainless LM  (2,3)	Stainless MM  (2,3)	Flat Top  (2,3)	PCD/CBN  (2,3)

Order Number	ANSI Number	Stock		Insert Number	Dimensions (inch)						Shim	Shim Screw	Clamp Screw *	Wrench
		R	L		H	B	LF	LH	HF	WF				
SDJCR/L-062	SDJCR/L062X	●	●	21.5 DCET DCGT DCMT DCMW DCGW	.375	.375	2.500	.500	.375	.500	—	—	TS25	TKY08F
SDJCR/L-083	SDJCR/L083X	●	●		.500	.500	3.500	.700	.500	.625			TS43	TKY15F
SDJCR/L-103	SDJCR/L103A	●	●		.625	.625	4.000	.700	.625	.750			TS406	TKY15R
SDJCR/L-123	SDJCR/L123B	●	●		.750	.750	4.500	.700	.750	.875	SPSDN32	JSS6	TS406	TKY15R
SDJCR/L-163	SDJCR/L163D	●	●		1.000	1.000	6.000	1.000	1.000	1.250				

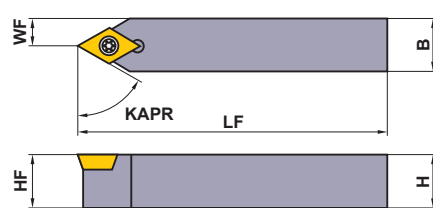
* Clamp Torque (lbf-in) : TS25=8.9, TS43=31, TS406=31

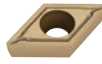
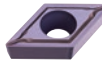
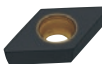
SDNC



External turning
Copying

Screw Clamp Type
SP Holder



Finish	Light	Medium	Stainless
FP  (2,3)	LP  (2,3)	MP  (2,3)	FM  (2,3)
Stainless LM  (2,3)	Stainless MM  (2,3)	Flat Top  (2,3)	PCD/CBN  (2,3)

Order Number	ANSI Number	Stock	Insert Number		Dimensions (inch)					Shim	Shim Screw	Clamp Screw*	Wrench
					H	B	LF	HF	WF				
SDNCN-062	SDNCN062X	●	DCET DCGT DCMT DCMW DCGW	21.5	.375	.375	2.500	.375	.188	—	—	TS25	TKY08F
SDNCN-083	SDNCN083X	●		32.5	.500	.500	3.500	.500	.250			TS43	TKY15F
SDNCN-103	SDNCN103A	●			.625	.625	4.000	.625	.313			SPSDN32	JSS6
SDNCN-123	SDNCN123B	●			.750	.750	4.500	.750	.375				
SDNCN-163	SDNCN163D	●			1.000	1.000	6.000	1.000	.500				

* Clamp Torque (lbf-in) : TS25=8.9, TS43=31, TS406=31

SDJC type inserts > A164-A171
SDNC type inserts > A164-A171
CBN & PCD inserts > B040, B041, B054

CUTTING CONDITIONS > A093, B008
SPARE PARTS > M001
TECHNICAL DATA > N001

EXTERNAL TURNING TOOLS

EXTERNAL TURNING TOOLS

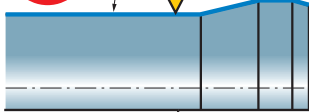
DC INSERTS TOOL HOLDERS

SDXC



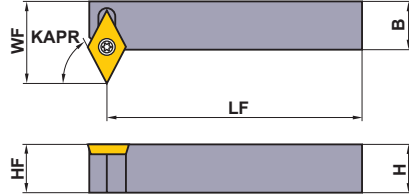
62.5°

KAPR

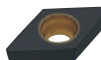


External turning
Copying

Screw Clamp Type
SP Holder



Right hand tool holder shown.

Finish	Light	Medium	Stainless
FP  (2,3)	LP  (2,3)	MP  (2,3)	FM  (2,3)
Stainless	Stainless	Flat Top	PCD/CBN
LM  (2,3)	MM  (2,3)	 (2,3)	 (2,3)

C

EXTERNAL TURNING TOOLS

Order Number	ANSI Number	Stock		Insert Number	Dimensions (inch)					Clamp Screw	Wrench	
		R	L		H	B	LF	HF	WF			
SDXCR/L-062	SDXCR/L062X	●	●	DCET DCGT DCMT DCMW DCGW	21.5	.375	.375	2.500	.375	.625	TS25	TKY08F
SDXCR/L-082	SDXCR/L082X	●	●			.500	.500	3.500	.500	.750		
SDXCR/L-103	SDXCR/L103A	●	●			.625	.625	4.000	.625	1.000	TS43	TKY15F

* Clamp Torque (lbf-in) : TS25=8.9, TS43=31

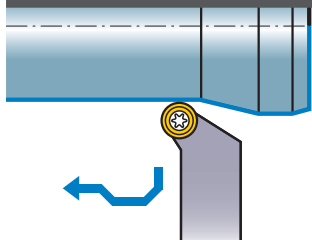
Note 1) Insert photo is an example. Letters show chip breaker style, figures show inscribed circle.

● : USA Stock

SDXC type inserts	➤ A164–A171
CBN & PCD inserts	➤ B040, B041, B054
CUTTING CONDITIONS	➤ A093, B008

RC INSERTS TOOL HOLDERS

SRGC



External turning
Copying

Screw Clamp Type
SP Holder

Medium –
Finish Cutting
AZ



Medium
Standard

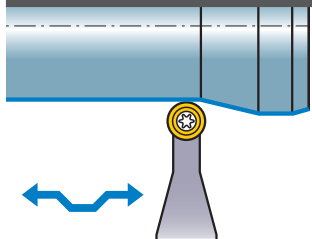


Right hand tool holder shown.

Order Number	ANSI Number	Stock		Insert Number	Dimensions (inch)						Clamp Screw *	Wrench
		R	L		H	B	LF	LH	HF	WF		
SRGCR/L-0608M	SRGCR/L0608X	●	●	RCGT RCMT 0803M0	.375	.375	2.500	.610	.375	.625	TS3	TKY08F
SRGCR/L-0808M	SRGCR/L0808X	●	●		.500	.500	3.500	.610	.500	.750		
SRGCR/L-1008M	SRGCR/L1008A	●	●		.625	.625	4.000	.610	.625	.875		

* Clamp Torque (lbf-in) : TS3=8.9

SRDC



External turning
Copying

Screw Clamp Type
SP Holder

Medium –
Finish Cutting
AZ



Medium
Standard



Order Number	ANSI Number	Stock		Insert Number	Dimensions (inch)						Clamp Screw *	Wrench
		R	L		H	B	LF	LH	HF	WF		
SRDCN-0608M	SRDCN0608X	●	●	RCGT RCMT 0803M0	.375	.375	2.500	.375	.375	.188	TS3	TKY08F
SRDCN-0808M	SRDCN0808X	●	●		.500	.500	3.500	.500	.500	.250		
SRDCN-1008M	SRDCN1008A	●	●		.625	.625	4.000	.500	.625	.313		

* Clamp Torque (lbf-in) : TS3=8.9

SRGC type inserts > A173
SRDC type inserts > A173
CUTTING CONDITIONS > A093

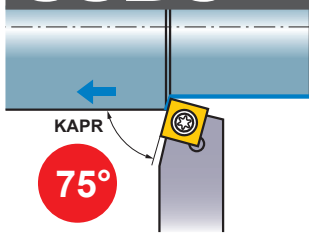
SPARE PARTS > M001
TECHNICAL DATA > N001

C033

EXTERNAL TURNING TOOLS

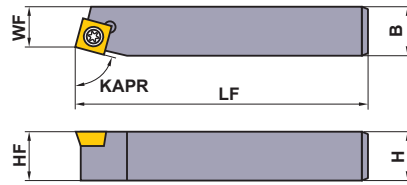
SC INSERTS TOOL HOLDERS

SSBC



External turning

Screw Clamp Type
SP Holder



Right hand tool holder shown.

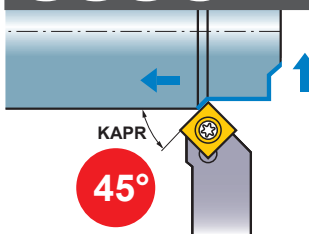
Finish	Light	Medium	Stainless
FP  (3)	LP  (3)	MP  (3)	FM  (3)
Stainless LM  (3,4)	Stainless MM  (3,4)	Medium Standard  (3)	Flat Top  (3)

Order Number	ANSI Number	Stock		Insert Number		Dimensions (inch)					Shim	Shim Screw	Clamp Screw *	Wrench
		R	L			H	B	LF	HF	WF				
SSBCR/L-103	SSBCR/L103A	●	●	SCMT SCMW	32.5	.625	.625	4.000	.625	.500	—	—	TS43	TKY15F
SSBCR/L-124	SSBCR/L124B	●	●		43	.750	.750	4.500	.750	.625	SPSSN42	JSS7	TS53	TKY25R
SSBCR/L-164	SSBCR/L164D	●	●			1.000	1.000	6.000	1.000	.875				

* Clamp Torque (lbf-in) : TS43=31, TS53=66

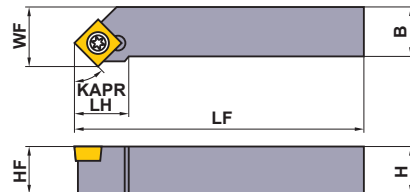
EXTERNAL TURNING TOOLS

SSSC



External turning
Facing, Chamfering

Screw Clamp Type
SP Holder



Right hand tool holder shown.

Finish	Light	Medium	Stainless
FP  (3)	LP  (3)	MP  (3)	FM  (3)
Stainless LM  (3,4)	Stainless MM  (3,4)	Medium Standard  (3)	Flat Top  (3)

Order Number	ANSI Number	Stock		Insert Number		Dimensions (inch)					Shim	Shim Screw	Clamp Screw	Wrench	
		R	L			H	B	LF	LH	HF					WF
SSSCR/L-083	SSSCR/L083X	●	●	SCMT SCMW	32.5	.500	.500	3.500	.625	.500	.550	—	—	TS43	TKY15F
SSSCR/L-103	SSSCR/L103A	●	●		.625	.625	4.000	.625	.625	.680					
SSSCR/L-124	SSSCR/L124B	●	●		43	.750	.750	4.500	1.000	.750	.850	SPSSN42	JSS7	TS53	TKY25R
SSSCR/L-164	SSSCR/L164D	●	●	1.000	1.000	6.000	1.000	1.000	1.110						

* Clamp Torque (lbf-in) : TS43=31, TS53=66

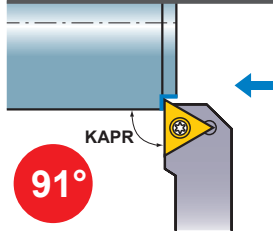
Note 1) Insert photo is an example. Letters show chip breaker style, figures show inscribed circle.

● : USA Stock

SSBC type inserts ➤ A174, A175
SSSC type inserts ➤ A174, A175
CUTTING CONDITIONS ➤ A093

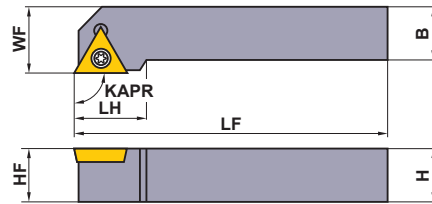
TC INSERTS TOOL HOLDERS

STGC



External turning

Screw Clamp Type
SP Holder



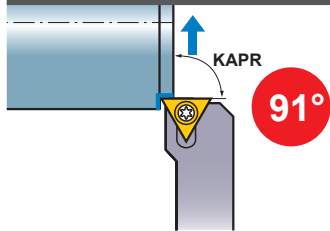
Right hand tool holder shown.

Finish	Light	Medium	Stainless
FP  (2,3)	LP  (2,3)	MP  (2,3)	FM  (2,3)
Stainless	Stainless	Flat Top	PCD/CBN
LM  (2,3)	MM  (2,3)	 (2,3)	 (2,3)

Order Number	ANSI Number	Stock		Insert Number	Dimensions (inch)						Shim	Shim Screw	Clamp Screw	Wrench	
		R	L		H	B	LF	LH	HF	WF					
STGCR/L-062	STGCR/L062X	●	●	TCGT TCMT TCMW TCGW	21.5	.375	.375	2.500	.550	.375	.500	—	—	TS25	TKY08F
STGCR/L-082.5	STGCR/L082.5X	●	●		2.52	.500	.500	3.500	.700	.500	.625			TS3	
STGCR/L-103	STGCR/L103A	●	●			.625	.625	4.000	.800	.625	.750			TS43	
STGCR/L-123	STGCR/L123B	●	●		32.5	.750	.750	4.500	.800	.750	.875	SPSTN32	JSS6	TS406	TKY15R
STGCR/L-163	STGCR/L163D	●	●				1.000	1.000	6.000	.900	1.000				

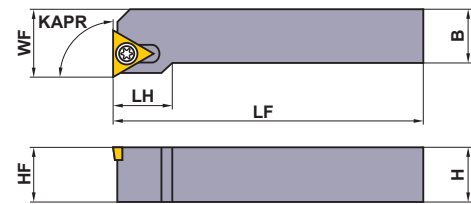
* Clamp Torque (lbf-in) : TS25=8.9, TS3=8.9, TS43=31, TS406=31

STFC



Facing

Screw Clamp Type
SP Holder



Right hand tool holder shown.

Finish	Light	Medium	Stainless
FP  (2,3)	LP  (2,3)	MP  (2,3)	FM  (2,3)
Stainless	Stainless	Flat Top	PCD/CBN
LM  (2,3)	MM  (2,3)	 (2,3)	 (2,3)

Order Number	ANSI Number	Stock		Insert Number	Dimensions (inch)						Shim	Shim Screw	Clamp Screw	Wrench	
		R	L		H	B	LF	LH	HF	WF					
STFCR/L-062	STFCR/L062X	●	●	TCGT TCMT TCMW TCGW	21.5	.375	.375	2.500	.500	.375	.500	—	—	TS25	TKY08F
STFCR/L-082.5	STFCR/L082.5X	●	●		2.52	.500	.500	3.500	.571	.500	.625			TS3	
STFCR/L-102.5	STFCR/L102.5A	●	●			.625	.625	4.000	.571	.625	.750				
STFCR/L-123	STFCR/L123B	●	●		32.5	.750	.750	4.500	.866	.750	.875	SPSTN32	JSS6	TS406	TKY15R
STFCR/L-163	STFCR/L163D	●	●			1.000	1.000	6.000	.866	1.000	1.250				

* Clamp Torque (lbf-in) : TS25=8.9, TS3=8.9, TS406=31

STGC type inserts > A177-A180
STFC type inserts > A177-A180
CBN & PCD inserts > B042, B055

CUTTING CONDITIONS > A093, B008
SPARE PARTS > M001
TECHNICAL DATA > N001

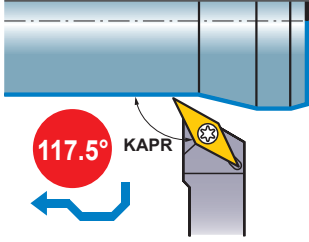
EXTERNAL TURNING TOOLS

C035

EXTERNAL TURNING TOOLS

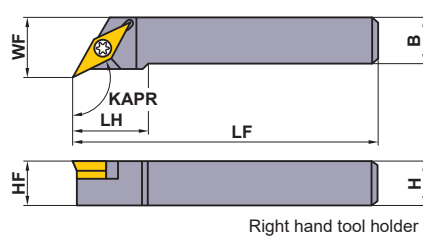
VC INSERTS TOOL HOLDERS

SVPC



External turning
Copying

Screw Clamp Type
SP Holder



Finish	Light	Medium	Stainless
FP	LP	MP	FM
			
(2,3)	(2,3)	(2,3)	(2,3)
Stainless	Stainless	Medium	Flat Top
LM	MM	Standard	
			
(2,3)	(2,3)	(2,3)	(2,3)

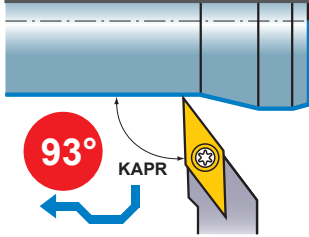
C

EXTERNAL TURNING TOOLS

Order Number	ANSI Number	Stock		Insert Number		Dimensions (inch)						Shim	Shim Pin	Clamp Screw *	Wrench
		R	L			H	B	LF	LH	HF	WF				
SVPCR/L-082	SVPCR/L082X	●	●	VCMT VCGT	22	.500	.500	3.500	1.000	.500	.750	—	—	TS25	TKY08F
SVPCR/L-102	SVPCR/L102A	●	●			.625	.625	4.000	1.000	.625	.875				
SVPCR/L-123	SVPCR/L123B	●	●	VCMW VCGW	33	.750	.750	4.500	1.206	.750	1.000	SPSVN32	BCP141	TS44	TKY15R
SVPCR/L-163	SVPCR/L163D	●	●			1.000	1.000	6.000	1.206	1.000	1.250				

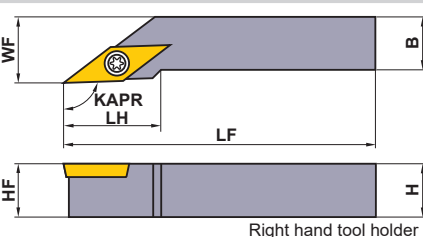
* Clamp Torque (lbf-in) : TS25=8.9, TS44=31

SVJC



External turning
Copying

Screw Clamp Type
SP Holder



Finish	Light	Medium	Stainless
FP	LP	MP	FM
			
(2,3)	(2,3)	(2,3)	(2,3)
Stainless	Stainless	Medium	Flat Top
LM	MM	Standard	
			
(3)	(3)	(2,3)	(2,3)

Order Number	ANSI Number	Stock		Insert Number	Dimensions (inch)						Shim	Shim Pin	Clamp Screw	Wrench	
		R	L		H	B	LF	LH	HF	WF					
SVJCR/L-062	SVJCR/L062X	●	●	VCMT VCGT VCMW VCGW	22	.375	.375	2.500	.750	.375	.500	—	—	TS25	TKY08F
SVJCR/L-083	SVJCR/L083X	●	●		33	.500	.500	3.500	1.000	.500	.625			TS43	TKY15F
SVJCR/L-103	SVJCR/L103A	●	●			.625	.625	4.000	1.000	.625	.750	SPSVN32	BCP141	TS44	TKY15R
SVJCR/L-123	SVJCR/L123B	●	●			.750	.750	4.500	1.000	.750	.875				
SVJCR/L-163	SVJCR/L163D	●	●			1.000	1.000	6.000	1.500	1.000	1.250				

* Clamp Torque (lbf-in) : TS25=8.9, TS43=31, TS44=31

Note 1) Insert photo is an example. Letters show chip breaker style, figures show inscribed circle.

● : USA Stock

C036

SVPC type inserts ➤ A190–A192
SVJC type inserts ➤ A190–A192
CBN & PCD inserts ➤ B046, B058
CUTTING CONDITIONS ➤ A093, B008

WC INSERTS TOOL HOLDERS

SWLC

External turning
Facing

Screw Clamp Type
SP Holder

Finish

Medium

FJ

MJ



(2,3)

(2,3)

Medium

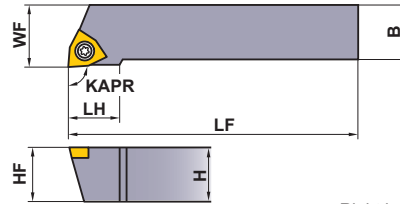
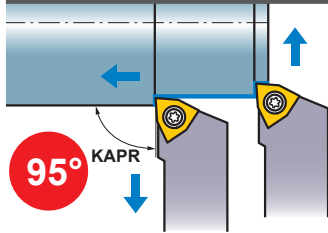
PCD/CBN

Standard



(2,3)

(2,3)



Right hand tool holder shown.

Order Number	ANSI Number	Stock		Insert Number		Dimensions (inch)						Clamp Screw	Wrench
		R	L			H	B	LF	LH	HF	WF		
SWLCR/L-052	SWLCR/L052X	●	●	WCGT WCMT WCGW	21.5°	.313	.313	2.500	.500	.313	.375	TS25	TKY08F
SWLCR/L-062	SWLCR/L062X	●	●			.375	.375	3.500	.500	.375	.500		
SWLCR/L-082	SWLCR/L082X	●	●			.500	.500	3.500	.500	.500	.625		
SWLCR/L-103	SWLCR/L103A	●	●		32.5°	.625	.625	4.000	.625	.625	.750	TS4	TKY15F
SWLCR/L-123	SWLCR/L123B	●	●		.750	.750	4.500	.625	.750	1.000			

* Clamp Torque (lbf-in) : TS25=8.9, TS4=31

EXTERNAL TURNING TOOLS

C

SWLC type inserts > A196, A197
CUTTING CONDITIONS > A093, B008

SPARE PARTS > M001
TECHNICAL DATA > N001

C037

EXTERNAL TURNING TOOLS

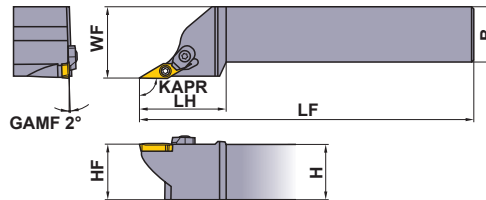
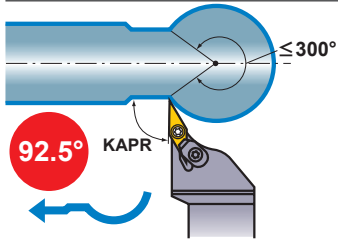
XC INSERTS TOOL HOLDERS

SXZC

External turning
Copying

DOUBLE CLAMP Type

Finish
SVX



Right hand tool holder shown.



(2)

Order Number	ANSI Number	Stock		Insert Number	Dimensions (inch)						* Clamp Screw	* Clamp Bridge	* Clamp Bridge Screw	* Spring	Wrench (Insert)	Wrench (Clamp Bridge)
		R	L		H	B	LF	LH	HF	WF						
SXZCR/L-102	SXZCR/L102A	●	●	XCMT 22 SVX	.625	.625	4.000	1.378	.625	.750						
SXZCR/L-122	SXZCR/L122B	●	●		.750	.750	4.500	1.378	.750	1.000	TS255	AMS3	AJS3010T10	ASS2	TKY08F	TKY10F
SXZCR/L-162	SXZCR/L162D	●	●		1.000	1.000	6.000	1.575	1.000	1.250						

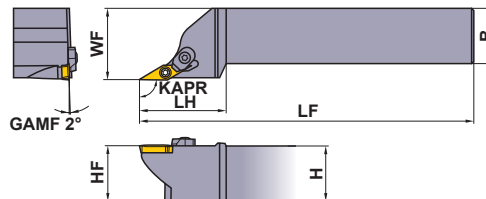
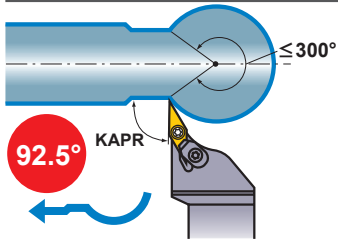
* Clamp Torque (lbf-in) : TS255=8.9, AJS3010T10=22

SXZC

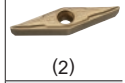
External turning
Copying

DOUBLE CLAMP Type

Finish
SVX



Right hand tool holder shown.

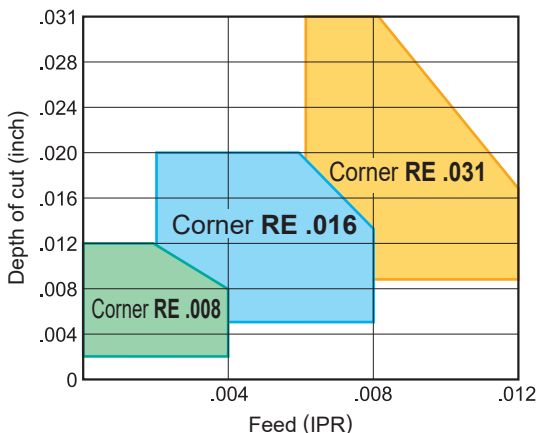


(2)

Order Number	ANSI Number	Stock		Insert Number	Dimensions (mm)						* Clamp Screw	* Clamp Bridge	* Clamp Bridge Screw	* Spring	Wrench (Insert)	Wrench (Clamp Bridge)
		R	L		H	B	LF	LH	HF	WF						
SXZCR/L1616H15	—	●	●	XCMT 22 SVX	16	16	100	35	16	20						
SXZCR/L2020K15	—	●	●		20	20	125	35	20	25	TS255	AMS3	AJS3010T10	ASS2	TKY08F	TKY10F
SXZCR/L2525M15	—	●	●		25	25	150	40	25	32						

* Clamp Torque (lbf-in) : TS255=8.9, AJS3010T10=22

APPLICATION RANGE



Note 1) Insert photo is an example. Letters show chip breaker style, figures show inscribed circle.

● : USA Stock

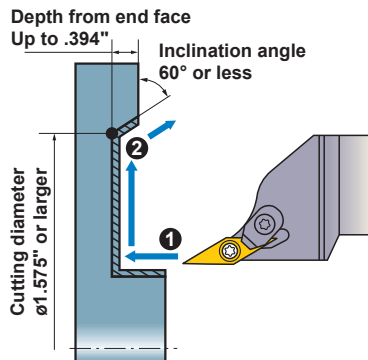
RECOMMENDED CUTTING CONDITIONS

	Work Material	Hardness	Grade	Cutting Speed (SFM)
P	Mild Steel	≤180HB	MC6125	1115 (785—1310)
	Carbon Steel, Alloy Steel	150HB—250HB	MC6125	720 (525—920)
M	Stainless Steel	≤200HB	VP15TF	330 (230—395)

Note 1) The above cutting conditions are general guidelines. Adjustments maybe necessary depending on machine rigidity, work material geometry and clamping.

OPERATIONAL GUIDANCE

Notes when end face profiling



Pay special attention to the following when face profiling.

Machining of an outer diameter (Step ①)

- To prevent burr formation, the depth of cut should be less than half the corner radius.

Machining of an inclination (Step ②)

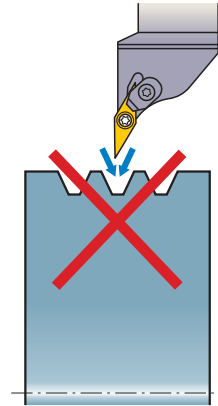
- To reduce the contact length of chips, the depth of cut should be less than half the corner radius.
- To prevent interference between the tool and the work material, the cutting diameter should be 1.575" or larger, inclination angle 60° or less and depth from the end face up to .394".

When changing inserts

- When indexing the inserts, it is recommended to preset the cutting edge position to maintain machining accuracy.

Not possible

Machining of V-pulleys

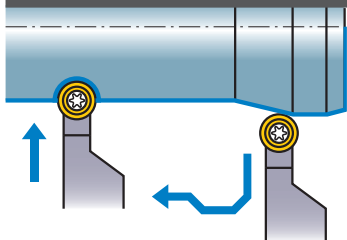


When machining V-pulleys, use a VNMG insert

EXTERNAL TURNING TOOLS

RP INSERTS TOOL HOLDERS

SRDP

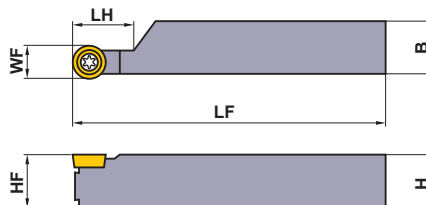


External turning
Copying

Screw Clamp Type
SP Holder

Medium

JS



Right hand tool holder shown.

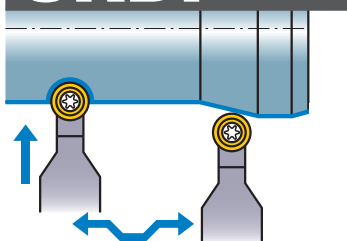
C

EXTERNAL TURNING TOOLS

Order Number	ANSI Number	Stock		Insert Number	Dimensions (inch)						Clamp Screw *	Wrench
		R	L		H	B	LF	LH	HF	WF		
SRDPR/L-1612	SRDPR/L1612D	●	●	RPMT120400E-JS	1.000	1.000	6.000	1.000	1.000	.500	TS43	TKY15F

* Clamp Torque (lbf-in) : TS43=31

SRDP

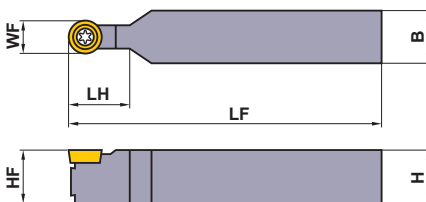


External turning
Copying

Screw Clamp Type
SP Holder

Medium

JS



Order Number	ANSI Number	Stock		Insert Number	Dimensions (inch)						Clamp Screw *	Wrench
		R	L		H	B	LF	LH	HF	WF		
SRDPN-1612	SRDPN1612D	●		RPMT120400E-JS	1.000	1.000	6.000	1.000	1.000	.500	TS43	TKY15F

* Clamp Torque (lbf-in) : TS43=31

Note 1) Insert photo is an example. Letters show chip breaker style, figures show inscribed circle.

● : USA Stock

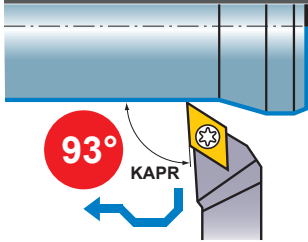
SRDPR/L type inserts > K034

SRDPN type inserts > K034

CUTTING CONDITIONS > A102

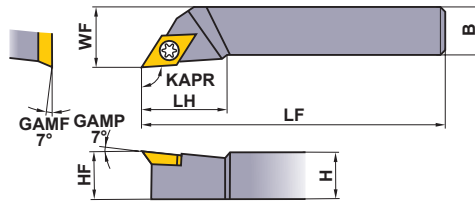
DE INSERTS TOOL HOLDERS

SDJE

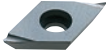


External turning
Copying

Screw Clamp Type for Aluminum
AL Holder



Right hand tool holder shown.

Finish	Medium
R/L-F  (4)	R/L  (4)
PCD  (4)	

Order Number	ANSI Number	Stock		Insert Number	Dimensions (inch)						Clamp Screw	Wrench
		R	L		H	B	LF	LH	HF	WF		
SDJER/L-104	SDJER/L104A	●	●	DEGX 43 R/L	.625	.625	4.000	1.000	.625	.750	CS451190T	TKY20F
SDJER/L-124	SDJER/L124B	●	●		.750	.750	4.500	1.000	.750	.875		
SDJER/L-164	SDJER/L164D	●	●		1.000	1.000	6.000	1.100	1.000	1.250		

* Clamp Torque (lbf-in) : CS451190T=44

EXTERNAL TURNING TOOLS

RECOMMENDED CUTTING CONDITIONS

Work Material	Grade	Cutting Speed (SFM)	Feed (IPR)	Depth of Cut (inch)
N Aluminum Alloy	HTi10	1310	.002—.012	.008—.118
	MD220	2620	.002—.012	.008—.020

SDJE type inserts > A172
PCD inserts > B060

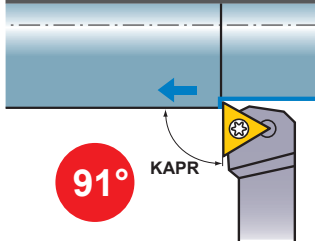
SPARE PARTS > M001
TECHNICAL DATA > N001

C041

EXTERNAL TURNING TOOLS

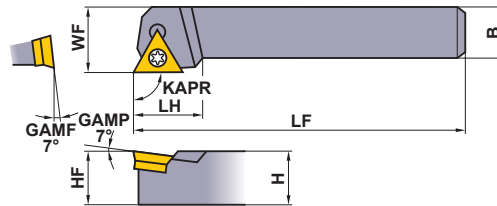
TE INSERTS TOOL HOLDERS

STGE



External turning

Screw Clamp Type for Aluminum AL Holder



Right hand tool holder shown.

Medium

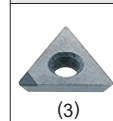
PCD

R/L

R/L



PCD



C

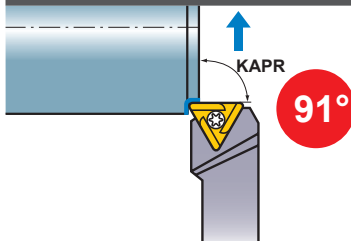
EXTERNAL TURNING TOOLS

Order Number	ANSI Number	Stock		Insert Number	Dimensions (inch)						Clamp Screw *	Wrench
		R	L		H	B	LF	LH	HF	WF		
STGER/L-103	STGER/L103A	●	●	TEGX 32	.625	.625	4.000	.800	.625	.750	FC400890T	TKY10F
STGER/L-123	STGER/L123B	●	●		.750	.750	4.500	.800	.750	.875		
STGER/L-163	STGER/L163D	●	●		1.000	1.000	6.000	.900	1.000	1.250		

Note 1) Right hand tool holder uses right hand insert. Left hand tool holder uses left hand insert.

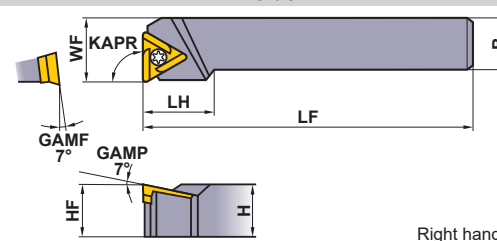
* Clamp Torque (lbf-in) : FC400890T=22

STFE



Facing

Screw Clamp Type for Aluminum AL Holder



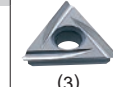
Right hand tool holder shown.

Medium

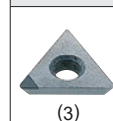
PCD

R/L

R/L



PCD



Order Number	ANSI Number	Stock		Insert Number	Dimensions (inch)						Clamp Screw *	Wrench
		R	L		H	B	LF	LH	HF	WF		
STFER/L-103	STFER/L103A	●	●	TEGX 32	.625	.625	4.000	.866	.625	.750	FC400890T	TKY10F
STFER/L-123	STFER/L123B	●	●		.750	.750	4.500	.866	.750	1.000		
STFER/L-163	STFER/L163D	●	●		1.000	1.000	6.000	.866	1.000	1.250		

Note 1) Right hand tool holder uses left hand insert. Left hand tool holder uses right hand insert.

* Clamp Torque (lbf-in) : FC400890T=22

Note 1) Insert photo is an example. Letters show chip breaker style, figures show inscribed circle.

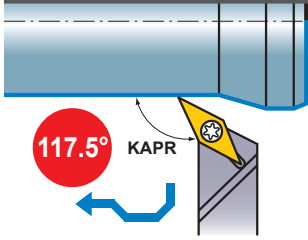
● : USA Stock

C042

STGE type inserts ➤ A181
STFE type inserts ➤ A181
PCD inserts ➤ B060

VD INSERTS TOOL HOLDERS

SVPD



External turning
Copying

Screw Clamp Type for Aluminum
AL Holder

Finish

R/L



(3)

PCD

R/L-F



(3)

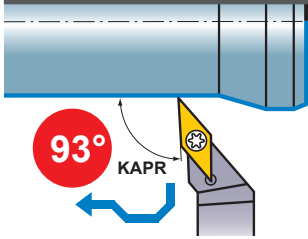
Right hand tool holder shown.

Order Number	ANSI Number	Stock		Insert Number	Dimensions (inch)					Clamp Screw*	Wrench
		R	L		H	B	LF	HF	WF		
SVPDR/L-123	SVPDR/L123B	●	●	VDGX 32°R/L	.750	.750	4.500	.750	1.000	FC400890T	TKY10F
SVPDR/L-163	SVPDR/L163D	●	●		1.000	1.000	6.000	1.000	1.250		

Note 1) Right hand tool holder uses right hand insert. Left hand tool holder uses left hand insert.

* Clamp Torque (lbf-in) : FC400890T=22

SVJD



External turning
Copying

Screw Clamp Type for Aluminum
AL Holder

Finish

R/L



(3)

PCD

R/L-F



(3)

Right hand tool holder shown.

Order Number	ANSI Number	Stock		Insert Number	Dimensions (inch)						Clamp Screw*	Wrench
		R	L		H	B	LF	LH	HF	WF		
SVJDR/L-103	SVJDR/L103A	●	●	VDGX 32°R/L	.625	.625	4.000	1.100	.625	.750	FC400890T	TKY10F
SVJDR/L-123	SVJDR/L123B	●	●		.750	.750	4.500	1.100	.750	.875		
SVJDR/L-163	SVJDR/L163D	●	●		1.000	1.000	6.000	1.200	1.000	1.250		

Note 1) Right hand tool holder uses right hand insert. Left hand tool holder uses left hand insert.

* Clamp Torque (lbf-in) : FC400890T=22

RECOMMENDED CUTTING CONDITIONS

Work Material	Grade	Cutting Speed (SFM)	Feed (IPR)	Depth of Cut (inch)
N	HTi10	1310	.002—.012	.008—.118
	MD220	2620	.002—.012	.008—.020

SVPD type inserts > A193

SVJD type inserts > A193

PCD inserts > B061

SPARE PARTS > M001

TECHNICAL DATA > N001

C043