

TC INSERTS TOOL HOLDERS

| STGC | | External turning | | | | | | | | SP type | | Finish | Medium | |
|-----------------------|-------|-------------------------------|---------------|-----------------|----|----|-----|------|----|----------------|----------------|----------------|-------------|---------|
| | | | | | | | | | | (11,16) | (11,13,16) | | | |
| | | | | | | | | | | Flat Top | CBN/PCD | (11,13,16) | (11,13) | |
| | | Right hand tool holder shown. | | | | | | | | | | | | |
| Order Number | Stock | | Insert Number | Dimensions (mm) | | | | | | Shim | Shim Pin | Clamp Screw | Wrench | |
| | R | L | | H1 | B | L1 | L2 | H2 | F1 | | | | | |
| STGCR/L1010E11 | ● | ● | TCMW TCMT | 1102 | 10 | 10 | 70 | 13.5 | 10 | 12 | — | — | TS25 | ①TKY08F |
| 1212F13 | ● | ● | | 1303 | 12 | 12 | 80 | 17.6 | 12 | 16 | — | — | TS3 | ①TKY08F |
| 1616H16 | ● | ● | | 16T3 | 16 | 16 | 100 | 20.7 | 16 | 20 | — | — | TS43 | ①TKY15F |
| 2020K16 | ● | ● | | 16T3 | 20 | 20 | 125 | 21.0 | 20 | 25 | SPSTN32 | JSS6 | TS406 | ②TKY15R |
| 2525M16 | ● | ● | | 16T3 | 25 | 25 | 150 | 21.0 | 25 | 32 | SPSTN32 | JSS6 | TS406 | ②TKY15R |

| STFC | | Facing | | | | | | | | SP type | | Finish | Medium | |
|-----------------------|-------|-------------------------------|---------------|-----------------|----|----|-----|------|----|----------------|-------------|-------------|-------------|---------|
| | | | | | | | | | | (11,16) | (11,13) | | | |
| | | | | | | | | | | Flat Top | CBN/PCD | (11,13) | (11,13) | |
| | | Right hand tool holder shown. | | | | | | | | | | | | |
| Order Number | Stock | | Insert Number | Dimensions (mm) | | | | | | Shim | Shim Pin | Clamp Screw | Wrench | |
| | R | L | | H1 | B | L1 | L2 | H2 | F1 | | | | | |
| STFCR/L1010E11 | ● | ● | TCMW TCMT | 1102 | 10 | 10 | 70 | 12.5 | 10 | 12 | — | — | TS25 | ①TKY08F |
| 1212F13 | ● | ● | | 1303 | 12 | 12 | 80 | 14.5 | 12 | 16 | — | — | TS3 | ①TKY08F |
| 1616H13 | ● | ● | | 1303 | 16 | 16 | 100 | 14.5 | 16 | 20 | — | — | TS3 | ①TKY08F |
| 2020K16 | ● | ● | | 16T3 | 20 | 20 | 125 | 22.0 | 20 | 25 | SPSTN32 | JSS6 | TS406 | ②TKY15R |
| 2525M16 | ● | ● | | 16T3 | 25 | 25 | 150 | 22.0 | 25 | 32 | SPSTN32 | JSS6 | TS406 | ②TKY15R |

(Note) When using inserts with right or left hand chip breakers, please use left hand inserts for right hand holders and right hand inserts for left hand holders.

RECOMMENDED CUTTING CONDITIONS

| | Work Material | Hardness | Cutting Mode | Breaker | Grade | Cutting Speed (m/min) |
|----------|---------------------------|--|----------------|-----------------|---------------|-----------------------|
| P | Mild Steel | ≤180HB | Finish Cutting | FV | VP45N | 165–240 |
| | | | Medium Cutting | Standard | UE6110 | 205–350 |
| | Carbon Steel, Alloy Steel | 180HB–280HB | Finish Cutting | FV | AP25N | 175–275 |
| | | | Medium Cutting | Standard | UE6110 | 150–260 |
| M | Stainless Steel | ≤200HB | Light Cutting | Standard | US735 | 70–130 |
| K | Cast Iron | Tensile Strength ≤350N/mm ² | Medium Cutting | Flat Top | UC5115 | 130–235 |

CBN & PCD inserts
A139, A151

STGC type inserts
A090

STFC type inserts
A090

SPARE PARTS
F001

TECHNICAL DATA
G001

EXTERNAL TURNING

TC INSERTS TOOL HOLDERS