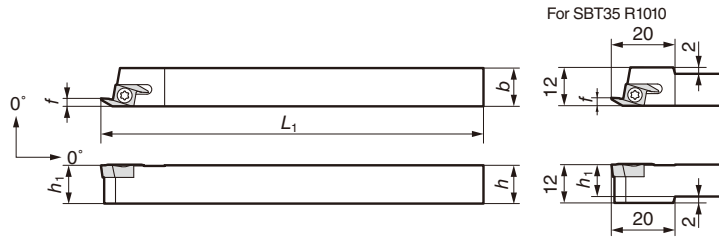
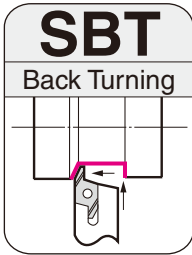


# SBT / PBT Type

## Back Turning



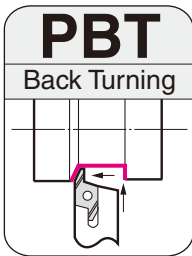
### Parts

Screw	(For Torx Holes) Wrench
BFTX0307N	TRX10
Recommended Tightening Torque (N·m)	2.0

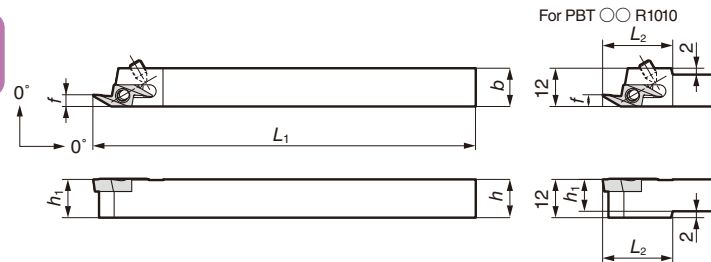
### Holder

Above figures show right hand tools.

Cat. No.	Stock	Dimensions (mm)						Applicable Insert
		h	b	L <sub>1</sub>	f	h <sub>1</sub>		
SBT35 R1010	●	10	10	120	2.5	10	BTR35 ○○	
SBT35 R1212	●	12	12	120	9.5	12		
SBT35 R1616	●	16	16	120	13.5	16		
SBT35 R2020	●	20	20	125	17.5	20		



Side lever locking holders



### Parts

Lever Pin	Clamp Bolt	Pin	(For Hexagonal Holes) Wrench
LCL09	BTT0407 BTT0411	LP07	TH020

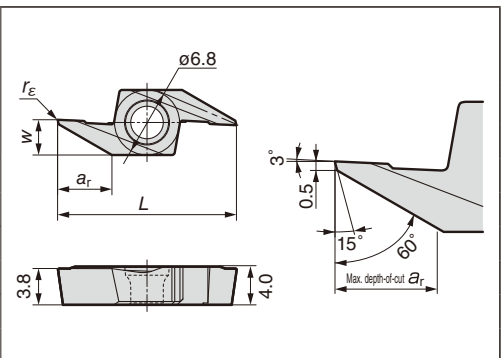
### Holder

Above figures show right hand tools.

Cat. No.	Stock	Dimensions (mm)								Applicable Insert	Lever Pin	Clamp Bolt	Pin	Wrench
		h	b	L <sub>1</sub>	f	h <sub>1</sub>	L <sub>2</sub>							
PBT35 R1010	●	10	10	120	2.5	10	20	BTR35 ○○	LCL09	BTT0407 BTT0411	LP07	TH020		
PBT35 R1212	●	12	12	120	2.5	12	—							
PBT35 R1616	●	16	16	120	2.5	16	—							
PBT35 R2020	●	20	20	120	2.5	20	—							
PBT55 R1010	●	10	10	120	3.7	10	22	BTR55 ○○	LCL09	BTT0407 BTT0411	LP07	TH020		
PBT55 R1212	●	12	12	120	3.7	12	—							
PBT55 R1616	●	16	16	120	3.7	16	—							
PBT55 R2020	●	20	20	120	3.7	20	—							
PBT80 R1010	●	10	10	120	5.2	10	25	BTR80 ○○	LCL09	BTT0407 BTT0411	LP07	TH020		
PBT80 R1212	●	12	12	120	5.2	12	—							
PBT80 R1616	●	16	16	120	5.2	16	—							
PBT80 R2020	●	20	20	120	5.2	20	—							

### Insert ( Coated Carbide/ Cermet)

Cat. No.	Stock				Dimensions (mm)				Applicable Holder
	Coated Carbide		Cermet		L	a <sub>r</sub>	w	r <sub>ε</sub>	
	AC530U	ACZ150	T11500A	T1200A					
BT R3505	●	●	●	▲	15	3.5	2.5	0.05	SBT35R ○○○○
BT R3515	●	●	●	▲	15	3.5	2.5	0.15	PBT35R ○○○○
BT R5505	●	●	—	—	19	5.5	3.7	0.05	PBT55R ○○○○
BT R5515	●	●	—	—	19	5.5	3.7	0.15	PBT55R ○○○○
BT R8005	●	●	—	—	24	8.0	5.2	0.05	PBT80R ○○○○
BT R8015	●	●	—	—	24	8.0	5.2	0.15	PBT80R ○○○○



### Recommended Cutting Conditions

Work material	P Carbon Steel		P Free-cutting Steel		M Stainless Steel	
	Plunging	Traverse	Plunging	Traverse	Plunging	Traverse
Cutting Speed v <sub>c</sub> (m/min)	50 to 150		50 to 150		50 to 150	
Feed Rate f (mm/rev)	0.02 to 0.05	0.02 to 0.10	0.02 to 0.10	0.02 to 0.15	0.02 to 0.04	0.02 to 0.06
Coolant	Oil based					

### Shank Tolerance of SBT Type/PBT Type

The shank height (h) has a plus tolerance (0.1-0.3) in order to avoid interference with the tool post.

