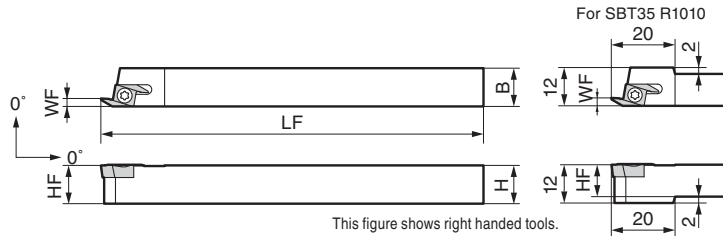
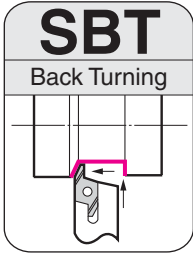




Expanded

SEC-Mini Tools SBT Type / PBT Type

Back Turning

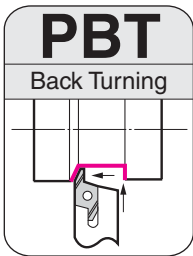


Parts

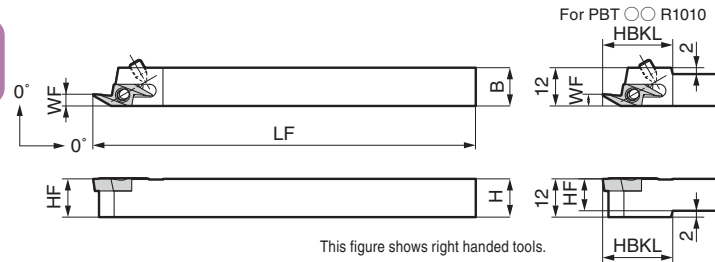
Screw	(For Torx holes)
Applicable inserts	Wrench
BTR35 ○○	TRX10
BFTX0307N	2.0

Holders

Cat. No.	Stock	Dimensions (mm)						Applicable inserts
		Height H	Width B	Length LF	Cutting edge distance WF	Cutting edge height HF	Head	
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

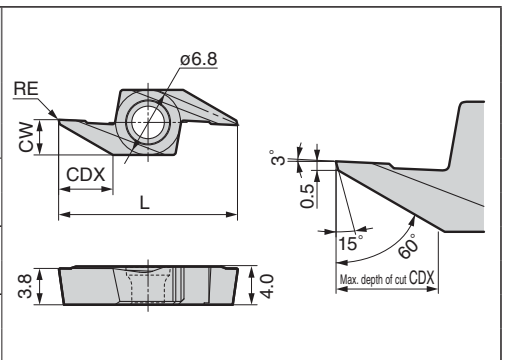
Lever pin	Tightening bolt	Locking pin	Wrench
Applicable inserts	LCL09	BTT0407 BTT0411	LP07 TH020
BTR35 ○○	LCL09	BTT0407 BTT0411	LP07 TH020
BTR55 ○○	LCL09	BTT0407 BTT0411	LP07 TH020
BTR80 ○○	LCL09	BTT0407 BTT0411	LP07 TH020

Holders

Cat. No.	Stock	Dimensions (mm)							Applicable inserts
		Height H	Width B	Length LF	Cutting edge distance WF	Cutting edge height HF	Head HBKL		
PBT35 R1010	●	10	10	120	2.5	10	20	BTR35 ○○	
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 ○○	
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 ○○	
PBT80 R1212	●	12	12	120	5.2	12	—		
PBT80 R1616	●	16	16	120	5.2	16	—		
PBT80 R2020	●	20	20	120	5.2	20	—		

Inserts (Coated carbide / Cermet)

Cat. No.	Stock				Dimensions (mm)				Applicable tools
	Coated carbide		Cermet		Length L	Depth of cut CDX	Edge width CW	Nose radius RE	
	AC1080U	AC530U	ACZ150	T1500A					
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 cutting	Plunging	Traverse cutting	Plunging	Traverse cutting
Cutting speed v_c (m/min)	50-150		50-150		50-150	
Feed rate f (mm/rev)	0.02-0.05	0.02-0.10	0.02-0.10	0.02-0.15	0.02-0.04	0.02-0.06
Coolant	Oil-base					

Shank Tolerance of SBT Model / PBT Type

To prevent interference of the cutting edge and tool post, the tolerance of the shank height (h) is positive (0.1 - 0.3).

