

Small Lathe Tools



External Holders **D1 to D29**



For Small Lathes

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Small Lathe Tools Selection D2
 General Features of Small Lathes D4
 Insert Grade Selection D6
 Chipbreaker Selection D7

External Holders	Special Tool Holders for Small Product Machining	SEC-PB Tool Holders SPB Type D8
		SEC-Wide-Cut Holders SGW Type D10
		SEC-MINI Tool Holders SBT Type/PBT Type D11
		SEC-Front Turning Tool Holders SFT Type D12
	SEC-Round Shank Tool Holders	RS-SCL Type D13
		RS-SDU Type/RS-SDX Type D14
		RS-SVX Type/RS-SVVP Type D15
		RS-PTXN Type D16
	SEC-MINI Tool Holders Zero Offset Holders	PCLC-X Type/SCLC-X Type/SCAC-X Type D17
		PDJC-X Type/SDJC-X Type D18
		SDAC-X Type/SDPC-X Type D19
		SVJC-X Type/PTXN-X Type D20
	SEC-MINI Tool Holders PC Type/SC Type	PCLC Type/SCLC Type D22
	SCAC Type D23	
SEC-MINI Tool Holders PD Type/SD Type	PDJC Type/SDJC Type D24	
	SDAC Type/SDNC Type D25	
SEC-MINI Tool Holders SS Type	SSBC Type D26	
SEC-MINI Tool Holders ST Type	STGC Type/STAC Type D27	
SEC-MINI Tool Holders SV Type (7° Positive)	SVLC Type/SVPC Type D28	
SEC-MINI Tool Holders SV Type (11° Positive)	SVLP Type/SVPP Type D29	

E Boring Bars

Multi-functional Small Lathe Tools E16
 SEC-Boring Bars (for Bottom Facing) E18
 SEC-Boring Bars (for Profiling) E28
 SEC-Boring Bars (for Through Boring) E48
 SEC-Boring Bars (for Stop Boring) E56
 SEC-MINI Boring Tool Holders E64

F Grooving / Cut-off Tools

SEC-Grooving Tools (External) F4
 SEC-Grooving Tools (Internal) F54
 SEC-Small Diameter Cut-Off Tool Holders F72
 SEC-Threading Tools (External) F94, F102
 SEC-Threading Tools (Internal) F94, F107

Stock Markings and Symbols	● mark: Standard stocked item	* mark: Semi-standard stock (please confirm stock availability)
	● mark: To be replaced with the new item featured on the same page	○ mark: Stock or planned stock (please confirm stock availability)
	▲ mark: To be replaced by a new product, made to order, or discontinued (please confirm stock availability).	Blank: Made-to-order item
		— mark: Not available

Small Lathe Tools Selection

For Small Lathes

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External Turning (1)

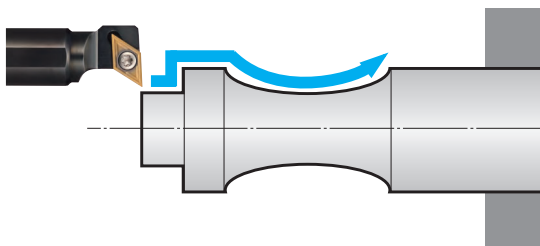
Application/Type/Page	Cutting Edge Shape
Cut-off SCT Type F72	
Back Turning SBT Type PBT Type D11	
Profiling SV Type D28 on	
General External Turning PD/SD Type D24, D25	
Grooving GWC Type F4	
Grooving & Cut-off GND Type <i>Expansion</i> F10 on	

External Turning (2)

Application/Type/Page	Cutting Edge Shape
Turning SFT Type D12	
Turning PTXN-X Type D20	
Grooving Traverse Cut SGE Type F52	
Threading STH Type F102	
Threading SSTE Type F94 on	
Threading THE Type F106	

External Turning (3)

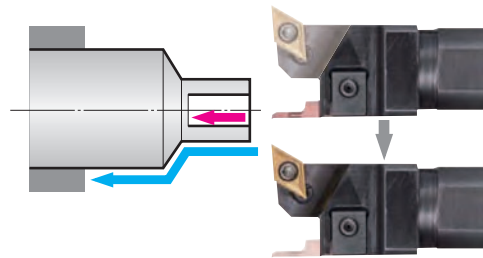
External turning made possible with holder sleeves.



Application/Type/Page	Round Shank Holder RS Type D13 to D16
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Multi-functional Tool

A single holder capable of performing two operations.



Application/Type/Page	Twin Head Holder I.D. + O.D. CKBE Type E16	I.D. + I.D. CKBB Type E17
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Small Lathe Tools Selection

For Internal Boring (1) Machining of very small diameters 1mm and above

Application/Type/Page	Very Small Dia. Boring	Very Small Dia. Boring (Round Shank)	Gang-Type Toolpost Very Small Dia. Boring	Solid Carbide Bar
	CKB Type	S-CKB Type / S-CKB-S Type	CKBS Type	BXBR Type
	E64	E66	E65	E69
Cutting Edge Shape	<p>General</p> <p>KBMX Type</p>	<p>Back Turning</p> <p>KBMZ Type</p>	<p>Grooving</p> <p>KBMG Type</p>	<p>Face Grooving</p> <p>KBMFR Type</p>

For Internal Boring (2) Machining of small diameters 5mm and above

Application/Type/Page	Boring
	SW Type / ST Type / SC Type / SD Type / SV Type / SS Type
	E18 to E63
Cutting Edge Shape	<p>Stop Boring</p> <p>E56 on</p> <p>Bottom Facing</p> <p>E18 on</p> <p>Profiling</p> <p>E28 on</p> <p>Concave Facing and Bottom Facing</p> <p>E37</p> <p>Through Boring</p> <p>E48 on</p>

Unit (mm)

For Grooving and Threading

Application/Type/Page	Internal Grooving	Internal Grooving	Internal Grooving	Internal Threading	Internal Threading
	SGIT Type	SSH Type <i>Expansion</i>	GNDIS Type	STHI Type	SSTI Type
	F55	F56 on	F44 on	F108	F94 on
Cutting Edge Shape	<p>0.5 to 2.0mm</p>	<p>0.74 to 4.0mm</p>	<p>1.5 to 3.0mm</p>	<p>Pitch 0.4 to 1.0mm</p>	<p>Pitch 0.5 to 3.0mm</p>

SUMIBORON (CBN) Small Hole Boring Bars

CBN

Application/Type/Page	Small Hole Boring Bars	Small Hole Boring Bars	Small Hole Boring Bars
	BSME Type	SEXC Type	BNBX Type
	E70	E71	E74
Cutting Edge Shape	<p>BSME Type</p>	<p>SEXC Type</p>	<p>BNBX Type</p>

SUMIDIA (PCD) Small Hole Boring Bars

PCD

Application/Type/Page	Small Hole Boring Bars	Small Hole Boring Bars
	DABB-C Type	DABB-N Type
	E77	E77
Cutting Edge Shape	<p>DABB-C Type</p>	<p>DABB-N Type</p>

For Small Lathes

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SumiSmall

For Small Lathes
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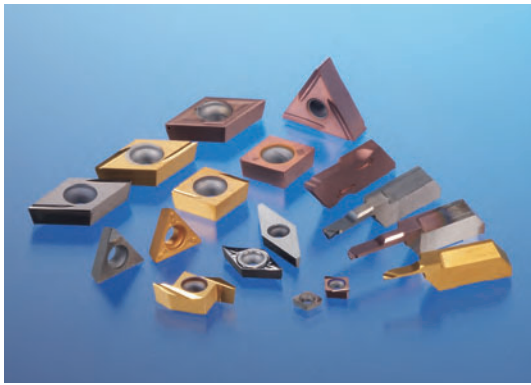


General Features

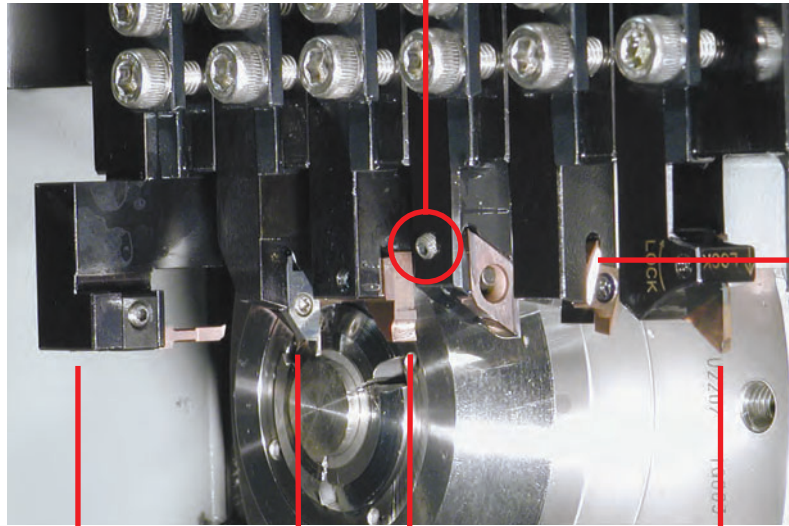
In 1984, Sumitomo Electric Hardmetal first released the SEC-MINI Tool Holder series for small product machining in small NC autolathes. Through these years of experience, new tool designs including our side lever lock tool holder were developed to meet various machining requirements such as back turning, profiling and cut-off; we continually strive to enhance the series.



Full Lineup of Grades from Carbide to PCD



D6 on



Special tools for small lathes to cover various types of machining

● **Very Small Dia. Boring Bar CKB Type**
Min. bore diameter $\phi 1$ to $\phi 5$ mm



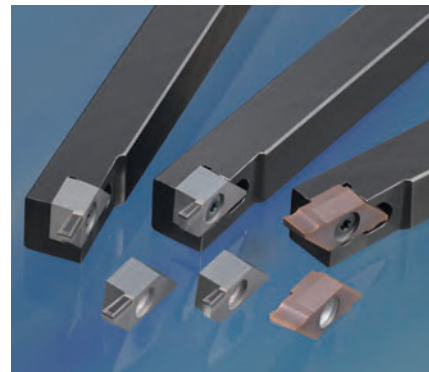
E64 on

● **Very Small Diameter Part Turning Tool SPB Type**
Best suited for very small parts with diameter of less than $\phi 10$ mm



D8 on

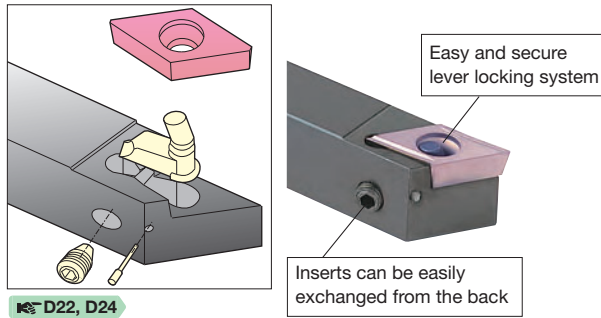
● **Wide-Cut Holders SGW Type**
Ideal for high-efficiency machining of long parts, eliminating chip control issues



D10

■ A wide selection of easy-to-use holders

● PC/PD Type Back Clamp Tool Holders



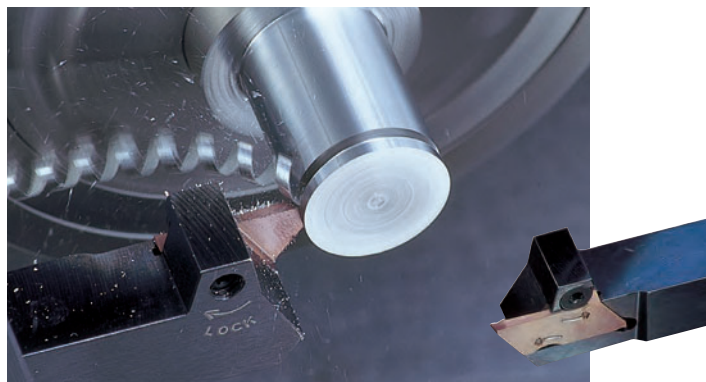
● Back-Turning Tool Holder SBT Type/PBT Type

Sharp cutting edge produces good surface finish
Maximum machining step 8.0 mm, width of cut 2.5 mm



● Cut-off Tool SCT Type

Inserts can be changed easily even from the back, simply by loosening the screw
Maximum cut-off diameters: ø5mm, ø12mm, ø16mm



● Zero Offset Holders *Products with part number suffix "-X"

Tool compensation not required for small gang-type lathes ☞ D17 on



● Twin Head Holder

Multi-functional Autolathe Tool
One holder performing 2 different operations ☞ E16 on



● Round Shank Holder RS Type

External turning made possible with holder sleeves ☞ D13 on



● SEC-Grooving Tool SSH Type *Expansion*

Internal coolant supply enables superb chip evacuation, while the tough carbide body allows stable machining
Supports internal grooving of ø8mm up ☞ F56 on



● SEC-Grooving Tool Holder GND Type *Expansion*

Lineup includes shanks for small lathes
Suitable for grooving at 1.25mm up
Internal coolant supply type now available as a series ☞ F10 on

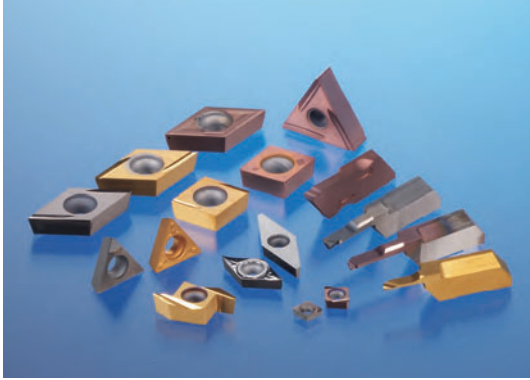


For Small Lathes D

Insert Grade Selection

For Small Lathes

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In 1984, Sumitomo Electric Hardmetal first released the SEC-MINI Tool Holder series for small product machining in small NC autolathes. A full range of insert grades including AC530U and AC1030U as well as Cermet T1500A, Cemented Carbide BL130, SUMIBORON BN2000, and SUMIDIA DA1000 are available to meet a variety of machining requirements. In addition to the high-precision grade ACZ150, AC1030U has been added to support an even wider range of precision application requirements, from automotive to electrical component machining.

Insert Grade Selection

Insert Grade	Application Range			Applicable Work Material					
	High-precision	Finishing to Light Cutting	Medium Cutting	P General Steel	M Stainless Steel	K Cast Iron	S Heat-Resistant Alloy	H Hardened Steel	N Non-ferrous Metal
Coated Carbide (PVD)	ACZ150			◎	◎				○
	AC5015S			○	◎	○	◎		○
	AC5025S			○	◎	○	◎		○
	AC530U			◎	◎	○	○		○
	AC1030U			◎	◎	○	○		○
Uncoated Cermet Coated Cermet	T1000A			◎	○	◎			○
	T1500A/T1500Z			◎	○	○			○
Cemented Carbide	BL130			○	○	○			○
	H1			○	○	○			◎
	EH510			○	○	○	◎		○
CBN (SUMIBORON)	BN1000/BN2000					◎	○	◎	
	BN7000								
PCD (SUMIDIA)	DA1000								◎

◎ 1st Recommendation ○ 2nd Recommendation

Recommended Cutting Conditions


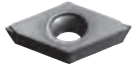
(Red text: 1st recommendation, Blue text: 2nd recommendation)

Work Material	P Free-Cutting Steel		P Carbon Steel		M Stainless Steel		S Heat-Resistant Alloy		H Hardened Steel		N Aluminum Alloy		N Brass	
	v_c (m/min)	f (mm/rev)	v_c (m/min)	f (mm/rev)	v_c (m/min)	f (mm/rev)	v_c (m/min)	f (mm/rev)	v_c (m/min)	f (mm/rev)	v_c (m/min)	f (mm/rev)	v_c (m/min)	f (mm/rev)
ACZ150	50 to 200	0.02 to 0.10	50 to 150	0.01 to 0.08	50 to 150	0.01 to 0.05					70 to 300	0.05 to 0.20	70 to 300	0.05 to 0.20
AC5015S	50 to 200	0.02 to 0.15	50 to 200	0.02 to 0.10	50 to 200	0.02 to 0.10	30 to 100	0.02 to 0.10					70 to 300	0.05 to 0.20
AC5025S	50 to 200	0.02 to 0.15	50 to 200	0.02 to 0.10	50 to 200	0.02 to 0.10	30 to 100	0.02 to 0.10					70 to 300	0.05 to 0.20
AC530U	50 to 200	0.02 to 0.15	50 to 200	0.02 to 0.10	50 to 200	0.02 to 0.10							70 to 300	0.05 to 0.20
AC1030U	50 to 200	0.02 to 0.15	50 to 150	0.02 to 0.10	50 to 150	0.02 to 0.10							70 to 300	0.05 to 0.20
T1000A	50 to 200	0.02 to 0.15	50 to 200	0.02 to 0.10	50 to 150	0.02 to 0.10					70 to 300	0.05 to 0.20	70 to 300	0.05 to 0.20
T1500A	50 to 200	0.02 to 0.15	50 to 200	0.02 to 0.10	50 to 150	0.02 to 0.10					70 to 300	0.05 to 0.20	70 to 300	0.05 to 0.20
T1500Z	50 to 200	0.02 to 0.15	50 to 200	0.02 to 0.10	50 to 150	0.02 to 0.10					70 to 300	0.05 to 0.20	70 to 300	0.05 to 0.20
BN1000									120 to 300	0.03 to 0.15				
BN2000									50 to 200	0.03 to 0.20				
BN7000							50 to 200	0.05 to 0.20						
DA1000											70 to 300	0.02 to 0.10	70 to 300	0.02 to 0.10

Chipbreaker Selection







■ Insert Series

● Insert Precision Selection Guide

Insert Class	M Class	G Class	E Class
			
Height Tolerance	±0.13mm	±0.13mm	±0.025mm
Features	Side surfaces have a sintered finish	Side surfaces are ground	Side surfaces are ground Thickness tolerances are tighter than G-class inserts
Applications	Roughing to Light Cutting	Finishing to Light Cutting	High-precision to finishing
Cat. No.	CCMT09T304N-LU DCMT070208N-SU	CCGT09T304R-FX DCGT11T302MN-SI(*)	CCET09T302R-FX DCET0702018L-FY

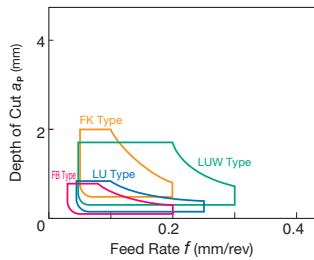
(*) A catalogue number with a feed direction symbol prefixed with "M" means that the product has a corner radius with negative tolerance.

● Chipbreaker Selection

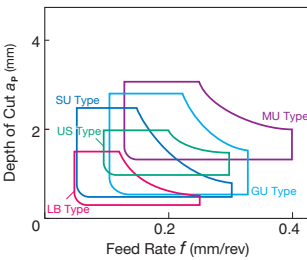
	Finishing to Light Cutting	Features
Parallel Type	FX Type 	Best suited for general-purpose external finishing with larger depths of cut.
Wide Type	FYS Type  FY Type 	Suppresses burrs in necking operation. Suppresses chattering during facing and external turning operations.
Molded Type	FC Type  SI Type 	3D chipbreaker with good chip control and sharp cutting edge. The FC type is for fine finishing, and the SI type for varying depths of cut.
	AG Type 	Breaker for aluminum alloy machining. Sharp edge and low adhesion.

■ Application Range of Chipbreakers for Finishing to Light Cutting

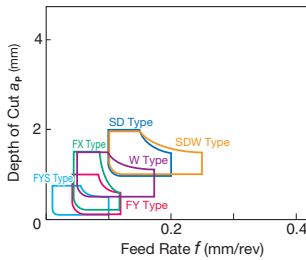
● M Class Finishing to Light Cutting



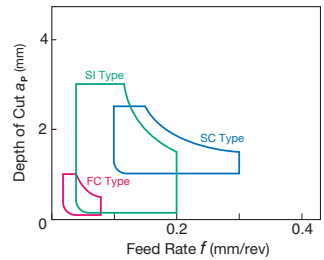
● M Class Light Cutting



● G Class Ground Type











● G Class Chipbreaker








■ Chipbreakers for Finishing to Light Cutting





Positive Type M Class

FB Type P M K N S  Finishing breaker for mild steel, with good chip control and surface finish. Relief Angle 5° 7° 11° CCMT09T300 Type	LU Type P M K N S  Chip control significantly improved in fine cutting. Relief Angle 5° 7° 11° CCMT09T300 Type	LUW Type P M K N S  High-performance finishing breaker with wiper edge. Relief Angle 7° 11° CCMT09T300 Type	FP Type P M K N S  Fine cutting breaker with two-step breaker structure. Relief Angle 7° CCMT09T300 Type	FK Type P M K N S  Finishing breaker with sharp edge and good chip control. Relief Angle 11° TPMT160400 Type
LB Type P M K N S  Light-cutting breaker with sharp edge and good chip control. Relief Angle 5° 7° 11° CCMT09T300 Type	SU Type P M K N S  General-purpose breaker with sharp edge. Relief Angle 7° 11° TPMT160400 Type	GU Type P M K N S  General-purpose chipbreaker combining stable chip evacuation performance and long tool life. Relief Angle 5° 7° 11° CCMT09T300 Type		

Positive Type G Class Ground Chipbreaker

FX Type P M K N S  Parallel breaker with sharp edge. Relief Angle 5° 7° 11° TPGT110300 Type	FYS Type P M K N S  Fine cutting breaker with sharp edge. Relief Angle 5° 7° CCGT04X100 Type	FY Type P M K N S  Wide breaker with sharp edge. Relief Angle 5° 7° 11° TPGT110300 Type	SD Type P M K N S  Stepped parallel ground type. Relief Angle 7° 11° TPGT110300 Type	AY Type P M K N S  High-quality ground aluminum breaker achieving excellent machined surface quality. Relief Angle 5° 7° 11° CCGT09T300 Type
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Positive Type G Class

FC Type P M K N S  Peripheral ground 3D breaker with good chip control and sharp edge. Relief Angle 7° 11° CCGT09T300 Type	SI Series P M K N S  Sharp edged breaker for a wide range of applications from finishing to light cutting. Relief Angle 7° CCGT09T300 Type	SC Type P M K N S  Two-step breaker for light cutting. Relief Angle 7° TCGT110300 Type	AG Type P M K N S  Al breaker for mirror finish and anti-adhesion. Relief Angle 7° CCGT09T300 Type
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Applicable Work Material: P Steel M Stainless Steel K Cast Iron N Non-ferrous Metal S Exotic Alloy

SPB Type

For Small Lathes

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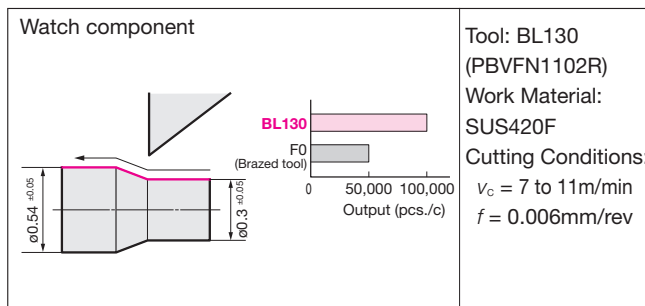
■ Features

- High rigidity type tools for gang-type NC lathes
- Inserts for various applications can be used on a single holder
- Can also be used on turret-type toolposts
- Uncoated blank inserts are stocked so cutting edges can be ground as required
- BL130 has wear resistance similar to coated grades and sharpness similar to uncoated grades
- Ultra-fine grained Cemented Carbide grade F1, typically used for brazed tools, is now available for indexable inserts

■ Applicable Grades

Applicable Work Material	Stainless Steel		Brass, Aluminum Alloy
	General Steel/SK Material		
Insert Grade	Austenitic	Martensitic Ferritic	
BL130	○	○	○
F1	○	◎	○

■ Application Examples



Very Small Diameter Part Turning
Screw-on

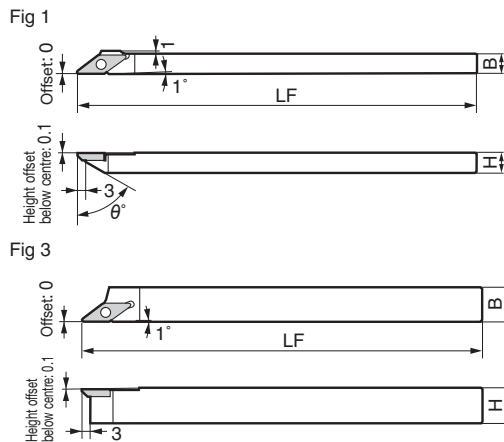
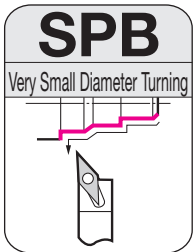


Figure shows right-hand (R) tool.

Holder

Toolpost	Cat. No.	Stock		Height H	Width B	Overall Length LF	Relief Angle θ°	Fig	Parts		Wrench
		R	L						Flat Insert	Screw	
Turret-type	SPB R/L0707-70	●	—	7	7	140	70	1	BFTX02505N	1.1	LT08-06
	SPB R/L0808-60	●	—	8	8	140	60	2	BFTX02506N	1.5	
	SPB R/L0808-70	●	—	8	8	140	70	2	BFTX02505N	1.1	
	SPB R/L0909-70	●	—	9.5	9.5	140	70	2	BFTX02505N	1.1	
	SPB R/L1010-60	●	—	10	10	140	60	2	BFTX02506N	1.5	
	SPB R/L1212-60	●	—	12	12	140	60	2	BFTX02506N	1.5	
Gang type	SPB R/L0808	●	—	8	8	140	—	3	BFTX02506N	1.5	LT08-06
	SPB R/L1010	●	—	10	10	140	—	3	BFTX02506N	1.5	
	SPB R/L1212	●	—	12	12	140	—	3	BFTX02506N	1.5	

SEC-PB Tool Holders
SPB Type

Insert

(□) Cemented Carbide

Blank Insert

Dimensions (mm)

Cat. No.	Stock				Overall length L	Applications	Fig
	BL130		F1				
	R	L	R	L			
PBVX 1102 R/L-NB	●	●	●	●	17.2	Wide Range	1
PBVX 1102 R/L-SB	●	●	●	●	(20.14)	Sharp edge	2
PBVX 1102 R/L-BB	●	●	●	●	17.2	Special	3

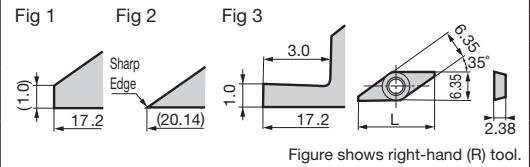


Figure shows right-hand (R) tool.

() is a reference value

Dimensions (mm)

Front Turning Insert

Cat. No.	Stock				Effective Length	Wiper Flat	Fig
	BL130		F1				
	R	L	R	L			
PBVFW 1102 R/L	●				1.0	Yes	1
PBVFN 1102 R/L	●				1.0	No	2

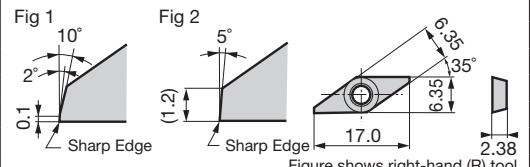


Figure shows right-hand (R) tool.

() is a reference value

Dimensions (mm)

Back Turning Insert

Cat. No.	Stock				Effective Length	Wiper Flat	Fig
	BL130		F1				
	R	L	R	L			
PBVBW 1102 R/L	●				1.0	Yes (2°)	1
PBVBN 1102 R/L	●				1.0	No (5°)	2

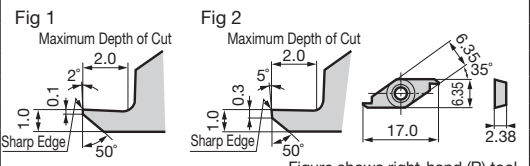


Figure shows right-hand (R) tool.

() is a reference value

Dimensions (mm)

Grooving Insert

Cat. No.	Stock				Machining Groove Depth CDX	Width of Cut CW	Fig
	BL130		F1				
	R	L	R	L			
PBVG 1102 R/L-030	●				0.5	0.3	1
PBVG 1102 R/L-050	●				1.0	0.5	1
PBVG 1102 R/L-100	●				2.0	1.0	1

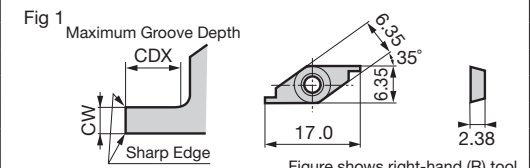
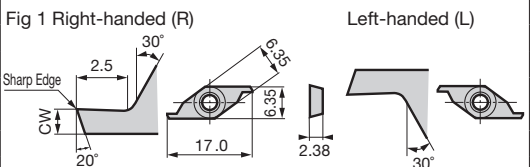


Figure shows right-hand (R) tool.

Dimensions (mm)

Cut-off Insert

Cat. No.	Stock				Max. Cut-off Dia.	Width of Cut CW	Fig
	BL130		F1				
	R	L	R	L			
PBVC 1102 R/L-50	●	●			5.0	1.0	1



Threading Insert

Cat. No.	Stock				Pitch	Fig
	BL130		F1			
	R	L	R	L		
PBVTF 1102 R/L	●				0.2 to 0.5	1
PBVTB 1102 R/L	●				0.2 to 0.5	2

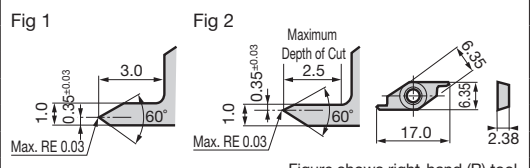


Figure shows right-hand (R) tool.

Recommended Cutting Conditions

Work Materials	P Free-Cutting Steel	P Carbon Steel	M Stainless Steel	N Non-ferrous Metal
Cutting Speed v_c (m/min)	5 to 80	5 to 80	5 to 50	5 to 100
Feed Rate f (mm/rev)	0.003 to 0.05			
Coolant	Wet (oil-based)			

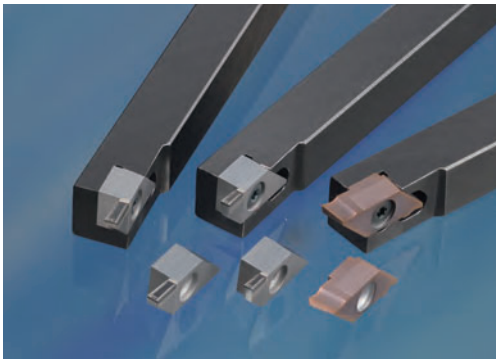
For Small Lathes

D

SGW Type

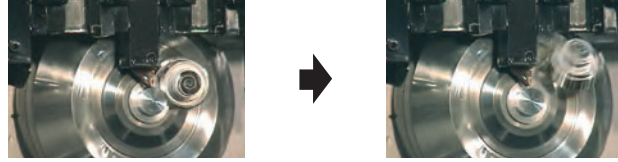
For Small Lathes

D



■ Features

- Enables high-efficiency roughing of long parts
- Coin-shaped chips are less likely to tangle with work material or machinery



■ Application Examples

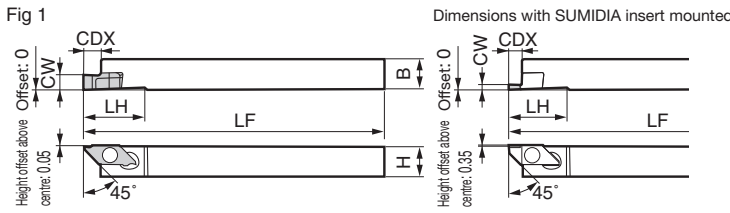
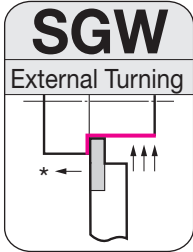
LD Type + DA1000

Conventional Tool

Work Material: Valve (A6061) Tool Cat. No.: KGV R2004-LD (DA1000)
Cutting Conditions: $v_c = 250\text{m/min}$, $f = 0.10\text{mm/rev}$, $a_p = 0.5\text{mm}$ Wet

■ SUMIDIA Multi-Function Tool with Chipbreaker SUMIDIA BREAK MASTER LD Type

- Provides excellent chip control in traverse cutting and grooving of aluminum alloy.
- Solves chip control problems and dramatically improves work efficiency.
- Achieves long, stable tool life by employing high-toughness grade SUMIDIA DA1000.



External Multi-purpose Type (Grooving/Traverse Cutting) Screw-on

*Use the SUMIDIA insert for traverse cutting.

Holder

Cat. No.	Stock	Height H	Width B	Overall Length LF	Maximum Groove Depth CDX	Head Length LH	Fig	Parts	
								Flat Insert Screw	Wrench
SGW R1212	●	12	12	120	7.0	24.5	1	BFTX0410T8R	1.1
SGW R1616	●	16	16	120	7.0	24.5	1		

The above dimensions for LF, CDX and LH are values with a carbide insert mounted. (Refer to the table below for dimensions with SUMIDIA insert mounted)

Insert (Carbide) (Coated Carbide)

Cat. No.	AC1030U	AC530U	Width of Cut CW	Overall Length L	Overall Length LF	Maximum Groove Depth CDX	Head Length LH	Effective Length	Fig	Dimensions (mm)	
										Effective Length	Fig
KGV R400	●	●	4.0	21.0	120	7.0	24.5	6.3	1		
KGV R500	●	●	5.0	21.0	120	7.0	24.5	6.3	1		
KGV R600	●	●	6.0	21.0	120	7.0	24.5	6.3	1		

Insert (SUMIDIA) (SUMIDIA)

Cat. No.	DA1000	Width of Cut CW	Overall Length L	Overall Length LF	Maximum Groove Depth CDX	Head Length LH	Effective Length	Fig	Dimensions (mm)	
									Effective Length	Fig
KGV R2004-LD	●	2.0	19.7	118.7	5.7	23.2	4.0	1		
KGV R2504-LD	●	2.5	19.7	118.7	5.7	23.2	4.0	1		
KGV R2506-LD	●	2.5	21.2	120.2	7.2	24.7	5.5	1		

The above dimensions for LF, CDX and LH are the holder dimensions with insert mounted.

Recommended Cutting Conditions

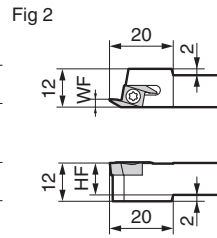
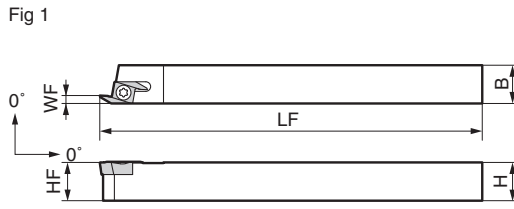
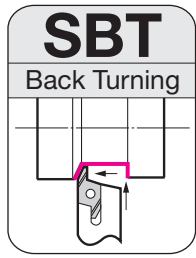
Work Material	P Steel	M Stainless Steel	N Non-ferrous Metal	N Non-ferrous Metal DA1000	
Insert Grade	AC1030U			DA1000	
Machining Details	Grooving			Grooving	Traverse Cutting
Spindle Speed n (min ⁻¹)	4,000 to 6,000			4,500 to 8,000	4,500 to 8,000
Feed Rate f (mm/rev)	0.05 to 0.15			0.07 to 0.15	0.07 to 0.15
Coolant	Wet (oil-based)				

Be careful with spindle power during use. For small lathes, insufficient spindle power during machining may cause the machine to stop.
Be careful when machining carbon steel and stainless steel in particular.

D10

Recommended Tightening Torque (N·m) Note: Regrinding the SUMIDIA BreakMaster LD Type will adversely affect chip evacuation performance.

SBT Type/PBT Type



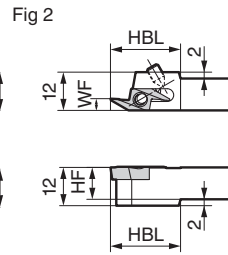
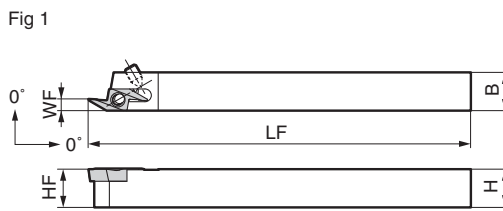
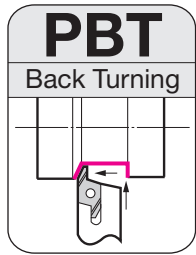
Back Turning
Screw-on

Holder

Cat. No.	Stock	Height H	Width B	Overall Length LF	Cutting Edge Distance WF	Cutting Edge Height HF	Applicable Insert	Parts			
								Fig	Flat Insert Screw	Wrench	
SBT35 R1010	●	10	10	120	2.5	10	BTR3500	2	BFTX0307N	2.0	TRX10 <small>(For Torx Holes)</small>
SBT35 R1212	●	12	12	120	2.5	12		1			
SBT35 R1616	●	16	16	120	2.5	16		1			
SBT35 R2020	●	20	20	125	2.5	20		1			

Dimensions (mm)

Back
Clamp



Back Turning
Lever Lock

Holder

Cat. No.	Stock	Height H	Width B	Overall Length LF	Cutting Edge Distance WF	Cutting Edge Height HF	Offset HBL	Applicable Insert	Parts				
									Fig	Lever Pin	Set Screw	Pin	Wrench
PBT35 R1010	●	10	10	120	2.5	10	20	BTR3500	2	LCL09	BTT0407	LP07	TH020
PBT35 R1212	●	12	12	120	2.5	12	—		1				
PBT35 R1616	●	16	16	120	2.5	16	—		1				
PBT35 R2020	●	20	20	120	2.5	20	—		1				
PBT55 R1010	●	10	10	120	3.7	10	22	BTR5500	2	LCL09	BTT0407	LP07	TH020
PBT55 R1212	●	12	12	120	3.7	12	—		1				
PBT55 R1616	●	16	16	120	3.7	16	—		1				
PBT55 R2020	●	20	20	120	3.7	20	—		1				
PBT80 R1010	●	10	10	120	5.2	10	25	BTR8000	2	LCL09	BTT0407	LP07	TH020
PBT80 R1212	●	12	12	120	5.2	12	—		1				
PBT80 R1616	●	16	16	120	5.2	16	—		1				
PBT80 R2020	●	20	20	120	5.2	20	—		1				

Dimensions (mm)

Insert (● Coated Carbide/● Cermet)

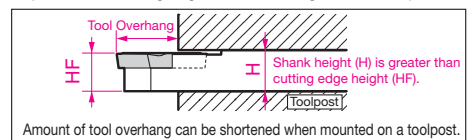
Cat. No.	AC1030U	AC530U	ACZ150	T1500A	Overall Length L	Maximum Depth of Cut CDX	Width of Cut CW	Corner Radius RE	Applicable Holders	Fig	Dimensions (mm)		
											RE	CDX	L
BT R3505	●	●	●	●	15	3.5	2.5	0.05	SBT35R0000	1			
BT R3515	●	●	●	●	15	3.5	2.5	0.15	PBT35R0000	1			
BT R5505	●	●	●	—	19	5.5	3.7	0.05	PBT55R0000	1			
BT R5515	●	●	●	—	19	5.5	3.7	0.15	PBT55R0000	1			
BT R8005	●	●	●	—	24	8.0	5.2	0.05	PBT80R0000	1			
BT R8015	●	●	●	—	24	8.0	5.2	0.15	PBT80R0000	1			

Recommended Cutting Conditions

Work Materials	P Free-Cutting Steel		P Carbon Steel		M Stainless Steel	
	Plunging	Traverse Cut	Plunging	Traverse Cut	Plunging	Traverse Cut
Cutting Speed v_c (m/min)	50 to 150		50 to 150		50 to 150	
Feed Rate f (mm/rev)	0.02 to 0.10	0.02 to 0.15	0.02 to 0.05	0.02 to 0.10	0.02 to 0.04	0.02 to 0.06
Coolant	Wet (oil-based)					

Shank Tolerance of SBT Type/PBT Type

A positive tolerance (0.1 - 0.3) is applied to the shank height (H) to prevent the cutting edge from interfering with the toolpost.



SEC-Front Turning Tool Holders

SFT Type

General Turning
Screw-on

For Small
Lathes

D

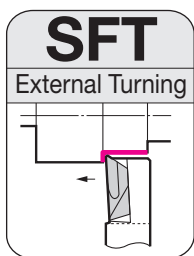
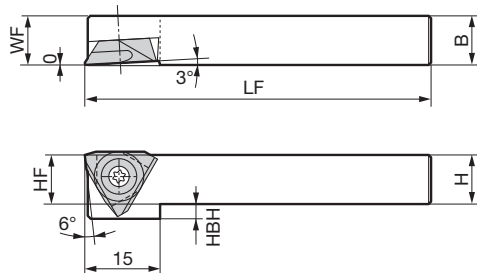


Fig 1



Holder

Parts Dimensions (mm)

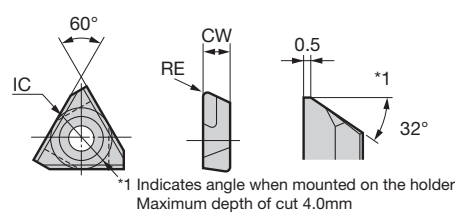
Cat. No.	Stock	Height H	Width B	Overall Length LF	Cutting Edge Distance WF	Cutting Edge Height HF	Offset HBH	Applicable Insert	Fig	Flat Insert Screw	Wrench
											 (For Torx Holes)
SFT R1010	●	10	10	120	10	10	3	TFR3300	1		 (For Torx Holes)
SFT R1212	●	12	12	120	12	12	1		1		
SFT R1616	●	16	16	120	16	16	—		1		
SFT R2020	●	20	20	120	20	20	—		1		

Insert (Coated Carbide)

Dimensions (mm)

Cat. No.	ACZ150	Inscribed Circle IC	Width of Cut CW	Corner Radius RE	Applicable Holders	Fig
TF R3300	●	9.525	4.76	—	SFT R0000	1
TF R3305	●	9.525	4.76	0.05		1
TF R3315	●	9.525	4.76	0.15		1
TF R3320	●	9.525	4.76	0.20		1

Fig 1



RS-SCL Type

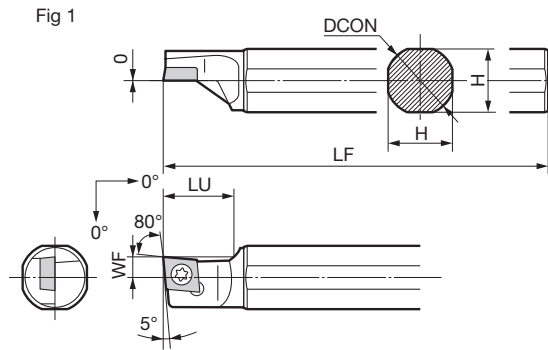
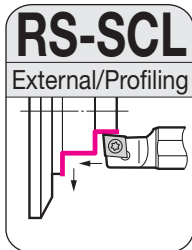


■ Features of Round Shank Holders

- Shank diameters from $\varnothing 14$ to $\varnothing 25$ mm are in stock. Holders can be fitted on various manufacturers' sleeve toolposts.
- Bars can be mounted from the rear of the sleeve toolpost to increase the tooling range.

For Small Lathes

D



General Turning
Screw-on

Holder

Parts

Dimensions (mm)

Cat. No.	Stock	Diameter DCON	Height H	Overall Length LF	Cutting Edge Distance WF	Usable Length LU	Applicable Insert		Flat Insert Screw		Wrench
							Cat. No.	Ref. Page	Fig		(For Torx Holes)
RS15H-SCL L06	●	15.875	15	100	6.0	20	CC□□0602	B76 on	1	BFTX02507NT	RT08
RS19X-SCL L06	●	19.05	18	120	6.0	20					
RS20X-SCL L06X	●	20	19	95	6.0	20					
RS20X-SCL L06	●	20	19	120	6.0	20					
RS22X-SCL L06	●	22	21	120	6.0	20					
RS25X-SCL L06	●	25	24	120	6.0	20					
RS25M-SCL L06	●	25.4	24	150	6.0	20	CC□□09T3	B79 on	1	BFTX0408NT	LT25NT
RS15H-SCL L09	●	15.875	15	100	6.0	20					
RS19X-SCL L09	●	19.05	18	120	6.0	20					
RS20X-SCL L09S	●	20	19	95	6.0	20					
RS20X-SCL L09	●	20	19	120	6.0	20					
RS22X-SCL L09	●	22	21	120	6.0	20					
RS25X-SCL L09	●	25	24	120	6.0	20	1				
RS25M-SCL L09	●	25.4	24	150	6.0	20					

Right hand (R) or neutral (N) inserts can be used.

SEC-Round Shank Tool Holders

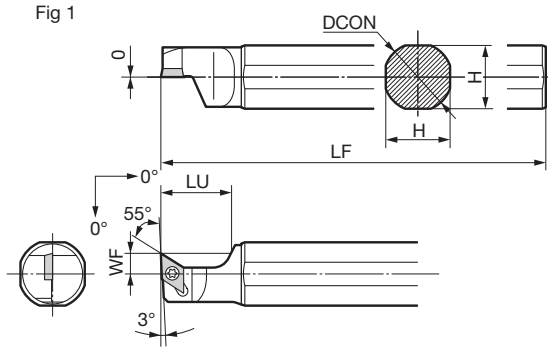
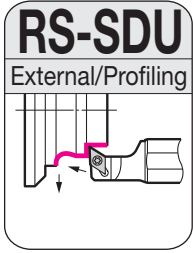
RS-SDU Type/RS-SDX Type



General Turning
Screw-on

For Small Lathes

D



Holder

Parts

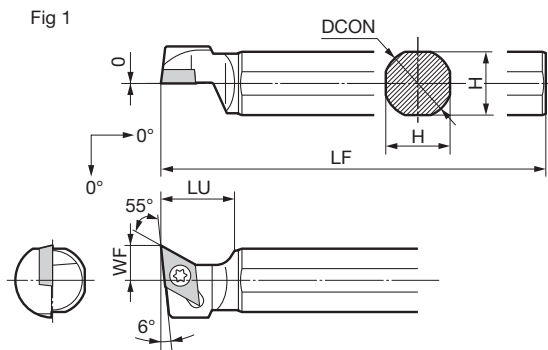
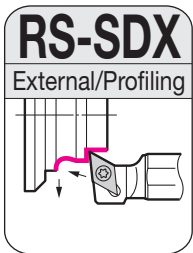
Dimensions (mm)

Cat. No.	Stock	Diameter DCON	Height H	Overall Length LF	Cutting Edge Distance WF	Usable Length LU	Applicable Insert		Flat Insert Screw		Wrench
							Cat. No.	Ref. Page	Fig		
RS14F-SDU L07	●	14	13	80	6.0	20	DC□□0702	B86 on	1	BFTX02507NT	RT08
RS15H-SDU L07	●	15.875	15	100	6.0	20					
RS16F-SDU L07	●	16	15	80	6.0	20					
RS16X-SDU L07	●	16	15	120	6.0	20					
RS19X-SDU L07	●	19.05	18	120	6.0	20					
RS20X-SDU L07S	●	20	19	95	6.0	20					
RS20X-SDU L07	●	20	19	120	6.0	20					
RS22X-SDU L07	●	22	21	120	6.0	20	DC□□11T3	B90 on	1	BFTX0410NT	LT25NT
RS19X-SDU L11	●	19.05	18	120	10.0	20					
RS20X-SDU L11S	●	20	19	95	10.0	20					
RS20X-SDU L11	●	20	19	120	10.0	20					
RS22X-SDU L11	●	22	21	120	10.0	20					
RS25X-SDU L11	●	25	24	120	10.0	20					
RS25M-SDU L11	●	25.4	24	150	10.0	20					

Right hand (R) or neutral (N) inserts can be used.



General Turning
Screw-on



Holder

Parts

Dimensions (mm)

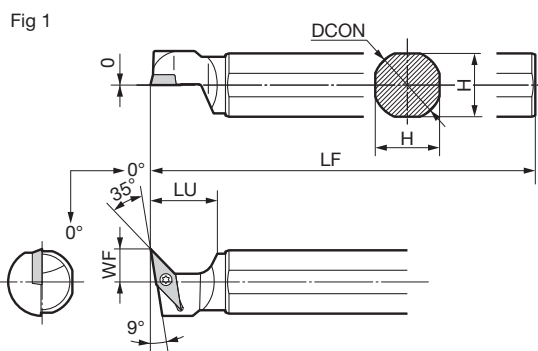
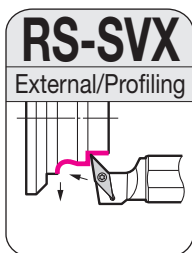
Cat. No.	Stock	Diameter DCON	Height H	Overall Length LF	Cutting Edge Distance WF	Usable Length LU	Applicable Insert		Flat Insert Screw		Wrench
							Cat. No.	Ref. Page	Fig		
RS19X-SDX L11	●	19.05	18	120	10.0	20	DC□□11T3	B90 on	1	BFTX0410NT	LT25NT
RS20X-SDX L11S	●	20	19	95	10.0	20					
RS20X-SDX L11	●	20	19	120	10.0	20					
RS25X-SDX L11	●	25	24	120	10.0	20					

Right hand (R) or neutral (N) inserts can be used.

RS-SVX Type/RS-SVVP Type



General Turning
Screw-on





For Small
Lathes

D

Holder

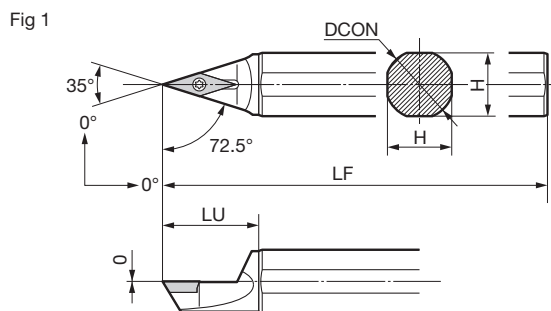
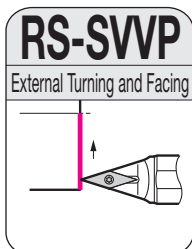
Parts Dimensions (mm)

Cat. No.	Stock	Diameter DCON	Height H	Overall Length LF	Cutting Edge Distance WF	Usable Length LU	Applicable Insert		Fig	Flat Insert Screw 	Wrench  (For Torx Holes)
							Cat. No.	Ref. Page			
RS15H-SVX L11	●	15.875	15	100	10.0	20	VC□□1103	B126 on	1	BFTX02507NT	RT08
RS19X-SVX L11	●	19.05	18	120	10.0	20					
RS20X-SVX L11S	●	20	19	95	10.0	20					
RS20X-SVX L11	●	20	19	120	10.0	20					
RS22X-SVX L11	●	22	21	120	10.0	20					
RS25X-SVX L11	●	25.4	24	150	10.0	20					

Right hand (R) or neutral (N) inserts can be used.





General Turning
Screw-on



Holder

Parts Dimensions (mm)

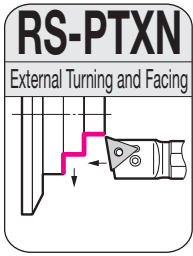
Cat. No.	Stock	Diameter DCON	Height H	Overall Length LF	Usable Length LU	Applicable Insert		Fig	Flat Insert Screw 	Wrench  (For Torx Holes)
						Cat. No.	Ref. Page			
RS19X-SVVP N11	●	19.05	18	120	27	VP□□1103	B129	1	BFTX02507NT	RT08
RS22X-SVVP N11	●	22	21	120	27					

SEC-Round Shank Tool Holders

RS-PTXN Type

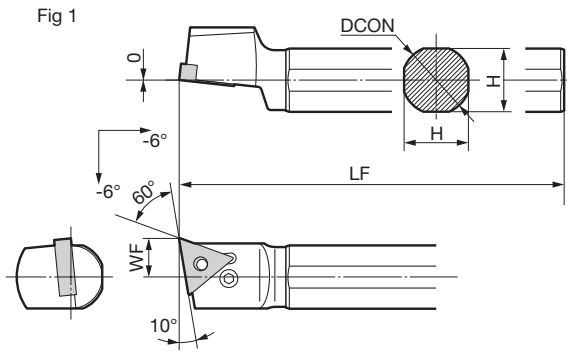


General Turning
Lever Lock



For Small Lathes

D



Holder

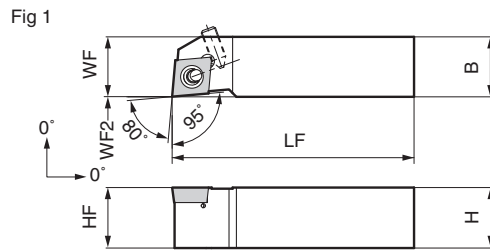
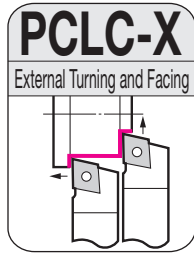
Parts

Dimensions (mm)

Cat. No.	Stock	Diameter DCON	Height H	Overall Length LF	Cutting Edge Distance WF	Applicable Insert		Fig	Lever Pin	Bolt	Wrench
						Cat. No.	Ref. Page				
RS19X-PTXN L16	●	19.05	18	120	11.0	TN□□1604	B56 on	1			 (For Hex Socket)
RS20X-PTXN L16	●	20	19	120	11.0			1			
RS25M-PTXN L16	●	25.4	24	150	13.0			1			

Right hand (R) or neutral (N) inserts can be used.

Zero Offset Holders



For PCLC R/L1212-K09X

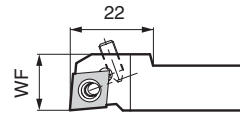


Figure shows right-hand (R) tool.

Holder

Parts

Dimensions (mm)

Cat. No.	Stock		Height H	Width B	Overall Length LF	Cutting Edge Distance WF	Cutting Edge Height HF	Offset WF2	Applicable Insert		Lever Pin Fig	Set Screw	Pin	Wrench (For Hex Socket)	
	R	L							Cat. No.	Ref. Page					
PCLC R/L1010-K06X	●		10	10	125	10	10	0	CC□T0602	B76 on	1	LCL06	BTT0407	LP07	TH020
PCLC R/L1212-K09X	●		12	12	125	15	12	0							
PCLC R/L1616-K09X	●		16	16	125	16	16	0	CC□T09T3	B79 on	1	LCL09	BTT0411	LP06	TH020

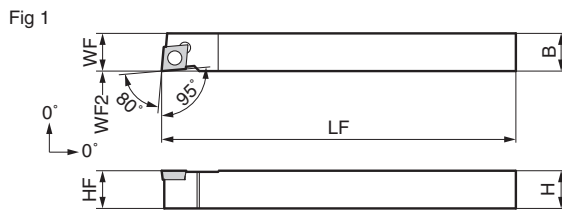
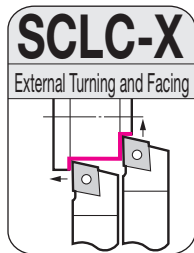


Figure shows right-hand (R) tool.

Holder

Parts

Dimensions (mm)

Cat. No.	Stock		Height H	Width B	Overall Length LF	Cutting Edge Distance WF	Cutting Edge Height HF	Offset WF2	Applicable Insert		Flat Insert Screw Fig	Wrench (For Torx Holes)		
	R	L							Cat. No.	Ref. Page				
SCLC R/L1010-H06X	●	●	10	10	100	10	10	0	CC□T0602	B76 on	1	BFTX02506N	1.5	TRX08
SCLC R/L1215-K09X	●	●	12	15	125	15	12	0						
SCLC R/L1215-F09X*	●	●	12	15	85	15	12	0	CC□T09T3	B79 on	1	BFTX0409N	3.4	TRX15

*85mm Shank

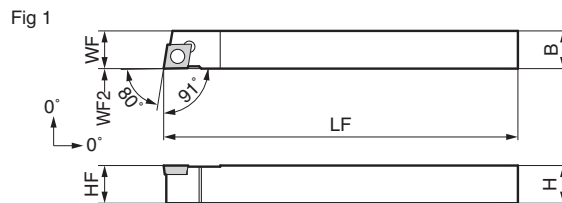
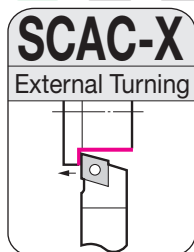


Figure shows right-hand (R) tool.

Holder

Parts

Dimensions (mm)

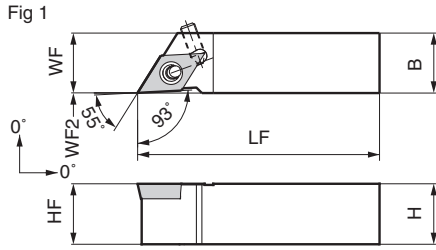
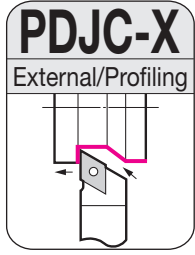
Cat. No.	Stock		Height H	Width B	Overall Length LF	Cutting Edge Distance WF	Cutting Edge Height HF	Offset WF2	Applicable Insert		Flat Insert Screw Fig	Wrench (For Torx Holes)		
	R	L							Cat. No.	Ref. Page				
SCAC R/L1010-H06X	●	●	10	10	100	10	10	0	CC□T0602	B76 on	1	BFTX02506N	1.5	TRX08
SCAC R/L1215-F09X*	●	●	12	15	85	15	12	0						
SCAC R/L1215-K09X	●	●	12	15	125	15	12	0	CC□T09T3	B79 on	1	BFTX0409N	3.4	TRX15

*85mm Shank

Zero Offset Holders



For Small Lathes



For PDJC R/L1212-K11X

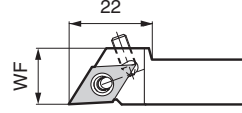


Figure shows right-hand (R) tool.

Holder

Parts

Dimensions (mm)

Cat. No.	Stock		Height H	Width B	Overall Length LF	Cutting Edge Distance WF	Cutting Edge Height HF	Offset WF2	Applicable Insert		Lever Pin	Set Screw	Pin	Wrench	
	R	L							Cat. No.	Ref. Page					
PDJC R/L1010-K07X	●		10	10	125	10	10	0	DC□T0702	B86 on	1	LCL06	BTT0407	LP04	TH020 <small>(For Hex Socket)</small>
PDJC R/L1212-K11X	●		12	12	125	15	12	0	DC□T11T3	B90 on	1	LCL09	BTT0411	LP07	TH020
PDJC R/L1616-K11X	●		16	16	125	16	16	0	DC□T11T3	B90 on	1	LCL09	BTT0411	LP07	TH020

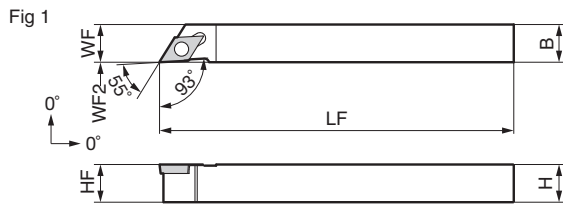
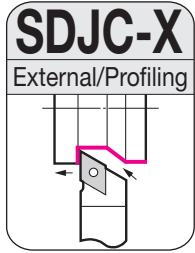


Figure shows right-hand (R) tool.

Holder

Parts

Dimensions (mm)

Cat. No.	Stock		Height H	Width B	Overall Length LF	Cutting Edge Distance WF	Cutting Edge Height HF	Offset WF2	Applicable Insert		Flat Insert	Screw	Wrench	
	R	L							Cat. No.	Ref. Page				
SDJC R/L1010-H07X	●	●	10	10	100	10	10	0	DC□T0702	B86 on	1	BFTX02506N	1.5	TRX08 <small>(For Torx Holes)</small>
SDJC R/L1215-F11X*	●	●	12	15	85	15	12	0	DC□T11T3	B90 on	1	BFTX0409N	3.4	TRX15
SDJC R/L1215-K11X	●	●	12	15	125	15	12	0	DC□T11T3	B90 on	1	BFTX0409N	3.4	TRX15

*85mm Shank

Zero Offset Holders

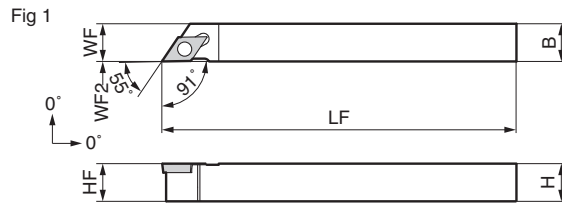
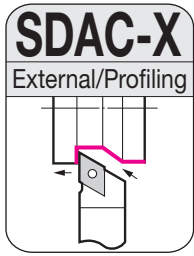


Figure shows right-hand (R) tool.

Holder

Parts

Dimensions (mm)

Cat. No.	Stock		Height H	Width B	Overall Length LF	Cutting Edge Distance WF	Cutting Edge Height HF	Offset WF2	Applicable Insert		Fig	Flat Insert Screw		Wrench
	R	L							Cat. No.	Ref. Page			N-m	
SDAC R/L1010-H07X	●	●	10	10	100	10	10	0	DC□T0702	B86 on	1	BFTX02506N	1.5	TRX08
SDAC R/L1215-F11X*	●	●	12	15	85	15	12	0	DC□T11T3	B90 on	1	BFTX0409N	3.4	TRX15
SDAC R/L1215-K11X	●	●	12	15	125	15	12	0	DC□T11T3	B90 on	1	BFTX0409N	3.4	TRX15

*85mm Shank

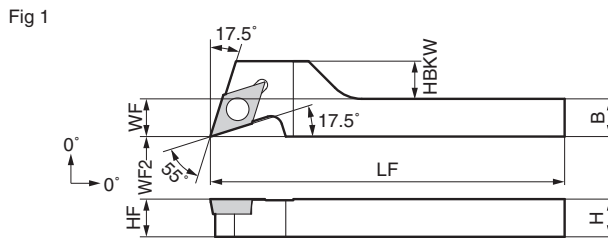
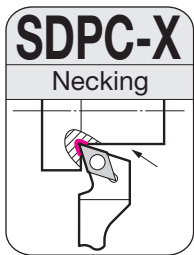


Figure shows right-hand (R) tool.

Holder

Parts

Dimensions (mm)

Cat. No.	Stock		Height H	Width B	Overall Length LF	Cutting Edge Distance WF	Cutting Edge Height HF	Step HBKW	Offset WF2	Applicable Insert		Fig	Flat Insert Screw		Wrench
	R	L								Cat. No.	Ref. Page			N-m	
SDPC R/L1010-H11X	●	●	10	10	100	10	10	10	0	DC□T11T3	B90 on	1	BFTX0409N	3.4	TRX15

Zero Offset Holders

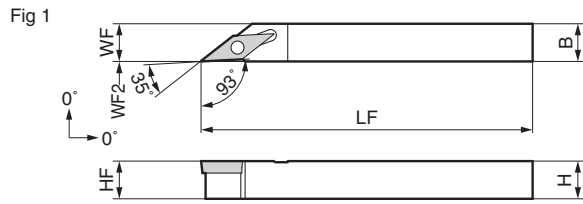
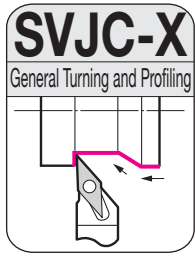


Figure shows right-hand (R) tool.

For Small Lathes

D

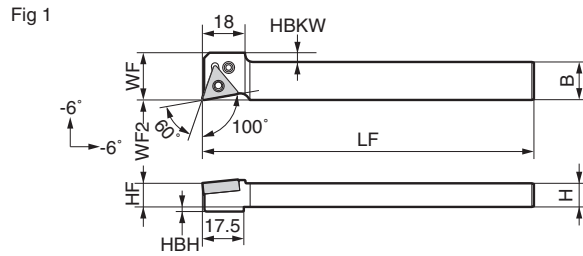
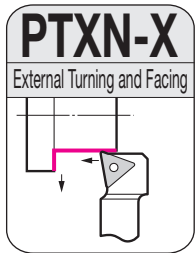
Holder

Parts

Dimensions (mm)

Cat. No.	Stock		Height H	Width B	Overall Length LF	Cutting Edge Distance WF	Cutting Edge Height HF	Offset WF2	Applicable Insert		Fig	Flat Insert Screw		Wrench (For Torx Holes)
	R	L							Cat. No.	Ref. Page		N-m		
SVJC R/L1010-H11X	●	●	10	10	100	10	10	0			1			
SVJC R/L1212-F11X*	●	●	12	12	85	12	12	0	VC□T1103	B126 on	1	BFTX02508NV	1.5	TRX08
SVJC R/L1212-K11X	●	●	12	12	125	12	12	0			1			

*85mm Shank



Holder

Parts

Dimensions (mm)

Cat. No.	Stock	Height H	Width B	Overall Length LF	Cutting Edge Distance WF	Cutting Edge Height HF	Step HBH	Step HBKW	Offset WF2	Applicable Insert		Fig	Lever Pin	Bolt	Wrench (For Hex Socket)
										Cat. No.	Ref. Page				
PTXN R1016-X16X	●	10	16	120	20	10	2	4	0			1			
PTXN R1216-X16X	●	12	16	120	20	12	0	4	0			1	LCL33NT	LCS33NT	LH020NT
PTXN R1616-X16X	●	16	16	120	20	16	0	4	0	TN□□1604	B56 on	1			
PTXN R2020-X16X	●	20	20	120	20	20	0	0	0			1			

MEMO

A large grid of dotted lines for writing a memo. The grid consists of 20 columns and 30 rows of small squares, providing a structured space for text.

SEC-MINI Tool Holders

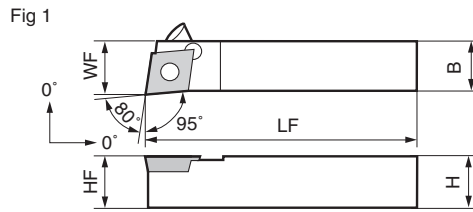
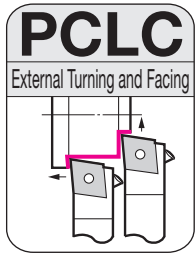
PC Type/SC Type



General External Turning
Lever Lock

For Small Lathes

D



For PCLC R/L0810-K06

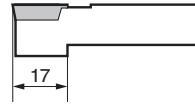


Figure shows right-hand (R) tool.

Holder

Parts

Dimensions (mm)

Cat. No.	Stock		Height H	Width B	Overall Length LF	Cutting Edge Distance WF	Cutting Edge Height HF	Applicable Insert		Fig	Lever Pin	Set Screw	Pin	Wrench <small>(For Hex Socket)</small>
	R	L						Cat. No.	Ref. Page					
PCLC R/L0810-K06	●	●	8	10	125	10.5	8	CC□□0602	B76 on	1	LCL06	BTT0407	LP07	TH020
PCLC R/L1010-K06	●	●	10	10	125	10.5	10			1		BTT0407		
PCLC R/L1212-M09	●	●	12	12	150	12.5	12			1		BTT0411		
PCLC R/L1616-M09	●	●	16	16	150	16.5	16	CC□□09T3	B79 on	1	LCL09		LP06	TH020
PCLC R/L2020-M09	●	●	20	20	150	20.5	20			1				



General External Turning
Screw-on

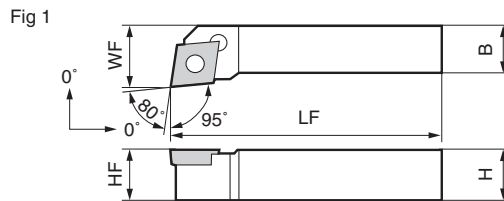
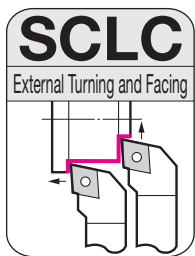


Figure shows right-hand (R) tool.

Holder

Parts

Dimensions (mm)

Cat. No.	Previous Cat. No.	Stock		Height H	Width B	Overall Length LF	Cutting Edge Distance WF	Cutting Edge Height HF	Applicable Insert		Fig	Flat Insert Screw		Wrench <small>(For Torx Holes)</small>
		R	L						Cat. No.	Ref. Page			N·m	
SCLC R/L0808H06	SCLC R/L0808-06	●	●	8	8	100	10	8	CC□□0602	B76 on	1	BFTX02506N	1.5	TRX08
SCLC R/L1010H06	SCLC R/L1010-06	●	●	10	10	100	12	10			1			
SCLC R/L1212H09	SCLC R/L1212-09	●	●	12	12	100	16	12			1			
SCLC R/L1616H09	SCLC R/L1616-09	●	●	16	16	100	20	16	CC□□09T3	B79 on	1	BFTX0409N	3.4	TRX15
SCLC R/L2020K09	SCLC R/L2020-09	●	●	20	20	125	24	20			1			

When using handed breaker inserts for facing, the holder and insert are opposite handed.



General External Turning
Screw-on

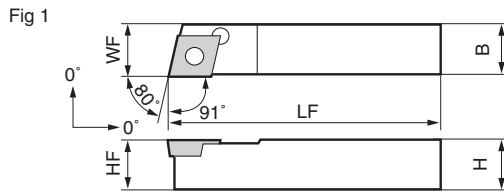
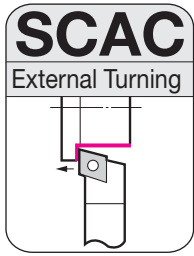


Figure shows right-hand (R) tool.

Holder

Parts

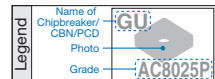
Dimensions (mm)

Cat. No.	Stock		Height H	Width B	Overall Length LF	Cutting Edge Distance WF	Cutting Edge Height HF	Applicable Insert		Fig	Flat Insert Screw		Wrench (For Torx Holes)
	R	L						Cat. No.	Ref. Page			N·m	
SCAC R/L0808-06	●		8	8	100	8.5	8	CC□□0602	B76 on	1	BFTX02506N	1.5	TRX08
SCAC R/L1010-06	●	●	10	10	100	10.5	10			1			
SCAC R/L1212-09	●	●	12	12	100	12.5	12			1			
SCAC R/L1616-09	●	●	16	16	100	16.5	16	CC□□09T3	B79 on	1	BFTX0409N	3.4	TRX15
SCAC R/L2020-09	●	●	20	20	125	20.5	20			1			

Applicable Inserts ◀ PCLC Type / SCLC Type / SCAC Type

1st Recommended Insert

- Refer as well to the Insert Selection Guide (page A10 on).
- Depending on the insert size, some combinations cannot be made-to-order or manufactured.



Cutting Range Process	P (Steel)			M (Stainless Steel)			K (Cast Iron)			S (Exotic Alloy)	N (Non-ferrous)		H (Hardened Steel)		Hard Brittle Material
	Finishing	Medium Cutting	Roughing	Finishing	Medium Cutting	Roughing	High-speed Finishing	Finishing to Medium Cutting	Medium to Roughing	Finishing to Medium Cutting	High-precision/Finishing	Finishing to Medium Cutting	Coated	Uncoated	—
General Cutting	FB T1500Z	GU AC8025P	MU AC8025P	LB AC6030M	GU AC6030M	MU AC6040M	SUMIBORON BN7000/BNC500	MU AC4015K	No Chipbreaker AC4015K	SU AC5015S	SUMIDIA DA1000	AG H1	SUMIBORON BNC2125	SUMIBORON BN2000	SUMIDIA DA90
High-precision	FC T1500A	SI AC1030U	SC AC1030U	FC AC1030U	SI AC1030U	SC AC1030U	SUMIBORON BN7000/BNC500	—	—	SI AC5015S	SUMIDIA DA1000	—	SUMIBORON BNC2115	SUMIBORON BN1000	SUMIDIA BINDERLESS NPD10
Recommended Cutting Conditions	A10 on			A14 on			A16 on			A18 on	A22 on		A20 on		M2 on

BNC500 is for ductile cast iron.

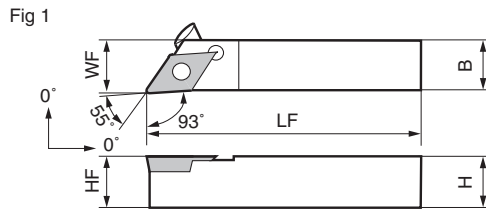
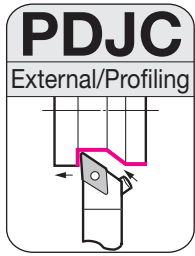
PD Type/SD Type



General External Turning and Profiling
Lever Lock

For Small Lathes

D



For PDJC R/L0810-K07

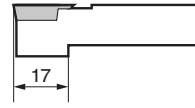


Figure shows right-hand (R) tool.

Holder

Parts

Dimensions (mm)

Cat. No.	Stock		Height H	Width B	Overall Length LF	Cutting Edge Distance WF	Cutting Edge Height HF	Applicable Insert		Fig	Lever Pin	Set Screw	Pin	Wrench (For Hex Socket)
	R	L						Cat. No.	Ref. Page					
PDJC R/L0810-K07	●	●	8	10	125	10.5	8	DC□□0702	B86 on	1	LCL06	BTT0407	LP04	TH020
PDJC R/L1010-K07	●	●	10	10	125	10.5	10			1		BTT0407		
PDJC R/L1212-M11	●	●	12	12	150	12.5	12			1		BTT0407		
PDJC R/L1616-M11	●	●	16	16	150	16.5	16	DC□□11T3	B90 on	1	LCL09	BTT0411	LP07	TH020
PDJC R/L2020-M11	●	●	20	20	150	20.5	20			1				



General External Turning and Profiling
Screw-on

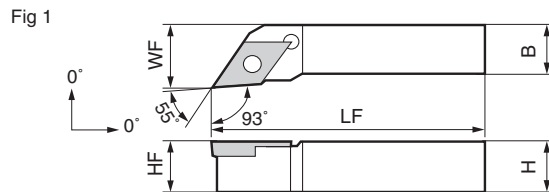
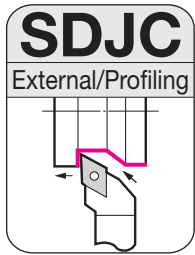


Figure shows right-hand (R) tool.

Holder

Parts

Dimensions (mm)

Cat. No.	Previous Cat. No.	Stock		Height H	Width B	Overall Length LF	Cutting Edge Distance WF	Cutting Edge Height HF	Applicable Insert		Fig	Flat Insert Screw		Wrench (For Torx Holes)
		R	L						Cat. No.	Ref. Page			N·m	
SDJC R/L0808H07	SDJC R/L0808-07	●		8	8	100	10	8	DC□□0702	B86 on	1	BFTX02506N	1.5	TRX08
SDJC R/L1010H07	SDJC R/L1010-07	●	●	10	10	100	12	10			1			
SDJC R/L1212H11	SDJC R/L1212-11	●	●	12	12	100	16	12			1			
SDJC R/L1616H11	SDJC R/L1616-11	●	●	16	16	100	20	16	DC□□11T3	B90 on	1	BFTX0409N	3.4	TRX15
SDJC R/L2020K11	SDJC R/L2020-11	●	●	20	20	125	24	20			1			

SD Type



General External Turning and Profiling
Screw-on

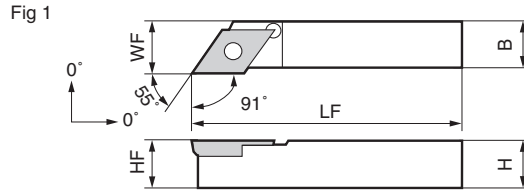
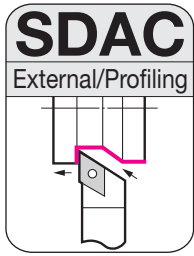


Figure shows right-hand (R) tool.

Holder

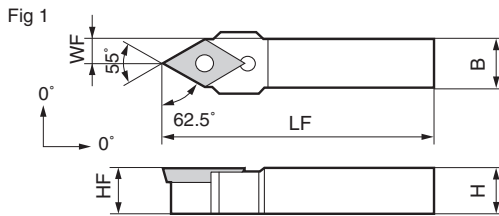
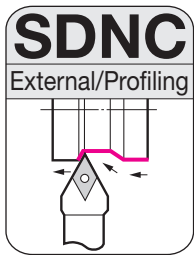
Parts

Dimensions (mm)

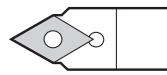
Cat. No.	Stock		Height H	Width B	Overall Length LF	Cutting Edge Distance WF	Cutting Edge Height HF	Applicable Insert		Fig	Flat Insert Screw		Wrench (For Torx Holes)
	R	L						Cat. No.	Ref. Page			N·m	
SDAC R/L0808-07	●	●	8	8	100	8.5	8	DC□□0702	B86 on	1	BFTX02506N	1.5	TRX08
SDAC R/L1010-07	●	●	10	10	100	10.5	10	DC□□0702	B86 on	1	BFTX02506N	1.5	TRX08
SDAC R/L1212-11	●	●	12	12	100	12.5	12	DC□□11T3	B90 on	1	BFTX0409N	3.4	TRX15
SDAC R/L1616-11	●	●	16	16	100	16.5	16	DC□□11T3	B90 on	1	BFTX0409N	3.4	TRX15
SDAC R/L2020-11	●	●	20	20	125	20.5	20	DC□□11T3	B90 on	1	BFTX0409N	3.4	TRX15



General External Turning and Profiling
Screw-on



For SDNC N1616
SDNC N2020



Holder

Parts

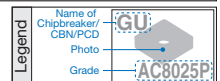
Dimensions (mm)

Cat. No.	Stock		Height H	Width B	Overall Length LF	Cutting Edge Distance WF	Cutting Edge Height HF	Applicable Insert		Fig	Flat Insert Screw		Wrench (For Torx Holes)
	R	L						Cat. No.	Ref. Page			N·m	
SDNC N0808-07			8	8	100	4	8	DC□□0702	B86 on	1	BFTX02506N	1.5	TRX08
SDNC N1010-07	●		10	10	100	5	10	DC□□0702	B86 on	1	BFTX02506N	1.5	TRX08
SDNC N1212-11	●		12	12	100	6	12	DC□□11T3	B90 on	1	BFTX0409N	3.4	TRX15
SDNC N1616-11	●		16	16	100	8	16	DC□□11T3	B90 on	1	BFTX0409N	3.4	TRX15
SDNC N2020-11	●		20	20	125	10	20	DC□□11T3	B90 on	1	BFTX0409N	3.4	TRX15

Applicable Inserts ◀ PDJC Type / SDJC Type / SDAC Type / SDNC Type

1st Recommended Insert

- Refer as well to the Insert Selection Guide (page A10 on).
- Depending on the insert size, some combinations cannot be made-to-order or manufactured.



Cutting Range Process	P (Steel)			M (Stainless Steel)			K (Cast Iron)			S (Exotic Alloy)	N (Non-ferrous)		H (Hardened Steel)		Hard Brittle Material
	Finishing	Medium Cutting	Roughing	Finishing	Medium Cutting	Roughing	High-speed Finishing	Finishing to Medium Cutting	Medium to Roughing	Finishing to Medium Cutting	High-precision/Finishing	Finishing to Medium Cutting	Coated	Uncoated	—
General Cutting	FB T1500Z	GU AC8025P	MU AC8025P	LB AC6030M	GU AC6030M	MU AC6030M	SUMIBORON BN7000/BNCS00	MU AC4015K	No Chipbreaker AC4015K	FX AC5015S	SUMIDIA DA1000	AG H1	SUMIBORON BNC2125	SUMIBORON BN2000	SUMIDIA DA90
High-precision	FC T1500A	SI AC1030U	SC AC1030U	FC AC1030U	SI AC1030U	SC AC1030U	SUMIBORON BN7000/BNCS00	—	—	SI AC5015S	SUMIDIA DA1000	—	SUMIBORON BNC2115	SUMIBORON BN1000	SUMIDIA DA90
Recommended Cutting Conditions	A10 on			A14 on			A16 on			A18 on	A22 on		A20 on		M2 on

BNCS500 is for ductile cast iron.

Recommended Tightening Torque (N·m)

D25

For Small Lathes

D

SS Type



General External Turning
Screw-on

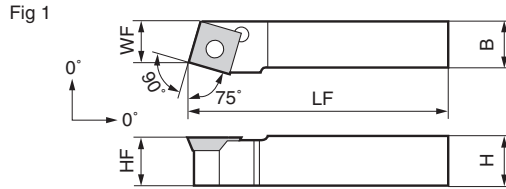
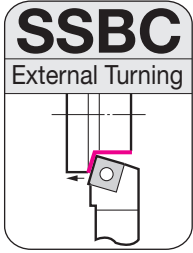


Figure shows right-hand (R) tool.

For Small Lathes

D

Holder

Parts

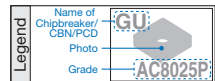
Dimensions (mm)

Cat. No.	Stock		Height H	Width B	Overall Length LF	Cutting Edge Distance WF	Cutting Edge Height HF	Applicable Insert		Fig	Flat Insert Screw		Wrench (For Torx Holes)
	R	L						Cat. No.	Ref. Page		N·m		
SSBC R/L1010-07	●	●	10	10	100	9	10	SC□□0702	B96	1	BFTX0307N	2.0	TRX10
SSBC R/L1212-09	●	●	12	12	100	11	12			1			
SSBC R/L1616-09	●	●	16	16	100	15	16	SC□□09T3	B97	1	BFTX0409N	3.4	TRX15
SSBC R/L2020-09	●	●	20	20	125	19	20			1			

Applicable Inserts ◀ SSBC Type

1st Recommended Insert

- Refer as well to the Insert Selection Guide (page A10 on).
- Depending on the insert size, some combinations cannot be made-to-order or manufactured.



Cutting Range Process	P (Steel)			M (Stainless Steel)			K (Cast Iron)		N (Non-ferrous)
	Finishing	Medium Cutting	Roughing	Finishing	Medium Cutting	Roughing	Finishing to Medium Cutting	Medium to Roughing	—
General Cutting	FB T1500Z	GU AC8025P	MU AC8025P	LB AC6030M	GU AC6030M	MU AC6040M	MU AC4015K	No Chipbreaker AC4015K	SUMIDIA DA1000
High-precision	FX T1500A	SC AC1030U	SC AC1030U	FX AC1030U	SC AC1030U	SC AC1030U	—	—	SUMIDIA DA1000
Recommended Cutting Conditions	A10 on			A14 on			A16 on		A22 on

ST Type



General External Turning
Screw-on

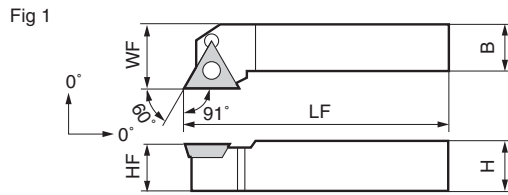
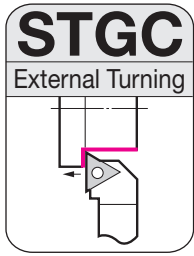


Figure shows right-hand (R) tool.

Holder

Parts

Dimensions (mm)

Cat. No.	Stock		Height H	Width B	Overall Length LF	Cutting Edge Distance WF	Cutting Edge Height HF	Applicable Insert		Fig	Flat Insert Screw		Wrench <small>(For Torx Holes)</small>
	R	L						Cat. No.	Ref. Page			N·m	
STGC R/L0808-09	●		8	8	100	10	8	TC□□0902	B108	1	BFTX02205N	0.5	TRX06
STGC R/L1010-09	●	●	10	10	100	12	10						
STGC R/L1212-11	●	●	12	12	100	16	12	TC□□1102	B109	1	BFTX02506N	1.5	TRX08
STGC R/L1616-11	●	●	16	16	100	20	16						
STGC R/L2020-11	●	●	20	20	125	25	20						



General External Turning
Screw-on

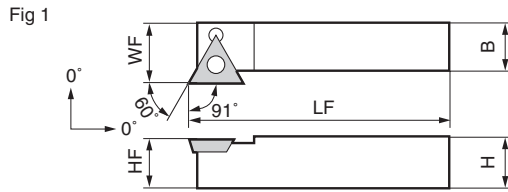
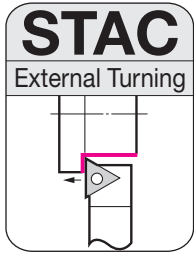


Figure shows right-hand (R) tool.

Holder

Parts

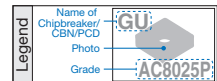
Dimensions (mm)

Cat. No.	Stock		Height H	Width B	Overall Length LF	Cutting Edge Distance WF	Cutting Edge Height HF	Applicable Insert		Fig	Flat Insert Screw		Wrench <small>(For Torx Holes)</small>
	R	L						Cat. No.	Ref. Page			N·m	
STAC R/L0808-09		●	8	8	100	8.5	8	TC□□0902	B108	1	BFTX02205N	0.5	TRX06
STAC R/L1010-09	●		10	10	100	10.5	10						
STAC R/L1212-11	●	●	12	12	100	12.5	12	TC□□1102	B109	1	BFTX02506N	1.5	TRX08
STAC R/L1616-11	●	●	16	16	100	16.5	16						
STAC R/L2020-11	●	●	20	20	125	20.5	20						

Applicable Inserts ◀ STGC Type / STAC Type

1st Recommended Insert

- Refer as well to the Insert Selection Guide (page A10 on).
- Depending on the insert size, some combinations cannot be made-to-order or manufactured.



Cutting Range / Process	P (Steel)			M (Stainless Steel)			K (Cast Iron)		N (Non-ferrous)
	Finishing	Medium Cutting	Roughing	Finishing	Medium Cutting	Roughing	Finishing to Medium Cutting	Medium to Roughing	—
General Cutting	LU T1500Z	SU AC8025P	SU AC8025P	LB AC6030M	SU AC6030M	SU AC6040M	MU AC4015K	No Chipbreaker AC4015K	SUMIDIA DA1000
High-precision	FX AC1030U	SI AC1030U	SC AC1030U	FX AC1030U	SI AC1030U	SC AC1030U	—	—	SUMIDIA DA1000
Recommended Cutting Conditions	A10 on			A14 on			A16 on		A22 on

SEC-MINI Tool Holders

SV Type (7° Pos.)



General External Turning and Profiling
Screw-on

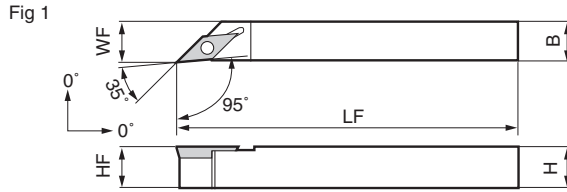
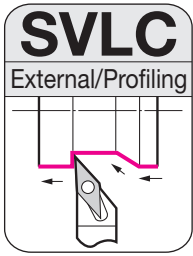


Figure shows right-hand (R) tool.

For Small Lathes

D

Holder

Parts

Dimensions (mm)

Cat. No.	Stock		Height H	Width B	Overall Length LF	Cutting Edge Distance WF	Cutting Edge Height HF	Applicable Insert		Fig	Flat Insert Screw		Wrench (For Torx Holes)
	R	L						Cat. No.	Ref. Page			N·m	
SVLC R/L1010-H11	●	●	10	10	100	10.5	10	VC□□1103	B126 on	1	BFTX02508NV	1.5	TRX08
SVLC R/L1212-H11	●	●	12	12	100	12.5	12						
SVLC R/L1616-H11	●	●	16	16	100	16.5	16						
SVLC R/L2020-K11*	●	●	20	20	125	20.5	20						

*Old Cat. No. SVLC R/L 2020-H11



General External Turning and Profiling
Screw-on

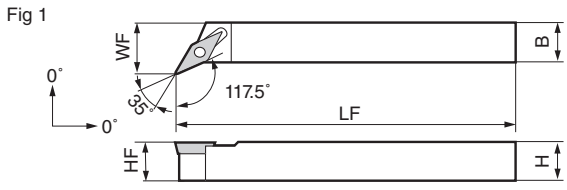
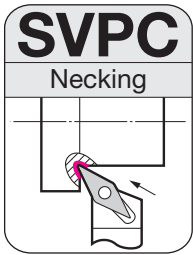


Figure shows right-hand (R) tool.

Holder

Parts

Dimensions (mm)

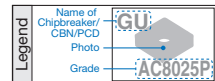
Cat. No.	Stock		Height H	Width B	Overall Length LF	Cutting Edge Distance WF	Cutting Edge Height HF	Applicable Insert		Fig	Flat Insert Screw		Wrench (For Torx Holes)
	R	L						Cat. No.	Ref. Page			N·m	
SVPC R/L1010-H11	●	●	10	10	100	14.5	10	VC□□1103	B126 on	1	BFTX02508NV	1.5	TRX08
SVPC R/L1212-H11	●	●	12	12	100	16.5	12						
SVPC R/L1616-H11	●	●	16	16	100	20.5	16						
SVPC R/L2020-K11*	●	●	20	20	125	24.5	20						

*Old Cat. No. SVPC R/L 2020-H11

Applicable Inserts ◀ SVLC Type / SVPC Type

1st Recommended Insert

- Refer as well to the Insert Selection Guide (page A10 on).
- Depending on the insert size, some combinations cannot be made-to-order or manufactured.



Cutting Range Process	P (Steel)		M (Stainless Steel)		S (Exotic Alloy)		N (Non-ferrous)		H (Hardened Steel)		Hard Brittle Material
	Finishing	Medium Cutting	Finishing	Medium Cutting	Finishing to Medium Cutting	Medium to Roughing	High-precision/Finishing	Finishing to Medium Cutting	Coated	Uncoated	—
General Cutting	FB T1500Z	GU AC8025P	LB AC6030M	GU AC6030M	SU AC5015S	SU AC5025S	SUMIDIA DA1000	AG H1	SUMIBORON BNC2125	SUMIBORON BN2000	SUMIDIA DA90
High-precision	FC T1500A	SI AC1030U	FC AC1030U	SI AC1030U	FC AC5015S	SI AC5015S	SUMIDIA DA1000	—	SUMIBORON BNC2115	SUMIBORON BN1000	SUMIDIA BINDERLESS NPD10
Recommended Cutting Conditions	⚙️ A10 on		⚙️ A14 on		⚙️ A18 on		⚙️ A22 on		⚙️ A20 on		⚙️ M2 on

SV Type (11° Pos.)



General External Turning and Profiling
Screw-on

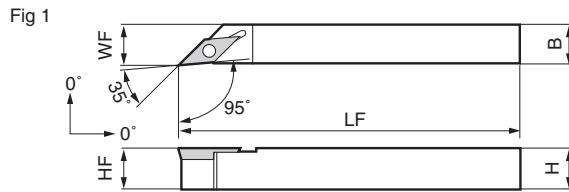
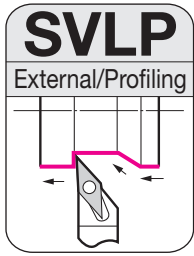


Figure shows right-hand (R) tool.

Holder

Parts

Dimensions (mm)

Cat. No.	Stock		Height H	Width B	Overall Length LF	Cutting Edge Distance WF	Cutting Edge Height HF	Applicable Insert		Flat Insert Screw		Wrench (For Torx Holes)	
	R	L						Cat. No.	Ref. Page	Fig	N·m		
SVLP R/L1010-H11	●	●	10	10	100	10.5	10	VP□T1103	B129	1	BFTX02508NV	1.5	TRX08
SVLP R/L1212-H11	●	●	12	12	100	12.5	12						
SVLP R/L1616-H11	●	●	16	16	100	16.5	16						



General External Turning and Profiling
Screw-on

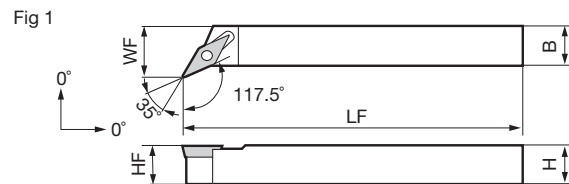
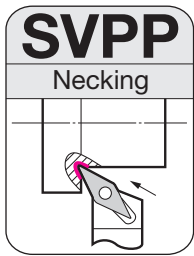


Figure shows right-hand (R) tool.

Holder

Parts

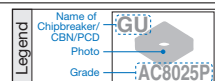
Dimensions (mm)

Cat. No.	Stock		Height H	Width B	Overall Length LF	Cutting Edge Distance WF	Cutting Edge Height HF	Applicable Insert		Flat Insert Screw		Wrench (For Torx Holes)	
	R	L						Cat. No.	Ref. Page	Fig	N·m		
SVPP R/L1010-H11	●	●	10	10	100	14.5	10	VP□T1103	B129	1	BFTX02508NV	1.5	TRX08
SVPP R/L1212-H11	●	●	12	12	100	16.5	12						
SVPP R/L1616-H11	●	●	16	16	100	20.5	16						

Applicable Inserts ◀ SVLP Type / SVPP Type

1st Recommended Insert

- Refer as well to the Insert Selection Guide (page A10 on).
- Depending on the insert size, some combinations cannot be made-to-order or manufactured.



Process	Cutting Range	
	P (Steel) Finishing	M (Stainless Steel) Finishing
High-precision	FX AC1030U	FX AC1030U
Recommended Cutting Conditions	☞ A24 on	☞ A24 on

