

External Holders

C1 to C46

C



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External Tool Holder Series



General Features

Since the development of the clamp-on SEC-2 type holders in 1959 and the cam-lock SEC-3 type the following year, Sumitomo Electric Hardmetal has had more than 60 years of experience in producing and developing indexable holders. Presently, Sumitomo Electric Hardmetal provides a wide variety of top quality external turning tools to satisfy any machining needs with reliable and consistent performance.

*SEC: Steady & Easy Clamp. The generic code for our indexable insert tools.

Tooling Selection

Applications		General Turning (Facing)	General Turning and Profiling	General Turning					
Insert Shape		80° Diamond Type C	55° Diamond Type D	Triangular Type T					
Structure	Type								
Double Clamp	M Type Tool Holders	DCLN C8 DCLN-J C8	DDJN C12 DDJN-J C12	DDHN C12	DDNN C13	DTGN C27	DTFN C27	MTJN C33	MTXN C33
	T-REX Tool Holders	—	—	DTR55C C15 <small>SemiTurn-REX</small>	DTR55Q C15 <small>SemiTurn-REX</small>	—	—	—	—
Pin Lock	30 Type Tool Holders	—	—	—	—	ETGN C30 ETAN C30	ETFN C31	ETEN C32	ETXN C32
Lever Lock	70 Type Tool Holders	PCLC D17 D22 <small>Back Clamp</small>	PCLN C8	PDJC D18 D24 <small>Back Clamp</small>	—	PTGN C28	PTTN C28	PTFN C29	PTXN D20
	70 Type Tool Holders	PCBN C10	PCFN C10	PDJN C13	—	—	—	—	—
Screw-on	Mini Holders	SCLC C11 D17 D22	SCAC D17 D23	SDJC C17 D18 D24	SDAC D19 D25	STGC D27	STAC D27	—	—
	Mini Holders	—	—	SDNC D25	SDPC D19	Clamp-on 40 Type Tool Holders	CTGP/CTAP [FP22/FP21] C34	CTFP [FP25] C35	—

Figures in [] are previous model numbers and those in <> indicate the lead angle of the holder. Be careful of interference during machining.

External Tool Holder Series

Performance Comparison Table

Series	Clamp Mechanism						Rake Angle		Clamp Rigidity	Operability	Index Accuracy	Chip Control	Legend
	P	E	C	M	S	D	Neg.	Pos.					
SumiTurn T-REX Tool Holders						○	○		◎	◎	◎	○	Clamp Mechanism P: Lever Lock E: Pin Lock C: Clamp-on M: Pin & Clamp-on S: Screw-on D: Double Clamp Features ◎: Excellent ○: Good △: Possible
SEC-D Type Holders						○	○		◎	◎	◎	○	
SEC-70 Type Tool Holders	○						○		◎	◎	◎	◎	
SEC-30 Type Holders		○					○		△	○	△	◎	
SEC-M Type Holders				○			○		◎	◎	○	○	
SUMIBORON PR Type Holders	○							○	◎	◎	◎	◎	

◎ mark: 1st Recommendation

Tooling Selection

Applications		General Turning	General Turning and Profiling	General Turning				Special Turning
Insert Shape		Trigon Type	35° Diamond Type	Square Type				Round Type
Structure	Type							
Double Clamp	M Type Tool Holders	 MWLN C41	 DVJN C36 DVJN-J C36	 DVVN C37	 DSBN C19	 DSDN C19	 DSSN C20	—
	D Type Tool Holders	 DWLN C40 DWLN-J C40	 DVQN C37	—	—	—	—	—
Pin Lock	30 Type Tool Holders	—	—	—	 ESBN C23	 ESDN C23	 ESSN C24	 ESKN C24
Lever Lock	70 Type Tool Holders	 PWLN C41	—	—	 PSBN C20	 PSDN C21	 PSSN C22	 PSKN C22
	—	—	—	—	—	—	—	 PRGC C18 PRDC C18
Screw-on	Mini Holders	—	 SVPC C39 D28 SVPP D29	 SVLC C38 D28 SVLP D29	 SSBC D26	—	—	—
	SV Type Profiling Tool Holders	—	 SVJC C38 D20	 SVVC C39	Clamp-on 40 Type Tool Holders SEC-R	 CSRP [FP11] C25	 CSDP [FP14] C25	 CSKP [FP15] C26
—	—	—	—	—	—	—	—	 BNRN L129

Figures in [] are previous model numbers and those in <> indicate the lead angle of the holder. Be careful of interference during machining.

SEC- External Holder Cat. No. Identification Table

SEC-External Holder Cat. No. Identification Tables

Example: **D T F N R 25 25(-) M 16 (04 W)**

(1) Clamping System (Refer to Table 1)
 (2) Insert Shape (Refer to Table 2)
 (3) Holder Style (Refer to Table 3)
 (4) Insert Relief Angle (Refer to Table 4)
 (5) Feed Direction (Refer to Table 5)
 (6) Shank Height (Refer to Table 6)
 (7) Shank Width (Refer to Table 7)
 (8) Shank Length (Refer to Table 8)
 (9) Insert Cutting Edge Length (B3 (Table 5) Previous cat. nos.: See Table 9)
 (10) Insert Thickness (Refer to Table 10)
 (11) Shim (Added only for holders with shims. Added only for holders with shims such as SEC-30/GD types)

Example

DTFNR2525M16

- Structure: Double Clamp Method
- Shape: With Triangle Insert, Cutting Edge Angle 91°
- Shank: H - 25mm, W - 25mm, L - 150mm

Table 1

(1) Clamping System					
Symbol	Clamp	Structure	Symbol	Clamp	Structure
C	Clamp-on		M	Clamp-on + Pin Lock	
D	Double Clamp		P	Lever Lock (insert supported by 2 faces)	
E	Pin Lock (insert supported by 1 face)		S	Screw-on	

Table 2

(2) Insert Shape			
Symbol	Insert Shape	Symbol	Insert Shape
A	85° Apex Angle Parallelogram	M	86° Apex Angle Diamond Type
B	82° Apex Angle Parallelogram	O	Octagonal Type
C	80° Apex Angle Diamond Type	P	Pentagonal Type
D	55° Apex Angle Diamond Type	R	Round Type
E	75° Apex Angle Diamond Type	S	Square Type
F	50° Apex Angle Diamond Type	T	Triangular Type
H	Trigon Type	V	35° Apex Angle Diamond Type
K	55° Apex Angle Parallelogram	W	Uneven Trigon Type
L	Rectangular Type		

Table 4

(4) Insert Relief Angle	
Symbol	Relief Angle
A	3°
B	5°
C	7°
D	15°
E	20°
F	25°
G	30°
N	0°
P	11°
O	Special Relief Angle

Table 5

(5) Feed Direction					
Symbol	Right Hand	Symbol	Left Hand	Symbol	Neutral
R		L		N	

Table 3

(3) Holder Style (— indicates main cutting edge)					
Symbol	Shape	Offset	Symbol	Shape	Offset
A		No	L		Yes
B		No	N		No
D		No	R		Yes
E		No	S		Yes
F		Yes	T		Yes
G		Yes	U		Yes
J		Yes	V		No
K		Yes	Y		Yes

Table 6

(6) Shank Height		(7) Shank Width	
Symbol	Height (mm)	Symbol	Width (mm)
12	12	12	12
16	16	16	16
20	20	20	20
25	25	25	25
32	32	32	32
40	40	40	40
50	50	50	50

2 digits are used for shank height and width dimensions in mm.

Table 7

(10) Insert Thickness			
Symbol	Thickness (mm)	Symbol	Thickness (mm)
X1	1.40/1.80*	04	4.76
01	1.59	05	5.56
02	2.38	06	6.35
T2	2.78	07	7.94
03	3.18	09	9.52
T3	3.97		

Table 8

(8) Shank Length	
Symbol	Length (mm)
F	80
H	100
K	125
M	150
N	160
P	170
Q	180
S	250
T	300
U	350

For some previous catalogue numbers, a hyphen (-) is used instead of a letter.

(Table 9) Applicable for previous cat. nos. only

Insert Inscribed Circle		Insert Thickness	
Symbol	Inscribed Circle (mm)	Symbol	Thickness (mm)
3	9.525	2	3.18
4	12.70	3	4.76
5	15.875	4	6.35
6	19.05	5	7.94
8	25.40	6	9.52

Previous cat. nos. indicated an inscribed circle symbol and insert thickness symbol displayed in 2 columns.

For Round Type Inserts

Symbol	Inscribed Circle (mm)
10	10
12	12
16	16
20	20
25	25
32	32

* 91° on our products

* CCET03X1→1.40, CCET04X1→1.80

Cutting Edge Position Dimensions

■ Cutting Position Dimension and Corner Radius

● Cutting position dimension by corner radius (ISO standard)

(Values for X and Y in the table are with lateral rake angle and cutting edge angle of 0°.)

Tool Shape			Dimensions (mm)			Tool Shape			Dimensions (mm)		
Symbol	Shape	Close-up of Cutting Edge	RE	X	Y	Symbol	Shape	Close-up of Cutting Edge	RE	X	Y
A			0.4	0.291	—	L			0.4	0.040	0.040
			0.8	0.581	—				0.8	0.079	0.079
			1.2	0.872	—				1.2	0.119	0.119
			1.6	1.162	—				1.6	0.159	0.159
			2.4	1.743	—				2.4	0.238	0.238
B			0.4	0.089	0.024	N			0.4	0.463	0.263
			0.8	0.178	0.048				0.8	0.925	0.471
			1.2	0.268	0.072				1.2	1.388	0.707
			1.6	0.357	0.096				1.6	1.850	0.943
			2.4	0.535	0.143				2.4	2.776	1.414
D			0.4	0.164	0.164	R			0.4	0.089	0.024
			0.8	0.329	0.329				0.8	0.178	0.048
			1.2	0.493	0.493				1.2	0.268	0.072
			1.6	0.658	0.658				1.6	0.357	0.096
			2.4	0.986	0.986				2.4	0.535	0.143
E			0.4	0.396	0.229	S			0.4	0.164	0.164
			0.8	0.793	0.458				0.8	0.329	0.329
			1.2	1.190	0.687				1.2	0.493	0.493
			1.6	1.587	0.916				1.6	0.658	0.658
			2.4	2.381	1.374				2.4	0.986	0.986
F			0.4	—	0.291	T			0.4	0.396	0.229
			0.8	—	0.581				0.8	0.793	0.458
			1.2	—	0.872				1.2	1.190	0.687
			1.6	—	1.162				1.6	1.587	0.916
			2.4	—	1.743				2.4	2.381	1.374
G			0.4	0.291	—	U			0.4	0.253	0.058
			0.8	0.581	—				0.8	0.506	0.116
			1.2	0.872	—				1.2	0.759	0.175
			1.6	1.162	—				1.6	1.013	0.233
			2.4	1.743	—				2.4	1.519	0.350
J			0.4	0.344	0.033	V			0.4	0.923	0.291
			0.8	0.687	0.079				0.8	1.846	0.582
			1.2	1.031	0.118				1.2	2.770	0.873
			1.6	1.375	0.157				1.6	3.693	1.164
			2.4	2.062	0.236				2.4	5.537	1.746
K			0.4	0.024	0.089	Y			0.4	0.002	0.033
			0.8	0.048	0.178				0.8	0.005	0.066
			1.2	0.072	0.268				1.2	0.008	0.099
			1.6	0.096	0.357				1.6	0.011	0.132
			2.4	0.143	0.535				2.4	0.017	0.198

● Corner radius position calculation

Calculation Formula for Corner Radius Position (mm)			Values of IC and RE for the Calculation of B (mm)				
Shape	Formula		Inscribed Circle Nominal Value	IC for Calculation	Corner Radius	Nominal Value	RE for Calculation
	Triangular Type	$B = 3/2d - RE$	3.97	3.9688	02	0.2	0.203
	Square Type	$B = (\sqrt{2} - 1) \times (d/2 - RE)$	4.76	4.7625	04	0.4	0.397
	Diamond Type	$B = (1/\sin(\theta/2) - 1) \times (d/2 - RE)$	5.56	5.5562	08	0.8	0.794
			6.35	6.3500	12	1.2	1.191
			7.94	7.9375	16	1.6	1.588
			9.525	9.5250	24	2.4	2.381
			12.70	12.7000			
			15.875	15.8750			
			19.05	19.0500			
			25.40	25.4000			

Internal Coolant Holders

External Holders

C

Neg.

Pos.

C

D

R

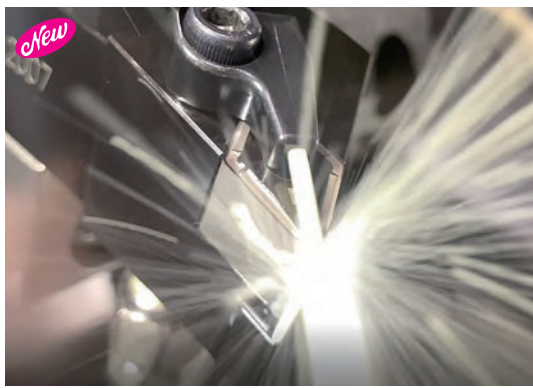
S

T

V

W

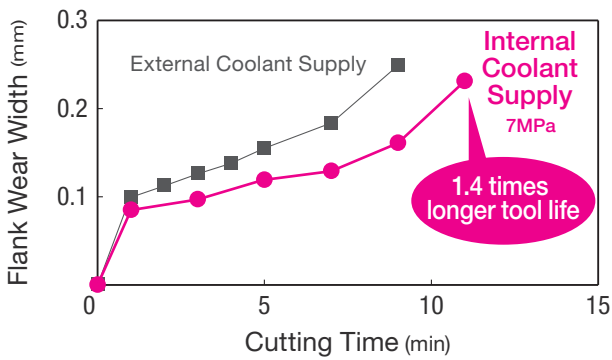
Special



Features

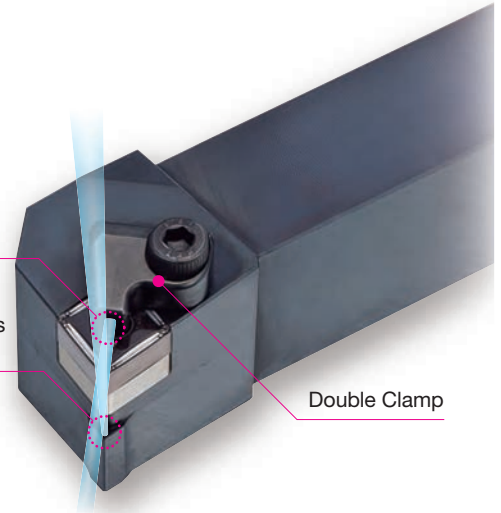
- Through-clamp internal coolant supply holder improves chip evacuation and tool life
- Enables directed coolant supply from a close range, towards the cutting edge
- Suppresses flank wear with additional coolant supply to the flank face
- Realises high rigidity and indexing accuracy with double clamping

Wear Resistance



Coolant supply near the rake face directed at the cutting edge

Coolant supply from the bottom suppresses flank wear

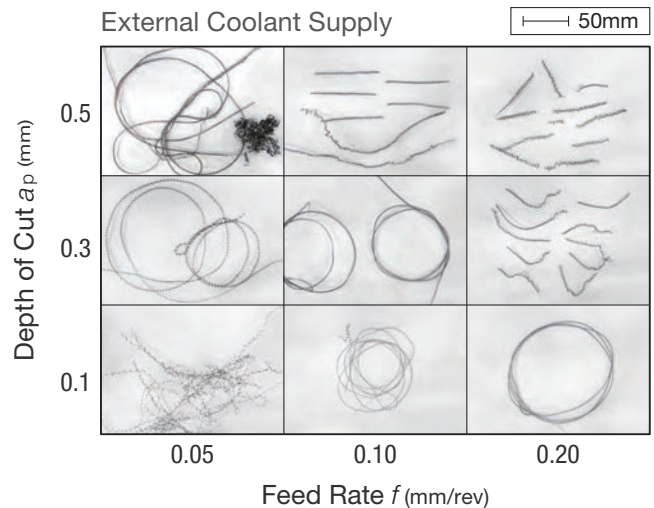
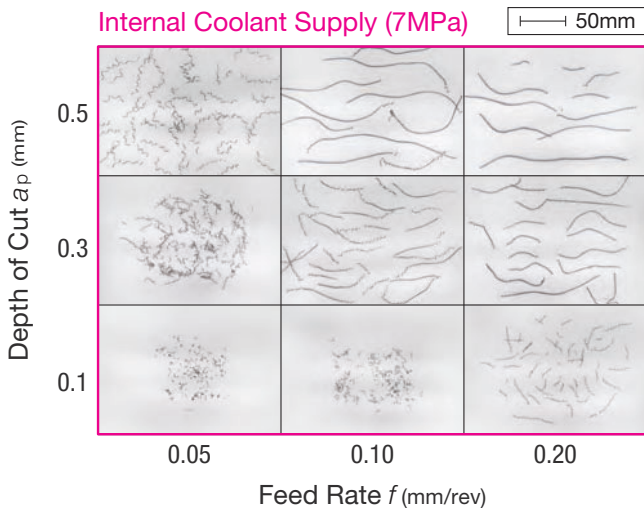


Double Clamp

Work Material: SUS316 Holder: DDJN R2525K15-J Insert: DNMG150408N-FE Cutting Conditions: $v_c=300\text{m/min}^*$ $f=0.1\text{mm/rev}$ $a_p=0.5\text{mm}$ Wet

*Evaluated under high-speed cutting conditions due to acceleration testing.

Chip Control



Work Material: SCM415 Holder: DDJN R2525K15-J Insert: DNMG150408N-FE Cutting Conditions: $v_c=300\text{m/min}$ Wet

Internal Coolant Holders

Parts for Internal Coolant Holder Piping

Fig 1

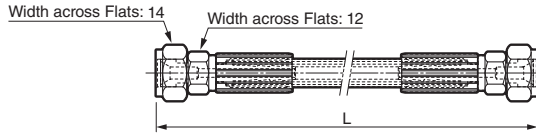


Fig 1

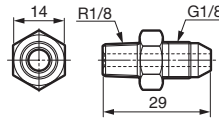
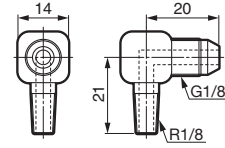


Fig 2



Component (Hose)

Cat. No.	Stock	Dimensions (mm)			Fig
		L	Screw Standard	Screw Standard	
J-HOSE-G1/8-G1/8-200	●	200	G1/8	G1/8	1
J-HOSE-G1/8-G1/8-300	●	300	G1/8	G1/8	1

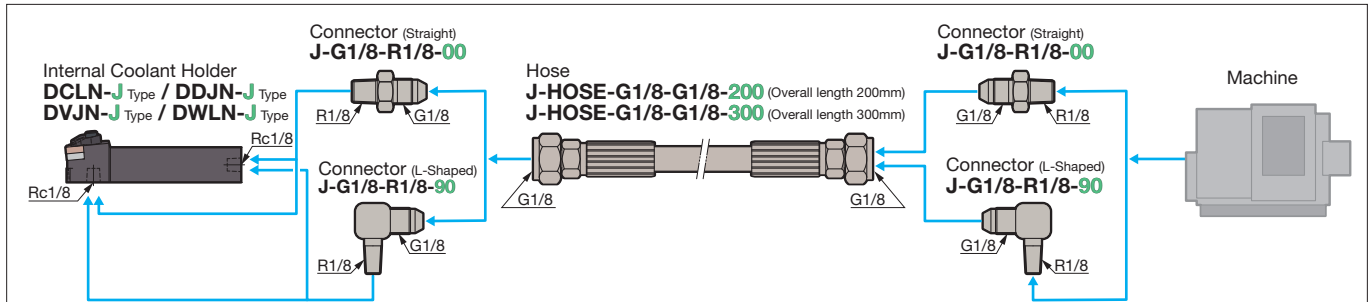
Hoses are sold separately.

Component (Connector)

Cat. No.	Stock	Dimensions (mm)		Fig
		Screw Standard	Screw Standard	
J-G1/8-R1/8-00	●	G1/8	R1/8	1
J-G1/8-R1/8-90	●	G1/8	R1/8	2

Connectors are sold separately.

Piping Method for Hoses and Connectors



- Apply sealant such as commercial sealing tape to the piping connection parts.
- Internal Coolant Holders have a plug (XP02) mounted on the holder back end at shipping. (See Fig 1) When piping from the holder back end, mount a plug (XP02) on the bottom of the holder for use. (See Fig 2)

Fig 1 Piping from bottom (at shipping)

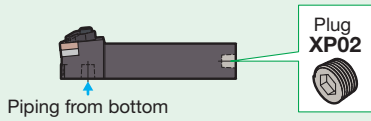
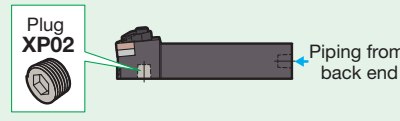


Fig 2 Piping from back end



DCLN Type / DCLN-J Type



SEC-D Type Holder - General Turning, Facing and Profiling
Double Clamp

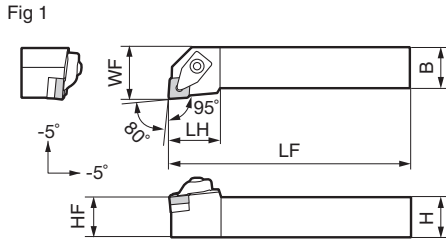
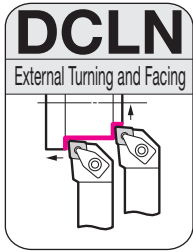


Figure shows right-hand (R) tool.

Holder

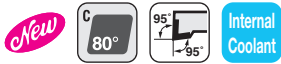
Parts

Dimensions (mm)

Cat. No.	Stock		Height	Width	Overall Length	Cutting Edge	Cutting Edge Height	Head	Applicable Insert		Clamp Set		Shim	Shim Screw	Wrench for Shims	Top Hex Wrench	Bottom Hex Wrench	
	R	L							H	B	LF	WF						HF
DCLN R/L2020K12	●	●	20	20	125	25	20	32	CN□□1204	B22 on	1	SCP-2	5.0	CNS1204	BFTX0409N	TRX15(*)	LH040	LH025
DCLN R/L2525M12	●	●	25	25	150	32	25	32	CN□□1606	B26 on	1	SCP-3	5.0	CNS1606	BFTX0509N	TRX20(*)	LH040	LH025
DCLN R/L2525M16	●	●	25	25	150	32	25	32	CN□□1906	B28 on	1	SCP-5	5.0	CNS1906	BFTX0511N	TRX20(*)	LH040	LH025
DCLN R/L3232P16	●	●	32	32	170	40	32	32	CN□□2509	B30 on	1	SCP-6	6.0	CNS2509	BFTX0615N	TRD25(*)	LH060	—
DCLN R/L3232P19	●	●	32	32	170	40	32	42										
DCLN R/L4040S19	●	●	40	40	250	50	40	42										
DCLN R/L4040S25	●	●	40	40	250	50	40	53										

*Wrench for shim is sold separately from the main body.

Clamp Set Parts **C46**



SEC-D Type Holder - General Turning, Facing and Profiling
Internal Coolant Supply: Double Clamp

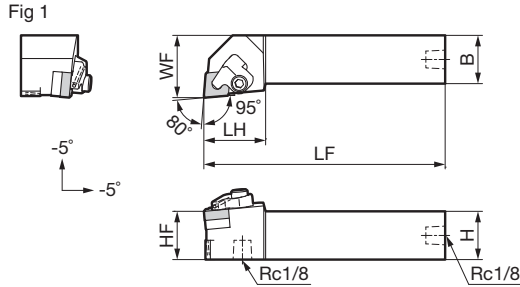
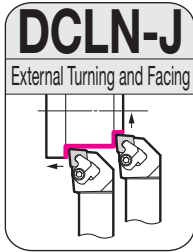


Figure shows right-hand (R) tool.

Holder

Parts

Dimensions (mm)

Cat. No.	Stock		Height	Width	Overall Length	Cutting Edge	Cutting Edge Height	Head	Applicable Insert		Clamp Plate	Cap Screw	Spring	O-ring	Shim	Shim Screw	Wrench for Shims	Top Hex Wrench	Bottom Hex Wrench	Plug		
	R	L							H	B	LF	WF	HF	LH	Cat. No.	Ref. Page	Fig	N-m				
DCLN R/L2020K12-J	●	●	20	20	125	27	20	32	CN□□1204	B22 on	1	JC R/L-01	CP-M5-20-1	5.0	CSP12J	SS060	CNS1204	BFTX0409N	TRX15(*)	LH040	LH025	XP02
DCLN R/L2525K12-J	●	●	25	25	125	32	25	32														

*Wrench for shim is sold separately from the main body.

PCLN Type

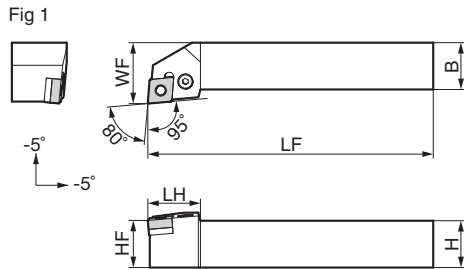
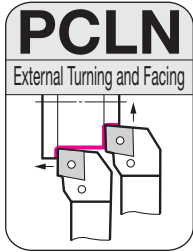
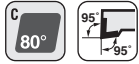


Figure shows right-hand (R) tool.

SEC-70 Type Holder - General Turning, Facing and Profiling
Lever Lock

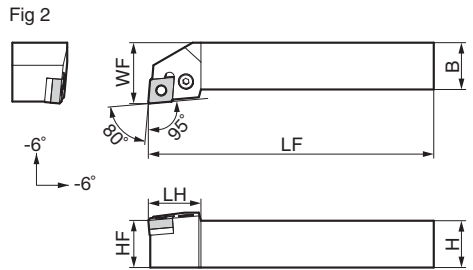


Figure shows right-hand (R) tool.

Holder

Parts

Dimensions (mm)

Cat. No.	Previous Cat. No.	Stock		Height	Width	Overall Length	Cutting Edge	Cutting Edge Height	Head	Applicable Insert		Lever Pin	Bolt	Shim	Shim Retainer	Wrench	
		R	L							Cat. No.	Ref. Page						
PCLN R/L1616H093	PCLN R/L1616-32	●	●	16	16	100	20	16	20	CN□□0903	B20	1	LCL3	LCS3	LSC32	LSP3	LH025
PCLN R/L2020K0904	PCLN R/L2020-33	●	●	20	20	125	25	20	20	CN□□0904	B21	1	LCL3	LCS3	LSC317	LSP3	LH025
PCLN R/L2525M0904	PCLN R/L2525-33	●	●	25	25	150	32	25	20	CN□□1204	B22 on	1	LCL4	LCS4	LSC42	LSP4	LH030
PCLN R/L2020K12	PCLN R/L2020-43	●	●	20	20	125	25	20	28			1					
PCLN R/L2520M12	PCLN R/L2520-43	●	●	25	20	150	25	25	28			1					
PCLN R/L2525M12	PCLN R/L2525-43	●	●	25	25	150	32	25	28			1					
PCLN R/L3225P12	PCLN R/L3225-43	●	●	32	25	170	32	32	28	CN□□1606	B26 on	1	LCL5	LCS5	LSC53	LSP5	LH030
PCLN R/L3232P12	PCLN R/L3232-43	●	●	32	32	170	40	32	28			1					
PCLN R/L2525M16	PCLN R/L2525-54	●	●	25	25	150	32	25	33	CN□□1906	B28 on	1	LCL6	LCS6	LSC63	LSP6	LH040
PCLN R/L3225P16	PCLN R/L3225-54	●	●	32	25	170	32	32	33			1					
PCLN R/L3232P16	PCLN R/L3232-54	●	●	32	32	170	40	32	33	CN□□1906	B28 on	2	LCL6	LCS6	LSC63	LSP6	LH040
PCLN R/L3225P19	PCLN R/L3225-64	●	●	32	25	170	32	32	38			1					
PCLN R/L3232P19	PCLN R/L3232-64	●	●	32	32	170	40	32	38	2							
PCLN R/L4040R19	PCLN R/L4040-64	●	●	40	40	200	50	40	38	2							

External Holders



Neg.

Pos.

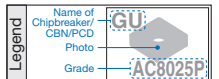


Special

Applicable Inserts ◀ DCLN Type / DCLN-J Type / PCLN Type / PCBN Type / PCFN Type

1st Recommended Insert

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



Cutting Range	P (Steel)			M (Stainless Steel)			K (Cast Iron)			S (Exotic Alloy)			N (Non-ferrous)		H (Hardened Steel)	
	Finishing	Medium Cutting	Roughing	Finishing	Medium Cutting	Roughing	High-speed Finishing	Finishing to Medium Cutting	Medium to Roughing	Finishing	Medium Cutting	Roughing	High-precision/Finishing	Finishing to Medium Cutting	Coated	Uncoated
Continuous Cutting	FE T1500Z	GU AC8015P	MU AC8025P	EF AC6020M	EG AC6020M	EM AC6030M	SUMIBORON BN7000/BNC500	UZ AC4010K	GZ AC4010K	EF AC5015S	EG AC5015S	EM AC5015S	SUMIDIA DA1000	AX H1	SUMIBORON BNC2115	SUMIBORON BN1000
General Cutting	SU AC8015P	GU AC8025P	MU AC8025P	EF AC6030M	EG AC6030M	EM AC6040M	SUMIBORON BN7000/BNC500	GZ AC4015K	GZ AC4015K	EF AC5015S	EG AC5015S	EM AC5025S	SUMIDIA DA1000	AX H1	SUMIBORON BNC2125	SUMIBORON BN2000
Interrupted Cutting	SX AC8025P	UX AC8035P	MX AC8035P	EF AC6030M	EG AC6040M	EM AC6040M	SUMIBORON BN7000/BNC500	GZ AC420K	No Chipbreaker AC420K	EF AC5025S	EG AC5025S	EM AC5025S	SUMIDIA DA1000	-	SUMIBORON BNC300	SUMIBORON BN350
Recommended Cutting Conditions	A10 on			A14 on			A16 on			A18 on			A22 on		A20 on	

BNCS500 is for ductile cast iron.

PCBN Type / PCFN Type



SEC-70 Holder - General Turning and Chamfering Lever Lock

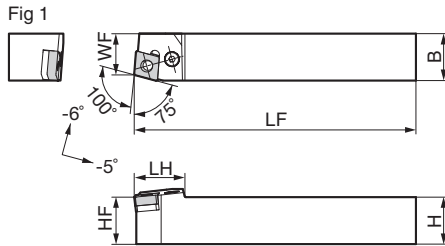
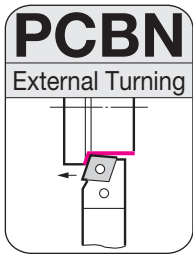


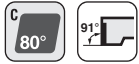
Figure shows right-hand (R) tool.

Holder

Parts

Dimensions (mm)

Cat. No.	Previous Cat. No.	Stock		Height	Width	Overall Length	Cutting Edge	Cutting Edge Height	Head	Applicable Insert		Lever Pin	Bolt	Shim	Shim Retainer	Wrench	
		R	L							Cat. No.	Ref. Page						
PCBN R/L2020K12	PCBN R/L2020-43	●	●	20	20	125	17	20	27	CN□□1204	B22 on	1	LCL4	LCS4	LSC42	LSP4	LH030
PCBN R/L2520M12	PCBN R/L2520-43	●	●	25	20	150	17	25	27								
PCBN R/L2525M12	PCBN R/L2525-43	●	●	25	25	150	22	25	27								
PCBN R/L3225P12	PCBN R/L3225-43			32	25	170	22	32	27	CN□□1606	B26 on	1	LCL5	LCS5	LSC53	LSP5	LH030
PCBN R/L2525M16	PCBN R/L2525-54			25	25	150	22	25	33								
PCBN R/L3225P16	PCBN R/L3225-54			32	25	170	22	32	33								
PCBN R/L3232P16	PCBN R/L3232-54			32	32	170	27	32	33	CN□□1906	B28 on	1	LCL6	LCS6	LSC63	LSP6	LH040
PCBN R/L3232P19	PCBN R/L3232-64			32	32	170	27	32	38								
PCBN R/L4040R19	PCBN R/L4040-64			40	40	200	35	40	38								



SEC-70 Type Holder - General Turning, Facing and Profiling Lever Lock

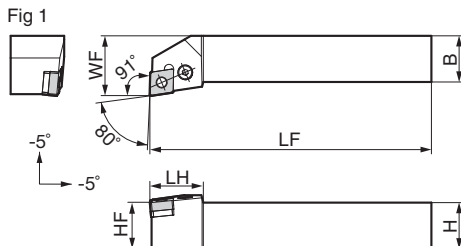
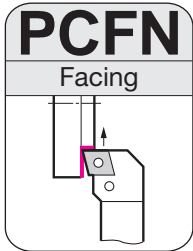


Figure shows right-hand (R) tool.

Holder

Parts

Dimensions (mm)

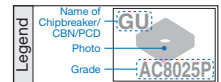
Cat. No.	Previous Cat. No.	Stock		Height	Width	Overall Length	Cutting Edge	Cutting Edge Height	Head	Applicable Insert		Lever Pin	Bolt	Shim	Shim Retainer	Wrench	
		R	L							Cat. No.	Ref. Page						
PCFN R/L2020K12	PCFN R/L2020-43	●	●	20	20	125	25	20	28	CN□□1204	B22 on	1	LCL4	LCS4	LSC42	LSP4	LH030
PCFN R/L2520M12	PCFN R/L2520-43	●	●	25	20	150	25	25	28								
PCFN R/L2525M12	PCFN R/L2525-43	●	●	25	25	150	32	25	28								
PCFN R/L3225P12	PCFN R/L3225-43			32	25	170	32	32	28	CN□□1204	B22 on	1	LCL4	LCS4	LSC42	LSP4	LH030
PCFN R/L2520M12	PCFN R/L2520-43	●	●	25	20	150	25	25	28								
PCFN R/L2525M12	PCFN R/L2525-43	●	●	25	25	150	32	25	28								

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

Applicable Inserts ◀ DCLN Type / DCLN-J Type / PCLN Type / PCBN Type / PCFN Type

1st Recommended Insert

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



Cutting Range	P (Steel)			M (Stainless Steel)			K (Cast Iron)			S (Exotic Alloy)			N (Non-ferrous)		H (Hardened Steel)	
	Finishing	Medium Cutting	Roughing	Finishing	Medium Cutting	Roughing	High-speed Finishing	Finishing to Medium Cutting	Medium to Roughing	Finishing	Medium Cutting	Roughing	High-precision/Finishing	Finishing to Medium Cutting	Coated	Uncoated
Continuous Cutting	FE T1500Z	GU AC8015P	MU AC8025P	EF AC6020M	EG AC6020M	EM AC6030M	SUMIBORON BN7000/BNC500	UZ AC4010K	GZ AC4010K	EF AC5015S	EG AC5015S	EM AC5015S	SUMIDIA DA1000	AX H1	SUMIBORON BNC2115	SUMIBORON BN1000
General Cutting	SU AC8015P	GU AC8025P	MU AC8025P	EF AC6030M	EG AC6030M	EM AC6040M	SUMIBORON BN7000/BNC500	GZ AC4015K	GZ AC4015K	EF AC5015S	EG AC5015S	EM AC5025S	SUMIDIA DA1000	AX H1	SUMIBORON BNC2125	SUMIBORON BN2000
Interrupted Cutting	SX AC8025P	UX AC8035P	MX AC8035P	EF AC6030M	EG AC6040M	EM AC6040M	SUMIBORON BN7000/BNC500	GZ AC420K	No Chipbreaker AC420K	EF AC5025S	EG AC5025S	EM AC5025S	SUMIDIA DA1000	-	SUMIBORON BNC300	SUMIBORON BN350
Recommended Cutting Conditions	A10 on			A14 on			A16 on			A18 on			A22 on		A20 on	

BNC500 is for ductile cast iron.

SCLC Type



SEC-SC Holder - General Turning and Facing
Screw-on

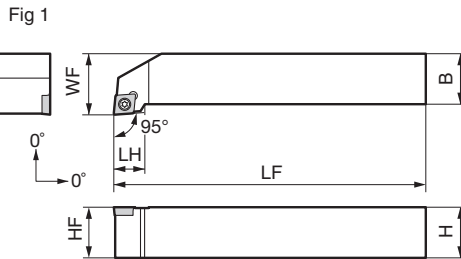


Figure shows right-hand (R) tool.

Holder

Parts

Dimensions (mm)

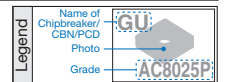
Cat. No.	Previous Cat. No.	Stock		Height	Width	Overall Length	Cutting Edge	Cutting Edge Height	Head	Applicable Insert		Flat Insert Screw		Wrench	
		R	L							H	B	LF	WF		HF
SCLC R/L0808H06	SCLC R/L0808-06	●	●	8	8	100	10	8	—	CC□□0602	B76 on	1	BFTX02506N	1.5	TRX08
SCLC R/L1010H06	SCLC R/L1010-06	●	●	10	10	100	12	10	15			1			
SCLC R/L1212H09	SCLC R/L1212-09	●	●	12	12	100	16	12	15			1			
SCLC R/L1616H09	SCLC R/L1616-09	●	●	16	16	100	20	16	15			1			
SCLC R/L2020K09	SCLC R/L2020-09	●	●	20	20	125	24	20	15			1			
SCLC R/L2525M09	SCLC R/L2525M09	●	●	25	25	150	30	25	15			1			

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

Applicable Inserts ◀ SCLC Type

1st Recommended Insert

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



Cutting Range	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

BN500 is for ductile cast iron.

☞ Recommended Tightening Torque (N·m)

DDJN Type / DDJN-J Type



SEC-D Holder - General Turning and Profiling
Double Clamp

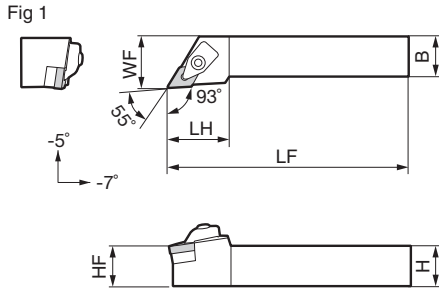
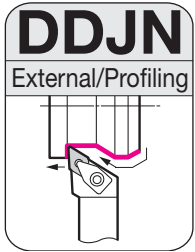


Figure shows right-hand (R) tool.

Holder

Parts

Dimensions (mm)

Cat. No.	Stock		Height	Width	Overall Length	Cutting Edge	Cutting Edge Height	Head	Applicable Insert		Fig	Clamp Set		Shim	Shim Screw	Wrench for Shims	Top Hex Wrench	Bottom Hex Wrench
	R	L							H	B		Cat. No.	Ref. Page					
DDJN R/L2020K15	●	●	20	20	125	25	20	38	DN□□1504	B32 on	1	SCP-2	5.0	DNS1504	BFTX0409N	TRX15(*)	LH040	LH025
DDJN R/L2525M15	●	●	25	25	150	32	25	38	DN□□1504	B32 on	1	SCP-2	5.0	DNS1504	BFTX0409N	TRX15(*)	LH040	LH025
DDJN R/L2525M15E	●	●	25	25	150	32	25	38	DN□□1506	B36 on	1	SCP-2	5.0	DNS1506	BFTX0409N	TRX15(*)	LH040	LH025

*Wrench for shim is sold separately from the main body.

Clamp Set Parts C46



SEC-D Type Holder - General Turning and Profiling
Internal Coolant Supply: Double Clamp

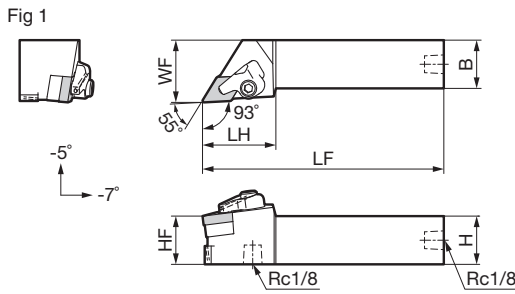
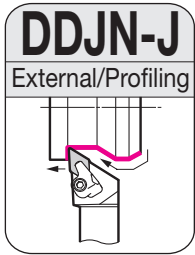


Figure shows right-hand (R) tool.

Holder

Parts

Dimensions (mm)

Cat. No.	Stock		Height	Width	Overall Length	Cutting Edge	Cutting Edge Height	Head	Applicable Insert		Fig	Clamp Plate	Cap Screw	Spring	O-ring	Shim	Shim Screw	Wrench for Shims	Top Hex Wrench	Bottom Hex Wrench	Plug	
	R	L							H	B		Cat. No.	Ref. Page									N-m
DDJN R/L2020K15-J	●	●	20	20	125	26	20	38	DN□□1504	B32 on	1	JD R/L-01	CP-M5-20-1	5.0	CSP12J	SS060	DNS1504	BFTX0409N	TRX15(*)	LH040	LH025	XP02
DDJN R/L2525K15-J	●	●	25	25	125	32	25	38	DN□□1504	B32 on	1	JD R/L-01	CP-M5-20-1	5.0	CSP12J	SS060	DNS1504	BFTX0409N	TRX15(*)	LH040	LH025	XP02
DDJN R/L2525K15E-J	●	●	25	25	125	32	25	38	DN□□1506	B36 on	1	JD R/L-01	CP-M5-20-1	5.0	CSP12J	SS060	DNS1506	BFTX0409N	TRX15(*)	LH040	LH025	XP02

*Wrench for shim is sold separately from the main body.

External Holders

C

Neg.

Pos.

C

D

R

S

T

V

W

Special

DDHN Type / DDNN Type



SEC-D Holder - General Turning and Profiling
Double Clamp

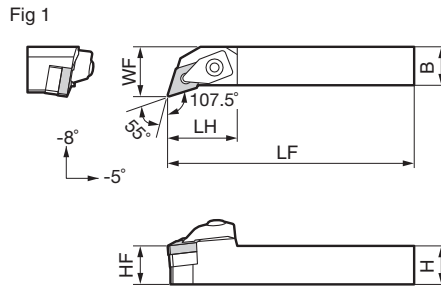
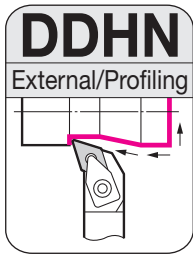


Figure shows right-hand (R) tool.

Holder

Parts

Dimensions (mm)

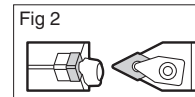
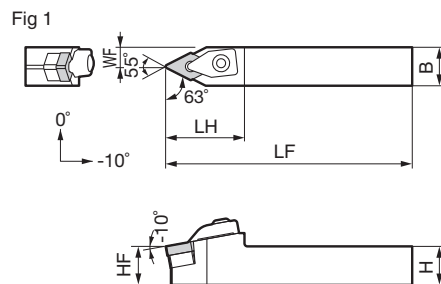
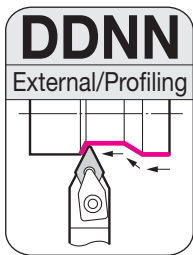
Cat. No.	Stock		Height	Width	Overall Length	Cutting Edge	Cutting Edge Height	Head	Applicable Insert		Fig	Clamp Set		Shim	Shim Screw	Wrench for Shims	Top Hex Wrench	Bottom Hex Wrench
	R	L							H	B		Cat. No.	Ref. Page					
DDHN R/L2020K15	●	●	20	20	125	25	20	35	DN□□1504	B32 on	1	SCP-2	5.0	DNS1504	BFTX0409N	TRX15(*)	LH040	LH025
DDHN R/L2525M15	●	●	25	25	150	32	25	35			1							

*Wrench for shim is sold separately from the main body.

Clamp Set Parts **C46**



SEC-D Holder - General Turning and Profiling
Double Clamp



Holder

Parts

Dimensions (mm)

Cat. No.	Stock		Height	Width	Overall Length	Cutting Edge	Cutting Edge Height	Head	Applicable Insert		Fig	Clamp Set		Shim	Shim Screw	Wrench for Shims	Top Hex Wrench	Bottom Hex Wrench
	H	B							LF	WF		HF	LH					
DDNN N2020K15	●	●	20	20	125	10.5	20	40	DN□□1504	B32 on	1	SCP-2	5.0	DNS1504	BFTX0409N	TRX15(*)	LH040	LH025
DDNN N2525M15	●	●	25	25	150	13.0	25	40			2							

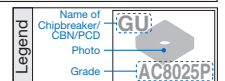
*Wrench for shim is sold separately from the main body.

Clamp Set Parts **C46**

Applicable Inserts ◀ DDJN Type / DDJN-J Type / DDHN Type / DDNN Type / PDJN Type

1st Recommended Insert

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



Cutting Range	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	Medium Cutting	Roughing	High-precision/Finishing	Finishing to Medium Cutting	Coated	Uncoated	Finishing
Continuous Cutting	FE	GU	MU	EF	EG	EM	SUMIBORON	UZ	GZ	EF	EG	EM	SUMIDIA	AX	SUMIBORON	SUMIBORON	SUMIDIA BINDERLESS
	T1500Z	AC8015P	AC8025P	AC6020M	AC6020M	AC6030M	BN7000/BNC500	AC4010K	AC4010K	AC5015S	AC5015S	AC5015S	DA1000	H1	BNC2115	BN1000	NPD10
General Cutting	SU	GU	MU	EF	EG	EM	SUMIBORON	GZ	GZ	EF	EG	EM	SUMIDIA	AX	SUMIBORON	SUMIBORON	SUMIDIA
	AC8015P	AC8025P	AC8025P	AC6030M	AC6030M	AC6040M	BN7000/BNC500	AC4015K	AC4015K	AC5015S	AC5015S	AC5025S	DA1000	H1	BNC2125	BN2000	DA90
Interrupted Cutting	SX	UX	MX	EF	EG	EM	SUMIBORON	GZ	No Chipbreaker	EF	EG	EM	SUMIDIA	—	SUMIBORON	SUMIBORON	—
	AC8025P	AC8035P	AC8035P	AC6030M	AC6040M	AC6040M	BN7000/BNC500	AC420K	AC420K	AC5025S	AC5025S	AC5025S	DA1000	—	BNC300	BN350	—
Recommended Cutting Conditions	A10 on			A14 on			A16 on			A18 on			A22 on		A20 on		M2 on

PDJN Type



SEC-70 Holder - General Turning and Profiling
Lever Lock

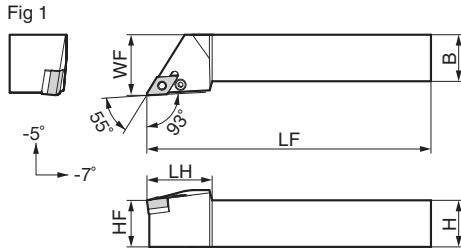
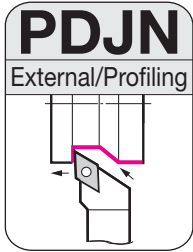


Figure shows right-hand (R) tool.

Holder

Parts

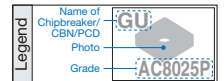
Dimensions (mm)

Cat. No.	Previous Cat. No.	Stock		Height	Width	Overall Length	Cutting Edge	Cutting Edge Height	Head	Applicable Insert		Lever Pin	Bolt	Shim	Shim Retainer	Wrench	
		R	L							Cat. No.	Ref. Page						
PDJN R/L2020K11	PDJN R/L2020-33	●	●	20	20	125	25	20	25	DN□□1104	B31 on	1	LCL3	LCS3	LSD317	LSP3	LH025
PDJN R/L2525M11	PDJN R/L2525-33	●	●	25	25	150	32	25	25			1					
PDJN R/L2020K1504	PDJN R/L2020-43	●	●	20	20	125	25	20	35	DN□□1504	B32 on	1	LCL4	LCS4	LSD42	LSP4	LH030
PDJN R/L2525M1504	PDJN R/L2525-43	●	●	25	25	150	32	25									
PDJN R/L3225P1504	PDJN R/L3225-43	●	●	32	25	170	32	35									
PDJN R/L3232P1504	PDJN R/L3232-43	●	●	32	32	170	40	32									
PDJN R/L2525M1506	PDJN R/L2525-44	●	●	25	25	150	32	25	35	DN□□1506	B36 on	1	LCL4	LCS4	LSD42	LSP4	LH030
PDJN R/L3225P1506	PDJN R/L3225-44	●	●	32	25	170	32	35									
PDJN R/L3232P1506	PDJN R/L3232-44	●	●	32	32	170	40	32									

Applicable Inserts ◀ DDJN Type / DDJN-J Type / DDHN Type / DDNN Type / PDJN Type

1st Recommended Insert

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



Cutting Range	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	Medium Cutting	Roughing	High-precision/Finishing	Finishing to Medium Cutting	Coated	Uncoated	Finishing
Continuous Cutting	FE T1500Z	GU AC8015P	MU AC8025P	EF AC6020M	EG AC6020M	EM AC6030M	SUMIBORON BN7000/BNC500	UZ AC4010K	GZ AC4010K	EF AC5015S	EG AC5015S	EM AC5015S	SUMIDIA DA1000	AX H1	SUMIBORON BNC2115	SUMIBORON BN1000	SUMIDIA BINDERLESS NPD10
General Cutting	SU AC8015P	GU AC8025P	MU AC8025P	EF AC6030M	EG AC6030M	EM AC6040M	SUMIBORON BN7000/BNC500	GZ AC4015K	GZ AC4015K	EF AC5015S	EG AC5015S	EM AC5025S	SUMIDIA DA1000	AX H1	SUMIBORON BNC2125	SUMIBORON BN2000	SUMIDIA DA90
Interrupted Cutting	SX AC8025P	UX AC8035P	MX AC8035P	EF AC6030M	EG AC6040M	EM AC6040M	SUMIBORON BN7000/BNC500	GZ AC420K	No Chipbreaker AC420K	EF AC5025S	EG AC5025S	EM AC5025S	SUMIDIA DA1000	—	SUMIBORON BNC300	SUMIBORON BN350	—
Recommended Cutting Conditions	I A10 on			I A14 on			I A16 on			I A18 on			I A22 on		I A20 on		I M2 on

T-REX Tool Holders



External Profiling
Double Clamp

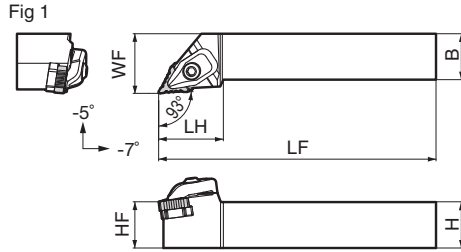


Figure shows right-hand (R) tool.

SumiTurn **T-REX**

Holder

Parts

Dimensions (mm)

Cat. No.	Stock		Height H	Width B	Overall Length LF	Cutting Edge WF	Cutting Edge Height HF	Head LH	Fig	Clamp Plate	Spring	Cap Screw	Shim	Shim Screw	Wrench (For Hex Socket)	Wrench for Shims (For Torx Holes)	
	R	L															
DTR55C R/L2020-K17	●	●	20	20	125	25	20	35	1	TRCP3	S-SP4-20	BX0520	3.5 to 4.5	TRW5505	BFTX0307N	TSW040	TRX10(*)
DTR55C R/L2525-M17	●	●	25	25	150	32	25	35	1	TRCP3	S-SP4-20	BX0520	3.5 to 4.5	TRW5505	BFTX0307N	TSW040	TRX10(*)

*Wrench for shim is sold separately from the main body.
S-DTR55C Type: Internal Profiling **E36**



External Profiling
Double Clamp

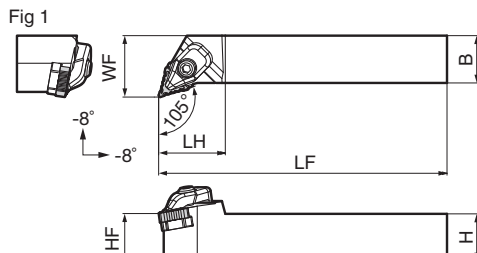


Figure shows right-hand (R) tool.

SumiTurn **T-REX**

Holder

Parts

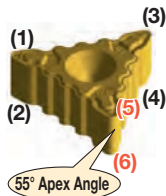
Dimensions (mm)

Cat. No.	Stock		Height H	Width B	Overall Length LF	Cutting Edge WF	Cutting Edge Height HF	Head LH	Fig	Clamp Plate	Spring	Cap Screw	Shim	Shim Screw	Wrench (For Hex Socket)	Wrench for Shims (For Torx Holes)	
	R	L															
DTR55Q R/L2020-K17	●	●	20	20	125	28.5	20	35	1	TRCP3	S-SP4-20	BX0520	3.5 to 4.5	TRW5505	BFTX0307N	TSW040	TRX10(*)
DTR55Q R/L2525-M17	●	●	25	25	150	32.0	25	35	1	TRCP3	S-SP4-20	BX0520	3.5 to 4.5	TRW5505	BFTX0307N	TSW040	TRX10(*)

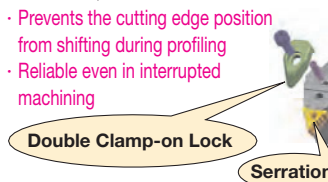
*Wrench for shim is sold separately from the main body.

■ Features

- 55° Included Angle with 6 Cutting Edges
1.5 times more cutting edges compared to DNMG inserts, for greatly reduced machining costs



- Extra-Strong Clamping
Powerful clamping with double clamp-on lock and serrated insert design



- Prevents the cutting edge position from shifting during profiling
- Reliable even in interrupted machining

● T-REX Insert/Tool Holder Identification

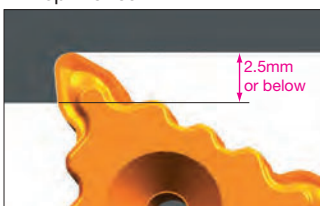
Insert
TRM 55 17 08 -GU
T-REX Apex Insert Size Corner Radius Name of Chipbreaker

External Holder
DTR 55 C R 2525 -M 17
T-REX Holders Apex Angle Feed Direction Shank Length Cutting Edge Angle Shank Size Insert Size

Note: Cutting Edge Angle
C: 93° (95.5° for main cutting edge)
Q: 105° (107.5° for main cutting edge)

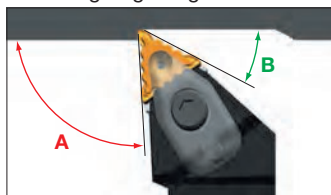
■ Important Notes

- Depth of cut



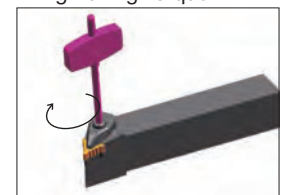
Maximum depth of cut should be 2.5mm.

- Cutting Edge Angle



Holder Cat. No.	A	B	Note
DTR55C Type	93°	27°	Main cutting edge angle is 95.5°
DTR55Q Type	105°	15°	Main cutting edge angle is 107.5°

- Tightening Torque



For the insert clamp, use the included dedicated wrench (TSW040) to tighten at 3.5 to 4.5N·m torque.





Recommended Tightening Torque (N·m)

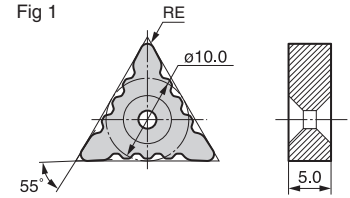
T-REX Tool Holders



Insert (Coated Carbide / Cermet)

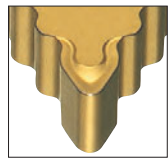
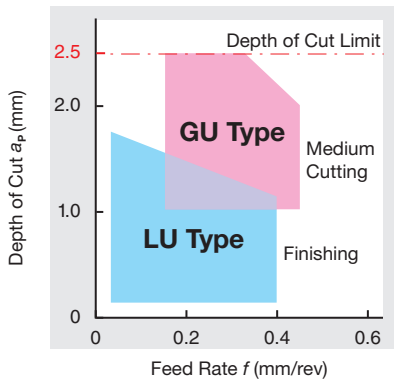
Dimensions (mm)

Applications	Appearance	Cat. No.	Corner Radius RE	AC810P	AC8025P	AC820P	AC830P	AC630M	T3000Z	Fig
Fine Cutting		TRM 551704-FL	0.4		●	●			▲	1
		551708-FL	0.8		●	●			▲	1
Finishing		TRM 551704-LU	0.4	●	●	●	●		▲	1
		551708-LU	0.8	●	●	●	●		▲	1
		551712-LU	1.2	●	●	●	●		▲	1
Medium Cutting		TRM 551704-SU	0.4	●	●	●		●	▲	1
		551708-SU	0.8	●	●	●		●	▲	1
		551712-SU	1.2	●	●	●		●	▲	1
Medium Cutting		TRM 551704-GU	0.4	●	●	●	●	●		1
		551708-GU	0.8	●	●	●	●	●		1
		551712-GU	1.2	●	●	●	●	●		1

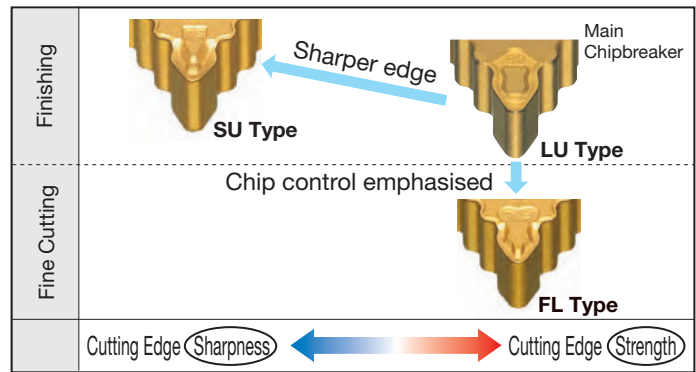


Chipbreaker Application Range

Main Chipbreakers



Finishing Sub-Chipbreakers



Application Range by Grade (Numbers in Table are Recommended Cutting Speed V_c (m/min))

Insert Grade		AC810P	AC8025P	AC820P	AC830P	AC630M	T3000Z
Grade Classification		Coated Carbide	Coated Carbide	Coated Carbide	Coated Carbide	Coated Carbide	Coated Cermet
Work Material	P Low Carbon Steel	200 400	150 350	150 350	120 300	120 300	100 400
	P General Steel/Alloy Steel	150 300	100 250	100 250	80 200	80 230	100 250
	M Stainless Steel				50 150	100 160	
Applications	Finishing	◎	○	○	○	○	◎
	Medium Cutting	○	◎	◎	○	◎	○
	Interrupted Cutting		○	○	◎	○	○

◎ : Ideal, ○ : Suitable

▲ mark: To be replaced by a new product, made to order, or discontinued (please confirm stock availability).

SDJC Type



SEC-SD Profiling Tool Holder - General Turning, Facing and Profiling
Screw-on

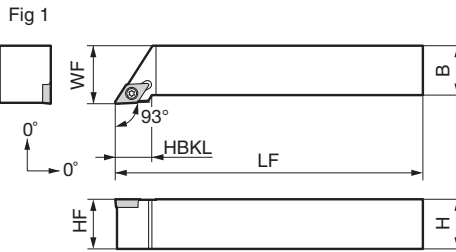
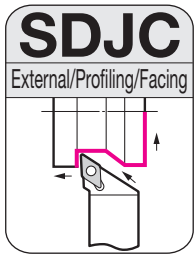


Figure shows right-hand (R) tool.

Holder

Parts

Dimensions (mm)

Cat. No.	Previous Cat. No.	Stock		Height H	Width B	Overall Length LF	Cutting Edge WF	Cutting Edge Height HF	Head HBKL	Applicable Insert		Flat Insert Screw		Wrench	
		R	L							Cat. No.	Ref. Page	Fig	Nm		
SDJC R/L0808H07	SDJC R/L0808-07	●		8	8	100	10	8	15	DC□□0702	B86 on	1	BFTX02506N	1.5	TRX08
SDJC R/L1010H07	SDJC R/L1010-07	●	●	10	10	100	12	10	18						
SDJC R/L1212H11	SDJC R/L1212-11	●	●	12	12	100	16	12	18	DC□□11T3	B90 on	1	BFTX0409N	3.4	TRX15
SDJC R/L1616H11	SDJC R/L1616-11	●	●	16	16	100	20	16	18						
SDJC R/L2020K11	SDJC R/L2020-11	●	●	20	20	125	24	20	18						
SDJC R/L2525M11	SDJC R/L2525M11	●	●	25	25	150	29	25	18						

External Holders



Neg.

Pos.

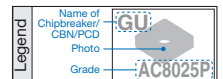


Special

Applicable Inserts ◀ SDJC Type

1st Recommended Insert

- Refer as well to the Insert Selection Guide (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 BINDERLESS NPD10	
Recommended Cutting Conditions	A10 on			A14 on			A16 on			A18 on	A22 on		A20 on			M2 on

BNCS00 is for ductile cast iron.

Recommended Tightening Torque (N·m)

PRGC Type / PRDC Type



SEC-70 Holder - General Turning and Profiling
Lever Lock

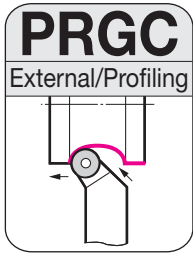


Fig 1

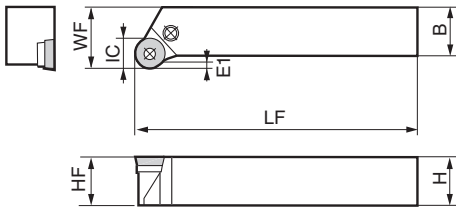


Figure shows right-hand (R) tool.

Holder

Parts

Dimensions (mm)

Cat. No.	Stock		Height H	Width B	Overall Length LF	Cutting Edge WF	Cutting Edge Height HF	Cutting Edge Distance E1	Inscribed Circle IC	Applicable Insert		Lever Pin Fig	Bolt	Shim	Shim Retainer	Wrench (For Hex Socket)	
	R	L								Cat. No.	Ref. Page						
PRGC R/L2020K10	●	●	20	20	125	25	20	1.5	10	RCM□1003M0	B94	1	LCL10	LCS10	LSR10	LSP10	LH020
PRGC R/L2525M10	●	●	25	25	150	32	25	1.5	10								
PRGC R/L2020K12	●	●	20	20	125	25	20	2.5	12	RCM□1204M0	B94	1	LCL12	LCS12	LSR12	LSP10	LH025
PRGC R/L2525M12	●	●	25	25	150	32	25	2.5	12								
PRGC R/L3225P12	●	●	32	25	170	32	32	2.5	12								
PRGC R/L2525M16			25	25	150	32	25	3.0	16	RCM□1606M0	B94	1	LCL16	LCS16	LSR16	LSP16	LH025
PRGC R/L3225P16			32	25	170	32	32	3.0	16								
PRGC R/L3232P20			32	32	170	40	32	4.0	20	RCM□2006M0	B94	1	LCL20	LCS20	LSR20	LSP20	LH030
PRGC R/L4040S25			40	40	250	50	40	4.5	25	RCM□2507M0	B94	1	LCL25	LCS25	LSR25	LSP25	LH040
PRGC R/L5050T32			50	50	300	63	50	5.5	32	RCM□3209M0	B94	1	LCL32	LCS32	LSR32	LSP32	LH050



SEC-70 Holder - General Turning and Profiling
Lever Lock

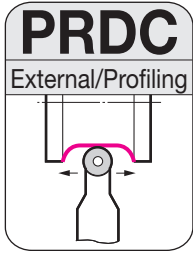
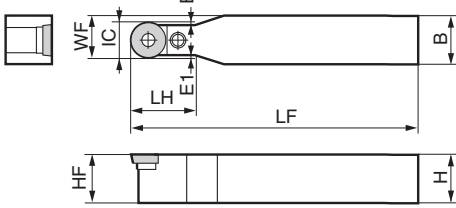


Fig 1



Holder

Parts

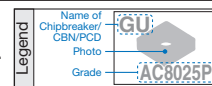
Dimensions (mm)

Cat. No.	Stock	Height H	Width B	Overall Length LF	Cutting Edge WF	Cutting Edge Height HF	Head LH	Cutting Edge Distance E1	Inscribed Circle IC	Applicable Insert		Lever Pin Fig	Bolt	Shim	Shim Retainer	Wrench (For Hex Socket)	
										Cat. No.	Ref. Page						
PRDC N2020M10	●	20	20	150	15.0	20	22	1.0	10	RCM□1003M0	B94	1	LCL10	LCS10	LSR10	LSP10	LH020
PRDC N2525M10	●	25	25	150	17.5	25	22	1.0	10								
PRDC N2525M12	●	25	25	150	18.5	25	24	1.2	12	RCM□1204M0	B94	1	LCL12	LCS12	LSR12	LSP10	LH025
PRDC N3225Q12	●	32	25	180	18.5	32	24	1.2	12								
PRDC N3225Q16	●	32	25	180	20.5	32	28	1.5	16	RCM□1606M0	B94	1	LCL16	LCS16	LSR16	LSP16	LH025
PRDC N3232Q20	●	32	32	180	26.0	32	32	1.7	20	RCM□2006M0	B94	1	LCL20	LCS20	LSR20	LSP20	LH030
PRDC N4040T25		40	40	300	32.5	40	42	2.0	25	RCM□2507M0	B94	1	LCL25	LCS25	LSR25	LSP25	LH040
PRDC N5050U32		50	50	350	41.0	50	52	2.5	32	RCM□3209M0	B94	1	LCL32	LCS32	LSR32	LSP32	LH050

Applicable Inserts ← PRGC Type / PRDC Type

1st Recommended Insert

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



Cutting Range Process	P (Steel)			K (Cast Iron)		S (Exotic Alloy)	
	Finishing	Medium Cutting	Roughing	Finishing to Medium Cutting	Medium to Roughing	Finishing to Medium Cutting	Medium to Roughing
Continuous Cutting	RX AC8015P	RX AC8025P	RX AC8025P	RP AC4010K	RP AC4010K	RP AC5015S	RP AC5015S
General Cutting	RX AC8025P	RH AC8025P	RH AC8035P	RP AC4015K	RP AC4015K	RP AC5015S	RP AC5015S
Interrupted Cutting	RH AC8025P	RH AC8035P	RP AC8035P	RP AC420K	RP AC420K	RP AC5025S	RP AC5025S
Recommended Cutting Conditions	A10 on			A16 on		A18 on	

DSBN Type / DSDN Type



SEC-D Holder - General Turning and Profiling
Double Clamp

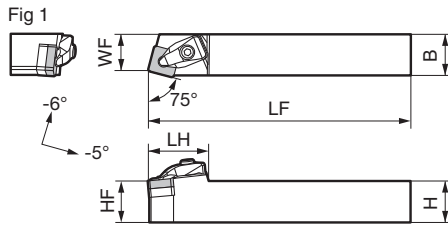
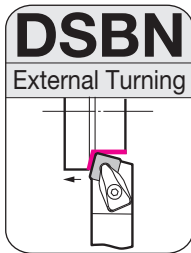


Figure shows right-hand (R) tool.

Holder

Parts

Dimensions (mm)

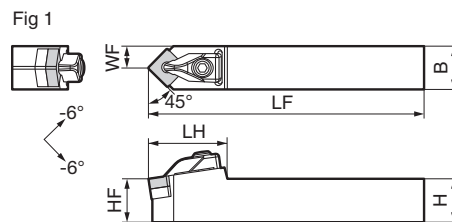
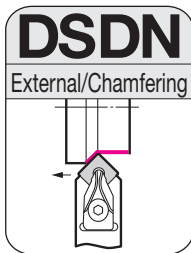
Cat. No.	Stock		Height	Width	Overall Length	Cutting Edge	Cutting Edge Height	Head	Applicable Insert		Fig	Clamp Set		Shim	Shim Screw	Wrench for Shims	Top Hex Wrench	Bottom Hex Wrench
	R	L							H	B		Cat. No.	Ref. Page					
DSBN R/L2020K12	●	●	20	20	125	17	20	36	SN□□1204	B41 on	1	SCP-2	5.0	SNS1204	BFTX0409N	TRX15(*)	LH040	LH025
DSBN R/L2525M12	●	●	25	25	150	22	25	36										
DSBN R/L2525M15	●	●	25	25	150	22	25	36	SN□□1506	B45 on	1	SCP-3	5.0	SNS1506	BFTX0509N	TRX20(*)	LH040	LH025
DSBN R/L3232P15	●	●	32	32	170	27	32	36										
DSBN R/L3232P19	●	●	32	32	170	27	32	45	SN□□1906	B47 on	1	SCP-5	5.0	SNS1906	BFTX0511N	TRX20(*)	LH040	LH025
DSBN R/L4040S19	●	●	40	40	250	35	40	45										
DSBN R/L4040S2507	●	●	40	40	250	35	40	58	SN□□2507	B49	1	SCP-6	6.0	SNS2507	BFTX0615N	TRD25(*)	LH060	—
DSBN R/L4040S2509	●	●	40	40	250	35	40	58	SN□□2509	B50	1	SCP-6	6.0	SNS2509	BFTX0615N	TRD25(*)	LH060	—

*Wrench for shim is sold separately from the main body.

Clamp Set Parts C46



SEC-D Holder - General Turning and Chamfering
Double Clamp



Holder

Parts

Dimensions (mm)

Cat. No.	Stock	Height	Width	Overall Length	Cutting Edge	Cutting Edge Height	Head	Applicable Insert		Fig	Clamp Set		Shim	Shim Screw	Wrench for Shims	Top Hex Wrench	Bottom Hex Wrench
								H	B		Cat. No.	Ref. Page					
DSDN N2020K12	●	20	20	125	10.0	20	36	SN□□1204	B41 on	1	SCP-2	5.0	SNS1204	BFTX0409N	TRX15(*)	LH040	LH025
DSDN N2525M12	●	25	25	150	12.5	25	36										

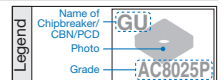
*Wrench for shim is sold separately from the main body.

Clamp Set Parts C46

Applicable Inserts ◀ DSDN Type / DSDN Type / DSSN Type / PSBN Type / PSDN Type / PSSN Type / PSKN Type / ESDN Type / ESDN Type / ESSN Type / ESKN Type

1st Recommended Insert

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



Cutting Range	P (Steel)			M (Stainless Steel)			K (Cast Iron)			S (Exotic Alloy)			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	Medium Cutting	Roughing	Coated	Uncoated	Finishing
Continuous Cutting	FE T1500Z	GU AC8015P	MU AC8025P	EF AC6020M	EG AC6020M	EM AC6030M	SUMIBORON BN7000/BNC500	UZ AC4010K	GZ AC4010K	EF AC5015S	EG AC5015S	EM AC5015S	SUMIBORON BNC2115	SUMIBORON BN1000	SUMIDIA BINDERLESS NPD10
General Cutting	SU AC8015P	GU AC8025P	MU AC8025P	EF AC6030M	EG AC6030M	EM AC6040M	SUMIBORON BN7000/BNC500	GZ AC4015K	GZ AC4015K	EF AC5015S	EG AC5015S	EM AC5025S	SUMIBORON BNC2125	SUMIBORON BN2000	SUMIDIA DA90
Interrupted Cutting	SX AC8025P	UX AC8035P	MX AC8035P	EF AC6030M	EG AC6040M	EM AC6040M	SUMIBORON BN7000/BNC500	GZ AC420K	GZ AC420K	EF AC5025S	EG AC5025S	EM AC5025S	SUMIBORON BNC2125	SUMIBORON BN350	—
Recommended Cutting Conditions	A10 on			A14 on			A16 on			A18 on			A20 on		M2 on

BNC500 is for ductile cast iron.

Recommended Tightening Torque (N·m)

DSSN Type / PSBN Type

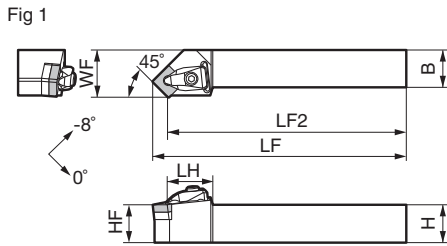


Figure shows right-hand (R) tool.

SEC-D Holder - General Turning, Facing and Chamfering Double Clamp

Holder

Parts

Dimensions (mm)

Cat. No.	Stock		Height H	Width B	Overall Length LF	Overall Length 2 LF2	Cutting Edge WF	Cutting Edge Height HF	Head LH	Applicable Insert		Fig	Clamp Set		Shim	Shim Screw	Wrench for Shims TRX (For Torx Holes)	Top Hex Wrench (For Hex Socket)	Bottom Hex Wrench (For Hex Socket)
	R	L								Cat. No.	Ref. Page		Nm	Nm					
DSSN R/L2020K12	●	●	20	20	133.3	125	25	20	30	SN□□1204	B41 on	1	SCP-2	5.0	SNS1204	BFTX0409N	TRX15(*)	LH040	LH025
DSSN R/L2525M12	●	●	25	25	158.3	150	32	25	30	SN□□1204	B41 on	1	SCP-2	5.0	SNS1204	BFTX0409N	TRX15(*)	LH040	LH025
DSSN R/L2525M15	●	●	25	25	160.2	150	32	25	30	SN□□1506	B45 on	1	SCP-3	5.0	SNS1506	BFTX0509N	TRX20(*)	LH040	LH025
DSSN R/L3232P15	●	●	32	32	180.2	170	40	32	30	SN□□1506	B45 on	1	SCP-3	5.0	SNS1506	BFTX0509N	TRX20(*)	LH040	LH025
DSSN R/L3232P19	●	●	32	32	182.5	170	40	32	36	SN□□1906	B47 on	1	SCP-5	5.0	SNS1906	BFTX0511N	TRX20(*)	LH040	LH025
DSSN R/L4040S19	●	●	40	40	262.5	250	50	40	36	SN□□1906	B47 on	1	SCP-5	5.0	SNS1906	BFTX0511N	TRX20(*)	LH040	LH025
DSSN R/L4040S2507	●	●	40	40	266.0	250	50	40	47	SN□□2507	B49	1	SCP-6	6.0	SNS2507	BFTX0615N	TRD25(*)	LH060	—
DSSN R/L4040S2509	●	●	40	40	266.0	250	50	40	47	SN□□2509	B50	1	SCP-6	6.0	SNS2509	BFTX0615N	TRD25(*)	LH060	—

*Wrench for shim is sold separately from the main body.

Clamp Set Parts **IC C46**

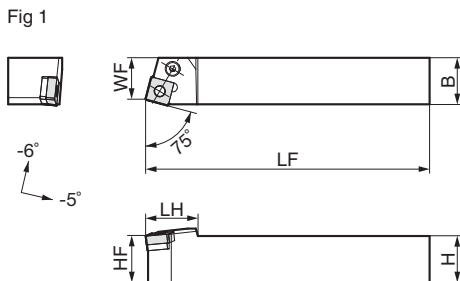
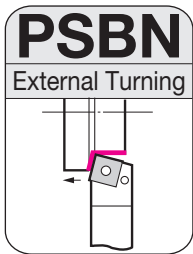


Figure shows right-hand (R) tool.

SEC-70 Holder - General Turning and Profiling Lever Lock

Holder

Parts

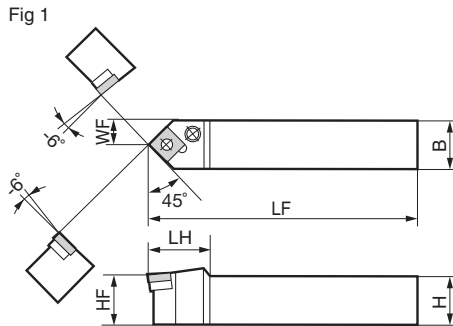
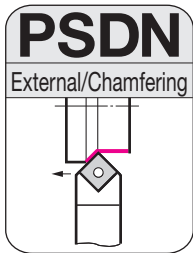
Dimensions (mm)

Cat. No.	Previous Cat. No.	Stock		Height H	Width B	Overall Length LF	Cutting Edge WF	Cutting Edge Height HF	Head LH	Applicable Insert		Fig	Lever Pin	Bolt	Shim	Shim Retainer	Wrench (For Hex Socket)
		R	L							Cat. No.	Ref. Page						
PSBN R/L1616H09	PSBN R/L1616-32	●	●	16	16	100	13	16	22	SN□□0903	B40	1	LCL3	LCS3	LSS32	LSP3	LH025
PSBN R/L2020K12	PSBN R/L2020-43	●	●	20	20	125	17	20	28	SN□□0903	B40	1	LCL3	LCS3	LSS32	LSP3	LH025
PSBN R/L2520M12	PSBN R/L2520-43	●	●	25	25	150	17	25	28	SN□□1204	B41 on	1	LCL4	LCS4	LSS42	LSP4	LH030
PSBN R/L2525M12	PSBN R/L2525-43	●	●	25	25	150	22	25	28	SN□□1204	B41 on	1	LCL4	LCS4	LSS42	LSP4	LH030
PSBN R/L3225P12	PSBN R/L3225-43	●	●	32	32	170	22	32	28	SN□□1204	B41 on	1	LCL4	LCS4	LSS42	LSP4	LH030
PSBN R/L3232P12	PSBN R/L3232-43	●	●	32	32	170	27	32	35	SN□□1204	B41 on	1	LCL4	LCS4	LSS42	LSP4	LH030
PSBN R/L3225P15	PSBN R/L3225-54	●	●	32	32	170	22	32	35	SN□□1506	B45 on	1	LCL5	LCS5	LSS53	LSP5	LH030
PSBN R/L3232P15	PSBN R/L3232-54	●	●	32	32	170	27	32	35	SN□□1506	B45 on	1	LCL5	LCS5	LSS53	LSP5	LH030
PSBN R/L3232P19	PSBN R/L3232-64	●	●	32	32	170	27	32	40	SN□□1906	B47 on	1	LCL6	LCS6	LSS63	LSP6	LH040
PSBN R/L4040R19	PSBN R/L4040-64	●	●	40	40	200	35	40	40	SN□□1906	B47 on	1	LCL6	LCS6	LSS63	LSP6	LH040
PSBN R/L5050S25	PSBN R/L5050-85	●	●	50	50	250	43	50	50	SN□□2507	B49	1	LCL8	LCS8	LSS84	LSP8	LH050

PSDN Type



SEC-70 Holder - General Turning and Chamfering
Lever Lock



Holder

Parts

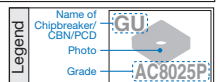
Dimensions (mm)

Cat. No.	Previous Cat. No.	Stock	Height		Overall Length	Cutting Edge	Cutting Edge Height	Head	Applicable Insert		Fig	Lever Pin	Bolt	Shim	Shim Retainer	Wrench
			H	B					Cat. No.	Ref. Page						
PSDN N1616H09	PSDN N1616-32	●	16	16	100	8.0	16	22	SN□□0903	B40	1	LCL3	LCS3	LSS32	LSP3	LH025
PSDN N2020K12	PSDN N2020-43	●	20	20	125	10.0	20	30	SN□□1204	B41 on	1	LCL4	LCS4	LSS42	LSP4	LH030
PSDN N2520M12	PSDN N2520-43	●	25	25	150	10.0	25	30			1					
PSDN N2525M12	PSDN N2525-43	●	25	25	150	12.5	25	30			1					
PSDN N3225P12	PSDN N3225-43	●	32	25	170	12.5	32	30	SN□□1506	B45 on	1	LCL5	LCS5	LSS53	LSP5	LH030
PSDN N3232P12	PSDN N3232-43	●	32	32	170	16.0	32	40			1					
PSDN N3225P15	PSDN N3225-54	●	32	25	170	12.5	32	40	SN□□1906	B47 on	1	LCL6	LCS6	LSS63	LSP6	LH040
PSDN N3232P15	PSDN N3232-54	●	32	32	170	16.0	32	40			1					
PSDN N3232P19	PSDN N3232-64	●	32	32	170	16.0	32	40								
PSDN N4040R19	PSDN N4040-64	●	40	40	200	20.0	40	40								

Applicable Inserts ◀ DSBN Type / DSDN Type / DSSN Type / PSBN Type / PSDN Type / PSSN Type / PSKN Type / ESBN Type / ESDN Type / ESSN Type / ESKN Type

1st Recommended Insert

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



Cutting Range	P (Steel)			M (Stainless Steel)			K (Cast Iron)			S (Exotic Alloy)			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	Medium Cutting	Roughing	Coated	Uncoated	Finishing
Continuous Cutting	FE T1500Z	GU AC8015P	MU AC8025P	EF AC6020M	EG AC6020M	EM AC6030M	SUMIBORON BN7000/BNC500	UZ AC4010K	GZ AC4010K	EF AC5015S	EG AC5015S	EM AC5015S	SUMIBORON BNC2115	SUMIBORON BN1000	SUMIDIA BINDERLESS NPD10
General Cutting	SU AC8015P	GU AC8025P	MU AC8025P	EF AC6030M	EG AC6030M	EM AC6040M	SUMIBORON BN7000/BNC500	GZ AC4015K	GZ AC4015K	EF AC5015S	EG AC5015S	EM AC5025S	SUMIBORON BNC2125	SUMIBORON BN2000	SUMIDIA DA90
Interrupted Cutting	SX AC8025P	UX AC8035P	MX AC8035P	EF AC6030M	EG AC6040M	EM AC6040M	SUMIBORON BN7000/BNC500	GZ AC420K	No Chipbreaker AC420K	EF AC5025S	EG AC5025S	EM AC5025S	SUMIBORON BNC2125	SUMIBORON BN350	-
Recommended Cutting Conditions	A10 on			A14 on			A16 on			A18 on			A20 on		M2 on

BNC500 is for ductile cast iron.

External Holders



Neg.

Pos.



Special

PSSN Type / PSKN Type



Fig 1

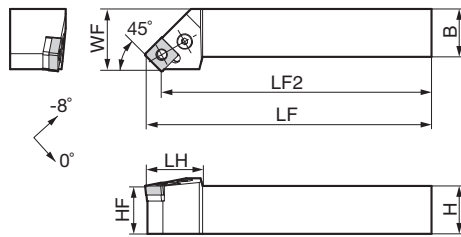


Figure shows right-hand (R) tool.

SEC-70 Holder - General Turning, Facing and Chamfering
Lever Lock

Holder

Parts

Dimensions (mm)

Cat. No.	Previous Cat. No.	Stock		Height	Width	Overall Length	Overall Length 2	Cutting Edge	Cutting Edge Height	Head	Applicable Insert		Lever Pin	Bolt	Shim	Shim Retainer	Wrench	
		R	L								Cat. No.	Ref. Page						
PSSN R/L1616H09	PSSN R/L1616-32	●	●	16	16	100	93.8	20	16	22	SN□□0903	B40	1	LCL3	LCS3	LSS32	LSP3	LH025
PSSN R/L2020K12	PSSN R/L2020-43	●	●	20	20	125	116.7	25	20	30	SN□□1204	B41 on	1	LCL4	LCS4	LSS42	LSP4	LH030
PSSN R/L2520M12	PSSN R/L2520-43			25	20	150	141.7	25	25	30			1					
PSSN R/L2525M12	PSSN R/L2525-43	●	●	25	25	150	141.7	32	25	30			1					
PSSN R/L3225P12	PSSN R/L3225-43			32	25	170	161.7	32	32	30			1					
PSSN R/L3232P12	PSSN R/L3232-43			32	32	170	161.7	40	32	30								
PSSN R/L3225P15	PSSN R/L3225-54			32	25	170	159.8	32	32	40	SN□□1506	B45 on	1	LCL5	LCS5	LSS53	LSP5	LH030
PSSN R/L3232P15	PSSN R/L3232-54	●	●	32	32	170	159.8	40	32	40			1					
PSSN R/L3232P19	PSSN R/L3232-64	●	●	32	32	170	157.5	40	32	40	SN□□1906	B47 on	1	LCL6	LCS6	LSS63	LSP6	LH040
PSSN R/L4040R19	PSSN R/L4040-64			40	40	200	187.5	50	40	40			1					

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

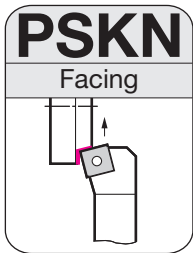
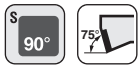


Fig 1

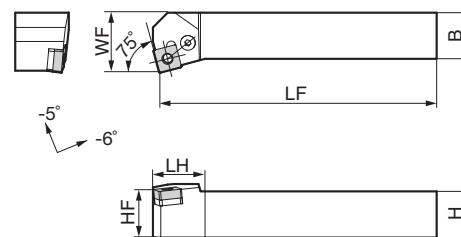


Figure shows right-hand (R) tool.

SEC-70 Type Holder - Facing
Lever Lock

Holder

Parts

Dimensions (mm)

Cat. No.	Previous Cat. No.	Stock		Height	Width	Overall Length	Cutting Edge	Cutting Edge Height	Head	Applicable Insert		Lever Pin	Bolt	Shim	Shim Retainer	Wrench	
		R	L							Cat. No.	Ref. Page						
PSKN R/L1616H09	PSKN R/L1616-32	●	●	16	16	100	20	16	20	SN□□0903	B40	1	LCL3	LCS3	LSS32	LSP3	LH025
PSKN R/L2020K12	PSKN R/L2020-43	●	●	20	20	125	25	20	26	SN□□1204	B41 on	1	LCL4	LCS4	LSS42	LSP4	LH030
PSKN R/L2520M12	PSKN R/L2520-43			25	20	150	25	25	26			1					
PSKN R/L2525M12	PSKN R/L2525-43	●	●	25	25	150	32	25	26			1					
PSKN R/L3225P12	PSKN R/L3225-43			32	25	170	32	32	26			1					
PSKN R/L3232P12	PSKN R/L3232-43			32	32	170	32	32	26								
PSKN R/L3225P15	PSKN R/L3225-54			32	25	170	32	32	32	SN□□1506	B45 on	1	LCL5	LCS5	LSS53	LSP5	LH030
PSKN R/L3232P15	PSKN R/L3232-54			32	32	170	32	32	32			1					
PSKN R/L3232P19	PSKN R/L3232-64	●	●	32	32	170	40	32	36	SN□□1906	B47 on	1	LCL6	LCS6	LSS63	LSP6	LH040
PSKN R/L4040R19	PSKN R/L4040-64			40	40	200	50	40	36			1					
PSKN R/L5050S25	PSKN R/L5050-85			50	50	250	60	50	50	SN□□2507	B49	1	LCL8	LCS8	LSS84	LSP8	LH050

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

External Holders



Neg.

Pos.



Special

ESBN Type / ESDN Type



SEC-30 Holder - General Turning
Pin Lock

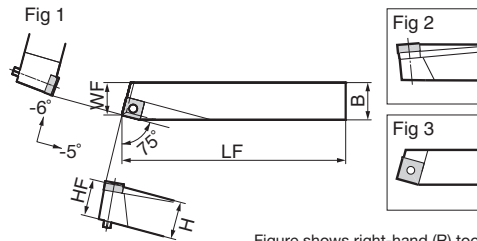


Figure shows right-hand (R) tool.

Holder

Parts

Dimensions (mm)

Cat. No.	Previous Cat. No.	Stock		Height H	Width B	Overall Length LF	Cutting Edge WF	Cutting Edge Height HF	Applicable Insert		Eccentric Pin Fig	Shim	Wrench	
		R	L						Cat. No.	Ref. Page				
ESBN R/L1212F09	ESBN R/L1212	●	●	12	12	80	9.5	11.5	SN□□0903	B40	1	P321US	—	KY40
ESBN R/L1616H09	ESBN R/L1616H32			16	16	100	13.0	15.5			1	P322US	—	
ESBN R/L1616H12	ESBN R/L1616H43			16	16	100	13.0	15.5	SN□□1204	B41 on	3	P432U	—	KY40
ESBN R/L2020K12	ESBN R/L2020			20	20	125	17.0	19.5			1	P433U	—	
ESBN R/L2020K12W	ESBN R/L2020W	●	●	20	20	125	17.0	19.5			2	P433W	ESS42	
ESBN R/L2520M12	ESBN R/L2520			25	20	150	17.0	24.5			3	P434U	—	
ESBN R/L2520M12W	ESBN R/L2520W			25	20	150	17.0	24.5			2	P434W	ESS42	
ESBN R/L2525M12	ESBN R/L2525			25	25	150	22.0	24.5			1	P434U	—	
ESBN R/L2525M12W	ESBN R/L2525W	●	●	25	25	150	22.0	24.5	2	P434W	ESS42			



SEC-30 Holder - General Turning and Chamfering
Pin Lock

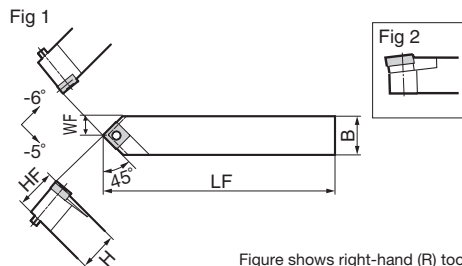
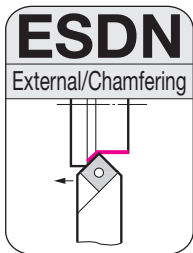


Figure shows right-hand (R) tool.

Holder

Parts

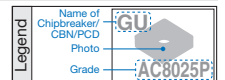
Dimensions (mm)

Cat. No.	Previous Cat. No.	Stock		Height H	Width B	Overall Length LF	Cutting Edge WF	Cutting Edge Height HF	Applicable Insert		Eccentric Pin Fig	Shim	Wrench	
		R	L						Cat. No.	Ref. Page				
ESDN R/L1212F09	ESDN R/L1212	●	●	12	12	80	6.0	11.5	SN□□0903	B40	1	P321US	—	KY40
ESDN R/L1616H09	ESDN R/L1616H32	●	●	16	16	100	8.0	15.5			1	P322US	—	
ESDN R/L2020K12	ESDN R/L2020			20	20	125	10.0	19.5	SN□□1204	B41 on	1	P433U	—	KY40
ESDN R/L2020K12W	ESDN R/L2020W	●	●	20	20	125	10.0	19.5			2	P433W	ESS42	
ESDN R/L2520M12	ESDN R/L2520			25	20	150	10.0	24.5			1	P434U	—	
ESDN R/L2520M12W	ESDN R/L2520W			25	20	150	10.0	24.5			2	P434W	ESS42	
ESDN R/L2525M12	ESDN R/L2525			25	25	150	12.5	24.5			1	P434U	—	
ESDN R/L2525M12W	ESDN R/L2525W	●	●	25	25	150	12.5	24.5			2	P434W	ESS42	

Applicable Inserts ◀ DSDN Type / DSDN Type / DSSN Type / PSBN Type / PSDN Type / PSSN Type / PSKN Type / ESDN Type / ESDN Type / ESSN Type / ESKN Type

1st Recommended Inserts

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



Cutting Range	P (Steel)			M (Stainless Steel)			K (Cast Iron)			S (Exotic Alloy)			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	Medium Cutting	Roughing	Coated	Uncoated	Finishing
Continuous Cutting	FE T1500Z	GU AC8015P	MU AC8025P	EF AC6020M	EG AC6020M	EM AC6030M	SUMIBORON BN7000/BNC500	UZ AC4010K	GZ AC4010K	EF AC5015S	EG AC5015S	EM AC5015S	SUMIBORON BNC2115	SUMIBORON BN1000	SUMIDIA BINDERLESS NPD10
General Cutting	SU AC8015P	GU AC8025P	MU AC8025P	EF AC6030M	EG AC6030M	EM AC6040M	SUMIBORON BN7000/BNC500	GZ AC4015K	GZ AC4015K	EF AC5015S	EG AC5015S	EM AC5025S	SUMIBORON BNC2125	SUMIBORON BN2000	SUMIDIA DA90
Interrupted Cutting	SX AC8025P	UX AC8035P	MX AC8035P	EF AC6030M	EG AC6040M	EM AC6040M	SUMIBORON BN7000/BNC500	GZ AC420K	No Chipbreaker AC420K	EF AC5025S	EG AC5025S	EM AC5025S	SUMIBORON BNC2125	SUMIBORON BN350	—
Recommended Cutting Conditions	A10 on			A14 on			A16 on			A18 on			A20 on		M2 on

BNC500 is for ductile cast iron.

External Holders



Neg.

Pos.



Special

ESSN Type / ESKN Type



SEC-30 Holder - General Turning, Facing and Chamfering
Pin Lock

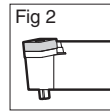
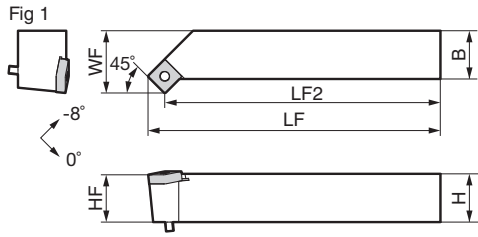


Figure shows right-hand (R) tool.

Holder

Parts

Dimensions (mm)

Cat. No.	Previous Cat. No.	Stock		Height H	Width B	Overall Length LF	Overall Length 2 LF2	Cutting Edge WF	Cutting Edge Height HF	Applicable Insert		Eccentric Pin	Shim	Wrench	
		R	L							Cat. No.	Ref. Page				
ESSN R/L1212F09	ESSN R/L1212	●	●	12	12	80	73.8	16	11.5	SN□□0903	B40	1	P321US	—	KY40
ESSN R/L1616H09	ESSN R/L1616H32	●	●	16	16	100	93.8	20	15.5						
ESSN R/L1616H12	ESSN R/L1616H43			16	16	100	91.7	20	15.5	SN□□1204	B41 on	1	P432U	—	KY40
ESSN R/L2020K12	ESSN R/L2020	●	●	20	20	125	116.7	25	19.5			1	P433U	—	
ESSN R/L2020K12W	ESSN R/L2020W	●	●	20	20	125	116.7	25	19.5			2	P433W	ESS42	
ESSN R/L2520M12	ESSN R/L2520			25	20	150	141.7	25	24.5			1	P434U	—	
ESSN R/L2520M12W	ESSN R/L2520W			25	20	150	141.7	25	24.5			2	P434W	ESS42	
ESSN R/L2525M12	ESSN R/L2525			25	25	150	141.7	32	24.5			1	P434U	—	
ESSN R/L2525M12W	ESSN R/L2525W	●	●	25	25	150	141.7	32	24.5			2	P434W	ESS42	

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



SEC-30 Type Holder - Facing
Pin Lock

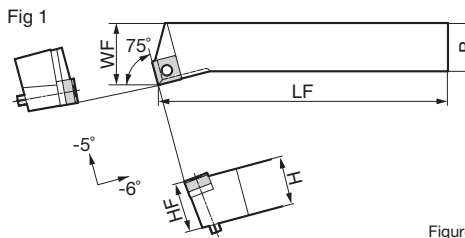


Figure shows right-hand (R) tool.

Holder

Parts

Dimensions (mm)

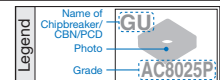
Cat. No.	Previous Cat. No.	Stock		Height H	Width B	Overall Length LF	Cutting Edge WF	Cutting Edge Height HF	Applicable Insert		Eccentric Pin	Shim	Wrench	
		R	L						Cat. No.	Ref. Page				
ESKN R/L1212F09	ESKN R/L1212	●	●	12	12	80	16	11.5	SN□□0903	B40	1	P321US	—	KY40
ESKN R/L1616H09	ESKN R/L1616H32	●	●	16	16	100	20	15.5						
ESKN R/L1616H12	ESKN R/L1616H43			16	16	100	20	15.5	SN□□1204	B41 on	1	P432U	—	KY40
ESKN R/L2020K12	ESKN R/L2020			20	20	125	25	19.5			1	P433U	—	
ESKN R/L2020K12W	ESKN R/L2020W	●	●	20	20	125	25	19.5			2	P433W	ESS42	
ESKN R/L2520M12	ESKN R/L2520			25	20	150	25	24.5			1	P434U	—	
ESKN R/L2520M12W	ESKN R/L2520W			25	20	150	25	24.5			2	P434W	ESS42	
ESKN R/L2525M12	ESKN R/L2525			25	25	150	32	24.5			1	P434U	—	
ESKN R/L2525M12W	ESKN R/L2525W	●	●	25	25	150	32	24.5			2	P434W	ESS42	

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

Applicable Inserts ◀ DSBN Type / DSDN Type / DSSN Type / PSBN Type / PSDN Type / PSSN Type / PSKN Type / ESBN Type / ESDN Type / ESSN Type / ESKN Type

1st Recommended Insert

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



Cutting Range	P (Steel)			M (Stainless Steel)			K (Cast Iron)			S (Exotic Alloy)			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	Medium Cutting	Roughing	Coated	Uncoated	
Continuous Cutting	FE T1500Z	GU AC8015P	MU AC8025P	EF AC6020M	EG AC6020M	EM AC6030M	SUMIBORON BN7000/BNC500	UZ AC4010K	GZ AC4010K	EF AC5015S	EG AC5015S	EM AC5015S	SUMIBORON BNC2115	SUMIBORON BN1000	SUMIDIA BINDERLESS NPD10
General Cutting	SU AC8015P	GU AC8025P	MU AC8025P	EF AC6030M	EG AC6030M	EM AC6040M	SUMIBORON BN7000/BNC500	GZ AC4015K	GZ AC4015K	EF AC5015S	EG AC5015S	EM AC5025S	SUMIBORON BNC2125	SUMIBORON BN2000	SUMIDIA DA90
Interrupted Cutting	SX AC8025P	UX AC8035P	MX AC8035P	EF AC6030M	EG AC6040M	EM AC6040M	SUMIBORON BN7000/BNC500	GZ AC420K	No Chipbreaker AC420K	EF AC5025S	EG AC5025S	EM AC5025S	SUMIBORON BNC2125	SUMIBORON BN350	—
Recommended Cutting Conditions	A10 on			A14 on			A16 on			A18 on			A20 on		M2 on

BNC500 is for ductile cast iron.

CSRP Type / CSDP Type



SEC-40 Holder - General Turning
Clamp-on

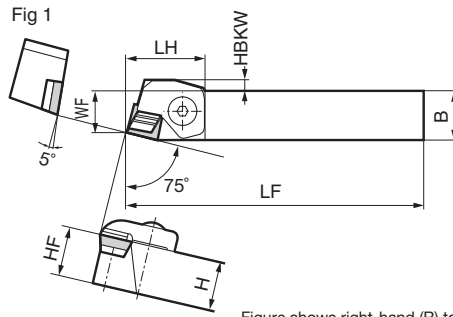


Figure shows right-hand (R) tool.

Holder

Parts

Dimensions (mm)

Cat. No.	Previous Cat. No.	Stock		Height	Width	Overall Length	Cutting Edge	Cutting Edge Height	Head	Step	Applicable Insert		Clamp Plate	Chipbreaker Piece	Bolt	Shim	Shim Retainer	Spring	Wrench (For Hex Socket)	
		R	L								Cat. No.	Ref. Page								
CSRP R/L1919-L12	FP11 R/L-33	●		19	19	140	15.5	19	34.5	5.0			1			BH0824R/L	GSPD422	SPP3	DSP5	LH040
CSRP R/L2525-N12	FP11 R/L-44A	●		25	25	160	21.5	25	34.5	—	SP□□1203	B103	1	DCR/L1	CBD4R/L	BH0830R/L	GSPD422	SPP3	DSP5	LH040
CSRP R/L3225-N12	FP11 R/L-45A			32	25	160	21.5	32	34.5	—			1			BH0830R/L				
CSRP R/L2525-N15	FP11 R/L-44B	●		25	25	160	21.5	25	40.0	4.5	SP□□1504	B104	1	DCR/L3	CBD5R/L	BH1030R/L	GSPD522	SPP3	DSP5	LH050
CSRP R/L3232-N15	FP11 R/L-55			32	32	180	26.0	32	40.0	—			1			BH1036R/L				



SEC-40 Holder - General Turning and Chamfering
Clamp-on

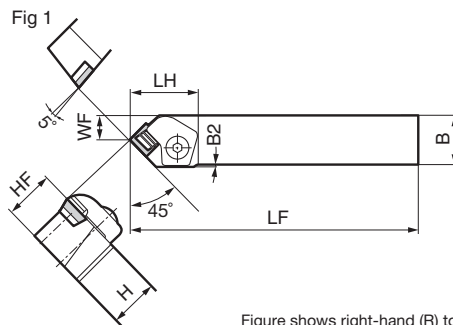


Figure shows right-hand (R) tool.

Holder

Parts

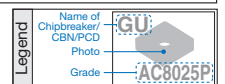
Dimensions (mm)

Cat. No.	Previous Cat. No.	Stock		Height	Width	Overall Length	Cutting Edge	Cutting Edge Height	Head	Step	Applicable Insert		Clamp Plate	Chipbreaker Piece	Bolt	Shim	Shim Retainer	Spring	Wrench (For Hex Socket)	
		R	L								Cat. No.	Ref. Page								
CSDP R/L1919-L12	FP14 R/L-33	●		19	19	140	10.5	19	35	6			1			BH0824R/L	GSPD422	SPP3	DSP5	LH040
CSDP R/L2525-N12	FP14 R/L-44A	●		25	25	160	12.5	25	35	2	SP□□1203	B103	1	DCR/L1	CBD4R/L	BH0830R/L	GSPD422	SPP3	DSP5	LH040
CSDP R/L3225-N12	FP14 R/L-45A			32	25	160	12.5	32	35	2			1			BH0830R/L				

Applicable Inserts ◀◀ CSRP Type / CSDP Type / CSKP Type

1st Recommended Insert

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



Cutting Range	P (Steel)		K (Cast Iron)			S (Exotic Alloy)		N (Non-ferrous)	H (Hardened Steel)
	Finishing	Medium Cutting	High-speed Finishing	Finishing to Medium Cutting	Medium to Roughing	Finishing to Medium Cutting	Medium to Roughing	—	Uncoated
Process									
General Cutting	FK T1500Z	SF AC8025P	SUMIBORON BN7000	No Chipbreaker AC4015K	No Chipbreaker AC4015K	No Chipbreaker AC5015S	No Chipbreaker AC5025S	SUMIDIA DA1000	SUMIBORON BN2000
Recommended Cutting Conditions	A10 on		A16 on			A18 on		A22 on	A20 on

External Holders

C

Neg.

Pos.

C

D

R

S

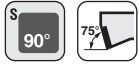
T

V

W

Special

SEC-External Holders CSKP Type



SEC-40 Type Holder - Facing
Clamp-on

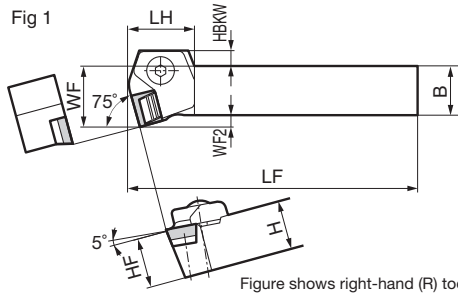
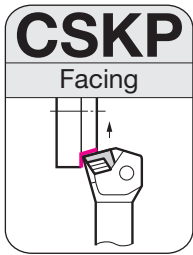


Figure shows right-hand (R) tool.

Holder

Cat. No.	Previous Cat. No.	Stock		Height	Width	Overall Length	Cutting Edge	Cutting Edge Height	Head	Offset	Step	Applicable Insert											
		R	L									H	B	LF	WF	HF	LH	WF2	HBKW	Cat. No.	Ref. Page	Fig	
CSKP R/L1919-L12	FP15 R/L-33			19	19	140	25	19	22	6	7												
CSKP R/L2525-N12	FP15 R/L-44A		●	25	25	160	32	25	22	7	—	SP□□1203	B103	1	DCL/R1	CBD4L/R	BH0824L/R	BH0830L/R	SSPD422	SPP3	DSP5	LH040	
CSKP R/L3225-N12	FP15 R/L-45A			32	25	160	32	32	22	7	—			1			BH0830L/R						
CSKP R/L2525-N15	FP15 R/L-44B		●	25	25	160	31	25	28	6	7	SP□□1504	B104	1	DCL/R3	CBD5L/R	BH1030L/R	BH1036L/R	SSPD522	SPP3	DSP5	LH050	
CSKP R/L3232-Q15	FP15 R/L-55			32	32	180	38	32	28	6	—			1									

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

Parts

Dimensions (mm)

Clamp Plate	Chipbreaker Piece	Bolt	Shim	Shim Retainer	Spring	Wrench

External Holders

Neg.

Pos.

C

D

R

S

T

V

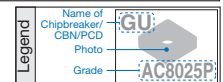
W

Special

Applicable Inserts ◀ CSRP Type / CSDP Type / CSKP Type

1st Recommended Insert

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



Cutting Range	P (Steel)		K (Cast Iron)			S (Exotic Alloy)		N (Non-ferrous)	H (Hardened Steel)
	Finishing	Medium Cutting	High-speed Finishing	Finishing to Medium Cutting	Medium to Roughing	Finishing to Medium Cutting	Medium to Roughing	—	Uncoated
General Cutting	FK 	SF 	SUMIBORON 	No Chipbreaker 	No Chipbreaker 	No Chipbreaker 	No Chipbreaker 	SUMIDIA 	SUMIBORON
Recommended Cutting Conditions	A10 on		A16 on			A18 on		A22 on	A20 on

DTGN Type / DTFN Type



SEC-D Holder - General Turning and Profiling Double Clamp

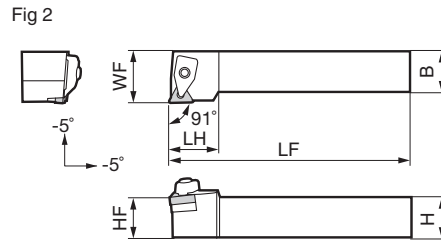
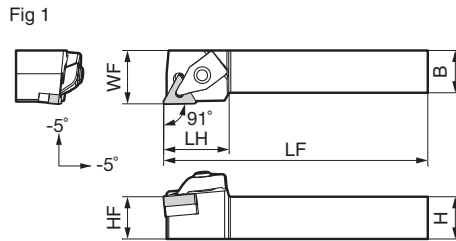
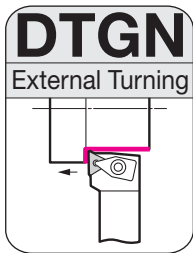


Figure shows right-hand (R) tool.

Holder

Parts

Dimensions (mm)

Cat. No.	Stock		Height H	Width B	Overall Length LF	Cutting Edge WF	Cutting Edge Height HF	Head LH	Applicable Insert		Fig	Clamp Set	Shim	Shim Screw	Wrench for Shims (For Torx Holes)	Top Hex Wrench (For Hex Socket)	Bottom Hex Wrench (For Hex Socket)	
	R	L							Cat. No.	Ref. Page								
DTGN R/L2020K16	●	●	20	20	125	25	20	31	TN□□1604	B56 on	1	SCP-1	5.0	TNS1604	BFTX0307N	TRX10(*)	LH040	LH025
DTGN R/L2525M16	●	●	25	25	150	32	25	31	TN□□1604	B56 on	2	SCP-1	5.0	TNS1604	BFTX0307N	TRX10(*)	LH040	LH025

*Wrench for shim is sold separately from the main body.

Clamp Set Parts **C46**



SEC-D Type Holder - Facing Double Clamp

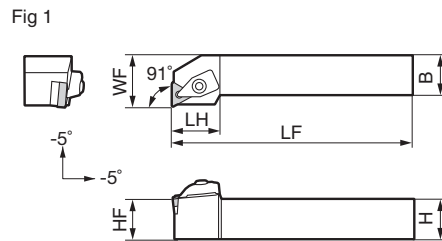
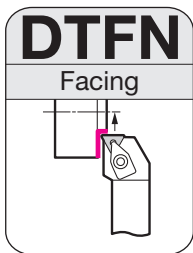


Figure shows right-hand (R) tool.

Holder

Parts

Dimensions (mm)

Cat. No.	Stock		Height H	Width B	Overall Length LF	Cutting Edge WF	Cutting Edge Height HF	Head LH	Applicable Insert		Fig	Clamp Set	Shim	Shim Screw	Wrench for Shims (For Torx Holes)	Top Hex Wrench (For Hex Socket)	Bottom Hex Wrench (For Hex Socket)	
	R	L							Cat. No.	Ref. Page								
DTFN R/L2020K16	●	●	20	20	125	25	20	30	TN□□1604	B56 on	1	SCP-1	5.0	TNS1604	BFTX0307N	TRX10(*)	LH040	LH025
DTFN R/L2525M16	●	●	25	25	150	32	25	30	TN□□1604	B56 on	1	SCP-1	5.0	TNS1604	BFTX0307N	TRX10(*)	LH040	LH025

*Wrench for shim is sold separately from the main body.

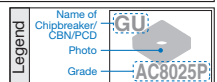
When using handed breaker inserts for facing, the holder and insert are opposite handed.

Clamp Set Parts **C46**

Applicable Inserts ◀ DTGN Type / DTFN Type / PTGN Type / PTTN Type / PTFN Type / ETGN Type / ETAN Type / ETFN Type / ETEN Type / ETXN Type / MTJN Type / MTXN Type

1st Recommended Insert

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



Cutting Range	P (Steel)			M (Stainless Steel)			K (Cast Iron)			S (Exotic Alloy)			N (Non-ferrous)	H (Hardened Steel)	
	Finishing	Medium Cutting	Roughing	Finishing	Medium Cutting	Roughing	High-speed Finishing	Finishing to Medium Cutting	Medium to Roughing	Finishing	Medium Cutting	Roughing	—	Coated	Uncoated
Continuous Cutting	FE T1500Z	GU AC8015P	MU AC8025P	EF AC6020M	EG AC6020M	EM AC6030M	SUMIBORON BN7000/BNC500	UZ AC4010K	GZ AC4010K	EF AC5015S	EG AC5015S	EM AC5015S	SUMIDIA DA1000	SUMIBORON BNC2115	SUMIBORON BN1000
General Cutting	SU AC8015P	GU AC8025P	MU AC8025P	EF AC6030M	EG AC6030M	EM AC6040M	SUMIBORON BN7000/BNC500	GZ AC4015K	GZ AC4015K	EF AC5015S	EG AC5015S	EM AC5025S	SUMIDIA DA1000	SUMIBORON BNC2125	SUMIBORON BN2000
Interrupted Cutting	SX AC8025P	UX AC8035P	MX AC8035P	EF AC6030M	EG AC6040M	EM AC6040M	SUMIBORON BN7000/BNC500	GZ AC420K	GZ AC420K	EF AC5025S	EG AC5025S	EM AC5025S	SUMIDIA DA1000	SUMIBORON BNC300	SUMIBORON BN350
Recommended Cutting Conditions	A10 on			A14 on			A16 on			A18 on			A22 on	A20 on	

BNC500 is for ductile cast iron.

External Holders



Neg.

Pos.



Special

PTGN Type / PTTN Type



SEC-70 Holder - General Turning and Profiling
Lever Lock

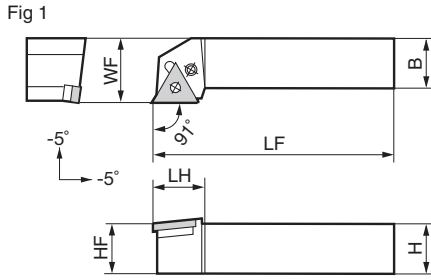
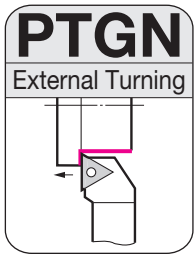


Figure shows right-hand (R) tool.

Holder

Parts

Dimensions (mm)

Cat. No.	Previous Cat. No.	Stock		Height H	Width B	Overall Length LF	Cutting Edge WF	Cutting Edge Height HF	Head LH	Applicable Insert		Lever Pin	Bolt	Shim	Shim Retainer	Wrench	
		R	L							Cat. No.	Ref. Page						
PTGN R/L1616H16	PTGN R/L1616-33	●	●	16	16	100	20	16	20	TN□□1604	B56 on	1 1 1 1	LCL3	LCS3	LST317	LSP3	LH025
PTGN R/L2020K16	PTGN R/L2020-33	●	●	20	20	125	25	20									
PTGN R/L2520M16	PTGN R/L2520-33	●	●	25	20	150	25	20									
PTGN R/L2525M16	PTGN R/L2525-33	●	●	25	25	150	32	25									
PTGN R/L3225P16	PTGN R/L3225-33			32	25	170	32	32	20	TN□□2204	B61 on	1 1 1 1	LCL4	LCS4	LST42	LSP4	LH030
PTGN R/L2525M22	PTGN R/L2525-43	●	●	25	25	150	32	25									
PTGN R/L3225P22	PTGN R/L3225-43			32	25	170	32	28									
PTGN R/L3232P22	PTGN R/L3232-43			32	32	170	40	32									
PTGN R/L3232P27	PTGN R/L3232-54			32	32	170	40	32	33	TN□□2706	B63	1 1	LCL5	LCS5	LST53	LSP5	LH030
PTGN R/L4040R27	PTGN R/L4040-54			40	40	200	50	40									



SEC-70 Holder - General Turning and Profiling
Lever Lock

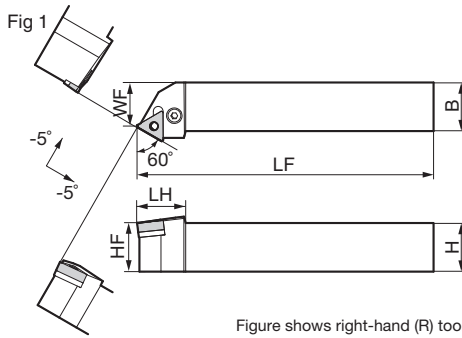
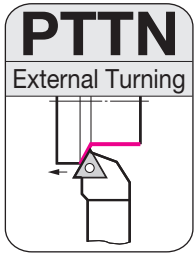


Figure shows right-hand (R) tool.

Holder

Parts

Dimensions (mm)

Cat. No.	Previous Cat. No.	Stock		Height H	Width B	Overall Length LF	Cutting Edge WF	Cutting Edge Height HF	Head LH	Applicable Insert		Lever Pin	Bolt	Shim	Shim Retainer	Wrench	
		R	L							Cat. No.	Ref. Page						
PTTN R/L1616H16	PTTN R/L1616-33	●	●	16	16	100	13	16	25	TN□□1604	B56 on	1 1 1 1	LCL3	LCS3	LST317	LSP3	LH025
PTTN R/L2020K16	PTTN R/L2020-33	●	●	20	20	125	17	20									
PTTN R/L2520M16	PTTN R/L2520-33	●	●	25	20	150	17	25									
PTTN R/L2525M16	PTTN R/L2525-33	●	●	25	25	150	22	25									
PTTN R/L3225P16	PTTN R/L3225-33			32	25	170	22	32	25	TN□□2204	B61 on	1 1 1 1	LCL4	LCS4	LST42	LSP4	LH030
PTTN R/L2525M22	PTTN R/L2525-43			25	25	150	22	25									
PTTN R/L3225P22	PTTN R/L3225-43			32	25	170	22	32									

External Holders

C

Neg.

Pos.

C

D

R

S

T

V

W

Special

PTFN Type



SEC-70 Type Holder - Facing
Lever Lock

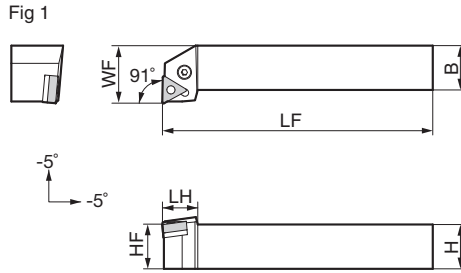
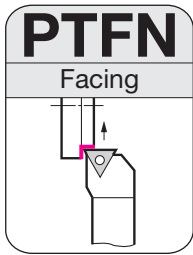


Figure shows right-hand (R) tool.

Holder

Parts

Dimensions (mm)

Cat. No.	Previous Cat. No.	Stock		Height	Width	Overall Length	Cutting Edge	Cutting Edge Height	Head	Applicable Insert		Lever Pin	Bolt	Shim	Shim Retainer	Wrench	
		R	L							Cat. No.	Ref. Page						
PTFN R/L1616H16	PTFN R/L1616-33	●	●	16	16	100	20	16	20	TN□□1604	B56 on	1	LCL3	LCS3	LST317	LSP3	LH025
PTFN R/L2020K16	PTFN R/L2020-33	●	●	20	20	125	25	20	20								
PTFN R/L2520M16	PTFN R/L2520-33			25	20	150	25	25	20								
PTFN R/L2525M16	PTFN R/L2525-33	●	●	25	25	150	32	25	20								
PTFN R/L3225P16	PTFN R/L3225-33			32	25	170	32	32	20	TN□□2204	B61 on	1	LCL4	LCS4	LST42	LSP4	LH030
PTFN R/L2525M22	PTFN R/L2525-43	●	●	25	25	150	32	25	25								
PTFN R/L3225P22	PTFN R/L3225-43			32	25	170	32	32	25								
PTFN R/L3232P22	PTFN R/L3232-43	●	●	32	32	170	40	32	25								
PTFN R/L3232P27	PTFN R/L3232-54			32	32	170	40	32	34	TN□□2706	B63	1	LCL5	LCS5	LST53	LSP5	LH030
PTFN R/L4040R27	PTFN R/L4040-54			40	40	200	50	40	34								

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

Applicable Inserts ◀ DTGN Type / DTFN Type / PTGN Type / PTTN Type / PTFN Type / ETGN Type / ETAN Type / ETFN Type / ETEN Type / ETXN Type / MTJN Type / MTXN Type

1st Recommended Insert

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

Cutting Range	P (Steel)			M (Stainless Steel)			K (Cast Iron)			S (Exotic Alloy)			N (Non-ferrous)	H (Hardened Steel)	
	Finishing	Medium Cutting	Roughing	Finishing	Medium Cutting	Roughing	High-speed Finishing	Finishing to Medium Cutting	Medium to Roughing	Finishing	Medium Cutting	Roughing	—	Coated	Uncoated
Continuous Cutting	FE	GU	MU	EF	EG	EM	SUMBORON	UZ	GZ	EF	EG	EM	SUMIDIA	SUMIBORON	SUMIBORON
	T1500Z	AC8015P	AC8025P	AC6020M	AC6020M	AC6030M	BN7000/BNC500	AC4010K	AC4010K	AC5015S	AC5015S	AC5015S	DA1000	BNC2115	BN1000
General Cutting	SU	GU	MU	EF	EG	EM	SUMBORON	GZ	GZ	EF	EG	EM	SUMIDIA	SUMIBORON	SUMIBORON
	AC8015P	AC8025P	AC8025P	AC6030M	AC6030M	AC6040M	BN7000/BNC500	AC4015K	AC4015K	AC5015S	AC5015S	AC5025S	DA1000	BNC2125	BN2000
Interrupted Cutting	SX	UX	MX	EF	EG	EM	SUMBORON	GZ	GZ	EF	EG	EM	SUMIDIA	SUMIBORON	SUMIBORON
	AC8025P	AC8035P	AC8035P	AC6030M	AC6040M	AC6040M	BN7000/BNC500	AC420K	AC420K	AC5025S	AC5025S	AC5025S	DA1000	BNC300	BN350
Recommended Cutting Conditions	A10 on			A14 on			A16 on			A18 on			A22 on	A20 on	

BNC500 is for ductile cast iron.

External Holders



Neg.

Pos.



Special

ETGN Type / ETAN Type

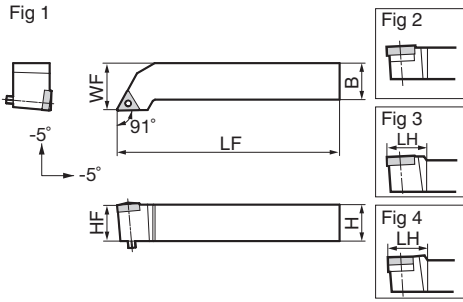
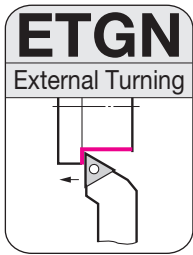


Figure shows right-hand (R) tool.

SEC-30 Holder - General Turning
Pin Lock

External Holders



Neg.

Pos.



Special

Holder

Cat. No.	Previous Cat. No.	Stock		Height H	Width B	Overall Length LF	Cutting Edge WF	Cutting Edge Height HF	Head LH	Applicable Insert		Fig	Eccentric Pin	Shim	Wrench			
		R	L							Cat. No.	Ref. Page							
ETGN R/L1212F11	ETGN R/L1212	●	●	12	12	80	16	11.5	—	TN□□1103	B54	1	P221US	—	KY25			
ETGN R/L1616H1603	ETGN R/L1616H32	●	●	16	16	100	20	15.5	—	TN□□1603	B55 on	1	P322US	—	KY40			
ETGN R/L1616H1604	ETGN R/L1616H33	●	●	16	16	100	20	15.5	—	TN□□1604	B56 on	1	P332US	—	KY40			
ETGN R/L2020K1603	ETGN R/L2020K32			20	20	125	25	19.5	—	TN□□1603	B55 on	1	P323US	—	KY40			
ETGN R/L2020K1603W	ETGN R/L2020K32W			20	20	125	25	19.5	—			2	P323WS	EST32				
ETGN R/L2020K1604	ETGN R/L2020K33	●	●	20	20	125	25	19.5	—	TN□□1604	B56 on	1	P333US	—	KY40			
ETGN R/L2020K1604W	ETGN R/L2020K33W	●	●	20	20	125	25	19.5	—			2	P333WS	EST32				
ETGN R/L2520M1604	ETGN R/L2520			25	20	150	25	24.5	—			1	P334US	—				
ETGN R/L2520M1604W	ETGN R/L2520W			25	20	150	25	24.5	—			2	P334WS	EST32				
ETGN R/L2525M1604	ETGN R/L2525M33			25	25	150	32	24.5	—			1	P334US	—				
ETGN R/L2525M1604W	ETGN R/L2525M33W	●	●	25	25	150	32	24.5	—			2	P334WS	EST32				
ETGN R/L2525M22	ETGN R/L2525M43			25	25	150	32	24.5	30			TN□□2204	B61 on	3		P434U	—	KY40
ETGN R/L2525M22W	ETGN R/L2525M43W	●	●	25	25	150	32	24.5	30					4		P434W	EST43	

Parts

Dimensions (mm)

SEC-30 Holder - General Turning
Pin Lock

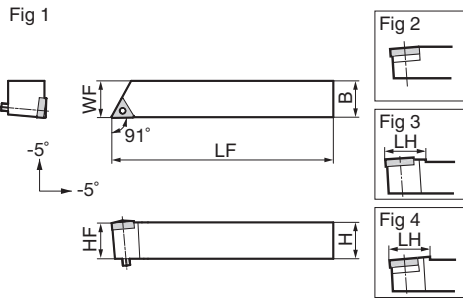
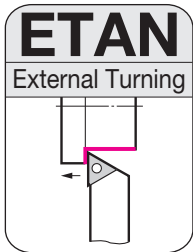


Figure shows right-hand (R) tool.

Holder

Cat. No.	Previous Cat. No.	Stock		Height H	Width B	Overall Length LF	Cutting Edge WF	Cutting Edge Height HF	Head LH	Applicable Insert		Fig	Eccentric Pin	Shim	Wrench			
		R	L							Cat. No.	Ref. Page							
ETAN R/L1212F11	ETAN R/L1212	●	●	12	12	80	12	11.5	—	TN□□1103	B54	1	P221US	—	KY25			
ETAN R/L1616H1603	ETAN R/L1616H32			16	16	100	16	15.5	—	TN□□1603	B55 on	1	P322US	—	KY40			
ETAN R/L1616H1604	ETAN R/L1616H33	●	●	16	16	100	16	15.5	—	TN□□1604	B56 on	1	P332US	—	KY40			
ETAN R/L2020K1603	ETAN R/L2020K32			20	20	125	20	19.5	—	TN□□1603	B55 on	1	P323US	—	KY40			
ETAN R/L2020K1603W	ETAN R/L2020K32W			20	20	125	20	19.5	—			2	P323WS	EST32				
ETAN R/L2020K1604	ETAN R/L2020K33			20	20	125	20	19.5	—	TN□□1604	B56 on	1	P333US	—	KY40			
ETAN R/L2020K1604W	ETAN R/L2020K33W	●	●	20	20	125	20	19.5	—			2	P333WS	EST32				
ETAN R/L2520M1604	ETAN R/L2520			25	20	150	20	24.5	—			1	P334US	—				
ETAN R/L2520M1604W	ETAN R/L2520W			25	20	150	20	24.5	—			2	P334WS	EST32				
ETAN R/L2525M1604	ETAN R/L2525M33			25	25	150	25	24.5	—			1	P334US	—				
ETAN R/L2525M1604W	ETAN R/L2525M33W	●	●	25	25	150	25	24.5	—			2	P334WS	EST32				
ETAN R/L2525M22	ETAN R/L2525M43			25	25	150	25	24.5	30			TN□□2204	B61 on	3		P434U	—	KY40
ETAN R/L2525M22W	ETAN R/L2525M43W	●	●	25	25	150	25	24.5	30					4		P434W	EST43	

Parts

Dimensions (mm)

ETFN Type



SEC-30 Type Holder - Facing
Pin Lock

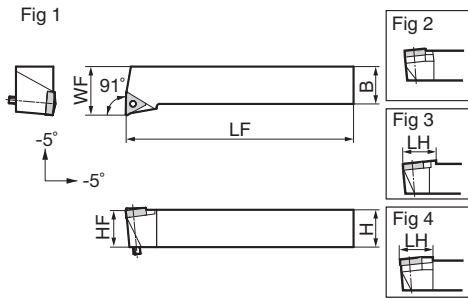
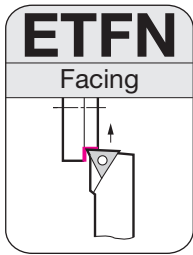


Figure shows right-hand (R) tool.

Holder

Parts

Dimensions (mm)

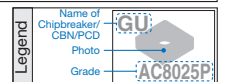
Cat. No.	Previous Cat. No.	Stock		Height		Width		Overall Length	Cutting Edge	Cutting Edge Height	Head	Applicable Insert		Eccentric Pin	Shim	Wrench
		R	L	H	B	LF	WF					HF	LH			
ETFN R/L1212F11	ETFN R/L1212	●	●	12	12	80	16	11.5	—	TN□□1103	B54	1	P221US	—	KY25	
ETFN R/L1616H1603	ETFN R/L1616H32			16	16	100	20	15.5	—	TN□□1603	B55 on	1	P322US	—	KY40	
ETFN R/L1616H1604	ETFN R/L1616H33	●	●	16	16	100	20	15.5	—	TN□□1604	B56 on	1	P332US	—	KY40	
ETFN R/L2020K1603	ETFN R/L2020K32			20	20	125	25	19.5	—	TN□□1603	B55 on	1	P323US	—	KY40	
ETFN R/L2020K1603W	ETFN R/L2020K32W			20	20	125	25	19.5	—			2	P323WS	EST32		
ETFN R/L2020K1604	ETFN R/L2020K33			20	20	125	25	19.5	—	TN□□1604	B56 on	1	P333US	—	KY40	
ETFN R/L2020K1604W	ETFN R/L2020K33W	●	●	20	20	125	25	19.5	—			2	P333WS	EST32		
ETFN R/L2520M1604	ETFN R/L2520			25	20	150	25	24.5	—			1	P334US	—		
ETFN R/L2520M1604W	ETFN R/L2520W			25	20	150	25	24.5	—			2	P334WS	EST32		
ETFN R/L2525M1604	ETFN R/L2525M33			25	25	150	32	24.5	—			1	P334US	—	KY40	
ETFN R/L2525M1604W	ETFN R/L2525M33W	●	●	25	25	150	32	24.5	—			2	P334WS	EST32		
ETFN R/L2525M22	ETFN R/L2525M43			25	25	150	32	24.5	30	TN□□2204	B61 on	3	P434U	—	KY40	
ETFN R/L2525M22W	ETFN R/L2525M43W	●	●	25	25	150	32	24.5	30			4	P434W	EST43		

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

Applicable Inserts ◀ DTGN Type / DTFN Type / PTGN Type / PTTN Type / PTFN Type / ETGN Type / ETAN Type / ETFN Type / ETEN Type / ETXN Type / MTJN Type / MTXN Type

1st Recommended Insert

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



Cutting Range	P (Steel)			M (Stainless Steel)			K (Cast Iron)			S (Exotic Alloy)			N (Non-ferrous)	H (Hardened Steel)	
	Finishing	Medium Cutting	Roughing	Finishing	Medium Cutting	Roughing	High-speed Finishing	Finishing to Medium Cutting	Medium to Roughing	Finishing	Medium Cutting	Roughing	—	Coated	Uncoated
Continuous Cutting	FE T1500Z	GU AC8015P	MU AC8025P	EF AC6020M	EG AC6020M	EM AC6030M	SUMIBORON BN7000/BNCS500	UZ AC4010K	GZ AC4010K	EF AC5015S	EG AC5015S	EM AC5015S	SUMIDIA DA1000	SUMIBORON BNC2115	SUMIBORON BN1000
General Cutting	SU AC8015P	GU AC8025P	MU AC8025P	EF AC6030M	EG AC6030M	EM AC6040M	SUMIBORON BN7000/BNCS500	GZ AC4015K	GZ AC4015K	EF AC5015S	EG AC5015S	EM AC5025S	SUMIDIA DA1000	SUMIBORON BNC2125	SUMIBORON BN2000
Interrupted Cutting	SX AC8025P	UX AC8035P	MX AC8035P	EF AC6030M	EG AC6040M	EM AC6040M	SUMIBORON BN7000/BNCS500	GZ AC420K	GZ AC420K	EF AC5025S	EG AC5025S	EM AC5025S	SUMIDIA DA1000	SUMIBORON BNC300	SUMIBORON BN350
Recommended Cutting Conditions	A10 on			A14 on			A16 on			A18 on			A22 on	A20 on	

BNCS500 is for ductile cast iron.

External Holders



Neg.

Pos.

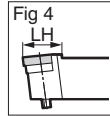
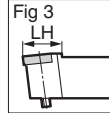
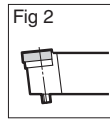
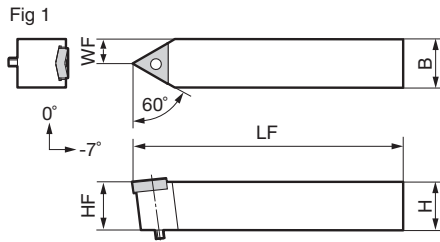
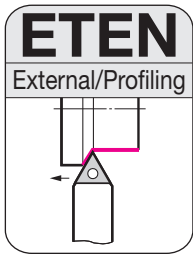


Special

ETEN Type / ETXN Type



SEC-30 Holder - General Turning and Profiling
Pin Lock



Holder

Parts

Dimensions (mm)

Cat. No.	Previous Cat. No.	Stock	Height H	Width B	Overall Length LF	Cutting Edge WF	Cutting Edge Height HF	Head LH	Applicable Insert		Fig	Eccentric Pin	Shim	Wrench	
									Cat. No.	Ref. Page					
ETEN N1212F11	ETEN N1212	●	12	12	80	6.0	11.5	—	TN□□1103	B54	1	P221US	—	KY25	
ETEN N1616H1603	ETEN N1616H32		16	16	100	8.0	15.5	—	TN□□1603	B55 on	1	P322US	—	KY40	
ETEN N1616H1604	ETEN N1616H33	●	16	16	100	8.0	15.5	—	TN□□1604	B56 on	1	P332US	—	KY40	
ETEN N2020K1603	ETEN N2020K32		20	20	125	10.0	19.5	—	TN□□1603	B55 on	1	P323US	—	KY40	
ETEN N2020K1603W	ETEN N2020K32W		20	20	125	10.0	19.5	—		2	P323WS	EST32			
ETEN N2020K1604	ETEN N2020K33	●	20	20	125	10.0	19.5	—	TN□□1604	B56 on	1	P333US	—	KY40	
ETEN N2020K1604W	ETEN N2020K33W	●	20	20	125	10.0	19.5	—			2	P333WS	EST32		
ETEN N2520M1604	ETEN N2520		25	20	150	10.0	24.5	—			1	P334US	—		
ETEN N2520M1604W	ETEN N2520W		25	20	150	10.0	24.5	—			2	P334WS	EST32		
ETEN N2525M1604	ETEN N2525M33		25	25	150	12.5	24.5	—			1	P334US	—		
ETEN N2525M1604W	ETEN N2525M33W	●	25	25	150	12.5	24.5	—			2	P334WS	EST32		
ETEN N2525M22	ETEN N2525M43		25	25	150	12.5	24.5	30	TN□□2204	B61 on	3	P434U	—	KY40	
ETEN N2525M22W	ETEN N2525M43W	●	25	25	150	12.5	24.5	30			4	P434W	EST43		



SEC-30 Holder - General Turning and Facing
Pin Lock

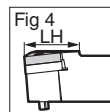
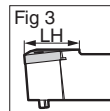
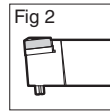
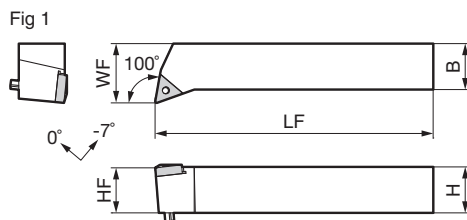
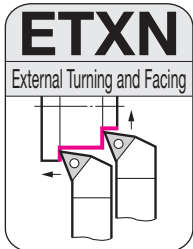


Figure shows right-hand (R) tool.

Holder

Parts

Dimensions (mm)

Cat. No.	Previous Cat. No.	Stock		Height H	Width B	Overall Length LF	Cutting Edge WF	Cutting Edge Height HF	Head LH	Applicable Insert		Fig	Eccentric Pin	Shim	Wrench	
		R	L							Cat. No.	Ref. Page					
ETXN R/L1212F11	ETXN R/L1212	●	●	12	12	80	16	11.5	—	TN□□1103	B54	1	P221US	—	KY25	
ETXN R/L1616H1603	ETXN R/L1616H32			16	16	100	20	15.5	—	TN□□1603	B55 on	1	P322US	—	KY40	
ETXN R/L1616H1604	ETXN R/L1616H33	●	●	16	16	100	20	15.5	—	TN□□1604	B56 on	1	P332US	—	KY40	
ETXN R/L2020K1603	ETXN R/L2020K32			20	20	125	25	19.5	—	TN□□1603	B55 on	1	P323US	—	KY40	
ETXN R/L2020K1603W	ETXN R/L2020K32W			20	20	125	25	19.5	—			2	P323WS	EST32		
ETXN R/L2020K1604	ETXN R/L2020K33	●	●	20	20	125	25	19.5	—	TN□□1604	B56 on	1	P333US	—	KY40	
ETXN R/L2020K1604W	ETXN R/L2020K33W	●	●	20	20	125	25	19.5	—			2	P333WS	EST32		
ETXN R/L2520M1604	ETXN R/L2520			25	20	150	25	24.5	—			1	P334US	—		
ETXN R/L2520M1604W	ETXN R/L2520W			25	20	150	25	24.5	—			2	P334WS	EST32		
ETXN R/L2525M1604	ETXN R/L2525M33			25	25	150	32	24.5	—			1	P334US	—		
ETXN R/L2525M1604W	ETXN R/L2525M33W	●	●	25	25	150	32	24.5	—			2	P334WS	EST32		
ETXN R/L2525M22	ETXN R/L2525M43			25	25	150	32	24.5	30	TN□□2204	B61 on	3	P434U	—	KY40	
ETXN R/L2525M22W	ETXN R/L2525M43W	●	●	25	25	150	32	24.5	30			4	P434W	EST43		

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

MTJN Type / MTXN Type



SEC-M Holder - General Turning and Profiling
Clamp-on + Pin Lock

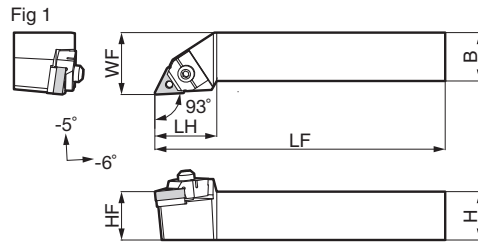
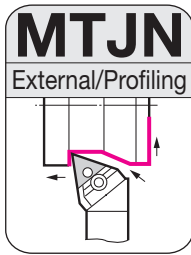


Figure shows right-hand (R) tool.

Holder

Parts

Dimensions (mm)

Cat. No.	Previous Cat. No.	Stock		Height	Width	Overall Length	Cutting Edge	Cutting Edge Height	Head	Applicable Insert		Wedge	Pin	Shim	Bolt	Nut	Ring	Wrench for Bolt	Wrench for Nut		
		R	L							Cat. No.	Ref. Page										
* MTJN R/L2020K16	MTJN R/L2020-33	●	●	20	20	125	25	20	32	TN□□1604	B56 on	1	MP317S								
** MTJN R/L2520M16	MTJN R/L2520-33	●	●	25	20	150	25	25	32	TN□□1604	B56 on	1	MMW30	MP320S	STW323	BHA0525	4.0	CPM32N	ER04	LH030	LH030
** MTJN R/L2525M16	MTJN R/L2525-33	●	●	25	25	150	32	25	32	TN□□1604	B56 on	1	MP320S								
** MTJN R/L2525M22	MTJN R/L2525-43	●	●	25	25	150	32	25	38	TN□□1604	B56 on	1	MP420								
** MTJN R/L3225P22	MTJN R/L3225-43	●	●	32	25	170	32	32	38	TN□□2204	B61 on	1	MMW40	MP420	STW434	BHA0625	4.5	CPM43N	ER05	LH040	LH030

When using CIS standard inserts, the pin for holders marked * is MP317 and the pin for holders marked ** is MP320.



SEC-M Holder - General Turning and Facing
Clamp-on + Pin Lock

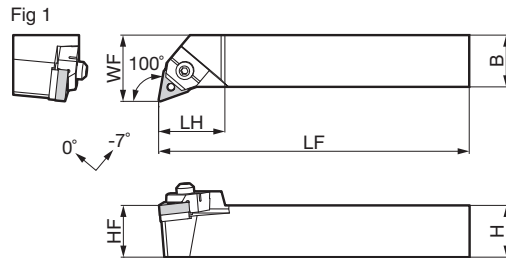
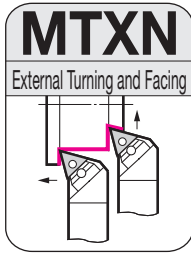


Figure shows right-hand (R) tool.

Holder

Parts

Dimensions (mm)

Cat. No.	Previous Cat. No.	Stock		Height	Width	Overall Length	Cutting Edge	Cutting Edge Height	Head	Applicable Insert		Wedge	Pin	Shim	Bolt	Nut	Ring	Wrench for Bolt	Wrench for Nut			
		R	L							Cat. No.	Ref. Page											
* MTXN R/L2020K16	MTXN R/L2020-33	●	●	20	20	125	25	20	32	TN□□1604	B56 on	1	MMW30	MP317S	STW323	BHA0525	4.0	CPM32N	ER04	LH030	LH030	
** MTXN R/L2525M16	MTXN R/L2525-33	●	●	25	25	150	32	25	32	TN□□1604	B56 on	1	MP320S									
** MTXN R/L2525M22	MTXN R/L2525-43	●	●	25	25	150	32	25	38	TN□□2204	B61 on	1	MMW40	MP420	STW434	BHA0625	4.5	CPM43N	ER05	LH040	LH030	

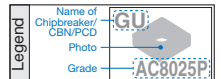
When using CIS standard inserts, the pin for holders marked * is MP317 and the pin for holders marked ** is MP320.

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

Applicable Inserts ◀ DTGN Type / DTFN Type / PTGN Type / PTTN Type / PTFN Type / ETGN Type / ETAN Type / ETFN Type / ETEN Type / ETXN Type / MTJN Type / MTXN Type

1st Recommended Insert

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



Cutting Range	P (Steel)			M (Stainless Steel)			K (Cast Iron)			S (Exotic Alloy)			N (Non-ferrous)	H (Hardened Steel)	
	Finishing	Medium Cutting	Roughing	Finishing	Medium Cutting	Roughing	High-speed Finishing	Finishing to Medium Cutting	Medium to Roughing	Finishing	Medium Cutting	Roughing	—	Coated	Uncoated
Continuous Cutting	FE T1500Z	GU AC8015P	MU AC8025P	EF AC6020M	EG AC6020M	EM AC6030M	SUMIBORON BN7000/BNC500	UZ AC4010K	GZ AC4010K	EF AC5015S	EG AC5015S	EM AC5015S	SUMIDIA DA1000	SUMIBORON BNC2115	SUMIBORON BN1000
General Cutting	SU AC8015P	GU AC8025P	MU AC8025P	EF AC6030M	EG AC6030M	EM AC6040M	SUMIBORON BN7000/BNC500	GZ AC4015K	GZ AC4015K	EF AC5015S	EG AC5015S	EM AC5025S	SUMIDIA DA1000	SUMIBORON BNC2125	SUMIBORON BN2000
Interrupted Cutting	SX AC8025P	UX AC8035P	MX AC8035P	EF AC6030M	EG AC6040M	EM AC6040M	SUMIBORON BN7000/BNC500	GZ AC420K	GZ AC420K	EF AC5025S	EG AC5025S	EM AC5025S	SUMIDIA DA1000	SUMIBORON BNC300	SUMIBORON BN350
Recommended Cutting Conditions	A10 on			A14 on			A16 on			A18 on			A22 on	A20 on	

BNC500 is for ductile cast iron.

CTGP Type / CTAP Type



SEC-40 Holder - General Turning
Clamp-on

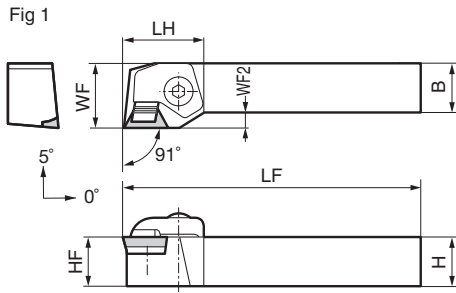


Figure shows right-hand (R) tool.

Holder

Parts

Dimensions (mm)

Cat. No.	Previous Cat. No.	Stock		Height	Width	Overall Length	Cutting Edge	Cutting Edge Height	Head	Offset	Applicable Insert		Fig	Clamp Plate	Chipbreaker Piece	Bolt	Shim	Shim Retainer	Spring	Wrench <small>(For Hex Socket)</small>
		R	L								Cat. No.	Ref. Page								
CTGP R/L1919-L16	FP22 R/L-33	●		19	19	140	25	19	34.5	6	TP□□1603	B116	1	DCR/L2	CBD4R/L	BH0824R/L	STPD322	SPP3	DSP5	LH040
CTGP R/L2525-N22	FP22 R/L-44B	●		25	25	160	32	25	41	7	TP□□2204	B120	1	DCR/L3	CBD5R/L	BH1030R/L	STPD422	SPP3	DSP5	LH050



SEC-40 Holder - General Turning
Clamp-on

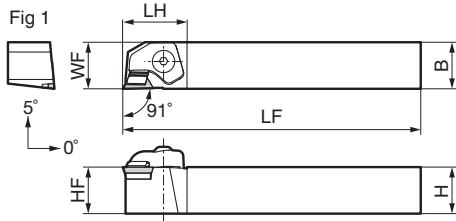
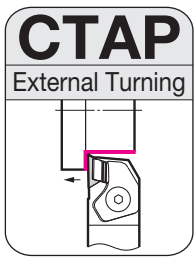


Figure shows right-hand (R) tool.

Holder

Parts

Dimensions (mm)

Cat. No.	Previous Cat. No.	Stock		Height	Width	Overall Length	Cutting Edge	Cutting Edge Height	Head	Applicable Insert		Fig	Clamp Plate	Chipbreaker Piece	Bolt	Shim	Shim Retainer	Spring	Wrench <small>(For Hex Socket)</small>	
		R	L							Cat. No.	Ref. Page									
CTAP R/L2525-N16	FP21 R/L-44A	●		25	25	160	25	25	34.5		TP□□1603	B116	1	DCR/L2	CBD4R/L	BH0830R/L	STPD322	SPP3	DSP5	LH040
CTAP R/L3225-N16	FP21 R/L-45A			32	25	160	25	32	34.5		TP□□1603	B116	1	DCR/L2	CBD4R/L	BH0830R/L	STPD322	SPP3	DSP5	LH040
CTAP R/L3232-Q22	FP21 R/L-55			32	32	180	32	32	41		TP□□2204	B120	1	DCR/L3	CBD5R/L	BH1036R/L	STPD422	SPP3	DSP5	LH050

External Holders

C

Neg.

Pos.

C

D

R

S

T

V

W

Special

CTFP Type



SEC-40 Type Holder - Facing
Clamp-on

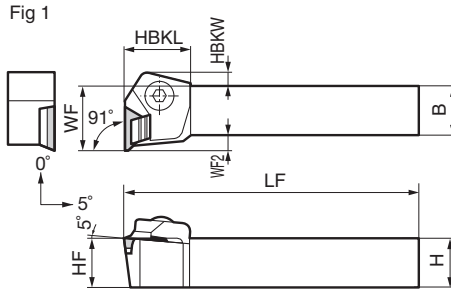
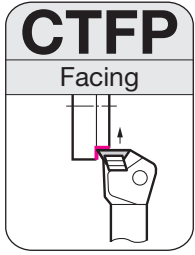


Figure shows right-hand (R) tool.

Holder

Parts

Dimensions (mm)

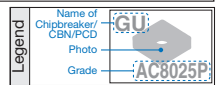
Cat. No.	Previous Cat. No.	Stock		Height	Width	Overall Length	Cutting Edge	Cutting Edge Height	Head	Offset	Step	Applicable Insert		Fig	Clamp Plate	Chipbreaker Piece	Bolt	Shim	Shim Retainer	Spring	Wrench (For Hex Socket)
		R	L									Cat. No.	Ref. Page								
CTFP R/L1919-L16	FP25 R/L-33	●		19	19	140	25	19	26	6	8			1	DCL/R2		BH0824L/R	STPD322	SPP3	DSP5	LH040
CTFP R/L2525-N16	FP25 R/L-44A	●		25	25	160	32	25	26	7	—	TP□□1603	B116	1	DCL/R2	CBD4L/R	BH0830L/R	STPD322	SPP3	DSP5	LH040
CTFP R/L3225-N16	FP25 R/L-45A			32	25	160	32	26	7	—	—			1	DCL/R2			STPD322	SPP3	DSP5	LH040
CTFP R/L2525-N22	FP25 R/L-44B	●		25	25	160	32	25	33	7	7	TP□□2204	B120	1	DCL/R3	CBD5L/R	BH1030L/R	STPD422	SPP3	DSP5	LH040
CTFP R/L3232-Q22	FP25 R/L-55			32	32	180	39	32	33	7	—			1	DCL/R3	CBD5L/R	BH1036L/R	STPD422	SPP3	DSP5	LH040

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

Applicable Inserts ◀ CTGP Type / CTAP Type / CTFP Type

1st Recommended Insert

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



Cutting Range	P (Steel)		K (Cast Iron)			S (Exotic Alloy)		N (Non-ferrous)	H (Hardened Steel)
	Finishing	Medium Cutting	High-speed Finishing	Finishing to Medium Cutting	Medium to Roughing	Finishing to Medium Cutting	Medium to Roughing	—	Uncoated
Process	FK	SF	SUMIBORON	No Chipbreaker	No Chipbreaker	No Chipbreaker	No Chipbreaker	SUMIDIA	SUMIBORON
General Cutting	T1500Z	AC8025P	BN7000	AC4015K	AC4015K	AC5015S	AC5025S	DA1000	BN2000
Recommended Cutting Conditions	A10 on		A16 on			A18 on		A22 on	A20 on

External Holders



Neg.

Pos.



Special

DVJN Type / DVJN-J Type



SEC-D Holder - General Turning and Profiling
Double Clamp

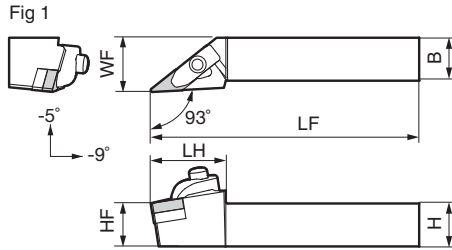
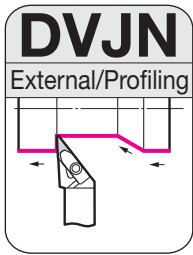


Figure shows right-hand (R) tool.

Holder

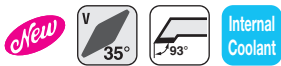
Parts

Dimensions (mm)

Cat. No.	Stock		Height	Width	Overall Length	Cutting Edge	Cutting Edge Height	Head	Applicable Insert		Fig	Clamp Set		Shim	Shim Screw	Wrench for Shims	Top Hex Wrench	Bottom Hex Wrench
	R	L							H	B		LF	WF					
DVJN R/L2020K16	●	●	20	20	125	25	20	35	VN□□1604	B66 on	1	SCP-4	5.0	VNS1604	BFTX0307N	TRX10(*)	LH040	LH025
DVJN R/L2525M16	●	●	25	25	150	32	25	35			1							

*Wrench for shim is sold separately from the main body.

Clamp Set Parts C46



SEC-D Type Holder - General Turning and Profiling
Internal Coolant Supply: Double Clamp

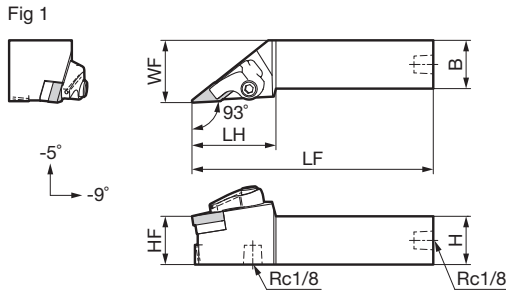
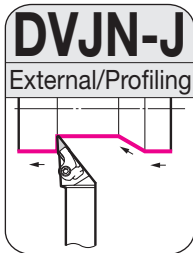


Figure shows right-hand (R) tool.

Holder

Parts

Dimensions (mm)

Cat. No.	Stock		Height	Width	Overall Length	Cutting Edge	Cutting Edge Height	Head	Applicable Insert		Fig	Clamp Plate	Cap Screw	Spring	O-ring	Shim	Shim Screw	Wrench for Shims	Top Hex Wrench	Bottom Hex Wrench	Plug	
	R	L							H	B		LF	WF	HF	LH	Cat. No.	Ref. Page	(N·m)				
DVJN R/L2020K16-J	●	●	20	20	125	27	20	43	VN□□1604	B66 on	1	JV R/L-01	CP-M5-20-1	5.0	CSP12J	SS060	VNS1604	BFTX0307N	TRX10(*)	LH040	LH025	XP02
DVJN R/L2525K16-J	●	●	25	25	125	32	25	43			1											

*Wrench for shim is sold separately from the main body.

External Holders

C

Neg.

Pos.

C

D

R

S

T

V

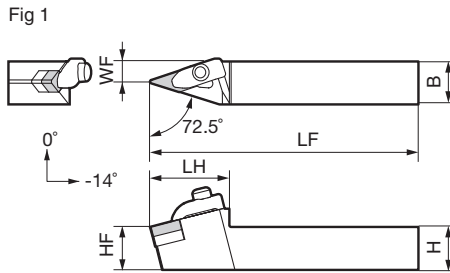
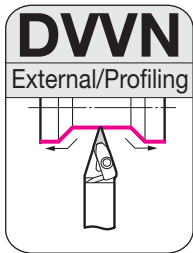
W

Special

DVVN Type / DVQN Type



SEC-D Holder - General Turning and Profiling
Double Clamp



Holder

Parts

Dimensions (mm)

Cat. No.	Stock		Height H	Width B	Overall Length LF	Cutting Edge WF	Cutting Edge Height HF	Head LH	Applicable Insert		Fig	Clamp Set		Shim	Shim Screw	Wrench for Shims (For Torx Holes)	Top Hex Wrench (For Hex Socket)	Bottom Hex Wrench (For Hex Socket)
	R	L							Cat. No.	Ref. Page		N-m	N-m					
DVVN N2020K16	●	●	20	20	125	10.0	20	37	VN□□1604	B66 on	1	SCP-4	5.0	VNS1604	BFTX0307N	TRX10(*)	LH040	LH025
DVVN N2525M16	●	●	25	25	150	12.5	25	37			1							

*Wrench for shim is sold separately from the main body.

Clamp Set Parts C46



SEC-D Holder - General Turning, Profiling and Necking
Double Clamp

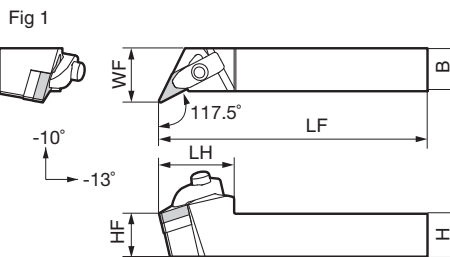


Figure shows right-hand (R) tool.

Holder

Parts

Dimensions (mm)

Cat. No.	Stock		Height H	Width B	Overall Length LF	Cutting Edge WF	Cutting Edge Height HF	Head LH	Applicable Insert		Fig	Clamp Set		Shim	Shim Screw	Wrench for Shims (For Torx Holes)	Top Hex Wrench (For Hex Socket)	Bottom Hex Wrench (For Hex Socket)
	R	L							Cat. No.	Ref. Page		N-m	N-m					
DVQN R/L2020K16	●	●	20	20	125	25	20	35	VN□□1604	B66 on	1	SCP-4	5.0	VNS1604	BFTX0307N	TRX10(*)	LH040	LH025
DVQN R/L2525M16	●	●	25	25	150	32	25	35			1							

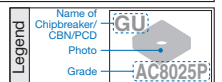
*Wrench for shim is sold separately from the main body.

Clamp Set Parts C46

Applicable Inserts ◀ DVJN Type / DVJN-J Type / DVVN Type / DVQN Type

1st Recommended Insert

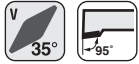
- Refer as well to the Insert Selection Guide (A10 on).
- Depending on the insert size, some combinations cannot be made-to-order or manufactured.



Cutting Range	P (Steel)		M (Stainless Steel)		K (Cast Iron)		S (Exotic Alloy)		N (Non-ferrous)	H (Hardened Steel)		Hard Brittle Material
	Finishing	Medium Cutting	Finishing	Medium Cutting	High-speed Finishing	Finishing to Medium Cutting	Finishing	Medium Cutting	—	Coated	Uncoated	Finishing
Continuous Cutting	FE T1500Z	GU AC8015P	EF AC6020M	EG AC6020M	SUMIBORON BN7000/BNC500	UZ AC4010K	EF AC5015S	EG AC5015S	SUMIDIA DA1000	SUMIBORON BNC2115	SUMIBORON BN1000	SUMIDIA BINDERLESS NPD10
General Cutting	SU AC8015P	GU AC8025P	EF AC6030M	EG AC6030M	SUMIBORON BN7000/BNC500	GZ AC4015K	EF AC5015S	EG AC5015S	SUMIDIA DA1000	SUMIBORON BNC2125	SUMIBORON BN2000	SUMIDIA DA90
Interrupted Cutting	SX AC8025P	UX AC8035P	EF AC6030M	EG AC6040M	SUMIBORON BN7000/BNC500	GZ AC420K	EF AC5025S	EG AC5025S	SUMIDIA DA1000	SUMIBORON BNC300	SUMIBORON BN350	—
Recommended Cutting Conditions	A10 on		A14 on		A16		A18 on		A22 on	A20 on		M2 on

BNC500 is for ductile cast iron.

SVLC Type / SVJC Type



SEC-SV Mini Holder - General Turning and Profiling
Screw-on

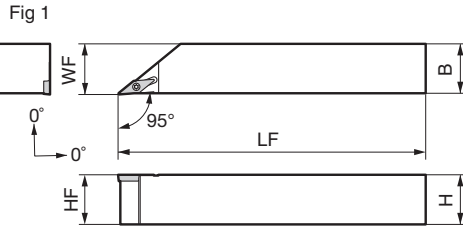
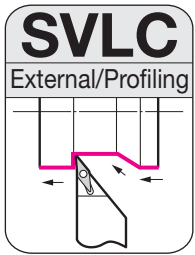


Figure shows right-hand (R) tool.

Holder

Parts

Dimensions (mm)

Cat. No.	Stock		Height		Width		Overall Length		Cutting Edge		Cutting Edge Height		Applicable Insert		Fig	Flat Insert Screw	Wrench (For Torx Holes)
	R	L	H	B	LF	WF	HF	Cat. No.	Ref. Page	Cat. No.	Ref. Page						
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										
SVLC R/L2525-M11	●	●	25	25	150	25.5	25										

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



SEC-SV Profiling Tool Holder - For External Profiling
Screw-on

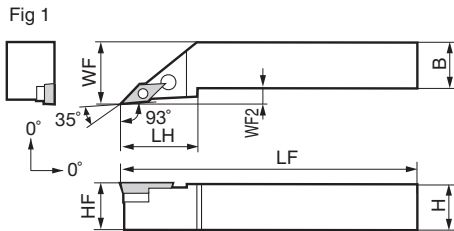
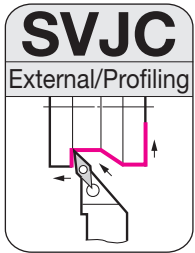


Figure shows right-hand (R) tool.

Holder

Parts

Dimensions (mm)

Cat. No.	Previous Cat. No.	Stock		Height		Width		Overall Length		Cutting Edge		Offset	Applicable Insert		Fig	Pin	Nut	Shim	Flat Insert Screw		Wrench (For Torx Holes)	Wrench for Nut (For Hex Socket)
		R	L	H	B	LF	WF	HF	LH	WF2	Cat. No.		Ref. Page	Cat. No.					Ref. Page			
SVJC R/L2020K16	SVJC R/L2020-33	●	●	20	20	125	25	20	41	5	VC□□1604	B127 on	1	VP20	CPV33N	SVP32	BFTX03508	2.0	TRX10	LH025		
SVJC R/L2525M16	SVJC R/L2525-33	●	●	25	25	150	32	25	41	7												
SVJC R/L3225P16	SVJC R/L3225-33	●	●	32	25	170	32	32	41	7												

External Holders

C

Neg.

Pos.

C

D

R

S

T

V

W

Special

SVVC Type / SVPC Type



SEC-SV Profiling Tool Holder - For External Profiling Screw-on

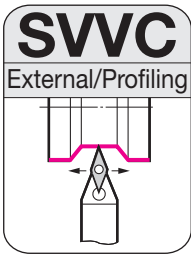
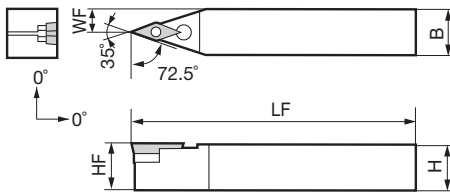


Fig 1



Holder

Parts

Dimensions (mm)

Cat. No.	Previous Cat. No.	Stock		Overall Length	Cutting Edge	Cutting Edge Height	Applicable Insert		Pin	Nut	Shim	Flat Insert Screw		Wrench	Wrench for Nut		
		H	B				Cat. No.	Ref. Page				N-m	(For Torx Holes)			(For Hex Socket)	
SVVC N2020K16	SVVC N2020-33	●	20	20	125	10.0	20	VC□□1604	B127 on	1	VP20	CPV33N	SVP32	BFTX03508	2.0	TRX10	LH025
SVVC N2525M16	SVVC N2525-33	●	25	25	150	12.5	25										
SVVC N3225P16	SVVC N3225-33	●	32	25	170	12.5	32										



SEC-SV Profiling Tool Holder - General Turning, Facing, Profiling and Necking Screw-on

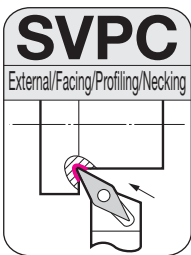


Fig 1

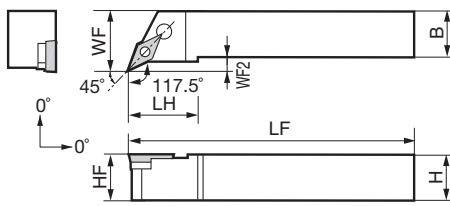


Figure shows right-hand (R) tool.

Holder

Parts

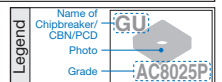
Dimensions (mm)

Cat. No.	Previous Cat. No.	Stock		Overall Length	Cutting Edge	Cutting Edge Height	Head	Offset	Applicable Insert		Pin	Nut	Shim	Flat Insert Screw		Wrench	Wrench for Nut		
		R	L						Cat. No.	Ref. Page				N-m	(For Torx Holes)			(For Hex Socket)	
SVPC R/L1010-H11	—	●	10	10	100	14.5	10	-4.5	VC□□1103	B126 on	1	—	—	BFTX02508NV	1.5	TRX08	—		
SVPC R/L1212-H11	—	●	12	12	100	16.5	12	-4.5											
SVPC R/L1616-H11	—	●	16	16	100	20.5	16	-4.5											
SVPC R/L2020K16	SVPC R/L2020-33	●	20	20	125	25	20	35	5.0	VC□□1604	B127 on	1	VP20	CPV33N	SVP32	BFTX03508	2.0	TRX10	LH025
SVPC R/L2525M16	SVPC R/L2525-33	●	25	25	150	32	25	35	7.0										
SVPC R/L3225P16	SVPC R/L3225-33	●	32	25	170	32	32	35	7.0										

Applicable Inserts ◀ SVLC Type / SVJC Type / SVVC Type / SVPC Type

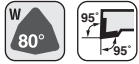
1st Recommended Insert

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



Cutting Range	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

DWLN Type / DWLN-J Type



SEC-D Holder - General Turning and Facing
Double Clamp

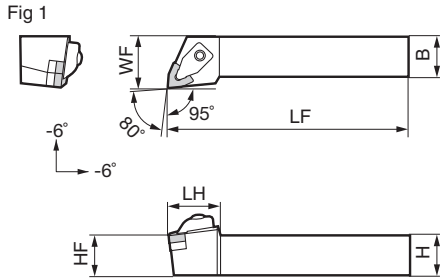
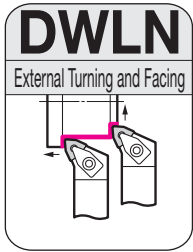


Figure shows right-hand (R) tool.

Holder

Parts

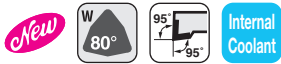
Dimensions (mm)

Cat. No.	Stock		Height	Width	Overall Length	Cutting Edge	Cutting Edge Height	Head	Applicable Insert		Clamp Set		Shim	Shim Screw	Wrench for Shims	Top Hex Wrench	Bottom Hex Wrench	
	R	L							H	B	LF	WF						HF
DWLN R/L2020K08	●	●	20	20	125	25	20	32	WN□□0804	B71 on	1	SCP-2	5.0	WNS0804	BFTX0409N	TRX15(*)	LH040	LH025
DWLN R/L2525M08	●	●	25	25	150	32	25	32										

*Wrench for shim is sold separately from the main body.

Clamp Set Parts refer to C46

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



SEC-D Type Holder - General Turning and Facing
Internal Coolant Supply: Double Clamp

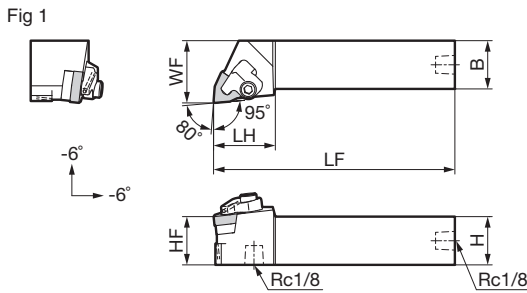
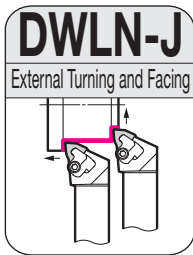


Figure shows right-hand (R) tool.

Holder

Parts

Dimensions (mm)

Cat. No.	Stock		Height	Width	Overall Length	Cutting Edge	Cutting Edge Height	Head	Applicable Insert		Clamp Plate	Cap Screw	Spring	O-ring	Shim	Shim Screw	Wrench for Shims	Top Hex Wrench	Bottom Hex Wrench	Plug		
	R	L							H	B	LF	WF	HF	LH	Cat. No.	Ref. Page	Fig	N-m				
DWLN R/L2020K08-J	●	●	20	20	125	26	20	32	WN□□0804	B71 on	1	JC R/L-01	CP-M5-20-1	5.0	CSP12J	SS060	WNS0804	BFTX0409N	TRX15(*)	LH040	LH025	XP02
DWLN R/L2525K08-J	●	●	25	25	125	32	25	32														

*Wrench for shim is sold separately from the main body.

External Holders

C

Neg.

Pos.

C

D

R

S

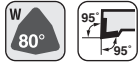
T

V

W

Special

PWLN Type / MWLN Type



SEC-70 Holder - General Turning and Facing
Lever Lock

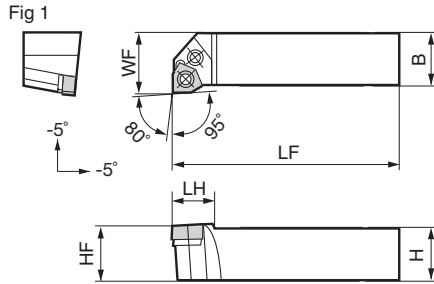
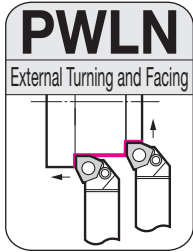


Figure shows right-hand (R) tool.

Holder

Parts

Dimensions (mm)

Cat. No.	Previous Cat. No.	Stock		Height	Width	Overall Length	Cutting Edge	Cutting Edge Height	Head	Applicable Insert		Lever Pin	Bolt	Shim	Shim Retainer	Wrench	
		R	L							Cat. No.	Ref. Page						
PWLN R/L2020K06	PWLN R/L2020-33	●	●	20	20	125	25	20	17	WN□□0604	B69 on	1	LCL3	LCS3	LSW317	LSP3	LH025 (For Hex Socket)
PWLN R/L2525M06	PWLN R/L2525-33	●	●	25	25	150	32	25	17								

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



SEC-M Holder - General Turning, Facing, Profiling and Necking
Clamp-on + Pin Lock

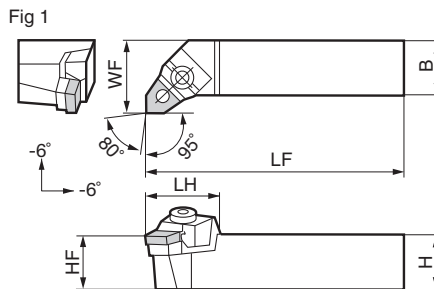
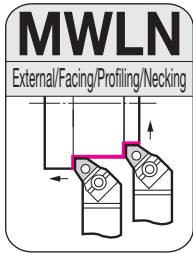


Figure shows right-hand (R) tool.

Holder

Parts

Dimensions (mm)

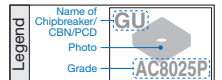
Cat. No.	Previous Cat. No.	Stock		Height	Width	Overall Length	Cutting Edge	Cutting Edge Height	Head	Applicable Insert		Wedge	Pin	Shim	Bolt	Nut	Ring	Wrench for Bolt	Wrench for Nut			
		R	L							Cat. No.	Ref. Page											
MWLN R/L2020K08	MWLN R/L2020-43	●	●	20	20	125	25	20	32	WN□□0804	B71 on	1	MP416	MP420	SWW433	BHA0625	4.5	CPM43S	CPM43N	ER05	LH040	LH030
MWLN R/L2525M08	MWLN R/L2525-43	●	●	25	25	150	32	25	32													
MWLN R/L3225P08	MWLN R/L3225-43	●	●	32	25	170	32	32	32													

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

Applicable Inserts ◀ DWLN Type / DWLN-J Type / PWLN Type / MWLN Type

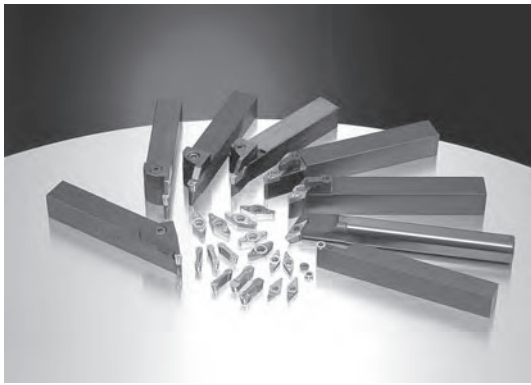
1st Recommended Insert

- 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	P (Steel)			M (Stainless Steel)			K (Cast Iron)		S (Exotic Alloy)			H (Hardened Steel)	
	Finishing	Medium Cutting	Roughing	Finishing	Medium Cutting	Roughing	Finishing to Medium Cutting	Medium to Roughing	Finishing	Medium Cutting	Roughing	Coated	Uncoated
Continuous Cutting	FE	GU	MU	EF	EG	EM	UZ	GZ	EF	EG	EM	SUMIBORON	SUMIBORON
	T1500Z	AC8015P	AC8025P	AC6020M	AC6020M	AC6030M	AC4010K	AC4010K	AC5015S	AC5015S	AC5015S	BNC2115	BN2000
General Cutting	SU	GU	MU	EF	EG	EM	GZ	GZ	EF	EG	EM	SUMIBORON	SUMIBORON
	AC8015P	AC8025P	AC8025P	AC6030M	AC6030M	AC6040M	AC4015K	AC4015K	AC5015S	AC5015S	AC5025S	BNC2125	BN2000
Interrupted Cutting	SX	UX	MX	EF	EG	EM	GZ	No Chipbreaker	EF	EG	EM	SUMIBORON	SUMIBORON
	AC8025P	AC8035P	AC8035P	AC6030M	AC6040M	AC6040M	AC420K	AC420K	AC5025S	AC5025S	AC5025S	BNC2125	BN2000
Recommended Cutting Conditions	A10 on			A14 on			A16 on		A18 on			A20 on	

MV Type / GD Type Profiling Tool Holders



General Features

With a wide range of insert shapes (35° diamond shaped type, dogbone type and round type) available in both cemented carbide and polycrystalline diamond grades, we are able to provide superior performance for a vast variety of applications and cutting conditions.

Features and Applications

- With our new range of holders for 35° diamond shaped inserts and AW type chipbreakers, we are able to expand our applications to cover roughing to finishing processes. AW type chipbreakers realize stable roughing with reduced cutting force and increased clamp rigidity due to the new tool holder design
- Wide variety of dogbone inserts
AW type chipbreakers, with their high rake design and newly designed dedicated tool holder, support a wide variety of tooling (straight, 15° angle, 45° angle)
- AW Type Chipbreaker for smooth chip control
- AG Type Chipbreaker for no chip adhesion on a mirror finish

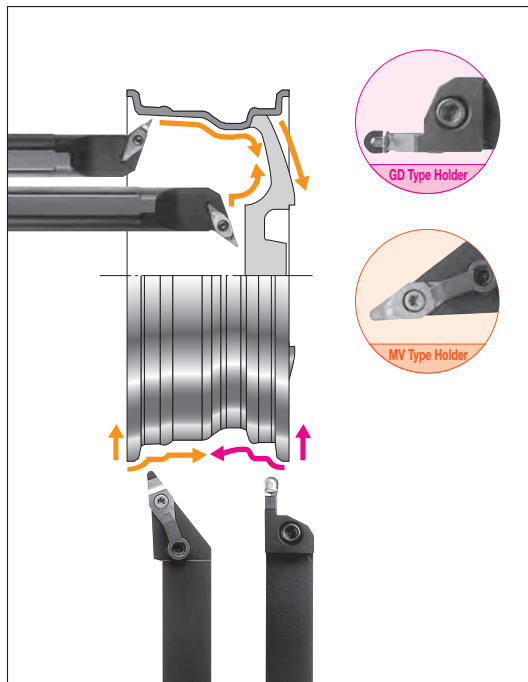
AW Type Chipbreaker

- 35° Diamond Type
VCGT220520N-AW (H1)
- Dogbone Insert
MDE4R-AW (H1)
MDE4R-AW (DA2200)

AG Type Chipbreaker

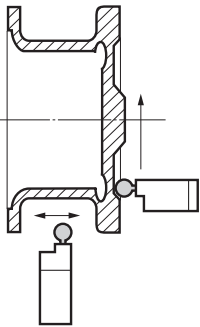
- 35° Diamond Type
VCGT160408N-AG (H1)

Tooling and Tool Types

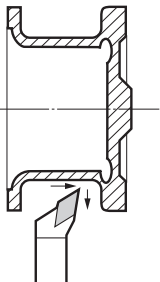


Product Name	Cat. No.	Page
SEC-GD Type Holders	GDE R/L2525-600W/S	C45
	GDE R/L2525-800W/S	
	GDE R/L2525-615W/S	
	GDE R/L2525-815W/S	
	GDE R/L2525-645W/S	
SEC-SV Type Holders	GDE R/L2525-845W/S	C45
	SVJC R/L2525M16	C38
	SVVC N2525M16	C39
SVPC R/L2525M16		
SEC-MV Type Holders	MVXC R/L2525Q22-20	C43
	MVXC R/L2525Q22-30	
	MVPC R/L2525Q22-20	
	MVPC R/L2525Q22-30	
SEC-D Type Holders	DVJN R/L2525 M16	C36
	DVVN N2525 M16	C37
	DVQN R/L2525 M16	

Application Examples



- Cutting Conditions
Tool Holder Cat. No.: GDEL2525-800W
Insert Cat. No.: MDE4R-AW
Grade: H1
 $n = 2,000\text{min}^{-1}$
 $f = 0.4 \text{ to } 0.6\text{mm/rev}$
 $a_p = 2.0\text{mm Wet}$
- Usage Results
Excellent chip control of AW breaker guarantees an increase in productivity.



- Cutting Conditions
Tool Holder Cat. No.: SVJCL2525M16
Insert Cat. No.: VCMT160412
Grade: DA1000
 $v_c = 2,500\text{m/min}$
 $f = 0.35\text{mm/rev}$
 $a_p = 0.2\text{mm Wet}$
- Usage Results
Will not fracture and provides over 17 times the tool life compared to competitors' PCDs.

DA1000 3,500 holes

Competitor's PCD 200 holes

Tool Life

External Holders

C

Neg.

Pos.

C

D

R

S

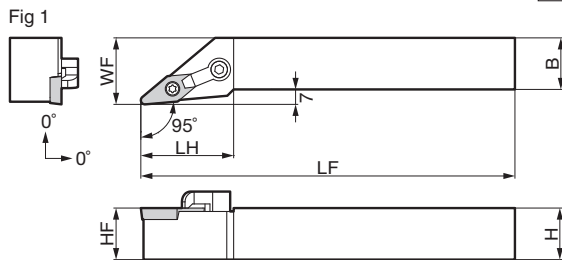
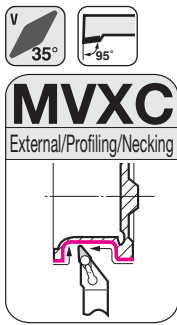
T

V

W

Special

MV Type Profiling Tool Holders



SEC-35° Diamond Type - General Turning, Profiling and Necking
Screw-on + Clamp-on

Figure shows right-hand (R) tool.

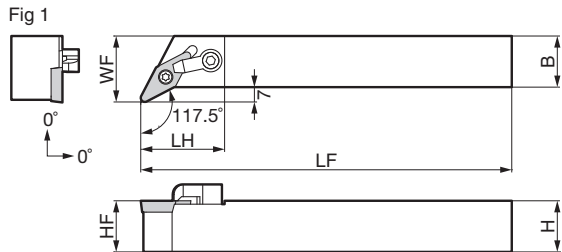
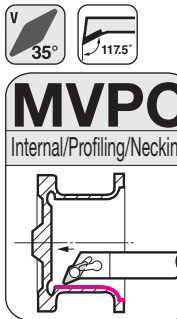
Holder

Parts

Dimensions (mm)

Cat. No.	Previous Cat. No.	Stock		Height H	Width B	Overall Length LF	Cutting Edge WF	Cutting Edge Height HF	Head LH	Fig	Clamp Plate	Double Screw	Flat Insert Screw	Wrench (For Torx Holes)	Wrench for Clamp Plate (For Hex Socket)
		R	L												
★ MVXC R/L2525Q22-20	MVXC R/L2525-2220	●	●	25	25	180	32	25	45	1	CCM8-LONG	WB8-24	BFTX0515N	TRX20	LH040
☆ MVXC R/L2525Q22-30	MVXC R/L2525-2230	●	●	25	25	180	32	25	45	1	CCM8-LONG	WB8-24	BFTX0515N	TRX20	LH040

★ mark: Corner Radius 2.0mm Insert, ☆ mark: Corner Radius 3.0mm Insert



SEC-35° Diamond Type Internal, Profiling and Necking
Screw-on + Clamp-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 WF	Cutting Edge Height HF	Head LH	Fig	Clamp Plate	Double Screw	Flat Insert Screw	Wrench (For Torx Holes)	Wrench for Clamp Plate (For Hex Socket)
		R	L												
★ MVPC R/L2525Q22-20	MVPC R/L2525-2220	●	●	25	25	180	32	25	41	1	CCM8-LONG	WB8-24	BFTX0515N	TRX20	LH040
☆ MVPC R/L2525Q22-30	MVPC R/L2525-2230	●	●	25	25	180	32	25	41	1	CCM8-LONG	WB8-24	BFTX0515N	TRX20	LH040

★ mark: Corner Radius 2.0mm Insert, ☆ mark: Corner Radius 3.0mm Insert

Insert (35° Diamond Type)

(□ Cemented Carbide / ■ SUMIDIA) Dimensions (mm)

Shape	Cat. No.	G10E	H1	DA1000	DA2200	Inscribed Circle IC	Thickness S	Corner Radius RE	Applicable Holders
AW	VCGT220520N-AW	—	●	—	—	12.70	5.56	2.0	MVXC Type (holder pictured above) MVPC Type (holder pictured above)
	VCGT220530N-AW	—	●	—	—	12.70	5.56	3.0	
	VCGT220530N-AG	—	●	—	—	12.70	5.56	3.0	
AG	VCMT220520	—	—	●	▲	12.70	5.56	2.0	SVJC Type C38 SVVC Type C39 SVPC Type C39
	VCMT220530	—	—	●	▲	12.70	5.56	3.0	
AW	VCGT160408N-AW	—	●	—	—	9.525	4.76	0.8	SVJC Type C38 SVVC Type C39 SVPC Type C39
	VCGT160412N-AW	—	●	—	—	9.525	4.76	1.2	
AG	VCGT160408N-AG	—	●	—	—	9.525	4.76	0.8	
	VCGT160412N-AG	—	●	—	—	9.525	4.76	1.2	
WF	NF-VCMT160404	—	—	●	▲	9.525	4.76	0.4	
	NF-VCMT160408	—	—	●	▲	9.525	4.76	0.8	
	NF-VCMT160412	—	—	●	▲	9.525	4.76	1.2	
UP	VCMT160408	—	—	●	▲	9.525	4.76	0.8	
	VCMT160412	—	—	●	▲	9.525	4.76	1.2	
	VCMT160412-WF	—	—	●	▲	9.525	4.76	1.2	
UP	VNMG160404N-UP	●	—	—	—	9.525	4.76	0.4	DVJN Type C36 DVVN Type C37 DVQNTType C37
	VNMG160408N-UP	●	—	—	—	9.525	4.76	0.8	
	NF-VNMX160404	—	—	●	▲	9.525	4.76	0.4	
UP	NF-VNMX160408	—	—	●	▲	9.525	4.76	0.8	
	NF-VNMX160412	—	—	●	▲	9.525	4.76	1.2	
	VNMX160404	—	—	●	▲	9.525	4.76	0.4	
UP	VNMX160408	—	—	●	▲	9.525	4.76	0.8	
	VNMX160412	—	—	●	▲	9.525	4.76	1.2	

VNMG160400N-UP (UP Type Chipbreaker) is available in AC820P, AC830P, AC6030M, AC6040M and AC630M grades.

▲ mark: To be replaced by a new product, made to order, or discontinued (please confirm stock availability). — mark: Not available

External Holders

C

Neg.

Pos.

C

D

R

S

T

V

W

Special

GD Type Profiling Tool Holders

Dogbone Insert for External/Profiling Clamp-on

External Holders

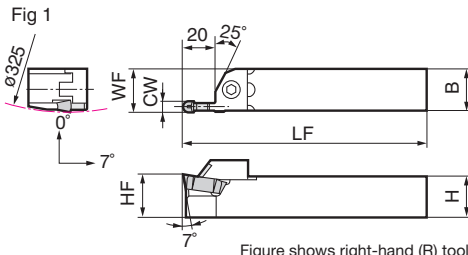
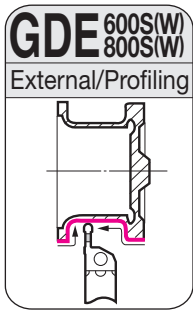


Figure shows right-hand (R) tool.

Holder

Parts

Dimensions (mm)

Cat. No.	Stock		Height	Width	Overall Length	Cutting Edge	Cutting Edge Height	Width of Cut	Group No.	Fig	Carbide Piece Clamp	Special Steel Clamp	Cap Screw	Wrench
	R	L	H	B	LF	WF	HF	CW			Fig	Fig	Fig	Fig
GDE R/L2525-600S	●	●	25	25	150	26	25	6	1	1				
GDE R/L2525-800S	●	●	25	25	150	26	25	8	2	1	—	GDS600R/L GDS800R/L	BX0625	LH050
GDE R/L2525-600W	●	●	25	25	150	26	25	6	1	1	GDW600R/L	—	BX0625	LH050
GDE R/L2525-800W	●	●	25	25	150	26	25	8	2	1	GDW800R/L	—	BX0625	LH050

Refer to MDE Type insert group numbers on C45 for applicable inserts.

Dogbone Insert for Facing/Internal Profiling Clamp-on

C

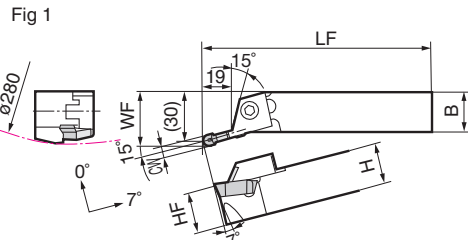
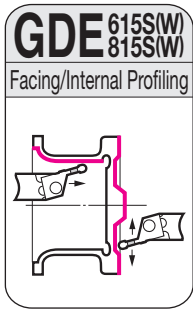


Figure shows right-hand (R) tool.

Holder

Parts

Dimensions (mm)

Cat. No.	Stock		Height	Width	Overall Length	Cutting Edge	Cutting Edge Height	Width of Cut	Group No.	Fig	Carbide Piece Clamp	Special Steel Clamp	Cap Screw	Wrench
	R	L	H	B	LF	WF	HF	CW			Fig	Fig	Fig	Fig
GDE R/L2525-615S	●	●	25	25	150	32.2	25	6	1	1				
GDE R/L2525-815S	●	●	25	25	150	33.2	25	8	2	1	—	GDS615R/L GDS815R/L	BX0625	LH050
GDE R/L2525-615W	●	●	25	25	150	32.2	25	6	1	1	GDW615R/L	—	BX0625	LH050
GDE R/L2525-815W	●	●	25	25	150	33.2	25	8	2	1	GDW815R/L	—	BX0625	LH050

Refer to MDE Type insert group numbers on C45 for applicable inserts.

D

R

S

T

V

W

Special

GD Type Profiling Tool Holders

Dogbone Insert for Internal Profiling
Clamp-on

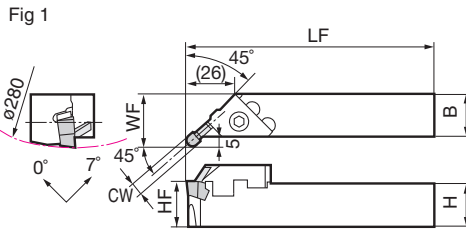
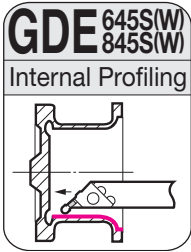


Figure shows right-hand (R) tool.

Holder

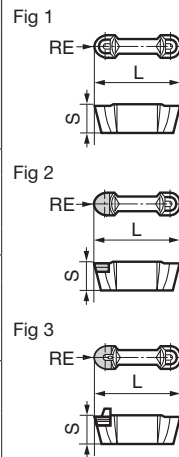
Cat. No.	Stock		Height H	Width B	Overall Length LF	Cutting Edge WF	Cutting Edge Height HF	Width of Cut CW	Group No.	Fig	Parts			
	R	L									Carbide Piece Clamp	Special Steel Clamp	Cap Screw	Wrench (For Hex Socket)
GDE R/L2525-645S	●	●	25	25	150	30	25	6	1	1	—	GDS645R/L	BX0625	LH050
GDE R/L2525-845S			25	25	150	30	25	8	2	1	GDS845R/L			
GDE R/L2525-645W			25	25	150	30	25	6	1	1	GDW645R/L	—		
GDE R/L2525-845W			25	25	150	30	25	8	2	1	GDW845R/L	—		

Refer to MDE Type insert group numbers below for applicable inserts.

Insert (Dogbone Type)



(Carbide / SUMIDIA)

Shape	Cat. No.	Stock		Dimensions (mm)				Group No.	Fig
		H1	DA2200	Overall Length L	Thickness S	Corner Radius RE	Width of Cut CW		
	MDE3R-AW	●	—	26	8.5	3.0	6	1	1
	MDE4R-AW	●	—	30	8.5	4.0	8	2	
	MDE3R	—	●	26	8.5	3.0	6	1	2
	MDE4R	—	●	30	8.5	4.0	8	2	
	MDE3R-AW	—	●	26	8.5	3.0	6	1	3
	MDE4R-AW	—	●	30	8.5	4.0	8	2	



Clamp Set Parts

Parts

Applicable Clamp Sets Cat. No.	Spring		Cap Screw		N·m
		Stock		Stock	
SCP-1	CSP08	●	CP-M5-20-1	●	5.0
SCP-2	CSP08	●	CP-M5-20-1	●	
SCP-3	CSP08	●	CP-M5-20-1	●	
SCP-4	CSP25	●	CP-M5-20-1	●	
SCP-5	CSP08	●	CP-M5-20-1	●	
SCP-6	CSP12	●	CP-M8-25-1	●	

CP-M5-20-1 can also be fastened from the other end of the screw.