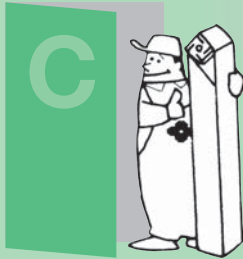


External Holders

C1 to C48

C



Negative	CN□□ Insert Applicable Holders	SEC-External Tool Holder Series C2
Positive	CC□□ Insert Applicable Holders	SEC-External Holder Identification Table and Cutting Edge Position Dimensions ... C4
Negative	DN□□ Insert Applicable Holders	SEC-External Holder Clamp Structure C6
Positive	T-REX Tool Holders DC□□ Insert Applicable Holders RCM□ Insert Applicable Holders SN□□ Insert Applicable Holders	SEC-External Holders / Internal Coolant Holders ... C8
Negative	SP□□ Insert (Without Hole) Applicable Holders	DCLN-J type / DCLN type C10
Positive	TN□□ Insert Applicable Holders	PCLN type C11
Negative	TP□□ Insert (Without Hole) Applicable Holders	PCBN type / PCFN type C12
Positive	VN□□ Insert Applicable Holders	SCLC type C13
Negative	VC□□ Insert Applicable Holders	DDJN-J type / DDJN type C14
Positive	WN□□ Insert Applicable Holders	DDHN type / DDNN type C15
Positive	For Aluminum Wheel Turning	PDJN type C16
		SumiTurn T-REX Tool Holders C17
		SDJC type C19
		PRGC type / PRDC type C20
		DSBN type / DSDN type C21
		DSSN type / PSBN type C22
		PSDN type C23
		PSSN type / PSKN type C24
		ESBN type / ESDN type C25
		ESSN type / ESKN type C26
		CSRP type / CSDP type (FP11 type / 14 type) C27
		CSKP type (FP15 type) C28
		DTGN type / DTFN type C29
		PTGN type / PTTN type C30
		PTFN type C31
		ETGN type / ETAN type C32
		ETFN type C33
		ETEN type / ETXN type C34
		MTJN type / MTXN type C35
		CTGP type / CTAP type (FP22 type / 21 type) C36
		CTFP type (FP25 type) C37
		DVJN-J type / DVJN type C38
		DVJN type / DVQN type C39
		SVLC type / SVJC type C40
		SVVC type / SVPC type C41
		DWLN-J type / DWLN type C42
		PWLN type / MWLN type C43
		Tool Holders for Aluminum Wheel Turning C44
		SEC-MV series Profiling Tool Holders C45
		SEC-GD series Profiling Tool Holders C46
		Double Clamp Tool Holders
		Clamp Set Parts C48

Stock Markings and Symbols

- mark: Standard stocked item
- mark: To be replaced with the new item featured on the same page
- ▲ mark: To be replaced by a new product, made to order, or discontinued (please confirm stock availability)

- * mark: Semi-standard stocked (please confirm stock availability)
- mark: Stock or planned stock (please confirm stock availability)
- Blank: Made-to-order item
- mark: Not available

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 tools. 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	55° Diamond type	Triangular type					
Structure	Type								
Double Clamp	M series Tool Holders D series Tool Holders	 DCLN-J C10 DCLN C10	 DDJN-J C14 DDJN C14	 DDHN C15	 DDNN C15	 DTGN C29	 DTFN C29	 MTJN C35	 MTXN C35
	T-REX Tool Holders	-	-	 DTR55C SumiT-REX C17	 DTR55Q SumiT-REX C17	-	-	-	-
Pin Lock	30 series Tool Holders	-	-	-	-	 ETGN C32 ETAN C32	 ETFN C33	 ETEN C34	 ETXN C34
Lever Lock	70 series Tool Holders	 PCLC D17 D22	 PCLN C11	 PDJC D18 D24	-	 PTGN C30	 PTTN C30	 PTFN C31	 PTXN D20
		 PCBN C12	 PCFN C12	 PDJN C16	-	-	-	-	-
Screw-on	Mini Holders	 SCLC C13 D17 D22	 SCAC D17 D23	 SDJC C19 D18 D24	 SDAC D19 D25	 STGC D27	 STAC D27	-	-
		-	-	 SDNC D25	 SDPC D19	Clamp-on 40 series Tool Holders	 CTGP/CTAP C36	 CTFP C37	-

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

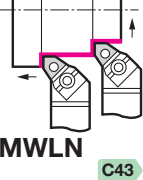
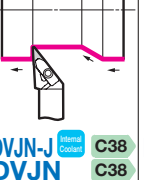
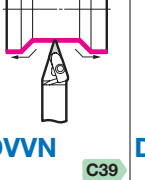
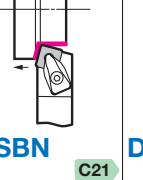
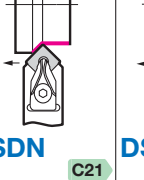
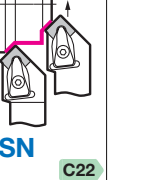


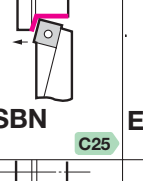
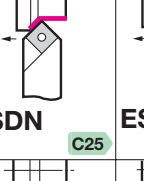
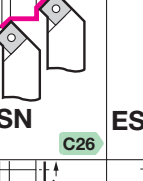
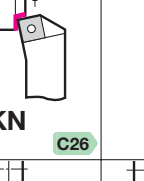

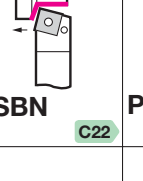
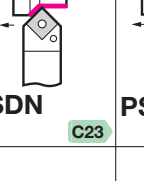
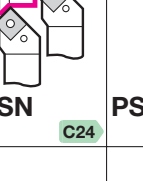

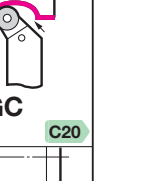

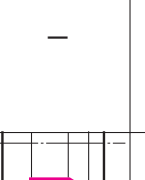
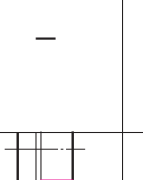
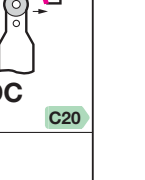
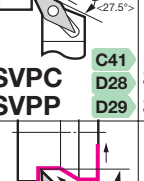
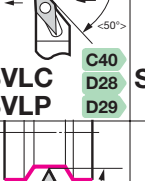
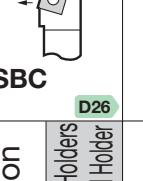
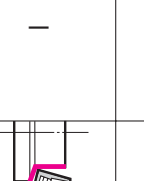
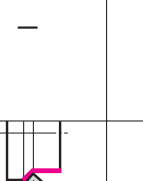

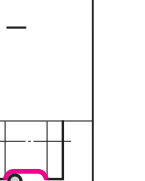
External Tool Holder Series

Performance Comparison Table

Series	Clamp Mechanism						Rake Angle		Clamp Rigidity	Operability	Indexing Accuracy	Chip Control
	P Lever Lock	E Pin Lock	C Lever Lock	M Pin & Clamp-on	S Screw-on	D Double Clamp	Negative	Positive				
SumiTurn T-REX Tool Holders						○	○	○	◎	◎	◎	○
SEC-D series Holders						○	○	◎	◎	◎	◎	○
SEC-70 series Holder	○						○	○	◎	◎	◎	◎
SEC-30 series Holder		○					○	○	△	○	△	◎
SEC-M series Holders				○			○	○	◎	◎	○	○
SUMIBORON PR series Holders	○							○	◎	◎	◎	◎

◎ mark: Very good (1st recommendation) ◎ mark: Very good ○ mark: Good △ mark: OK

Tooling Selection

Applications		General Turning	General Turning and Profiling	General Turning				Special Turning	
Insert Shape		Trigon type W	35° Diamond type V	Square type S				Round type R	
Structure	Type								
Double Clamp	M series Tool Holders	 MWLN C43	 DVJN-J DVJN C38 Internal Coolant	 DVVN C39	 DSBN C21	 DSDN C21	 DSSN C22	-	
	D series Tool Holders	 DWLN-J DWLN C42	 DVQN C39	-	-	-	-	-	
Pin Lock	30 series Tool Holders	-	-	 ESBN C25	 ESDN C25	 ESSN C26	 ESKN C26	-	
Lever Lock	70 series Tool Holders	 PWLN C43	-	 PSBN C22	 PSDN C23	 PSSN C24	 PSKN C24	 PRGC C20	
	Mini Holders	-	 SVPC C41 D28 SVPP D29	 SVLC C40 D28 SVLP D29	 SSBC D26	-	-	 PRDC C20	
Screw-on	SV series Profiling Tool Holders	-	 SVJC C40 D20	 SVVC C41	 Clamp-on	 CSRP [FP11] C27	 CSDP [FP14] C27	 CSKP [FP15] C28	 BNRN L139
	40 series Tool Holders Roll Turning Tool Holder	-	-	-	-	-	-	-	

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

External Holder 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) Cutting Edge Shape Code (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

DTFN R2525M16

- Structure: Double Clamp Method
- Shape: With Triangle Insert, Cutting 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 is supported by 2 faces)	
E	Pin Lock (Insert is supported by 1 face)		S	Screw-on	

Table 2

(2) Insert Shape					
Symbol	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	Hexagonal type	V	35° Apex Angle Diamond type		
K	55° Apex Angle Parallelogram	W	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) Cutting Edge Shape Code (— 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

In previous cat. nos., the inscribed circle and insert thickness symbols are combined and displayed as a 2 digit code.

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 Dimensions and Corner Radius

● Cutting position dimensions by corner radius (ISO standard) (Values for X and Y in the table are with lateral rake angle and cutting edge inclination 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			

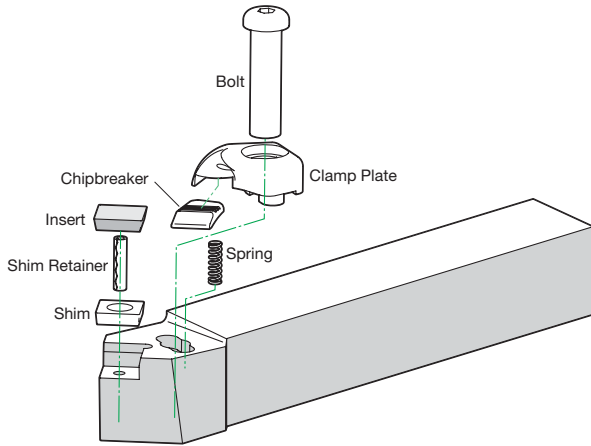
SEC- External Holder Clamp Structure

SEC-External Holder Clamp Structure List (Examples)

External Holders

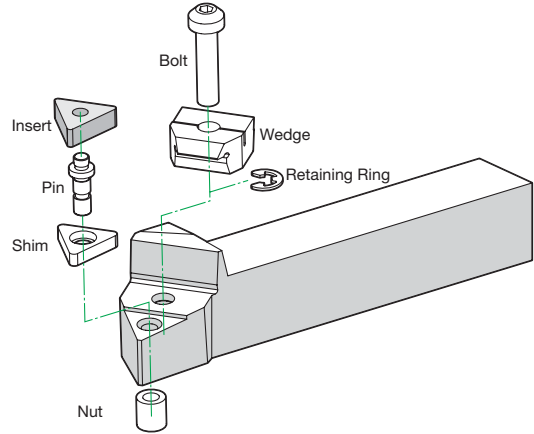
C Clamp-on

CSRP type / CSDP type / CSKP type / CTGP type / CTAP type / CTFP type



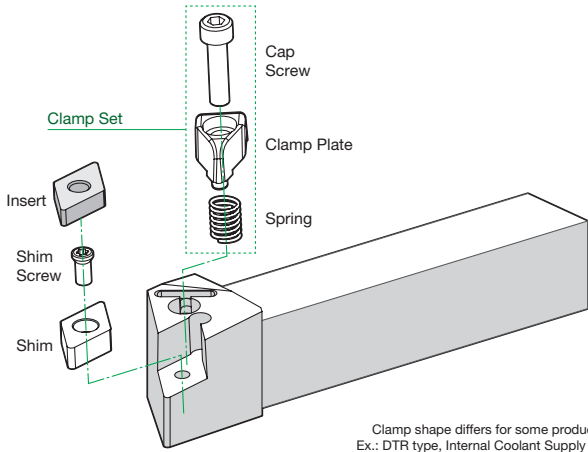
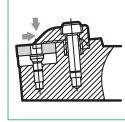
M Top Clamp + Pin Lock

MTJN type / MTXN type / MWLN type



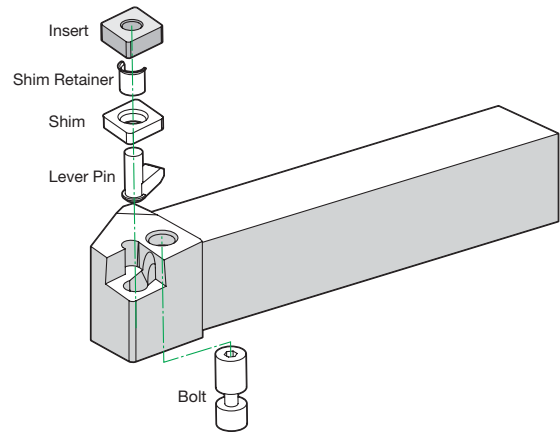
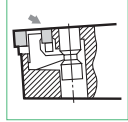
D Double Clamp

DCLN(-J) type / DDJN(-J) type / DDHN type / DDNN type
 DSDN type / DSDN type / DSSN type / DTGN type / DTFN type
 DVJN(-J) type / DVVN type / DVQN type / DWLN(-J) type / DTR type (T-REX)



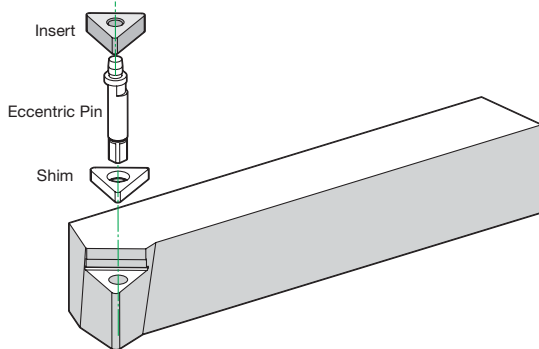
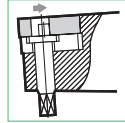
P Lever Lock

PCLN type / PCBN type / PCFN type / PDJN type
 PRGC type / PRDC type / PSBN type / PSDN type / PSSN type / PSKN type
 PTGN type / PTTN type / PTFN type / PWLN type



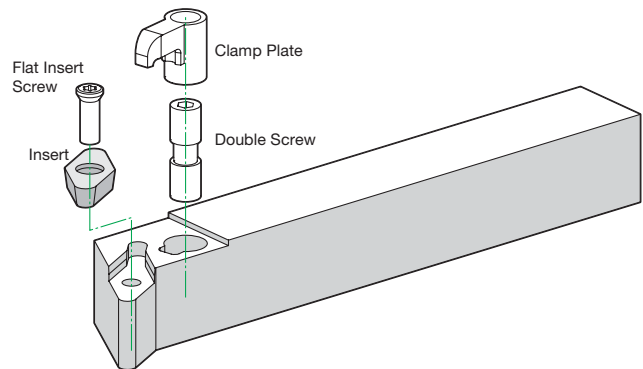
E Pin Lock

ESBN type / ESDN type / ESSN type / ESKN type
 ETGN type / ETAN type / ETFN type / ETEN type / ETXN type

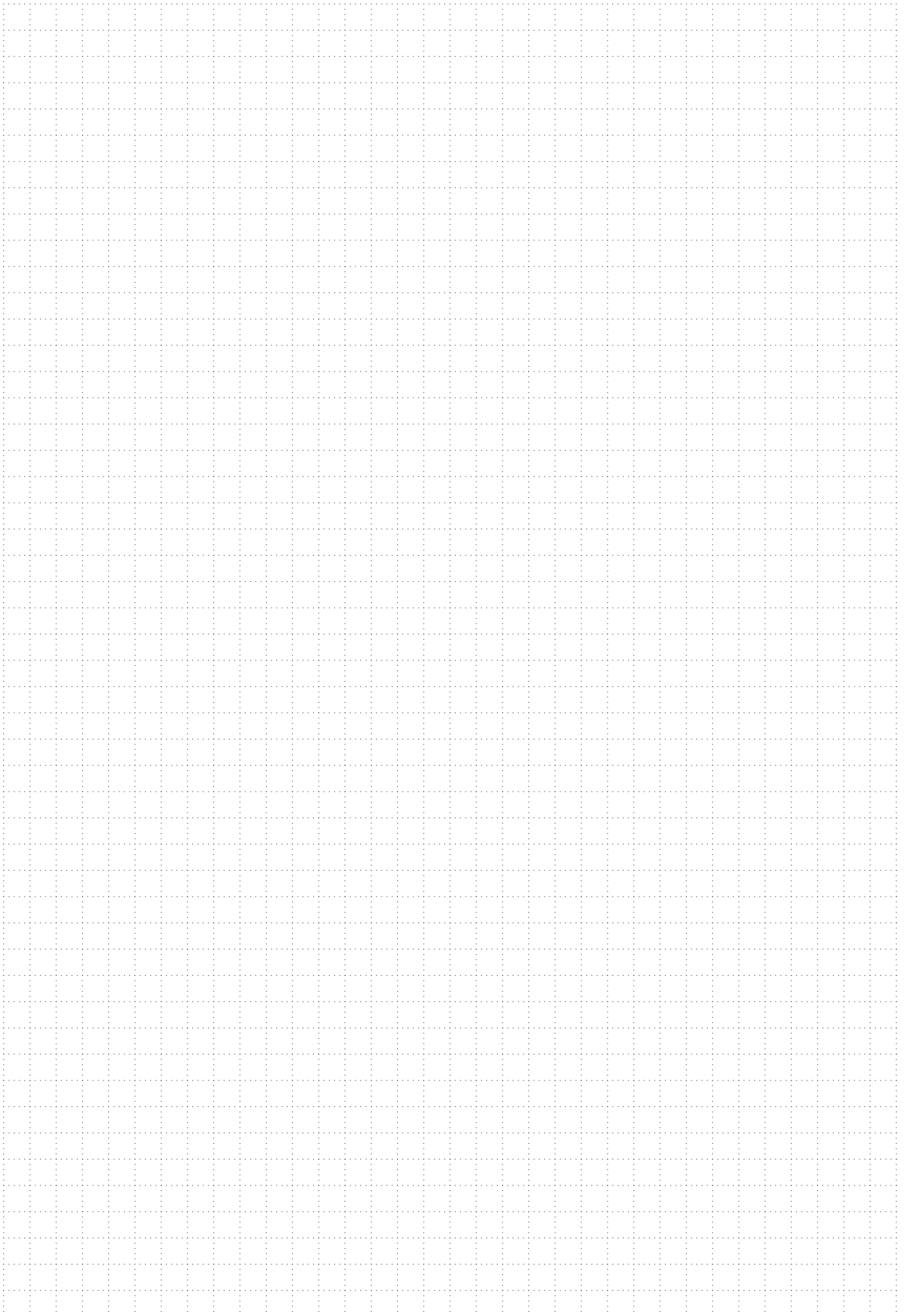


Screw-on + Clamp-on

MVXC type Profiling Tool Holders / MVPC type Profiling Tool Holders



MEMO



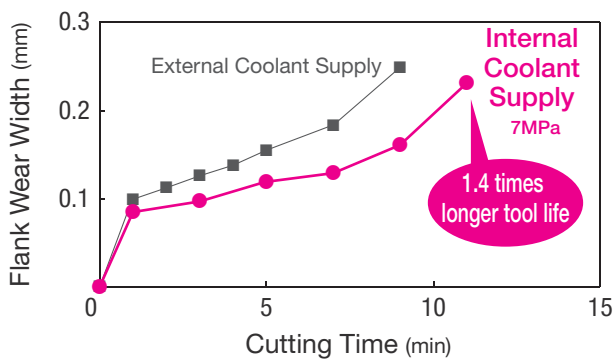
Internal Coolant Holders



■ Features

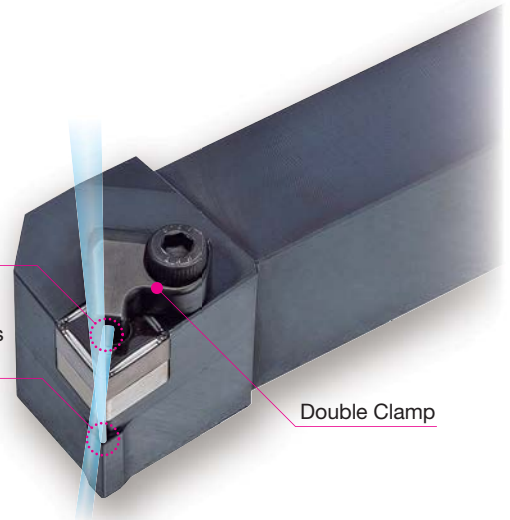
- Through-clamp internal coolant supply holder improves chip evacuation and tool life
- Enables directed coolant supply from a close range, towards the cutting edge
- Suppresses flank wear with additional coolant supply to the flank face
- Realises high rigidity and indexing accuracy with double clamping
- 1st recommendation for external holder selection

■ Wear Resistance



Coolant supply near the rake face directed at the cutting edge

Coolant supply from the bottom suppresses flank wear

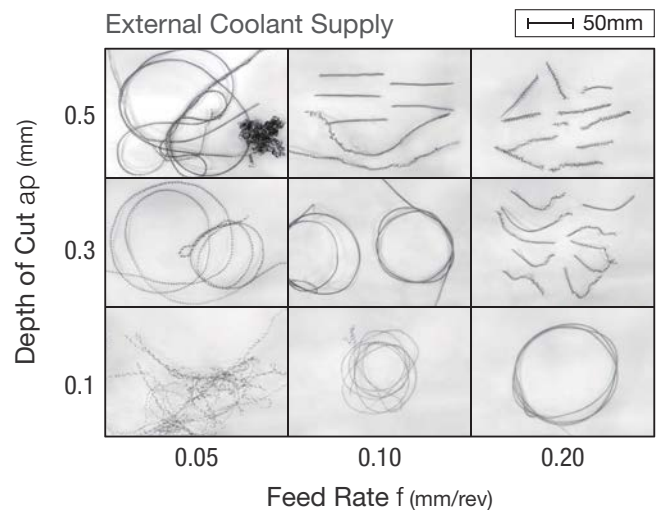
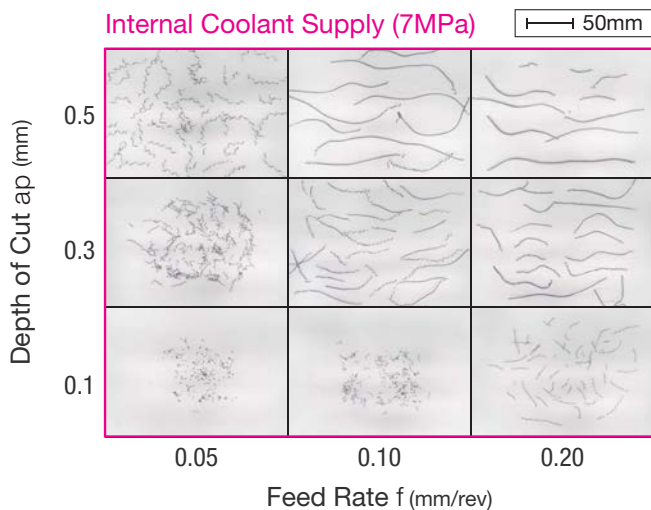


Double Clamp

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 accelerated testing.

■ Chip Evacuation



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

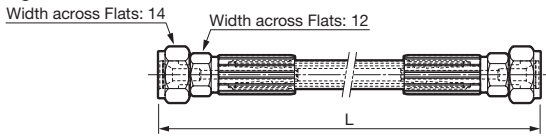


Fig 1

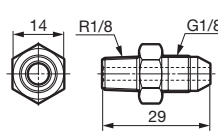
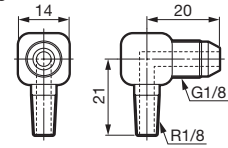


Fig 2



Parts (Hose)

Cat. No.	Stock	L	Screw Standard	Screw Standard	Fig
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

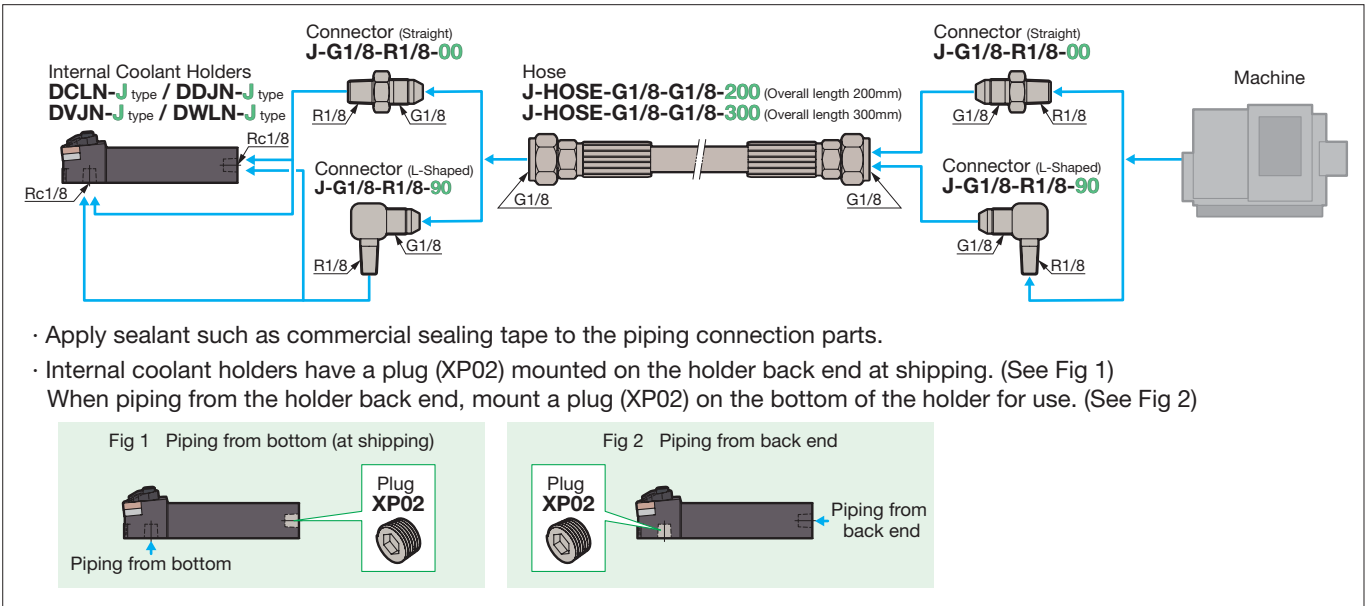
Hoses are sold separately.

Parts (Connector)

Cat. No.	Stock	Screw Standard	Screw Standard	Fig
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



Precautions for SEC-External Holders / Internal Coolant Holders

Insert Removal Precautions

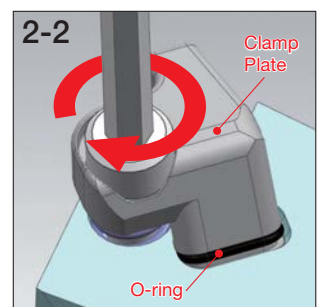
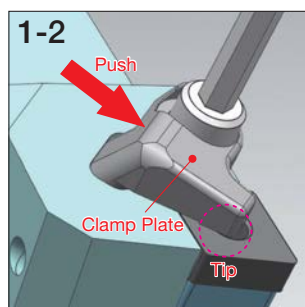
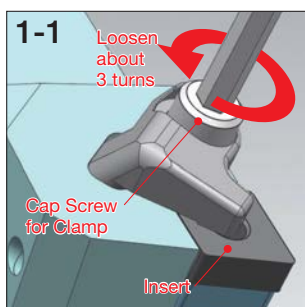
- Use a wrench to loosen the cap screw for clamp by about three turns, and then remove the insert. (Fig 1-1 below)
- If the clamp plate tip catches on the insert when removing, push the clamp plate in the arrow direction as in Fig 1-2 below.

Precautions for Removing and Assembling O-Rings and Clamps

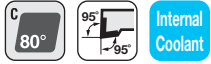
- O-rings are consumable parts. If worn or damaged, replace with a new O-ring as stipulated.
- When replacing, remove the cap screw and then remove the clamp from the body. (Be careful not to lose the spring).
- Remove the old O-ring from the clamp plate, clean the clamp plate groove, and then set the new O-ring so that it fits entirely into the groove.
- When setting the clamp plate, as in Fig 2-1 below, place the spring and then set and tighten the clamp plate and cap screw to mount the clamp plate on the body. (Fig 2-2 below) **Be careful at this point that the O-ring does not protrude.**
- When mounting the clamp plate, **do not tighten the cap screw forcefully all the way to the bottom** without setting the insert.

Others

- Coolant pressure supports up to **max. 15MPa**.
- To maximize coolant effects on the flank and prevent holder interference, use with an insert of **corner radius RE0.4 to 1.2mm**.



DCLN-J type / DCLN type



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

External Holders

C

Negative

Positive

C

D

R

S

T

V

W

Special

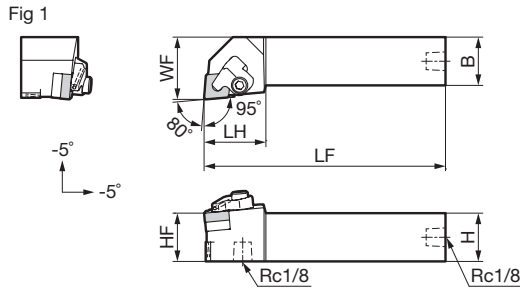
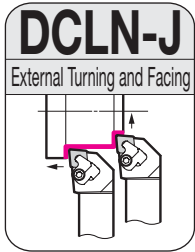


Figure shows right-handed (R) tool.

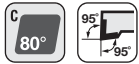
Holder

Parts

Dimensions (mm)

Cat. No.	Stock		Height H	Width B	Overall Length LF	Cutting Edge Width WF	Cutting Edge Height HF	Head LH	Applicable Insert		Clamp Plate	Cap Screw	Spring	O-ring	Shim	Shim Screw	Wrench for Shim	Top Hex Wrench	Bottom Hex Wrench	Plug		
	R	L							Cat. No.	Ref. Page												
DCLN R/L2020K12-J	●	●	20	20	125	25	20	32	CN□□1204	B16	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.



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

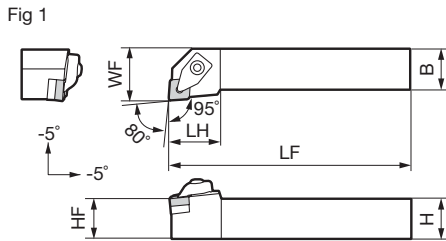
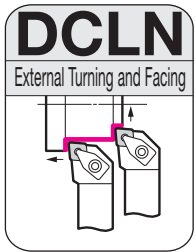


Figure shows right-handed (R) tool.

Holder

Parts

Dimensions (mm)

Cat. No.	Stock		Height H	Width B	Overall Length LF	Cutting Edge Width WF	Cutting Edge Height HF	Head LH	Applicable Inserts		Clamp Set		Shim	Shim Screw	Wrench for Shim	Top Hex Wrench	Bottom Hex Wrench			
	R	L							Cat. No.	Ref. Page	Fig	N-m								
DCLN R/L2020K12	●	●	20	20	125	25	20	32	CN□□1204	B16	1	1	SCP-2	5.0	CNS1204	BFTX0409N	TRX15(*)	LH040	LH025	
DCLN R/L2525M12	●	●	25	25	150	32	25	32												
DCLN R/L2525M16	●	●	25	25	150	32	25	32	CN□□1606	B20	1	1	SCP-3	5.0	CNS1606	BFTX0509N	TRX20(*)	LH040	LH025	
DCLN R/L3232P16	●	●	32	32	170	40	32	32												
DCLN R/L3232P19	●	●	32	32	170	40	32	42	CN□□1906	B22	1	1	SCP-5	5.0	CNS1906	BFTX0511N	TRX20(*)	LH040	LH025	
DCLN R/L4040S19	●	●	40	40	250	50	40	42												
DCLN R/L4040S25	●	●	40	40	250	50	40	53	CN□□2509	B24	1	1	SCP-6	6.0	CNS2509	BFTX0615N	TRD25(*)	LH060	—	

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

Clamp Set Parts **C48**

Note: The values in red (cutting edge WF) have been changed from those in the 2021-2022 General Catalogue.

PCLN type

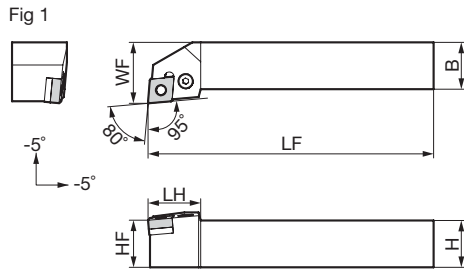
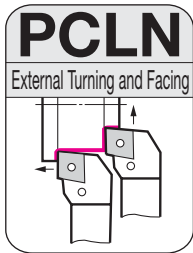
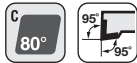


Figure shows right-handed (R) tool.

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

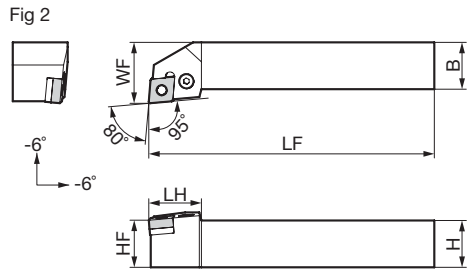


Figure shows right-handed (R) tool.

Holder

Parts

Dimensions (mm)

Cat. No.	Previous Cat. No.	Stock		Height	Width	Overall Length	Cutting Edge	Cutting Edge Height	Head	Applicable Inserts		Lever Pin	Bolt	Shim	Shim Retainer	Wrench	
		R	L							Cat. No.	Ref. Page						
PCLN R/L1616H0903	PCLN R/L1616-32	●	●	16	16	100	20	16	20	CN□□0903	B14	1	LCL3	LCS3	LSC32	LSP3	LH025
PCLN R/L2020K0904	PCLN R/L2020-33	●	●	20	20	125	25	20	20	CN□□0904	B15	1	LCL3	LCS3	LSC317	LSP3	LH025
PCLN R/L2525M0904	PCLN R/L2525-33	●	●	25	25	150	32	25	20			1					
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	CN□□1204	B16~	1	LCL4	LCS4	LSC42	LSP4	LH030
PCLN R/L3225P12	PCLN R/L3225-43	●	●	32	25	170	32	32	28			1					
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			1					
PCLN R/L3225P16	PCLN R/L3225-54	●	●	32	25	170	32	32	33	CN□□1606	B20~	1	LCL5	LCS5	LSC53	LSP5	LH030
PCLN R/L3232P16	PCLN R/L3232-54	●	●	32	32	170	40	32	33			1					
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	CN□□1906	B22~	2	LCL6	LCS6	LSC63	LSP6	LH040
PCLN R/L4040R19	PCLN R/L4040-64	●	●	40	40	200	50	40	38			2					

External Holders



Negative

Positive

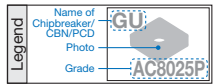


Special

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

1st Recommended Insert

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



Application 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 BN7125/BNC500	UZ AC4010K	GZ AC4010K	EF AC5015S	EG AC5015S	EM AC5015S	SUMIDIA DA1000	AX H1	SUMIBORON BNC2115	SUMIBORON BN1000
General Machining	SU AC8015P	GU AC8025P	MU AC8025P	EF AC6030M	EG AC6030M	EM AC6040M	SUMIBORON BN7125/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 BN7125/BNC500	GZ AC420K	No Chipbreaker AC420K	EF AC5025S	EG AC5025S	EM AC5025S	SUMIDIA DA1000	-	SUMIBORON BNC300	SUMIBORON BN350
Recommended Cutting Conditions	A10~			A14~			A16~			A18~			A22~		A20~	

BN7125 is for ductile cast iron.

PCBN type / PCFN type



SEC-70 Holder - General Turning
Lever Lock

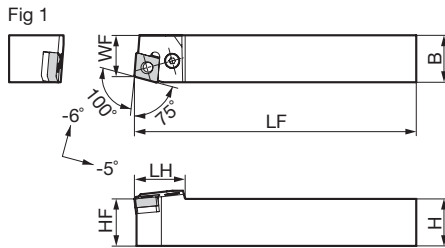
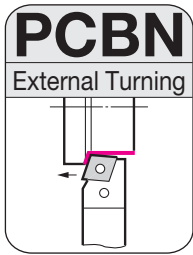


Figure shows right-handed (R) tool.

Holder

Parts

Dimensions (mm)

Cat. No.	Previous Cat. No.	Stock		Height	Width	Overall Length	Cutting Edge	Cutting Edge Height	Head	Applicable Inserts		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	B16~	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								
PCBN R/L2525M16	PCBN R/L2525-54			25	25	150	22	25	33	CN□□1606	B20~	1	LCL5	LCS5	LSC53	LSP5	LH030
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								
PCBN R/L3232P19	PCBN R/L3232-64			32	32	170	27	32	38	CN□□1906	B22~	1	LCL6	LCS6	LSC63	LSP6	LH040
PCBN R/L4040R19	PCBN R/L4040-64			40	40	200	35	40	38								



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

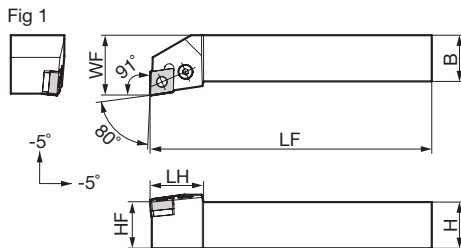
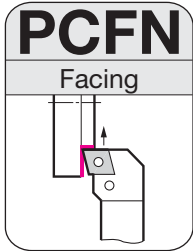


Figure shows right-handed (R) tool.

Holder

Parts

Dimensions (mm)

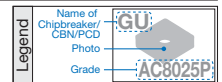
Cat. No.	Previous Cat. No.	Stock		Height	Width	Overall Length	Cutting Edge	Cutting Edge Height	Head	Applicable Insert		Lever Pin	Bolt	Shim	Shim Retainer	Wrench	
		R	L							Cat. No.	Ref. Page						
PCFN R/L2020K12	PCFN R/L2020-43	●	●	20	20	125	25	20	28	CN□□1204	B16~	1	LCL4	LCS4	LSC42	LSP4	LH030
PCFN 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								

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

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

1st Recommended Insert

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



Application 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 BN7125/BNC500	UZ AC4010K	GZ AC4010K	EF AC5015S	EG AC5015S	EM AC5015S	SUMIDIA DA1000	AX H1	SUMIBORON BNC2115	SUMIBORON BN1000
General Machining	SU AC8015P	GU AC8025P	MU AC8025P	EF AC6030M	EG AC6030M	EM AC6040M	SUMIBORON BN7125/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 BN7125/BNC500	GZ AC420K	No Chipbreaker AC420K	EF AC5025S	EG AC5025S	EM AC5025S	SUMIDIA DA1000	-	SUMIBORON BNC300	SUMIBORON BN350
Recommended Cutting Conditions	A10~			A14~			A16~			A18~			A22~		A20~	

BNC500 is for ductile cast iron.

SCLC type



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

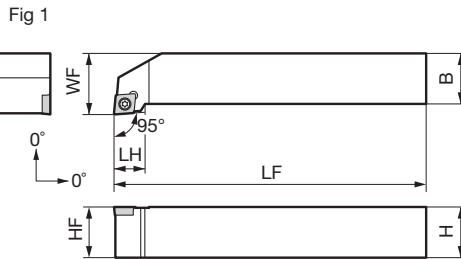


Figure shows right-handed (R) tool.

Holder

Parts

Dimensions (mm)

Cat. No.	Previous Cat. No.	Stock		Height H	Width B	Overall Length LF	Cutting Edge Width WF	Cutting Edge Height HF	Head LH	Applicable Inserts		Flat Insert Screw		Wrench		
		R	L							Cat. No.	Ref. Page	Fig	N·m			
SCLC R/L0808H06	SCLC R/L0808-06	●	●	8	8	100	10	8	—	CC□□0602	B70~	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	25	20	15		CC□□09T3	B73~	1	BFTX0409N	3.4	TRX15
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.

Note: The values in red (cutting edge WF) have been changed from those in the 2021-2022 General Catalogue.

Applicable Inserts ◀ SCLC type

1st Recommended Insert

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

Application 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 Machining	FB T1500Z	GU AC8025P	MU AC8025P	LB AC6030M	GU AC6030M	MU AC6040M	SUMIBORON BN7125/BNCS00	MU AC4015K	No Chipbreaker AC4015K	SU AC5015S	SUMIDIA DA1000	AG H1	SUMIBORON BNC2125	SUMIBORON BN2000	SUMIDIA DA90
High-precision	FF AC1030U	SI AC1030U	SC AC1030U	FF AC1030U	SI AC1030U	SC AC1030U	SUMIBORON BN7125/BNCS00	—	—	SI AC5015S	SUMIDIA DA1000	—	SUMIBORON BNC2115	SUMIBORON BN1000	SUMIDIA BINDERLESS NPD10
Recommended Cutting Conditions	A10-			A14-			A16-			A18-	A22-		A20-		M2-

BNCS00 is for ductile cast iron.

Recommended Tightening Torque (N·m)

DDJN-J type / DDJN type



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

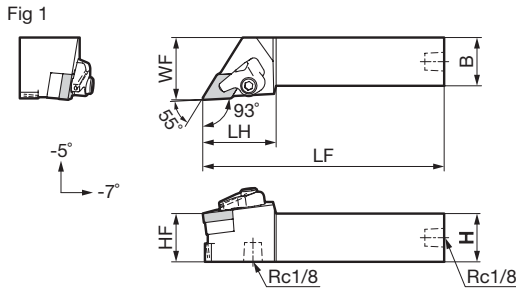
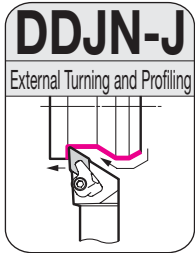


Figure shows right-handed (R) tool.

Holder

Parts

Dimensions (mm)

Cat. No.	Stock		Height	Width	Overall Length	Cutting Edge	Cutting Edge Height	Head	Applicable Inserts		Clamp Plate	Cap Screw	Spring	O-ring	Shim	Shim Screw	Wrench for Shim	Top Hex Wrench	Bottom Hex Wrench	Plug		
	R	L							H	B											LF	WF
DDJN R/L2020K15-J	●	●	20	20	125	25	20	38	DN□□1504	B26~	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	B26~	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	B30~	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.



SEC-D Holder - General Turning and Profiling
Double Clamp

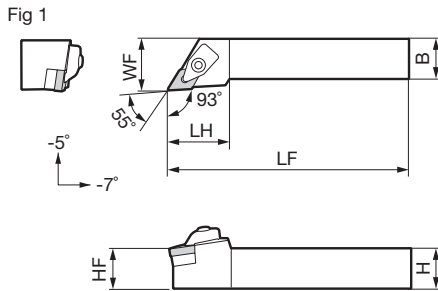
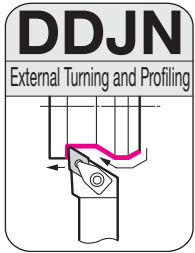


Figure shows right-handed (R) tool.

Holder

Parts

Dimensions (mm)

Cat. No.	Stock		Height	Width	Overall Length	Cutting Edge	Cutting Edge Height	Head	Applicable Inserts		Clamp Set		Shim	Shim Screw	Wrench for Shim	Top Hex Wrench	Bottom Hex Wrench	
	R	L							H	B	LF	WF						Hf
DDJN R/L2020K15	●	●	20	20	125	25	20	38	DN□□1504	B26~	1	SCP-2	5.0	DNS1504	BFTX0409N	TRX15(*)	LH040	LH025
DDJN R/L2525M15	●	●	25	25	150	32	25	38	DN□□1504	B26~	1	SCP-2	5.0	DNS1504	BFTX0409N	TRX15(*)	LH040	LH025
DDJN R/L2525M15E	●	●	25	25	150	32	25	38	DN□□1506	B30~	1	SCP-2	5.0	DNS1506	BFTX0409N	TRX15(*)	LH040	LH025

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

Clamp Set Parts **C48**

Note: The values in red (cutting edge WF) have been changed from those in the 2021-2022 General Catalogue.

External Holders

Negative

Positive

C

D

R

S

T

V

W

Special

DDHN type / DDNN type



SEC-D series Holder - General Turning and Profiling Double Clamp

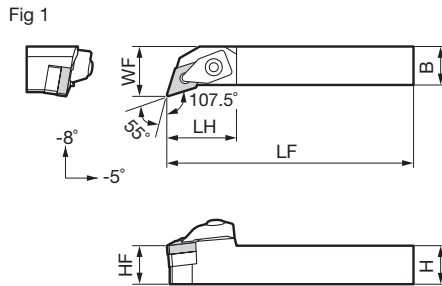
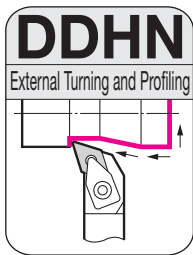


Figure shows right-handed (R) tool.

Holder

Parts

Dimensions (mm)

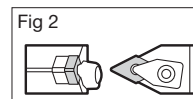
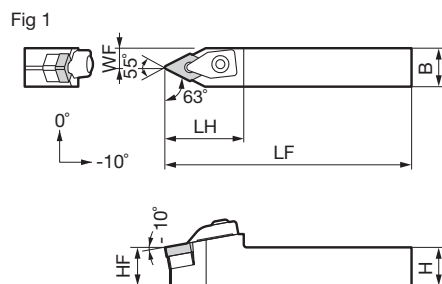
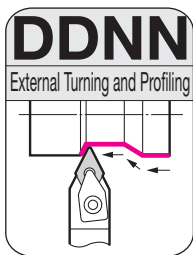
Cat. No.	Stock		Height	Width	Overall Length	Cutting Edge	Cutting Edge Height	Head	Applicable Insert		Fig	Clamp Set		Shim	Shim Screw	Wrench for Shim	Top Hex Wrench	Bottom Hex Wrench
	R	L							H	B		Cat. No.	Ref. Page					
DDHN R/L2020K15	●	●	20	20	125	25	20	35	DN□□1504	B26~	1	SCP-2	5.0	DNS1504	BFTX0409N	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 **C48**



SEC-D series 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 Shim	Top Hex Wrench	Bottom Hex Wrench
	H	B							H	B		Cat. No.	Ref. Page					
DDNN N2020K15	●	●	20	20	125	10.5	20	40	DN□□1504	B26~	1	SCP-2	5.0	DNS1504	BFTX0409N	TRX15(*)	LH040	LH025
DDNN N2525M15	●	●	25	25	150	13.0	25	40			2							

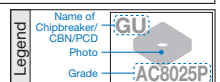
*Wrench for shim is sold separately from the main body.

Clamp Set Parts **C48**

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

1st Recommended Insert

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



Application 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 BN7125/BNC500	UZ AC4010K	GZ AC4010K	EF AC5015S	EG AC5015S	EM AC5015S	SUMIDIA DA1000	AX H1	SUMIBORON BNC2115	SUMIBORON BN1000	SUMIDIA NPD10
General Machining	SU AC8015P	GU AC8025P	MU AC8025P	EF AC6030M	EG AC6030M	EM AC6040M	SUMIBORON BN7125/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 BN7125/BNC500	GZ AC420K	No Chipbreaker AC420K	EF AC5025S	EG AC5025S	EM AC5025S	SUMIDIA DA1000	—	SUMIBORON BNC300	SUMIBORON BN350	—
Recommended Cutting Conditions	A10~			A14~			A16~			A18~			A22~		A20~		M2~

PDJN type



SEC-70 Holder - General Turning and Profiling
Lever Lock

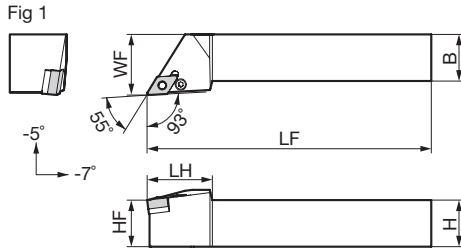
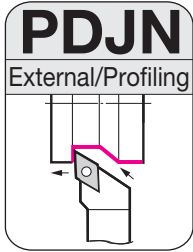


Figure shows right-handed (R) tool.

Holder

Parts

Dimensions (mm)

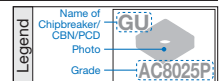
Cat. No.	Previous Cat. No.	Stock		Height	Width	Overall Length	Cutting Edge	Cutting Edge Height	Head	Applicable Inserts		Lever Pin	Bolt	Shim	Shim Retainer	Wrench	
		R	L							Cat. No.	Ref. Page						
PDJN R/L2020K11	PDJN R/L2020-33	●	●	20	20	125	25	20	25	DN□□1104	B25~	1	LCL3	LCS3	LSD317	LSP3	LH025
PDJN 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			1					
PDJN R/L2525M1504	PDJN R/L2525-43	●	●	25	25	150	32	25	35	DN□□1504	B26~	1	LCL4	LCS4	LSD42	LSP4	LH030
PDJN R/L3225P1504	PDJN R/L3225-43	●	●	32	25	170	32	32	35			1					
PDJN R/L3232P1504	PDJN R/L3232-43	●	●	32	32	170	40	32	35			1					
PDJN R/L2525M1506	PDJN R/L2525-44	●	●	25	25	150	32	25	35			1	LCL4	LCS4	LSD42	LSP4	LH030
PDJN R/L3225P1506	PDJN R/L3225-44	●	●	32	25	170	32	32	35	DN□□1506	B30~	1	LCL4	LCS4	LSD42	LSP4	LH030
PDJN R/L3232P1506	PDJN R/L3232-44	●	●	32	32	170	40	32	35			1					

- External Holders
- C
- Negative
- Positive
- C
- D
- R
- S
- T
- V
- W
- Special

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

1st Recommended Insert

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



Application 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 BN7125/BNC500	UZ AC4010K	GZ AC4010K	EF AC5015S	EG AC5015S	EM AC5015S	SUMIDIA DA1000	AX H1	SUMIBORON BNC2115	SUMIBORON BN1000	SUMIDIA BINDERLESS NPD10
General Machining	SU AC8015P	GU AC8025P	MU AC8025P	EF AC6030M	EG AC6030M	EM AC6040M	SUMIBORON BN7125/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 BN7125/BNC500	GZ AC420K	No Chipbreaker AC420K	EF AC5025S	EG AC5025S	EM AC5025S	SUMIDIA DA1000	—	SUMIBORON BNC300	SUMIBORON BN350	—
Recommended Cutting Conditions	I A10~			I A14~			I A16~			I A18~			I A22~		I A20~		I M2~

T-REX Tool Holders



External Profiling
Double Clamp

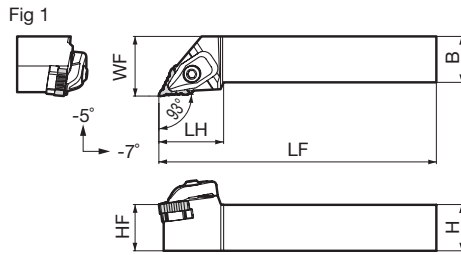


Figure shows right-handed (R) tool.

Holder

Parts

Dimensions (mm)

Cat. No.	Stock		Height H	Width B	Overall Length LF	Cutting Edge WF	Cutting Edge Height HF	Head LH	Fig	Clamp Plate	Spring	Cap Screw	Shim	Shim Screw	Wrench	Wrench for Shim	
	R	L								TRCP3	S-SP4-20	BX0520	N-m	TRW5505	BFTX0307N	TSW040	TRX10(*)
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 **IC E34**



External Profiling
Double Clamp

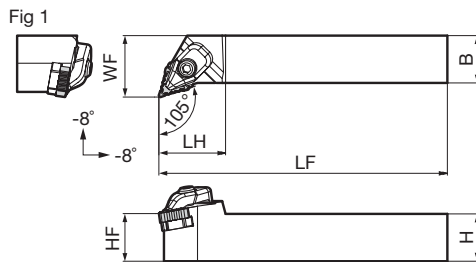


Figure shows right-handed (R) tool.

Holder

Parts

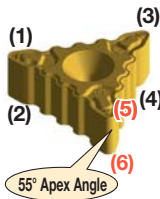
Dimensions (mm)

Cat. No.	Stock		Height H	Width B	Overall Length LF	Cutting Edge WF	Cutting Edge Height HF	Head LH	Fig	Clamp Plate	Spring	Cap Screw	Shim	Shim Screw	Wrench	Wrench for Shim	
	R	L								TRCP3	S-SP4-20	BX0520	N-m	TRW5505	BFTX0307N	TSW040	TRX10(*)
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(*)

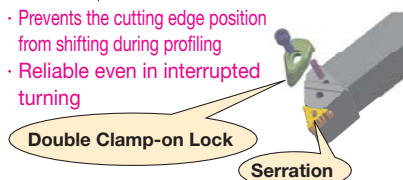
*Wrench for shim is sold separately from the main body.

■ Features

- 55° Apex 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 turning

● T-REX Insert/Tool Holder Identification

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

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

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

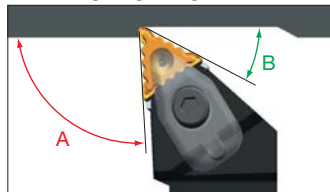
■ Important Notes

- Depth of Cut



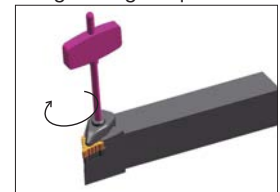
Maximum depth of cut should be 2.5mm.

- 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)

External Holders

C

Negative

Positive

C

D

R

S

T

V

W





Special

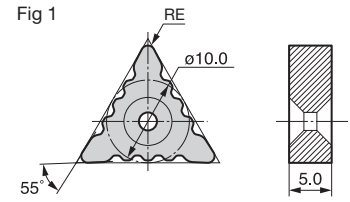
T-REX Tool Holders



Insert (Coated Carbide / Cermet)

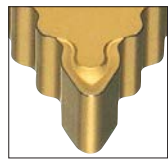
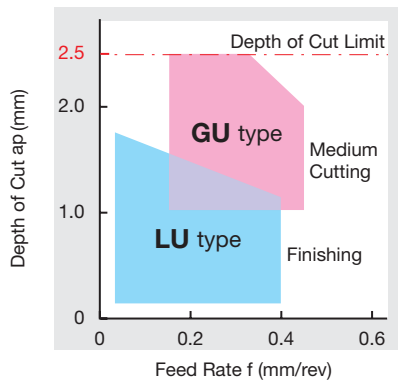
Dimensions (mm)

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

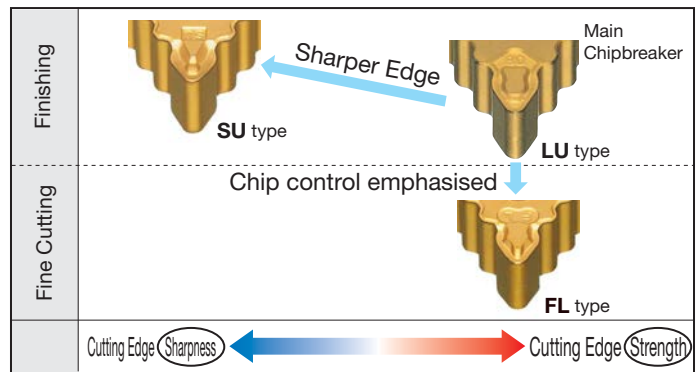


Chipbreaker Application Range

Main Chipbreakers



Finishing Sub-Chipbreakers



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

Insert Grades		AC810P	AC8025P	AC820P	AC830P	AC630M	T3000Z
Grade Classification		Coating	Coating	Coating	Coating	Coating	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

SDJC type



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

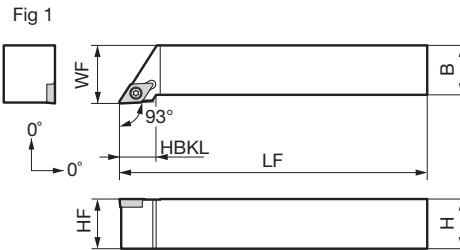
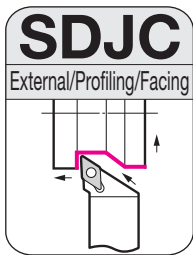


Figure shows right-handed (R) tool.

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 Inserts		Flat Insert Screw			Wrench
		R	L							Cat. No.	Ref. Page	Fig			
SDJC R/L0808H07	SDJC R/L0808-07	●		8	8	100	10	8	15	DC□□0702	B80~	1		1.5	TRX08
SDJC R/L1010H07	SDJC R/L1010-07	●	●	10	10	100	12	10	18			1			
SDJC R/L1212H11	SDJC R/L1212-11	●	●	12	12	100	16	12	18			1			
SDJC R/L1616H11	SDJC R/L1616-11	●	●	16	16	100	20	16	18			1			
SDJC R/L2020K11	SDJC R/L2020-11	●	●	20	20	125	24	20	18	DC□□11T3	B84~	1		3.4	TRX15
SDJC R/L2525M11	SDJC R/L2525M11	●	●	25	25	150	29	25	18			1			

External Holders

C

Negative

Positive

C

D

R

S

T

V

W

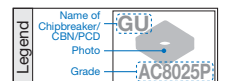
Special

Applicable Inserts ◀ SDJC type

1st Recommended Insert

● Refer as well to the Insert Selection Guide (A10~).

● Depending on the insert size, some combinations cannot be made-to-order or manufactured.



Application 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 Machining									No Chipbreaker						
	T1500Z	AC8025P	AC8025P	AC6030M	AC6030M	AC6030M	BN7125/BN C500	AC4015K	AC4015K	AC5015S	DA1000	H1	BNC2125	BN2000	DA90
High-precision								—	—			—			
	AC1030U	AC1030U	AC1030U	AC1030U	AC1030U	AC1030U	BN7125/BN C500	—	—	AC5015S	DA1000	—	BNC2115	BN1000	NPD10
Recommended Cutting Conditions	A10~			A14~			A16~			A18~	A22~	—	A20~		M2~

BN C500 is for ductile cast iron.

PRGC type / PRDC type



SEC-70 Holder - General Turning and Profiling
Lever Lock

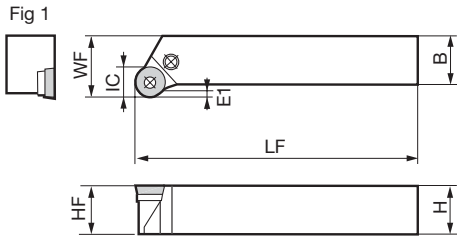
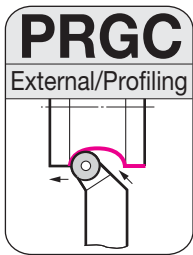


Figure shows right-handed (R) tool.

Holder

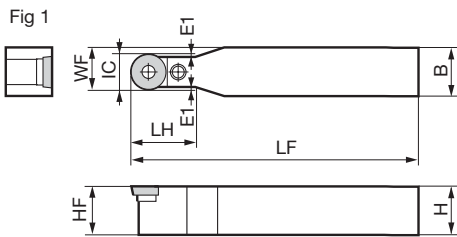
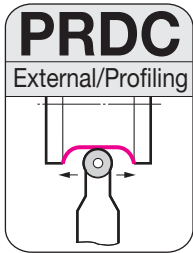
Parts

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 Inserts		Lever Pin Fig	Bolt	Shim	Shim Retainer	Wrench <small>(For Hexagonal hole)</small>	
	R	L								Cat. No.	Ref. Page						
PRGC R/L2020K10	●	●	20	20	125	25	20	1.5	10	RCM□1003M0	B88	1	LCL10	LCS10	LSR10	LSP10	LH020
PRGC R/L2525M10	●	●	25	25	150	32	25	1.5	10	RCM□1003M0	B88	1	LCL10	LCS10	LSR10	LSP10	LH020
PRGC R/L2020K12	●	●	20	20	125	25	20	2.5	12	RCM□1204M0	B88	1	LCL12	LCS12	LSR12	LSP10	LH025
PRGC R/L2525M12	●	●	25	25	150	32	25	2.5	12	RCM□1204M0	B88	1	LCL12	LCS12	LSR12	LSP10	LH025
PRGC R/L3225P12	●	●	32	25	170	32	32	2.5	12	RCM□1204M0	B88	1	LCL12	LCS12	LSR12	LSP10	LH025
PRGC R/L2525M16	●	●	25	25	150	32	25	3.0	16	RCM□1606M0	B88	1	LCL16	LCS16	LSR16	LSP16	LH025
PRGC R/L3225P16	●	●	32	25	170	32	32	3.0	16	RCM□1606M0	B88	1	LCL16	LCS16	LSR16	LSP16	LH025
PRGC R/L3232P20	●	●	32	32	170	40	32	4.0	20	RCM□2006M0	B88	1	LCL20	LCS20	LSR20	LSP20	LH030
PRGC R/L4040S25	●	●	40	40	250	50	40	4.5	25	RCM□2507M0	B88	1	LCL25	LCS25	LSR25	LSP25	LH040
PRGC R/L5050T32	●	●	50	50	300	63	50	5.5	32	RCM□3209M0	B88	1	LCL32	LCS32	LSR32	LSP32	LH050



SEC-70 Holder - General Turning and Profiling
Lever Lock



Holder

Parts

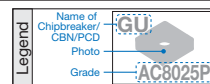
Dimensions (mm)

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 Inserts		Lever Pin Fig	Bolt	Shim	Shim Retainer	Wrench <small>(For Hexagonal hole)</small>	
										Cat. No.	Ref. Page						
PRDC N2020M10	●	20	20	150	15.0	20	22	1.0	10	RCM□1003M0	B88	1	LCL10	LCS10	LSR10	LSP10	LH020
PRDC N2525M10	●	25	25	150	17.5	25	22	1.0	10	RCM□1003M0	B88	1	LCL10	LCS10	LSR10	LSP10	LH020
PRDC N2525M12	●	25	25	150	18.5	25	24	1.2	12	RCM□1204M0	B88	1	LCL12	LCS12	LSR12	LSP10	LH025
PRDC N3225Q12	●	32	25	180	18.5	32	24	1.2	12	RCM□1204M0	B88	1	LCL12	LCS12	LSR12	LSP10	LH025
PRDC N3225Q16	●	32	25	180	20.5	32	28	1.5	16	RCM□1606M0	B88	1	LCL16	LCS16	LSR16	LSP16	LH025
PRDC N3232Q20	●	32	32	180	26.0	32	32	1.7	20	RCM□2006M0	B88	1	LCL20	LCS20	LSR20	LSP20	LH030
PRDC N4040T25	●	40	40	300	32.5	40	42	2.0	25	RCM□2507M0	B88	1	LCL25	LCS25	LSR25	LSP25	LH040
PRDC N5050U32	●	50	50	350	41.0	50	52	2.5	32	RCM□3209M0	B88	1	LCL32	LCS32	LSR32	LSP32	LH050

Applicable Inserts ◀ PRGC type / PRDC type

1st Recommended Insert

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



Application range	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 Machining	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	Vc A10~			Vc A16~		Vc A18~	

DSBN type / DSDN type



SEC-D series Holder - General Turning and Profiling Double Clamp

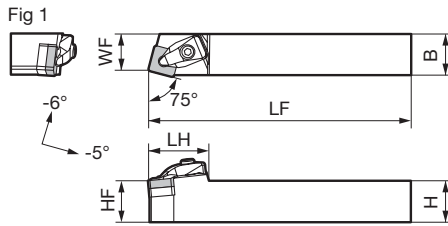
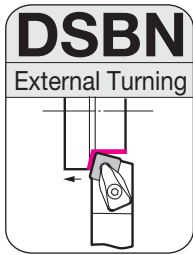


Figure shows right-handed (R) tool.

Holder

Parts

Dimensions (mm)

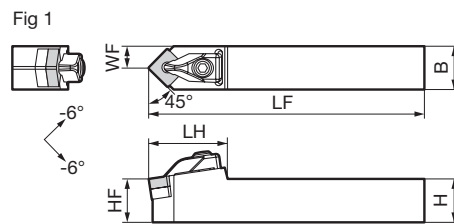
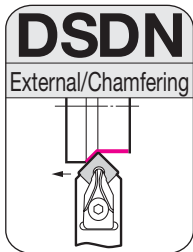
Cat. No.	Stock		Height	Width	Overall Length	Cutting Edge	Cutting Edge Height	Head	Applicable Inserts		Fig	Clamp Set		Shim	Shim Screw	Wrench for Shim	Top Hex Wrench	Bottom Hex Wrench
	R	L							H	B		LF	WF					
DSBN R/L2020K12	●	●	20	20	125	17	20	36	SN□□1204	B35~	1	SCP-2	5.0	SNS1204	BFTX0409N	TRX15(*)	LH040	LH025
DSBN R/L2525M12	●	●	25	25	150	22	25	36	SN□□1204	B35~	1	SCP-2	5.0	SNS1204	BFTX0409N	TRX15(*)	LH040	LH025
DSBN R/L2525M15	●	●	25	25	150	22	25	36	SN□□1506	B39~	1	SCP-3	5.0	SNS1506	BFTX0509N	TRX20(*)	LH040	LH025
DSBN R/L3232P15	●	●	32	32	170	27	32	36	SN□□1506	B39~	1	SCP-3	5.0	SNS1506	BFTX0509N	TRX20(*)	LH040	LH025
DSBN R/L3232P19	●	●	32	32	170	27	32	45	SN□□1906	B41~	1	SCP-5	5.0	SNS1906	BFTX0511N	TRX20(*)	LH040	LH025
DSBN R/L4040S19	●	●	40	40	250	35	40	45	SN□□1906	B41~	1	SCP-5	5.0	SNS1906	BFTX0511N	TRX20(*)	LH040	LH025
DSBN R/L4040S2507	●	●	40	40	250	35	40	58	SN□□2507	B43	1	SCP-6	6.0	SNS2507	BFTX0615N	TRD25(*)	LH060	—
DSBN R/L4040S2509	●	●	40	40	250	35	40	58	SN□□2509	B44	1	SCP-6	6.0	SNS2509	BFTX0615N	TRD25(*)	LH060	—

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

Clamp Set Parts C48



SEC-D series Holder - General Turning and Chamfering Double Clamp



Holder

Parts

Dimensions (mm)

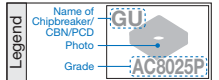
Cat. No.	Stock		Height	Width	Overall Length	Cutting Edge	Cutting Edge Height	Head	Applicable Insert		Fig	Clamp Set		Shim	Shim Screw	Wrench for Shim	Top Hex Wrench	Bottom Hex Wrench
	H	B							LF	WF		HF	LH					
DSDN N2020K12	●	●	20	20	125	10.0	20	36	SN□□1204	B35~	1	SCP-2	5.0	SNS1204	BFTX0409N	TRX15(*)	LH040	LH025
DSDN N2525M12	●	●	25	25	150	12.5	25	36	SN□□1204	B35~	1	SCP-2	5.0	SNS1204	BFTX0409N	TRX15(*)	LH040	LH025

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

Clamp Set Parts C48

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~).
● Depending on the insert size, some combinations cannot be made-to-order or manufactured.



Application 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 BN7125/BNC500	UZ AC4010K	GZ AC4010K	EF AC5015S	EG AC5015S	EM AC5015S	SUMIBORON BNC2115	SUMIBORON BN1000	SUMIDIA BINDERLESS NPD10
General Machining	SU AC8015P	GU AC8025P	MU AC8025P	EF AC6030M	EG AC6030M	EM AC6040M	SUMIBORON BN7125/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 BN7125/BNC500	GZ AC420K	No Chipbreaker AC420K	EF AC5025S	EG AC5025S	EM AC5025S	SUMIBORON BNC2125	SUMIBORON BN350	—
Recommended Cutting Conditions	A10~			A14~			A16~			A18~			A20~		M2~

BNC500 is for ductile cast iron.

Recommended Tightening Torque (N·m)

DSSN type / PSBN type

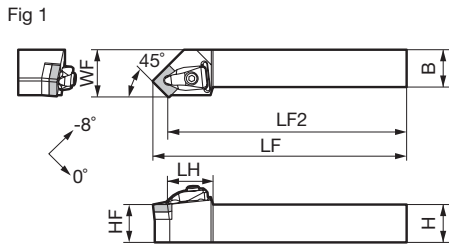


Figure shows right-handed (R) tool.

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

External Holders



Negative

Positive



Special

Holder

Cat. No.	Stock		Height H	Width B	Overall Length LF	Overall Length 2 LF2	Cutting Edge WF	Cutting Edge Height HF	Head LH	Applicable Inserts		Clamp Set		Shim	Shim Screw	Wrench for Shim TRX (For Torx holes)	Top Hex Wrench LH040 (For Hexagonal hole)	Bottom Hex Wrench LH025 (For Hexagonal hole)	
	R	L								Cat. No.	Ref. Page	Fig	N·m						
DSSN R/L2020K12	●	●	20	20	133.3	125	25	20	30	SN□□1204	B35~	1	SCP-2	5.0	SNS1204	BFTX0409N	TRX15(*)	LH040	LH025
DSSN R/L2525M12	●	●	25	25	158.3	150	32	25	30	SN□□1204	B35~	1	SCP-2	5.0	SNS1204	BFTX0409N	TRX15(*)	LH040	LH025
DSSN R/L2525M15	●	●	25	25	160.2	150	32	25	30	SN□□1506	B39~	1	SCP-3	5.0	SNS1506	BFTX0509N	TRX20(*)	LH040	LH025
DSSN R/L3232P15	●	●	32	32	180.2	170	40	32	30	SN□□1506	B39~	1	SCP-3	5.0	SNS1506	BFTX0509N	TRX20(*)	LH040	LH025
DSSN R/L3232P19	●	●	32	32	182.5	170	40	32	36	SN□□1906	B41~	1	SCP-5	5.0	SNS1906	BFTX0511N	TRX20(*)	LH040	LH025
DSSN R/L4040S19	●	●	40	40	262.5	250	50	40	36	SN□□1906	B41~	1	SCP-5	5.0	SNS1906	BFTX0511N	TRX20(*)	LH040	LH025
DSSN R/L4040S2507	●	●	40	40	266.0	250	50	40	47	SN□□2507	B43	1	SCP-6	6.0	SNS2507	BFTX0615N	TRD25(*)	LH060	—
DSSN R/L4040S2509	●	●	40	40	266.0	250	50	40	47	SN□□2509	B44	1	SCP-6	6.0	SNS2509	BFTX0615N	TRD25(*)	LH060	—

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

Clamp Set Parts **C48**

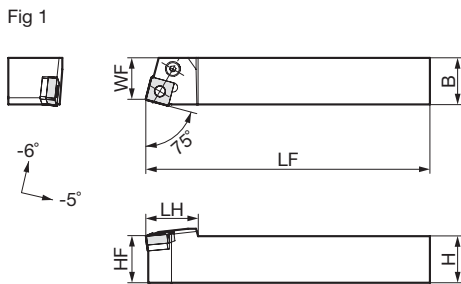
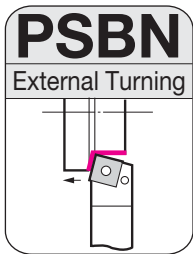


Figure shows right-handed (R) tool.

SEC-70 Holder - General Turning and Profiling Lever Lock

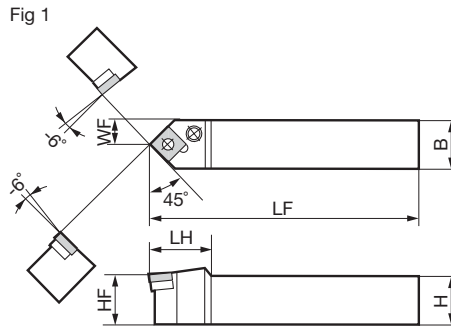
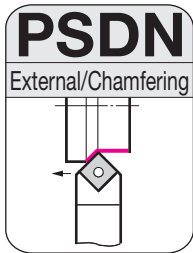
Holder

Cat. No.	Previous Cat. No.	Stock		Height H	Width B	Overall Length LF	Cutting Edge WF	Cutting Edge Height HF	Head LH	Applicable Inserts		Parts					
		R	L							Cat. No.	Ref. Page	Fig	Lever Pin	Bolt	Shim	Shim Retainer	Wrench
PSBN R/L1616H09	PSBN R/L1616-32	●	●	16	16	100	13	16	22	SN□□0903	B34	1	LCL3	LCS3	LSS32	LSP3	LH025
PSBN R/L2020K12	PSBN R/L2020-43	●	●	20	20	125	17	20	28			1					
PSBN R/L2520M12	PSBN R/L2520-43	●	●	25	25	150	17	25	28			1					
PSBN R/L2525M12	PSBN R/L2525-43	●	●	25	25	150	22	25	28	SN□□1204	B35~	1	LCL4	LCS4	LSS42	LSP4	LH030
PSBN R/L3225P12	PSBN R/L3225-43	●	●	32	32	170	22	32	28			1					
PSBN R/L3232P12	PSBN R/L3232-43	●	●	32	32	170	27	32	35			1					
PSBN R/L3225P15	PSBN R/L3225-54	●	●	32	32	170	22	32	35	SN□□1506	B39~	1	LCL5	LCS5	LSS53	LSP5	LH030
PSBN R/L3232P15	PSBN R/L3232-54	●	●	32	32	170	27	32	35			1					
PSBN R/L3232P19	PSBN R/L3232-64	●	●	32	32	170	27	32	40	SN□□1906	B41~	1	LCL6	LCS6	LSS63	LSP6	LH040
PSBN R/L4040R19	PSBN R/L4040-64	●	●	40	40	200	35	40	40			1					
PSBN R/L5050S25	PSBN R/L5050-85	●	●	50	50	250	43	50	50	SN□□2507	B43	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 Inserts		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	B34	1	LCL3	LCS3	LSS32	LSP3	LH025
PSDN N2020K12	PSDN N2020-43	●	20	20	125	10.0	20	30	SN□□1204	B35~	1	LCL4	LCS4	LSS42	LSP4	LH030
PSDN N2520M12	PSDN N2520-43		25	20	150	10.0	25	30								
PSDN N2525M12	PSDN N2525-43	●	25	25	150	12.5	25	30								
PSDN N3225P12	PSDN N3225-43		32	25	170	12.5	32	30								
PSDN N3232P12	PSDN N3232-43	●	32	32	170	16.0	32	40	SN□□1506	B39~	1	LCL5	LCS5	LSS53	LSP5	LH030
PSDN N3225P15	PSDN N3225-54		32	25	170	12.5	32	40								
PSDN N3232P15	PSDN N3232-54		32	32	170	16.0	32	40	SN□□1906	B41~	1	LCL6	LCS6	LSS63	LSP6	LH040
PSDN N3232P19	PSDN N3232-64	●	32	32	170	16.0	32	40								
PSDN N4040R19	PSDN N4040-64		40	40	200	20.0	40	40								

External Holders



Negative

Positive



Special

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~).
● Depending on the insert size, some combinations cannot be made-to-order or manufactured.

Application 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 BN7125/BNC500	UZ AC4010K	GZ AC4010K	EF AC5015S	EG AC5015S	EM AC5015S	SUMIBORON BNC2115	SUMIBORON BN1000	SUMIDIA NPD10
General Machining	SU AC8015P	GU AC8025P	MU AC8025P	EF AC6030M	EG AC6030M	EM AC6040M	SUMIBORON BN7125/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 BN7125/BNC500	GZ AC420K	No Chipbreaker AC420K	EF AC5025S	EG AC5025S	EM AC5025S	SUMIBORON BNC2125	SUMIBORON BN350	-
Recommended Cutting Conditions	A10~			A14~			A16~			A18~			A20~		M2~

BNC500 is for ductile cast iron.

PSSN type / PSKN type

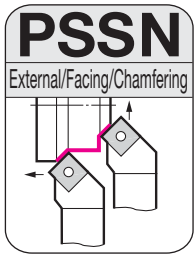


Fig 1

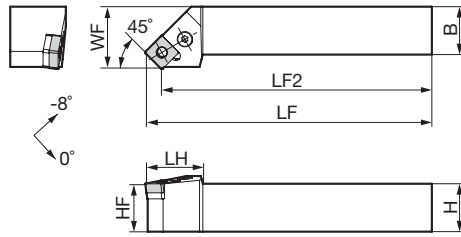


Figure shows right-handed (R) tool.

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 Inserts		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	B34	1	LCL3	LCS3	LSS32	LSP3	LH025
PSSN R/L2020K12	PSSN R/L2020-43	●	●	20	20	125	116.7	25	20	30	SN□□1204	B35~	1	LCL4	LCS4	LSS42	LSP4	LH030
PSSN R/L2520M12	PSSN R/L2520-43	●	●	25	20	150	141.7	25	25	30								
PSSN R/L2525M12	PSSN R/L2525-43	●	●	25	25	150	141.7	32	25	30								
PSSN R/L3225P12	PSSN R/L3225-43	●	●	32	25	170	161.7	32	32	30								
PSSN R/L3232P12	PSSN R/L3232-43	●	●	32	32	170	161.7	40	32	30	SN□□1506	B39~	1	LCL5	LCS5	LSS53	LSP5	LH030
PSSN R/L3225P15	PSSN R/L3225-54	●	●	32	25	170	159.8	32	32	40								
PSSN R/L3232P15	PSSN R/L3232-54	●	●	32	32	170	159.8	40	32	40	SN□□1906	B41~	1	LCL6	LCS6	LSS63	LSP6	LH040
PSSN R/L3232P19	PSSN R/L3232-64	●	●	32	32	170	157.5	40	32	40								
PSSN R/L4040R19	PSSN R/L4040-64	●	●	40	40	200	187.5	50	40	40								

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

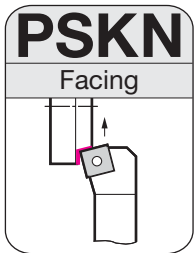
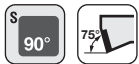


Fig 1

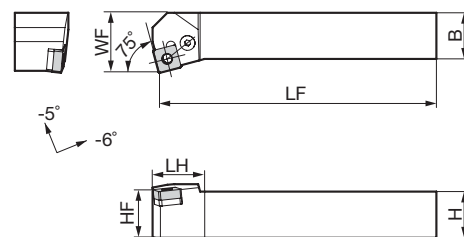


Figure shows right-handed (R) tool.

SEC-70 series 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 Inserts		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	B34	1	LCL3	LCS3	LSS32	LSP3	LH025	
PSKN R/L2020K12	PSKN R/L2020-43	●	●	20	20	125	25	20	26	SN□□1204	B35~	1	LCL4	LCS4	LSS42	LSP4	LH030	
PSKN R/L2520M12	PSKN R/L2520-43	●	●	25	20	150	25	25	26									
PSKN R/L2525M12	PSKN R/L2525-43	●	●	25	25	150	32	25	26									
PSKN R/L3225P12	PSKN R/L3225-43	●	●	32	25	170	32	32	26									
PSKN R/L3232P12	PSKN R/L3232-43	●	●	32	32	170	32	32	26	SN□□1506	B39~	1	LCL5	LCS5	LSS53	LSP5	LH030	
PSKN R/L3225P15	PSKN R/L3225-54	●	●	32	25	170	32	32	32									
PSKN R/L3232P15	PSKN R/L3232-54	●	●	32	32	170	40	32	32	SN□□1906	B41~	1	LCL6	LCS6	LSS63	LSP6	LH040	
PSKN R/L3232P19	PSKN R/L3232-64	●	●	32	32	170	40	32	36									
PSKN R/L4040R19	PSKN R/L4040-64	●	●	40	40	200	50	40	36									
PSKN R/L5050S25	PSKN R/L5050-85	●	●	50	50	250	60	50	50	50	SN□□2507	B43	1	LCL8	LCS8	LSS84	LSP8	LH050

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

Note: The values in red (cutting edge WF) have been changed from those in the 2021-2022 General Catalogue.

External Holders

Negative

Positive

C

D

R

S

T

V

W

Special

ESBN type / ESDN type



SEC-30 Holder - General Turning
Pin Lock

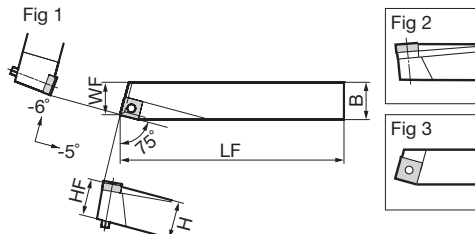


Figure shows right-handed (R) tool.

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 Inserts		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	B34	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	B35~	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

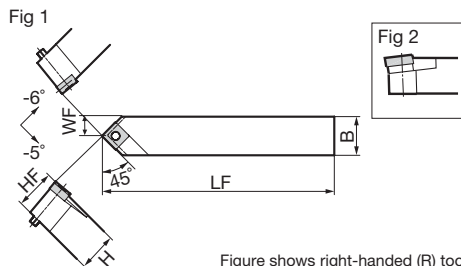


Figure shows right-handed (R) tool.

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 Inserts		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	B34	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	B35~	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 ◀ DSNB 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~).
● Depending on the insert size, some combinations cannot be made-to-order or manufactured.

Application 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 BN7125/BNC500	UZ AC4010K	GZ AC4010K	EF AC5015S	EG AC5015S	EM AC5015S	SUMIBORON BNC2115	SUMIBORON BN1000	SUMIDIA NPD10
General Machining	SU AC8015P	GU AC8025P	MU AC8025P	EF AC6030M	EG AC6030M	EM AC6040M	SUMIBORON BN7125/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 BN7125/BNC500	GZ AC420K	No Chipbreaker AC420K	EF AC5025S	EG AC5025S	EM AC5025S	SUMIBORON BNC2125	SUMIBORON BN350	—
Recommended Cutting Conditions	A10~			A14~			A16~			A18~			A20~		M2~

BNC500 is for ductile cast iron.

External Holders



Negative

Positive



D

R

S

T

V

W

Special

ESSN type / ESKN type



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

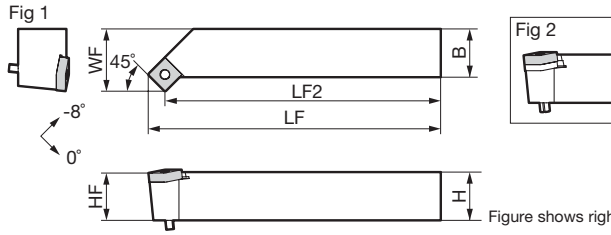


Figure shows right-handed (R) tool.

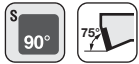
Holder

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 Inserts		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	B34	1	P321US	—	KY40
ESSN R/L1616H09	ESSN R/L1616H32	●	●	16	16	100	93.8	20	15.5			1	P322US	—	
ESSN R/L1616H12	ESSN R/L1616H43			16	16	100	91.7	20	15.5	SN□□1204	B35~	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 series Holder - Facing
Pin Lock

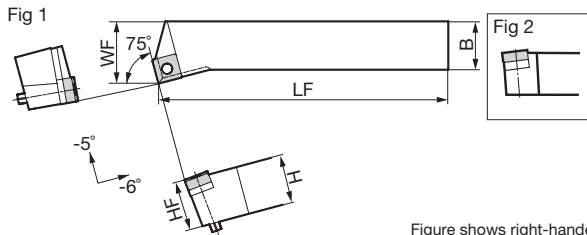


Figure shows right-handed (R) tool.

Holder

Parts

Dimensions (mm)

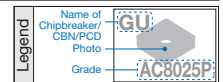
Cat. No.	Previous Cat. No.	Stock		Height H	Width B	Overall Length LF	Cutting Edge WF	Cutting Edge Height HF	Applicable Inserts		Eccentric Pin	Shim	Wrench	
		R	L						Cat. No.	Ref. Page				
ESKN R/L1212F09	ESKN R/L1212	●	●	12	12	80	16	11.5	SN□□0903	B34	1	P321US	—	KY40
ESKN R/L1616H09	ESKN R/L1616H32	●	●	16	16	100	20	15.5			1	P322US	—	
ESKN R/L1616H12	ESKN R/L1616H43			16	16	100	20	15.5	SN□□1204	B35~	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~).
- Depending on the insert size, some combinations cannot be made-to-order or manufactured.



Application 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 BN7125/BNC500	UZ AC4010K	GZ AC4010K	EF AC5015S	EG AC5015S	EM AC5015S	BNC2115	BN1000	NPD10
General Machining	SU AC8015P	GU AC8025P	MU AC8025P	EF AC6030M	EG AC6030M	EM AC6040M	SUMIBORON BN7125/BNC500	GZ AC4015K	GZ AC4015K	EF AC5015S	EG AC5015S	EM AC5025S	BNC2125	BN2000	DA90
Interrupted Cutting	SX AC8025P	UX AC8035P	MX AC8035P	EF AC6030M	EG AC6040M	EM AC6040M	SUMIBORON BN7125/BNC500	GZ AC420K	No Chipbreaker AC420K	EF AC5025S	EG AC5025S	EM AC5025S	BNC2125	BN350	—
Recommended Cutting Conditions	A10~			A14~			A16~			A18~			A20~		M2~

BNC500 is for ductile cast iron.

CSRP type / CSDP type



SEC-40 Holder - General Turning
Clamp-on

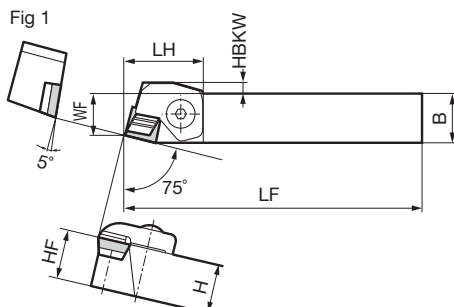


Figure shows right-handed (R) tool.

Holder

Parts

Dimensions (mm)

Cat. No.	Previous Cat. No.	Stock		Height	Width	Overall Length	Cutting Edge	Cutting Edge Height	Head	Step	Applicable Inserts		Clamp Plate	Chipbreaker	Bolt	Shim	Shim Retainer	Spring	Wrench		
		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								
CSRP R/L2525-N12	FP11 R/L-44A	●		25	25	160	21.5	25	34.5	—	SP□□1203	B97	1	DCR/L1	CBD4R/L	BH0824R/L BH0830R/L	SSPD422	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	B98	1	DCR/L3	CBD5R/L	BH1030R/L BH1036R/L	SSPD522	SPP3	DSP5	LH050	
CSRP R/L3232-N15	FP11 R/L-55			32	32	180	26.0	32	40.0	—			1								



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

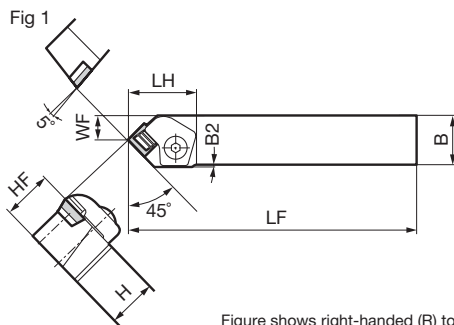


Figure shows right-handed (R) tool.

Holder

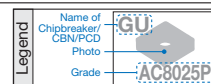
Parts

Dimensions (mm)

Cat. No.	Previous Cat. No.	Stock		Height	Width	Overall Length	Cutting Edge	Cutting Edge Height	Head	Step	B2	Applicable Insert		Clamp Plate	Chipbreaker	Bolt	Shim	Shim Retainer	Spring	Wrench	
		R	L									Cat. No.	Ref. Page								
CSDP R/L1919-L12	FP14 R/L-33	●		19	19	140	10.5	19	35	6											
CSDP R/L2525-N12	FP14 R/L-44A	●		25	25	160	12.5	25	35	2											
CSDP R/L3225-N12	FP14 R/L-45A			32	25	160	12.5	32	35	2											

Applicable Inserts ◀◀ CSRP type / CSDP type / CSKP type

- 1st Recommended Insert**
- Refer as well to the Insert Selection Guide (A10~).
 - Depending on the insert size, some combinations cannot be made-to-order or manufactured.



Application 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 Machining	T1500Z	AC8025P	BN7125	AC4015K	AC4015K	AC5015S	AC5025S	DA1000	BN2000
Recommended Cutting Conditions	A10~		A16~			A18~		A22~	A20~

External Holders

C

Negative

Positive

C

D

R

S

T

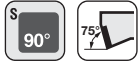
V

W

Special

SEC-External Holders

CSKP type



SEC-40 series Holder - Facing
Clamp-on

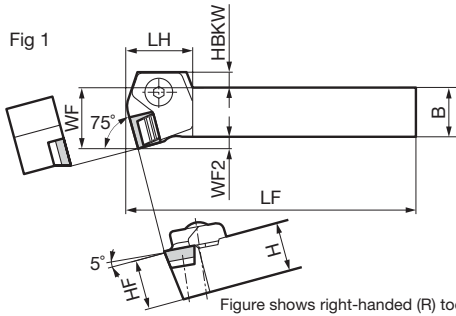
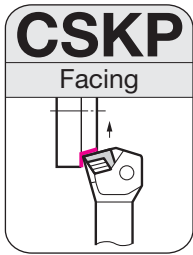


Figure shows right-handed (R) tool.

External Holders

Negative

Positive

C

D

R

S

T

V

W

Special

Holder

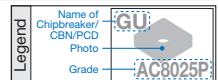
Cat. No.	Previous Cat. No.	Stock		Height	Width	Overall Length	Cutting Edge	Cutting Edge Height	Head	Offset	Step	Applicable Inserts		Parts									
		R	L									Cat. No.	Ref. Page	Clamp Plate	Chipbreaker	Bolt	Shim	Shim Retainer	Spring	Wrench			
CSKP R/L1919-L12	FP15 R/L-33			19	19	140	25	19	22	6	7			1			BH0824L/R						
CSKP R/L2525-N12	FP15 R/L-44A	●		25	25	160	32	25	22	7	—	SP□□1203	B97	1	DCL/R1	CBD4L/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	B98	1	DCL/R3	CBD5L/R	BH1030L/R	SSPD522	SPP3	DSP5	LH050		
CSKP R/L3232-Q15	FP15 R/L-55			32	32	180	38	32	28	6	—			1			BH1036L/R						

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

Applicable Inserts ◀ CSRP type / CSDP type / CSKP type

1st Recommended Insert

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

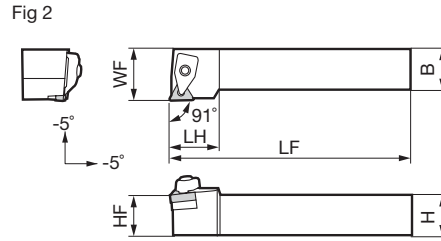
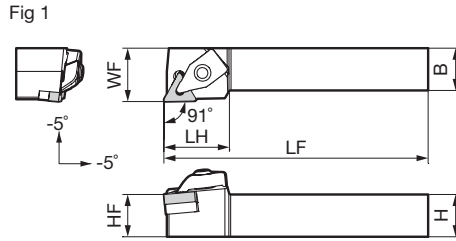
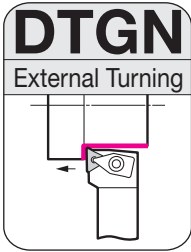


Application range	P (Steel)		K (Cast Iron)			S (Exotic Alloy)		N (Non-Ferrous)	H (Hardened Steel)
	Finishing	Medium Cutting	High-speed Finishing	Finishing to Medium Cutting	Medium to Roughing	Finishing to Medium Cutting	Medium to Roughing	—	Uncoated
Process									
General Machining	FK T1500Z	SF AC8025P	SUMIBORON BN7125	No Chipbreaker AC4015K	No Chipbreaker AC4015K	No Chipbreaker AC5015S	No Chipbreaker AC5025S	SUMIDIA DA1000	SUMIBORON BN2000
Recommended Cutting Conditions	A10~		A16~			A18~		A22~	A20~

DTGN type / DTFN type



SEC-D Holder - General Turning and Profiling
Double Clamp



Holder

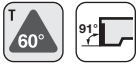
Parts

Figure shows right-handed (R) tool.

Cat. No.	Stock		Height H	Width B	Overall Length LF	Cutting Edge WF	Cutting Edge Height HF	Head LH	Applicable Insert		Dimensions (mm)							
	R	L							Cat. No.	Ref. Page	Clamp Set	Shim	Shim Screw	Wrench for Shim	Top Hex Wrench	Bottom Hex Wrench		
DTGN R/L2020K16	●	●	20	20	125	25	20	31	TN□□1604	B50~	1	SCP-1	5.0	TNS1604	BFTX0307N	TRX10(*)	LH040	LH025
DTGN R/L2525M16	●	●	25	25	150	32	25	31			2							

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

Clamp Set Parts C48



SEC-D series Holder - Facing
Double Clamp

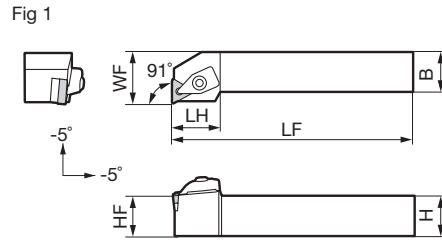
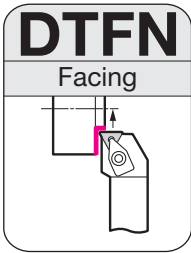


Figure shows right-handed (R) tool.

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		Dimensions (mm)							
	R	L							Cat. No.	Ref. Page	Clamp Set	Shim	Shim Screw	Wrench for Shim	Top Hex Wrench	Bottom Hex Wrench		
DTFN R/L2020K16	●	●	20	20	125	25	20	30	TN□□1604	B50~	1	SCP-1	5.0	TNS1604	BFTX0307N	TRX10(*)	LH040	LH025
DTFN R/L2525M16	●	●	25	25	150	32	25	30			1							

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

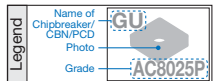
Clamp Set Parts C48

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~).
- Depending on the insert size, some combinations cannot be made-to-order or manufactured.



Application 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	SUMIBORON	UZ	GZ	EF	EG	EM	SUMIDIA	SUMIBORON	SUMIBORON
	T1500Z	AC8015P	AC8025P	AC6020M	AC6020M	AC6030M	BN7125/BNC500	AC4010K	AC4010K	AC5015S	AC5015S	AC5015S	DA1000	BNC2115	BN1000
General Machining	SU	GU	MU	EF	EG	EM	SUMIBORON	GZ	GZ	EF	EG	EM	SUMIDIA	SUMIBORON	SUMIBORON
	AC8015P	AC8025P	AC8025P	AC6030M	AC6030M	AC6040M	BN7125/BNC500	AC4015K	AC4015K	AC5015S	AC5015S	AC5025S	DA1000	BNC2125	BN2000
Interrupted Cutting	SX	UX	MX	EF	EG	EM	SUMIBORON	GZ	GZ	EF	EG	EM	SUMIDIA	SUMIBORON	SUMIBORON
	AC8025P	AC8035P	AC8035P	AC6030M	AC6040M	AC6040M	BN7125/BNC500	AC420K	AC420K	AC5025S	AC5025S	AC5025S	DA1000	BNC300	BN350
Recommended Cutting Conditions	A10~			A14~			A16~			A18~			A22~	A20~	

BNC500 is for ductile cast iron.

PTGN type / PTTN type

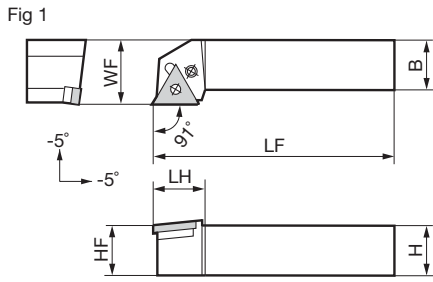
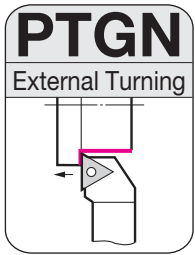


Figure shows right-handed (R) tool.

SEC-70 Holder - General Turning and Profiling
Lever Lock

Holder

Parts

Dimensions (mm)

Cat. No.	Previous Cat. No.	Stock		Height	Width	Overall Length	Cutting Edge	Cutting Edge Height	Head	Applicable Inserts		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	B50~	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	B55~	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	32									
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	B57	1	LCL5	LCS5	LST53	LSP5	LH030
PTGN R/L4040R27	PTGN R/L4040-54	●	●	40	40	200	50	40	33								

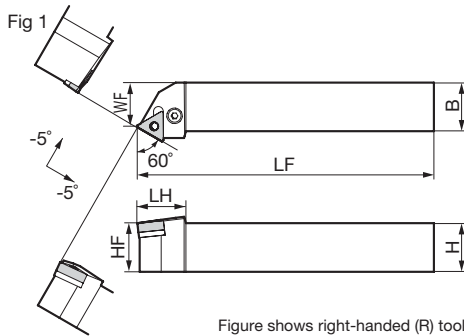
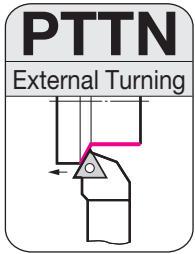


Figure shows right-handed (R) tool.

SEC-70 Holder - General Turning and Profiling
Lever Lock

Holder

Parts

Dimensions (mm)

Cat. No.	Previous Cat. No.	Stock		Height	Width	Overall Length	Cutting Edge	Cutting Edge Height	Head	Applicable Inserts		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	B50~	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	B55~	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

Negative

Positive

C

D

R

S

T

V

W

Special

PTFN type



SEC-70 series Holder - Facing
Lever Lock

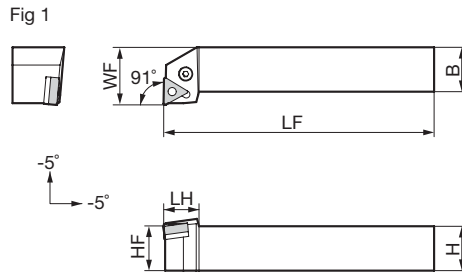
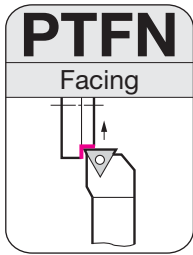


Figure shows right-handed (R) tool.

Holder

Parts

Dimensions (mm)

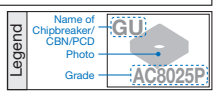
Cat. No.	Previous Cat. No.	Stock		Height	Width	Overall Length	Cutting Edge	Cutting Edge Height	Head	Applicable Inserts		Lever Pin	Bolt	Shim	Shim Retainer	Wrench	
		R	L							Cat. No.	Ref. Page						
PTFN R/L1616H16	PTFN R/L1616-33	●	●	16	16	100	20	16	20	TN□□1604	B50~	1	LCL3	LCS3	LST317	LSP3	LH025
PTFN 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	B56~	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	B57	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~).
- Depending on the insert size, some combinations cannot be made-to-order or manufactured.



Application 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	SUMIBORON	UZ	GZ	EF	EG	EM	SUMIDIA	SUMIBORON	SUMIBORON
General Machining	T1500Z	AC8015P	AC8025P	AC6020M	AC6020M	AC6030M	BN7125/BNC500	AC4010K	AC4010K	AC5015S	AC5015S	AC5015S	DA1000	BNC2115	BN1000
	SU	GU	MU	EF	EG	EM	SUMIBORON	GZ	GZ	EF	EG	EM	SUMIDIA	SUMIBORON	SUMIBORON
Interrupted Cutting	AC8015P	AC8025P	AC8025P	AC6030M	AC6030M	AC6040M	BN7125/BNC500	AC4015K	AC4015K	AC5015S	AC5015S	AC5025S	DA1000	BNC2125	BN2000
	SX	UX	MX	EF	EG	EM	SUMIBORON	GZ	GZ	EF	EG	EM	SUMIDIA	SUMIBORON	SUMIBORON
Recommended Cutting Conditions	A10~			A14~			A16~			A18~			A22~	A20~	

BNC500 is for ductile cast iron.

External Holders



Negative

Positive



Special

ETGN type / ETAN type

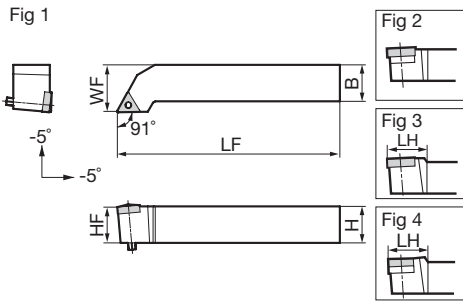
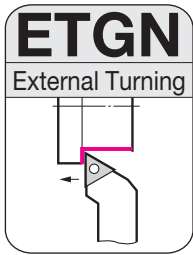


Figure shows right-handed (R) tool.

SEC-30 Holder - General Turning
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 Inserts		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	B48	1	P221US	—	KY25
ETGN R/L1616H1603	ETGN R/L1616H32	●	●	16	16	100	20	15.5	—	TN□□1603	B49~	1	P322US	—	KY40
ETGN R/L1616H1604	ETGN R/L1616H33	●	●	16	16	100	20	15.5	—	TN□□1604	B50~	1	P332US	—	KY40
ETGN R/L2020K1603	ETGN R/L2020K32			20	20	125	25	19.5	—	TN□□1603	B49~	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	B50~	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	B55~	3	P434U	—	KY40
ETGN R/L2525M22W	ETGN R/L2525M43W	●	●	25	25	150	32	24.5	30			4	P434W	EST43	

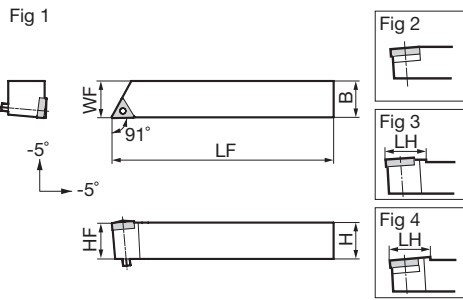
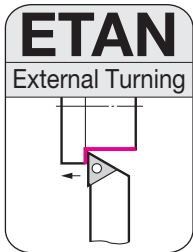


Figure shows right-handed (R) tool.

SEC-30 Holder - General Turning
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 Inserts		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	B48	1	P221US	—	KY25
ETAN R/L1616H1603	ETAN R/L1616H32			16	16	100	16	15.5	—	TN□□1603	B49~	1	P322US	—	KY40
ETAN R/L1616H1604	ETAN R/L1616H33	●	●	16	16	100	16	15.5	—	TN□□1604	B50~	1	P332US	—	KY40
ETAN R/L2020K1603	ETAN R/L2020K32			20	20	125	20	19.5	—	TN□□1603	B49~	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	B50~	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	B55~	3	P434U	—	KY40
ETAN R/L2525M22W	ETAN R/L2525M43W	●	●	25	25	150	25	24.5	30			4	P434W	EST43	

ETFN type



SEC-30 series Holder - Facing
Pin Lock

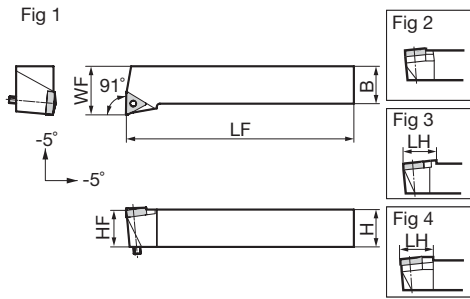
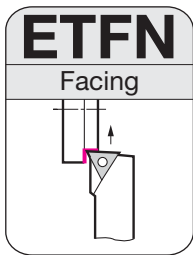


Figure shows right-handed (R) tool.

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 Inserts		Eccentric Pin	Shim	Wrench
		R	L							Cat. No.	Ref. Page			
ETFN R/L1212F11	ETFN R/L1212	●	●	12	12	80	16	11.5	—	TN□□1103	B48	1 P221US	—	KY25
ETFN R/L1616H1603	ETFN R/L1616H32			16	16	100	20	15.5	—	TN□□1603	B49~	1 P322US	—	KY40
ETFN R/L1616H1604	ETFN R/L1616H33	●	●	16	16	100	20	15.5	—	TN□□1604	B50~	1 P332US	—	KY40
ETFN R/L2020K1603	ETFN R/L2020K32			20	20	125	25	19.5	—	TN□□1603	B49~	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	B50~	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	—	
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	B55~	3 P434U	—	KY40
ETFN R/L2525M22W	ETFN R/L2525M43W	●	●	25	25	150	32	24.5	30			4 P434W	EST43	

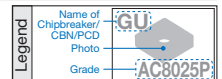
When using handed breaker inserts for facing, the holder and insert are opposite handed.

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~).
- Depending on the insert size, some combinations cannot be made-to-order or manufactured.



Application 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	SUMIBORON	UZ	GZ	EF	EG	EM	SUMIDIA	SUMIBORON	SUMIBORON
General Machining	T1500Z	AC8015P	AC8025P	AC6020M	AC6020M	AC6030M	BN7125/BNC500	AC4010K	AC4010K	AC5015S	AC5015S	AC5015S	DA1000	BNC2115	BN1000
	SU	GU	MU	EF	EG	EM	SUMIBORON	GZ	GZ	EF	EG	EM	SUMIDIA	SUMIBORON	SUMIBORON
Interrupted Cutting	AC8015P	AC8025P	AC8025P	AC6030M	AC6030M	AC6040M	BN7125/BNC500	AC4015K	AC4015K	AC5015S	AC5015S	AC5025S	DA1000	BNC2125	BN2000
	SX	UX	MX	EF	EG	EM	SUMIBORON	GZ	GZ	EF	EG	EM	SUMIDIA	SUMIBORON	SUMIBORON
Recommended Cutting Conditions	A10~			A14~			A16~			A18~			A22~	A20~	

BNC500 is for ductile cast iron.

External Holders



Negative

Positive

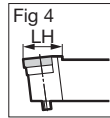
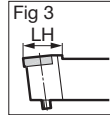
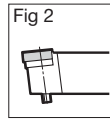
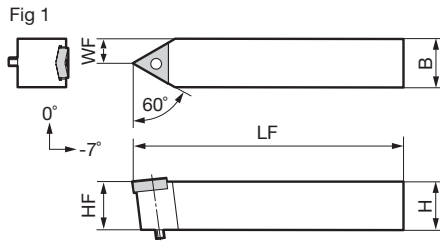
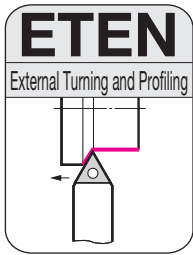


Special

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 Inserts		Fig	Eccentric Pin	Shim	Wrench
									Cat. No.	Ref. Page				
ETEN N1212F11	ETEN N1212	●	12	12	80	6.0	11.5	—	TN□□1103	B48	1	P221US	—	KY25
ETEN N1616H1603	ETEN N1616H32		16	16	100	8.0	15.5	—	TN□□1603	B49~	1	P322US	—	KY40
ETEN N1616H1604	ETEN N1616H33	●	16	16	100	8.0	15.5	—	TN□□1604	B50~	1	P332US	—	KY40
ETEN N2020K1603	ETEN N2020K32		20	20	125	10.0	19.5	—	TN□□1603	B49~	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	B50~	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	—	TN□□1604	B50~	1	P334US	—	KY40
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	B55~	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

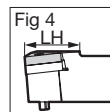
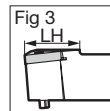
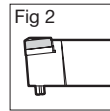
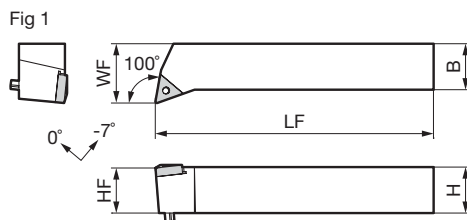
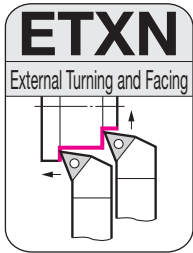


Figure shows right-handed (R) tool.

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 Inserts		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	B48	1	P221US	—	KY25
ETXN R/L1616H1603	ETXN R/L1616H32			16	16	100	20	15.5	—	TN□□1603	B49~	1	P322US	—	KY40
ETXN R/L1616H1604	ETXN R/L1616H33	●	●	16	16	100	20	15.5	—	TN□□1604	B50~	1	P332US	—	KY40
ETXN R/L2020K1603	ETXN R/L2020K32			20	20	125	25	19.5	—	TN□□1603	B49~	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	B50~	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	—	TN□□1604	B50~	1	P334US	—	KY40
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	B55~	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

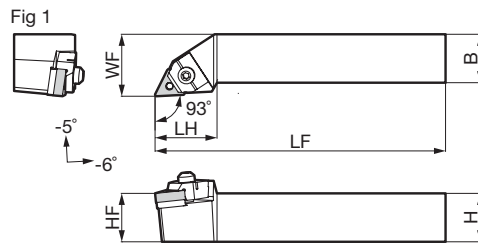
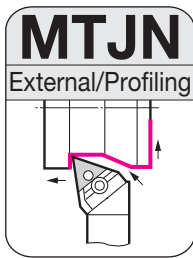


Figure shows right-handed (R) tool.

Holder

Parts

Dimensions (mm)

Cat. No.	Previous Cat. No.	Stock		Height	Width	Overall Length	Cutting Edge	Cutting Edge Height	Head	Applicable Inserts		Wedge	Pin	Shim	Bolt	Nut	Retaining 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	B50~	1	MP317S								
** MTJN R/L2520M16	MTJN R/L2520-33	●	●	25	20	150	25	25	32	TN□□1604	B50~	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	B50~	1	MP320S								
* MTJN R/L2525M22	MTJN R/L2525-43	●	●	25	25	150	32	25	38	TN□□1604	B50~	1	MP320S								
* MTJN R/L3225P22	MTJN R/L3225-43	●	●	32	25	170	32	32	38	TN□□2204	B55~	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

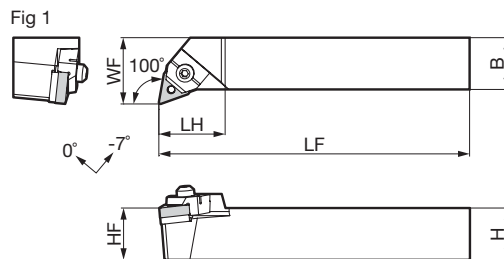
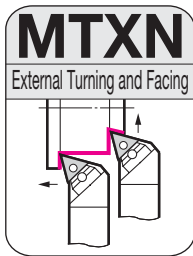


Figure shows right-handed (R) tool.

Holder

Parts

Dimensions (mm)

Cat. No.	Previous Cat. No.	Stock		Height	Width	Overall Length	Cutting Edge	Cutting Edge Height	Head	Applicable Inserts		Wedge	Pin	Shim	Bolt	Nut	Retaining 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	B50~	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	B50~	1	MMW30	MP320S	STW323	BHA0525	4.0	CPM32N	ER04	LH030	LH030
* MTXN R/L2525M22	MTXN R/L2525-43	●	●	25	25	150	32	25	38	TN□□2204	B55~	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~).
- Depending on the insert size, some combinations cannot be made-to-order or manufactured.

Application 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	SUMIBORON	UZ	GZ	EF	EG	EM	SUMIDIA	SUMIBORON	SUMIBORON
General Machining	T1500Z	AC8015P	AC8025P	AC6020M	AC6020M	AC6030M	BN7125/BNC500	AC4010K	AC4010K	AC5015S	AC5015S	AC5015S	DA1000	BNC2115	BN1000
	SU	GU	MU	EF	EG	EM	SUMIBORON	GZ	GZ	EF	EG	EM	SUMIDIA	SUMIBORON	SUMIBORON
Interrupted Cutting	AC8015P	AC8025P	AC8025P	AC6030M	AC6030M	AC6040M	BN7125/BNC500	AC4015K	AC4015K	AC5015S	AC5015S	AC5025S	DA1000	BNC2125	BN2000
	SX	UX	MX	EF	EG	EM	SUMIBORON	GZ	GZ	EF	EG	EM	SUMIDIA	SUMIBORON	SUMIBORON
Recommended Cutting Conditions	A10~			A14~			A16~			A18~			A22~	A20~	

BNC500 is for ductile cast iron.

Recommended Tightening Torque (N·m)

CTGP type / CTAP type



SEC-40 Holder - General Turning
Clamp-on

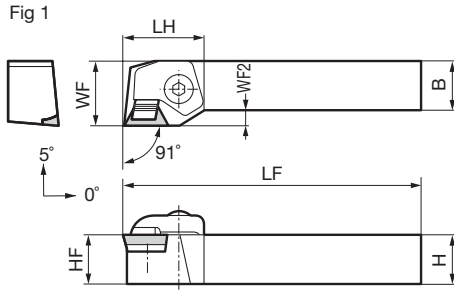


Figure shows right-handed (R) tool.

Holder

Parts

Dimensions (mm)

Cat. No.	Previous Cat. No.	Stock		Height	Width	Overall Length	Cutting Edge	Cutting Edge Height	Head	Offset	Applicable Inserts		Fig	Clamp Plate	Chipbreaker	Bolt	Shim	Shim Retainer	Spring	Wrench
		R	L								Cat. No.	Ref. Page								
CTGP R/L1919-L16	FP22 R/L-33	●		19	19	140	25	19	34.5	6	TP□□1603	B111	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	B115	1	DCR/L3	CBD5R/L	BH1030R/L	STPD422	SPP3	DSP5	LH050



SEC-40 Holder - General Turning
Clamp-on

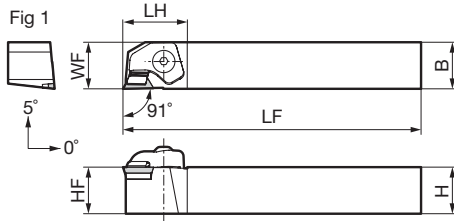
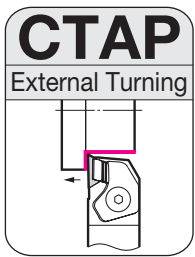


Figure shows right-handed (R) tool.

Holder

Parts

Dimensions (mm)

Cat. No.	Previous Cat. No.	Stock		Height	Width	Overall Length	Cutting Edge	Cutting Edge Height	Head	Offset	Applicable Inserts		Fig	Clamp Plate	Chipbreaker	Bolt	Shim	Shim Retainer	Spring	Wrench
		R	L								Cat. No.	Ref. Page								
CTAP R/L2525-N16	FP21 R/L-44A	●		25	25	160	25	25	34.5		TP□□1603	B111	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	B111	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	B115	1	DCR/L3	CBD5R/L	BH1036R/L	STPD422	SPP3	DSP5	LH050

External Holders

C

Negative

Positive

C

D

R

S

T

V

W

Special

CTFP type



SEC-40 Holder - Facing
Clamp-on

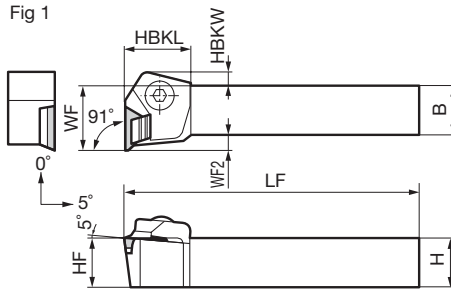
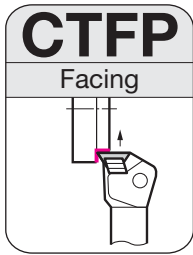


Figure shows right-handed (R) tool.

Holder

Parts

Dimensions (mm)

Cat. No.	Previous Cat. No.	Stock		Height	Width	Overall Length	Cutting Edge	Cutting Edge Height	Head	Offset	Step	Applicable Inserts		Clamp Plate	Chipbreaker	Bolt	Shim	Shim Retainer	Spring	Wrench		
		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					
CTFP R/L2525-N16	FP25 R/L-44A	●		25	25	160	32	25	26	7	—	TP□□1603	B111	1	DCL/R2	CBD4L/R	BH0830L/R	STPD322	SPP3	DSP5	LH040	
CTFP R/L3225-N16	FP25 R/L-45A			32	25	160	32	32	26	7	—			1	DCL/R2							
CTFP R/L2525-N22	FP25 R/L-44B	●		25	25	160	32	25	33	7	7	TP□□2204	B115	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.

External Holders



Negative

Positive

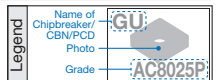


Special

Applicable Inserts ◀ CTGP type / CTAP type / CTFP type

1st Recommended Insert

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



Application 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 Machining	T1500Z	AC8025P	BN7125	AC4015K	AC4015K	AC5015S	AC5025S	DA1000	BN2000
Recommended Cutting Conditions	A10~		A16~			A18~		A22~	A20~

DVJN-J type / DVJN type



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

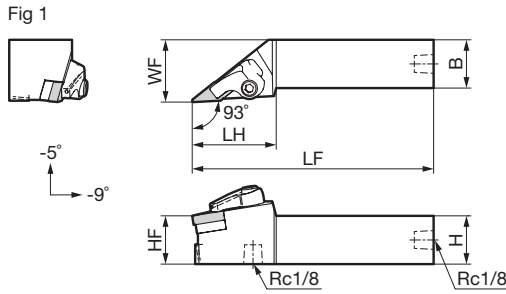
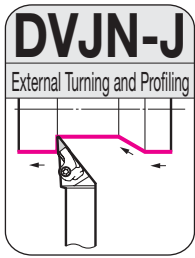


Figure shows right-handed (R) tool.

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 Shim	Top Hex Wrench	Bottom Hex Wrench	Plug		
	R	L							Cat. No.	Ref. Page												
DVJN R/L2020K16-J	●	●	20	20	125	25	20	43	VN□□1604	B60~	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														

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



SEC-D series Holder - General Turning and Profiling
Double Clamp

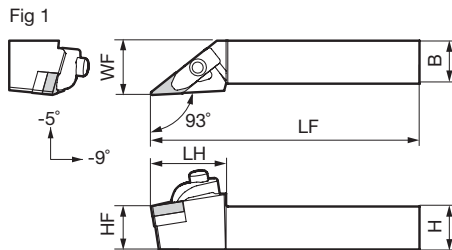
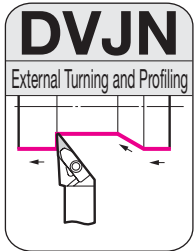


Figure shows right-handed (R) tool.

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 Shim	Top Hex Wrench	Bottom Hex Wrench		
	R	L							Cat. No.	Ref. Page								
DVJN R/L2020K16	●	●	20	20	125	25	20	35	VN□□1604	B60~	1	SCP-4	5.0	VNS1604	BFTX0307N	TRX10(*)	LH040	LH025
DVJN R/L2525M16	●	●	25	25	150	32	25	35										

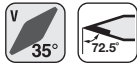
*Wrench for shim is sold separately from the main body.

Clamp Set Parts **C48**

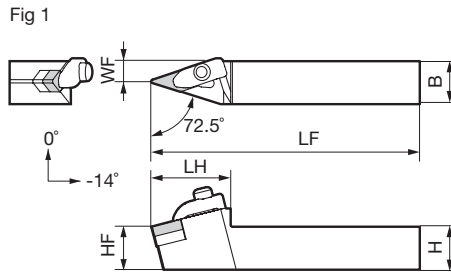
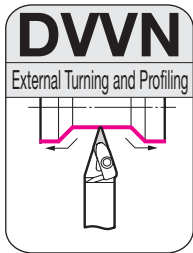
Note: The values in red (cutting edge WF) have been changed from those in the 2021-2022 General Catalogue.

- External Holders
- C
- Negative
- Positive
- C
- D
- R
- S
- T
- V
- W
- Special

DVNN type / DVQN type



SEC-D series Holder - General Turning and Profiling Double Clamp



Holder

Parts

Cat. No.	Stock		Height H	Width B	Overall Length LF	Cutting Edge Width WF	Cutting Edge Height HF	Head Length LH	Applicable Insert		Fig	Clamp Set		Shim	Shim Screw	Wrench for Shim (For Torx hole)	Top Hex Wrench (For Hexagonal hole)	Bottom Hex Wrench (For Hexagonal hole)
	R	L							Cat. No.	Ref. Page		Nm	Nm					
DVNN N2020K16	●	●	20	20	125	10.0	20	37	VN□□1604	B60~	1	SCP-4	5.0	VNS1604	BFTX0307N	TRX10(*)	LH040	LH025
DVNN N2525M16	●	●	25	25	150	12.5	25	37	VN□□1604	B60~	1	SCP-4	5.0	VNS1604	BFTX0307N	TRX10(*)	LH040	LH025

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

Clamp Set Parts C48



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

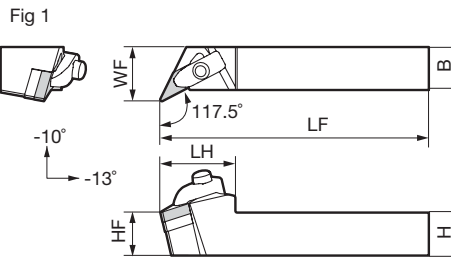


Figure shows right-handed (R) tool.

Holder

Parts

Cat. No.	Stock		Height H	Width B	Overall Length LF	Cutting Edge Width WF	Cutting Edge Height HF	Head Length LH	Applicable Insert		Fig	Clamp Set		Shim	Shim Screw	Wrench for Shim (For Torx hole)	Top Hex Wrench (For Hexagonal hole)	Bottom Hex Wrench (For Hexagonal hole)
	R	L							Cat. No.	Ref. Page		Nm	Nm					
DVQN R/L2020K16	●	●	20	20	125	25	20	35	VN□□1604	B60~	1	SCP-4	5.0	VNS1604	BFTX0307N	TRX10(*)	LH040	LH025
DVQN R/L2525M16	●	●	25	25	150	32	25	35	VN□□1604	B60~	1	SCP-4	5.0	VNS1604	BFTX0307N	TRX10(*)	LH040	LH025

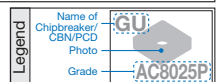
*Wrench for shim is sold separately from the main body.

Clamp Set Parts C48

Applicable Inserts ◀ DVJN-J type / DVJN type / DVNN type / DVQN type

1st Recommended Insert

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



Application 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 BN7125/BNC500	UZ AC4010K	EF AC5015S	EG AC5015S	SUMIDIA DA1000	SUMIBORON BNC2115	SUMIBORON BN1000	SUMIDIA BINDERLESS NPD10
General Machining	SU AC8015P	GU AC8025P	EF AC6030M	EG AC6030M	SUMIBORON BN7125/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 BN7125/BNC500	GZ AC420K	EF AC5025S	EG AC5025S	SUMIDIA DA1000	SUMIBORON BNC300	SUMIBORON BN350	—
Recommended Cutting Conditions	A10~		A14~		A16~		A18~		A22~	A20~		M2~

BNC500 is for ductile cast iron.

Recommended Tightening Torque (N-m)

SVLC type / SVJC type

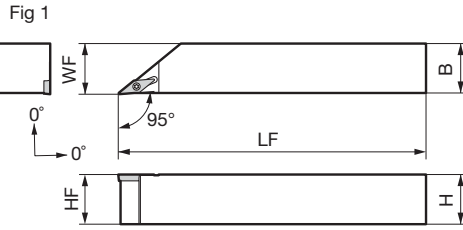
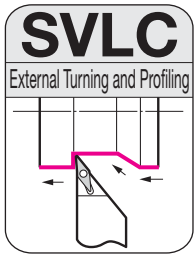
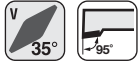


Figure shows right-handed (R) tool.

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

Holder

Parts

Dimensions (mm)

Cat. No.	Stock		Height H	Width B	Overall Length LF	Cutting Edge WF	Cutting Edge Height HF	Applicable Insert		Fig	Flat Insert Screw		Wrench (For Torx hole)
	R	L						Cat. No.	Ref. Page			N-m	
SVLC R/L1010-H11	●	●	10	10	100	10.5	10	VC□□1103	B121~	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

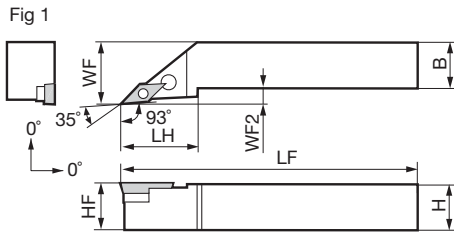
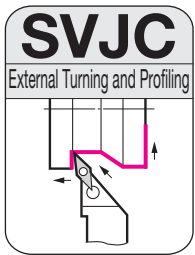


Figure shows right-handed (R) tool.

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

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	Offset WF2	Applicable Insert		Fig	Pin	Nut	Shim	Flat Insert Screw		Wrench (For Torx hole)	Wrench for Nut (For Hexagonal hole)
		R	L								Cat. No.	Ref. Page						N-m		
SVJC R/L2020K16	SVJC R/L2020-33	●	●	20	20	125	25	20	41	5	VC□□1604	B122~	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

Negative

Positive

C

D

R

S

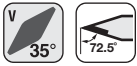
T

V

W

Special

SVVC type / SVPC type



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

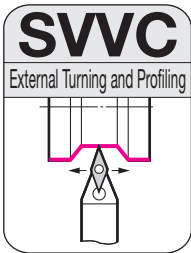
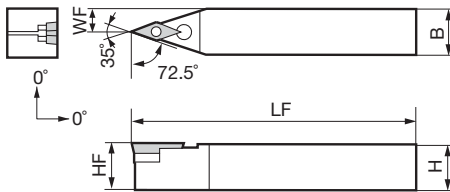


Fig 1



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 hole)		
SVVC N2020K16	SVVC N2020-33	● 20	● 20	125	10.0	20	VC□□1604	B12-	1 VP20	CPV33N	SVP32	BFTX03508	2.0	TRX10	LH025
SVVC N2525M16	SVVC N2525-33	● 25	● 25	150	12.5	25		1 VP25							
SVVC N3225P16	SVVC N3225-33	● 32	● 25	170	12.5	32		1 VP32							



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

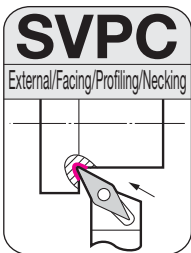


Fig 1

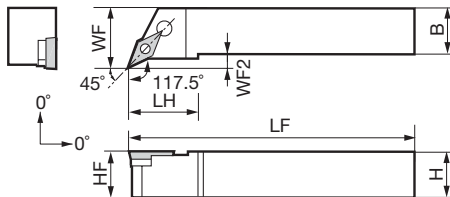


Figure shows right-handed (R) tool.

Holder

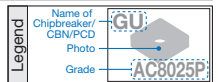
Parts

Dimensions (mm)

Cat. No.	Previous Cat. No.	Stock		Overall Length	Cutting Edge	Cutting Edge Height	Head	Offset	Applicable Inserts		Pin	Nut	Shim	Flat Insert Screw		Wrench	Wrench for Nut		
		R	L						Cat. No.	Ref. Page				(N-m)	(For Torx hole)			(For Hexagonal hole)	
SVPC R/L1010-H11	—	●	●	10	10	100	14.5	10	—	4.5	—	—	—	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	B12-	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~).
● Depending on the insert size, some combinations cannot be made-to-order or manufactured.



Application 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 Machining	FB T1500Z	GU AC8025P	LB AC6030M	GU AC6030M	SU AC5015S	SU AC5025S	SUMIDIA DA1000	AG H1	SUMIBORON BNC2125	SUMIBORON BN2000	SUMIDIA DA90
High-precision	FF AC1030U	SI AC1030U	FF AC1030U	SI AC1030U	FF AC1030U	SI AC5015S	SUMIDIA DA1000	—	SUMIBORON BNC2115	SUMIBORON BN1000	SUMIDIA BINDERLESS NPD10
Recommended Cutting Conditions	A10~		A14~		A18~		A22~		A20~		M2~

DWLN-J type / DWLN type



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

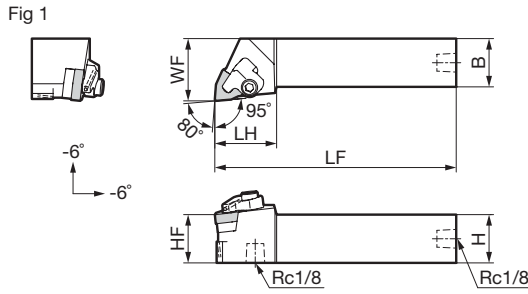
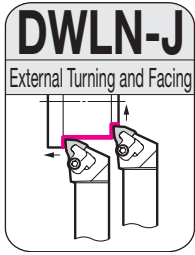


Figure shows right-handed (R) tool.

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 Shim	Top Hex Wrench	Bottom Hex Wrench	Plug		
	R	L							Cat. No.	Ref. Page											Fig	
DWLN R/L2020K08-J	●	●	20	20	125	25	20	32	WN□□0804	B65~	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	WN□□0804	B65~	1	JC R/L-01	CP-M5-20-1	5.0	CSP12J	SS060	WNS0804	BFTX0409N	TRX15(*)	LH040	LH025	XP02

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



SEC-D series Holder - General Turning and Facing
Double Clamp

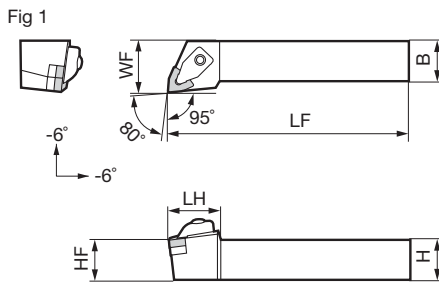
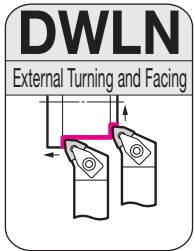


Figure shows right-handed (R) tool.

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 Shim	Top Hex Wrench	Bottom Hex Wrench	
	R	L							Cat. No.	Ref. Page	Fig	N-m						
DWLN R/L2020K08	●	●	20	20	125	25	20	32	WN□□0804	B65~	1	SCP-2	5.0	WNS0804	BFTX0409N	TRX15(*)	LH040	LH025
DWLN R/L2525M08	●	●	25	25	150	32	25	32	WN□□0804	B65~	1	SCP-2	5.0	WNS0804	BFTX0409N	TRX15(*)	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 **C48**

Note: The values in red (cutting edge WF) have been changed from those in the 2021-2022 General Catalogue.

External Holders

C

Negative

Positive

C

D

R

S

T

V

W

Special

PWLN type / MWLN type



SEC-70 Holder - General Turning and Facing
Lever Lock

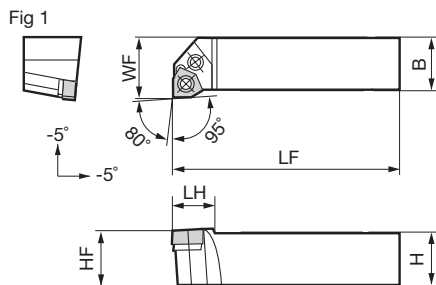
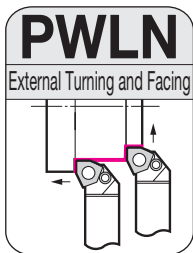


Figure shows right-handed (R) tool.

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	B63~	1	LCL3	LCS3	LSW317	LSP3	LH025
PWLN R/L2525M06	PWLN R/L2525-33	●	●	25	25	150	32	25	17			1					

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

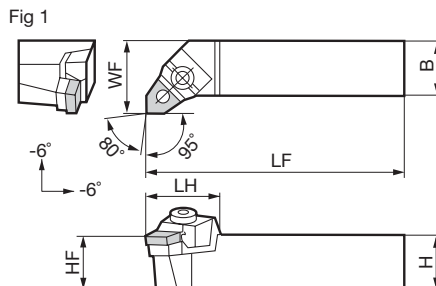
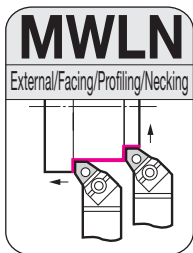


Figure shows right-handed (R) tool.

Holder

Parts

Dimensions (mm)

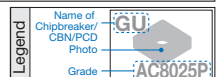
Cat. No.	Previous Cat. No.	Stock		Height	Width	Overall Length	Cutting Edge	Cutting Edge Height	Head	Applicable Insert		Wedge	Pin	Shim	Bolt	Nut	Retaining Ring	Wrench for Bolt	Wrench for Nut		
		R	L							Cat. No.	Ref. Page										
MWLN R/L2020K08	MWLN R/L2020-43	●	●	20	20	125	25	20	32	WN□□0804	B65~	1	MP416			CPM43S					
MWLN R/L2525M08	MWLN R/L2525-43	●	●	25	25	150	32	25	32			1	MWW40	MP420	SWW433	BHA0625	4.5	CPM43N	ER05	LH040	LH030
MWLN R/L3225P08	MWLN R/L3225-43	●	●	32	25	170	32	32	32			1	MP420			CPM43N					

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

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

1st Recommended Insert

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



Application range / Process	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 T1500Z	GU AC8015P	MU AC8025P	EF AC6020M	EG AC6020M	EM AC6030M	UZ AC4010K	GZ AC4010K	EF AC5015S	EG AC5015S	EM AC5015S	SUMIBORON BNC2115	SUMIBORON BN2000
General Machining	SU AC8015P	GU AC8025P	MU AC8025P	EF AC6030M	EG AC6030M	EM AC6040M	GZ AC4015K	GZ AC4015K	EF AC5015S	EG AC5015S	EM AC5025S	SUMIBORON BNC2125	SUMIBORON BN2000
Interrupted Cutting	SX AC8025P	UX AC8035P	MX AC8035P	EF AC6030M	EG AC6040M	EM AC6040M	GZ AC420K	No Chipbreaker AC420K	EF AC5025S	EG AC5025S	EM AC5025S	SUMIBORON BNC2125	SUMIBORON BN2000
Recommended Cutting Conditions	A10~			A14~			A16~		A18~			A20~	

MV series / GD series Profiling Tool Holders

External Holders

C

Negative

Positive

C

D

R

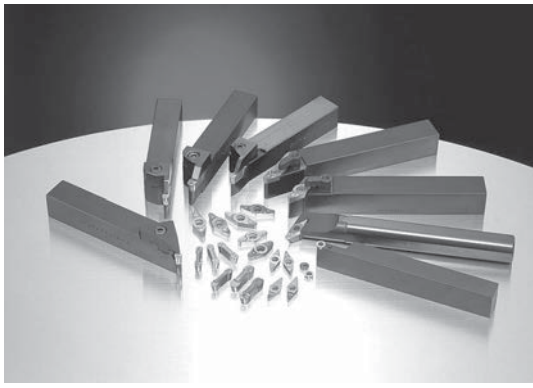
S

T

V

W

Special



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.
- 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

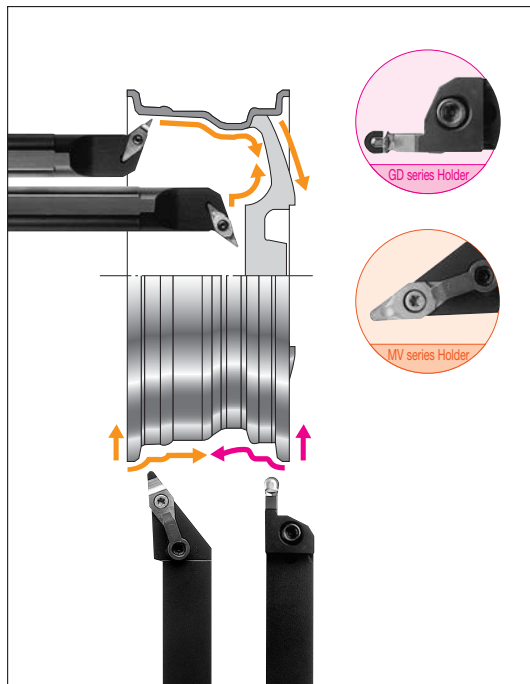
AW type Chipbreaker

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

AG type Chipbreaker

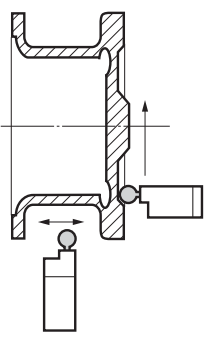
- 35° Diamond type
VCGT160408N-AG (H1)

Series Tool type

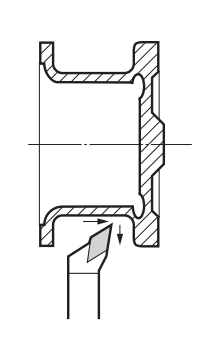


Product Name	Cat. No.	Page
SEC-GD series Holders	GDE R/L2525-600W/S	C47
	GDE R/L2525-800W/S	
	GDE R/L2525-615W/S	
	GDE R/L2525-815W/S	
	GDE R/L2525-645W/S	
SEC-SV series Holders	GDE R/L2525-845W/S	C47
	SVJC R/L2525M16	C40
	SVVC N2525M16	C41
SVPC R/L2525M16		
SEC-MV series Holders	MVXC R/L2525Q22-20	C45
	MVXC R/L2525Q22-30	
	MVPC R/L2525Q22-20	
	MVPC R/L2525Q22-30	
SEC-D series Holders	DVJN R/L2525 M16	C38
	DVVN N2525 M16	C39
	DVQN R/L2525 M16	

Application Examples



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



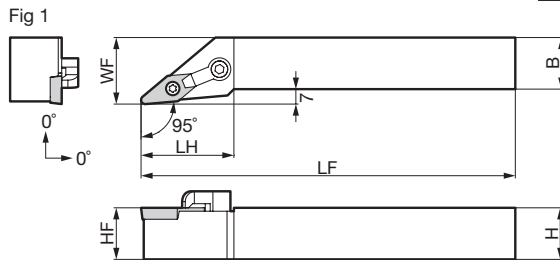
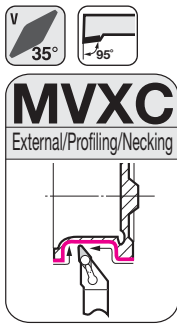
- Cutting Conditions
Tool Holder Cat. No.: SVJCL2525M16
Insert Cat. No.: VCMT160412
Grade: DA1000
 $vc = 2,500\text{m/min}$
 $f = 0.35\text{mm/rev}$
 $ap = 0.2\text{mm}$
- Usage Results
Will not fracture and provides over 17 times the tool life compared to competitors' PCDs.

DA1000 3,500 holes

Competitor's PCD 200 pcs

Tool Life

MV series Profiling Tool Holders



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

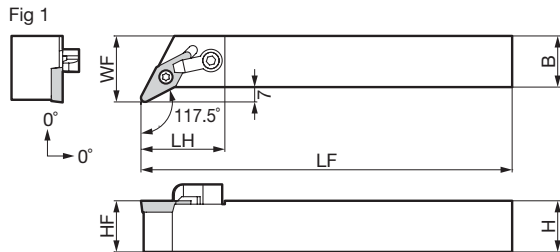
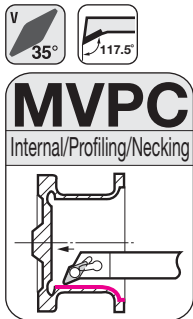
Holder

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 Head Screw	Wrench (For Torx hole)	Wrench for Clamp Plate (For Hexagonal hole)
		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 Boring, Profiling and Necking
Screw-on + Clamp-on

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 Head Screw	Wrench (For Torx hole)	Wrench for Clamp Plate (For Hexagonal hole)
		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 C40 SVVC type C41 SVPC type C41
	VCMT220530	—	—	●	▲	12.70	5.56	3.0	
	VCGT160408N-AW	—	●	—	—	9.525	4.76	0.8	
AW	VCGT160412N-AW	—	●	—	—	9.525	4.76	1.2	DVJN type C38 DVVN type C39 DVQN type C39
	VCGT160408N-AG	—	●	—	—	9.525	4.76	0.8	
	VCGT160412N-AG	—	●	—	—	9.525	4.76	1.2	
AG	NF-VCMT160404	—	—	●	▲	9.525	4.76	0.4	DVJN type C38 DVVN type C39 DVQN type C39
	NF-VCMT160408	—	—	●	▲	9.525	4.76	0.8	
	NF-VCMT160412	—	—	●	▲	9.525	4.76	1.2	
WF	VCMT160408	—	—	●	▲	9.525	4.76	0.8	DVJN type C38 DVVN type C39 DVQN type C39
	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 C38 DVVN type C39 DVQN type C39
	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	DVJN type C38 DVVN type C39 DVQN type C39
	NF-VNMX160412	—	—	●	▲	9.525	4.76	1.2	
	VNMX160404	—	—	●	▲	9.525	4.76	0.4	
UP	VNMX160408	—	—	●	▲	9.525	4.76	0.8	DVJN type C38 DVVN type C39 DVQN type C39
	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)

External Holders

C

Negative

Positive

C

D

R

S

T

V

W

Special

GD series Profiling Tool Holders

Dogbone Insert - External Turning and Profiling Clamp-on

External Holders

C

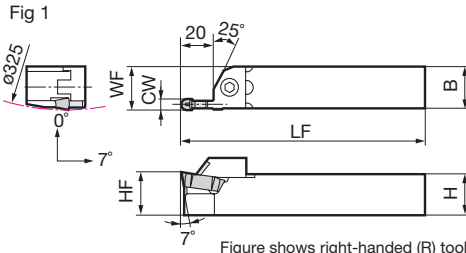
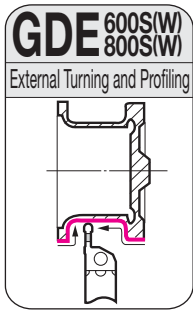


Figure shows right-handed (R) tool.

Negative

Positive

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 Plate	Special Steel Clamp Plate	Cap Screw	Wrench
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	—		
GDE R/L2525-800W	●	●	25	25	150	26	25	8	2	1	GDW800R/L	—		

Refer to MDE series insert group numbers on C47 for applicable inserts.

Dogbone Insert - Facing and Internal Profiling Clamp-on

C

D

R

S

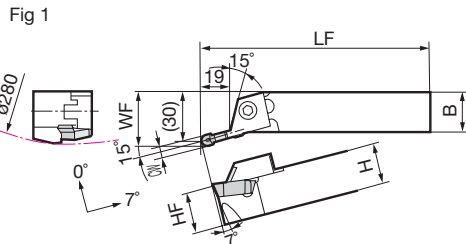
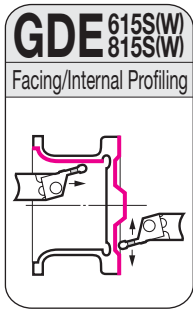


Figure shows right-handed (R) tool.

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 Plate	Special Steel Clamp Plate	Cap Screw	Wrench
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	—		
GDE R/L2525-815W	●	●	25	25	150	33.2	25	8	2	1	GDW815R/L	—		

Refer to MDE series insert group numbers on C47 for applicable inserts.

T

V

W

Special

GD series Profiling Tool Holders

Dogbone Insert for Internal Profiling
Clamp-on

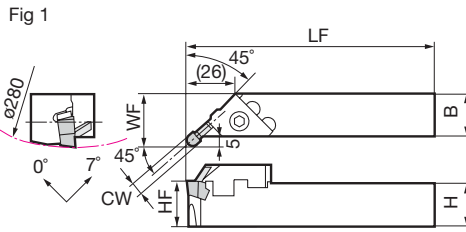
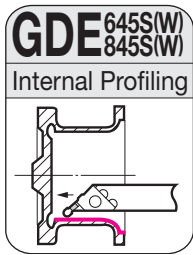


Figure shows right-handed (R) tool.

Holder

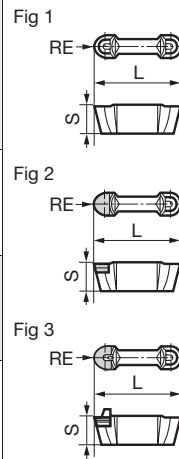
Cat. No.	Stock		Height H	Width B	Overall Length LF	Cutting Edge WF	Cutting Edge Height HF	Width of Cut CW	Group No.	Fig	Parts			
	R	L									Carbide Piece Clamp Plate	Special Steel Clamp Plate	Cap Screw	Wrench <small>(For Hexagonal hole)</small>
GDE R/L2525-645S	●	●	25	25	150	30	25	6	1	1	—	GDS645R/L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

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

Insert (Dogbone type)

(□ Carbide / ■ SUMIDIA)

Shape	Cat. No.	Stock H1	Dimensions (mm)				Group No.	Fig
			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	



External
Holders



Negative

Positive





Special

Clamp Set Parts

External Holders

Parts

Applicable Clamp Set 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	●	6.0

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