

External Holders

C1 to C48

C



External Holders

C

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

C1

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	 DTGN C29	 DTFN C29	 MTJN C35	 MTXN C35
		—	—	 DDNN C15	—	—	—	—	—
Pin Lock	30 series Tool Holders	—	—	—	—	 ETGN C32 ETAN C32	 ETFN C33	 ETEN C34	 ETXN C34
		Lever Lock	70 series Tool Holders	 PCLC D26 D30	 PCLN C11	 PDJC D27 D32	—	 PTGN C30	 PTTN C30
 PCBN C12	 PCFN C12			 PDJN C16	—	—	—	—	—
Screw-on	Mini Holders	 SCLC C13 D26 D30	 SCAC D26 D31	 SDJC C17 D27 D32	 SDAC D28 D33	 STGC D35	 STAC D35	—	—
		—	—	 SDNC D33	 SDPC D28	Clamp-on 40 series Tool Holders	 CTGP/CTAP [FP22/FP21] C36	 CTFP [FP25] C37	—

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



Back Clamping



Internal Coolant Supply

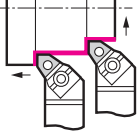
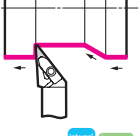
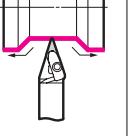
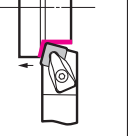
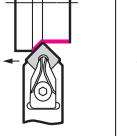
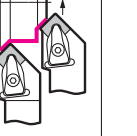
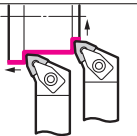
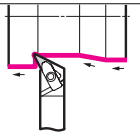
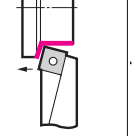
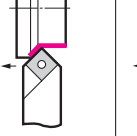
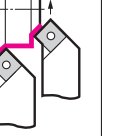
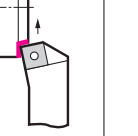
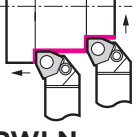
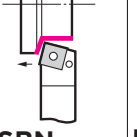
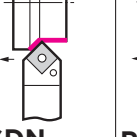
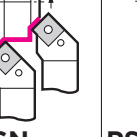
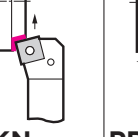
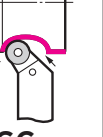
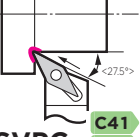
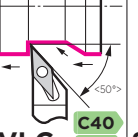
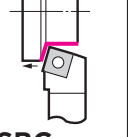
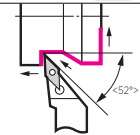
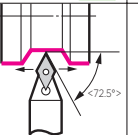
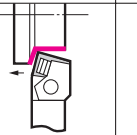
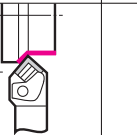
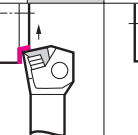
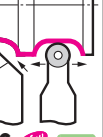
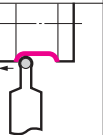
External Tool Holder Series

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				
SEC-D series Holders						○	○		◎	◎	◎	○
SEC-70 series Holders	○						○		◎	◎	◎	◎
SEC-30 series Holders		○					○		△	○	△	◎
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 	35° Diamond type 	Square type 				Round type 
Structure	Type							
Double Clamp	M series Tool Holders	 MWLN C43	 DVJN-J C38	 DVVN C39	 DSBN C20	 DSDN C20	 DSSN C21	—
	D series Tool Holders	 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 C18
Screw-on	Mini Holders	—	 SVPC C41	 SVLC C40	 SSBC D34	—	—	—
	SV series Profiling Tool Holders	—	 SVPP D37	 SVLP D37	Clamp-on 40 series Tool Holders Roll Turning Tool Holder	 CSRП [FP11] C27	 CSDP [FP14] C27	 CSKP [FP15] C28
		—	—	—	—	—	Holders for Round type Inserts	 SRGC C19
		—	—	—	—	—	—	 SRDC C19
		—	—	—	—	—	—	 BNRN L141

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



Back Clamping



Internal Coolant Supply

External Holder Cat. No. Identification Tables

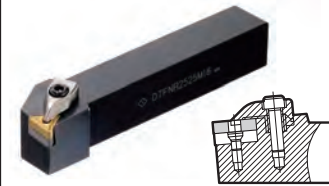
■ SEC-External Holder Cat. No. Identification Tables

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

(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 Added only for holders with the same catalogue numbers but different insert thicknesses	(11) Shim Added only for holders with shims such as SEC-30 (G) types
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● Example

DTFNR2525M16



- 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
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-handed	Symbol	Left-handed	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

Table 7

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

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

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

Table 10

(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		

*CCET03X1→1.40, CCET04X1→1.80

* 91° on our products

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

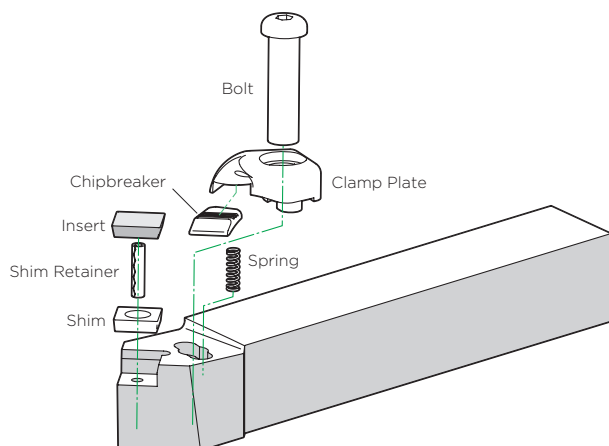
Calculation Formula for Corner Radius Position (mm)			Values of IC and RE for the Calculation of B (mm)		
Shape	Formula		Inscribed Circle Nominal Value	IC for Calculation	Corner Radius
	Triangular type	$B = 3/2d - RE$	3.97	3.9688	02
	Square type	$B = (\sqrt{2} - 1) \times (d/2 - RE)$	4.76	4.7625	04
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

External Holder Clamp Structure

■ SEC-External Holder Clamp Structure List (Examples)

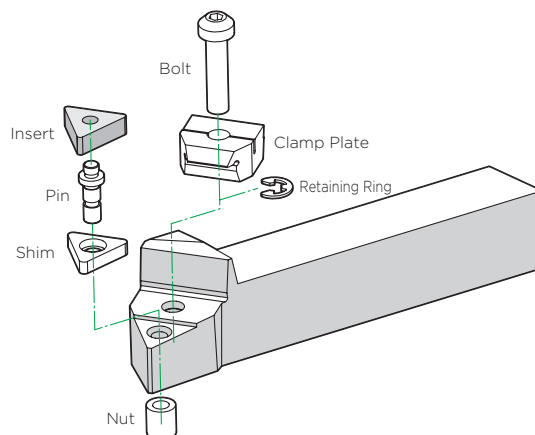
C Clamp-on

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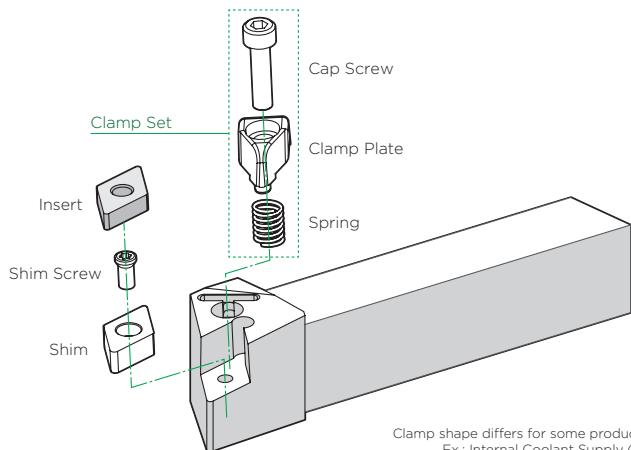
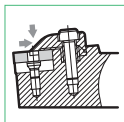
M Clamp-on + Pin Lock

MTJN type / MTXN type / MWLN type



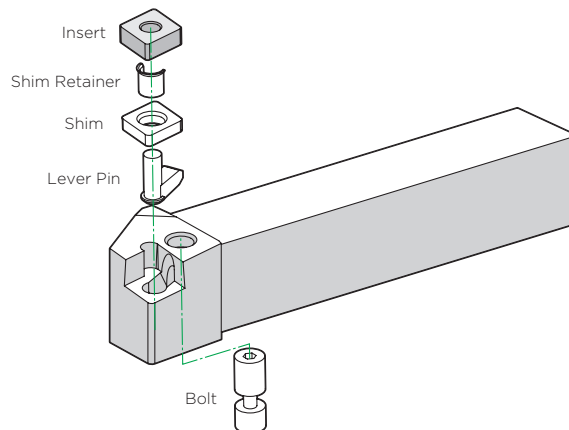
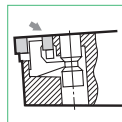
D Double Clamp

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DVJN(-J) type / DVVN type / DVQN type / DWLN(-J) type



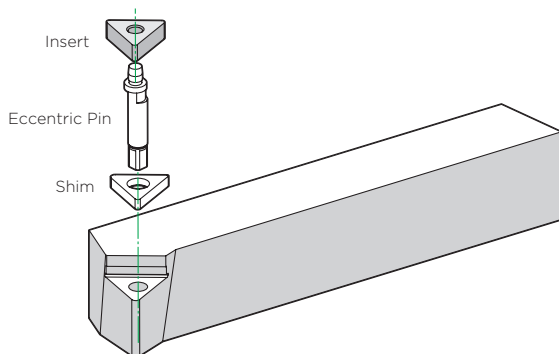
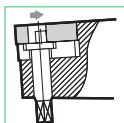
P Lever Lock

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



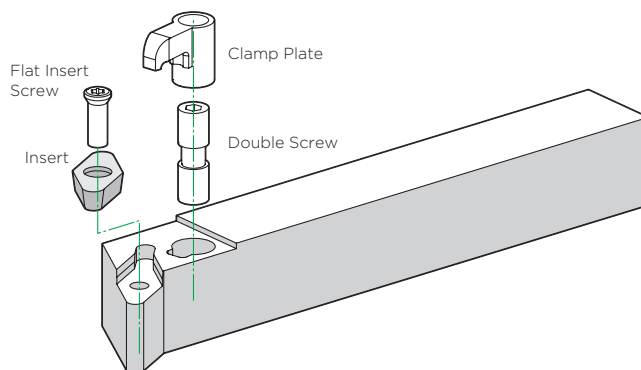
E Pin Lock

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

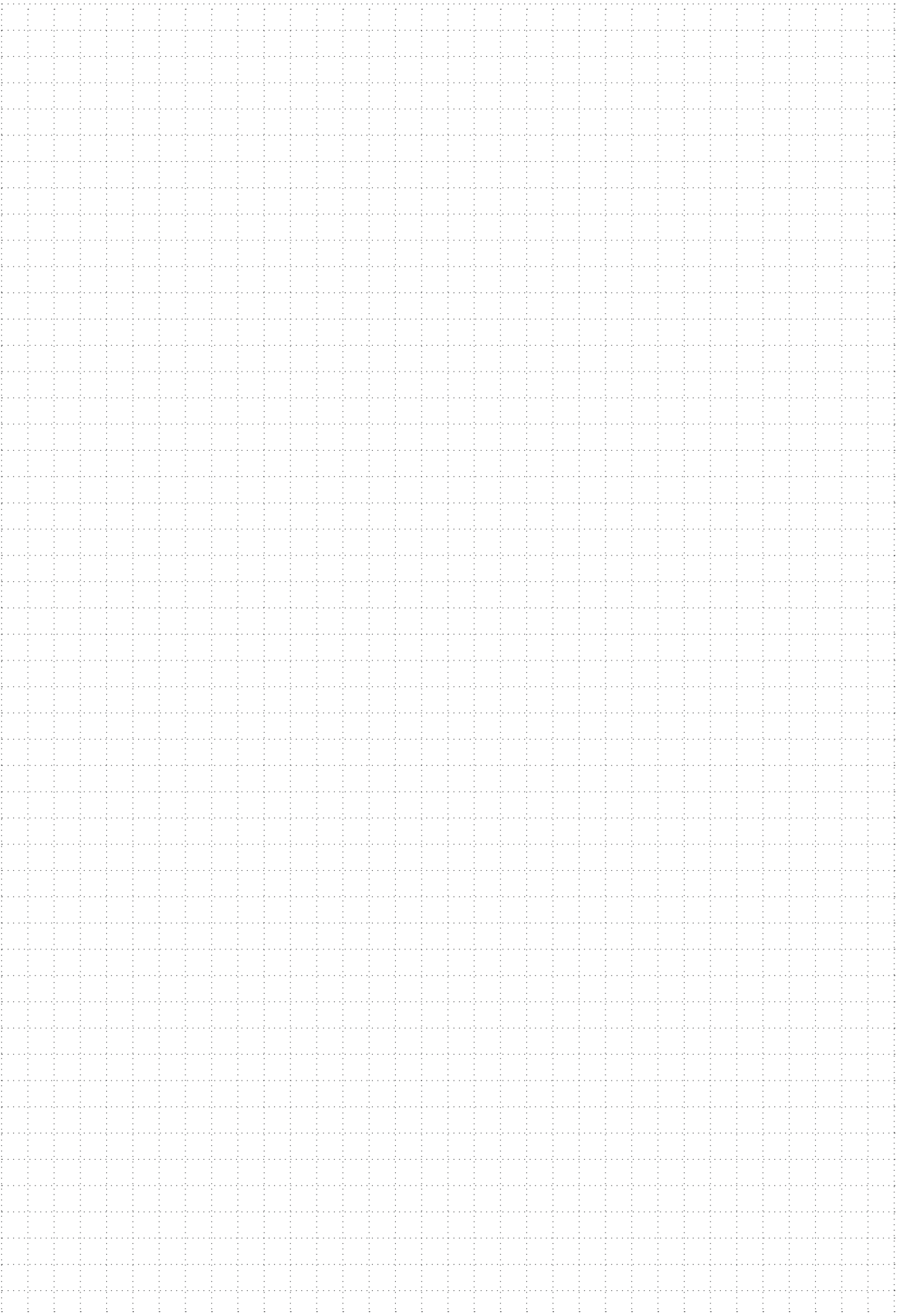


Screw-on + Clamp-on

MVXC type Profiling Tool Holders / MVPC type Profiling Tool Holders



MEMO



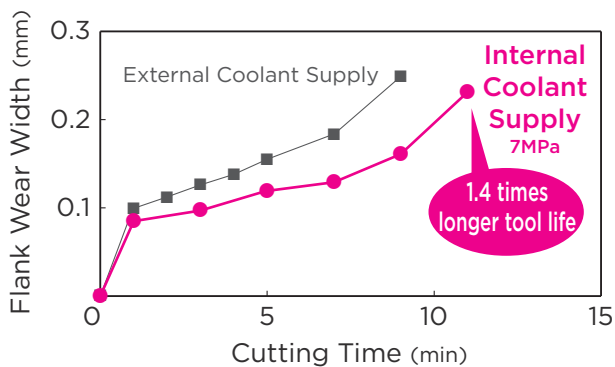
Internal Coolant Holders



■ Features

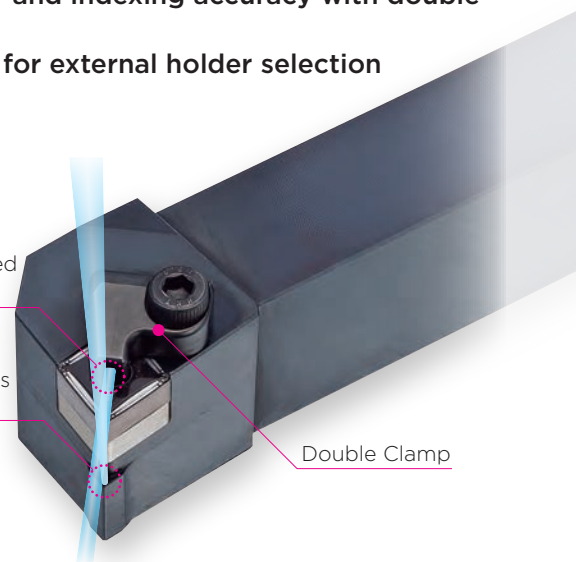
- Through-clamp internal coolant supply holder improves chip evacuation and tool life
- Enables directed coolant supply from a close range, towards the cutting edge
- Suppresses flank wear with additional coolant supply to the flank face
- Realises high rigidity and indexing accuracy with double clamping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

■ Wear Resistance



Coolant supply near the rake face directed at the cutting edge

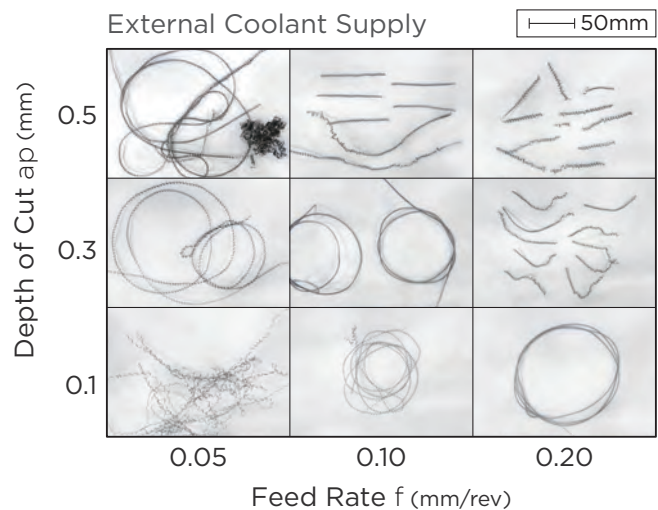
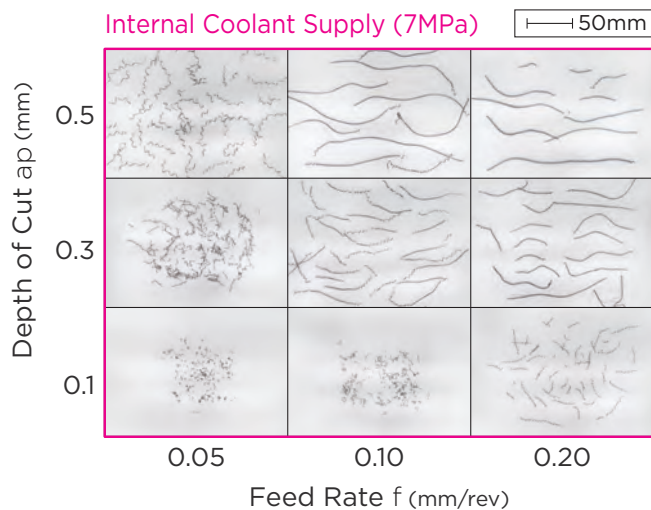
Coolant supply from the bottom suppresses flank wear



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

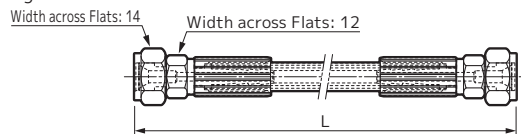


Fig 1

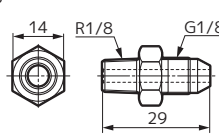
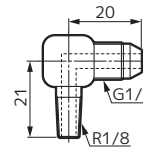


Fig 2



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

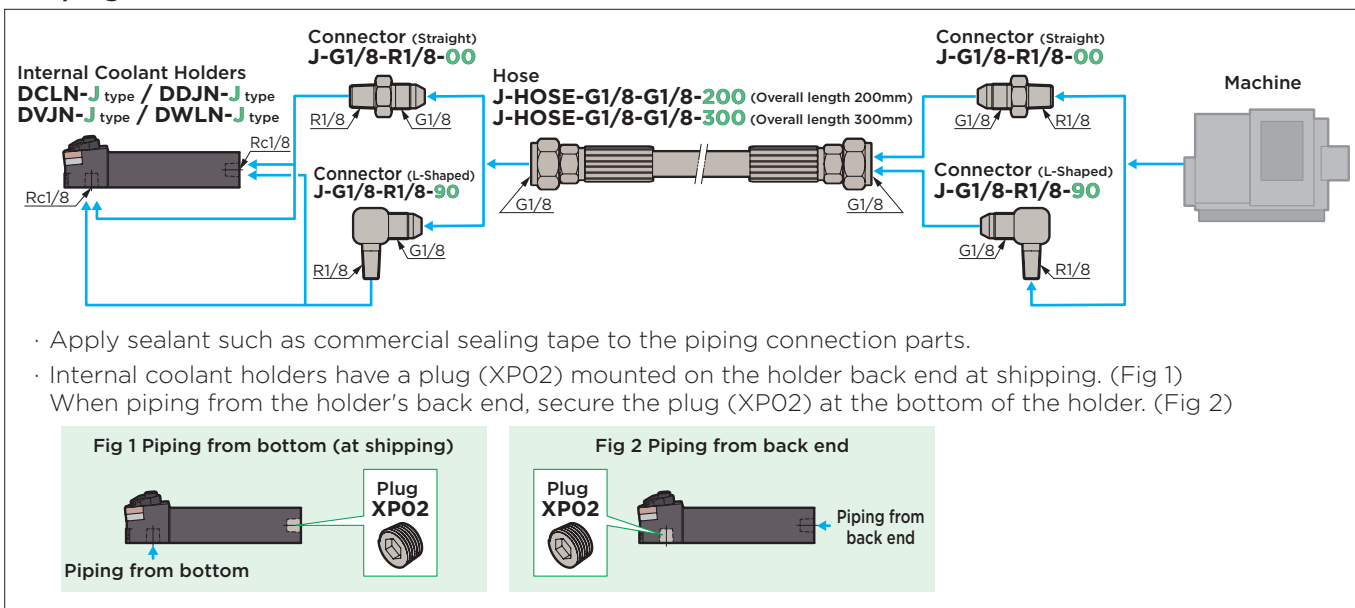
Hoses are sold separately.

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



- Apply sealant such as commercial sealing tape to the piping connection parts.
- Internal coolant holders have a plug (XP02) mounted on the holder back end at shipping. (Fig 1)
When piping from the holder's back end, secure the plug (XP02) at the bottom of the holder. (Fig 2)

Precautions for SEC-External Holders - Internal Coolant Holders

Insert Removal Precautions

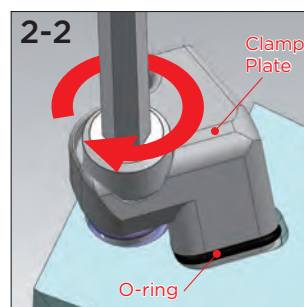
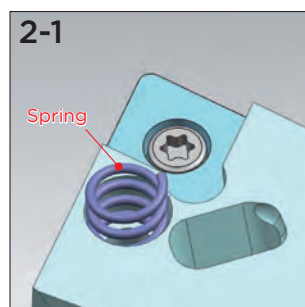
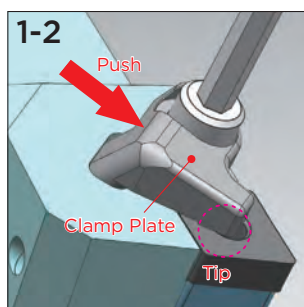
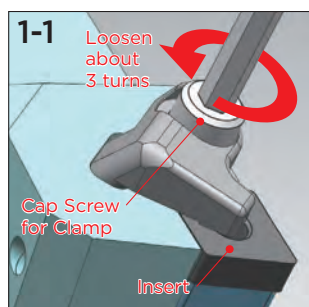
- Use a wrench to loosen the cap screw for clamp by about three turns, and then remove the insert. (Fig 1-1 below)
- If the clamp plate tip catches on the insert when removing, push the clamp plate in the arrow direction as in Fig 1-2 below.

Precautions for Removing and Assembling O-Rings and Clamps

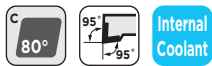
- O-rings are consumable parts. If worn or damaged, replace with a new O-ring as stipulated.
- When replacing, remove the cap screw and then remove the clamp from the body. (Be careful not to lose the spring).
Remove the old O-ring from the clamp plate, clean the clamp plate groove, and then set the 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 maximise coolant effects on the flank and prevent holder interference, use with an insert with **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

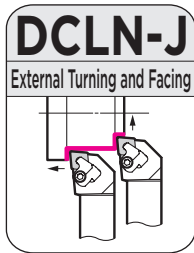


Fig 1

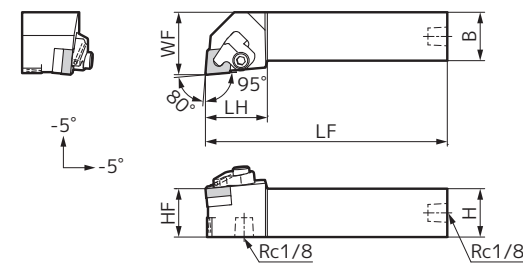


Figure shows right-handed (R) tool.

Holder

Parts

Dimensions (mm)

Cat. No.	Stock		Height	Width	Overall Length	Cutting Edge	Cutting Edge Height	Head	Applicable Insert		Fig	Clamp 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	HF	LH	Cat. No.	Ref. Page								 (For Torx hole)	 (For Hexagonal hole)	 (For Hexagonal hole)		
DCLN R/L2020K12-J	●	●	20	20	125	25	20	32	CN□□1204	B14 ~	1	JCR/L-01	CP-M5-20-1	5.0	CSP12J	SSO60	CNS1204	BFTX0409N	TRX15(*)	LH040	LH025	XPO2
DCLN R/L2525K12-J	●	●	25	25	125	32	25	32	CN□□1204	B14 ~	1	JCR/L-01	CP-M5-20-1	5.0	CSP12J	SSO60	CNS1204	BFTX0409N	TRX15(*)	LH040	LH025	XPO2

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



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

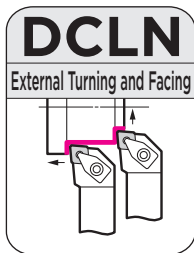


Fig 1

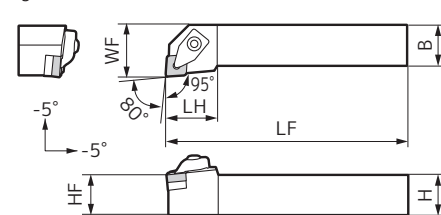


Figure shows right-handed (R) tool.

Holder

Parts

Dimensions (mm)

Cat. No.	Stock		Height	Width	Overall Length	Cutting Edge Length	Cutting Edge Height	Head	Applicable Insert		Fig	Clamp Set		Shim	Shim Screw	Wrench for Shim	Top Hex Wrench	Bottom Hex Wrench
	R	L							Cat. No.	Ref. Page		SCP-2	N-m					
			H	B	LF	WF	HF	LH			Cat. No.			Ref. Page	SCP-2	N-m		
DCLN R/L2020K12	●	●	20	20	125	25	20	32	CN□□1204	B14 ~	1	SCP-2	5.0	CNS1204	BFTX0409N	TRX15(*)	LH040	LH025
DCLN R/L2525M12	●	●	25	25	150	32	25	32	CN□□1204	B14 ~	1	SCP-2	5.0	CNS1204	BFTX0409N	TRX15(*)	LH040	LH025
DCLN R/L2525M16	●	●	25	25	150	32	25	32	CN□□1606	B18 ~	1	SCP-3	5.0	CNS1606	BFTX0509N	TRX20(*)	LH040	LH025
DCLN R/L3232P16	●	●	32	32	170	40	32	32	CN□□1606	B18 ~	1	SCP-3	5.0	CNS1606	BFTX0509N	TRX20(*)	LH040	LH025
DCLN R/L3232P19	●	●	32	32	170	40	32	42	CN□□1906	B20 ~	1	SCP-5	5.0	CNS1906	BFTX0511N	TRX20(*)	LH040	LH025
DCLN R/L4040S19	●	●	40	40	250	50	40	42	CN□□1906	B20 ~	1	SCP-5	5.0	CNS1906	BFTX0511N	TRX20(*)	LH040	LH025
DCLN R/L4040S25	●	●	40	40	250	50	40	53	CN□□2509	B22	1	SCP-6	6.0	CNS2509	BFTX0615N	TRD25(*)	LH060	—

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

Clamp Set Parts **C48**

PCLN type

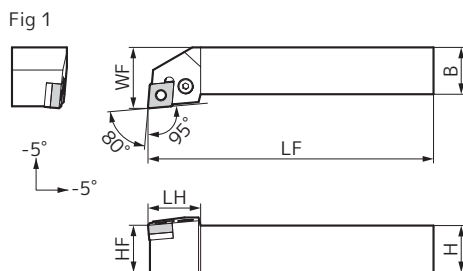
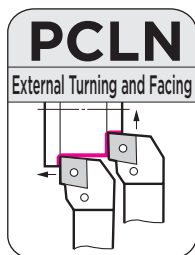
SEC-70 series Holder - General Turning, Facing and Profiling
Lever Lock

Figure shows right-handed (R) tool.

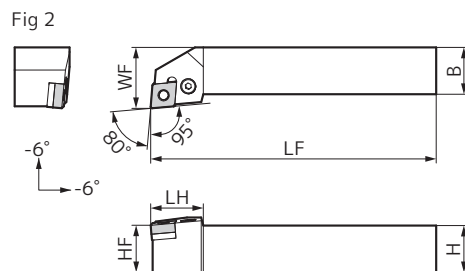


Figure shows right-handed (R) tool.

Holder

Parts

Dimensions (mm)

Cat. No.	Previous Cat. No.	Stock		Height	Width	Overall Length	Cutting Edge	Cutting Edge Height	Head	Applicable Insert		Fig	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	B12	1	LCL3	LCS3	LSC32	LSP3	LH025
PCLN R/L2020K0904	PCLN R/L2020-33	●	●	20	20	125	25	20	20	CN□□0904	B13	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	B14 ~	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	B18 ~	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	B20 ~	2	LCL6	LCS6	LSC63	LSP6	LH040
PCLN R/L4040R19	PCLN R/L4040-64	●	●	40	40	200	50	40	38			2					

External Holders



Negative

Positive



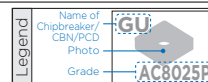
Special

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

1st Recommended Insert

● Refer as well to the Insert Selection Guide (Page 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 AC8115P	MU AC8020P	EF AC6020M	EG AC6020M	EM AC6030M	SUMIBORON BN7125/BNCS500	UZ AC4010K	GZ AC4010K	EF AC5015S	EG AC5015S	EM AC5015S	SUMIDIA DA1000	AX H1	SUMIBORON BNC2115	SUMIBORON BN1000
General Machining	SU AC8115P	GU AC8025P	MU AC8025P	EF AC6030M	EG AC6030M	EM AC6135M	SUMIBORON BN7125/BNCS500	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	EH AC6135M	EM AC6145M	SUMIBORON BN7125/BNCS500	GZ AC4125K	No Chipbreaker AC4125K	EF AC5025S	EG AC5025S	EM AC5025S	SUMIDIA DA1000	—	SUMIBORON BNC2135	SUMIBORON BN350
Recommended Cutting Conditions	A10 ~			A14 ~			A16 ~			A18 ~			A22 ~		A20 ~	

BNC500 is for ductile cast iron.

PCBN type / PCFN type

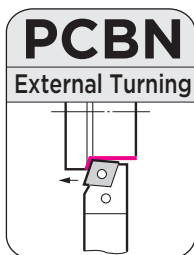
SEC-70 series Holder - General Turning
Lever Lock

Fig 1

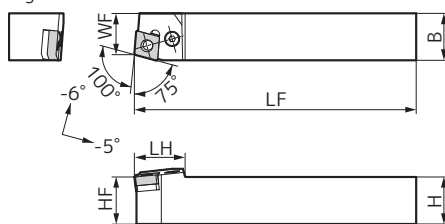


Figure shows right-handed (R) tool.

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					
PCBN R/L2020K12	PCBN R/L2020-43	●	●	20	20	125	17	20	27	CN□□1204	B14 ~	1	LCL4	LCS4	LSC42	LSP4
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	B18 ~	1	LCL5	LCS5	LSC53	LSP5
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							
PCBN R/L4040R19	PCBN R/L4040-64	●	●	40	40	200	35	40	38	CN□□1906	B20 ~	1	LCL6	LCS6	LSC63	LSP6

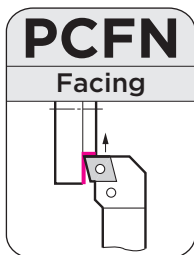
SEC-70 series Holder - General Turning, Facing and Profiling
Lever Lock

Fig 1

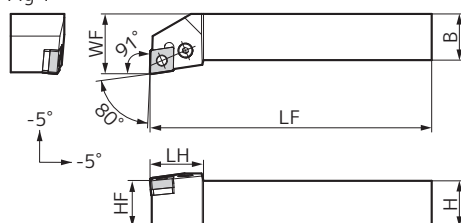


Figure shows right-handed (R) tool.

Holder

Parts

Dimensions (mm)

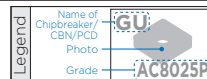
Cat. No.	Previous Cat. No.	Stock		Height	Width	Overall Length	Cutting Edge	Cutting Edge Height	Head	Applicable Insert		Lever Pin	Bolt	Shim	Shim Retainer	Wrench
		R	L							Cat. No.	Ref. Page					
PCFN R/L2020K12	PCFN R/L2020-43	●	●	20	20	125	25	20	28	CN□□1204	B14 ~	1	LCL4	LCS4	LSC42	LSP4
PCFN R/L2520M12	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 chipbreaker 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 (Page 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	GU	MU	EF	EG	EM	SUMIBORON	UZ	GZ	EF	EG	EM	SUMIDIA	AX	SUMIBORON	SUMIBORON
	T1500Z	AC8115P	AC8020P	AC6020M	AC6020M	AC6030M	BN7125/BNC500	AC4010K	AC4010K	AC5015S	AC5015S	AC5015S	DA1000	H1	BNC2115	BN1000
General Machining	SU	GU	MU	EF	EG	EM	SUMIBORON	GZ	GZ	EF	EG	EM	SUMIDIA	AX	SUMIBORON	SUMIBORON
	AC8115P	AC8025P	AC8025P	AC6030M	AC6030M	AC6135M	BN7125/BNC500	AC4015K	AC4015K	AC5015S	AC5015S	AC5025S	DA1000	H1	BNC2125	BN2000
Interrupted Cutting	SX	UX	MX	EF	EH	EM	SUMIBORON	GZ	No Chipbreaker	EF	EG	EM	SUMIDIA	—	SUMIBORON	SUMIBORON
	AC8025P	AC8035P	AC8035P	AC6030M	AC6135M	AC6145M	BN7125/BNC500	AC4125K	AC4125K	AC5025S	AC5025S	AC5025S	DA1000	—	BNC2135	BN350
Recommended Cutting Conditions	A10 ~			A14 ~			A16 ~			A18 ~			A22 ~		A20 ~	

BNC500 is for ductile cast iron.

SCLC type

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

SumiSmall

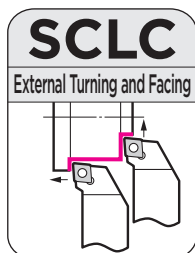


Fig 1

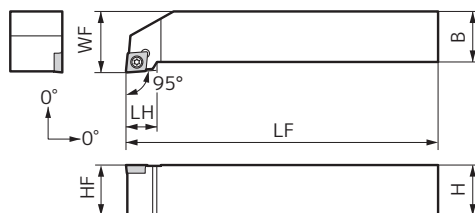


Figure shows right-handed (R) tool.

Holder

Parts

Dimensions (mm)

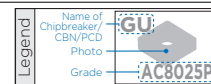
Cat. No.	Previous Cat. No.	Stock		Height	Width	Overall Length	Cutting Edge	Cutting Edge Height	Head	Applicable Insert		Fig	Flat Insert Screw		Wrench	
		R	L							Cat. No.	Ref. Page					
				H	B	LF	WF	HF	LH						(For Torx hole)	
SCLC R/L0808H06	SCLC R/L0808-06	●	●	8	8	100	10	8	—	CC□□0602	B68 ~	1		BFTX02506N	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	CC□□09T3	B71 ~	1		BFTX0409N	3.4	TRX15
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			1				
SCLC R/L2525M09	SCLC R/L2525M09	●	●	25	25	150	30	25	15			1				

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

Applicable Inserts ◀ SCLC type

1st Recommended Insert

- Refer as well to the Insert Selection Guide (Page 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 Materials
	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 AC8020P	LB AC6030M	GU AC6030M	MU AC6135M	SUMIBORON BN7125/BNC500	MU AC4015K	No Chipbreaker AC4015K	SU AC5015S	SUMIDIA DA1000	AG H1	SUMIBORON BNC2125	SUMIBORON BN2000	SUMIDIA DA1090
	FF AC1030U	SI AC1030U	SC AC1030U	FF AC1030U	SI AC1030U	SC AC1030U	SUMIBORON BN7125/BNC500	—	—	SI AC5015S	SUMIDIA DA1000	—	SUMIBORON BNC2115	SUMIBORON BN1000	SUMIDIA BINDERLESS NPD10
Recommended Cutting Conditions	A10 ~			A14 ~			A16 ~			A18 ~	A22 ~		A20 ~		M2 ~

BNC500 is for ductile cast iron.

Recommended Tightening Torque (N·m)

DDJN-J type / DDJN type

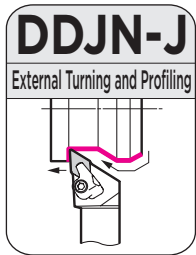
SEC-D series Holder - General Turning and Profiling
Internal Coolant Supply, Double Clamp

Fig 1

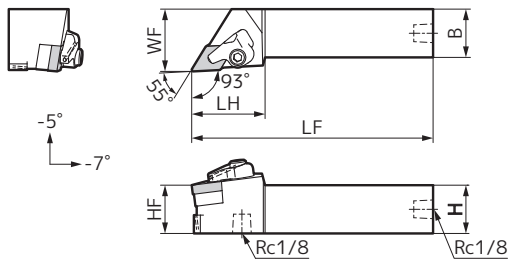


Figure shows right-handed (R) tool.

Holder

Parts

Dimensions (mm)

Cat. No.	Stock		Height	Width	Overall Length	Cutting Edge Length	Cutting Edge Height	Head	Applicable Insert		Fig	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												
DDJN R/L2020K15-J	●	●	20	20	125	25	20	38			1	JDR/L-01	CP-M5-20-1	5.0	CSP12J	SSO60	DNS1504	BFTX0409N	TRX15(*)	LH040	LH025	XPO2
DDJN R/L2525K15-J	●	●	25	25	125	32	25	38	DN□□1504	B24 ~	1	JDR/L-01	CP-M5-20-1	5.0	CSP12J	SSO60	DNS1504	BFTX0409N	TRX15(*)	LH040	LH025	XPO2
DDJN R/L2525K15E-J	●	●	25	25	125	32	25	38	DN□□1506	B28 ~	1	JDR/L-01	CP-M5-20-1	5.0	CSP12J	SSO60	DNS1506	BFTX0409N	TRX15(*)	LH040	LH025	XPO2

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

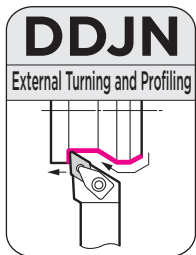
SEC-D series Holder - General Turning and Profiling
Double Clamp

Fig 1

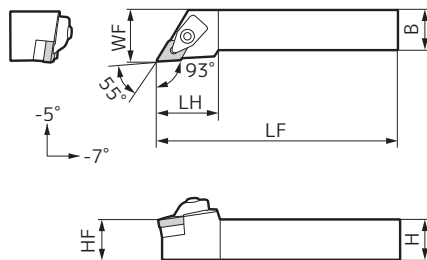


Figure shows right-handed (R) tool.

Holder

Parts

Dimensions (mm)

Cat. No.	Stock		Height	Width	Overall Length	Cutting Edge Length	Cutting Edge Height	Head	Applicable Insert		Fig	Clamp Set		Shim	Shim Screw	Wrench for Shim	Top Hex Wrench	Bottom Hex Wrench
	R	L							Cat. No.	Ref. Page								
DDJN R/L2020K15	●	●	20	20	125	25	20	38	DN□□1504	B24 ~	1	SCP-2	5.0	DNS1504	BFTX0409N	TRX15(*)	LH040	LH025
DDJN R/L2525M15	●	●	25	25	150	32	25	38	DN□□1504	B24 ~	1	SCP-2	5.0	DNS1504	BFTX0409N	TRX15(*)	LH040	LH025
DDJN R/L2525M15E	●	●	25	25	150	32	25	38	DN□□1506	B28 ~	1	SCP-2	5.0	DNS1506	BFTX0409N	TRX15(*)	LH040	LH025

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

Clamp Set Parts C48

External Holders

C

Negative

Positive

C

D

R

S

T

V

W

Special

DDHN type / DDNN type



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

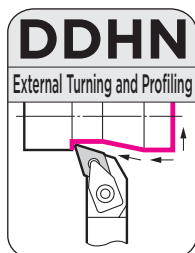


Fig 1

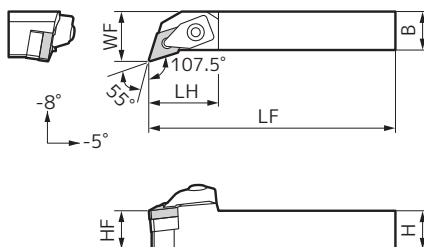


Figure shows right-handed (R) tool.

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	LF	WF	HF	LH	Cat. No.	Ref. Page		SCP-2	N-m	DNS1504	BFTX0409N	TRX15(*)	LH040	LH025
DDHN R/L2020K15	●	●	20	20	125	25	20	35	DN□□1504	B24 ~	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

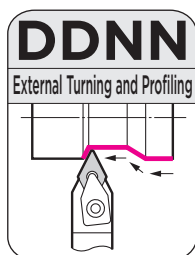


Fig 1

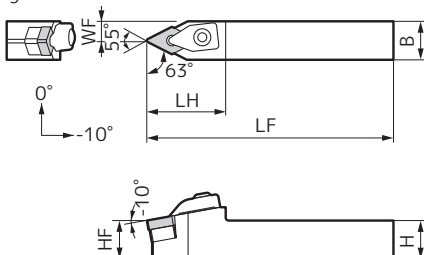
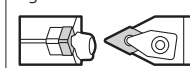


Fig 2



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	Cat. No.	Ref. Page		SCP-2	N-m	DNS1504	BFTX0409N	TRX15(*)	LH040	LH025
DDNN N2020K15	●	20	20	125	10.5	20	40	DN□□1504	B24 ~	1	SCP-2	5.0	DNS1504	BFTX0409N	TRX15(*)	LH040	LH025
DDNN N2525M15	●	25	25	150	13.0	25	40			2							

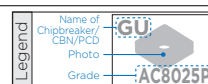
*Wrench for shim is sold separately from the main body.

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 (Page 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 Materials
	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 AC8115P	MU AC8020P	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 AC8115P	GU AC8025P	MU AC8025P	EF AC6030M	EG AC6030M	EM AC6135M	SUMIBORON BN7125/BNC500	GZ AC4015K	GZ AC4015K	EF AC5015S	EG AC5015S	EM AC5025S	SUMIDIA DA1000	AX H1	SUMIBORON BNC2125	SUMIBORON BN2000	SUMIDIA DA1090
Interrupted Cutting	SX AC8025P	UX AC8035P	MX AC8035P	EF AC6030M	EH AC6135M	EM AC6145M	SUMIBORON BN7125/BNC500	GZ AC4125K	No Chipbreaker AC4125K	EF AC5025S	EG AC5025S	EM AC5025S	SUMIDIA DA1000	—	SUMIBORON BNC2135	SUMIBORON BN350	—
Recommended Cutting Conditions	A10 ~			A14 ~			A16 ~			A18 ~			A22 ~		A20 ~		M2 ~

BNC500 is for ductile cast iron.

Recommended Tightening Torque (N·m)

PDJN type



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

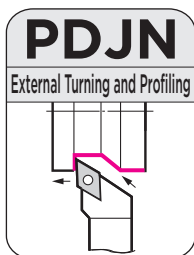


Fig 1

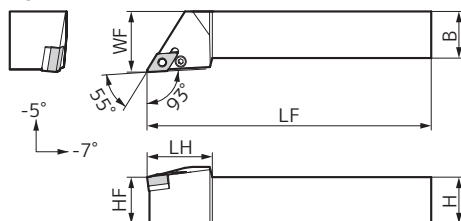


Figure shows right-handed (R) tool.

Holder

Parts

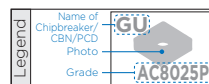
Dimensions (mm)

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					
PDJN R/L2020K11	PDJN R/L2020-33	●	●	20	20	125	25	20	25	DN□□1104	B23 ~	1	LCL3	LCS3	LSD317	LSP3
PDJN R/L2525M11	PDJN R/L2525-33	●	●	25	25	150	32	25	25			1				LH025
PDJN R/L2020K1504	PDJN R/L2020-43	●	●	20	20	125	25	20	35	DN□□1504	B24 ~	1	LCL4	LCS4	LSD42	LSP4
PDJN R/L2525M1504	PDJN R/L2525-43	●	●	25	25	150	32	25	35			1				
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	DN□□1506	B28 ~	1	LCL4	LCS4	LSD42	LSP4
PDJN R/L3225P1506	PDJN R/L3225-44			32	25	170	32	32	35			1				
PDJN R/L3232P1506	PDJN R/L3232-44			32	32	170	40	32	35			1				

Applicable Inserts ◀ DDJN-J type / DDJN type / DDHN type / DDNN type / PDJN 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	P (Steel)			M (Stainless Steel)			K (Cast Iron)			S (Exotic Alloy)			N (Non-Ferrous)		H (Hardened Steel)		Hard Brittle Materials
	Finishing	Medium Cutting	Roughing	Finishing	Medium Cutting	Roughing	High-speed Finishing	Finishing to Medium Cutting	Medium to Roughing	Finishing	Medium Cutting	Roughing	High-precision/Finishing	Finishing to Medium Cutting	Coated	Uncoated	Finishing
Continuous Cutting	FE	GU	MU	EF	EG	EM	SUMIBORON	UZ	GZ	EF	EG	EM	SUMIDIA	AX	SUMIBORON	SUMIBORON	SUMIDIA BINDERLESS
General Machining	T1500Z	AC8115P	AC8020P	AC6020M	AC6020M	AC6030M	BN7125/BNCS500	AC4010K	AC4010K	AC5015S	AC5015S	AC5015S	DA1000	H1	BNC2115	BN1000	NPD10
	SU	GU	MU	EF	EG	EM	SUMIBORON	GZ	GZ	EF	EG	EM	SUMIDIA	AX	SUMIBORON	SUMIBORON	SUMIDIA
Interrupted Cutting	AC8115P	AC8025P	AC8025P	AC6030M	AC6030M	AC6135M	BN7125/BNCS500	AC4015K	AC4015K	AC5015S	AC5015S	AC5025S	DA1000	H1	BNC2125	BN2000	DA1090
	SX	UX	MX	EF	EH	EM	SUMIBORON	GZ	No Chipbreaker	EF	EG	EM	SUMIDIA		SUMIBORON	SUMIBORON	
Recommended Cutting Conditions	A10 ~			A14 ~			A16 ~			A18 ~			A22 ~		A20 ~		M2 ~

BNCS500 is for ductile cast iron.

SDJC type



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

SumiSmall

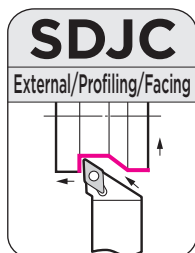


Fig 1

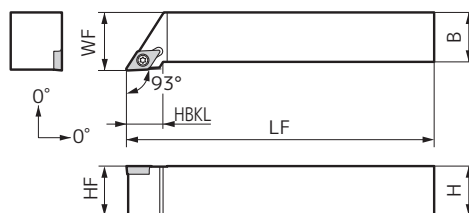


Figure shows right-handed (R) tool.

Holder

Parts

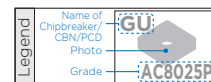
Dimensions (mm)

Cat. No.	Previous Cat. No.	Stock		Height H	Width B	Overall Length LF	Cutting Edge WF	Cutting Edge Height HF	Head HBKL	Applicable Insert			Flat Insert Screw			Wrench
		R	L							Cat. No.	Ref. Page	Fig		N·m		
SDJC R/L0808H07	SDJC R/L0808-07	●		8	8	100	10	8	15	DC□□0702	B78 ~	1 1		BFTX02506N	1.5	TRX08
SDJC R/L1010H07	SDJC R/L1010-07	●	●	10	10	100	12	10	18							
SDJC R/L1212H11	SDJC R/L1212-11	●	●	12	12	100	16	12	18							
SDJC R/L1616H11	SDJC R/L1616-11	●	●	16	16	100	20	16	18							
SDJC R/L2020K11	SDJC R/L2020-11	●	●	20	20	125	24	20	18	DC□□11T3	B82 ~	1 1 1		BFTX0409N	3.4	TRX15
SDJC R/L2525M11	SDJC R/L2525M11	●	●	25	25	150	29	25	18							

Applicable Inserts ◀ SDJC 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)	N (Non-Ferrous)		H (Hardened Steel)		Hard Brittle Materials
	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 AC8020P	LB AC6030M	GU AC6030M	MU AC6135M	SUMIBORON BN7125/BNCS500	MU AC4015K	No Chipbreaker AC4015K	FX AC5015S	SUMIDIA DA1000	AG H1	SUMIBORON BNC2125	SUMIBORON BN2000	SUMIDIA DA1090
High-precision	FF AC1030U	SI AC1030U	SC AC1030U	FF AC1030U	SI AC1030U	SC AC1030U	SUMIBORON BN7125/BNCS500	—	—	SI AC5015S	SUMIDIA DA1000	—	SUMIBORON BNC2115	SUMIBORON BN1000	SUMIDIA BINDERLESS NPD10
Recommended Cutting Conditions	ISO A10 ~			ISO A14 ~			ISO A16 ~			ISO A18 ~	ISO A22 ~		ISO A20 ~		ISO M2 ~

BNC500 is for ductile cast iron.

Recommended Tightening Torque (N·m)

PRGC type/PRDC type

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

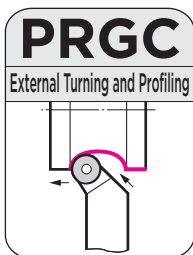


Fig 1

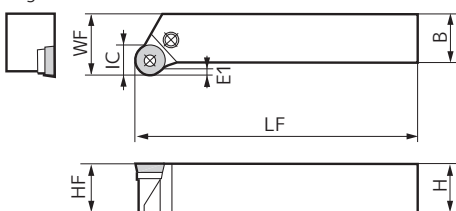


Figure shows right-handed (R) tool.

Holder

Parts

Dimensions (mm)

Cat. No.	Stock		Height	Width	Overall Length	Cutting Edge	Cutting Edge Height	Cutting Edge Distance	Inscribed Circle	Applicable Insert		Fig	Lever Pin	Bolt	Shim	Shim Retainer	Wrench
	R	L								Cat. No.	Ref. Page						
PRGC R/L2020K10	●	●	20	20	125	25	20	1.5	10	RCM□1003M0	B86	1	LCL10	LCS10	LSR10	LSP10	LH020
PRGC R/L2525M10	●	●	25	25	150	32	25	1.5	10			1					
PRGC R/L2020K12	●	●	20	20	125	25	20	2.5	12	RCM□1204M0	B86	1	LCL12	LCS12	LSR12	LSP10	LH025
PRGC R/L2525M12	●	●	25	25	150	32	25	2.5	12			1					
PRGC R/L3225P12	●	●	32	25	170	32	32	2.5	12			1					
PRGC R/L2525M16			25	25	150	32	25	3.0	16	RCM□1606M0	B86	1	LCL16	LCS16	LSR16	LSP16	LH025
PRGC R/L3225P16			32	25	170	32	32	3.0	16			1					
PRGC R/L3232P20			32	32	170	40	32	4.0	20	RCM□2006M0	B86	1	LCL20	LCS20	LSR20	LSP20	LH030
PRGC R/L4040S25			40	40	250	50	40	4.5	25	RCM□2507M0	B86	1	LCL25	LCS25	LSR25	LSP25	LH040
PRGC R/L5050T32			50	50	300	63	50	5.5	32	RCM□3209M0	B86	1	LCL32	LCS32	LSR32	LSP32	LH050

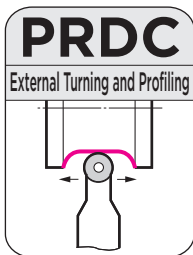
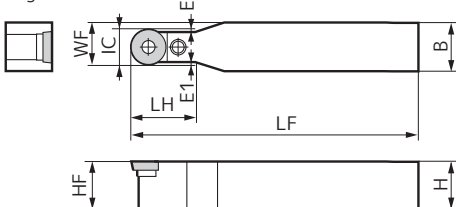


Fig 1



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

Holder

Parts

Dimensions (mm)

Cat. No.	Stock	Height	Width	Overall Length	Cutting Edge	Cutting Edge Height	Head	Cutting Edge Distance	Inscribed Circle	Applicable Insert		Fig	Lever Pin	Bolt	Shim	Shim Retainer	Wrench
										Cat. No.	Ref. Page						
PRDC N2020M10	●	20	20	150	15.0	20	22	1.0	10	RCM□1003M0	B86	1	LCL10	LCS10	LSR10	LSP10	LH020
PRDC N2525M10	●	25	25	150	17.5	25	22	1.0	10			1					
PRDC N2525M12	●	25	25	150	18.5	25	24	1.2	12	RCM□1204M0	B86	1	LCL12	LCS12	LSR12	LSP10	LH025
PRDC N3225Q12	●	32	25	180	18.5	32	24	1.2	12			1					
PRDC N3225Q16	●	32	25	180	20.5	32	28	1.5	16	RCM□1606M0	B86	1	LCL16	LCS16	LSR16	LSP16	LH025
PRDC N3232Q20	●	32	32	180	26.0	32	32	1.7	20	RCM□2006M0	B86	1	LCL20	LCS20	LSR20	LSP20	LH030
PRDC N4040T25		40	40	300	32.5	40	42	2.0	25	RCM□2507M0	B86	1	LCL25	LCS25	LSR25	LSP25	LH040
PRDC N5050U32		50	50	350	41.0	50	52	2.5	32	RCM□3209M0	B86	1	LCL32	LCS32	LSR32	LSP32	LH050

SRGC type / SRDC type



SEC-External Holder (for Round type Inserts) - General Turning and Profiling
Screw-on

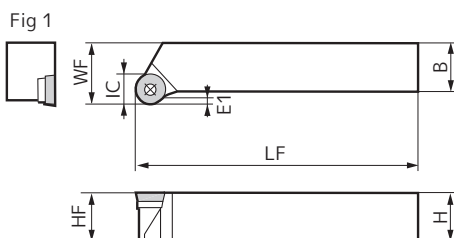
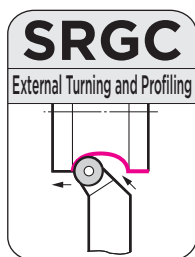


Figure shows right-handed (R) tool.

Holder

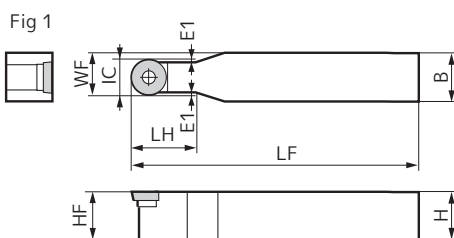
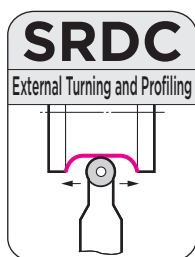
Parts

Dimensions (mm)

Cat. No.	Stock		Height	Width	Overall Length	Cutting Edge	Cutting Edge Distance	Inscribed Circle	Applicable Insert		Fig	Flat Insert Screw		Wrench
	R	L	H	B	LF	WF	E1	IC	Cat. No.	Ref. Page			N·m	
SRGC R/L2020K08	●	●	20	20	125	25	1.0	8	RCMT0803M0	B86	1 1		1.6	TRX10
SRGC R/L2525M08	●	●	25	25	150	32	1.0	8						



SEC-External Holder (for Round type Inserts) - General Turning and Profiling
Screw-on



Holder

Parts

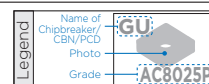
Dimensions (mm)

Cat. No.	Stock	Height	Width	Overall Length	Cutting Edge	Cutting Edge Distance	Inscribed Circle	Applicable Insert		Fig	Flat Insert Screw		Wrench
		H	B	LF	WF	E1	IC	Cat. No.	Ref. Page			N·m	
SRDC N2020K08	●	20	20	125	14.25	0.5	8	RCMT0803M0	B86	1 1		1.6	TRX10
SRDC N2525M08	●	25	25	150	16.75	0.5	8						

Applicable Inserts ◀ PRGC type / PRDC type / SRGC type / SRDC 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	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	RE AC8115P	RX AC8020P	RX AC8020P	RP AC4010K	RP AC4010K	RE AC5015S	RP AC5015S
General Machining	RX AC8025P	RH AC8025P	RH AC8035P	RP AC4015K	RP AC4015K	RE AC5015S	RP AC5015S
Interrupted Cutting	RH AC8025P	RH AC8035P	RP AC8035P	RP AC4125K	RP AC4125K	RE AC5025S	RP AC5025S
Recommended Cutting Conditions	A10 ~			A16 ~		A18 ~	

DSBN type / DSDN type



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

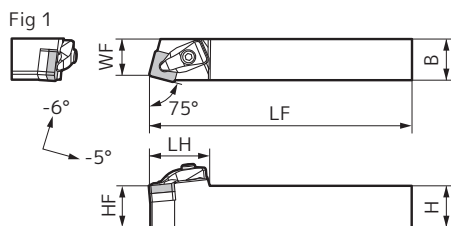
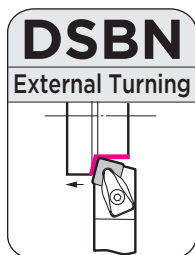


Figure shows right-handed (R) tool.

Holder

Parts

Dimensions (mm)

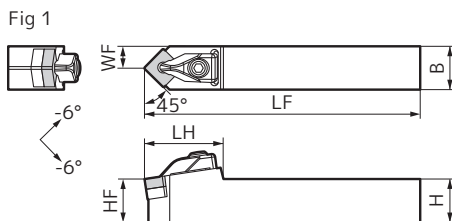
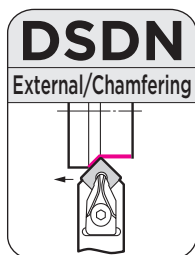
Cat. No.	Stock		Height H	Width B	Overall Length LF	Cutting Edge WF	Cutting Edge Height HF	Head LH	Applicable Insert		Fig	Clamp Set		Shim	Shim Screw	Wrench for Shim	Top Hex Wrench	Bottom Hex Wrench
	R	L							Cat. No.	Ref. Page		SCP-2	N-m					
DSBN R/L2020K12	●	●	20	20	125	17	20	36	SN□□1204	B33 ~	1	SCP-2	5.0	SNS1204	BFTX0409N	TRX15(*)	LH040	LH025
DSBN R/L2525M12	●	●	25	25	150	22	25	36	SN□□1506	B37 ~	1	SCP-3	5.0	SNS1506	BFTX0509N	TRX20(*)	LH040	LH025
DSBN R/L2525M15	●	●	25	25	150	22	25	36	SN□□1506	B37 ~	1	SCP-3	5.0	SNS1506	BFTX0509N	TRX20(*)	LH040	LH025
DSBN R/L3232P15	●	●	32	32	170	27	32	36	SN□□1906	B39 ~	1	SCP-5	5.0	SNS1906	BFTX0511N	TRX20(*)	LH040	LH025
DSBN R/L3232P19	●	●	32	32	170	27	32	45	SN□□1906	B39 ~	1	SCP-5	5.0	SNS1906	BFTX0511N	TRX20(*)	LH040	LH025
DSBN R/L4040S19	●	●	40	40	250	35	40	45	SN□□2507	B41	1	SCP-6	6.0	SNS2507	BFTX0615N	TRD25(*)	LH060	—
DSBN R/L4040S2507	●	●	40	40	250	35	40	58	SN□□2509	B42	1	SCP-6	6.0	SNS2509	BFTX0615N	TRD25(*)	LH060	—
DSBN R/L4040S2509	●	●	40	40	250	35	40	58	SN□□2509	B42	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



Parts

Dimensions (mm)

Cat. No.	Stock	Height H	Width B	Overall Length LF	Cutting Edge WF	Cutting Edge Height HF	Head LH	Applicable Insert		Fig	Clamp Set		Shim	Shim Screw	Wrench for Shim	Top Hex Wrench	Bottom Hex Wrench
								Cat. No.	Ref. Page		SCP-2	N-m					
DSDN N2020K12	●	20	20	125	10.0	20	36	SN□□1204	B33 ~	1	SCP-2	5.0	SNS1204	BFTX0409N	TRX15(*)	LH040	LH025
DSDN N2525M12	●	25	25	150	12.5	25	36	SN□□1204	B33 ~	1	SCP-2	5.0	SNS1204	BFTX0409N	TRX15(*)	LH040	LH025

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

Clamp Set Parts C48

DSSN type

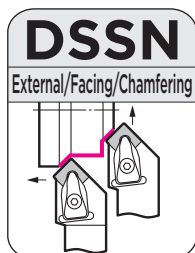
SEC-D series Holder - General Turning, Facing and Chamfering
Double Clamp

Fig 1

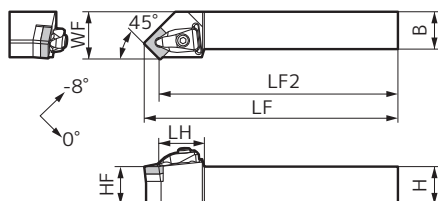


Figure shows right-handed (R) tool.

Holder

Parts

Dimensions (mm)

Cat. No.	Stock		Height	Width	Overall Length	Overall Length 2	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								Cat. No.	Ref. Page		N-m						
DSSN R/L2020K12	●	●	20	20	133.3	125	25	20	30	SN□□1204	B33	1	SCP-2	5.0	SNS1204	BFTX0409N	TRX15(*)	LH040	LH025
DSSN R/L2525M12	●	●	25	25	158.3	150	32	25	30	SN□□1506	B37	1	SCP-3	5.0	SNS1506	BFTX0509N	TRX20(*)	LH040	LH025
DSSN R/L2525M15	●	●	25	25	160.2	150	32	25	30	SN□□1506	B37	1	SCP-3	5.0	SNS1506	BFTX0509N	TRX20(*)	LH040	LH025
DSSN R/L3232P15	●	●	32	32	180.2	170	40	32	30	SN□□1906	B39	1	SCP-5	5.0	SNS1906	BFTX0511N	TRX20(*)	LH040	LH025
DSSN R/L3232P19	●	●	32	32	182.5	170	40	32	36	SN□□1906	B39	1	SCP-5	5.0	SNS1906	BFTX0511N	TRX20(*)	LH040	LH025
DSSN R/L4040S19	●	●	40	40	262.5	250	50	40	36	SN□□2507	B41	1	SCP-6	6.0	SNS2507	BFTX0615N	TRD25(*)	LH060	—
DSSN R/L4040S2507	●	●	40	40	266.0	250	50	40	47	SN□□2509	B42	1	SCP-6	6.0	SNS2509	BFTX0615N	TRD25(*)	LH060	—
DSSN R/L4040S2509	●	●	40	40	266.0	250	50	40	47	SN□□2509	B42	1	SCP-6	6.0	SNS2509	BFTX0615N	TRD25(*)	LH060	—

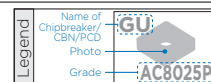
*Wrench for shim is sold separately from the main body.

Clamp Set Parts C48

Applicable Inserts ◀ DSSN 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 (Page 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 Materials
	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 AC8115P	MU AC8020P	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 AC8115P	GU AC8025P	MU AC8025P	EF AC6030M	EG AC6030M	EM AC6135M	SUMIBORON BN7125/BNC500	GZ AC4015K	GZ AC4015K	EF AC5015S	EG AC5015S	EM AC5025S	SUMIBORON BNC2125	SUMIBORON BN2000	SUMIDIA DA1090
Interrupted Cutting	SX AC8025P	UX AC8035P	MX AC8035P	EF AC6030M	EH AC6135M	EM AC6145M	SUMIBORON BN7125/BNC500	GZ AC4125K	No Chipbreaker AC4125K	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)

PSBN type



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

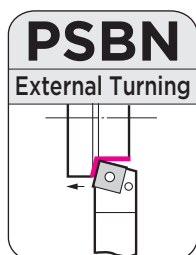


Fig 1

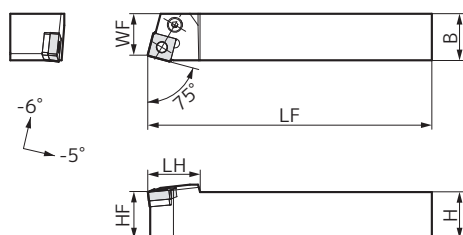


Figure shows right-handed (R) tool.

Holder

Parts

Dimensions (mm)

Cat. No.	Previous Cat. No.	Stock		Height	Width	Overall Length	Cutting Edge	Cutting Edge Height	Head	Applicable Insert		Fig	Lever Pin	Bolt	Shim	Shim Retainer	Wrench
		R	L	H	B	LF	WF	HF	LH	Cat. No.	Ref. Page						
PSBN R/L1616H09	PSBN R/L1616-32	●	●	16	16	100	13	16	22	SN□□0903	B32	1	LCL3	LCS3	LSS32	LSP3	LH025
PSBN R/L2020K12	PSBN R/L2020-43	●	●	20	20	125	17	20	28	SN□□1204	B33 ~	1	LCL4	LCS4	LSS42	LSP4	LH030
PSBN R/L2520M12	PSBN R/L2520-43			25	20	150	17	25	28			1					
PSBN R/L2525M12	PSBN R/L2525-43	●	●	25	25	150	22	25	28			1					
PSBN R/L3225P12	PSBN R/L3225-43			32	25	170	22	32	28			1					
PSBN R/L3232P12	PSBN R/L3232-43			32	32	170	27	32	35	SN□□1506	B37 ~	1	LCL5	LCS5	LSS53	LSP5	LH030
PSBN R/L3225P15	PSBN R/L3225-54			32	25	170	22	32	35			1					
PSBN R/L3232P15	PSBN R/L3232-54	●	●	32	32	170	27	32	35	SN□□1906	B39 ~	1	LCL6	LCS6	LSS63	LSP6	LH040
PSBN R/L3232P19	PSBN R/L3232-64	●	●	32	32	170	27	32	40			1					
PSBN R/L4040R19	PSBN R/L4040-64			40	40	200	35	40	40	SN□□2507	B41	1	LCL8	LCS8	LSS84	LSP8	LH050
PSBN R/L5050S25	PSBN R/L5050-85			50	50	250	43	50	50			1					

External Holders

Negative

Positive

C

D

R

S

T

V

W

Special

PSDN type



SEC-70 series Holder - General Turning and Chamfering
Lever Lock

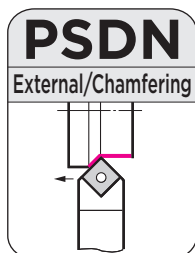
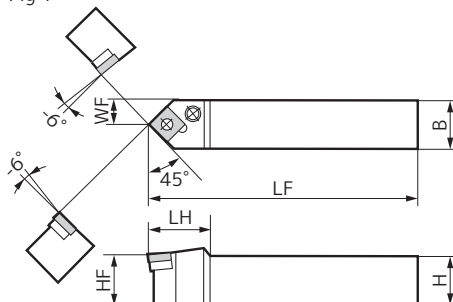


Fig 1



Holder

Parts

Dimensions (mm)

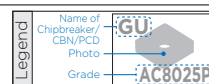
Cat. No.	Previous Cat. No.	Stock	Height H	Width B	Overall Length LF	Cutting Edge WF	Cutting Edge Height HF	Head LH	Applicable Insert		Fig	Lever Pin	Bolt	Shim	Shim Retainer	Wrench
									Cat. No.	Ref. Page						
PSDN N1616H09	PSDN N1616-32	●	16	16	100	8.0	16	22	SN□□0903	B32	1	LCL3	LCS3	LSS32	LSP3	LH025
PSDN N2020K12	PSDN N2020-43	●	20	20	125	10.0	20	30	SN□□1204	B33 ~	1	LCL4	LCS4	LSS42	LSP4	LH030
PSDN N2520M12	PSDN N2520-43	●	25	20	150	10.0	25	30			1					
PSDN N2525M12	PSDN N2525-43	●	25	25	150	12.5	25	30			1					
PSDN N3225P12	PSDN N3225-43	●	32	25	170	12.5	32	30			1					
PSDN N3232P12	PSDN N3232-43	●	32	32	170	16.0	32	40	SN□□1506	B37 ~	1	LCL5	LCS5	LSS53	LSP5	LH030
PSDN N3225P15	PSDN N3225-54	●	32	25	170	12.5	32	40			1					
PSDN N3232P15	PSDN N3232-54	●	32	32	170	16.0	32	40	SN□□1906	B39 ~	1	LCL6	LCS6	LSS63	LSP6	LH040
PSDN N3232P19	PSDN N3232-64	●	32	32	170	16.0	32	40			1					
PSDN N4040R19	PSDN N4040-64	●	40	40	200	20.0	40	40			1					

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 (Page 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 Materials
	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 AC8115P	MU AC8020P	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 AC8115P	GU AC8025P	MU AC8025P	EF AC6030M	EG AC6030M	EM AC6135M	SUMIBORON BN7125/BNC500	GZ AC4015K	GZ AC4015K	EF AC5015S	EG AC5015S	EM AC5025S	SUMIBORON BNC2125	SUMIBORON BN2000	SUMIDIA DA1090	
Interrupted Cutting	SX AC8025P	UX AC8035P	MX AC8035P	EF AC6030M	EH AC6135M	EM AC6145M	SUMIBORON BN7125/BNC500	GZ AC4125K	No Chipbreaker AC4125K	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



Special

PSSN type / PSKN type



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

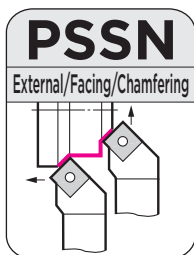


Fig 1

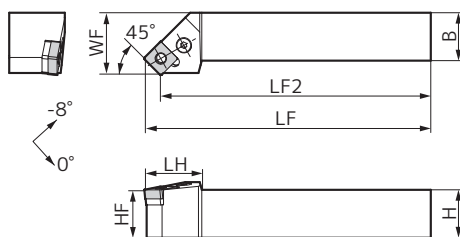


Figure shows right-handed (R) tool.

Holder

Parts

Dimensions (mm)

Cat. No.	Previous Cat. No.	Stock		Height	Width	Overall Length	Overall Length 2	Cutting Edge	Cutting Edge Height	Head	Applicable Insert		Fig	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	B32	1	LCL3	LCS3	LSS32	LSP3	LH025
PSSN R/L2020K12	PSSN R/L2020-43	●	●	20	20	125	116.7	25	20	30	SN□□1204	B33 ~	1	LCL4	LCS4	LSS42	LSP4	LH030
PSSN R/L2520M12	PSSN R/L2520-43	●	●	25	20	150	141.7	25	25	30			1					
PSSN R/L2525M12	PSSN R/L2525-43	●	●	25	25	150	141.7	32	25	30			1					
PSSN R/L3225P12	PSSN R/L3225-43	●	●	32	25	170	161.7	32	32	30			1					
PSSN R/L3232P12	PSSN R/L3232-43	●	●	32	32	170	161.7	40	32	30	SN□□1506	B37 ~	1	LCL5	LCS5	LSS53	LSP5	LH030
PSSN R/L3225P15	PSSN R/L3225-54	●	●	32	25	170	159.8	32	32	40			1					
PSSN R/L3232P15	PSSN R/L3232-54	●	●	32	32	170	159.8	40	32	40	SN□□1906	B39 ~	1	LCL6	LCS6	LSS63	LSP6	LH040
PSSN R/L3232P19	PSSN R/L3232-64	●	●	32	32	170	157.5	40	32	40			1					
PSSN R/L4040R19	PSSN R/L4040-64	●	●	40	40	200	187.5	50	40	40			1					

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



SEC-70 series Holder - Facing
Lever Lock

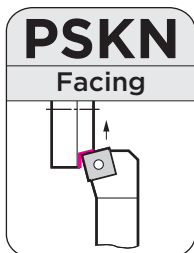


Fig 1

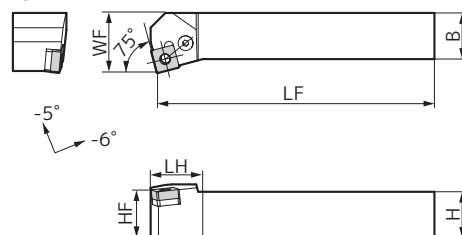


Figure shows right-handed (R) tool.

Holder

Parts

Dimensions (mm)

Cat. No.	Previous Cat. No.	Stock		Height	Width	Overall Length	Cutting Edge	Cutting Edge Height	Head	Applicable Insert		Fig	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	B32	1	LCL3	LCS3	LSS32	LSP3	LH025
PSKN R/L2020K12	PSKN R/L2020-43	●	●	20	20	125	25	20	26	SN□□1204	B33 ~	1	LCL4	LCS4	LSS42	LSP4	LH030
PSKN R/L2520M12	PSKN R/L2520-43	●	●	25	20	150	25	25	26			1					
PSKN R/L2525M12	PSKN R/L2525-43	●	●	25	25	150	32	25	26			1					
PSKN R/L3225P12	PSKN R/L3225-43	●	●	32	25	170	32	32	26			1					
PSKN R/L3232P12	PSKN R/L3232-43	●	●	32	32	170	32	32	26	SN□□1506	B37 ~	1	LCL5	LCS5	LSS53	LSP5	LH030
PSKN R/L3225P15	PSKN R/L3225-54	●	●	32	25	170	32	32	32			1					
PSKN R/L3232P15	PSKN R/L3232-54	●	●	32	32	170	40	32	32	SN□□1906	B39 ~	1	LCL6	LCS6	LSS63	LSP6	LH040
PSKN R/L3232P19	PSKN R/L3232-64	●	●	32	32	170	40	32	36			1					
PSKN R/L4040R19	PSKN R/L4040-64	●	●	40	40	200	50	40	36	SN□□2507	B41	1	LCL8	LCS8	LSS84	LSP8	LH050
PSKN R/L5050S25	PSKN R/L5050-85	●	●	50	50	250	60	50	50			1					

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

ESBN type / ESDN type

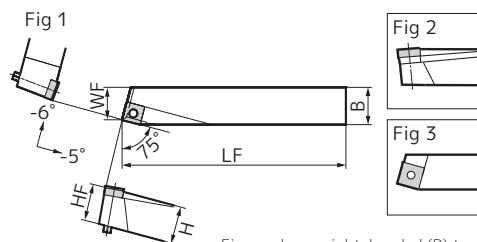
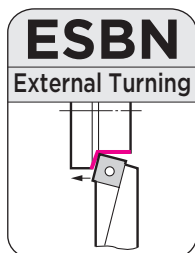
SEC-30 series Holder - General Turning
Pin Lock

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 Insert		Fig	Eccentric Pin	Shim	Wrench
		R	L						Cat. No.	Ref. Page				
ESBN R/L1212F09	ESBN R/L1212	●	●	12	12	80	9.5	11.5	SN□□0903	B32	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	B33 ~	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	

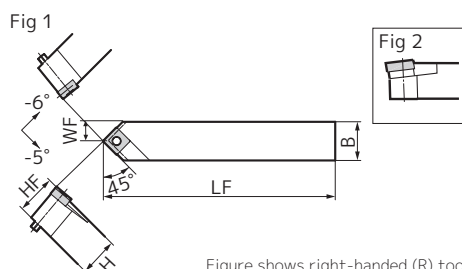
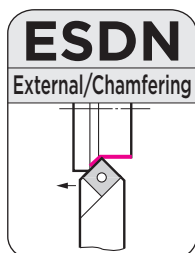
SEC-30 series Holder - General Turning and Chamfering
Pin Lock

Figure shows right-handed (R) tool.

Holder

Parts

Dimensions (mm)

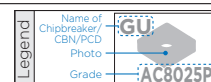
Cat. No.	Previous Cat. No.	Stock		Height H	Width B	Overall Length LF	Cutting Edge WF	Cutting Edge Height HF	Applicable Insert		Fig	Eccentric Pin	Shim	Wrench
		R	L						Cat. No.	Ref. Page				
ESDN R/L1212F09	ESDN R/L1212	●	●	12	12	80	6.0	11.5	SN□□0903	B32	1	P321US	—	KY40
ESDN R/L1616H09	ESDN R/L1616H32	●	●	16	16	100	8.0	15.5			1	P322US	—	
ESDN R/L2020K12	ESDN R/L2020	—	—	20	20	125	10.0	19.5	SN□□1204	B33 ~	2	P433U	—	KY40
ESDN R/L2020K12W	ESDN R/L2020W	●	●	20	20	125	10.0	19.5			2	P433W	ESS42	
ESDN R/L2520M12	ESDN R/L2520	—	—	25	20	150	10.0	24.5			1	P434U	—	
ESDN R/L2520M12W	ESDN R/L2520W	—	—	25	20	150	10.0	24.5			2	P434W	ESS42	
ESDN R/L2525M12	ESDN R/L2525	—	—	25	25	150	12.5	24.5			1	P434U	—	
ESDN R/L2525M12W	ESDN R/L2525W	●	●	25	25	150	12.5	24.5			2	P434W	ESS42	

Applicable Inserts ◀ DSDN type/DSDN type/DSSN type/PSBN type/PSDN type/PSSN type/PSKN type/ESBN type/ESDN type/ESSN type/ESKN 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	P (Steel)			M (Stainless Steel)			K (Cast Iron)			S (Exotic Alloy)			H (Hardened Steel)		Hard Brittle Materials
	Finishing	Medium Cutting	Roughing	Finishing	Medium Cutting	Roughing	High-speed Finishing	Finishing to Medium Cutting	Medium to Roughing	Finishing	Medium Cutting	Roughing	Coated	Uncoated	
Continuous Cutting	FE T1500Z	GU AC8115P	MU AC8020P	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 AC8115P	GU AC8025P	MU AC8025P	EF AC6030M	EG AC6030M	EM AC6135M	SUMIBORON BN7125/BNC500	GZ AC4015K	GZ AC4015K	EF AC5015S	EG AC5015S	EM AC5025S	SUMIBORON BNC2125	SUMIBORON BN2000	SUMIDIA DA1090
Interrupted Cutting	SX AC8025P	UX AC8035P	MX AC8035P	EF AC6030M	EH AC6135M	EM AC6145M	SUMIBORON BN7125/BNC500	GZ AC4125K	No Chipbreaker AC4125K	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

C

Negative

Positive

C

D

R

S

T

V

W

Special

ESSN type / ESKN type

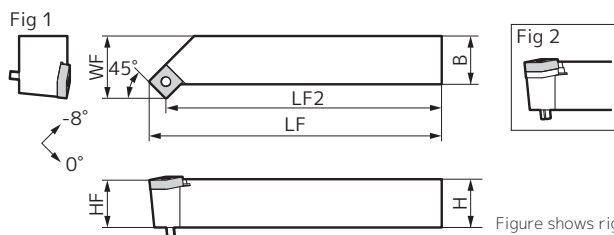
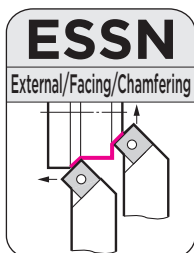
SEC-30 series Holder - General Turning, Facing and Chamfering
Pin Lock

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 Insert		Fig	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	B32	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	B33 ~	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 chipbreaker inserts for facing, the holder and insert are opposite handed.

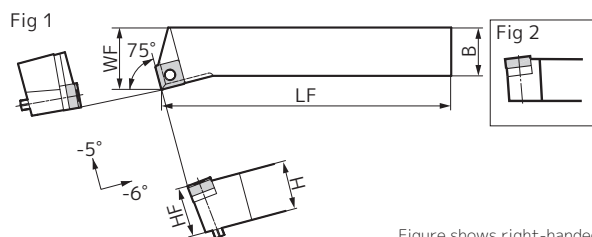
SEC-30 series Holder - Facing
Pin Lock

Figure shows right-handed (R) tool.

Holder

Parts

Dimensions (mm)

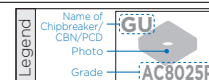
Cat. No.	Previous Cat. No.	Stock		Height H	Width B	Overall Length LF	Cutting Edge WF	Cutting Edge Height HF	Applicable Insert		Fig	Eccentric Pin	Shim	Wrench
		R	L						Cat. No.	Ref. Page				
ESKN R/L1212F09	ESKN R/L1212	●	●	12	12	80	16	11.5	SN□□0903	B32	1	P321US	—	KY40
ESKN R/L1616H09	ESKN R/L1616H32	●	●	16	16	100	20	15.5			1	P322US	—	
ESKN R/L1616H12	ESKN R/L1616H43	●	●	16	16	100	20	15.5	SN□□1204	B33 ~	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 chipbreaker 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 (Page 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 Materials
Process	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	GU	MU	EE	EG	EM	SUMIBORON	UZ	GZ	EF	EG	EM	SUMIBORON	SUMIBORON	SUMIDIA BINDERLESS
	T1500Z	AC8115P	AC8020P	AC6020M	AC6020M	AC6030M	BN7125/BNCS500	AC4010K	AC4010K	AC5015S	AC5015S	AC5015S	BNC2115	BN1000	NPD10
General Machining	SU	GU	MU	EE	EG	EM	SUMIBORON	GZ	GZ	EF	EG	EM	SUMIBORON	SUMIBORON	SUMIDIA
	AC8115P	AC8025P	AC8025P	AC6030M	AC6030M	AC6135M	BN7125/BNCS500	AC4015K	AC4015K	AC5015S	AC5015S	AC5025S	BNC2125	BN2000	DA1090
Interrupted Cutting	SX	UX	MX	EE	EH	EM	SUMIBORON	GZ	No Chipbreaker	EF	EG	EM	SUMIBORON	SUMIBORON	—
	AC8025P	AC8035P	AC8035P	AC6030M	AC6135M	AC6145M	BN7125/BNCS500	AC4125K	AC4125K	AC5025S	AC5025S	AC5025S	BNC2125	BN350	—
Recommended Cutting Conditions	A10 ~			A14 ~			A16 ~			A18 ~			A20 ~		M2 ~

BNC500 is for ductile cast iron.

CSRP type / CSDP type



SEC-40 series Holder - General Turning
Clamp-on

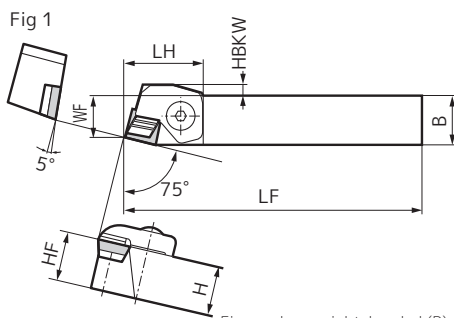
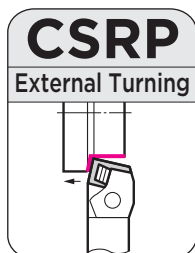


Figure shows right-handed (R) tool.

Holder

Parts

Dimensions (mm)

Cat. No.	Previous Cat. No.	Stock		Height	Width	Overall Length	Cutting Edge	Cutting Edge Height	Head	Step	Applicable Insert		Fig	Clamp Plate	Chipbreaker	Bolt	Shim	Shim Retainer	Spring	Wrench
		R	L	H	B	LF	WF	HF	LH	HBKW	Cat. No.	Ref. Page								
CSRP R/L1919-L12	FP11 R/L-33	●		19	19	140	15.5	19	34.5	5.0	SP□□1203	B95	1			BH0824R/L				
CSRP R/L2525-N12	FP11 R/L-44A	●		25	25	160	21.5	25	34.5	—			1	DCR/L1	CBD4R/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	B96	1			BH1030R/L				
CSRP R/L3232-N15	FP11 R/L-55			32	32	180	26.0	32	40.0	—			1	DCR/L3	CBD5R/L	BH1036R/L	SSPD522	SPP3	DSP5	LH050



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

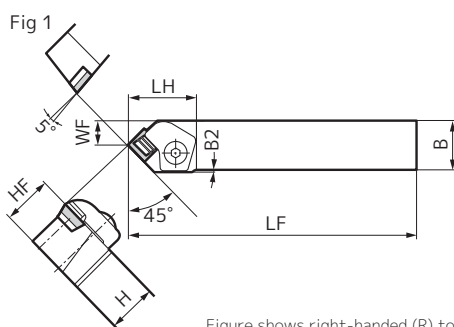
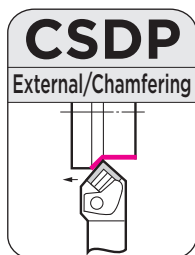


Figure shows right-handed (R) tool.

Holder

Parts

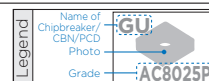
Dimensions (mm)

Cat. No.	Previous Cat. No.	Stock		Height	Width	Overall Length	Cutting Edge	Cutting Edge Height	Head	Step	Applicable Insert		Fig	Clamp Plate	Chipbreaker	Bolt	Shim	Shim Retainer	Spring	Wrench							
		R	L								H	B									LF	WF	HF	LH	B2	Cat. No.	Ref. Page
CSDP R/L1919-L12	FP14 R/L-33	●		19	19	140	10.5	19	35	6	SP□□1203	B95	1														
CSDP R/L2525-N12	FP14 R/L-44A	●		25	25	160	12.5	25	35	2			1								DCR/L1	CBD4R/L	BH0824R/L	SPPD422	SPP3	DSP5	LH040
CSDP R/L3225-N12	FP14 R/L-45A			32	25	160	12.5	32	35	2			1										BH0830R/L				

Applicable Inserts ◀ CSRP type/CSDP type/CSKP type

1st Recommended Insert

- Refer as well to the Insert Selection Guide (Page 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
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 ~

External Holders

C

Negative

Positive

C

D

R

S

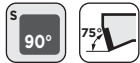
T

V

W

Special

CSKP type



SEC-40 series Holder - Facing
Clamp-on

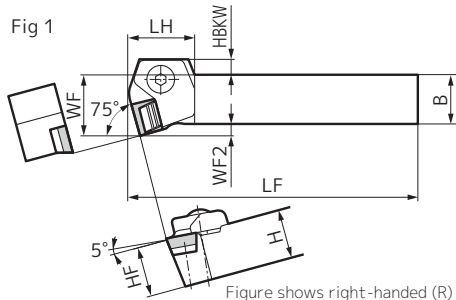


Figure shows right-handed (R) tool.

Holder

Parts

Dimensions (mm)

Cat. No.	Previous Cat. No.	Stock		Height	Width	Overall Length	Cutting Edge	Cutting Edge Height	Head	Offset	Step	Applicable Insert		Clamp Plate	Chipbreaker	Bolt	Shim	Shim Retainer	Spring	Wrench
		R	L	H	B	LF	WF	HF	LH	WF2	HBKW	Cat. No.	Ref. Page	Fig						
CSKP R/L1919-L12	FP15 R/L-33			19	19	140	25	19	22	6	7			1			BH0824L/R			
CSKP R/L2525-N12	FP15 R/L-44A	●		25	25	160	32	25	22	7	—	SP□□1203	B95	1	DCL/R1	CBD4L/R	BH0830L/R	SSPD422	SPP3	DSP5
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	B96	1	DCL/R3	CBD5L/R	BH1030L/R	SSPD522	SPP3	DSP5
CSKP R/L3232-Q15	FP15 R/L-55			32	32	180	38	32	28	6	—			1			BH1036L/R			

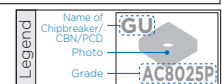
When using handed chipbreaker inserts for facing, the holder and insert are opposite handed.

Applicable Inserts ◀ CSRP type/CSDP type/CSKP type

1st Recommended Insert

- Refer as well to the Insert Selection Guide (Page 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
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	I _{SE} A10 ~		I _{SE} A16 ~			I _{SE} A18 ~		I _{SE} A22 ~	I _{SE} A20 ~



DTGN type / DTFN type



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

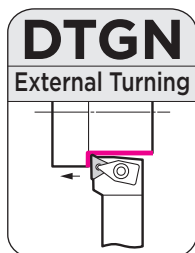


Fig 1

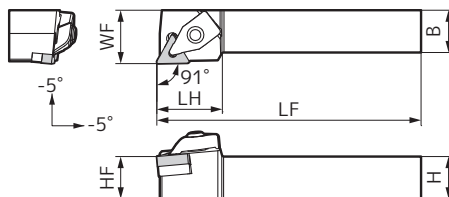


Fig 2

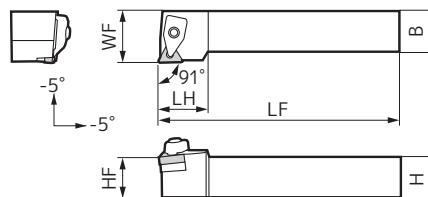


Figure shows right-handed (R) tool.

Holder

Parts

Dimensions (mm)

Cat. No.	Stock		Height	Width	Overall Length	Cutting Edge Length	Cutting Edge Height	Head	Applicable Insert		Fig	Clamp Set		Shim	Shim Screw	Wrench for Shim	Top Hex Wrench	Bottom Hex Wrench
	R	L							Cat. No.	Ref. Page								
DTGN R/L2020K16	●	●	20	20	125	25	20	31	TN□□1604	B48 ~	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 IE C48



SEC-D series Holder - Facing
Double Clamp

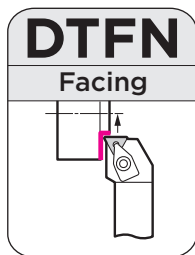


Fig 1

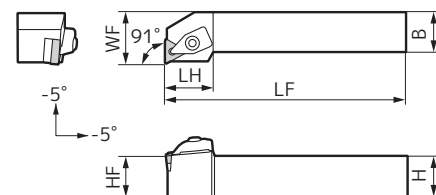


Figure shows right-handed (R) tool.

Holder

Parts

Dimensions (mm)

Cat. No.	Stock		Height	Width	Overall Length	Cutting Edge Length	Cutting Edge Height	Head	Applicable Insert		Fig	Clamp Set		Shim	Shim Screw	Wrench for Shim	Top Hex Wrench	Bottom Hex Wrench
	R	L							Cat. No.	Ref. Page								
DTFN R/L2020K16	●	●	20	20	125	25	20	30	TN□□1604	B48 ~	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.

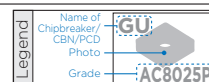
Clamp Set Parts IE C48

When using handed chipbreaker 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 (Page 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	AC8115P	AC8020P	AC6020M	AC6020M	AC6030M	BN7125/BNCS500	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	AC8115P	AC8025P	AC8025P	AC6030M	AC6030M	AC6135M	BN7125/BNCS500	AC4015K	AC4015K	AC5015S	AC5015S	AC5025S	DA1000	BNC2125	BN2000
	SX	UX	MX	EF	EH	EM	SUMIBORON	GZ	GZ	EF	EG	EM	SUMIDIA	SUMIBORON	SUMIBORON
Recommended Cutting Conditions	IE A10 ~			IE A14 ~			IE A16 ~			IE A18 ~			IE A22 ~	IE A20 ~	

BNC500 is for ductile cast iron.

Recommended Tightening Torque (N·m)

PTGN type / PTTN type



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



Fig 1

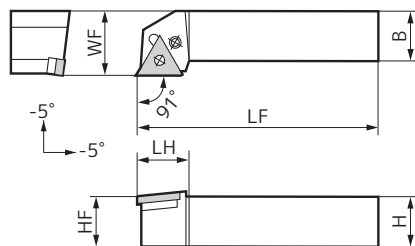


Figure shows right-handed (R) tool.

Holder

Parts

Dimensions (mm)

Cat. No.	Previous Cat. No.	Stock		Height	Width	Overall Length	Cutting Edge	Cutting Edge Height	Head	Applicable Insert		Fig	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	B48 ~	1					
PTGN R/L2020K16	PTGN R/L2020-33	●	●	20	20	125	25	20	20			1					
PTGN R/L2520M16	PTGN R/L2520-33			25	20	150	25	25	20			1					
PTGN R/L2525M16	PTGN R/L2525-33	●	●	25	25	150	32	25	20			1					
PTGN R/L3225P16	PTGN R/L3225-33			32	25	170	32	32	20	TN□□2204	B53 ~	1					
PTGN R/L2525M22	PTGN R/L2525-43	●	●	25	25	150	32	25	28			1					
PTGN R/L3225P22	PTGN R/L3225-43			32	25	170	32	32	28			1					
PTGN R/L3232P22	PTGN R/L3232-43			32	32	170	40	32	28			1					
PTGN R/L3232P27	PTGN R/L3232-54			32	32	170	40	32	33	TN□□2706	B55	1					
PTGN R/L4040R27	PTGN R/L4040-54			40	40	200	50	40	33			1					



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

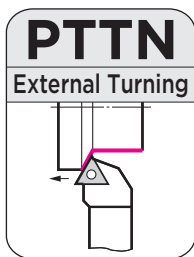


Fig 1

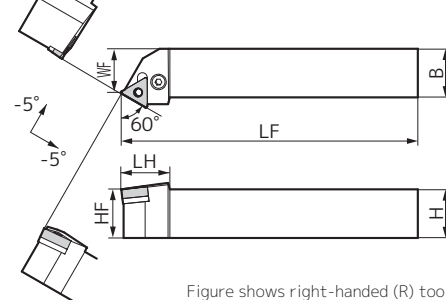


Figure shows right-handed (R) tool.

Holder

Parts

Dimensions (mm)

Cat. No.	Previous Cat. No.	Stock		Height	Width	Overall Length	Cutting Edge	Cutting Edge Height	Head	Applicable Insert		Fig	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	B48 ~	1					
PTTN R/L2020K16	PTTN R/L2020-33	●	●	20	20	125	17	20	25			1					
PTTN R/L2520M16	PTTN R/L2520-33			25	20	150	17	25	25			1					
PTTN R/L2525M16	PTTN R/L2525-33	●	●	25	25	150	22	25	25			1					
PTTN R/L3225P16	PTTN R/L3225-33			32	25	170	22	32	25	TN□□2204	B53 ~	1					
PTTN R/L2525M22	PTTN R/L2525-43			25	25	150	22	25	25			1					
PTTN R/L3225P22	PTTN R/L3225-43			32	25	170	22	32	25			1					

PTFN type

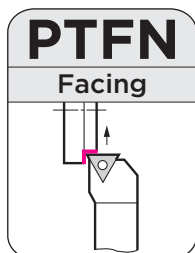
SEC-70 series Holder - Facing
Lever Lock

Fig 1

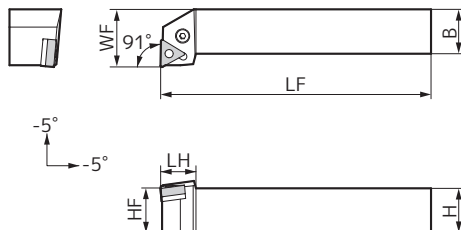


Figure shows right-handed (R) tool.

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					
PTFN R/L1616H16	PTFN R/L1616-33	●	●	16	16	100	20	16	20	TN□□1604	B48 ~	1	LCL3	LCS3	LST317	LSP3
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	B53 ~	1	LCL4	LCS4	LST42	LSP4
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	B55	1	LCL5	LCS5	LST53	LSP5
PTFN R/L4040R27	PTFN R/L4040-54			40	40	200	50	40	34							

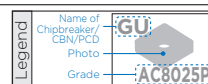
When using handed chipbreaker inserts for facing, the holder and insert are opposite handed.

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 (Page 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	AC8115P	AC8020P	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	AC8115P	AC8025P	AC8025P	AC6030M	AC6030M	AC6135M	BN7125/BNC500	AC4015K	AC4015K	AC5015S	AC5015S	AC5025S	DA1000	BNC2125	BN2000
	SX	UX	MX	EF	EH	EM	SUMIBORON	GZ	GZ	EF	EG	EM	SUMIDIA	SUMIBORON	SUMIBORON
Recommended Cutting Conditions	IE A10 ~			IE A14 ~			IE A16 ~			IE A18 ~			IE A22 ~	IE A20 ~	

BNC500 is for ductile cast iron.

External Holders



Negative

Positive



Special

ETGN type / ETAN type



SEC-30 series Holder - General Turning
Pin Lock

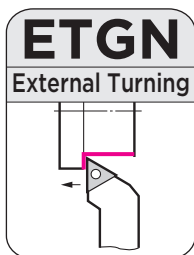


Fig 1

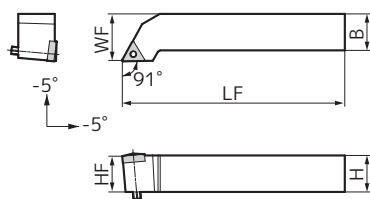


Figure shows right-handed (R) tool.

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 Insert		Fig	Eccentric Pin	Shim	Wrench
		R	L							Cat. No.	Ref. Page				
ETGN R/L1212F11	ETGN R/L1212	●	●	12	12	80	16	11.5	—	TN□□1103	B46	1	P221US	—	KY25
ETGN R/L1616H1603	ETGN R/L1616H32	●	●	16	16	100	20	15.5	—	TN□□1603	B47 ~	1	P322US	—	KY40
ETGN R/L1616H1604	ETGN R/L1616H33	●	●	16	16	100	20	15.5	—	TN□□1604	B48 ~	1	P332US	—	KY40
ETGN R/L2020K1603	ETGN R/L2020K32			20	20	125	25	19.5	—	TN□□1603	B47 ~	1	P323US	—	KY40
ETGN R/L2020K1603W	ETGN R/L2020K32W			20	20	125	25	19.5	—	TN□□1603	B47 ~	2	P323WS	EST32	KY40
ETGN R/L2020K1604	ETGN R/L2020K33	●	●	20	20	125	25	19.5	—	TN□□1604	B48 ~	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	—	TN□□2204	B53 ~	2	P334WS	EST32	KY40
ETGN R/L2525M22	ETGN R/L2525M43			25	25	150	32	24.5	30			3	P434U	—	
ETGN R/L2525M22W	ETGN R/L2525M43W	●	●	25	25	150	32	24.5	30			4	P434W	EST43	



SEC-30 series Holder - General Turning
Pin Lock

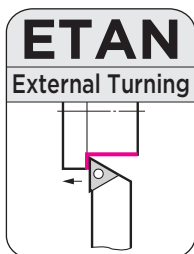


Fig 1

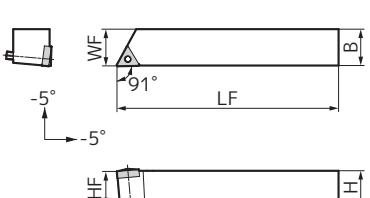


Figure shows right-handed (R) tool.

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 Insert		Fig	Eccentric Pin	Shim	Wrench
		R	L							Cat. No.	Ref. Page				
ETAN R/L1212F11	ETAN R/L1212	●	●	12	12	80	12	11.5	—	TN□□1103	B46	1	P221US	—	KY25
ETAN R/L1616H1603	ETAN R/L1616H32			16	16	100	16	15.5	—	TN□□1603	B47 ~	1	P322US	—	KY40
ETAN R/L1616H1604	ETAN R/L1616H33	●	●	16	16	100	16	15.5	—	TN□□1604	B48 ~	1	P332US	—	KY40
ETAN R/L2020K1603	ETAN R/L2020K32			20	20	125	20	19.5	—	TN□□1603	B47 ~	1	P323US	—	KY40
ETAN R/L2020K1603W	ETAN R/L2020K32W			20	20	125	20	19.5	—	TN□□1603	B47 ~	2	P323WS	EST32	KY40
ETAN R/L2020K1604	ETAN R/L2020K33			20	20	125	20	19.5	—	TN□□1604	B48 ~	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	—	TN□□2204	B53 ~	2	P334WS	EST32	KY40
ETAN R/L2525M22	ETAN R/L2525M43			25	25	150	25	24.5	30			3	P434U	—	
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

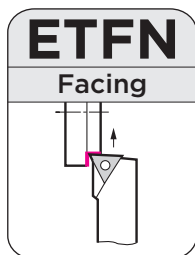


Fig 1

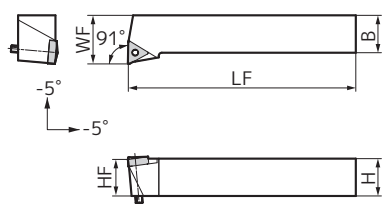


Figure shows right-handed (R) tool.

Holder

Parts

Dimensions (mm)

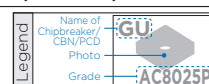
Cat. No.	Previous Cat. No.	Stock		Height	Width	Overall Length	Cutting Edge	Cutting Edge Height	Head	Applicable Insert		Fig	Eccentric Pin	Shim	Wrench
		R	L							Cat. No.	Ref. Page				
ETFN R/L1212F11	ETFN R/L1212	●	●	12	12	80	16	11.5	—	TN□□1103	B46	1	P221US	—	KY25
ETFN R/L1616H1603	ETFN R/L1616H32			16	16	100	20	15.5	—	TN□□1603	B47 ~	1	P322US	—	KY40
ETFN R/L1616H1604	ETFN R/L1616H33	●	●	16	16	100	20	15.5	—	TN□□1604	B48 ~	1	P332US	—	KY40
ETFN R/L2020K1603	ETFN R/L2020K32			20	20	125	25	19.5	—	TN□□1603	B47 ~	1	P323US	—	KY40
ETFN R/L2020K1603W	ETFN R/L2020K32W			20	20	125	25	19.5	—			2	P323WS	EST32	KY40
ETFN R/L2020K1604	ETFN R/L2020K33			20	20	125	25	19.5	—	TN□□1604	B48 ~	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	B53 ~	3	P434U	—	KY40
ETFN R/L2525M22W	ETFN R/L2525M43W	●	●	25	25	150	32	24.5	30			4	P434W	EST43	

When using handed chipbreaker 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 (Page 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
Process															
Continuous Cutting	FE 	GU 	MU 	EF 	EG 	EM 	SUMIBORON	UZ 	GZ 	EF 	EG 	EM 	SUMIDIA	SUMIBORON 	SUMIBORON
	T1500Z	AC8115P	AC8020P	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
	AC8115P	AC8025P	AC8025P	AC6030M	AC6030M	AC6135M	BN7125/BNC500	AC4015K	AC4015K	AC5015S	AC5015S	AC5025S	DA1000	BNC2125	BN2000
Interrupted Cutting	SX 	UX 	MX 	EF 	EH 	EM 	SUMIBORON	GZ 	GZ 	EF 	EG 	EM 	SUMIDIA	SUMIBORON	SUMIBORON
	AC8025P	AC8035P	AC8035P	AC6030M	AC6135M	AC6145M	BN7125/BNC500	AC4125K	AC4125K	AC5025S	AC5025S	AC5025S	DA1000	BNC2135	BN3500
Recommended Cutting Conditions	 A10 ~			 A14 ~			 A16 ~			 A18 ~			 A22 ~	 A20 ~	

BNC500 is for ductile cast iron.

External Holders

C

Negative

Positive

C

D

R

S

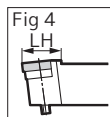
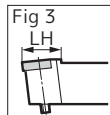
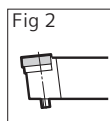
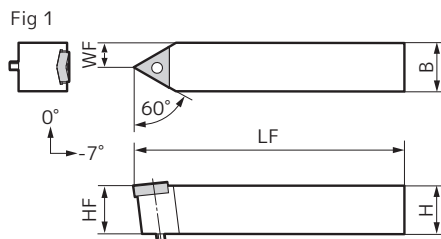
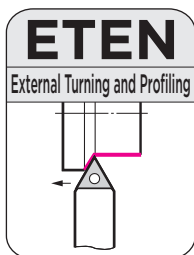
T

V

W

Special

ETEN type / ETXN type

SEC-30 series Holder - General Turning and Profiling
Pin Lock

Holder

Parts

Dimensions (mm)

Cat. No.	Previous Cat. No.	Stock	Height H	Width B	Overall Length LF	Cutting Edge WF	Cutting Edge Height HF	Head LH	Applicable Insert		Fig	Eccentric Pin	Shim	Wrench
									Cat. No.	Ref. Page				
ETEN N1212F11	ETEN N1212	●	12	12	80	6.0	11.5	—	TN□□1103	B46	1	P221US	—	KY25
ETEN N1616H1603	ETEN N1616H32	—	16	16	100	8.0	15.5	—	TN□□1603	B47 ~	1	P322US	—	KY40
ETEN N1616H1604	ETEN N1616H33	●	16	16	100	8.0	15.5	—	TN□□1604	B48 ~	1	P332US	—	KY40
ETEN N2020K1603	ETEN N2020K32	—	20	20	125	10.0	19.5	—	TN□□1603	B47 ~	1	P323US	—	KY40
ETEN N2020K1603W	ETEN N2020K32W	—	20	20	125	10.0	19.5	—	TN□□1603	B47 ~	2	P323WS	EST32	KY40
ETEN N2020K1604	ETEN N2020K33	●	20	20	125	10.0	19.5	—	TN□□1604	B48 ~	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	B48 ~	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	B53 ~	3	P434U	—	KY40
ETEN N2525M22W	ETEN N2525M43W	●	25	25	150	12.5	24.5	30			4	P434W	EST43	

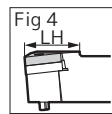
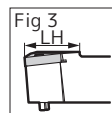
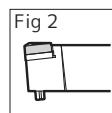
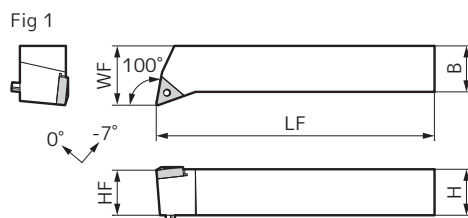
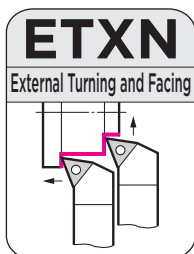
SEC-30 series Holder - General Turning and Facing
Pin Lock

Figure shows right-handed (R) tool.

Holder

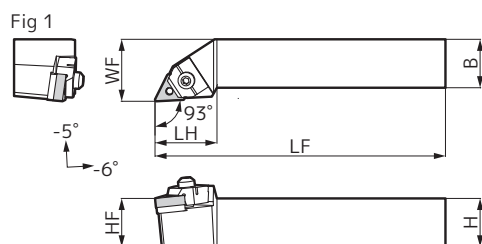
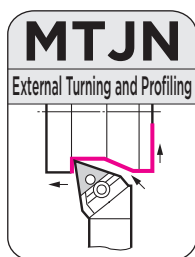
Parts

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 Insert		Fig	Eccentric Pin	Shim	Wrench
		R	L							Cat. No.	Ref. Page				
ETXN R/L1212F11	ETXN R/L1212	●	●	12	12	80	16	11.5	—	TN□□1103	B46	1	P221US	—	KY25
ETXN R/L1616H1603	ETXN R/L1616H32	—	—	16	16	100	20	15.5	—	TN□□1603	B47 ~	1	P322US	—	KY40
ETXN R/L1616H1604	ETXN R/L1616H33	●	●	16	16	100	20	15.5	—	TN□□1604	B48 ~	1	P332US	—	KY40
ETXN R/L2020K1603	ETXN R/L2020K32	—	—	20	20	125	25	19.5	—	TN□□1603	B47 ~	1	P323US	—	KY40
ETXN R/L2020K1603W	ETXN R/L2020K32W	—	—	20	20	125	25	19.5	—	TN□□1603	B47 ~	2	P323WS	EST32	KY40
ETXN R/L2020K1604	ETXN R/L2020K33	●	●	20	20	125	25	19.5	—	TN□□1604	B48 ~	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	B48 ~	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	B53 ~	3	P434U	—	KY40
ETXN R/L2525M22W	ETXN R/L2525M43W	●	●	25	25	150	32	24.5	30			4	P434W	EST43	

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

MTJN type / MTXN type



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

Figure shows right-handed (R) tool.

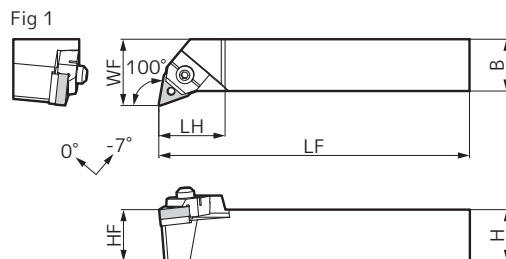
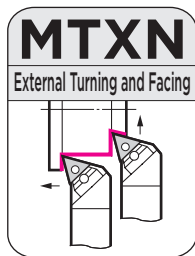
Holder

Parts

Dimensions (mm)

Cat. No.	Previous Cat. No.	Stock		Height	Width	Overall Length	Cutting Edge	Cutting Edge Height	Head	Applicable Inserts		Fig	Clamp Plate	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	B48 ~	1	MMW30	MP317S	STW323	BHA0525	4.0	CPM32N	ER04	LH030
** MTJN R/L2520M16	MTJN R/L2520-33	●	●	25	25	150	25	25	32	TN□□1604	B48 ~	1	MMW30	MP320S	STW323	BHA0525	4.0	CPM32N	ER04	LH030
** MTJN R/L2525M16	MTJN R/L2525-33	●	●	25	25	150	32	25	32	TN□□1604	B48 ~	1	MMW30	MP320S	STW323	BHA0525	4.0	CPM32N	ER04	LH030
MTJN R/L2525M22	MTJN R/L2525-43	●	●	25	25	150	32	25	38	TN□□2204	B53 ~	1	MMW40	MP420	STW434	BHA0625	4.5	CPM43N	ER05	LH040
MTJN R/L3225P22	MTJN R/L3225-43	●	●	32	25	170	32	32	38	TN□□2204	B53 ~	1	MMW40	MP420	STW434	BHA0625	4.5	CPM43N	ER05	LH040

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



SEC-M series 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		Fig	Clamp Plate	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	B48 ~	1	MMW30	MP317S	STW323	BHA0525	4.0	CPM32N	ER04	LH030
** MTXN R/L2525M16	MTXN R/L2525-33	●	●	25	25	150	32	25	32	TN□□1604	B48 ~	1	MMW30	MP320S	STW323	BHA0525	4.0	CPM32N	ER04	LH030
MTXN R/L2525M22	MTXN R/L2525-43	●	●	25	25	150	32	25	38	TN□□2204	B53 ~	1	MMW40	MP420	STW434	BHA0625	4.5	CPM43N	ER05	LH040

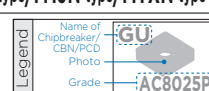
When using CIS standard inserts, the pin for holders marked * is MP317 and the pin for holders marked ** is MP320.

When using handed chipbreaker 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 (Page 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	—	Coated	Uncoated
Continuous Cutting	FE	GU	MU	EF	EG	EM	SUMIBORON	UZ	GZ	EF	EG	EM	SUMIDIA	SUMIBORON	SUMIBORON	SUMIDIA	SUMIBORON	SUMIBORON
General Machining	T1500Z	AC8115P	AC8020P	AC6020M	AC6020M	AC6030M	BN7125/BNC500	AC4010K	AC4010K	AC5015S	AC5015S	AC5015S	DA1000	BNC2115	BN1000	DA1000	BNC2115	BN1000
	SU	GU	MU	EF	EG	EM	SUMIBORON	GZ	GZ	EF	EG	EM	SUMIDIA	SUMIBORON	SUMIBORON	DA1000	BNC2115	BN2000
Interrupted Cutting	AC8115P	AC8025P	AC8025P	AC6030M	AC6030M	AC6135M	BN7125/BNC500	AC4015K	AC4015K	AC5015S	AC5015S	AC5025S	DA1000	BNC2125	BN2000	DA1000	BNC2125	BN2000
	SX	UX	MX	EF	EH	EM	SUMIBORON	GZ	GZ	EF	EG	EM	SUMIDIA	SUMIBORON	SUMIBORON	DA1000	BNC2135	BN350
Recommended Cutting Conditions	I _{CS} A10 ~			I _{CS} A14 ~			I _{CS} A16 ~			I _{CS} A18 ~			I _{CS} A22 ~			I _{CS} A20 ~		

BNC500 is for ductile cast iron.

Recommended Tightening Torque (N·m)

CTGP type/CTAP type



SEC-40 series Holder - General Turning
Clamp-on



Fig 1

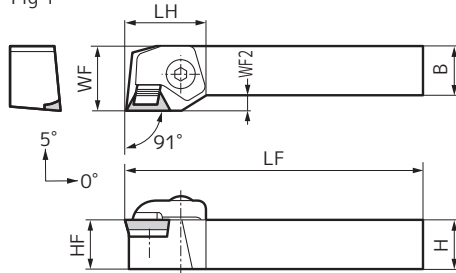


Figure shows right-handed (R) tool.

Holder

Parts

Dimensions (mm)

Cat. No.	Previous Cat. No.	Stock		Height	Width	Overall Length	Cutting Edge	Cutting Edge Height	Head	Offset	Applicable Insert		Fig	Clamp Plate	Chipbreaker	Bolt	Shim	Shim Retainer	Spring	Wrench
		R	L	H	B	LF	WF	HF	LH	WF2	Cat. No.	Ref. Page								
CTGP R/L1919-L16	FP22 R/L-33	●		19	19	140	25	19	34.5	6	TP□□1603	B109	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	B113	1	DCR/L3	CBD5R/L	BH1030R/L	STPD422	SPP3	DSP5	LH050



SEC-40 series Holder - General Turning
Clamp-on

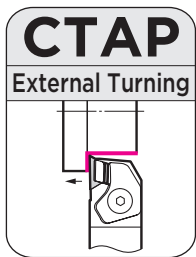


Fig 1

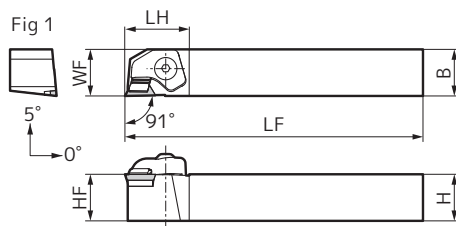


Figure shows right-handed (R) tool.

Holder

Parts

Dimensions (mm)

Cat. No.	Previous Cat. No.	Stock		Height	Width	Overall Length	Cutting Edge	Cutting Edge Height	Head	Offset	Applicable Insert		Fig	Clamp Plate	Chipbreaker	Bolt	Shim	Shim Retainer	Spring	Wrench
		R	L	H	B	LF	WF	HF	LH	WF2	Cat. No.	Ref. Page								
CTAP R/L2525-N16	FP21 R/L-44A	●		25	25	160	25	25	34.5		TP□□1603	B109	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	B109	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	B113	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 series Holder - Facing
Clamp-on

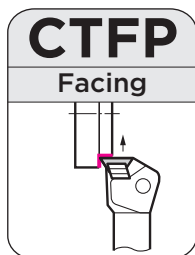


Fig 1

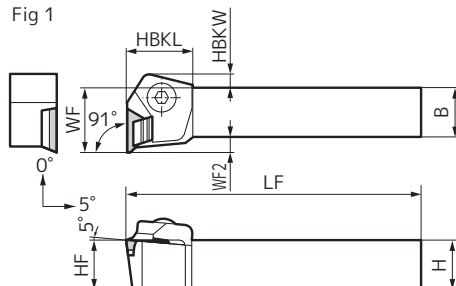


Figure shows right-handed (R) tool.

Holder

Parts

Dimensions (mm)

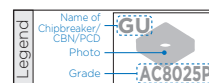
Cat. No.	Previous Cat. No.	Stock		Height	Width	Overall Length	Cutting Edge	Cutting Edge Height	Head	Offset	Step	Applicable Inserts		Fig	Clamp Plate	Chipbreaker	Bolt	Shim	Shim Retainer	Spring	Wrench
		R	L	H	B	LF	WF	HF	HBKL	WF2	HBKW	Cat. No.	Ref. Page								
CTFP R/L1919-L16	FP25 R/L-33	●		19	19	140	25	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	B109	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	B113	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				

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

Applicable Inserts ◀ CTGP type/CTAP type/CTFP type

1st Recommended Insert

- Refer as well to the Insert Selection Guide (Page 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
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 ~

External Holders

C

Negative

Positive

C

D

R

S

T

V

W

Special

DVJN-J type / DVJN type



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

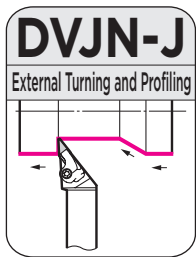


Fig 1

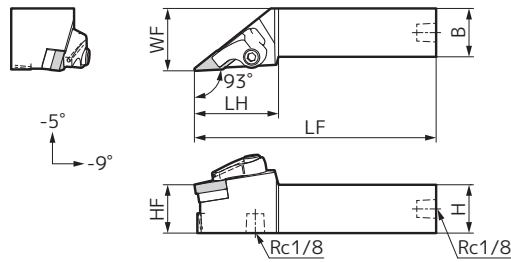


Figure shows right-handed (R) tool.

Holder

Parts

Dimensions (mm)

Cat. No.	Stock		Height	Width	Overall Length	Cutting Edge	Cutting Edge Height	Head	Applicable Insert		Fig	Clamp 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	HF	LH	Cat. No.	Ref. Page												
												(For Torx hole)	(For Hexagonal hole)	(For Hexagonal hole)								
DVJN R/L2020K16-J	●	●	20	20	125	25	20	43	VN□□1604	B58 ~	1	JVR/L-01	CP-M5-20-1	5.0	CSP12J	SSO60	VNS1604	BFTX0307N	TRX10(*)	LH040	LH025	XPO2
DVJN R/L2525K16-J	●	●	25	25	125	32	25	43	VN□□1604	B58 ~	1	JVR/L-01	CP-M5-20-1	5.0	CSP12J	SSO60	VNS1604	BFTX0307N	TRX10(*)	LH040	LH025	XPO2

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



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

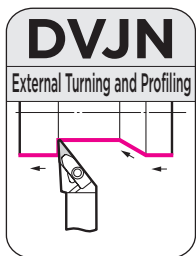


Fig 1

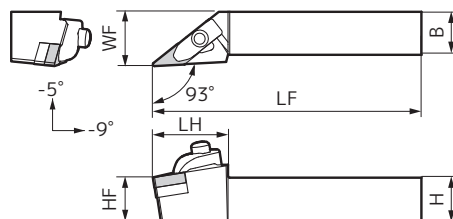


Figure shows right-handed (R) tool.

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		LF	WF	HF	LH	Cat. No.	Ref. Page	
DVJN R/L2020K16	●	●	20	20	125	25	20	35	VN□□1604	B58 ~	1	SCP-4	5.0	VNS1604	BFTX0307N	TRX10(*)	LH040	LH025
DVJN R/L2525M16	●	●	25	25	150	32	25	35	VN□□1604	B58 ~	1	SCP-4	5.0	VNS1604	BFTX0307N	TRX10(*)	LH040	LH025

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

Clamp Set Parts **C48**

DVVN type / DVQN type



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

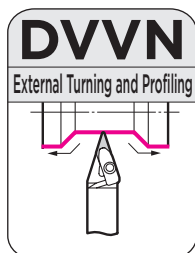
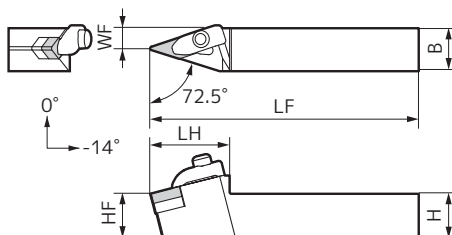


Fig 1



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							Cat. No.	Ref. Page		SCP-4	N-m					
DVVN N2020K16	●	●	20	20	125	10.0	20	37	VN□□1604	B58 ~	1	SCP-4	5.0	VNS1604	BFTX0307N	TRX10(*)	LH040	LH025
DVVN N2525M16	●	●	25	25	150	12.5	25	37	VN□□1604	B58 ~	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



Fig 1

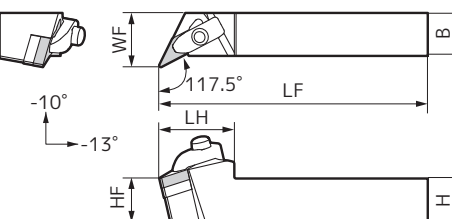


Figure shows right-handed (R) tool.

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							Cat. No.	Ref. Page		SCP-4	N-m					
DVQN R/L2020K16	●	●	20	20	125	25	20	35	VN□□1604	B58 ~	1	SCP-4	5.0	VNS1604	BFTX0307N	TRX10(*)	LH040	LH025
DVQN R/L2525M16	●	●	25	25	150	32	25	35	VN□□1604	B58 ~	1	SCP-4	5.0	VNS1604	BFTX0307N	TRX10(*)	LH040	LH025

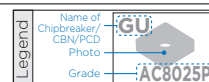
*Wrench for shim is sold separately from the main body.

Clamp Set Parts C48

Applicable Inserts ◀ DVJN-J type / DVJN type / DVVN type / DVQN 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	P (Steel)		M (Stainless Steel)		K (Cast Iron)		S (Exotic Alloy)		N (Non-Ferrous)	H (Hardened Steel)		Hard Brittle Materials
	Finishing	Medium Cutting	Finishing	Medium Cutting	High-speed Finishing	Finishing to Medium Cutting	Finishing	Medium Cutting	—	Coated	Uncoated	Finishing
Continuous Cutting	FE T1500Z	GU AC8115P	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 AC8115P	GU AC8025P	EF AC6030M	EG AC6030M	SUMIBORON BN7125/BNC500	GZ AC4015K	EF AC5015S	EG AC5015S	SUMIDIA DA1000	SUMIBORON BNC2125	SUMIBORON BN2000	SUMIDIA DA1090
Interrupted Cutting	SX AC8025P	UX AC8035P	EF AC6030M	EG AC6135M	SUMIBORON BN7125/BNC500	GZ AC4125K	EF AC5025S	EG AC5025S	SUMIDIA DA1000	SUMIBORON BNC2135	SUMIBORON BN350	—
Recommended Cutting Conditions	I A10 ~		I A14 ~		I A16 ~		I A18 ~		I A22 ~	I A20 ~		I M2 ~

BNC500 is for ductile cast iron.

Recommended Tightening Torque (N·m)

SVLC type / SVJC type

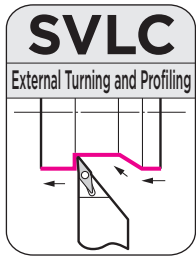
SEC-SV series Mini Holder - General Turning and Profiling
Screw-on

Fig 1

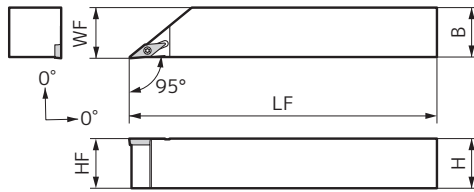


Figure shows right-handed (R) tool.

Holder

Parts

Dimensions (mm)

Cat. No.	Stock		Height H	Width B	Overall Length LF	Cutting Edge WF	Cutting Edge Height HF	Applicable Insert		Fig	Flat Insert Screw		Wrench
	R	L						Cat. No.	Ref. Page				
SVLC R/L1010-H11	●	●	10	10	100	10.5	10	VC□□1103	B119 ~	1			TRX08
SVLC R/L1212-H11	●	●	12	12	100	12.5	12			1			
SVLC R/L1616-H11	●	●	16	16	100	16.5	16			1			
SVLC R/L2020-K11	●	●	20	20	125	20.5	20			1			
SVLC R/L2525-M11	●	●	25	25	150	25.5	25			1			

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

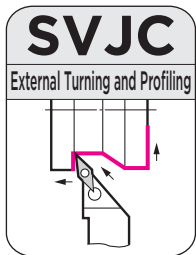
SEC-SV series Profiling Tool Holder - External Profiling
Screw-on

Fig 1

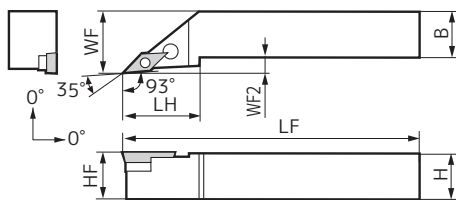


Figure shows right-handed (R) tool.

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 Offset LH	WF2	Applicable Insert		Fig	Pin	Nut	Shim	Flat Insert Screw		Wrench	Wrench for Nut
		R	L								Cat. No.	Ref. Page								
SVJC R/L2020K16	SVJC R/L2020-33	●	●	20	20	125	25	20	41	5	VC□□1604	B120 ~	1	VP20	CPV33N	SVP32			TRX10	LH025
SVJC R/L2525M16	SVJC R/L2525-33	●	●	25	25	150	32	25	41	7			1	VP25						
SVJC R/L3225P16	SVJC R/L3225-33	●	●	32	25	170	32	32	41	7			1	VP32						

SVVC type / SVPC type



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

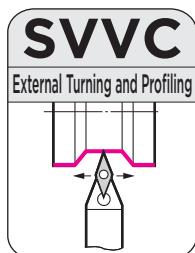
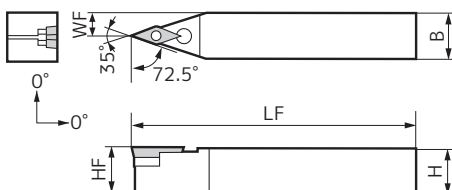


Fig 1



Holder

Parts

Dimensions (mm)

Cat. No.	Previous Cat. No.	Stock	Height	Width	Overall Length	Cutting Edge	Cutting Edge Height	Applicable Insert		Fig	Pin	Nut	Shim	Flat Insert Screw	Wrench	Wrench for Nut	
			H	B	LF	WF	HF	Cat. No.	Ref. Page								
SVVC N2020K16	SVVC N2020-33	●	20	20	125	10.0	20	VC□□1604	B120 ~	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 series Profiling Tool Holder - General Turning, Facing, Profiling and Necking
Screw-on

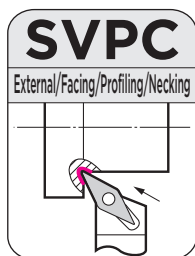


Fig 1

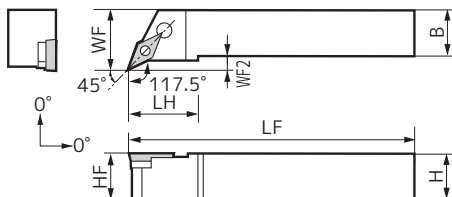


Figure shows right-handed (R) tool.

Holder

Parts

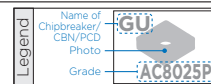
Dimensions (mm)

Cat. No.	Previous Cat. No.	Stock		Height	Width	Overall Length	Cutting Length	Cutting Edge Height	Head	Offset	Applicable Insert		Fig.	Pin	Nut	Shim	Flat Insert Screw	Wrench	Wrench for Nut	
		R	L								Cat. No.	Ref. Page								
SVPC R/L1010-H11	—	●	●	10	10	100	14.5	10	—	4.5	VC□□1103	B119 ~	1					 (For Torx hole)	 (For Hexagonal hole)	
SVPC R/L1212-H11	—	●	●	12	12	100	16.5	12	—	4.5			1							
SVPC R/L1616-H11	—	●	●	16	16	100	20.5	16	—	4.5			1							
SVPC R/L2020K16	SVPC R/L2020-33	●	●	20	20	125	25	20	35	5.0	VC□□1604	B120 ~	1	VP20	CPV33N	SVP32	BFTX03508	2.0	TRX10	LH025
SVPC R/L2525M16	SVPC R/L2525-33	●	●	25	25	150	32	25	35	7.0			1	VP25						
SVPC R/L3225P16	SVPC R/L3225-33	●	●	32	25	170	32	32	35	7.0			1	VP32						

Applicable Inserts ◀ SVLC type / SVJC type / SVVC type / SVPC 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	P (Steel)		M (Stainless Steel)		S (Exotic Alloy)		N (Non-Ferrous)		H (Hardened Steel)		Hard Brittle Materials
	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 DA1090
	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

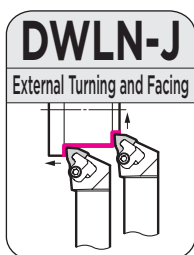


Fig 1

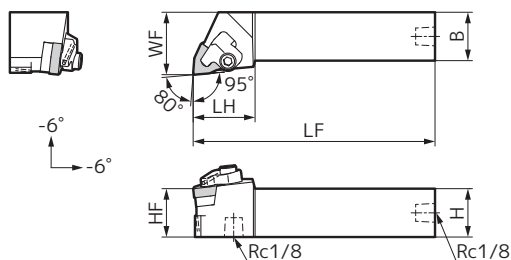


Figure shows right-handed (R) tool.

Holder

Parts

Dimensions (mm)

Cat. No.	Stock		Height	Width	Overall Length	Cutting Edge	Cutting Edge Height	Head	Applicable Insert		Fig	Clamp 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			N·m	CP-M5-20-1								
DWLN R/L2020K08-J	●	●	20	20	125	25	20	32	WN□□0804	B63 ~	1	JCR/L-01	CP-M5-20-1	5.0	CSP12J	SSO60	WNS0804	BFTX0409N	TRX15(*)	LH040	LH025	XP02
DWLN R/L2525K08-J	●	●	25	25	125	32	25	32	WN□□0804	B63 ~	1	JCR/L-01	CP-M5-20-1	5.0	CSP12J	SSO60	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

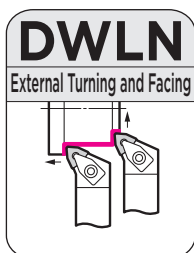


Fig 1

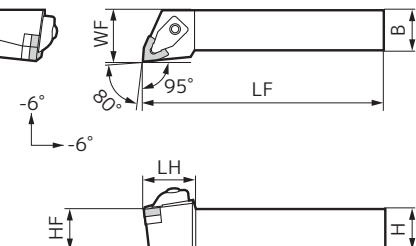


Figure shows right-handed (R) tool.

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		LF	WF	HF	LH	Cat. No.	Ref. Page	
DWLN R/L2020K08	●	●	20	20	125	25	20	32	WN□□0804	B63 ~	1	SCP-2	5.0	WNS0804	BFTX0409N	TRX15*((For Torx hole)	LH040 (For Hexagonal hole)	LH025 (For Hexagonal hole)
DWLN R/L2525M08	●	●	25	25	150	32	25	32	WN□□0804	B63 ~	1	SCP-2	5.0	WNS0804	BFTX0409N	TRX15*((For Torx hole)	LH040 (For Hexagonal hole)	LH025 (For Hexagonal hole)

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

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

Clamp Set Parts **C48**

PWLN type / MWLN type



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

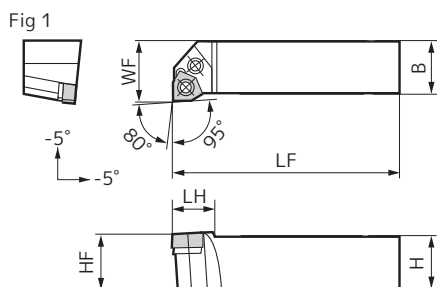
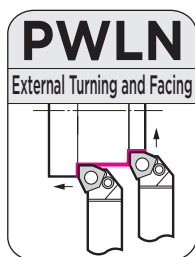


Figure shows right-handed (R) tool.

Holder

Parts

Dimensions (mm)

Cat. No.	Previous Cat. No.	Stock		Height	Width	Overall Length	Cutting Edge Length	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	B61 ~ 1	LCL3	LCS3	LSW317	LSP3	LH025
PWLN R/L2525M06	PWLN R/L2525-33	●	●	25	25	150	32	25	17							

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



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

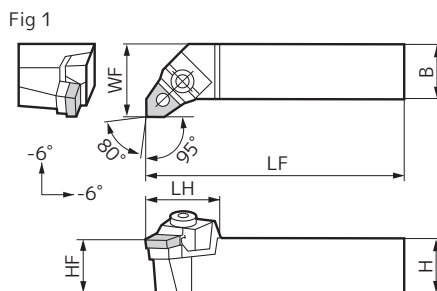
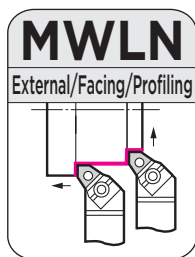


Figure shows right-handed (R) tool.

Holder

Parts

Dimensions (mm)

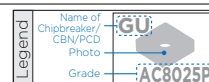
Cat. No.	Previous Cat. No.	Stock		Height	Width	Overall Length	Cutting Edge Length	Cutting Edge Height	Head	Applicable Insert		Clamp Plate	Pin	Shim	Bolt	Nut	Retaining Ring	Wrench for Bolt	Wrench for Nut
		R	L							Cat. No.	Ref. Page								
MWLN R/L2020K08	MWLN R/L2020-43	●	●	20	20	125	25	20	32	WN□□0804	B63 ~ 1	MP416	MP416	SWW433	BHA0625	CPM43S	ER05	LH040	LH030
MWLN R/L2525M08	MWLN R/L2525-43	●	●	25	25	150	32	25	32			MP420	MP420	SWW433	BHA0625	CPM43N			
MWLN R/L3225P08	MWLN R/L3225-43	●	●	32	25	170	32	32	32			MP420	MP420			CPM43N			

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

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

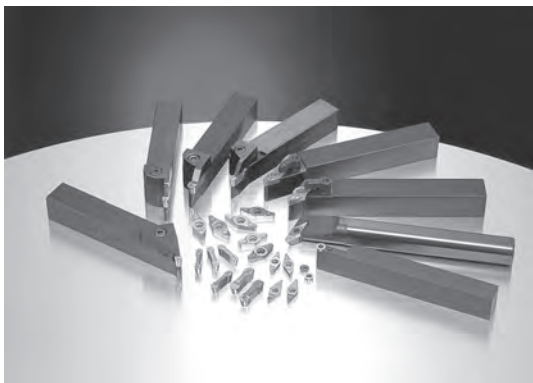
1st Recommended Insert

- 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	P (Steel)			M (Stainless Steel)			K (Cast Iron)		S (Exotic Alloy)			H (Hardened Steel)	
	Finishing	Medium Cutting	Roughing	Finishing	Medium Cutting	Roughing	Finishing to Medium Cutting	Medium to Roughing	Finishing	Medium Cutting	Roughing	Coated	Uncoated
Continuous Cutting	FE	GU	MU	EF	EG	EM	UZ	GZ	EF	EG	EM	SUMIBORON	SUMIBORON
General Machining	T1500Z	AC8115P	AC8020P	AC6020M	AC6020M	AC6030M	AC4010K	AC4010K	AC5015S	AC5015S	AC5015S	BNC2115	BN2000
	SU	GU	MU	EF	EG	EM	GZ	GZ	EF	EG	EM	SUMIBORON	SUMIBORON
Interrupted Cutting	AC8115P	AC8025P	AC8025P	AC6030M	AC6030M	AC6135M	AC4015K	AC4015K	AC5015S	AC5015S	AC5025S	BNC2125	BN2000
	SX	UX	MX	EF	EH	EM	GZ	No Chipbreaker	EF	EG	EM	SUMIBORON	SUMIBORON
Recommended Cutting Conditions	A10 ~			A14 ~			A16 ~		A18 ~			A20 ~	

MV series / GD series Profiling Tool Holders



General Features

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

Features and Applications

- **The 35° diamond shaped inserts** support a wide range of applications from roughing to finishing. With newly designed holders for higher clamping rigidity and AW-type chipbreakers that reduce cutting resistance, stable roughing operations are achieved.
- Wide variety of **dogbone inserts**
AW type chipbreakers, with their high-raked 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

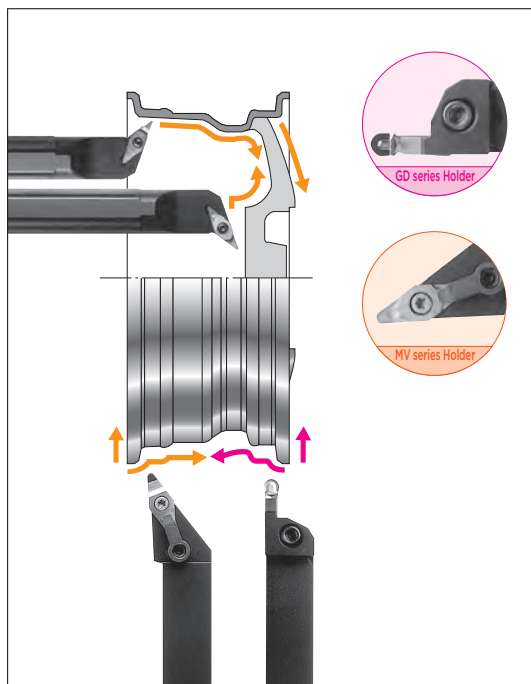
AW type Chipbreaker

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

AG type Chipbreaker

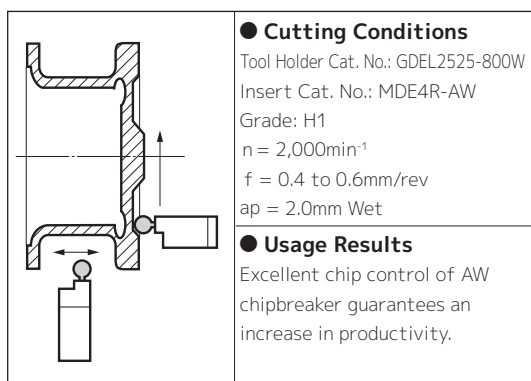
- **35° Diamond type**
VCGT160408N-AG (H1)

Series Tool type



Product Name	Cat. No.	Page
SEC-GD series Holders	GDE R/L2525-600W/S	C46
	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
SEC-MV series Holders	SVPC R/L2525M16	C45
	MVXC R/L2525Q22-20	
	MVXC R/L2525Q22-30	
	MVPC R/L2525Q22-20	
SEC-D series Holders	MVPC R/L2525Q22-30	C38
	DVJN R/L2525 M16	
	DVVN N2525 M16	C39
	DVQN R/L2525 M16	

Application Examples

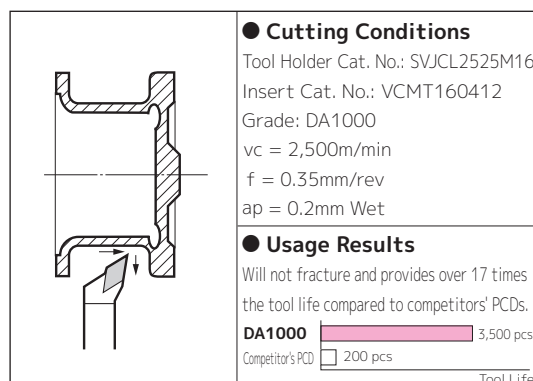


Cutting Conditions

Tool Holder Cat. No.: GDEL2525-800W
Insert Cat. No.: MDE4R-AW
Grade: H1
 $n = 2,000\text{min}^{-1}$
 $f = 0.4 \text{ to } 0.6\text{mm/rev}$
 $ap = 2.0\text{mm Wet}$

Usage Results

Excellent chip control of AW chipbreaker guarantees an increase in productivity.



Cutting Conditions

Tool Holder Cat. No.: SVJCL2525M16
Insert Cat. No.: VCMT160412
Grade: DA1000
 $vc = 2,500\text{m/min}$
 $f = 0.35\text{mm/rev}$
 $ap = 0.2\text{mm Wet}$

Usage Results

Will not fracture and provides over 17 times the tool life compared to competitors' PCDs.

DA1000 3,500 pcs
Competitor's PCD 200 pcs

Tool Life

MV series Profiling Tool Holders

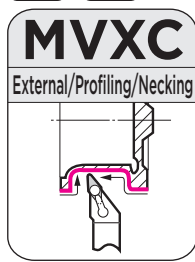
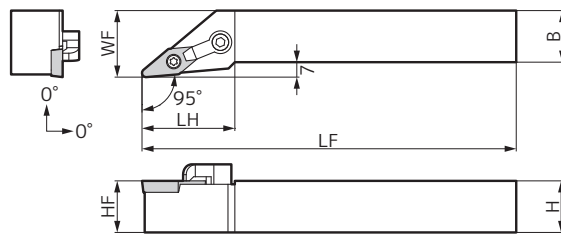


Fig 1



SEC-35° Diamond type - General Turning, Profiling and Necking
Screw-on + Clamp-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 LH	Fig	Parts				
		R	L								Clamp Plate	Double Screw	Flat Insert Screw	Wrench	Wrench for Clamp
★ MVXC R/L2525Q22-20	MVXC R/L2525-2220	●	●	25	25	180	32	25	45	1					
☆ 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

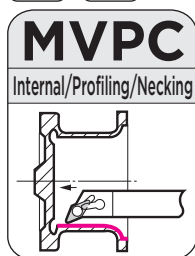
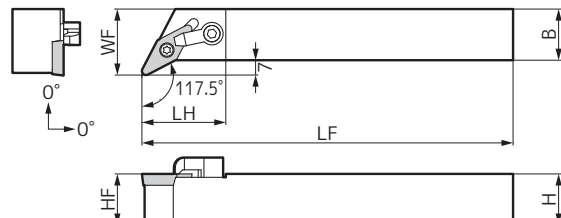


Fig 1



SEC-35° Diamond type - Internal Boring, Profiling and Necking
Screw-on + Clamp-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 LH	Fig	Parts				
		R	L								Clamp Plate	Double Screw	Flat Insert Screw	Wrench	Wrench for Clamp
★ MVPC R/L2525Q22-20	MVPC R/L2525-2220	●	●	25	25	180	32	25	41	1					
☆ 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 When performing internal machining, clearance modification to the bottom of the cutting edge is required.

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 Holder	
	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	☆	
	VCMT220520	—	—	●	▲	12.70	5.56	2.0	★	SVJC type SVVC type SVPC type
	VCMT220530	—	—	●	▲	12.70	5.56	3.0	☆	
	VCGT160408N-AW	—	●	—	—	9.525	4.76	0.8		
	VCGT160412N-AW	—	●	—	—	9.525	4.76	1.2		
	VCGT160408N-AG	—	●	—	—	9.525	4.76	0.8		
	VCGT160412N-AG	—	●	—	—	9.525	4.76	1.2		
	NF-VCMT160404	—	—	●	▲	9.525	4.76	0.4		
	NF-VCMT160408	—	—	●	▲	9.525	4.76	0.8		
	NF-VCMT160412	—	—	●	▲	9.525	4.76	1.2		
	VCMT160408	—	—	●	▲	9.525	4.76	0.8		
	VCMT160412	—	—	●	▲	9.525	4.76	1.2		
	VCMT160412-WF	—	—	●	▲	9.525	4.76	1.2		
	VNMG160404N-UP	●	—	—	—	9.525	4.76	0.4		DVJN type DVVN type DVQN type
	VNMG160408N-UP	●	—	—	—	9.525	4.76	0.8		
	NF-VNMX160404	—	—	●	▲	9.525	4.76	0.4		
	NF-VNMX160408	—	—	●	▲	9.525	4.76	0.8		
	NF-VNMX160412	—	—	●	▲	9.525	4.76	1.2		
	VNMX160404	—	—	●	▲	9.525	4.76	0.4		
	VNMX160408	—	—	●	▲	9.525	4.76	0.8		
	VNMX160412	—	—	●	▲	9.525	4.76	1.2		

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

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

External
Holders

C

Negative

Positive

C

D

R

S

T

V

W

Special

GD series Profiling Tool Holders

Dogbone Insert type - External Turning and Profiling
Clamp-on

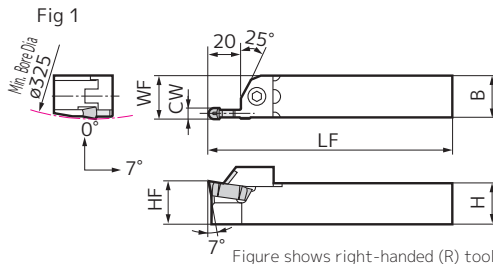
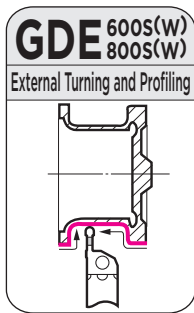


Figure shows right-handed (R) tool.

Holder

Cat. No.	Stock		Height	Width	Overall Length	Cutting Edge	Cutting Edge Height	Width of Cut	Group No.	Fig	Parts			
	R	L	H	B	LF	WF	HF	CW			Carbide Piece Clamp Plate	Special Steel Clamp Plate	Cap Screw	Wrench
GDE R/L2525-600S	●	●	25	25	150	26	25	6	1	1	—	GDS600R/L	BX0625	LH050
GDE R/L2525-800S	●	●	25	25	150	26	25	8	2	1	—	GDS800R/L		
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 page C47 for applicable inserts.

Dogbone Insert type - Facing and Internal Profiling
Clamp-on

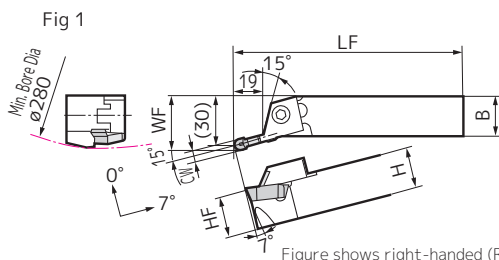
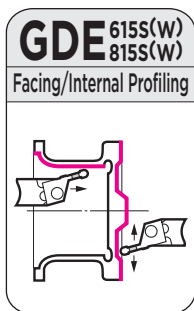


Figure shows right-handed (R) tool.

Holder

Cat. No.	Stock		Height	Width	Overall Length	Cutting Edge	Cutting Edge Height	Width of Cut	Group No.	Fig	Parts			
	R	L	H	B	LF	WF	HF	CW			Carbide Piece Clamp Plate	Special Steel Clamp Plate	Cap Screw	Wrench
GDE R/L2525-615S	●	●	25	25	150	32.2	25	6	1	1	—	GDS615R/L	BX0625	LH050
GDE R/L2525-815S	●	●	25	25	150	33.2	25	8	2	1	—	GDS815R/L		
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 page C47 for applicable inserts.

External Holders

Negative

Positive

C

D

R

S

T

V

W

Special

GD series Profiling Tool Holders

Dogbone Insert type - Internal Profiling
Clamp-on

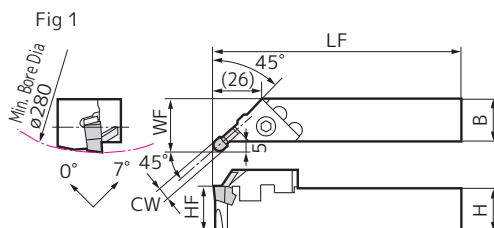
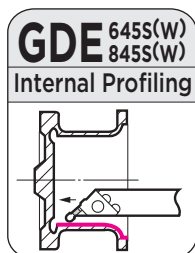


Figure shows right-handed (R) tool.

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	Carbide Piece Clamp Plate	Special Steel Clamp Plate	Cap Screw	Wrench
	R	L												 (For Hexagonal hole)
GDE R/L2525-645S	●	●	25	25	150	30	25	6	1	1	—	GDS645R/L	BX0625	LH050
GDE R/L2525-845S			25	25	150	30	25	8	2	1	—	GDS845R/L		
GDE R/L2525-645W			25	25	150	30	25	6	1	1	GDW645R/L	—		
GDE R/L2525-845W			25	25	150	30	25	8	2	1	GDW845R/L	—		

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

Insert (Dogbone type)

(□ Carbide/ ■ SUMIDIA)

Shape	Cat. No.	Stock		Dimensions (mm)				Group No.	Fig
		H1	DA2200	Overall Length	Thickness	Corner Radius	Width of Cut		
	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	

Fig 1

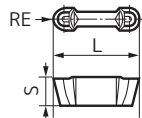


Fig 2

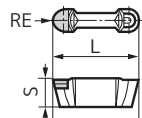
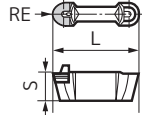


Fig 3



External Holders

C

Negative

Positive

C

D

R

S

T

V

W

Special

Clamp Set Parts

External Holders



Parts

Applicable Clamp Set Cat. No.	Spring		Cap Screw		
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.