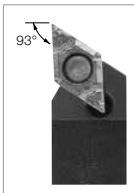
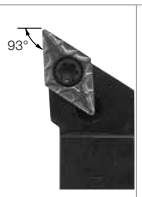
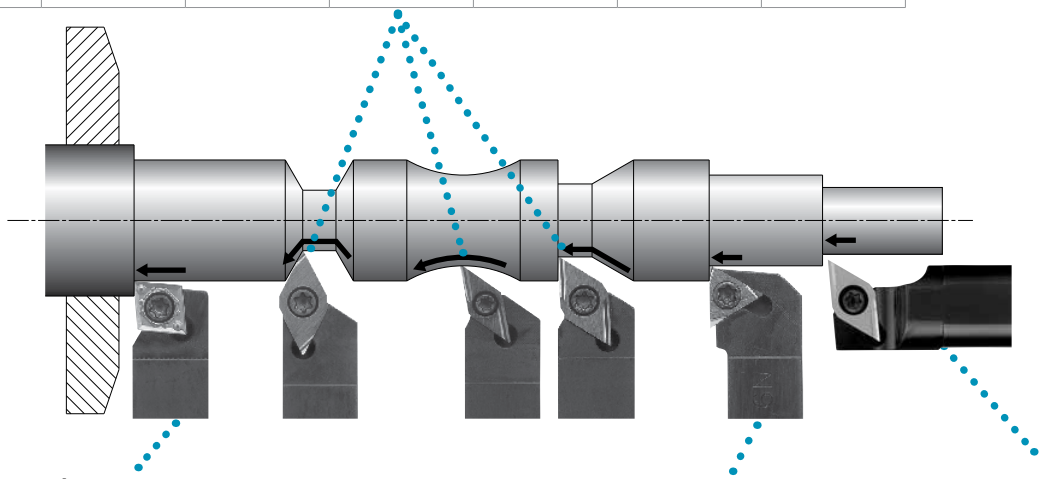
SMALL TOOLS

E1 - E60

TURNING SUMMARY		E2 - E10
IDENTIFICATION SYSTEM		E11
TOOLHOLDERS FOR BACK TURNING		E12 - E21
TKFB INSERT	(Back Turning / Goose-neck / Y-axis)	E12, E14
TKFB-GTP	(Back Turning)	E13
TKF-AGT / TKF-AS INSERT	(Back Turning)	E18
ABS INSERT	(Back Turning)	E19
ABW INSERT	(Back Turning)	E20
GOOSE-NECK HOLDER		E22 - E23
DC INSERT	(Goose-neck Holder)	E22
VP INSERT	(Goose-neck Holder)	E23
EXTERNAL TURNING (BACK CLAMP / SCREW CLAMP)		E24 - E44
CC INSERT	(Without Offset / With Offset)	E24
DC INSERT	(Without Offset / With Offset)	E27
DP INSERT	(Without Offset)	E34
TC / TP INSERT		E35
VB / VC INSERT	(Without Offset / With Offset)	E36
VP INSERT	(Without Offset / With Offset)	E42
EXTERNAL SLEEVE HOLDER TOOLS		E45 - E47
CC INSERT		E45
DC INSERT		E46
VB / VC INSERT		E47
SMALL DOUBLE-SIDED TOOLING (SCREW CLAMP)		E48 - E49
CN / DN INSERT	(Without Offset)	E48
TN INSERT	(Without Offset)	E49
SMALL DOUBLE-SIDED TOOLING (LEVER LOCK)		E50 - E51
CN INSERT	(Without Offset)	E50
TN INSERT	(Without Offset)	E51
SUB-SPINDLE TOOLS (FOR STAR™ MACHINES)		E52 - E54
RECOMMENDED CUTTING CONDITIONS		E55 - E56
NEW PART DESCRIPTION REFERENCE TABLE		E57 - E60

External / Copying

						
ADJC-FF	SDJC-FF(JCTM) SDJC-FF-Y	SDJC	SDLC-FF SDLP-FF	SDLN	SDNC-F	SDNC
Back Clamp Without Offset	Screw Clamp Without Offset	Screw Clamp	Screw Clamp Without Offset	Screw Clamp Without Offset	Screw Clamp	Screw Clamp
E27	E27~E30	E29	E32, E34	E48	E33	E32



External / Facing

ACLC-FF	SCLC-FF(JCTM)	SCLC	SCLN-FF
Back Clamp Without Offset	Screw Clamp Without Offset	Screw Clamp	Screw Clamp Without Offset
E24	E24, E25	E26	E48

External

STGC(P)	STLN-FF
Screw Clamp	Screw Clamp Without Offset
E35	E49

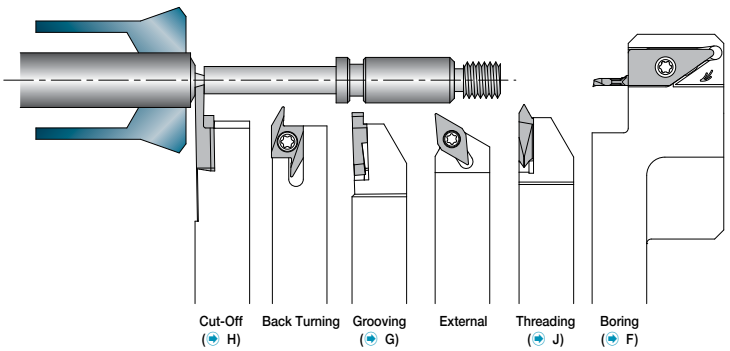
External Sleeve Holder

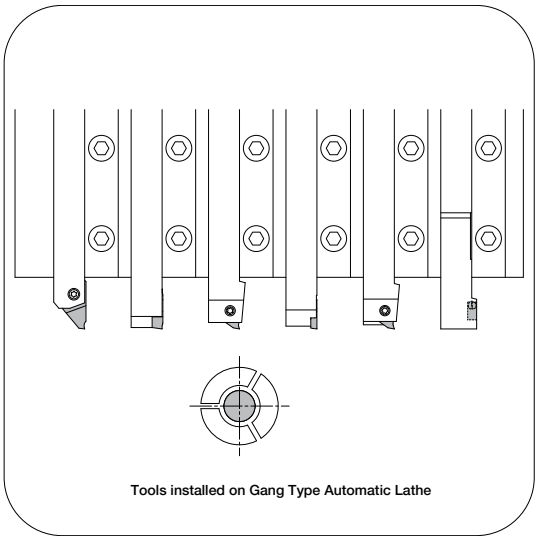
S...SDLC

Screw Clamp Shank Dia.
Ø0.625"~Ø1.000"
Ø12.0mm~Ø25.4mm

E46

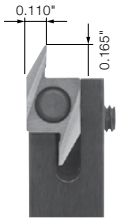
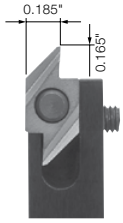
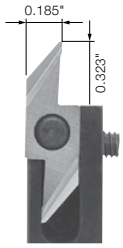
Tooling Example ① - CNC Automatic Lathe (Gang Type)

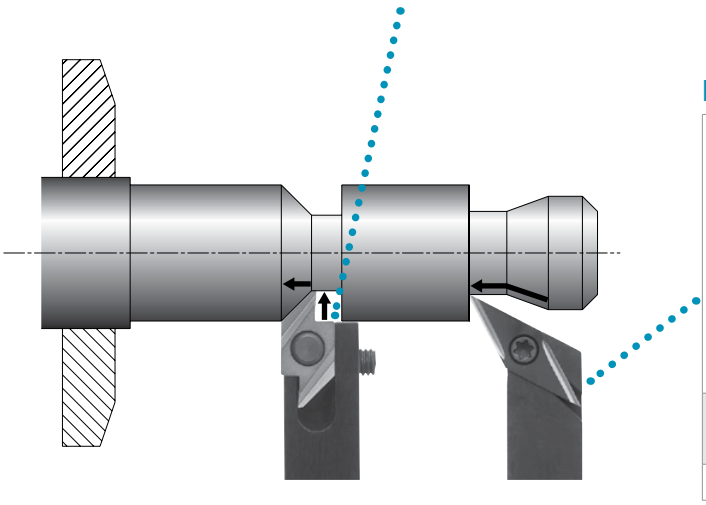




Tools installed on Gang Type Automatic Lathe

Back Turning

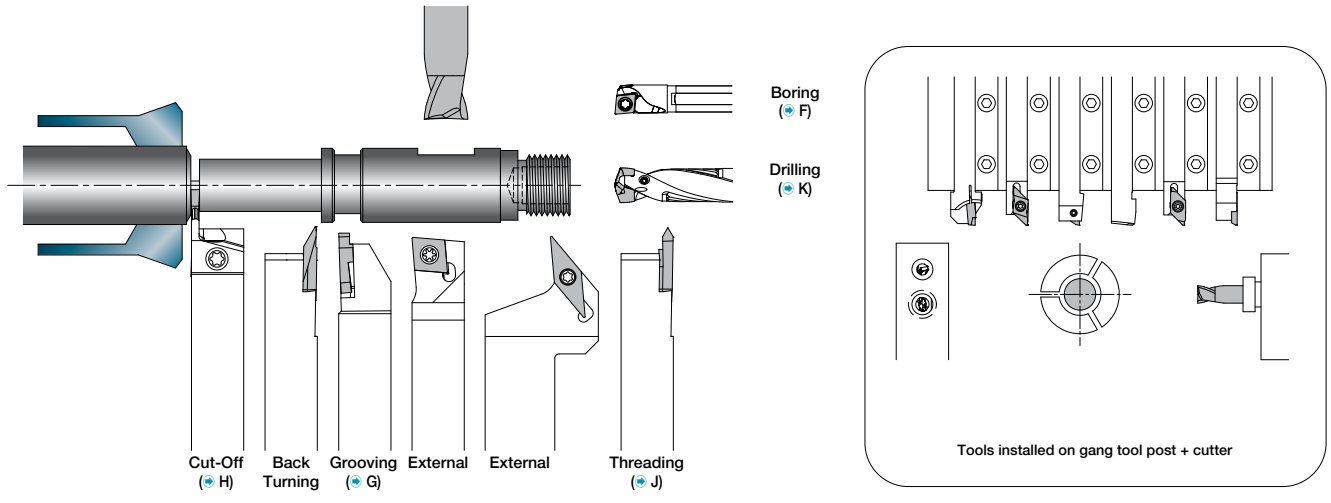
						
AABS-40F	**SABS-40F**	**AABW-40F**	**SABW-40F**	**AABW-50F**	**SABW-50F**	**KTKF**
Back Clamp Edge Width: 0.110" / 2.8mm D.O.C. ~0.158" / ~4.0mm	Screw Clamp Edge Width: 0.110" / 2.8mm D.O.C. ~0.158" / ~4.0mm	Back Clamp Edge Width: 0.185" / 4.7mm D.O.C. ~0.158" / ~4.0mm	Screw Clamp Edge Width: 0.185" / 4.7mm D.O.C. ~0.158" / ~4.0mm	Back Clamp Edge Width: 0.185" / 4.7mm D.O.C. ~0.197" / ~5.0mm	Screw Clamp Edge Width: 0.185" / 4.7mm D.O.C. ~0.197" / ~5.0mm	Screw Clamp Edge Width: 0.059"~0.150" / 1.5mm~3.8mm D.O.C. 0.071"~0.217" / 1.8mm~5.5mm
E19	E19	E20	E20	E21	E21	E12



External / Facing / Copying / Undercutting

SVPB	**SVPP-FF**
Screw Clamp	Screw Clamp (Without Offset)
E38	E44

Tooling Example ② - CNC Automatic Lathe (Gang Type)



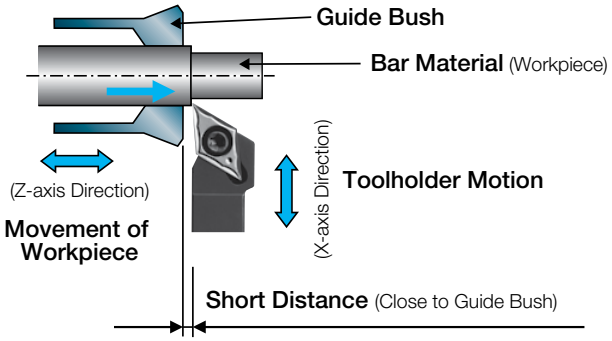
Goose-Neck Toolholder

for Swiss Tool Automatic Lathe (Gang Edge Tool Post)

Swiss Tool Automatic Lathe (Guide Bush System)

The Goose-neck Holder works with automatic lathes that do not move toolholders in longitudinal direction (Z-axis)

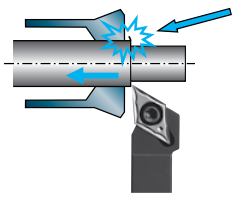
When Using a Conventional Toolholder



Tool position is fixed and workpiece moves longitudinally

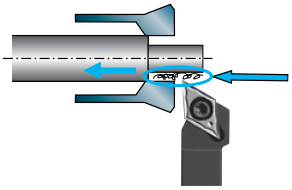
Problems When Using a Conventional Toolholder

Problems When Machining with a Conventional Toolholder

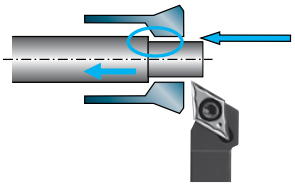


Case 1
At multiple passes, when the bar material returns into guide bush, the burr contacts and breaks the guide bush.

Case 2
The workpiece burr contacts guide bush and causes dimensional variation.



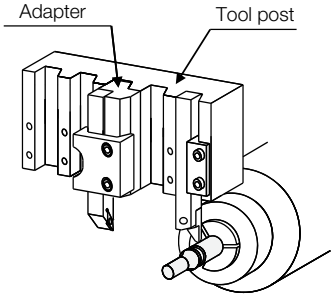
Case 3
Chips may come into guide bush when bar material returns into guide bush after roughing.



Case 4
Bar material gets out of control of guide bush and unable to continue cutting.

Toolholder Installation Problems When Using a Conventional Toolholder

1) Additional space is required for an adapter.
2) Toolholder's handling is difficult due to limited space.
3) It is necessary to buy an adapter.
4) An adapter may interfere with the next toolpost



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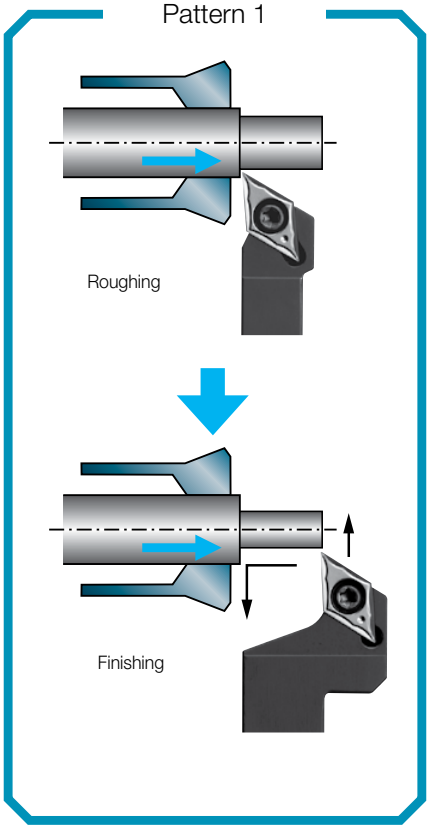
ADVANTAGES

of the Goose-Neck Holder

1) Additional finishing process improves machining precision
2) Chips do not enter guide bushing
3) Large chip evacuation space produces better chip control

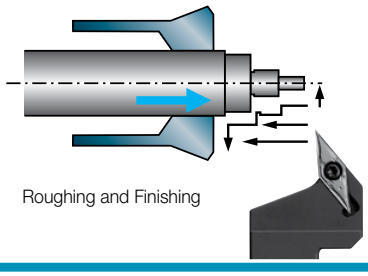
Available for machining after roughing without returning bar material into guide bushing, prevents damages and improves precision.

Pattern 1

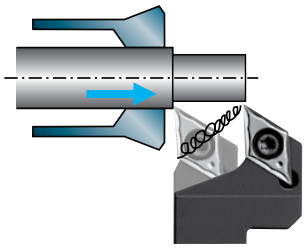


Available for machining from roughing to finishing with a single Goose-neck Holder.

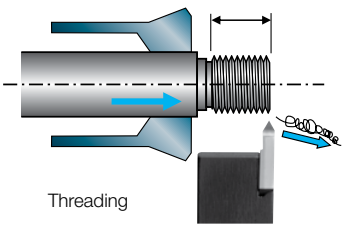
Pattern 2



For smooth chip control



Optimized location of the cutting edge makes enough space for smooth chip evacuation of long chipping materials

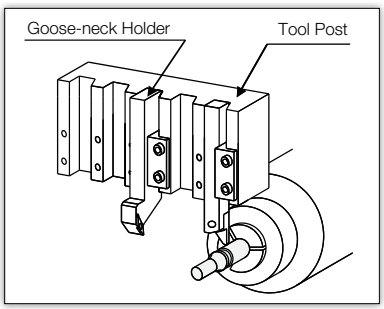


With conventional toolholders, chips can be entangled in guide bushing and damage workpiece

Advantages of Toolholder Installation

Using Goose-neck Holder

1) Maximum number of toolholders can be attached
2) No interference with next tool post

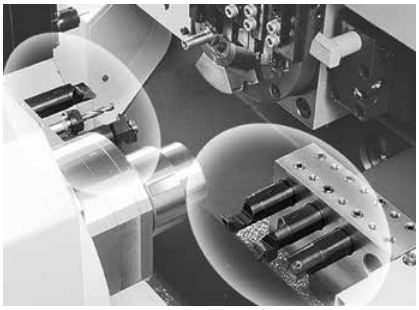


External Sleeve Holder

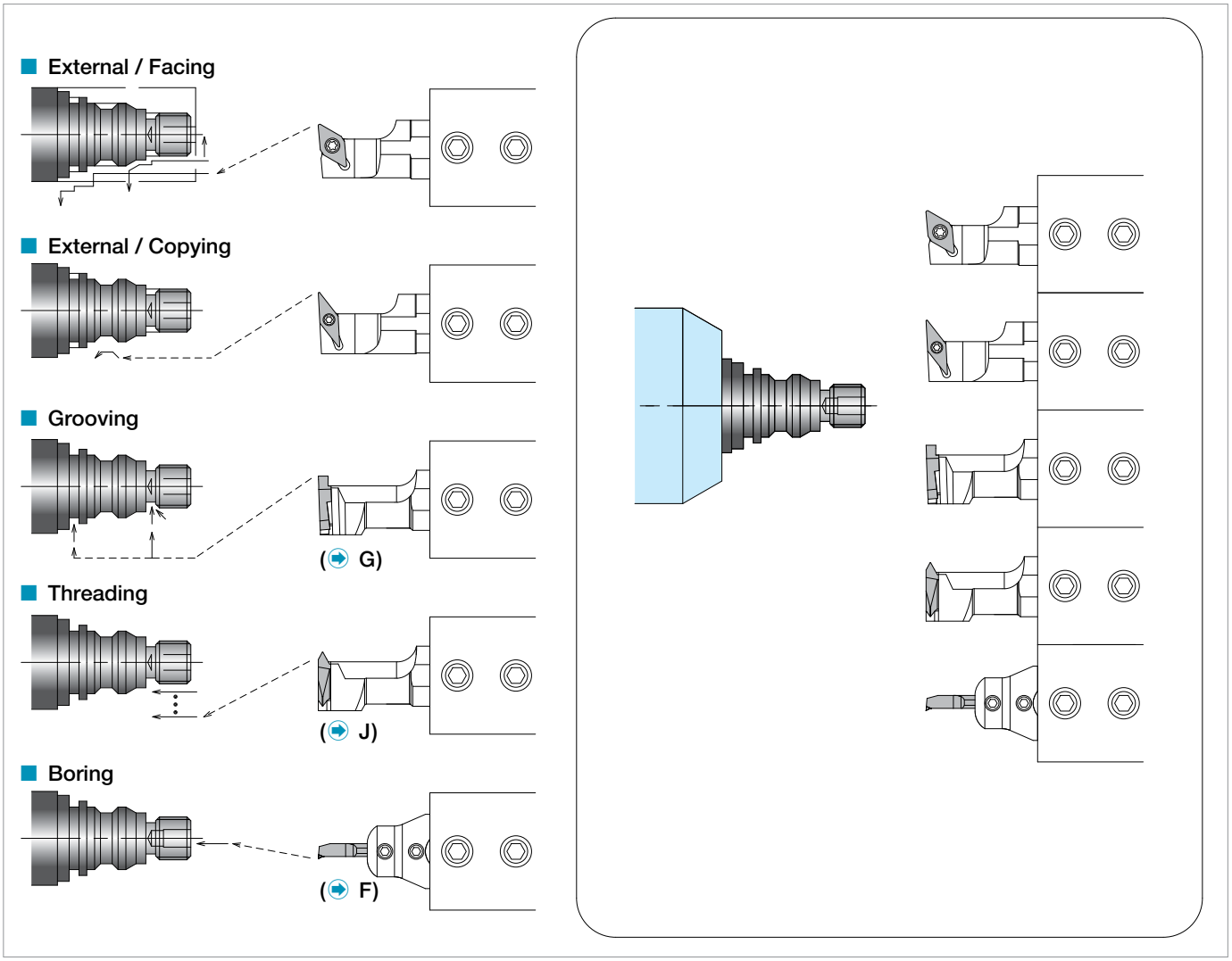
More Tools for CNC Automatic Lathe

Use External Sleeve Holders ➡➡➡ With Attachable Tools During Intricate Part Machining

S...SCLC	**S...SDUC**	**S...SDLC**	**S...SVUB(C)**
Screw Clamp Shank Dia. Ø0.625"~Ø1.000" Ø12.0mm~Ø25.4mm	Screw Clamp Shank Dia. Ø0.625"~Ø1.000" Ø14.0mm~Ø25.4mm	Screw Clamp Shank Dia. Ø0.625"~Ø1.000" Ø12.0mm~Ø25.4mm	Screw Clamp Shank Dia. Ø0.625"~Ø1.000" Ø12.0mm~Ø25.4mm
E45	E46	E46	E47



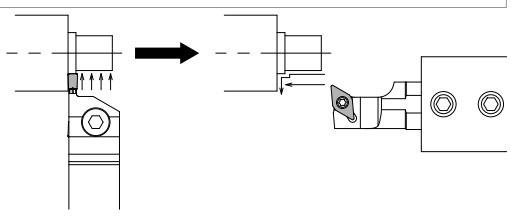
Tooling Example ③ - CNC Automatic Lathe (Opposed Gang Type)



See **Page** ➡ R66~R71 for Automatic Lathe List of Machine Manufacturer and Tooling Examples

Examples of Finishing with Sleeve Holder

1) Roughing by Grooving Toolholder
2) Finishing by Sleeve Holder Improves Chip Control and Reduces Cutting Time



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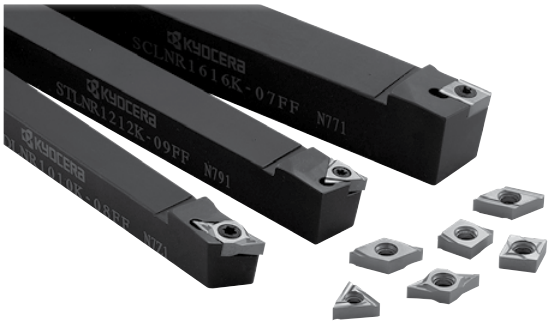
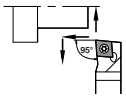
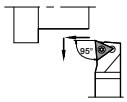
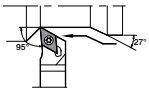
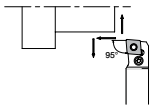
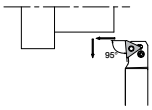
Double-Sided Swiss Tools (Screw Clamp)



Application	External / Facing	External / Up Facing	External / Copying
Cutting Edge Angle	95°	95°	95°
Screw Clamp (Without Offset)	 SCLN	 STLN	 SDLN
Ref. Page	E48	E49	E48

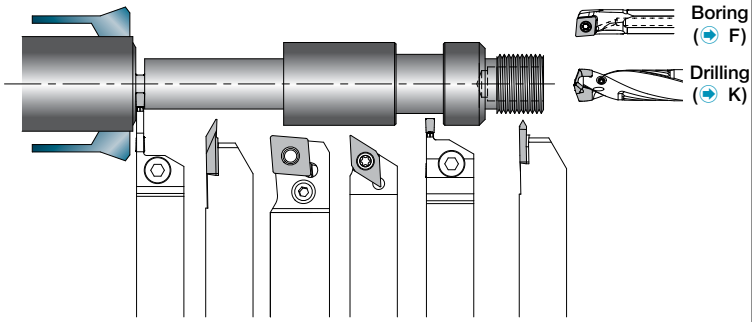
The double-sided design offers less cost per insert and more stability.
Sharp cutting performance equivalent to conventional positive inserts.

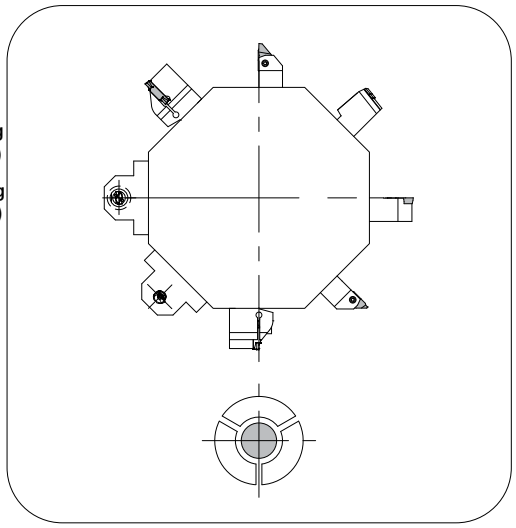
Double-Sided Toolholder for Automatic Lathe (Without Offset / Lever Lock)

Application	External / Facing	External / Up Facing
Cutting Edge Angle	95°	95°
Lever Lock (Without Offset)	 PCLN-FF	 PTLN-FF
Ref. Page	E50	E51

The Lever Lock type is available for small tools with external turning.

Double-Sided Toolholder for Automatic Lathe (Without Offset / Lever Lock)





See Page R66~R71 for Automatic Lathe List of Machine Manufacturer and Tooling Examples

JCTM-Series NEW

Direct from Turret High-Pressure Coolant-Through Cut-Off Holders

Supports Internal Coolant with or without Piping Systems

Internal Coolant without Piping *When the tool turret supports direct coolant

Coolant is supplied directly from the tool turret into the holder without the need to install piping

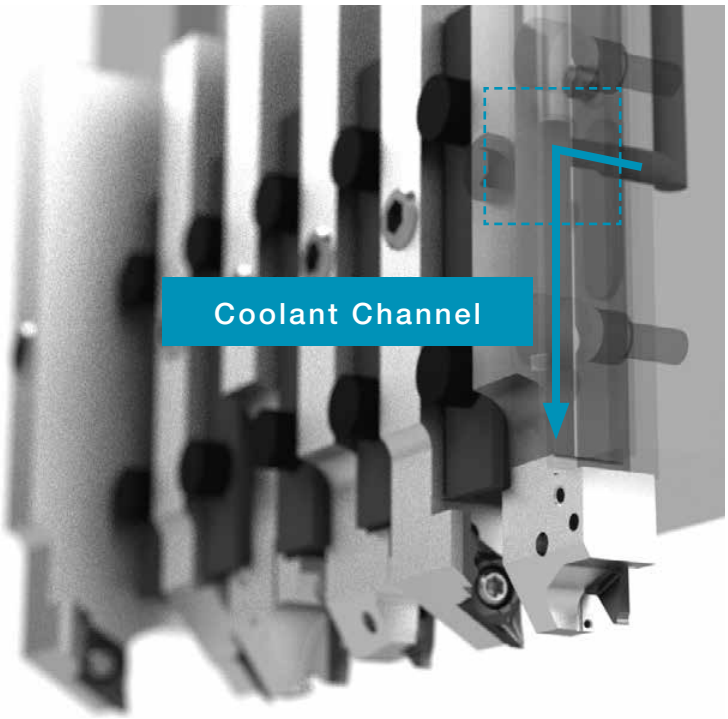
Applicable to Wide Range of Machines

The tool turret is optional. Please contact our company sales representative for details.

(Random order)
Based on Kyocera Survey in January 2021

CITIZEN MACHINERY CO., LTD. (L20, D25, M32)
STAR MICRONICS CO., LTD. (SB-R series, SR series, SV series)
TSUGAMI CORPORATION (S205/206-Ⅱ □16 type, S205A/206A-Ⅱ □16 type)

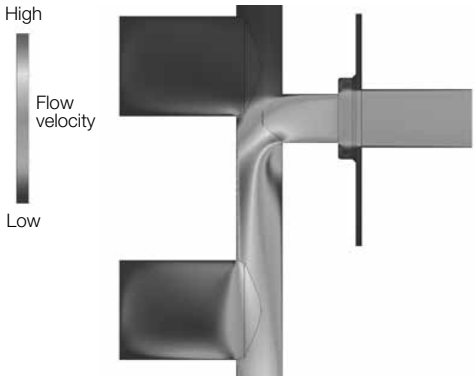
Compatible with various machine including the above.Toolholders can be customized as well.



Optimized Coolant Supply

Supply hole designed to reduce energy loss based on extensive flow analysis

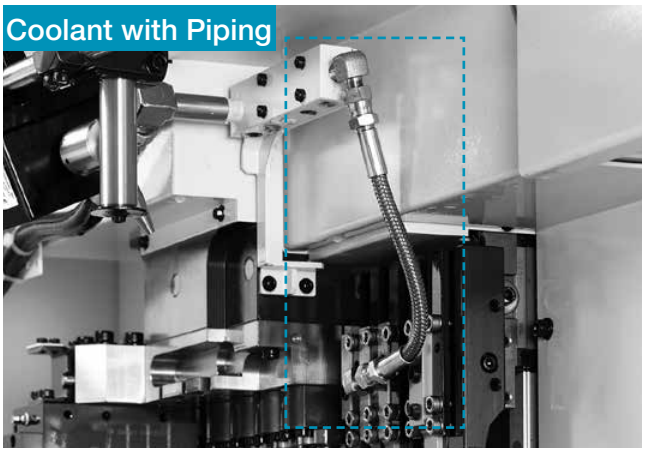
Analysis Image (Internal Evaluation)



Internal Coolant with Piping *Piping parts: See pages H18 and H19

Compatible with internal coolant on any machine with standard piping parts

Commercial piping parts are available when using at normal pressure



NEW ITEMS!

Screw-Clamp-JCTM NEW

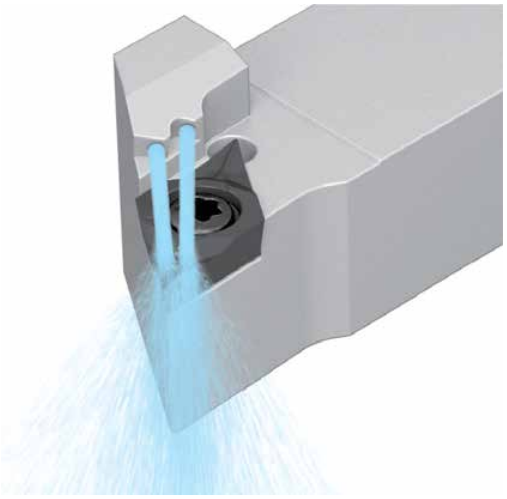
Coolant-Through Turning Holders for Small Parts Machining

Double Coolant Hole Design Delivers an Ample Supply of Coolant to the Cutting Edge Excellent Chip Control and Longer Tool Life

1 Superior Chip Control Performance

2 Sufficient Cooling of the Cutting Edge Leads to Longer Tool Life

Double coolant hole design provides coolant to the insert cutting edge surface



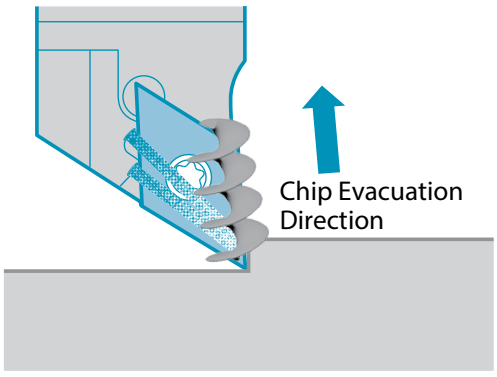
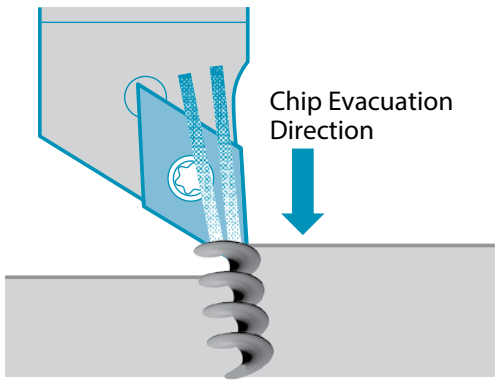
Double Coolant Holes

Provides stable chip curls for superior chip control

The cutting edge stays cool increasing tool life

Insert cross-section

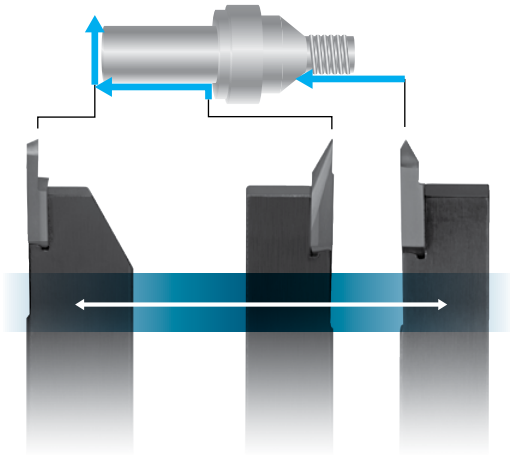
Coolant System Comparison (Internal Evaluation)

	Screw-Clamp-JCTM Holder	Competitor A Holder
Coolant System	Discharges coolant towards the rake surface of insert 	Discharges coolant down onto the chip forcing the chip into the part 
Superior Chip Control	Excellent : Provides stable chip curls	Poor : Chip becomes unstable
Coolant Effects	Excellent : Ensures proper cooling of the cutting edge	Poor : Chip can cause interference with the workpiece

Small Parts Machining

KTKF

E12



Back Turning

TKFB

E12

GQ Chipbreaker

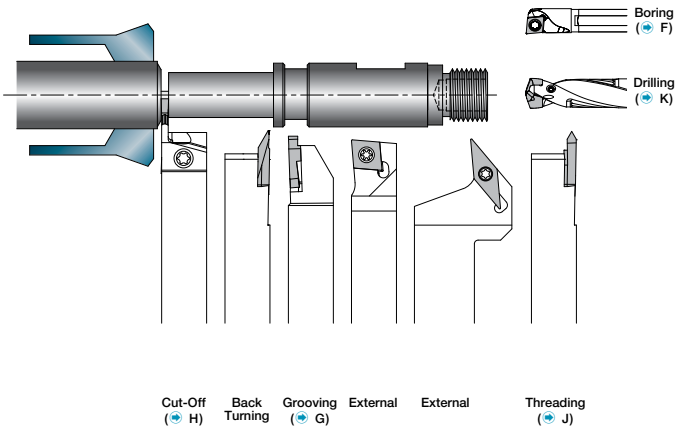
Double function chipbreaker
for improved chip control

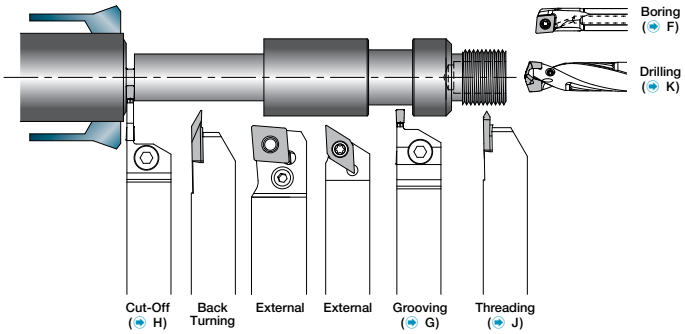
TKFB-GQ

NEW **PR1725**
Insert grade for Steel and Stainless

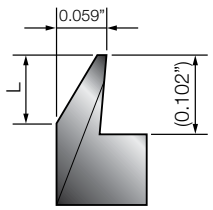
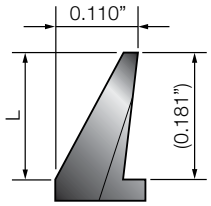
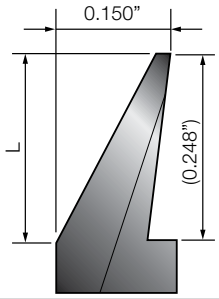
PR1535
Insert grade for Stainless and HRSA

Tooling Examples of KTKF Toolholders





Cutting Edge Shape

For Small D.O.C.		For General Purpose		For Large D.O.C.	
					
Part Number	Cutting Edge Length **L**	Part Number	Cutting Edge Length **L**	Part Number	Cutting Edge Length **L**
TKFB12R15..	0.083"	**TKFB12R28..**	0.165"	**TKFB16R38..**	0.228"
-	-	**TKFB12L28..**	0.173"	**TKFB16L38..**	0.244"
For small diameter workpieces or shorter lengths Minimum overhang length of toolholder, stable machining		For General Purpose Good Chip Control		Large D.O.C. Per Pass	

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Square / Rectangle Shank Identification System

Note: JCT-Series holders for small parts machining have rectangle shanks
See below for part number identification examples

Square Shank:
This number will represent the number of sixteenths of width and height.
Ex. 6/16 = 3/8" Square
Rectangle Shank:
the first digit represents the number of eighths of width and the second digit the number of quarters of height.
Ex. **Width** = 6/8 = 3/4"
Height = 2/4 = 1/2"

Number of 1/8ths on 1/4" I.C. and over.

Optional Code: Manufacturer Options (**FF** : Without Offset) (**JCT** : Jet Coolant-Through Series)

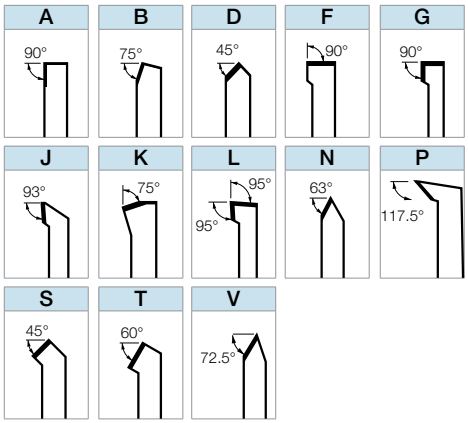
	Clamping System	Insert Shape	Hand of Tool	Shank Size	Insert Size I.C.	Others
ANSI (inch)	S	C	L	C	R	6 – 2	JX	FF	(JCT)
ISO (metric)	S	C	L	C	R	12	12	JX – 09	FF	(JCT)

Clamping System
A : Back Clamp
C : Top Clamp
P : Level Lock
S : Screw Clamp

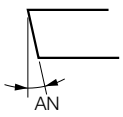
Insert Shape
C : 80° Rhombic
D : 55° Rhombic
S : 90° Square
T : 60° Triangle
V : 35° Rhombic

Hand of Tool
R : Right-Hand
L : Left-Hand
N : Neutral

Cutting Edge Angle



Insert Relief Angle

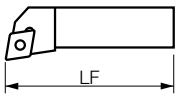


B : 5° Positive
C : 7° Positive
N : 0° Negative
P : 11° Positive

Shank Height
Shank Height (mm)

Shank Width
Shank Width (mm)

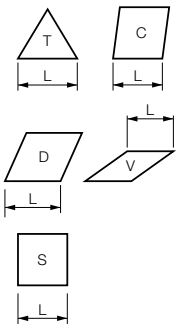
Toolholder Length



F : 80 (85)
H : 100

JX : 4.750" 120mm
K : 125mm
M : 150

Insert Size



• Some back turning toolholders have Kyocera's unique descriptions

External Sleeve Holder Identification System

	ANSI (in)	ISO (mm)		ANSI (in)	ISO (mm)
F:	3.00	80	Q:	7.00	180
G:	3.50	90	R:	8.00	200
H:	4.00	100	S:	10.00	250
J:	4.50	110	T:	12.00	300
K:	5.00	125	U:	14.00	350
L:	5.50	140	V:	16.00	400
M:	6.00	150	W:	18.00	450
N:	6.50	160	Y:	20.00	500
P:	6.75	170	X:	Special	

	Shank	Toolholder Length	Clamping System	Insert Shape	Hand of Tool	Shank Diameter	Cutting Edge Angle	Insert Relief Angle	Insert Size (mm)
ANSI (inch)	S	19	K –	S	C	L	C	L	09				
ISO (metric)	S	20	K –	S	C	L	C	L	09				

Shank
S : Steel

Toolholder Length
See table above

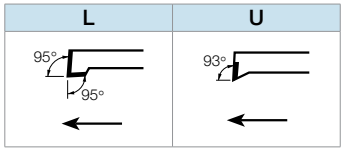
Clamping System
S : Screw Clamp

Insert Shape
C : 80° Rhombic
D : 55° Rhombic
V : 35° Rhombic

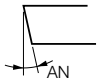
Hand of Tool
L : Left-Hand

Shank Diameter
ANSI
A two-digit number that indicates the shank diameter in 1/16" increments.
ISO
Shank diameter in mm

Cutting Edge Angle

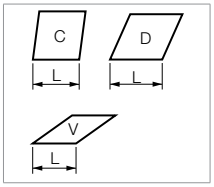


Insert Relief Angle



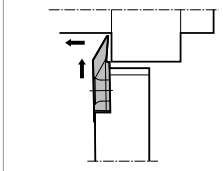
B : 5° Positive
C : 7° Positive

Insert Size (mm)



• The dimensions and specifications are subject to change for improvement without notice.
• Depending on the machine specifications such as attachment Dimensions, the symbol may not match the actual toolholder length.

KTKF / KTKF Goose-neck Holder



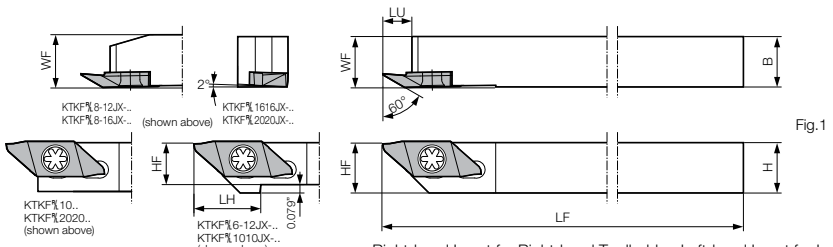
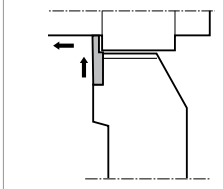


Fig.1

• Right-hand shown

Right-hand Insert for Right-hand Toolholder, Left-hand Insert for Left-hand Toolholder



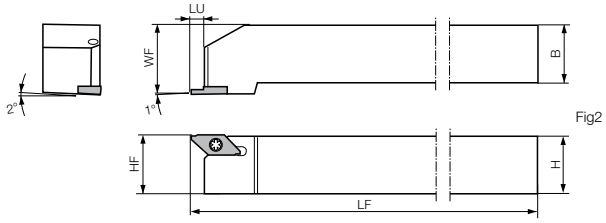
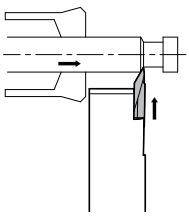


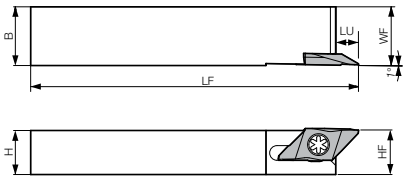
Fig2

• Right-hand shown

Right-hand Insert for Right-hand Toolholder



(Goose-neck Holder)



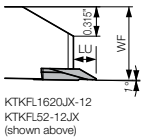


Fig.3

• Left-hand Shown

Left-hand Insert for Left-hand Toolholder

Toolholder Dimensions

Part Number		Stock R	Stock L	Unit	Dimensions H	HF	B	LF	LH	WF	LU	Drawing	Spare Parts: Clamp Screw	Spare Parts: Wrench	Applicable Inserts
KTKF□	6-12JX	●	●	inch	0.375	0.375	0.375	4.750	0.590	0.375	0.236	Fig.1	SB-4590TRWN	LTW-10S	TKFB12□… TKF12□…
	8-12JX	●	●		0.500	0.500	0.500	4.750	-	0.500	0.236				
	10-12JX	●	●		0.625	0.625	0.625	4.750	-	0.625	0.236				
KTKF□	6-16JX	●	●		0.375	0.375	0.375	4.750	0.787	0.375	0.315	Fig.1	SB-4590TRWN	LTW-10S	TKFB16□… TKF16□…
	8-16JX	●	●		0.500	0.500	0.500	4.750	-	0.500	0.315				
	10-16JX	●	●		0.625	0.625	0.625	4.750	-	0.625	0.315				
KTKF□	1010JX-12	●	●	mm	10	10	10	120	15	10	6	Fig.1	SB-4590TRWN	LTW-10S	TKFB12□… TKF12□…
	1212JX-12	●	●		12	12	12	120	-	12	6				
	1616JX-12	●	●		16	16	16	120	-	16	6				
	2020JX-12	●	●		20	20	20	120	-	20	6				
KTKF□	1010JX-16	●	●		10	10	10	120	20	10	8	Fig.1	SB-4590TRWN	LTW-10S	TKFB16□… TKF16□…
	1212JX-16	●	●		12	12	12	120	-	12	8				
	1616JX-16	●	●		16	16	16	120	-	16	8				
	2020JX-16	●	●		20	20	20	120	-	20	8				
KTKF□	1212F-12	●	●		12	12	12	85	-	12	6	Fig.1	SB-4590TRWN	LTW-10S	TKFB12R… TKF12R…
	1212F-16	●	●		12	12	12	85	-	12	8				TKFB16R… TKF16R…
KTKFR	2525M-12	●			25	25	25	150	-	30	6	Fig.2	SB-4590TRWN	LTW-10S	TKFB12R… TKF12R…
	2525M-16	●			25	25	25	150	-	30	8				TKFB16R… TKF16R…
KTKFL	52-12JX		●	inch	0.500	0.500	0.625	4.750	-	0.625	0.236	Fig.3	SB-4590TRWN	LTW-10S	TKFB12L… TKF12L…
	62.5-12JX		●		0.625	0.625	0.750	4.750	-	0.750	0.236				
KTKFL	1216JX-12		●	mm	12	12	16	120	-	16	6	Fig.3	SB-4590TRWN	LTW-10S	
	1620JX-12		●		16	16	20	120	-	20	6				

• Dimensions LU shows the distance from the toolholder to the cutting edge

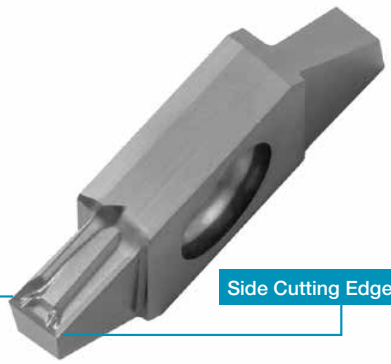
Recommended Cutting Conditions ➡ **E56**

NEW ITEMS!

GTP Chipbreaker NEW

KTKF Insert for Small Parts Machining

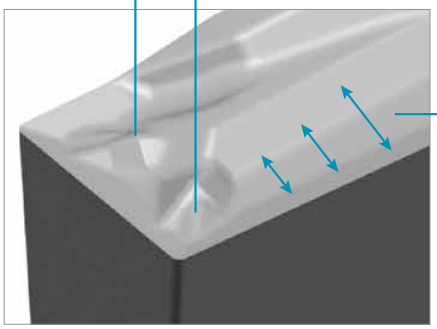
Reduce Cycle Time with Grooving and Traversing Capabilities



Dots for Grooving

Dots for Traversing

Dots utilized for each machining application
Maintains good chip control in small D.O.C.

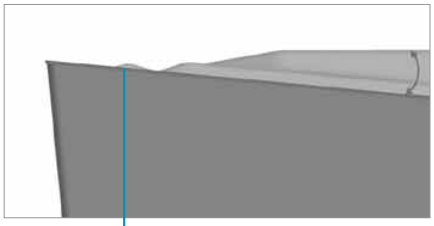


Side Cutting Edge (Back)

Side Cutting Edge (Front)

Chipbreaker Width

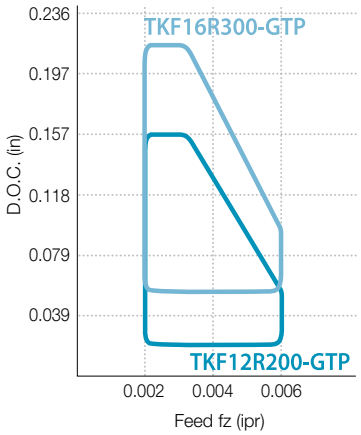
Width is optimized for depth of cut
Maintains good chip control for a wide range of machining applications



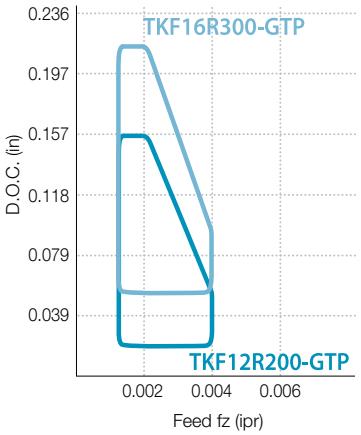
Sloped Cutting Edge

Sloped cutting edge reduces radial force
Great chattering resistance

Chipbreaker Range
(Steel)

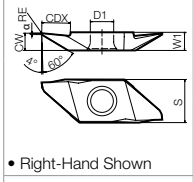
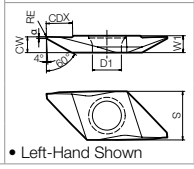


Chipbreaker Range
(Stainless Steel)



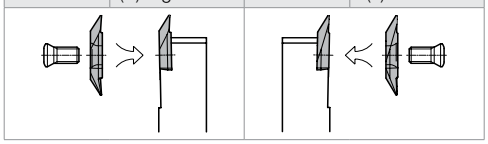
KTKF Applicable Back Turning Inserts B102-B103

TKFB

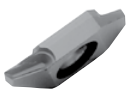
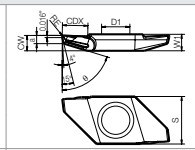
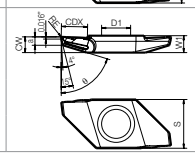
Insert (Photo Shows Right-Hand)	Part Number	Corner-R (RE) : mm (inch)
 • Right-Hand Shown  • Left-Hand Shown	TKFB 12R15005M	<0.05 (<0.002)
	12R28005M	<0.05 (<0.002)
	12R28010M	<0.10 (<0.004)
	TKFB 16R38005M	<0.05 (<0.002)
	16R38010M	<0.10 (<0.004)
	TKFB 12L28005MR	<0.05 (<0.002)
	12L28010MR	<0.10 (<0.004)
	TKFB 16L38005MR	<0.05 (<0.002)
	16L38010MR	<0.10 (<0.004)

Combination of Toolholders & Inserts (See Fig Below)

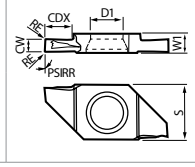
Toolholders	(R) Right-hand	Toolholders	(L) Left-hand
Inserts	(R) Right-hand	Inserts	(L) Left-hand



TKFB-GQ

Insert (Photo Shows Right-Hand)	Part Number	Corner-R (RE) : mm (inch)
 Polished 	TKFB 12R28005P-GQ	0.05 (<0.002)
	12R28015P-GQ	0.15 (<0.006)
	TKFB 16R38005P-GQ	0.05 (<0.002)
	16R38015P-GQ	0.15 (<0.006)
	TKFB 12R28005-GQ	0.05 (<0.002)
	12R28015-GQ	0.15 (<0.006)
	TKFB 16R38005-GQ	0.05 (<0.002)
	16R38015-GQ	0.15 (<0.006)

TKF-GTP

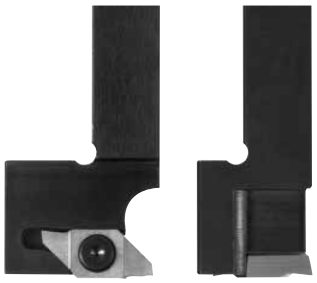
Insert (Photo Shows Right-Hand)	Part Number	Corner-R (RE) : mm (inch)
	TKF 12R200-GTP	0.08 (0.003)
	TKF 16R300-GTP	0.08 (0.003)

Recommended Cutting Conditions E56

Y-axis Toolholders

Improved Chip Control

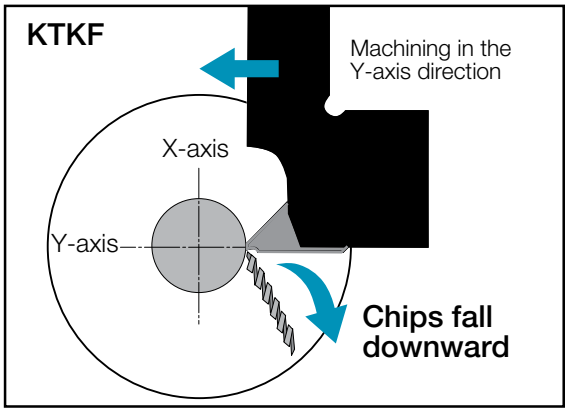
New Toolholder Designs for Better Chip Evacuation in Small Parts Machining



KTKFR-Y

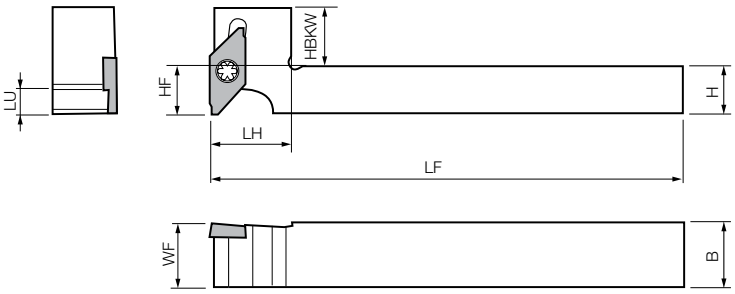
SDJCR-Y
E28

1 Controlled Chip Evacuation for Stable Machining



The Y-axis machining direction allows the chips to fall down and away from the workpiece, improving chip evacuation.

KTKF-Y (Y-axis Holder)



• Right-hand shown

Right-hand Insert for Right-hand Toolholder, Left-hand Insert for Left-hand Toolholder

Toolholder Dimensions

Part Number		Stock		Dimensions (mm)								Spare Parts		Applicable Inserts
												Clamp Screw	Wrench	
		R	L	H	HF	B	LF	LH	WF	LU	HBKW			
KTKFR	1216JX-12-Y	●		12	12	16	120	20	16	6	15	SB-4590TRWN	FT-10	TKFB12R...
	1616JX-12-Y	●		16	16	16		25	16		11			

• Dimensions LU shows the distance from the toolholder to the cutting edge

Recommended Cutting Conditions E56

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(Technical Support) **800.823.7284 - Option 2**
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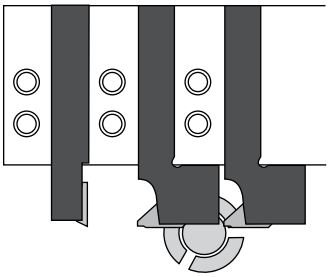
● : Standard Item △ : Phaseout Item (will be removed from next catalog)
Contact your local Kyocera sales engineer to upgrade old products to new technology

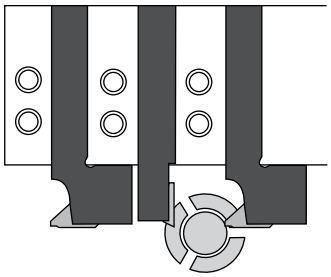
Precautions

Do not use Y-axis toolholders side-by-side to prevent interference (Only two Y-axis holders can be used at the same time)

Interference

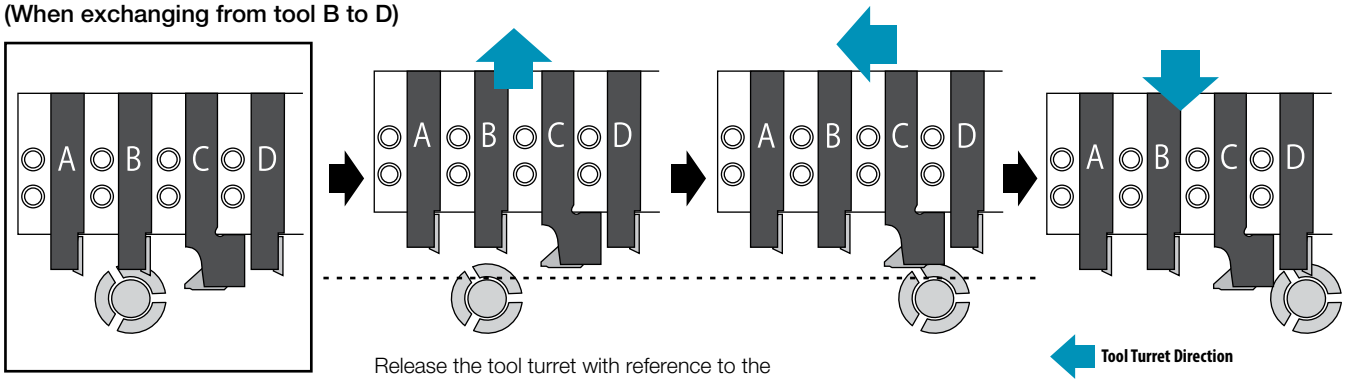


Without Interference



Standard toolholders may be mounted between two Y-axis toolholders

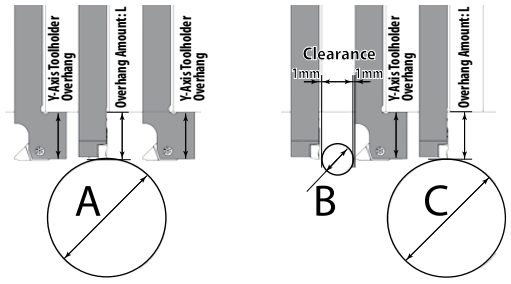
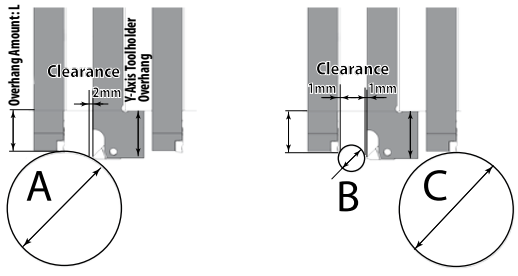
When changing the tool, set the retracted position with reference to the cutting edge of the Y-axis holder (When exchanging from tool B to D)



Release the tool turret with reference to the overhang amount of the Y-axis toolholder

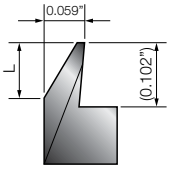
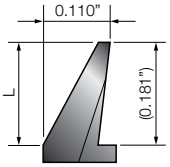
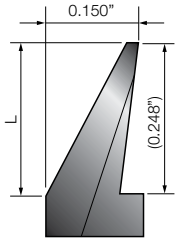
Note that using other toolholder styles together will result in different outside diameters

(Unit: mm)

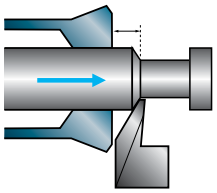
Y-axis Toolholder Overhang	Examples	Overhang Amount : L / Available Outside Cutting Dia. (Ø)	20	22	25
20		A	Without Restriction	Without Restriction	Without Restriction
		B	13.0	13.0	13.0
		C	Without Restriction	Without Restriction	Without Restriction
25		A	38.0	58.0	Without Restriction
		B	14.9	13.6	13.0
		C	45.0	60.0	Without Restriction

Edge Tips Details and Selection Guide

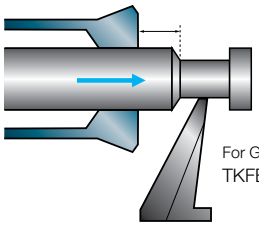
Cutting Edge Shape

For Small D.O.C.		For General Purpose		For Large D.O.C.	
					
Part Number	Cutting Edge Length **L**	Part Number	Cutting Edge Length **L**	Part Number	Cutting Edge Length **L**
TKFB12R15..	0.083"	**TKFB12R28..**	0.165"	**TKFB16R38..**	0.228"
-	-	**TKFB12L28..**	0.173"	**TKFB16L38..**	0.244"
For small diameter workpieces or short length Minimum overhang length of toolholder, stable machining		For general purpose Good chip control		D.O.C. per pass is large.	

How to Select



For Small D.O.C.
TKFB12R15..

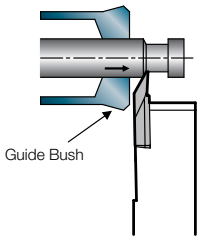
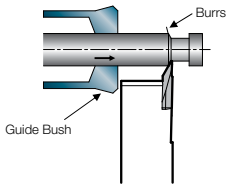


For General Purpose
TKFB12R28..

In case D.O.C. is same, if insert with narrower edge width is used, overhang length from guide bushing is shorter, which enables better stability due to less workpiece vibration.

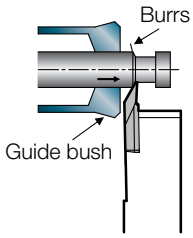
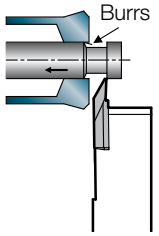
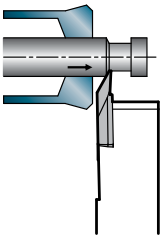
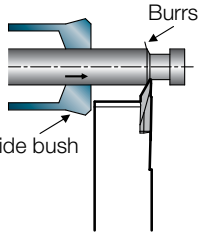
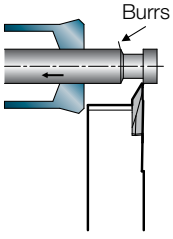
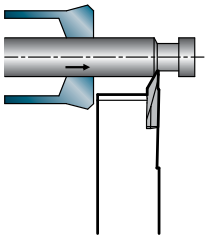
➡High Precision Cutting

Choosing Hand of Back Turning Toolholder

(R) Right-hand		Cutting close to guide bushing is possible Since TKFB12R15005M has a narrow cutting edge (width=0.059"), cutting close to guide bushing is possible ➡Good for small parts and high precision cutting
(L) Left-hand	Even if burrs occur, they will not return into the guide bush. 	Cutting with distance from guide bushing Good chip control due to large space between the guide bushing and the tool. ➡How to improve chip control for roughing to finishing In case of using a left-hand toolholder in finishing, the burred portions of workpiece do not return into the guide bushing, which enables stability of external diameter. Also, a Left-hand toolholder prevents wear of guide bushing due to chip biting.

Workpiece Material Motion & How to Select Hand of Tool

When Roughing, Medium, & Finishing

	Roughing	Workpiece position after roughing	Finishing
(R) Right-hand			
(L) Left-hand			

※Good dimensional accuracy: If a Left-hand toolholder is used, burrs on workpiece generated during roughing do not damage the guide bushing during finishing.

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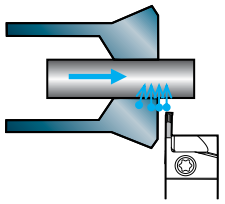
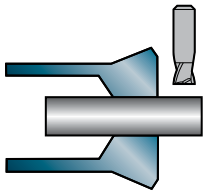
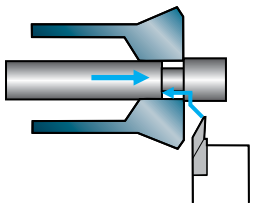
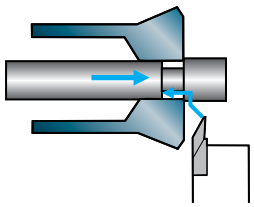
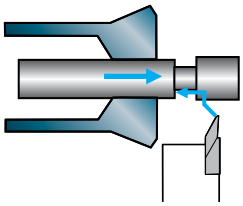
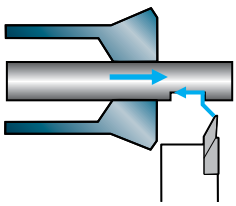
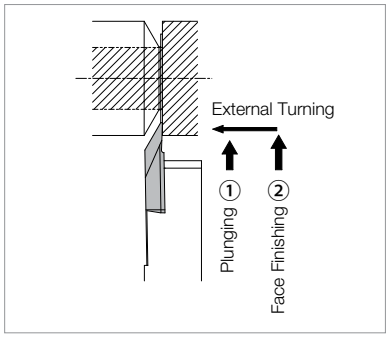
Chip Control Improvement During Back Turning

	① Chip control improvement by tool pass changes	② Chip control improvement by tool pass changes
Roughing / Pre-Stage Machining	● Roughing (1) GMM2420-020MW (Grooving) 	● Pre-stage Machining is Processed with Solid End Mill (1) 2FESW040-040-04 (Solid End Mill) 
Finishing (Countermeasure 1) Use Right-Hand Toolholder	(1) When Using TKFB12R28010M (Back Turning / Righ-hand)  **Advantages :** Smooth Surface Finish **Disadvantages :** If machining pass is long, the guide bushing can not support the workiece	(1) When Using TKFB12R28010M (Back Turning / Righ-hand)  **Advantages :** 1. Minimal deflection during long machining passes 2. Chips are broken into small pieces, though the workpiece material is elastic. **Disadvantages :** The pre-stage machining may cause fractures, because of interruption
Finishing (Countermeasure 2) Use Left-Hand Toolholder	(2) When Using TKFB12L28010M (Back Turning / Left-hand)  **Advantages :** 1. Smooth Surface Finish 2. High precision cutting if the machined portion does not contact the guide bushing **Disadvantages :** If machining pass is long, the guide bushing can not support the workiece	(2) When Using TKFB12L28010M (Back Turning / Left-hand)  **Advantages :** 1. Minimal deflection during long machining passes 2. Chips are broken into small pieces, though the workpiece material is elastic 3. High precision cutting if the machined portion does not contact the guide bushing **Disadvantages :** The pre-stage machining may cause fractures, because of interruption

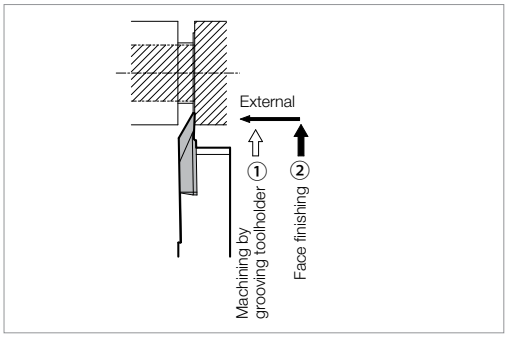
Peeled Surface Countermeasures During Face Back Turning

When peeled surface occurs on the workpiece face, please apply the countermeasures below.

● **Countermeasure 1** (Face Finishing)

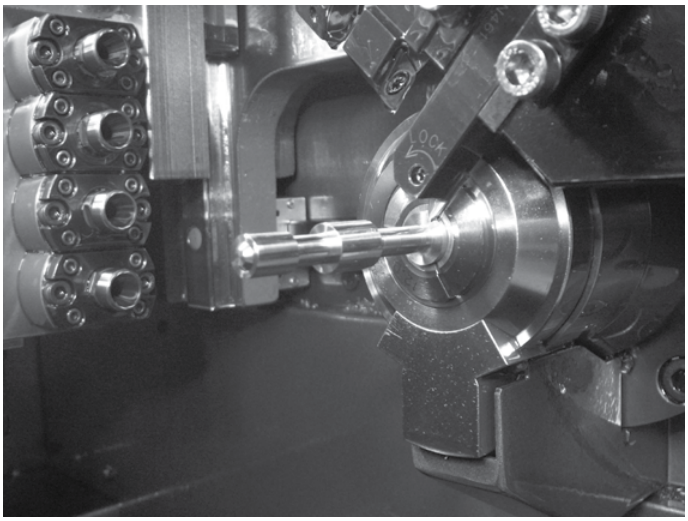


● **Countermeasure 2** (Face Finishing After Grooving)



TKF PCD Inserts for Non-Ferrous

The KTKF toolholder can be used as multi-functional tooling for non-ferrous and non-metal when combined with a TKF-AGT and TKF-AS insert. (See Fig. 1)



Example of Spool Cutting

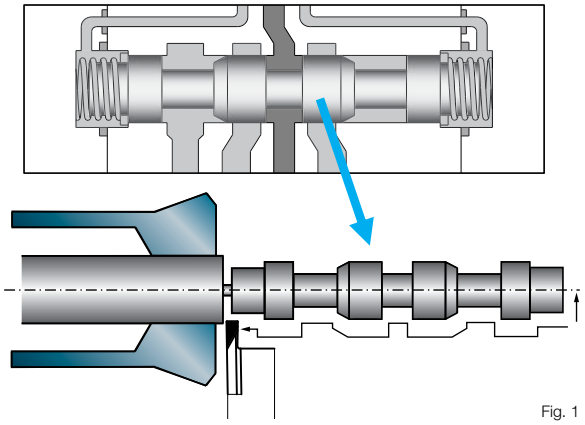
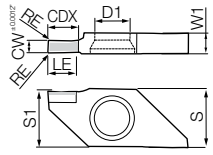
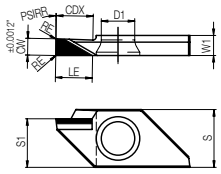
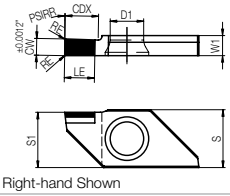


Fig. 1

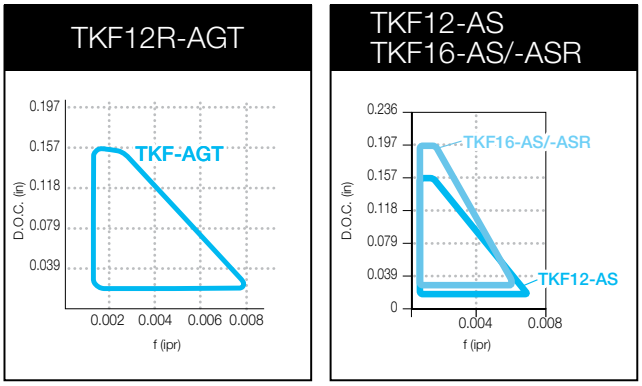
Example of the pass of KTKF toolholder + TKF-AS insert

Applicable Inserts C32

Inserts (Photo Shows Right-hand)		Part Number	
NEW Traversing / Grooving	 • Right-hand Shown	TKF12R	200-AGT
			250-AGT
Traversing / Grooving	 • Right-hand Shown	TKF12R/L	200-AS
		TKF16R/L	250-AS
Grooving Inserts (Traversing possible)	 • Right-hand Shown	TKF12R/L	150-NB
			200-NB
			250-NB
			250-NB4.5

Applicable Toolholder E12, E14
Recommended Cutting Conditions E56

Applicable Range



- TKF PCD inserts are only for turning and grooving
- Cut-off is not recommended

Insert Identification System

TKF	12	R	200	-	AS
TKF	12	L	200	-	AS
Insert Type	Insert Size		Width (Edge Width)		

Insert Hand	Name of Chipbreaker
R : Right-hand	AS : AS Chipbreaker
L : Left-hand	NB : Without Chipbreaker

Note 1) When using TKF-AS insert with KTKF toolholder, the edge position is 1.0mm below the center. (See **Fig.2**) Please adjust the edge height at the parameter of the NC lathe or using soleplates.

2) When the edge height can not be adjusted, please use TKF-AGT or TKF-NB insert. (**Fig.3**)

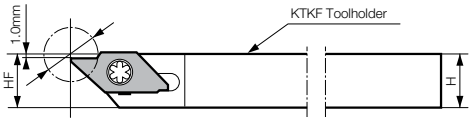


Fig.2 When TKF-AS/-ASR installed (the edge position: 1.0mm below the center)

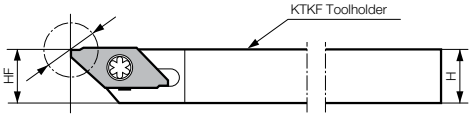
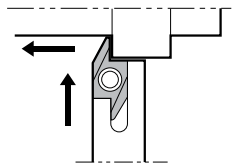
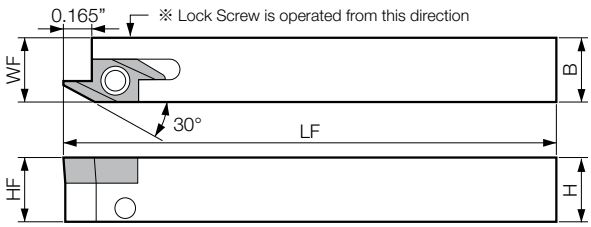


Fig.3 When TKF-NB / TKF-AGT installed

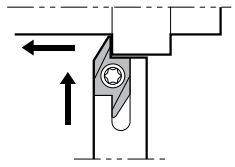
AABS Back Clamp (Edge Width: 0.110" • Depth 0.158" MAX)

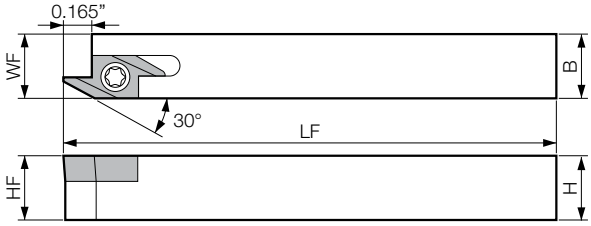




• Right-hand Shown

SABS Screw Clamp (Edge Width: 0.110" • Depth 0.158" MAX)



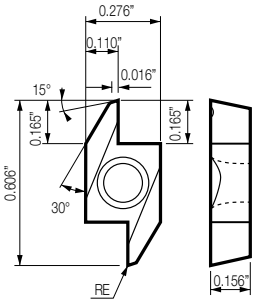


• Right-hand Shown

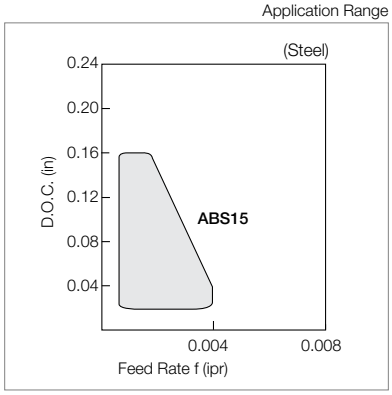
Toolholder Dimensions

Part Number		Stock	Unit	Dimensions H	HF	B	LF	WF	Standard Corner-R (RE)	Spare Parts: Anchor Pin	Lock Screw	Clamp Screw	Wrench
AABSR	6-15JXF	●	inch	0.375	0.375	0.375	4.750	0.383	0.006	LPA-11	HSB4X8R	-	FH-2
	8-15JXF	●		0.500	0.500	0.500	4.750	0.508	0.006	LPA-13			
	10-15JXF	●		0.625	0.625	0.625	4.750	0.633	0.006	LPA-17			
AABSR	1010JX-40F	●	mm	10	10	10	120	10.2	0.15	LPA-11	HSB4X8R	-	FH-2
	1212JX-40F	●		12	12	12	120	12.2	0.15	LPA-13			
	1616JX-40F	●		16	16	16	120	16.2	0.15	LPA-17			
SABSR	6-15JXF	●	inch	0.375	0.375	0.375	4.750	0.383	0.006	-	-	SB-3080TR	FT-10
	8-15JXF	●		0.500	0.500	0.500	4.750	0.508					
	10-15JXF	●		0.625	0.625	0.625	4.750	0.633					
SABSR	1010JX-40F	●	mm	10	10	10	120	10.2	0.15	-	-	SB-3080TR	FT-10
	1212JX-40F	●		12	12	12	120	12.2					
	1616JX-40F	●		16	16	16	120	16.2					
SABSR	1212F-40F	●		12	12	12	85	12.2	0.15	-	-	SB-3080TR	FT-10
	2020K-40F	●		20	20	20	125	20.2					

Applicable Inserts

Insert		Part Number	Corner-R (RE) : mm (inch)	Reference Page
		ABS 15R4005	0.05 (0.002)	B104
		15R4015	0.15 (0.006)	
		ABS 15R4005M	<0.05 (<0.002)	
		15R4015M	<0.15 (<0.006)	

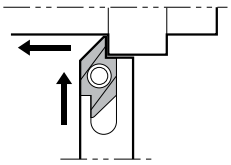
Application Range

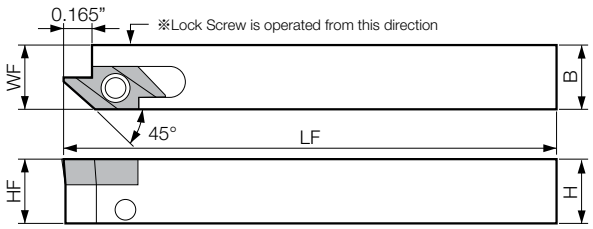


Recommended Cutting Conditions → **E56**

● : Standard Item △ : Phaseout Item (will be removed from next catalog)
Contact your local Kyocera sales engineer to upgrade old products to new technology

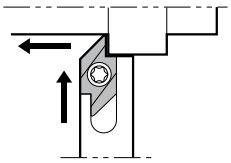
AABW Back Clamp (Edge Width: 0.185" • Depth 0.158" MAX)

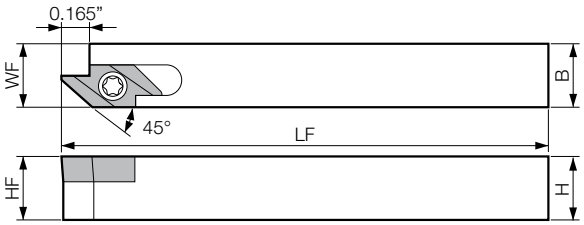




• Right-hand Shown

SABW Screw Clamp (Edge Width: 0.185" • Depth 0.158" MAX)



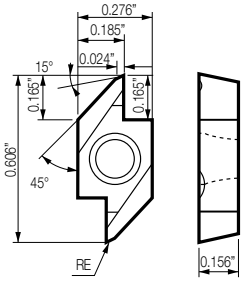


• Right-hand Shown

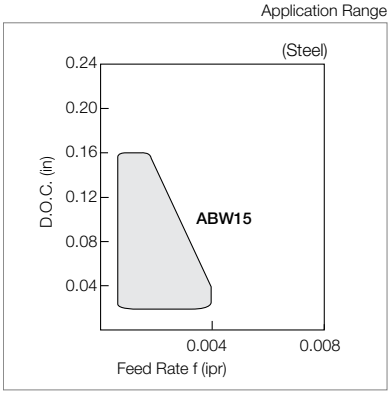
Toolholder Dimensions

Part Number	Stock	Unit	Dimensions H	HF	B	LF	WF	Standard Corner-R (RE)	Spare Parts: Anchor Pin	Lock Screw	Clamp Screw	Wrench
AABWR 6-15JXF	●	inch	0.375	0.375	0.375	4.750	0.383	0.006	LPA-11	HSB4X8R	-	FH-2
8-15JXF	●		0.500	0.500	0.500	4.750	0.508	0.006	LPA-13			
10-15JXF	●		0.625	0.625	0.625	4.750	0.633	0.006	LPA-17			
AABWR 1010JX-40F	●	mm	10	10	10	120	10.2	0.15	LPA-11	HSB4X8R	-	FH-2
1212JX-40F	●		12	12	12	120	12.2	0.15	LPA-13			
1616JX-40F	●		16	16	16	120	16.2	0.15	LPA-17			
SABWR 8-15JXF	●	inch	0.500	0.500	0.500	4.750	0.508	0.006	-	-	SB-3080TR	FT-10
10-15JXF	●		0.625	0.625	0.625	4.750	0.633					
SABWR 1010JX-40F	●	mm	10	10	10	120	10.2	0.15	-	-	SB-3080TR	FT-10
1212JX-40F	●		12	12	12	120	12.2					
1616JX-40F	●		16	16	16	120	16.2					
SABWR 2020K-40F	●		20	20	20	125	20.2	0.15	-	-	SB-3080TR	FT-10

Applicable Inserts

Insert		Part Number	Corner-R (RE) : mm (inch)	Reference Page
		**ABW 15R4005**	0.05 (0.002)	→ **B104**
		15R4015	0.15 (0.006)	
		ABW 15R4005M	<0.05 (<0.002)	
		15R4015M	<0.15 (<0.006)	

Application Range

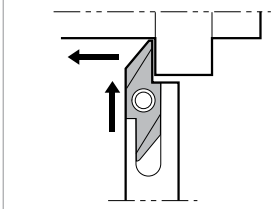


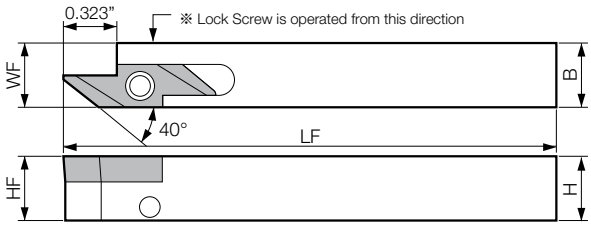
Recommended Cutting Conditions → **E56**

(Customer Service) **800.823.7284 - Option 1**
(Technical Support) **800.823.7284 - Option 2**
Visit us online at **KyoceraPrecisionTools.com**

● : Standard Item △ : Phaseout Item (will be removed from next catalog)
Contact your local Kyocera sales engineer to upgrade old products to new technology

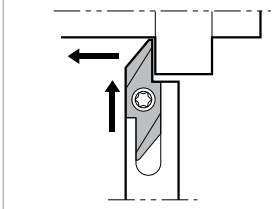
AABW Back Clamp (Edge Width: 0.185" • Depth 0.197" MAX)

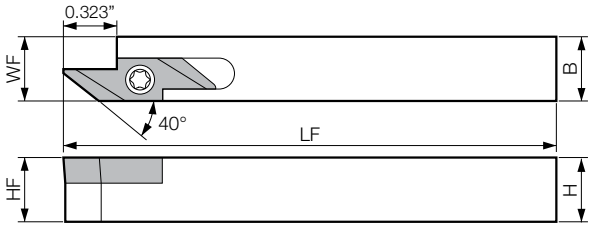




• Right-hand Shown

SABW Screw Clamp (Edge Width: 0.185" • Depth 0.197" MAX)



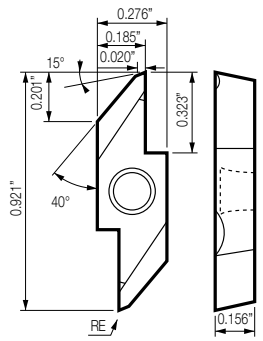


• Right-hand Shown

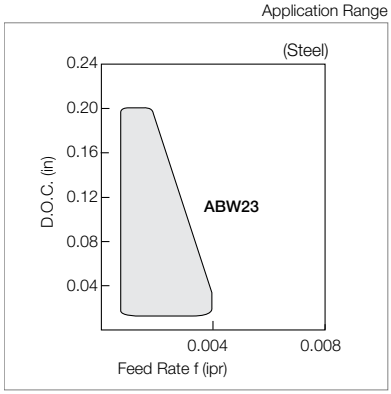
Toolholder Dimensions

Part Number	Stock	Unit	Dimensions H	HF	B	LF	WF	Standard Corner-R (RE)	Spare Parts: Anchor Pin	Lock Screw	Clamp Screw	Wrench
AABWR 6-23JXF	●	inch	0.375	0.375	0.375	4.750	0.383	0.006	LPA-11	HSB4X8R	-	FH-2
8-23JXF	●		0.500	0.500	0.500	4.750	0.508	0.006	LPA-13			
10-23JXF	●		0.625	0.625	0.625	4.750	0.633	0.006	LPA-17			
AABWR 1010JX-50F	●	mm	10	10	10	120	10.2	0.15	LPA-11	HSB4X8R	-	FH-2
1212JX-50F	●		12	12	12	120	12.2	0.15	LPA-13			
1616JX-50F	●		16	16	16	120	16.2	0.15	LPA-17			
SABWR 8-23JXF	●	inch	0.500	0.500	0.500	4.750	0.508	0.006	-	-	SB-3080TR	FT-10
10-23JXF	●		0.625	0.625	0.625	4.750	0.633					
SABWR 1010JX-50F	●	mm	10	10	10	120	10.2	0.15	-	-	SB-3080TR	FT-10
1212JX-50F	●		12	12	12	120	12.2					
1616JX-50F	●		16	16	16	120	16.2					
SABWR 2020K-50F	●		20	20	20	125	20.2	0.15	-	-	SB-3080TR	FT-10

Applicable Inserts

Insert		Part Number	Corner-R (RE) : mm (inch)	Reference Page
		**ABW 23R5005**	0.05 (0.002)	B104
		23R5015	0.15 (0.006)	
		ABW 23R5005M	<0.05 (<0.002)	
		23R5015M	<0.15 (<0.006)	

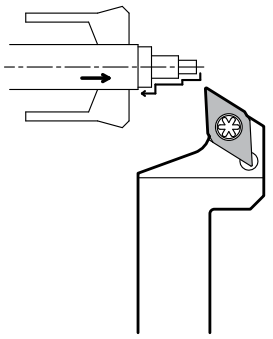
Application Range

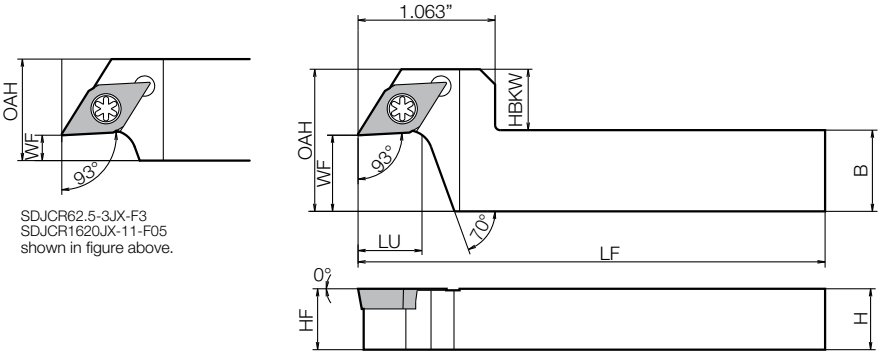


Recommended Cutting Conditions → **E56**

● : Standard Item △ : Phaseout Item (will be removed from next catalog)
Contact your local Kyocera sales engineer to upgrade old products to new technology

SDJC (External / Copying)





SDJCR62.5-3JX-F3
SDJCR1620JX-11-F05
shown in figure above.

• Right-hand Shown

Toolholder Dimensions

Part Number		Stock	Unit	Dimensions								Standard Corner-R (RE)	Spare Parts	
				H	HF	B	LF	LU	OAH	HBKW	WF		Clamp Screw	Wrench
SDJCR	52-3JX-F3	●	inch	0.500	0.500	0.625	4.750	0.488	0.687	0.062	0.187	0.008	SB-4085TR	FT-15
	52-3JX-F9	●		0.500	0.500	0.625	4.750	0.488	1.125	0.500	0.562			
	62.5-3JX-F9	●		0.625	0.625	0.750	4.750	0.488	1.125	0.375	0.562			
SDJCR	1216JX-11-F05	●	mm	12	12	16	120	12.6	18	2	5	0.2	SB-4085TR	FT-15
	1216JX-11-F15	●		12	12	16	120	12.6	28	12	15			
	1620JX-11-F05	●		16	16	20	120	12.6	20	-	5			
	1620JX-11-F15	●		16	16	20	120	12.6	28	8	15			

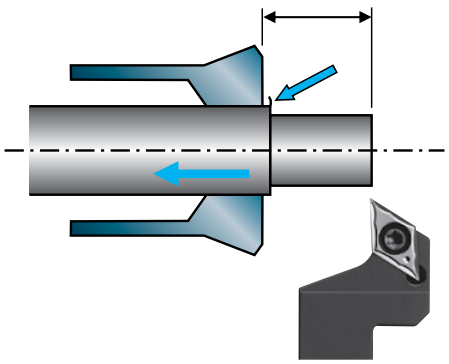
Applicable Inserts

Application	Minute D.O.C.	Finishing	Finishing	Finishing	Finishing	Finishing	Finishing-Medium	Finishing-Medium	Finishing	Finishing / Precision	Low Feed	Low Feed / Precision
Ref. Page	B62	B62	B62	B62	B63	B63	B64	B63	B67	B66	B68, B69	B68
Insert / Toolholder	**CF**	**GF**	**SKS**	**SK**	**WP** (Wiper)	**PP**	**GK**	**GQ**	**R-F**	**R-FSF**	**(E/F) R-U**	**FR-USF**
SDJCR..-3JX-F.. SDJCR..-11-F..	DCGT325..	DCGT325..	DCGT325..	DCGT325..	DCMX325..	DCMT325..	DCMT325..	DCGT325..	DCGT325..	DCET325..	DCGT325..	DCET325..
Application	Low Feed	Low Feed / Precision	Low Carbon Steel / Finishing	Low Carbon Steel / Finishing-Medium	Stainless Steel	Cast Iron	Non-ferrous Metals	Non-ferrous Metals	Non-ferrous Metals	Non-ferrous Metals	Hard Materials	
Ref. Page	B70, B71	B70	B65	B65	B65	B71	B71	B71	C25	C25	C15	
Insert / Toolholder	**(E/F)R-J**	**FR-JSF**	**XP**	**XQ**	**MQ**	**No Chipbreaker**	**AH**	**R-A3**	**PCD**	**APD**	**CBN**	
SDJCR..-3JX-F.. SDJCR..-11-F..	DC_T325..	DCET325..	DCMT325..	DCMT325..	DCMT325..	DCGW325..	DCGT325..	DCGT325..	DCMT325..	DCMT325..	DCMW325..	

When using **WP** chipbreaker, program corrections are required. **R51**

Recommended Cutting Conditions **E55**

Goose-neck Designed for Multiple Passes, Both Roughing & Finishing!

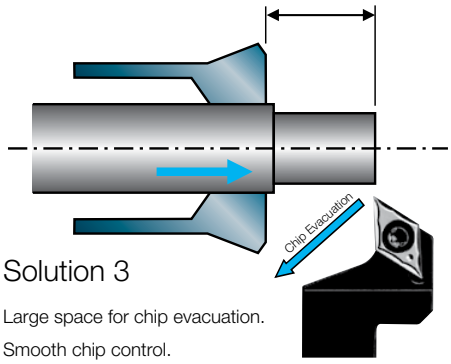


Solution 1

No breakage will occur because the burrs do not contact the guide bushing.

Solution 2

Longitudinal dimensions will be stable. External diameter will be stable by multiple pass machining (roughing and finishing).



Solution 3

Large space for chip evacuation. Smooth chip control.

(Customer Service) **800.823.7284 - Option 1**
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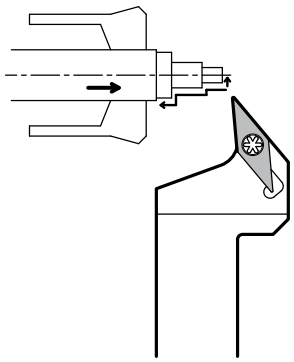
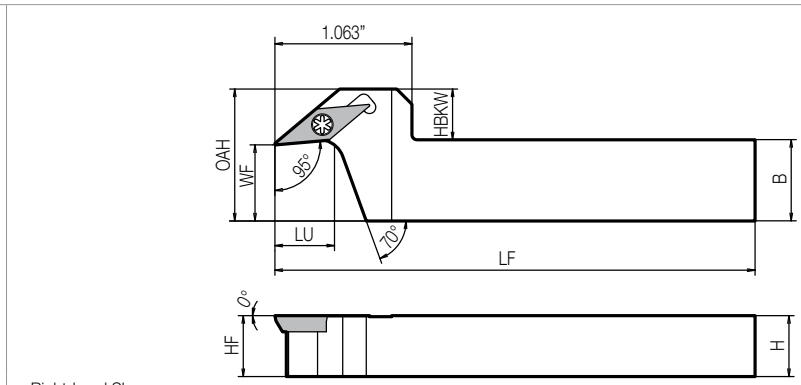
● : Standard Item △ : Phaseout Item (will be removed from next catalog)
Contact your local Kyocera sales engineer to upgrade old products to new technology

SVLP (External / Copying)





• Right-hand Shown

Toolholder Dimensions

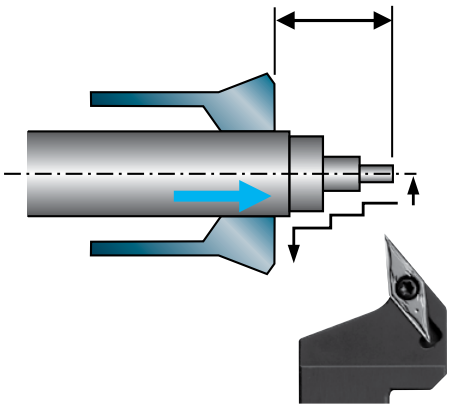
Part Number		Stock	Unit	Dimensions								Standard Corner-R (RE)	Spare Parts	
				H	HF	B	LF	LU	OAH	HBKW	WF		Clamp Screw	Wrench
SVLPR	**52-2JX-F9**	●	inch	0.500	0.500	0.625	4.750	0.472	1.000	0.375	0.562	0.008	SB-2570TR	FT-15
	62.5-2JX-F9	●		0.625	0.625	0.750	4.750	0.472	1.000	0.250	0.562			
SVLPR	**1216JX-11-F15**	●	mm	12	12	16	120	12	26	10	15	0.2	SB-2570TR	FT-8
	1620JX-11-F15	●		16	16	20	120	12	26	6	15			

Applicable Inserts

Application	Minute D.O.C.	Finishing	Finishing	Finishing / Precision	Low Feed	Low Feed / Precision
Ref. Page	B94	B94	B94	B95	B96	B96
Insert / Toolholder	**CF**	**CK**	**GF**	**R-FSF**	**FR-U**	**FR-USF**
SVLPR..-2JX-F.. **SVLPR..-11-F..**	VPGT22..	VPGT22..	VPGT22..	VPET22..	VPET22..	VPET22..

Recommended Cutting Conditions ➡ **E55**

One Toolholder for Complex Workpieces

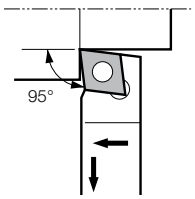


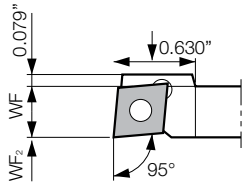
Toolholder for VP type inserts.

Complex workpieces can be processed with one toolholder.

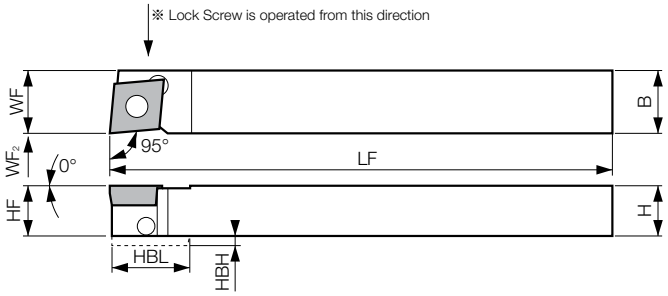
It is available for undercutting and external/face finishing.

■ ACLC-FF (Without Offset • External / Facing)





ACLC□6-3JXFF
ACLC□1010JX-06FF
shown above



• Right-hand Shown

● Toolholder Dimensions

Part Number		Stock R	Stock L	Unit	Dimensions H	HF	HBH	B	LF	HBL	WF	WF_2	Standard Corner-R (RE)	Spare Parts: Anchor Pin	Lock Screw	Wrench
ACLC□	6-2JXFF	●	●	inch	0.375	0.375	-	0.375	4.750	-	0.375	0	0.008	LPF-11	HSB4X8□	FH-2
	6-3JXFF	●	●		0.375	0.375	0.097	0.375	4.750	0.630	0.375	0	0.008	LPF-13		
	8-3JXFF	●	●		0.500	0.500	-	0.500	4.750	-	0.500	0				
	10-3JXFF	●	●		0.625	0.625	-	0.625	4.750	-	0.625	0	0.008	LPF-17		
ACLC□	1010JX-06FF	●	●	mm	10	10	-	10	120	-	10	0	0.2	LPF-11	HSB4X8□	FH-2
	1010JX-09FF	●	●		10	10	2	10	120	16	10	0	0.2	LPF-13		
	1212JX-09FF	●	●		12	12	-	12	120	-	12	0				
	1616JX-09FF	●	●		16	16	-	16	120	-	16	0	0.2	LPF-17		

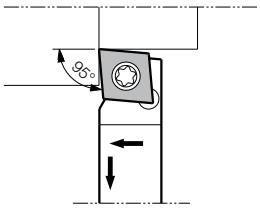
• Lock Screw : HSB4X8R for Right-hand Toolholder, HSB4X8L for Left-hand Toolholder

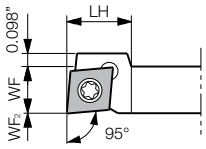
● Applicable Inserts

Application	Finishing	Finishing	Finishing-Medium	Low Feed	Stainless Steel	Cast Iron	Non-ferrous Metals	Non-ferrous Metals	Non-ferrous Metals	Hard Material
Ref. Page	B53	B53	B54	B58, B59	B55	B60	B60	B60	C24	C14
Insert / Toolholder	SKS	SK	GK	(E/F)□-U	MQ	No Chipbreaker	AH	□-A3	PCD	CBN
ACLC□..-2JXFF ACLC□..-06FF	CCGT215..	CCGT215..	CCMT215..	CCGT215..	-	CCGW215..	-	-	CCMT215.. CCGW215..	CCMW215..
ACLC□..-3JXFF ACLC□..-09FF	CCGT325..	CCGT325..	CCMT325..	CCGT325..	CCMT325..	CCGW325..	CCGT325..	CCGT325..	CCMT325.. CCGW325..	CCMW325..

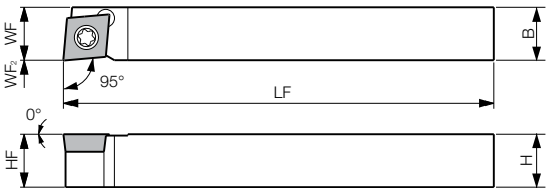
Recommended Cutting Conditions ➡ **E55**

■ SCLC-FF (Without Offset • External / Facing)





SCLC□6-3JXFF
SCLC□1010JX-09FF
shown above



• Right-hand Shown

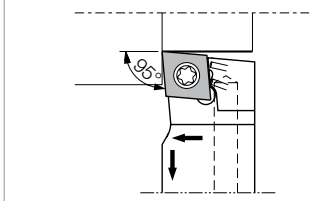
● Toolholder Dimensions

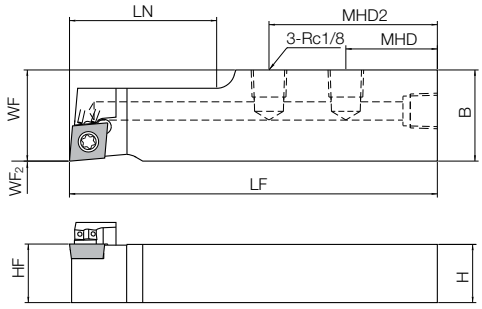
Part Number		Stock R	Stock L	Unit	Dimensions H	HF	B	LF	LH	WF	WF_2	Standard Corner-R (RE)	Spare Parts: Clamp Screw	Wrench
SCLC□	6-2JXFF	●	●	inch	0.375	0.375	0.375	4.750	-	0.375	0	0.008	SB-2570TR	FT-8
	6-3JXFF	●			0.375	0.375	0.375	4.750	0.590	0.375	0	0.008	SB-4085TR	FT-15
	8-3JXFF	●	●		0.500	0.500	0.500	4.750	-	0.500	0			
	10-3JXFF	●	●		0.625	0.625	0.625	4.750	-	0.625	0			
SCLC□	0808F-06FF	●	●	mm	8	8	8	85	-	8	0	0.2	SB-2570TR	FT-8
	1212F-09FF	●	●		12	12	12	85	-	12	0	0.2	SB-4085TR	FT-15
SCLC□	1010JX-06FF	●	●		10	10	10	120	-	10	0	0.2	SB-2570TR	FT-8
	1010JX-09FF	●	●		10	10	10	120	15	10	0	0.2	SB-4085TR	FT-15
	1212JX-09FF	●	●		12	12	12	120	-	12	0			
	1616JX-09FF	●	●		16	16	16	120	-	16	0			
	2020JX-09FF	●	●		20	20	20	120	-	20	0	0.2		

(Customer Service) **800.823.7284 - Option 1**
(Technical Support) **800.823.7284 - Option 2**
Visit us online at **KyoceraPrecisionTools.com**
● : Standard Item △ : Phaseout Item (will be removed from next catalog)
Contact your local Kyocera sales engineer to upgrade old products to new technology

SCLC-FFJCT (Without Offset • External / Copying, Jet Coolant-Through)

SCLC-FFJCT holders are being phased out. Switch to new SCLC-FFJCTM style below.





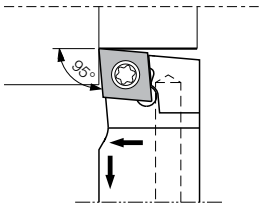
• Right-hand Shown

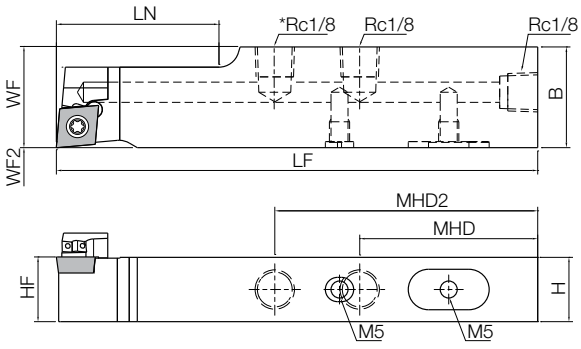
Toolholder Dimensions

Coolant Connections and Pipe Parts ➡ **H14-H15**

Part Number	Stock R	Stock L	Unit	H	HF	B	LF	LN	WF	WF2	MHD	MHD2	Standard Corner-R (RE)	Spare Parts: Clamp Screw	Spare Parts: Wrench	Spare Parts: Plug
SCLCR 62-3FFJCT	△		inch	0.500	0.500	0.750	4.750	1.110	0.750	0	1.378	-	0.008	SB-4085TR	FT-15	GP-1
82.5-3FFJCT	△		inch	0.625	0.625	1.000	4.750	1.582	1.000	0	0.984	1.811	0.008	SB-4085TR	FT-15	GP-1
SCLCR 1220H-09FFJCT	△		mm	12	12	20	100	28	20	0	35	-	0.2	SB-4085TR	FT-15	GP-1
1625H-09FFJCT	△		mm	16	16	25	100	40	25	0	25	46	0.2	SB-4085TR	FT-15	GP-1
2025H-09FFJCT	△		mm	20	20	25	100	40	25	0	25	46	0.2	SB-4085TR	FT-15	GP-1

SCLC-FFJCTM (Without Offset • External / Copying, Direct from Turret Jet Coolant-Through) NEW





*SCLCR5.72··· : 2-Rc1/8
*SCLCR12··· : 2-Rc1/8

• Right-hand Shown

Toolholder Dimensions

Coolant Connections and Pipe Parts ➡ **H18-H19**

Part Number	Stock R	Stock L	Unit	H	HF	B	LF	LN	WF	WF2	MHD	MHD2	Standard Corner-R (RE)	Spare Parts: Clamp Screw	Spare Parts: Wrench	Spare Parts: Plug 1	Spare Parts: Plug 2
SCLCR 5.72-3FFJCTM	●		inch	0.500	0.500	0.708	4.750	1.110	0.708	0	2.150	-	0.008	SB-4085TR	FT-15	GP-1	HS5X4LP
82.5-3FFJCTM	●		inch	0.625	0.625	1.000	4.750	1.585	1.000	0	1.730	2.560	0.008	SB-4085TR	FT-15	GP-1	HS5X4LP
SCLCR 1218JX-09FFJCTM	●		mm	12	12	18	120	28	18	0	54	-	0.2	SB-4085TR	FT-15	GP-1	HS5X4LP
1625JX-09FFJCTM	●		mm	16	16	25	120	40	25	0	44	65	0.2	SB-4085TR	FT-15	GP-1	HS5X4LP
2025JX-09FFJCTM	●		mm	20	20	25	120	40	25	0	44	65	0.2	SB-4085TR	FT-15	GP-1	-

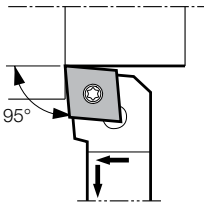
Applicable Inserts

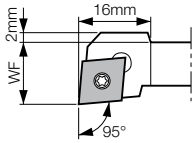
Application	Finishing	Finishing	Finishing-Medium	Low Feed	Stainless Steel	Cast Iron	Non-ferrous Metals	Non-ferrous Metals	Non-ferrous Metals	Hard Material
Ref. Page	B53	B53	B54	B58, B59	B55	B60	B60	B60	C24	C14
Insert / Toolholder	SKS	SK	GK	(E/F)R/L-U	MQ	No Chipbreaker	AH	R/L-A3	PCD	CBN
SCLCR/L..-2JXFF SCLCR/L..-06FF	CCGT215..	CCGT215..	CCMT215..	CCGT215..	-	CCGW215..	-	-	CCMT215.. CCGW215..	CCMW215..
SCLCR/L..-3JXFF SCLCR/L..-3..(JCT) SCLCR/L..-09FF(JCT)	CCGT325..	CCGT325..	CCMT325..	CCGT325..	CCMT325..	CCGW325..	CCGT325..	CCGT325..	CCMT325.. CCGW325..	CCMW325..

Recommended Cutting Conditions ➡ **E55**

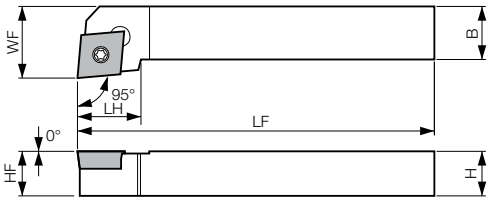
● : Standard Item △ : Phaseout Item (will be removed from next catalog)
Contact your local Kyocera sales engineer to upgrade old products to new technology

SCLC (External / Facing)





SCLC□1010F-09
shown above



• Right-hand Shown

Toolholder Dimensions

Part Number		Stock R	Stock L	Unit	Dimensions H	HF	B	LF	LH	WF	Standard Corner-R (RE)	Spare Parts: Clamp Screw	Spare Parts: Wrench	Spare Parts: Wrench
SCLC□	6-2X	●		inch	0.375	0.375	0.375	3.000	0.354	0.500	0.004	SB-2570TR	FT-8	-
SCLC□	8-3A	●	●		0.500	0.500	0.500	4.000	0.551	0.625				
	10-3C	●			0.625	0.625	0.625	5.000	0.572	0.750	0.004	SB-4085TR	FT-15	-
	12-3C	●	●		0.750	0.750	0.750	5.000	0.572	0.875				
	16-3D	●			1.000	1.000	1.000	6.000	0.790	1.250	0.008	SB-4085TR	FT-15	-
SCLC□	1010F-06	●	●	mm	10	10	10	80	9	12	0.2	SB-2570TR	FT-8	-
	1010F-09	●	●		10	10	10	80	14	14				
	1212H-09	●	●		12	12	12	100	14	16				
	1616H-09	●	●		16	16	16	100	15	20	0.2	SB-4085TR	FT-15	-
	2020K-09	●	●		20	20	20	125	20	25				
	2525M-09	●	●		25	25	25	150	22	32				
SCLC□	1616H-12	●	●		16	16	16	100	20	20				
	2020K-12	●	●		20	20	20	125	22	25	0.4	SB-5090TR	-	LTW-20
	2525M-12	●	●		25	25	25	150	22	32				

Applicable Inserts

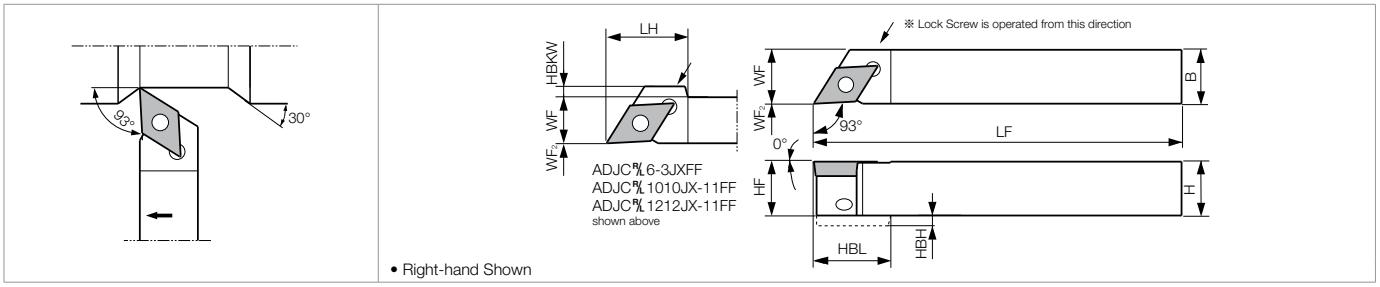
Application	Finishing	Finishing	Finishing-Medium	Low Feed	Stainless Steel	Cast Iron	Non-ferrous Metals	Non-ferrous Metals	Non-ferrous Metals	Hard Material
Ref. Page	B53	B53	B54	B58, B59	B55	B60	B60	B60	C24	C14
Insert / Toolholder	SKS	SK	GK	(E/F)□-U	MQ	No Chipbreaker	AH	□-A3	PCD	CBN
SCLC□..-2.. SCLC□..-06	CCGT215..	CCGT215..	CCMT215..	CCGT215..	-	CCGW215..	-	-	CCMT215.. CCGW215..	CCMW215..
SCLC□..-3.. SCLC□..-09	CCGT325..	CCGT325..	CCMT325..	CCGT325..	CCMT325..	CCGW325..	CCGT325..	CCGT325..	CCMT325.. CCGW325..	CCMW325..
SCLC□..-12	-	-	CCMT43..	-	-	-	-	CCGT43..	-	-

Recommended Cutting Conditions ➡ **E55**

(Customer Service) **800.823.7284 - Option 1**
(Technical Support) **800.823.7284 - Option 2**
Visit us online at **KyoceraPrecisionTools.com**

● : Standard Item △ : Phaseout Item (will be removed from next catalog)
Contact your local Kyocera sales engineer to upgrade old products to new technology

ADJC-FF (Without Offset • External / Copying)



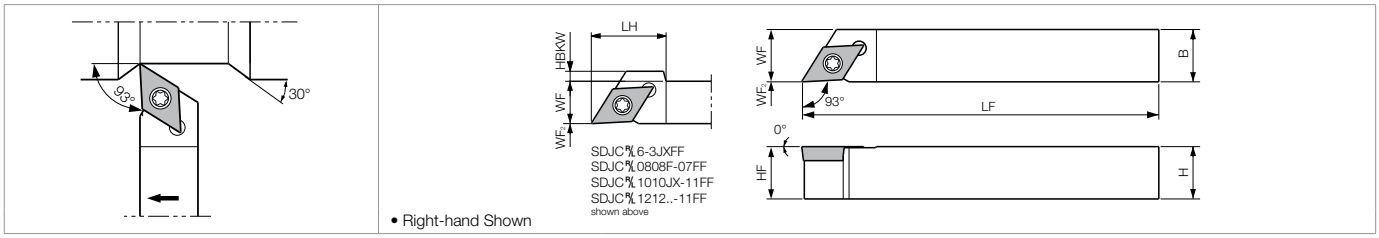
• Right-hand Shown

Toolholder Dimensions

Part Number		Stock R	Stock L	Unit	Dimensions H	HF	HBH	B	LF	LH HBL	WF	HBKW	WF_2	Standard Corner-R (RE)	Spare Parts: Anchor Pin	Lock Screw	Wrench
ADJC□	6-2JXFF	●	●	inch	0.375	0.375	-	0.375	4.750	-	0.375	-	0	0.008	LPF-11	HSB4X8□	FH-2
	6-3JXFF	●	●		0.375	0.375	0.097	0.375	4.750	0.787	0.375	0.137	0	0.008	LPF-13		
	8-3JXFF	●	●		0.500	0.500	-	0.500	4.750	-	0.500	-	0				
	10-3JXFF	●	●		0.625	0.625	-	0.625	4.750	-	0.625	-	0	0.008	LPF-17		
ADJC□	1010JX-07FF	●	●	mm	10	10	-	10	120	-	10	-	0	0.2	LPF-11	HSB4X8□	FH-2
	1010JX-11FF	●	●		10	10	2	10	120	20	10	3	0	0.2	LPF-13		
	1212JX-11FF	●	●		12	12	-	12	120	20	12	1	0				
	1616JX-11FF	●	●		16	16	-	16	120	-	16	-	0	0.2	LPF-17		

• Lock Screw : HSB4X8R for Right-hand Toolholder, HSB4X8L for Left-hand Toolholder

SDJC-FF (Without Offset • External / Copying)



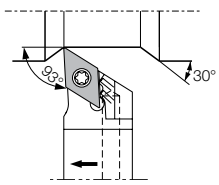
• Right-hand Shown

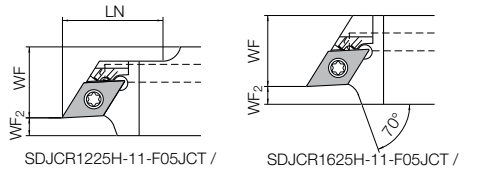
Toolholder Dimensions

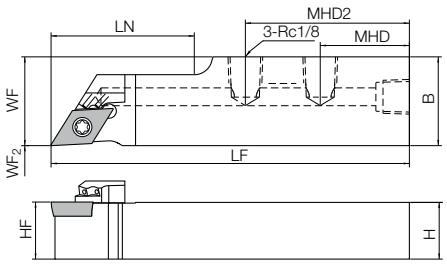
Part Number		Stock R	Stock L	Unit	Dimensions H	HF	B	LF	LH	WF	HBKW	WF_2	Standard Corner-R (RE)	Drawing	Spare Parts: Clamp Screw	Wrench
SDJC□	6-2JXFF	●		inch	0.375	0.375	0.375	4.750	-	0.375	-	0	0.008	Fig.1	SB-2570TR	FT-8
	6-3JXFF	●			0.375	0.375	0.375	4.750	0.787	0.375	0.137				SB-4085TR	FT-15
	8-3JXFF	●	●		0.500	0.500	0.500	4.750	-	0.500	-					
	10-3JXFF	●			0.625	0.625	0.625	4.750	-	0.625	-					
SDJC□	0808F-07FF	●	●	mm	8	8	8	85	14	8	0.5	0	0.2	Fig.1	SB-2570TR	FT-8
	1212F-11FF	●	●		12	12	12	85	20	12	1.0				SB-4085TR	FT-15
SDJC□	1010JX-07FF	●	●		10	10	10	120	-	10	-	0	0.2	Fig.1	SB-2570TR	FT-8
	1010JX-11FF	●	●		10	10	10	120	20	10	3.0				SB-4085TR	FT-15
	1212JX-11FF	●	●		12	12	12	120	20	12	1.0					
	1616JX-11FF	●	●		16	16	16	120	-	16	-					
	2020JX-11FF	●	●		20	20	20	120	-	20	-					

SDJC-JCT (Without Offset • External / Copying, Jet Coolant-Through)

**SDJC-JCT holders are being phased out.
Switch to new SDJC-JCTM style below.**







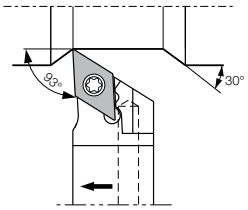
• Right-hand Shown

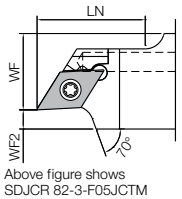
Toolholder Dimensions

Coolant Connections and Pipe Parts ➡ **H14-H15**

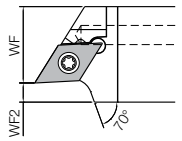
Part Number	Stock R	Stock L	Unit	H	HF	B	LF	LN	WF	WF_2	MHD	MHD2	Standard Corner-R (RE)	Spare Parts: Clamp Screw	Spare Parts: Wrench	Spare Parts: Plug
SDJCR 62-3FFJCT	△		in	0.500	0.500	0.750	4.750	1.110	0.750	0	1.378	-	0.008	SB-4085TR	FT-15	GP-1
82.5-3FFJCT	△			0.625	0.625	1.000	4.750	1.582	1.000		0.984	1.811				
SDJCR 1220H-11FFJCT	△		mm	12	12	20	100	28	20	0	35	-	0.2	SB-4085TR	FT-15	GP-1
1625H-11FFJCT	△			16	16	25		40	25		25	46				
2025H-11FFJCT	△			20	20	25		40	25		25	46				
SDJCR 1225H-11-F05JCT	△			12	12	25	100	28	20	5	35	-	0.2			
1235H-11-F15JCT	△			12	12	35		28	20	15	35	-				
SDJCR 1625H-11-F05JCT	△			16	16	25	100	-	20	5	25	46	0.2			
1635H-11-F15JCT	△			16	16	35		-	20	15	25	46				

SDJC-JCTM (Without Offset • External / Copying, Direct from Turret Jet Coolant-Through) NEW

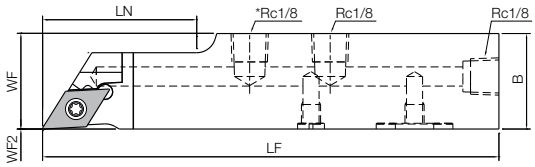


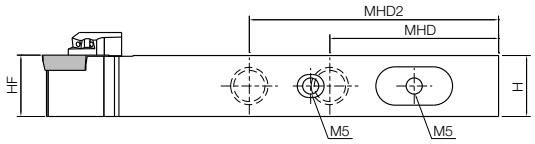


Above figure shows
SDJCR 82-3-F05JCTM
SDJCR 112-3-F15JCTM
SDJCR 1225 JX 11 F05JCTM
SDJCR 1235 JX 11 F15JCTM



Above figure shows
SDJCR 82.5-3-F05JCTM
SDJCR 112.5-3-F15JCTM
SDJCR 1625 JX 11 F05JCTM
SDJCR 1635 JX 11 F 15 JCTM





*SDJCR5.72-3FFJCTM : 2-Rc1/8
*SDJCR82-3-F05JCTM : 2-Rc1/8
*SDJCR112-3-F15JCTM : 2-Rc1/8
*SDJCR12··· : 2-Rc1/8

• Right-hand Shown

Toolholder Dimensions

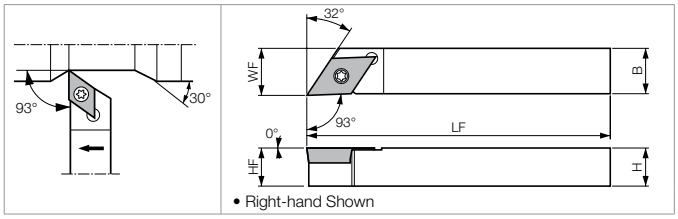
Coolant Connections and Pipe Parts ➡ **H18-H19**

Part Number	Stock R	Stock L	Unit	H	HF	B	LF	LN	WF	WF_2	MHD	MHD2	Standard Corner-R (RE)	Spare Parts: Clamp Screw	Spare Parts: Wrench	Spare Parts: Plug 1	Spare Parts: Plug 2
SDJCR 5.72-3FFJCTM	●		in	0.500	0.500	0.708	4.750	1.110	0.708	0	2.150	-	0.008	SB-4085TR	FT-15	GP-1	HS5X4LP
82.5-3FFJCTM	●			0.625	0.625	1.000		1.585	1.000		1.730	2.560					
SDJCR 82-3-F05JCTM	●			0.500	0.500	1.000	4.750	1.585	1.000	0.197	1.730	2.560	0.008	SB-4085TR	FT-15	GP-1	HS5X4LP
112-3-F15JCTM	●					1.375		1.110	1.375	0.591	2.150	-					
82.5-3-F05JCTM	●			0.625	0.625	1.000		1.585	1.000	0.197	1.730	2.560					
112.5-3-F15JCTM	●					1.375		1.110	1.375	0.591	2.150	-					
SDJCR 1218JX-11FFJCTM	●		mm	12	12	18	120	28	18	0	54	-	0.2	SB-4085TR	FT-15	GP-1	HS5X4LP
1625JX-11FFJCTM	●			16	16	25		40	25		44	65					
2025JX-11FFJCTM	●			20	20												-
SDJCR 1225JX11F05JCTM	●			12	12	25	120	28	20	5	54	-	0.2				HS5X4LP
1235JX11F15JCTM	●					35				15							
SDJCR 1625JX11F05JCTM	●			16	16	25	120	-	20	5	44	65	0.2				
1635JX11F15JCTM	●					35				15							

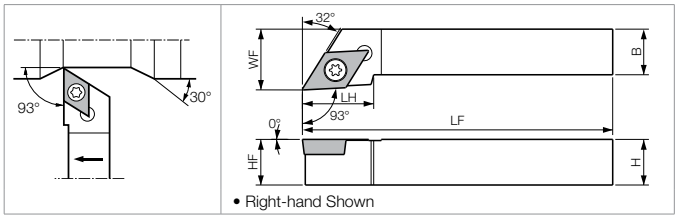
(Customer Service) **800.823.7284 - Option 1**
(Technical Support) **800.823.7284 - Option 2**
Visit us online at **KyoceraPrecisionTools.com**

● : Standard Item △ : Phaseout Item (will be removed from next catalog)
Contact your local Kyocera sales engineer to upgrade old products to new technology

SDJC-F (External / Copying)



SDJC (External / Copying)



Toolholder Dimensions

Part Number		Stock R	Stock L	Unit	Dimensions H	HF	B	LF	LH	WF	HBKW	WF_2	Standard Corner-R (RE)	Spare Parts: Clamp Screw	Spare Parts: Wrench
SDJC□	6-2CF	●		inch	0.375	0.375	0.375	5.000	-	0.395	-	-	0.004	SB-2570TR	FT-8
SDJC□	8-3DF	●			0.500	0.500	0.500	6.000		0.520	-	-	1/32	SB-4085TR	FT-15
SDJC□	6-2X	●			0.375	0.375	0.375	3.000	0.472	0.500	-	-	0.004	SB-2570TR	FT-8
SDJC□	8-3A	●	●		0.500	0.500	0.500	4.000	0.709	0.625	-	-		SB-4085TR	FT-15
	10-3C	●	●		0.625	0.625	0.625	5.000	0.709	0.750					
	12-3C	●	●		0.750	0.750	0.750			0.875					
	16-3D	●			1.000	1.000	1.000	6.000	0.810	1.250			0.008		
SDJC□	1010F-07	●	●	mm	10	10	10	80	12	12	-	-	0.2	SB-2570TR	FT-8
SDJC□	1010F-11	●	●		10	10	10	80	18	12	-	-	0.2	SB-4085TR	FT-15
	1212H-11	●	●		12	12	12	100	18	16	-	-			
	1616H-11	●	●		16	16	16	100	18	20	-	-			
	2020K-11	●	●		20	20	20	125	18	25	-	-			
	2525M-11	●	●		25	25	25	150	23	32	-	-			

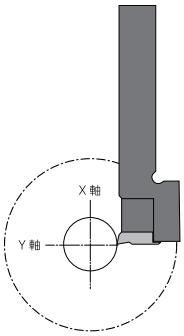
Applicable Inserts

Application	Minute D.O.C.	Finishing	Finishing	Finishing	Finishing	Finishing-Medium	Finishing-Medium	Finishing	Finishing / Precision	Low Feed
Ref. Page	B62	B62	B62	B63	B63	B64	B63	B67	B66	B68, B69
Insert / Toolholder	**CF**	**SKS**	**SK**	**WP** (Wiper)	**PP**	**GK**	**GQ**	**□-F**	**□-FSF**	**(E/F) □-U**
□DJC□..-2.. □DJC□..-07...	DCGT215..	DCGT215..	DCGT215..	DCMX215..	DCMT215..	DCMT215..	DCGT215..	DCGT215..	DCET215..	DCGT215..
□DJC□..-3... □DJC□..-11... SDJCR..-11...JCT(M)	DCGT325..	DCGT325..	DCGT325..	DCMX325..	DCMT325..	DCMT325..	DCGT325..	DCGT325..	DCET325..	DCGT325..
Application	Low Feed / Precision	Low Feed	Low Carbon Steel / Finishing	Low Carbon Steel / Finishing-Medium	Stainless Steel	Cast Iron	Non-ferrous Metals	Non-ferrous Metals	Non-ferrous Metals	Hard materials
Ref. Page	B68	B70, B71	B65	B65	B65	B71	B71	B71	C25	C15
Insert / Toolholder	**F□-USF**	**(E/F) □-J**	**XP**	**XQ**	**MQ**	**No Chipbreaker**	**AH**	**□-A3**	**PCD**	**CBN**
□DJC□..-2.. □DJC□..-07...	DCET215..	DCET215..	DCMT215..	-	DCMT215..	DCGW215..	-	-	DCMT215..	DCMW215..
□DJC□..-3... □DJC□..-11... SDJCR..-11...JCT(M)	DCET325..	DC_T325..	DCMT325..	DCMT325..	DCMT325..	DCGW325..	DCGT325..	DCGT325..	DCMT325..	DCMW325..

When using **WP** chipbreaker, program corrections are required. → **R51**

Recommended Cutting Conditions → **E55**

SDJC-FF-Y (Y-axis External / Copying)



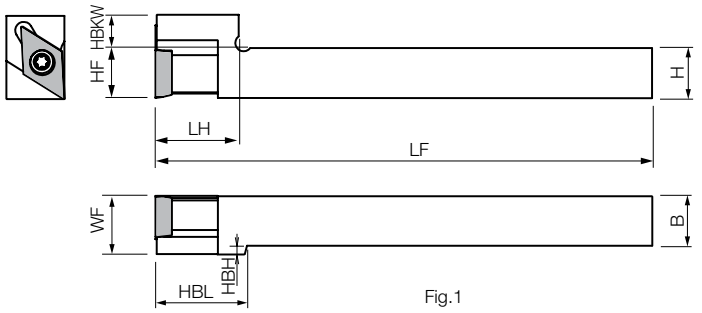


Fig.1

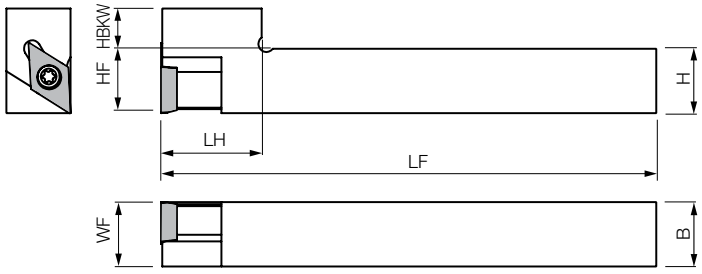


Fig.2

• Right-hand Shown

Toolholder Dimensions

Part Number	Stock R	Stock L	Unit	H	HF	B	LF	LH	WF	HBKW	HBL	HBH	WF_2	Standard Corner-R (RE)	Drawing	Spare Parts: Clamp Screw	Spare Parts: Wrench
SDJCR 1212JX-11FF-Y	●		mm	12	12	12	120	20	14	8	22	2	0	0.2	Fig.1	SB-4085TR	FT-15
1616JX-11FF-Y	●		mm	16	16	16	120	25	16	10	-	-	0	0.2	Fig.2	SB-4085TR	FT-15

Applicable Inserts

Application	Minute D.O.C.	Finishing	Finishing	Finishing	Finishing	Finishing	Finishing-Medium	Finishing-Medium	Finishing	Finishing / Precision	Low Feed	Low Feed / Precision
Ref. Page	B62	B62	B62	B62	B63	B63	B64	B63	B67	B66	B68, B69	B68
Insert / Toolholder	**CF**	**GF**	**SKS**	**SK**	**WP** (Wiper)	**PP**	**GK**	**GQ**	**R-F**	**R-FSF**	**(E/F) R-U**	**FR-USF**
SDJCR..-11FF-Y	DCGT325..	DCGT325..	DCGT325..	DCGT325..	DCMX325..	DCMT325..	DCMT325..	DCGT325..	DCGT325..	DCET325..	DCGT325..	DCET325..

Application	Low Feed	Low Feed / Precision	Low Carbon Steel / Finishing	Low Carbon Steel / Finishing-Medium	Stainless Steel	Cast Iron	Non-ferrous Metals	Non-ferrous Metals	Non-ferrous Metals	Non-ferrous Metals	Hard Materials	
Ref. Page	B70, B71	B70	B65	B65	B65	B71	B71	B71	C25	C25	C15	
Insert / Toolholder	**(E/F)R-J**	**FR-JSF**	**XP**	**XQ**	**MQ**	No Chipbreaker	**AH**	**R-A3**	**PCD**	**APD**	**CBN**	
SDJCR..-11FF-Y	DC_T325..	DCET325..	DCMT325..	DCMT325..	DCMT325..	DCGW325..	DCGT325..	DCGT325..	DCMT325..	DCMT325..	DCMW325..	

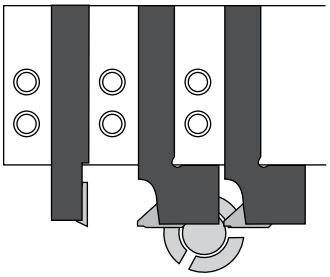
When using **WP** chipbreaker, program corrections are required. R51

Recommended Cutting Conditions **E55**

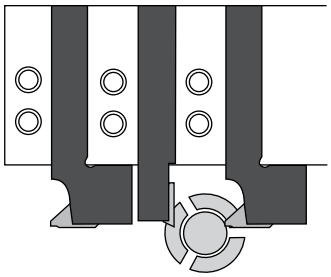
Precautions

Do not use Y-axis toolholders side-by-side to prevent interference (Only two Y-axis holders can be used at the same time)

Interference

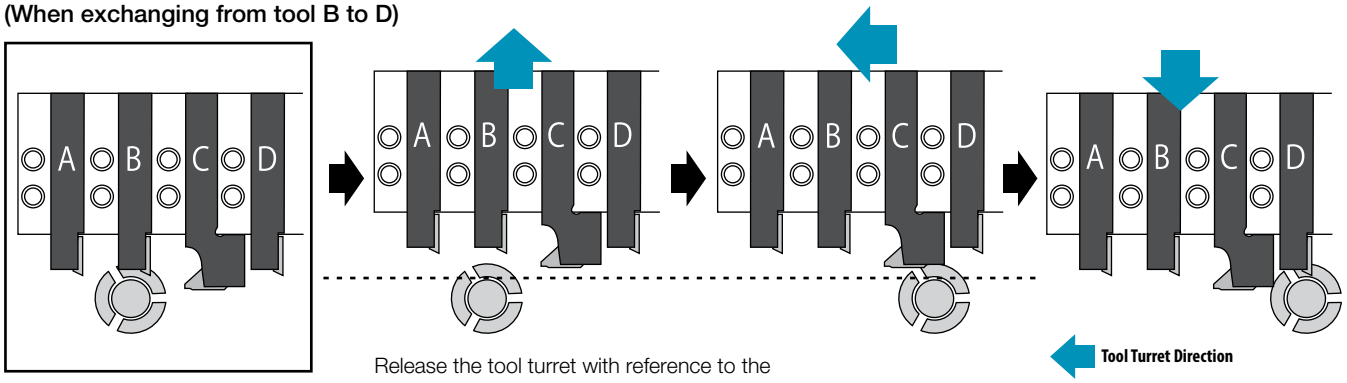


Without Interference



Standard toolholders may be mounted between two Y-axis toolholders

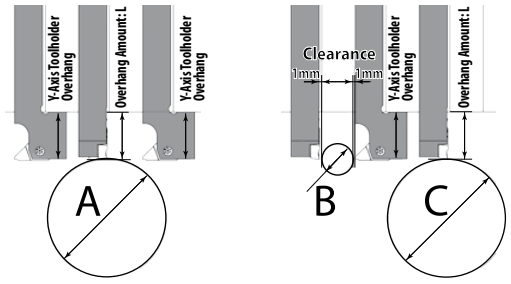
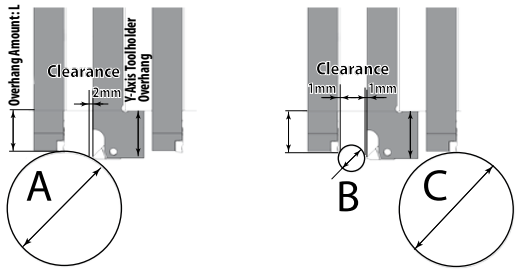
When changing the tool, set the retracted position with reference to the cutting edge of the Y-axis holder (When exchanging from tool B to D)



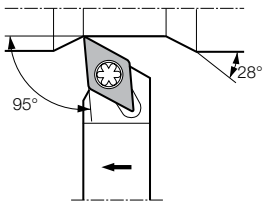
Release the tool turret with reference to the overhang amount of the Y-axis toolholder

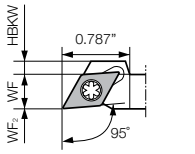
Note that using other toolholder styles together will result in different outside diameters

(Unit: mm)

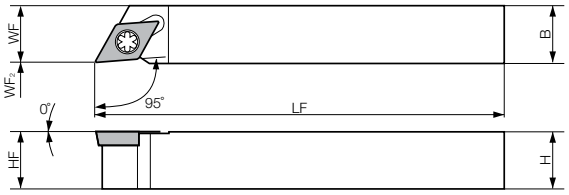
Y-axis Toolholder Overhang	Examples	Overhang Amount : L / Available Outside Cutting Dia. (Ø)	20	22	25
20		A	Without Restriction	Without Restriction	Without Restriction
		B	13.0	13.0	13.0
		C	Without Restriction	Without Restriction	Without Restriction
25		A	38.0	58.0	Without Restriction
		B	14.9	13.6	13.0
		C	45.0	60.0	Without Restriction

SDLC-FF (Without Offset • External / Copying)





SDLC□6-3JXFF
SDLC□8-3JXFF
SDLC□1010..-11FF
SDLC□1212..-11FF
shown above

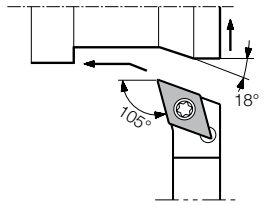


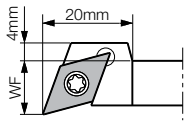
• Right-hand Shown

Toolholder Dimensions

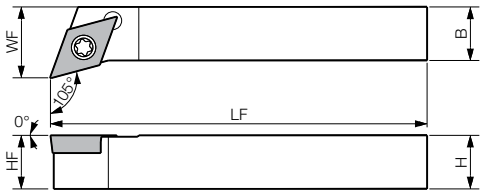
Part Number		Stock R	Stock L	Unit	Dimensions H	HF	B	LF	WF	HBKW	WF_2	Standard Corner-R (RE)	Spare Parts: Clamp Screw	Spare Parts: Wrench
SDLC□	8-3JXFF	●		inch	0.500	0.500	0.500	4.750	0.500	0.051	0	0.008	SB-4085TR	FT-15
	10-3JXFF	●			0.625	0.625	0.625	4.750	0.625	-	0			
SDLC□	1010JX-07FF	●	●	mm	10	10	10	120	10	-	0	0.2	SB-2570TR	FT-8
	1212JX-07FF	●	●		12	12	12	120	12	-	0			
	1616JX-07FF	●	●		16	16	16	120	16	-	0			
SDLC□	1010JX-11FF	●	●		10	10	10	120	10	4	0	0.2	SB-4085TR	FT-15
	1212JX-11FF	●	●		12	12	12	120	12	2	0			
	1616JX-11FF	●	●		16	16	16	120	16	-	0			
SDLC□	1212F-07FF	●			12	12	12	85	12	-	0	0.2	SB-2570TR	FT-8
SDLC□	1010F-11FF	●			10	10	10	80	10	4	0	0.2	SB-4085TR	FT-15
	1212F-11FF	●			12	12	12	85	12	2	0			
	1616H-11FF	●			16	16	16	100	16	-	0			

SDXC (External / Facing / Copying)





SDXC□1010JX-11
shown above



• Right-hand Shown

Toolholder Dimensions

Part Number		Stock R	Stock L	Dimensions (mm) H	HF	B	LF	WF	Standard Corner-R (RE)	Spare Parts: Clamp Screw	Spare Parts: Wrench
SDXC□	1010JX-07	●	●	10	10	10	120	12	0.2	SB-2570TR	FT-8
	1010JX-11	●	●	10	10	10	120	12	0.2	SB-4085TR	FT-15
	1212JX-11	●	●	12	12	12	120	16	0.2		
	1616JX-11	●	●	16	16	16	120	20	0.2		

Applicable Inserts

Application	Minute D.O.C.	Finishing	Finishing	Finishing	Finishing	Finishing	Finishing-Medium	Finishing-Medium	Finishing	Finishing / Precision	Low Feed	Low Feed / Precision
Ref. Page	B62	B62	B62	B62	-	B63	B64	B63	B67	B66	B68, B69	B68
Insert / Toolholder	CF	GF	SKS	SK	WP (Wiper)	PP	GK	GQ	R-F	R-FSF	(E/F) R-U	FR-USF
SDLC□..-07... SDXC□..-07	DCGT215..	DCGT215..	DCGT215..	DCGT215..	-	DCMT215..	DCMT215..	DCGT215..	DCGT215..	DCET215..	DCGT215..	DCET215..
SDLC□..-3... / -11... SDXC□..-11	DCGT325..	DCGT325..	DCGT325..	DCGT325..	-	DCMT325..	DCMT325..	DCGT325..	DCGT325..	DCET325..	DCGT325..	DCET325..

Application	Low Feed	Low Feed / Precision	Low Carbon Steel / Finishing	Low Carbon Steel / Finishing-Medium	Stainless Steel	Cast Iron	Non-ferrous Metals	Non-ferrous Metals	Non-ferrous Metals	Non-ferrous Metals	Hard Materials	
Ref. Page	B70, B71	B70	B65	B65	B65	B71	B71	B71	C25	C25	C15	
Insert / Toolholder	(E/F)R-J	FR-JSF	XP	XQ	MQ	No Chipbreaker	AH	R-A3	PCD	APD	CBN	
SDLC□..-07... SDXC□..-07	DCET215..	DCET215..	DCMT215..	-	DCMT215..	DCGW215..	-	-	DCMT215..	DCMT215..	DCMW215..	
SDLC□..-3... / -11... SDXC□..-11	DC_T325..	DCET325..	DCMT325..	DCMT325..	DCMT325..	DCGW325..	DCGT325..	DCGT325..	DCMT325..	DCMT325..	DCMW325..	

Recommended Cutting Conditions ➡ E55

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● : Standard Item △ : Phaseout Item (will be removed from next catalog)
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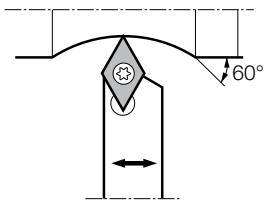
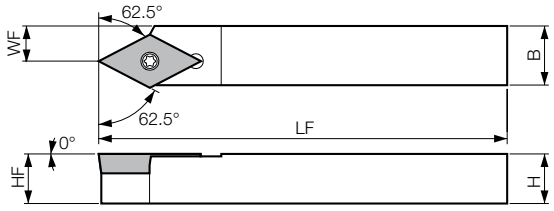
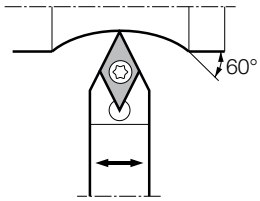
SDNC-F (External / Copying)

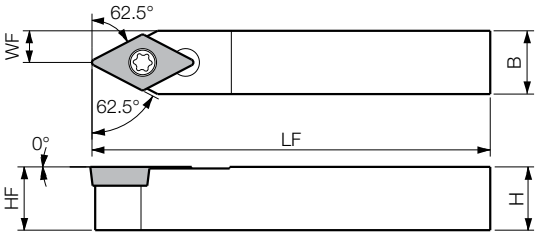




• Right-hand Shown

SDNC (External / Copying)





Toolholder Dimensions

Part Number		Stock			Unit	Dimensions					Standard Corner-R (RE)	Spare Parts	
		R	N	L		H	HF	B	LF	WF		Clamp Screw	Wrench
SDNC□L	1010JX-07F	●		●	mm	10	10	10	120	7	0.2	SB-2570TR	FT-8
SDNCN	6-2JX		●		inch	0.375	0.375	0.375	4.750	0.187	0.008	SB-2570TR	FT-8
	8-2JX		●			0.500	0.500	0.500	4.750	0.250			
	6-3JX		●			0.375	0.375	0.375	4.750	0.187	0.008	SB-4085TR	FT-15
	8-3JX		●			0.500	0.500	0.500	4.750	0.250			
	10-3JX		●			0.625	0.625	0.625	4.750	0.312			
SDNCN	1010JX-07		●		mm	10	10	10	120	5	0.2	SB-2570TR	FT-8
	1212JX-07		●			12	12	12	120	6			
SDNCN	1010JX-11		●			10	10	10	120	5	0.2	SB-4085TR	FT-15
	1212JX-11		●			12	12	12	120	6			
	1616JX-11		●			16	16	16	120	8			
SDNCN	1010F-11		●			10	10	10	80	5	0.2	SB-4085TR	FT-15
	1616H-11		●			16	16	16	100	8			

Applicable Inserts

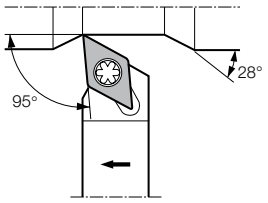
Application	Minute D.O.C.	Finishing	Finishing	Finishing	Finishing	Finishing	Finishing-Medium	Finishing-Medium	Finishing	Finishing / Precision	Low Feed	Low Feed / Precision
Ref. Page	B62	B62	B62	B62	-	B63	B64	B63	B67	B66	B68, B69	B68
Insert / Toolholder	CF	GF	SKS	SK	WP (Wiper)	PP	GK	GQ	R-F	R-FSF	(E/F) R-U	FR-USF
SDNC□...-07 SDNCN...-2JX SDNCN...-07	DCGT215..	DCGT215..	DCGT215..	DCGT215..	-	DCMT215..	DCMT215..	DCGT215..	DCGT215..	DCET215..	DCGT215..	DCET215..
SDNCN...-3 SDNCN...-11	DCGT325..	DCGT325..	DCGT325..	DCGT325..	-	DCMT325..	DCMT325..	DCGT325..	DCGT325..	DCET325..	DCGT325..	DCET325..

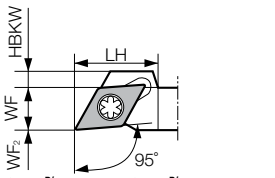
Application	Low Feed	Low Feed / Precision	Low Carbon Steel / Finishing	Low Carbon Steel / Finishing-Medium	Stainless Steel	Cast Iron	Non-ferrous Metals	Non-ferrous Metals	Non-ferrous Metals	Non-ferrous Metals	Hard Materials	
Ref. Page	B70, B71	B70	B65	B65	B65	B71	B71	B71	C25	C25	C15	
Insert / Toolholder	(E/F)R-J	FR-JSF	XP	XQ	MQ	No Chipbreaker	AH	R-A3	PCD	APD	CBN	
SDNC□...-07 SDNCN...-2JX SDNCN...-07	DCET215..	DCET215..	DCMT215..	-	DCMT215..	DCGW215..	-	-	DCMT215..	DCMT215..	DCMW215..	
SDNCN...-3 SDNCN...-11	DC_T325..	DCET325..	DCMT325..	DCMT325..	DCMT325..	DCGW325..	DCGT325..	DCGT325..	DCMT325..	DCMT325..	DCMW325..	

Recommended Cutting Conditions ➡ **E55**

● : Standard Item △ : Phaseout Item (will be removed from next catalog)
Contact your local Kyocera sales engineer to upgrade old products to new technology

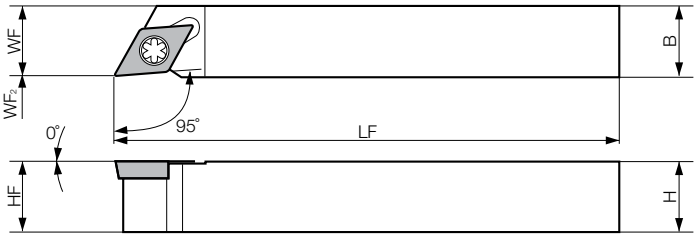
SDLP-FF (Without Offset • External / Copying)





SDLP□6-3JXFF
SDLP□8-3JXFF
shown above

SDLP□0808F-07FF
SDLP□1212F-11FF
SDLP□1010JX-11FF
SDLP□1212JX-11FF
shown above



• Right-hand Shown

Toolholder Dimensions

Part Number	Stock R	Stock L	Unit	Dimensions H	HF	B	LF	LH	WF	HBKW	WF_2	Standard Corner-R(RE)	Spare Parts: Clamp Screw	Spare Parts: Wrench
SDLP□ 0808F-07FF	●	●	mm	8	8	8	85	14	8	0.5	0	0.2	SB-2570TR	FT-8
SDLP□ 1010JX-07FF	●	●		10	10	10	120	-	10	-	0	0.2	SB-2570TR	FT-8
1010JX-11FF	●	●		10	10	10	120	20	10	4.0	0	0.2	SB-4085TR	FT-15
1212JX-11FF	●	●		12	12	12	120	20	12	2.0	0			
1616JX-11FF	●	●		16	16	16	120	-	16	-	0			

Applicable Inserts

Application	Finishing / Precision	Low Feed / Precision
Ref. Page	B72	B72
Insert / Toolholder	□-FSF	F□-USF
SDLP□..-07FF	DPET215..	DPET215..
SDLP□..-11FF	DPET325..	DPET325..

Recommended Cutting Conditions **E55**

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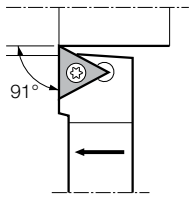
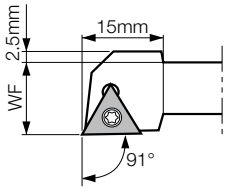
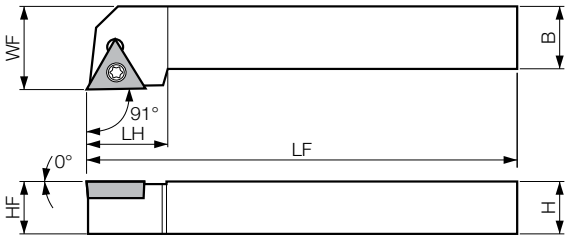
Contact your local Kyocera sales engineer to upgrade old products to new technology

STGC(P) (External)





STGC(P)□1010F-11
shown above



• Right-hand Shown

Toolholder Dimensions

Part Number		Stock R	Stock L	Unit	Dimensions H	HF	B	LF	LH	WF	Standard Corner-R(RE)	Spare Parts: Clamp Screw	Spare Parts: Wrench
STGC□	0808E-08	●		mm	8	8	8	70	12	10	0.2	SB-2050TR	FT-6
	1010F-08	●	●		10	10	10	80	12	12			
STGC□	1010F-11	●	●		10	10	10	80	15	14	0.4	SB-2570TR	FT-8
	1212H-11	●	●		12	12	12	100	15	16			
	1616H-11	●	●		16	16	16	100	15	20			
	2020K-11	●	●		20	20	20	125	15	25			
	2525M-11	●	●		25	25	25	150	20	32			
STGP□	0808E-08	●			8	8	8	70	12	10	0.2	SB-2050TR	FT-6
STGP□	1010F-11	●	●		10	10	10	80	15	14	0.2	SB-3080TR	FT-10
	1212H-11	●	●		12	12	12	100	15	16			
	1616H-11	●	●		16	16	16	100	15	20			

Applicable Inserts (STGC)

Application	Low Feed	Low Feed / Precision	Cast Iron	Non-ferrous Metals	Non-ferrous Metals
Ref. Page	B78	B77	B79	B79	C26
Insert / Toolholder	(E/F) □-U	F□-USF	Without Chipbreaker □-A3	□-A3	PCD
STGC□..-08	TCGT1515..	TCET1515..	TCGW1515..	-	TCMT1515..
STGC□..-11	TCGT22..	TCET22..	TCGW22..	TCGT22..	TCMT22.. TCGW22..

Applicable Inserts (STGP)

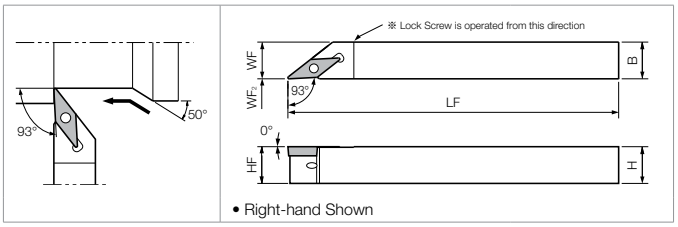
Application	Minute D.O.C.	Finishing	Finishing-Medium	Finishing	Finishing / Precision	Low Feed / Precision	Medium	Low Carbon Steel / Finishing	Low Carbon Steel / Finishing-Medium	Cast Iron
Ref. Page	B80	B80	B81	B82, B83	B85	B86	B84	B81	B81	B86
Insert / Toolholder	CF	PP	HQ	□	□-FSF	F□-USF	□-H	XP	XQ	No Chipbreaker
STGP□..-08	TPGT1515..	-	-	TPGH1515..	TPET1515..	TPET1515..	-	-	-	TPGB1515..
STGP□..-11	-	TPMT22..	TPMT22..	TPGH22..	TPET22..	TPET22..	TPGH22..	TPMT22..	TPMT22..	TPGB22..

Application	Non-ferrous Metals	Non-ferrous Metals	Hard Materials
Ref. Page	C26 ~ C28	C27	C16
Insert / Toolholder	PCD	APD	CBN
STGP□..-08	TPMH1515.. TPGB1515..	-	TPGB1515..
STGP□..-11	TPMH22.. TPGB22..	TPMT22..	TPGB22..

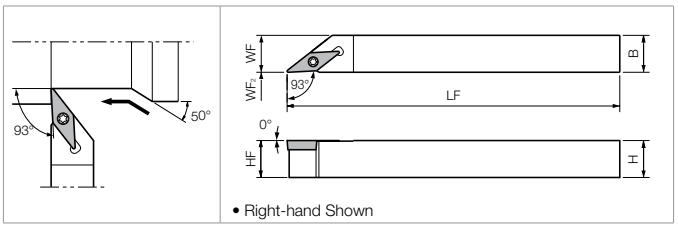
Recommended Cutting Conditions ➡ E55

● : Standard Item △ : Phaseout Item (will be removed from next catalog)
Contact your local Kyocera sales engineer to upgrade old products to new technology

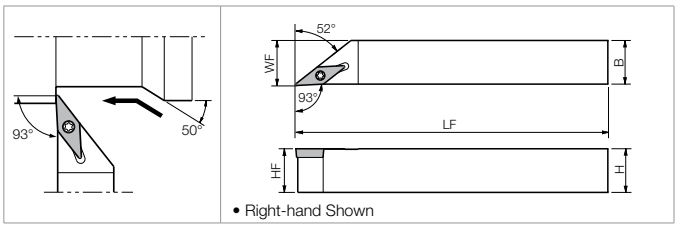
AVJB-FF (Without Offset • External / Copying)



SVJB-FF (Without Offset • External / Copying)



SVJB-F (External / Copying)



Toolholder Dimensions

Part Number		Stock R	Stock L	Unit	Dimensions H	HF	B	LF	WF	WF_2	Standard Corner-R (RE)	Spare Parts: Anchor Pin	Lock Screw	Clamp Screw	Wrench
AVJB[R/L]	6-2JXFF	●	●	inch	0.375	0.375	0.375	4.750	0.375	0	1/64	LPF-11	HSB4X8[R/L]	-	FH-2
	8-2JXFF	●	●		0.500	0.500	0.500	4.750	0.500			LPF-1113			
	10-2JXFF	●	●		0.625	0.625	0.625	4.750	0.625			LPF-1117			
AVJB[R/L]	1010JX-11FF	●	●	mm	10	10	10	120	10	0	0.4	LPF-11	HSB4X8[R/L]	-	FH-2
	1212JX-11FF	●	●		12	12	12	120	12			LPF-1113			
	1616JX-11FF	●	●		16	16	16	120	16			LPF-1117			
SVJB[R/L]	6-2JXFF	●	●	inch	0.375	0.375	0.375	4.750	0.375	0	1/64	-	-	SB-2570TR	FT-8
	8-2JXFF	●	●		0.500	0.500	0.500	4.750	0.500						
	10-2JXFF	●			0.625	0.625	0.625	4.750	0.625						
SVJB[R/L]	1010JX-11FF	●	●	mm	10	10	10	120	10	0	0.4	-	-	SB-2570TR	FT-8
	1212JX-11FF	●	●		12	12	12	120	12						
	1616JX-11FF	●	●		16	16	16	120	16						
	2020JX-11FF	●	●		20	20	20	120	20						
SVJB[R/L]	6-2CF	●	●	inch	0.375	0.375	0.375	5.000	0.395	-	1/64	-	-	SB-2570TR	FT-8
	8-2DF	●	●		0.500	0.500	0.500	6.000	0.520						

• Lock Screw : HSB4X8R for Right-hand Toolholder, HSB4X8L for Left-hand Toolholder

Applicable Inserts

Application	Finishing	Finishing	Finishing-Medium	Finishing	Finishing / Precision	Finishing-Medium	Non-ferrous Metals	Hard Materials
Ref. Page	B89	B89	B89	B90	B89	B91	C28	C17
Insert / Toolholder	GP	VF	HQ	[R/L]-F	[R/L]-FSF	[R/L]-Y	PCD	CBN
AVJB[R/L]..-2... AVJB[R/L]..-11FF SVJB[R/L]..-2... SVJB[R/L]..-11FF	VBMT22..	VBMT22..	VBMT22..	VBGT22..	VBET22..	VBGT22..	VBMT22..	VBGW22..

Recommended Cutting Conditions ➡ **E55**

(Customer Service) **800.823.7284 - Option 1**
(Technical Support) **800.823.7284 - Option 2**
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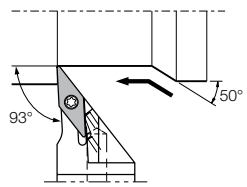
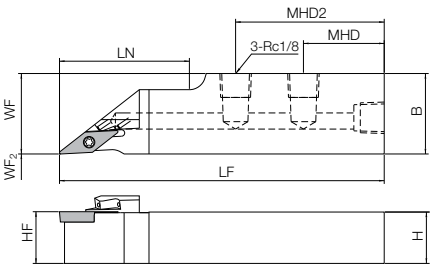
● : Standard Item △ : Phaseout Item (will be removed from next catalog)
Contact your local Kyocera sales engineer to upgrade old products to new technology

SVJB-FFJCT (Without Offset • External / Copying, Jet Coolant-Through)

SVJB-JCT holders are being phased out. Switch to new SVJB-JCTM style below.





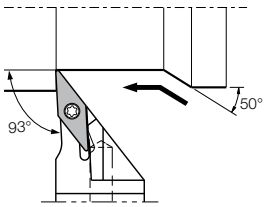
• Right-hand Shown

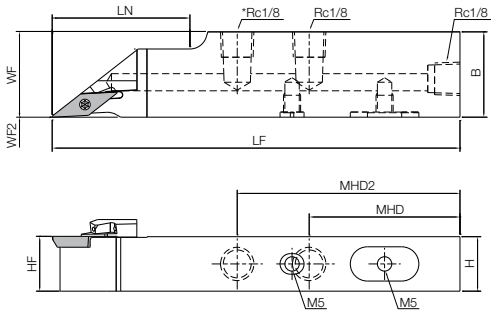
Toolholder Dimensions

Coolant Connections and Pipe Parts ➡ **H14-H15**

Part Number	Stock R	Stock L	Unit	H	HF	B	LF	LN	WF	WF2	MHD	MHD2	Standard Corner-R (RE)	Spare Parts: Clamp Screw	Spare Parts: Wrench	Spare Parts: Plug
SVJBR 62-2FFJCT	△		inch	0.500	0.500	0.750	4.750	1.110	0.750	0	1.378	-	1/64	SB-2570TR	FT-8	GP-1
82.5-2FFJCT	△		inch	0.625	0.625	1.000	4.750	1.110	1.000	0	0.984	1.811	1/64	SB-2570TR	FT-8	GP-1
SVJBR 1220H-11FFJCT	△		mm	12	12	20	100	28	20	0	35	-	0.4	SB-2570TR	FT-8	GP-1
1625H-11FFJCT	△		mm	16	16	25	100	40	25	0	25	46	0.4	SB-2570TR	FT-8	GP-1
2025H-11FFJCT	△		mm	20	20	25	100	40	25	0	25	46	0.4	SB-2570TR	FT-8	GP-1

SVJB-FFJCTM (Without Offset • External / Copying, Direct from Turret Jet Coolant-Through) NEW





*SVJBR5.72··· : 2-Rc1/8
*SVJBR12··· : 2-Rc1/8
(Coolant outlet : Single)

• Right-hand Shown

Toolholder Dimensions

Coolant Connections and Pipe Parts ➡ **H18-H19**

Part Number	Stock R	Stock L	Unit	H	HF	B	LF	LN	WF	WF2	MHD	MHD2	Standard Corner-R (RE)	Spare Parts: Clamp Screw	Spare Parts: Wrench	Spare Parts: Plug 1	Spare Parts: Plug 2
SVJBR 5.72-2FFJCTM	●		inch	0.500	0.500	0.708	4.750	1.110	0.708	0	2.150	-	0.016	SB-2570TR	FT-8	GP-1	HS5X4LP
82.5-2FFJCTM	●		inch	0.625	0.625	1.000	4.750	1.585	1.000	0	1.730	2.560	0.016	SB-2570TR	FT-8	GP-1	HS5X4LP
SVJBR 1218JX-11FFJCTM	●		mm	12	12	18	120	28	18	0	54	-	0.4	SB-2570TR	FT-8	GP-1	HS5X4LP
1625JX-11FFJCTM	●		mm	16	16	25	120	40	25	0	44	65	0.4	SB-2570TR	FT-8	GP-1	HS5X4LP
2025JX-11FFJCTM	●		mm	20	20	25	120	40	25	0	44	65	0.4	SB-2570TR	FT-8	GP-1	-

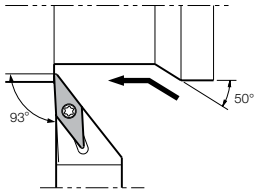
Applicable Inserts

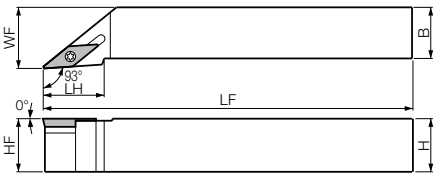
Application	Finishing	Finishing	Finishing-Medium	Finishing	Finishing / Precision	Finishing-Medium	Non-ferrous Metals	Hard Materials
Ref. Page	➡ B89	➡ B89	➡ B89	➡ B90	➡ B89	➡ B91	➡ C28	➡ C17
Insert / Toolholder	GP	VF	HQ	R/L-F	R/L-FSF	R/L-Y	PCD	CBN
SVJBR..-2FFJCT(M) SVJBR..-11FFJCT(M)	VBMT22..	VBMT22..	VBMT22..	VBGT22..	VBET22..	VBGT22..	VBMT22..	VBGW22..

Recommended Cutting Conditions ➡ **E55**

● : Standard Item △ : Phaseout Item (will be removed from next catalog)
Contact your local Kyocera sales engineer to upgrade old products to new technology

SVJB (External / Copying)





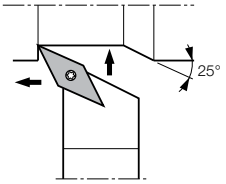
• Right-hand Shown

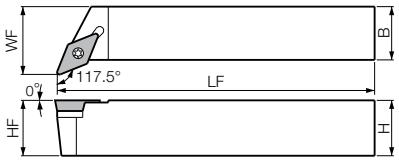
Toolholder Dimensions

Part Number	Stock R	Stock L	Unit	Dimensions H	HF	B	LF	WF	WF_2	Standard Corner-R (RE)	Clamp Screw	Wrench	Shim	Shim Screw	Wrench
SVJB□ 8-2A	●	●	inch	0.500	0.500	0.500	4.000	0.625	-	1/64	SB-2570TR	FT-8	-	-	-
12-3C	●			0.750	0.750	0.750	5.000	0.875		1/32	SB-4085TR	T-15			
16-3D	●			1.000	1.000	1.000	6.000	1.250		1/32					
SVJB□ 2020K-11	●	●	mm	20	20	20	125	25	-	0.4	SB-2570TR	FT-8	-	-	-
2525M-11	●	●		25	25	25	150	32							
SVJB□ 2020K-16N	●	●		20	20	20	125	25	-	0.8	SB-40125TRN	FT-15	SVN-32N (SVN-32S)	SS-4N	LW-4
2525M-16N	●	●		25	25	25	150	32							

• For insert with corner-R (RE) = 0.008" or 1/64", shim in parenthese is recommended (sold separately)

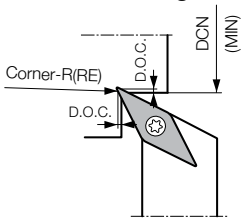
SVPB (External / Facing / Copying / Undercutting)





• Right-hand Shown

Undercutting Diameter of SVPB



Corner-R (RE)	D.O.C.	DCN (MIN)
0.016	0.020	Ø0.984
	0.039	Ø1.181
0.032	0.020	Ø1.772
	0.039	Ø2.165

Toolholder Dimensions

Part Number	Stock R	Stock L	Dimensions (mm) H	HF	B	LF	WF	Standard Corner-R (RE)	Spare Parts: Clamp Screw	Wrench	Shim	Shim Screw	Wrench
SVPB□ 1010JX-11	●	●	10	10	10	120	14.5	0.4	SB-2570TR	FT-8	-	-	-
1212JX-11	●	●	12	12	12	120	16.5						
1616JX-11	●	●	16	16	16	120	20.5						
SVPB□ 2020K-11	●	●	20	20	20	125	25.0	0.4	SB-2570TR	FT-8	-	-	-
2525M-11	●	●	25	25	25	150	32.0						
SVPB□ 2020K-16N	●	●	20	20	20	125	25.0	0.8	SB-40125TRN	FT-15	SVN-32N (SVN-32S)	SS-4N	LW-4
2525M-16N	●	●	25	25	25	150	32.0						

• For insert with corner-R (RE) = 0.008" or 1/64", shim in parenthese is recommended (sold separately)

Applicable Inserts

Application	Finishing	Finishing	Finishing-Medium	Finishing	Finishing / Precision	Finishing-Medium	Non-ferrous Metals	Non-ferrous Metals	Non-ferrous Metals	Hard Materials
Ref. Page	B89	B89	B89	B90	B89	B91	B93	B93	C28	C17
Insert / Toolholder	GP	VF	HQ	□-F	□-FSF	□-Y	AH	□-A3	PCD	CBN
SVJB□..-2.. SVJB□..-11 SVPB□..-11	VBMT22..	VBMT22..	VBMT22..	VBGT22..	VBET22..	VBGT22..	-	-	VBMT22..	VBGW22..
SVJB□..-3... SVJB□..-16N SVPB□..-16N	VBMT33..	VBMT33..	VBMT33..	-	-	VBGT33..	VCGT33..	VCGT33..	VBMT33..	VBGW33..

Recommended Cutting Conditions ➔ **E55**

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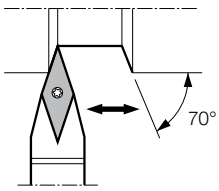
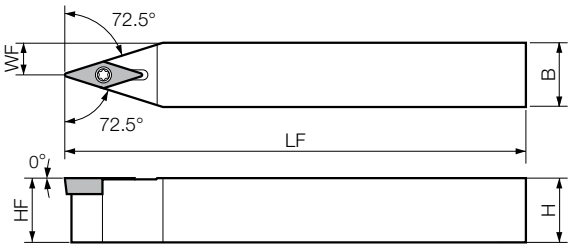
● : Standard Item △ : Phaseout Item (will be removed from next catalog)
Contact your local Kyocera sales engineer to upgrade old products to new technology

SVVB (External / Copying)





Toolholder Dimensions

Part Number		Stock	Unit	Dimensions H	HF	B	LF	WF	Standard Corner-R(RE)	Spare Parts: Clamp Screw	Wrench	Shim	Shim Screw	Wrench
SVVBN	**6-2JX**	●	inch	0.375	0.375	0.375	4.750	0.187	0.016	SB-2570TR	FT-8	-	-	-
	8-2JX	●		0.500	0.500	0.500	4.750	0.250						
	10-2JX	●		0.625	0.625	0.625	4.750	0.312						
SVVBN	**1010JX-11**	●	mm	10	10	10	120	5.0	0.4	SB-2570TR	FT-8	-	-	-
	1212JX-11	●		12	12	12	120	6.0						
	1616JX-11	●		16	16	16	120	8.0						
SVVBN	**1010F-11**	●		10	10	10	80	5.0	0.4	SB-2570TR	FT-8	-	-	-
	1616H-11	●		16	16	16	100	8.0						
	2020K-11	●		20	20	20	125	10.0						
	2525M-11	●		25	25	25	150	12.5						
SVVBN	**2020K-16N**	●		20	20	20	125	10.0	0.8	SB-40125TRN	FT-15	SVN-32N (SVN-32S)	SS-4N	LW-4
	2525M-16N	●		25	25	25	150	12.5						

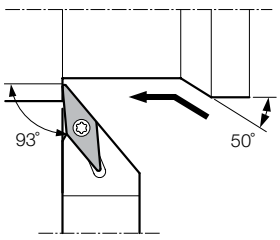
• For insert with corner-R (RE) = 0.008" or 1/64", shim in parenthese is recommended (sold separately)

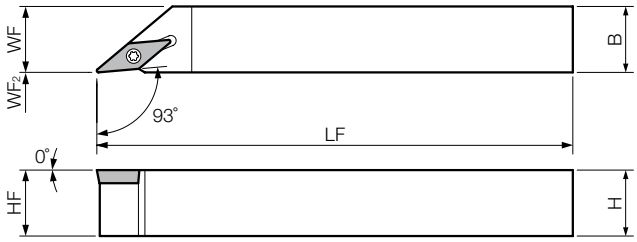
Applicable Inserts

Application	Finishing	Finishing	Finishing-Medium	Finishing	Finishing / Precision	Finishing-Medium	Non-ferrous Metals	Non-ferrous Metals	Non-ferrous Metals	Hard Materials
Ref. Page	B89	B89	B89	B90	B89	B91	B93	B93	C28	C17
Insert / Toolholder	**GP**	**VF**	**HQ**	**R/L-F**	**R/L-FSF**	**R/L-Y**	**AH**	**R/L-A3**	**PCD**	**CBN**
SVVBN..-2JXFF **SVVBN..-11**	VBMT22..	VBMT22..	VBMT22..	VBGT22..	VBET22..	VBGT22..	-	-	VBMT22..	VBGW22..
SVVBN..-16N	VBMT33..	VBMT33..	VBMT33..	-	-	VBGT33..	VCGT33..	VCGT33..	VBMT33..	VBGW33..

Recommended Cutting Conditions ➡ **E55**

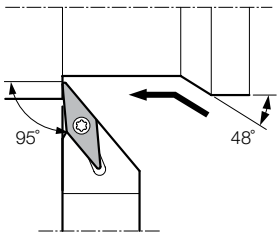
SVJC-FF (Without Offset • External / Copying)

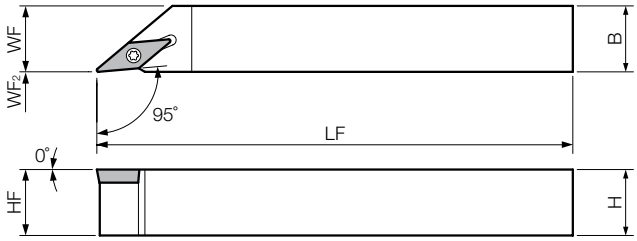




• Right-hand Shown

SVLC-FF (Without Offset • External / Copying)





• Right-hand Shown

Toolholder Dimensions

Part Number		Stock R	Stock L	Unit	Dimensions H	HF	B	LF	WF	WF_2	Standard Corner-R (RE)	Spare Parts: Clamp Screw	Spare Parts: Wrench
SVJC□	1010JX-11FF	●	●	mm	10	10	10	120	10	0	0.2	SB-2570TR	FT-8
	1212F-11FF	●	●		12	12	12	85	12				
	1212JX-11FF	●	●		12	12	12	120	12				
	1616JX-11FF	●	●		16	16	16		16				
	2020JX-11FF	●	●		20	20	20		20				
SVLC□	1212F-11FF	●	●		12	12	12	85	12	0	0.2	SB-2570TR	FT-8
	1212JX-11FF	●	●		12	12	12	120	12				
	1616JX-11FF	●	●		16	16	16	120	16				

Applicable Inserts

Application	Minute D.O.C.	Finishing	Finishing	Finishing	Finishing-Medium
Ref. Page	B92	B92	B92	B93	B93
Insert / Toolholder	CF	GF	SKS	□-F	□-Y
SVJC□...11FF	VCGT22..	VCGT22..	VCGT22..	VCET22..	VCET22..
SVLC□...11FF					

Recommended Cutting Conditions ➡ **E55**

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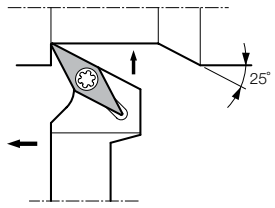
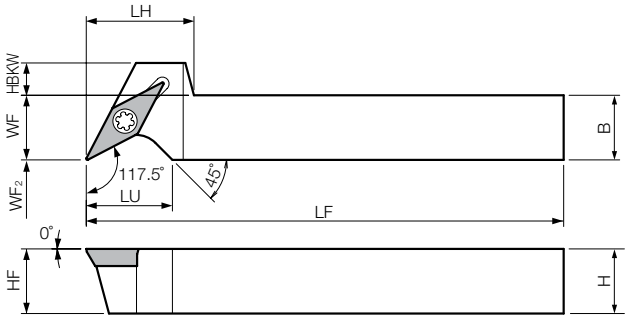
SVPC-FF (Without Offset • External / Facing / Copying / Undercutting)



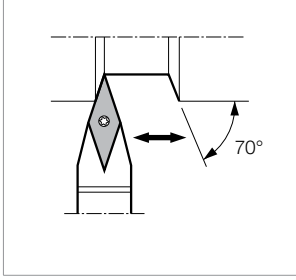


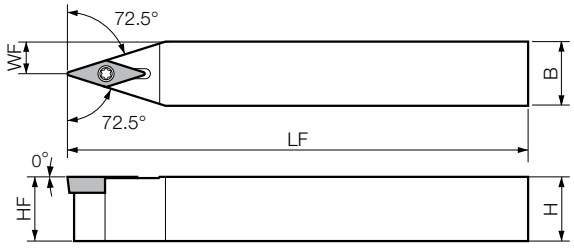
• Right-hand Shown

Toolholder Dimensions

Part Number		Stock R	Stock L	Unit	Dimensions H	HF	B	LF	LU	LH	WF	HBKW	WF_2	Standard Corner-R (RE)	Spare Parts: Clamp Screw	Spare Parts: Wrench
SVPCR	**1010JX-11FF**	●		mm	10	10	10	120	16	20	10	8	0	0.2	SB-2570TR	FT-8
	1212F-11FF	●			12	12	12	85	16		12	6				
	1212JX-11FF	●			12	12	12	120	16		12	6				
	1616JX-11FF	●			16	16	16	120	20		16	2				

SVVC (External / Copying)





Toolholder Dimensions

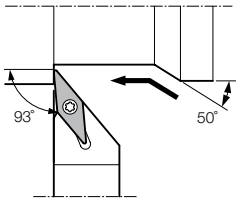
Part Number		Stock	Unit	Dimensions H	HF	B	LF	WF	Standard Corner-R (RE)	Spare Parts: Clamp Screw	Spare Parts: Wrench
SVVCN	**1010JX-11**	●	mm	10	10	10	120	5	0.2	SB-2570TR	FT-8
	1212JX-11	●		12	12	12		6			
	1616JX-11	●		16	16	16		8			

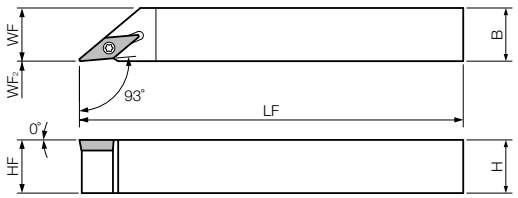
Applicable Inserts

Application	Minute D.O.C.	Finishing	Finishing	Finishing	Finishing-Medium
Ref. Page	B92	B92	B92	B93	B93
Insert / Toolholder	CF	GF	SKS	-F	-Y
SVPCR...11FF	VCGT22..	VCGT22..	VCGT22..	VCET22..R-F	VCET22..R-Y
SVVCN...11				VCET22.. -F	VCET22.. -Y

Recommended Cutting Conditions E55

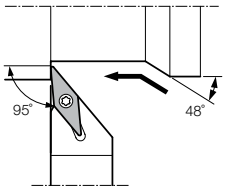
SVJP-FF (Without Offset • External / Copying)

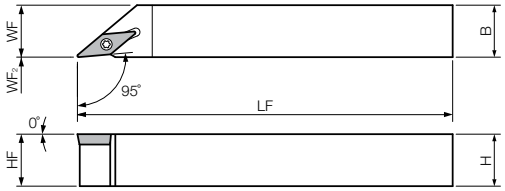




• Right-hand Shown

SVLP-FF (Without Offset • External / Copying)





• Right-hand Shown

Toolholder Dimensions

Part Number	Stock R	Stock L	Unit	H	HF	B	LF	LN	WF	WF_2	MHD	MHD2	Standard Corner-R (RE)	Spare Parts: Clamp Screw	Spare Parts: Wrench
SVJP□ 8-2JXFF	●	●	inch	0.500	0.500	0.500	4.750	-	0.500	0	-	-	0.008	SB-2570TR	FT-8
10-2JXFF	●			0.625	0.625	0.625	4.750		0.625						
SVJP□ 1212F-11FF	●	●	mm	12	12	12	85	-	12	0	-	-	0.2	SB-2570TR	FT-8
1212JX-11FF	●	●		12	12	12	120		12						
1616JX-11FF	●	●		16	16	16	120		16						
2020JX-11FF	●	●		20	20	20	120		20						
SVLP□ 8-2JXFF	●		inch	0.500	0.500	0.500	4.750	-	0.500	0	-	-	0.008	SB-2570TR	FT-8
SVLP□ 1010JX-08FF	●	●	mm	10	10	10	120	-	10	0	-	-	0.1	SB-2050TR	FT-6
1212JX-08FF	●	●		12	12	12	120		12						
1616JX-08FF	●	●		16	16	16	120		16						
SVLP□ 1212JX-11FF	●	●		12	12	12	120	-	12	0	-	-	0.2	SB-2570TR	FT-8
1616JX-11FF	●	●		16	16	16	120		16						
SVLP□ 1212F-08FF	●			12	12	12	85		12	0			0.1	SB-2050TR	FT-6
1212F-11FF	●			12	12	12	85		12				0.2	SB-2570TR	FT-8

Applicable Inserts

Application	Minute D.O.C.	Finishing	Finishing	Finishing	Finishing / Precision	Low Feed	Low Feed / Precision
Ref. Page	B94	B94	B94	B94	B95	B96	B96
Insert / Toolholder	CF	SKS	CK	GF	□-FSF	F□-U	F□-USF
SVLP□...-15JXFF SVLP□...-08FF	-	-	VPGT1515..	-	VPET1515..	-	VPET1515..
SVJP□...-2JXFF SVJP□...-11FF SVLP□...-2JXFF SVLP□...-11FF	VPGT22..	VPGT22..	VPGT22..	VPGT22..	VPET22..	VPET22..	VPET22..

Recommended Cutting Conditions ➡ **E55**

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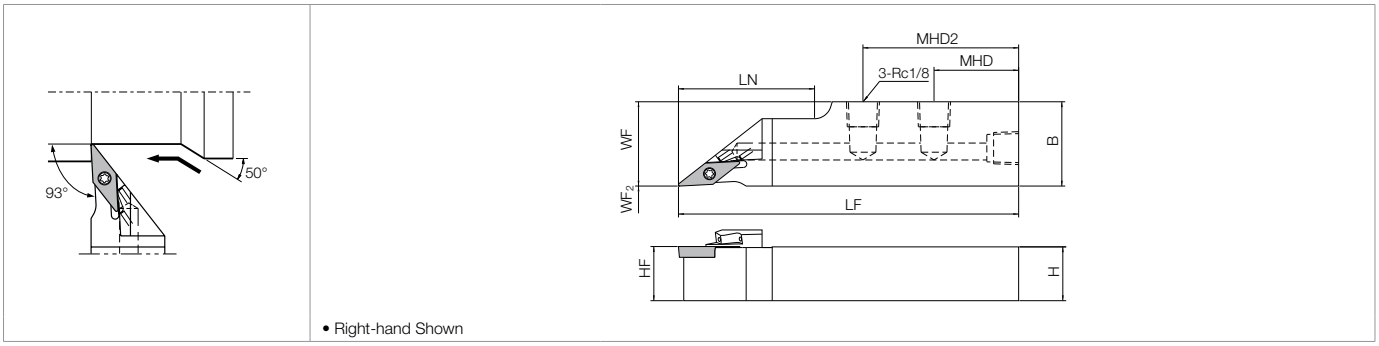
Contact your local Kyocera sales engineer to upgrade old products to new technology

SVJP-FFJCT (Without Offset • External / Copying, Jet Coolant-Through)

SVJP-FFJCT holders are being phased out. Switch to new SVJP-FFJCTM style below.



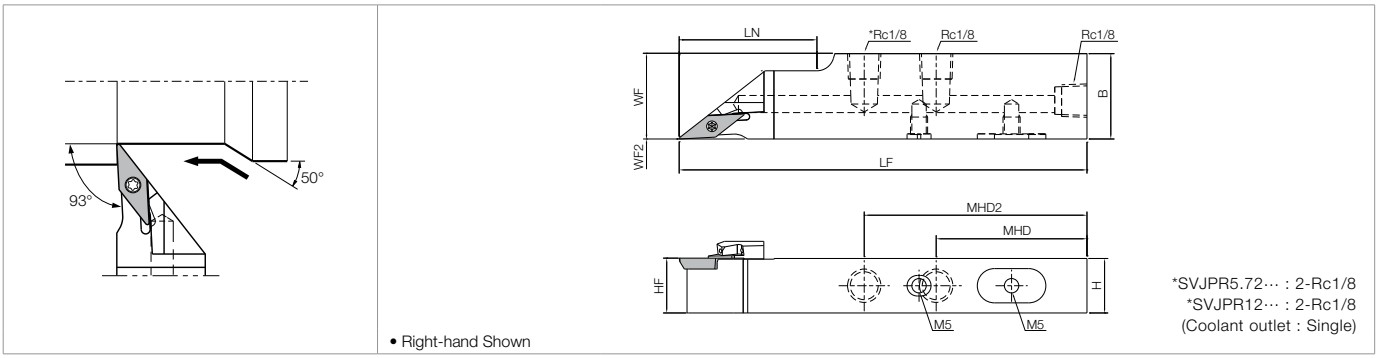
• Right-hand Shown

Toolholder Dimensions

Coolant Connections and Pipe Parts ➡ **H14-H15**

Part Number	Stock R	Stock L	Unit	H	HF	B	LF	LN	WF	WF_2	MHD	MHD2	Standard Corner-R (RE)	Spare Parts: Clamp Screw	Spare Parts: Wrench	Spare Parts: Plug
SVJPR 1220H-11FFJCT	△		mm	12	12	20	100	28	20	0	35	-	0.2	SB-2570TR	FT-8	GP-1
SVJPR 1625H-11FFJCT	△		mm	16	16	25	100	40	25	0	25	46	0.2	SB-2570TR	FT-8	GP-1
SVJPR 2025H-11FFJCT	△		mm	20	20	25	100	40	25	0	25	46	0.2	SB-2570TR	FT-8	GP-1

SVJP-FFJCTM (Without Offset • External / Copying, Direct from Turret Jet Coolant-Through) NEW



• Right-hand Shown

*SVJPR5.72··· : 2-Rc1/8
*SVJPR12··· : 2-Rc1/8
(Coolant outlet : Single)

Toolholder Dimensions

Coolant Connections and Pipe Parts ➡ **H18-H19**

Part Number	Stock R	Stock L	Unit	H	HF	B	LF	LN	WF	WF_2	MHD	MHD2	Standard Corner-R (RE)	Spare Parts: Clamp Screw	Spare Parts: Wrench	Spare Parts: Plug 1	Spare Parts: Plug 2
SVJPR 5.72-2FFJCTM	●		inch	0.500	0.500	0.708	4.750	1.110	0.708	0	2.150	-	0.008	SB-2570TR	FT-8	GP-1	HS5X4LP
82.5-2FFJCTM	●		inch	0.625	0.625	1.000		1.585	1.000		1.730	2.560					
SVJPR 1218JX-11FFJCTM	●		mm	12	12	18	120	28	18	0	54	-	0.2	SB-2570TR	FT-8	GP-1	HS5X4LP
1625JX-11FFJCTM	●		mm	16	16	25		40	25		44	65					
2025JX-11FFJCTM	●		mm	20	20												-

Applicable Inserts

Application	Minute D.O.C.	Finishing	Finishing	Finishing	Finishing / Precision	Low Feed	Low Feed / Precision
Ref. Page	➡ B94	➡ B94	➡ B94	➡ B94	➡ B95	➡ B96	➡ B96
Insert / Toolholder	CF	SKS	CK	GF	R%-FSF	F R%-U	F R%-USF
SVJPR...-11FFJCT SVJPR...-2FFJCTM SVJPR...-11FFJCTM	VPGT22..	VPGT22..	VPGT22..	VPGT22..	VPET22..	VPET22..	VPET22..

Recommended Cutting Conditions ➡ **E55**

● : Standard Item △ : Phaseout Item (will be removed from next catalog)
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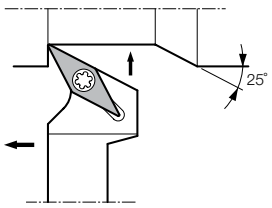
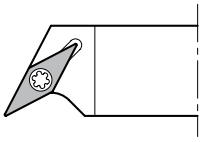
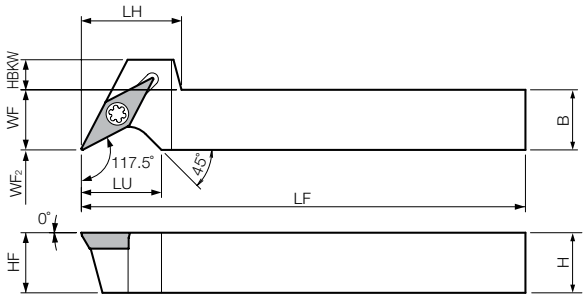
SVPP-FF (Without Offset • External / Facing / Copying / Undercutting)





SVPPR10-15JXFF
SVPPR1616..-08FF
shown above



• Right-hand Shown

Toolholder Dimensions

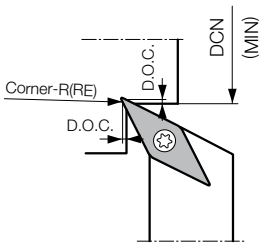
Part Number	Stock	Unit	Dimensions									Standard Corner-R(RE)	Spare Parts	
			H	HF	B	LF	LU	LH	WF	HBKW	WF_2		Clamp Screw	Wrench
SVPPR 8-15JXFF	●	inch	0.500	0.500	0.500	4.750	0.551	0.630	0.500	0.051	0	0.004	SB-2050TR	FT-6
SVPPR 8-2JXFF	●		0.500	0.500	0.500	4.750	0.630	0.787	0.500	0.209	0		SB-2570TR	FT-8
10-2JXFF	●		0.625	0.625	0.625	4.750	0.787	0.787	0.625	0.084	0			
SVPPR 1010JX-08FF	●	mm	10	10	10	120	12	16	10.0	4	0	0.1	SB-2050TR	FT-6
1212JX-08FF	●		12	12	12	120	12	16	12.0	2	0			
1616JX-08FF	●		16	16	16	120	12	-	16.0	-	0			
SVPPR 1010JX-11FF	●		10	10	10	120	16	20	10.0	8	0	0.2	SB-2570TR	FT-8
1212JX-11FF	●		12	12	12	120	16	20	12.0	6	0			
1616JX-11FF	●		16	16	16	120	16	20	16.0	2	0			
SVPPR 1212F-08FF	●		12	12	12	85	12	16	12.0	2	0	0.1	SB-2050TR	FT-6
1212F-11FF	●		12	12	12	85	16	20	12.0	6	0	0.2	SB-2570TR	FT-8

Applicable Inserts

Application	Minute D.O.C.	Finishing	Finishing	Finishing	Finishing / Precision	Low Feed	Low Feed / Precision
Ref. Page	B94	B94	B94	B94	B95	B96	B96
Insert / Toolholder	CF	SKS	CK	GF	R/L-FSF	FR/L-U	FR/L-USF
SVPPR...-15JXFF SVPPR...-08FF	-	-	VPGT1515..	-	VPET1515..	-	VPET1515..
SVPPR...-2JXFF SVPPR...-11FF	VPGT22..	VPGT22..	VPGT22..	VPGT22..	VPET22..	VPET22..	VPET22..

Recommended Cutting Conditions → **E55**

Undercutting Diameter of SVPP-FF



(in)

Corner-R (RE)	D.O.C.	DCN (MIN)
0.008	0.020	Ø0.787
	0.039	Ø0.984

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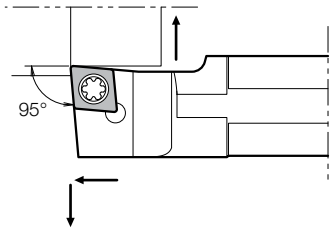
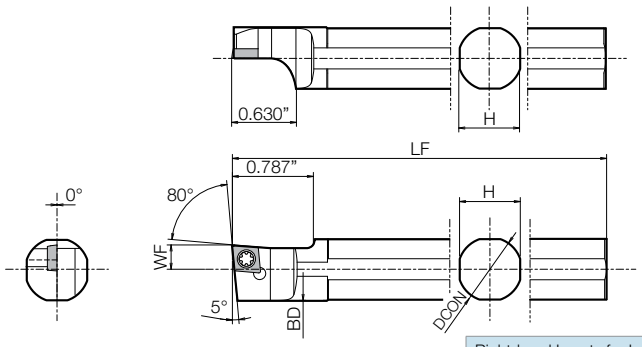
S...SCLC (External / Facing)





• Left-hand Shown

Right-hand Inserts for Left-hand Toolholders.

Toolholder Dimensions

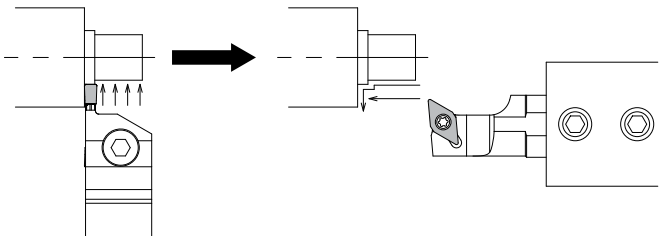
Part Number	Stock	Unit	Dimensions					Standard Corner-R(RE)	Spare Parts	
			DCON	LF	WF	BD	H		Clamp Screw	Wrench
S15F -SCLCL06	●	inch	0.625	3.346	0.236	0.606	0.590	0.016	SB-2570TR	FT-8
S19G -SCLCL06	●		0.750	3.543	0.236	0.724	0.669			
S19K -SCLCL06	●		0.750	4.724	0.236	0.724	0.669			
S19G -SCLCL09	●		0.750	3.543	0.393	0.724	0.669	0.016	SB-4065TR	FT-5
S19K -SCLCL09	●		0.750	4.724	0.393	0.724	0.669			
S25K -SCLCL09	●		1.000	4.724	0.393	0.976	0.905			
S12F -SCLCL06	●	mm	12	80	6	13.4	11	0.4	SB-2560TR	FT-8
S14H -SCLCL06	●		14	100	6	13.4	13			
S16F -SCLCL06	●		16	85	6	15.4	15	0.4	SB-2570TR	
S20G -SCLCL06	●		20	90	6	19.4	18			
S20K -SCLCL06	●		20	120	6	19.4	18			
S20G -SCLCL09	●		20	90	10	19.4	18	0.4	SB-4065TR	FT-15
S20K -SCLCL09	●		20	120	10	19.4	18			
S25.0H -SCLCL09	●		25	100	10	24.4	23			

Applicable Inserts

Application	Finishing	Finishing	Finishing-Medium	Low Feed	Stainless Steel	Cast Iron	Non-ferrous Metals	Non-ferrous Metals	Non-ferrous Metals	Hard Materials
Ref. Page	B53	B53	B54	B58, B59	B55	B60	B60	B60	C24	C14
Insert / Toolholder	SKS	SK	GK	(E/F)R-U	MQ	No Chipbreaker	AH	R-A3	PCD	CBN
S...SCLCL06	CCGT215..	CCGT215..	CCMT215..	CCGT215..	-	CCGW215..	-	-	CCMT215.. CCGW215..	CCMW215..
S...SCLCL09	CCGT325..	CCGT325..	CCMT325..	CCGT325..	CCMT325..	CCGW325..	CCGT325..	CCGT325..	CCMT325.. CCGW325..	CCMW325..

Recommended Cutting Conditions E55

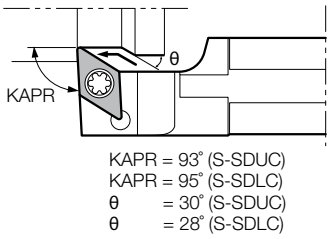
Finishing with Sleeve Holder



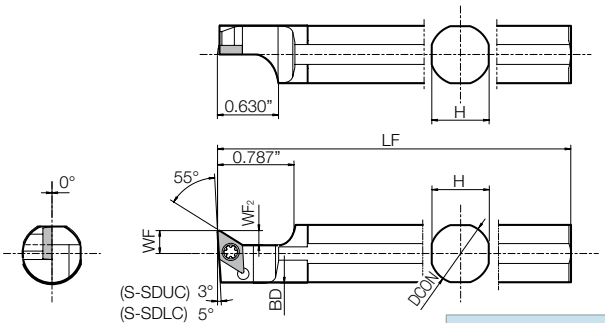
1) Roughing by grooving toolholder

2) Finishing by Sleeve Holder improves chip control and reduces cutting time

S...SDUC (External / Copying) / S...SDLC (External / Copying)



KAPR = 93° (S-SDUC)
KAPR = 95° (S-SDLC)
θ = 30° (S-SDUC)
θ = 28° (S-SDLC)



• Left-hand Shown

Right-hand Inserts for Left-hand Toolholders.

Toolholder Dimensions

Part Number	Stock	Unit	Dimensions						Standard Corner-R (RE)	Spare Parts	
			DCON	LF	WF	BD	H	WF_2		Clamp Screw	Wrench
S15F -SDUCL07	●	inch	0.625	3.346	0.236	0.606	0.590	0.150	1/64	SB-2560TR	FT-8
S19G -SDUCL07	●		0.750	3.543	0.236	0.724	0.669	0.150			
S19K -SDUCL07	●		0.750	4.724	0.236	0.724	0.669	0.150			
S19G -SDUCL11	●		0.750	3.543	0.393	0.724	0.669	0.228	1/64	SB-4085TR	FT-15
S19K -SDUCL11	●		0.750	4.724	0.393	0.724	0.669	0.228			
S25K -SDUCL11	●		1.000	4.724	0.393	0.976	0.905	0.228			
S15F -SDLCL07	●		0.625	3.346	0.236	0.606	0.590	0.150	1/64	SB-2560TR	FT-8
S19G -SDLCL07	●		0.750	3.543	0.236	0.724	0.669	0.150			
S19K -SDLCL07	●		0.750	4.724	0.236	0.724	0.669	0.150			
S19G -SDLCL11	●		0.750	3.543	0.393	0.724	0.669	0.228	1/64	SB-4085TR	FT-15
S19K -SDLCL11	●		0.750	4.724	0.393	0.724	0.669	0.228			
S25K -SDLCL11	●		1.000	4.724	0.393	0.976	0.905	0.228			
S14H -SDUCL07	●	mm	14	100	6	13.4	13	3.8	0.4	SB-2560TR	FT-8
S20G -SDUCL07	●		20	90	6	19.4	18	3.8			
S20K -SDUCL07	●		20	120	6	19.4	18	3.8			
S20G -SDUCL11	●		20	90	10	19.4	18	5.8	0.4	SB-4085TR	FT-15
S20K -SDUCL11	●		20	120	10	19.4	18	5.8			
S22K -SDUCL11	●		22	120	10	21.4	20	5.8			
S25.0H -SDUCL11	●		25	100	10	24.4	23	5.8			
S12F -SDLCL07	●		12	80	6	13.4	11	3.8	0.4	SB-2560TR	FT-8
S14H -SDLCL07	●		14	100	6	13.4	13	3.8			
S16F -SDLCL07	●		16	85	6	15.4	15	3.8			
S20G -SDLCL07	●		20	90	6	19.4	18	3.8			
S20K -SDLCL07	●		20	120	6	19.4	18	3.8			
S20G -SDLCL11	●		20	90	10	19.4	18	5.8	0.4	SB-4085TR	FT-15
S20K -SDLCL11	●		20	120	10	19.4	18	5.8			
S22K -SDLCL11	●		22	120	10	21.4	20	5.8			
S25.0H -SDLCL11	●		25	100	10	24.4	23	5.8			

Applicable Inserts

Application	Minute D.O.C.	Finishing	Finishing	Finishing	Finishing	Finishing-Medium	Finishing-Medium	Finishing	Finishing / Precision	Low Feed
Ref. Page	B62	B63	B63	B63	B63	B64	B63	B67	B66	B68, B69
Insert / Toolholder	**CF**	**SKS**	**SK**	**WP** (Wiper)	**PP**	**GK**	**GQ**	**R-F**	**R-FSF**	**(E/F) R-U**
S...SD□CL07	DCGT215..	DCGT215..	DCGT215..	DCMX215..	DCMT215..	DCMT215..	DCGT215..	DCGT215..	DCET215..	DCGT215..
S...SD□CL11	DCGT325..	DCGT325..	DCGT325..	DCMX325..	DCMT325..	DCMT325..	DCGT325..	DCGT325..	DCET325..	DCGT325..
Application	Low Feed / Precision	Low Feed	Low Carbon Steel / Finishing	Low Carbon Steel/ Finishing-Medium	Stainless Steel	Cast Iron	Non-ferrous Metals	Non-ferrous Metals	Non-ferrous Metals	Hard materials
Ref. Page	B68	B70, B71	B65	B65	B65	B71	B71	B71	C25	C15
Insert / Toolholder	**FR-USF**	**(E/F)R-J**	**XP**	**XQ**	**MQ**	**Without Chipbreaker**	**AH**	**R-A3**	**PCD**	**CBN**
S...SD□CL07	DCET215..	DCET215..	DCMT215..	-	DCMT215..	DCGW215..	-	-	DCMT215..	DCMW215..
S...SD□CL11	DCET325..	DC_T325..	DCMT325..	DCMT325..	DCMT325..	DCGW325..	DCGT325..	DCGT325..	DCMT325..	DCMW325..

When using **WP** chipbreaker, program corrections are required. (S...SDLC type cannot be used) ➡ **R51**

Recommended Cutting Conditions ➡ **E55**

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● : Standard Item □ : Made to Order △ : Phaseout Item (will be removed from next catalog)
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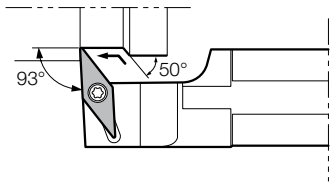
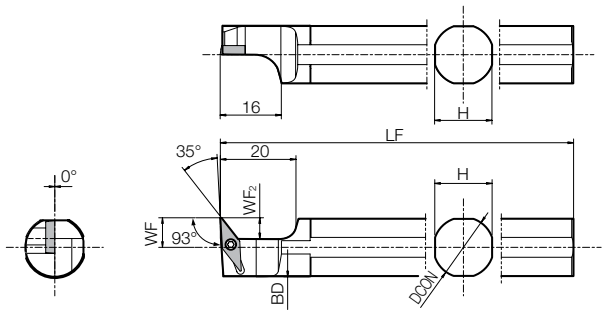
S...SVUB(C) (External / Copying)





• Left-hand Shown

Right-hand Inserts for Left-hand Toolholders.

Toolholder Dimensions

Part Number	Stock	Unit	Dimensions						Standard Corner-R (RE)	Spare Parts	
			DCON	LF	WF	BD	H	WF_2		Clamp Screw	Wrench
S15F -SVUCL08	●	inch	0.625	3.346	0.315	0.606	0.591	0.217	1/64	SB-2050TR	FT-6
S19G -SVUCL11	●		0.750	3.543	0.413	0.724	0.669	0.315	0.008	SB-2570TR	FT-8
S19K -SVUCL11	●		0.750	4.724	0.413	0.724	0.669	0.315			
S25K -SVUCL11	●		1.000	4.724	0.413	0.976	0.906	0.315			
S19K -SVUBL11	●		0.750	4.724	0.413	0.724	0.669	0.315	1/64	SB-2570TR	FT-8
S25K -SVUBL11	●		1.000	4.724	0.413	0.976	0.906	0.315			
S12F -SVUCL08	●	mm	12	80	7.5	13.4	11	5.5	0.4	SB-2050TR	FT-6
S14H -SVUCL08	●		14	100	7.5	13.4	13	5.5			
S16F -SVUCL08	●		16	85	8	15.4	15	5.5			
S20G -SVUCL11	●		20	90	10.5	19.4	18	8	0.2	SB-2570TR	FT-8
S20K -SVUCL11	●		20	120	10.5	19.4	18	8			
S25.0H -SVUCL11	●		25	100	10.5	24.4	23	8			
S20G -SVUBL11	●		20	90	10.5	19.4	18	8	0.4	SB-2570TR	FT-8
S20K -SVUBL11	●		20	120	10.5	19.4	18	8			
S25.0H -SVUBL11	●		25	100	10.5	24.4	23	8			

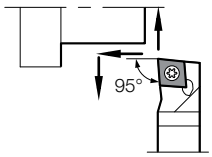
Applicable Inserts

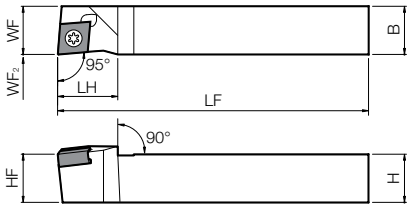
Application	Minute D.O.C.	Finishing	Finishing	Finishing	Finishing	Finishing-Medium	Finishing	Finishing / Precision	Finishing-Medium
Ref. Page	B92	B92	B92	B89	B89, B92	B89, B92	B90, B93	B89	B91, B93
Insert / Toolholder	**CF**	**GF**	**SKS**	**GP**	**VF**	**HQ**	**R-F**	**R-FSF**	**R-Y**
S...SVUCL08	-	-	-	-	VCMT1515..	VCMT1515..	-	-	-
S...SVUBL11	-	-	-	VBMT22..	VBMT22..	VBMT22..	VBGT22..	VBET22..	VBGT22..
S...SVUCL11	VCGT22..	VCGT22..	VCGT22..	-	-	-	VCET22..	-	VCET22..

Application	Non-ferrous Metals	Hard Materials
Ref. Page	C28	C17
Insert / Toolholder	**PCD**	**CBN**
S...SVUCL08	VCMT1515..	VCGW1515..
S...SVUBL11	VBMT22..	VBGW22..
S...SVUCL11	-	-

Recommended Cutting Conditions ➡ **E55**

SCLN (Without Offset • External / Facing)





Side Rake Angle : - 6°
Inclination Angle : - 6°

• Right-hand Shown

Toolholder Dimensions

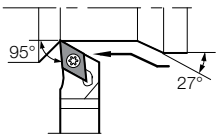
Part Number	Stock	Unit	Dimensions							Standard Corner-R (RE)	Spare Parts		Applicable Inserts
			H	HF	B	LF	LH	WF	WF_2		Clamp Screw	Wrench	
SCLNR 6-2.4FF	●	inch	0.375	0.375	0.375	6.00	0.590	0.375	0	0.008	SB-3080TR	LTW-10SS	CNGU242.. CNMU242..
8-2.4DF	●		0.500	0.500	0.500	6.00	0.590	0.500	0				
10-2.4CF	●		0.625	0.625	0.625	5.00	0.590	0.625	0				
SCLNR 1010K-07FF	●	mm	10	10	10	120	15	10	0	0.2	SB-3080TR	LTW-10SS	CNGU242.. CNMU242..
1212F-07FF	●		12	12	12	85	15	12	0				
1212K-07FF	●		12	12	12	120	15	12	0				
1616K-07FF	●		16	16	16	120	15	16	0				

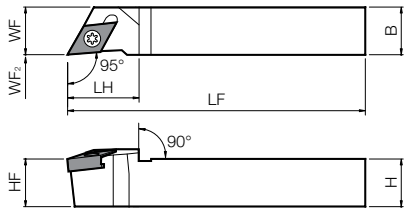
Applicable Inserts

Application	Finishing-Medium	Medium-Roughing	Finishing	Low Feed
Ref. Page	B50	B50	B50	B50
Insert / Toolholder	SK	GK	FR-F	(F/E)R-U
SCLNR...-2.4... SCLNR...-07FF	CNGU242..	CNMU242..	CNGU242..	CNGU242..

Recommended Cutting Conditions **E49**

SDLN (Without Offset • External / Copying)





Side Rake Angle : - 6°
Inclination Angle : - 7°

• Right-hand Shown

Toolholder Dimensions

Part Number	Stock	Unit	Dimensions							Standard Corner-R (RE)	Spare Parts		Applicable Inserts
			H	HF	B	LF	LH	WF	WF_2		Clamp Screw	Wrench	
SDLNR 6-2.2FF	●	inch	0.375	0.375	0.375	6.00	0.708	0.375	0	0.008	SB-3080TR	LTW-10SS	DNGU222.. DNMU222..
8-2.2DF	●		0.500	0.500	0.500	6.00	0.708	0.500	0				
10-2.2CF	●		0.625	0.625	0.625	5.00	0.708	0.625	0				
SDLNR 1010K-08FF	●	mm	10	10	10	120	18	10	0	0.2	SB-3080TR	LTW-10SS	DNGU222.. DNMU222..
1212F-08FF	●		12	12	12	85	18	12	0				
1212K-08FF	●		12	12	12	120	18	12	0				
1616K-08FF	●		16	16	16	120	18	16	0				

Applicable Inserts

Application	Finishing-Medium	Medium-Roughing	Finishing	Low Feed
Ref. Page	B51	B51	B51	B51
Insert / Toolholder	SK	GK	FR-F	(F/E)R-U
SDLNR...2.2... SDLNR...-08FF	DNGU222..	DNMU222..	DNGU222..	DNGU222..

Recommended Cutting Conditions **E49**

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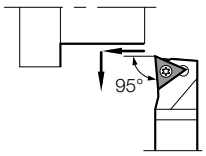
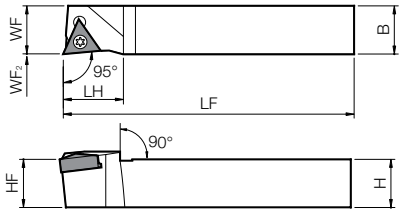
STLN (Without Offset • External / Up Facing)





Side Rake Angle : - 6°
Inclination Angle : - 7°

• Right-hand Shown

Toolholder Dimensions

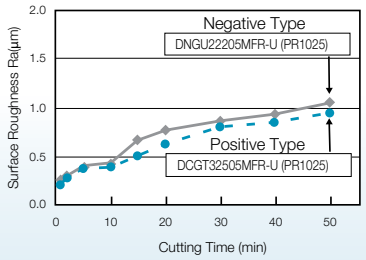
Part Number		Stock	Unit	Dimensions							Standard Corner-R (RE)	Spare Parts		Applicable Inserts
				H	HF	B	LF	LH	WF	WF_2		Clamp Screw	Wrench	
STLNR	6-1.8FF	●	inch	0.375	0.375	0.375	6.00	0.590	0.375	0	0.008	SB-2570TR	LTW-8SS	TNGU182..
	8-1.8DF	●		0.500	0.500	0.500	6.00	0.590	0.500	0				
STLNR	1010K-09FF	●	mm	10	10	10	120	15	10	0	0.2	SB-2570TR	LTW-8SS	TNGU182..
	1212F-09FF	●		12	12	12	85	15	12	0				
	1212K-09FF	●		12	12	12	120	15	12	0				
	1616K-09FF	●		16	16	16	120	15	16	0				

Applicable Inserts

Application	Finishing	Low Feed
Ref. Page	B52	B52
Insert / Toolholder	FR-F	(E/F)R-U
STLNR...1.8... STLNR...-09FF	TNGU182..	TNGU182..

Double-sided design allows both edges to be used. Compared to the positive type, the double-sided design offers less cost per insert and more stability.

Surface roughness comparison (Sharp edge)

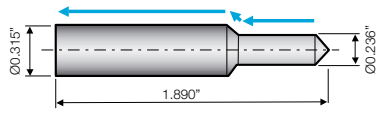


<Cutting Conditions>
Workpiece Material : 1045 Steel Vc = 325 sfm, D.O.C. = 0.059", f = 0.0012 ipr, Wet

(Internal Evaluation)

Case Studies

303 Stainless Steel



<Conventional Conditions>
• Spool
<0.236" Dia. portion>
• Vc = 225 sfm
• D.O.C. = 0.049"
• f = 0.001 ipr
• Wet
<0.315" Dia. portion>
• Vc = 425 sfm
• D.O.C. = 0.001"
• f = 0.001 ipr
• Wet

Required Surface 0.8µmRa

DNGU22205MF-SK (PR1025)	60,000 pcs/Insert (4 edges)
Competitor D (DCGT)	20,000 pcs/Insert (2 edges)

Competitor D (DCGT) machined 10,000 pcs/edge. PR1025 machined 15,000 pcs/edge resulting in 3 times longer tool life per insert.

(User Evaluation)

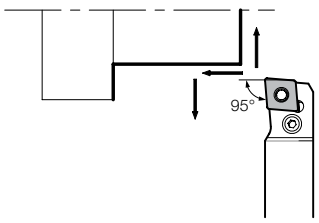
Recommended Cutting Conditions

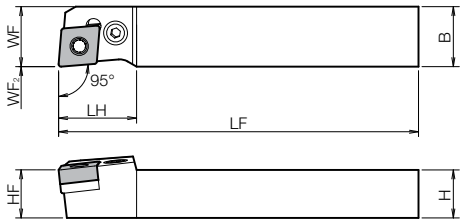
Workpiece Material	PR1225	PR1535	PR1705	PR1725
Free-Cutting Steel	-	-	● Vc=330sfm (200~490)	◔ Vc=330sfm (200~490)
Carbon Steel / Alloy Steel	◔ Vc=330sfm (200~500)	◔ Vc=330sfm (200~490)	◔ Vc=430sfm (200~720)	● Vc=430sfm (200~660)
Stainless Steel	◔ Vc=260sfm (160~490)	◔ Vc=330sfm (200~590)	-	◔ Vc=330sfm (260~490)

● : Continuous to Light interruption / 1st Recommendation
◔ : Continuous to Light interruption / 2nd Recommendation

● : Standard Item △ : Phaseout Item (will be removed from next catalog)
Contact your local Kyocera sales engineer to upgrade old products to new technology

PCLN-FF (Without Offset • External / Facing)





Side Rake Angle : - 6°
Inclination Angle : - 6°

• Right-hand Shown

Toolholder Dimensions

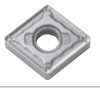
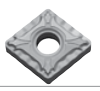
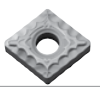
Part Number		Stock	Dimensions (mm)							Standard Corner-R (RE)	Spare Parts					
			H	HF	B	LF	LH	WF	WF_2		Lever	Lock Screw	Shim	Shim Pin	Punch	Wrench
PCLNR	**1620JX-12FF**	●	16	16	20	120	26	20	0	0.8	LL-2N	LS-2N	LC-42N	LSP-2	PC-2	LW-3
	2020JX-12FF	●	20	20												

Applicable Inserts (1st Recommendation)

Application	Finishing-Medium	Medium-Roughing
Ref. Page	B19	B19
Insert / Toolholder	**FP-SK**	**FP-TK**
PCLNR...-12FF	CNGG43..FP-SK	CNGG43..FP-TK

Recommended Cutting Conditions **E49**

Applicable Inserts (CN□□ Optional)

Application	Finishing	Finishing-Medium	Finishing	Finishing-Medium	Finishing-Medium	Finishing-Medium	Medium-Roughing	Medium-Roughing	Medium-Roughing	Medium-Roughing / High Feed Rate
Insert	**WF** (Wiper)	**WE** (Wiper)	**PP**	**PQ**	**CQ**	**CJ**	**GS**	**PG** 	**PS**	**PT**
Size	43..	43..	43..	43..	43..	43..	43..	43..	43..	43..
Ref. Page	B16	B16	B16	B16	B17	B17	B17	B17	B17	B18
Application	Roughing	Roughing	Single Sided / Roughing / High Feed Rate	Finishing	Medium	Soft Steel / Small D.O.C.	Soft Steel / Finishing	Soft Steel / Medium	Soft Steel / Roughing	Stainless Steel / Finishing
Insert	**Standard**	**PH**	**PX**	**R/L-S**	**R/L**	**XF**	**XP** 	**XQ** 	**XS**	**MQ**
Size	43..	43..	43..	-	43..	43..	43..	43..	43..	43..
Ref. Page	B18	B18	B19	-	B22	B19	B19	B19	B19	B20
Application	Stainless Steel / Medium-Roughing	Stainless Steel / Medium-Roughing	Cast Iron	Cast Iron	Cast Iron	Cast Iron	Cast Iron	Cast Iron	Cast Iron	Cast Iron
Insert	**MS**	**MU**	**KQ**	**KG**	**KH**	**C**	**ZS**	**GC**	**Without Chipbreaker**	**Ceramic**
Size	43..	43..	43..	43..	43..	43..	43..	43..	43..	43..
Ref. Page	B20	B20	B21	B21	B21	B21	B21	B21	B21	B108
Application	Non-ferrous Metals	Non-ferrous Metals	Non-ferrous Metals	Heat-Resistant Alloys	Heat-Resistant Alloy Roughing	Heat-Resistant Alloy Roughing	Hard Materials			
Insert	**A3**	**AH**	**PCD**	**SQ**	**SG**	**R/L-SX**	**CBN**			
Size	43..	43..	43..	43..	43..	43..	43..			
Ref. Page	B22	B22	C23	B20	B20	B21	C6, C7			

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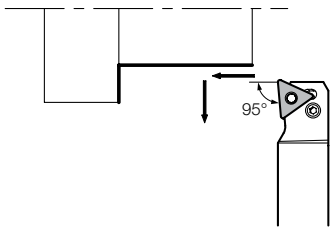
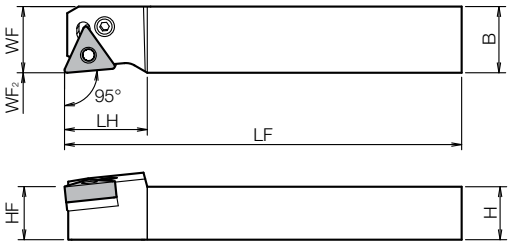
PTLN-FF (Without Offset • External / Up Facing)





Side Rake Angle : - 6°
Inclination Angle : - 6°

• Right-hand Shown

Toolholder Dimensions

Part Number		Stock	Dimensions (mm)							Standard Corner-R (RE)	Spare Parts					
			H	HF	B	LF	LH	WF	WF_2		Lever	Lock Screw	Shim	Shim Pin	Punch	Wrench
PTLNR	**1620JX-16FF**	●	16	16	20	120	24	20	0	0.8	LL-1N	LS-1N	LT-32N ※LT-32N-20	LSP-1	PC-1	FH-2.5
	2020JX-16FF	●	20	20												

※ When using inserts whose corner R (RE) is greater than 1/16", please purchase and use **LT-32N-20** shim to prevent workpiece and shim interference

Applicable Inserts (1st Recommendation)

Application	Finishing-Medium	Medium-Roughing	Large D.O.C.
Ref. Page	B38	B39	B38
Insert / Toolholder	**FP-SK**	**FP-TK**	**R-LD**
PTLNR...-16FF	TNGG33..FP-SK	TNGG33..FP-TK	TNMG33..R-LD

Recommended Cutting Conditions **E49**

Applicable Inserts (TN□□ Optional)

Application	Finishing	Finishing-Medium	Finishing-Medium	Medium-Roughing	Medium-Roughing	Medium-Roughing	Medium-Roughing / High Feed Rate	Medium-Roughing / High Feed Rate	Medium-Roughing	Single Sided / Roughing / High Feed	Roughing
Insert	**PP**	**PQ**	**CQ**	**GS**	**PG**	**PS**	**PT**	**GT**	**PH**	**PX**	**Standard**
Size	33..	33..	33..	33..	33..	33..	33..	33..	33..	33..	33..
Ref. Page	B36	B36	B36	B36	B36	B37	B37	B37	B37	B38	B37
Application	Finishing	Finishing-Roughing	Medium-Roughing Low Cutting Force	Soft Steel / Small D.O.C.	Soft Steel / Finishing	Soft Steel / Medium	Soft Steel / Roughing	Stainless Steel / Finishing	Stainless Steel / Medium-Roughing	Stainless Steel / Medium-Roughing	Heat-Resistant Alloy Roughing
Insert	**R-S**	**R-□**	**R-25R**	**XF**	**XP**	**XQ**	**XS**	**MQ**	**MS**	**MU**	**SG**
Size	33..	33..	33..	33..	33..	33..	33..	33..	33..	33..	33..
Ref. Page	B42	B42, B43	B43	B38	B38	B38	B38	B39	B39	B39	B39
Application	Cast Iron	Cast Iron	Cast Iron	Cast Iron	Cast Iron	Non-ferrous Metals	Non-ferrous Metals	Non-ferrous Metals	Hard Materials		
Insert	**KQ**	**KG**	**KH**	**ZS**	**Ceramic**	**R-A3**	**AH**	**PCD**	**CBN**		
Size	33..	33..	33..	33..	33..	33..	33..	33..	33..		
Ref. Page	B40	B40	B40	B40	B113	B41	B41	C23	C10, C11		

KSTB...CCET

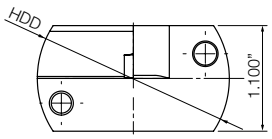


Fig.1

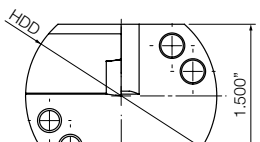
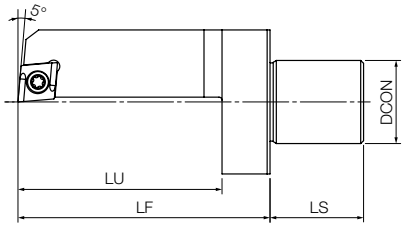


Fig.2



Toolholder Dimensions

Part Number	Stock	Dimensions (in)					Drawing	Spare Parts		Applicable Inserts ➔ B53~B60		Reference Machine
		DCON	HDD	LF	LU	LS		Clamp Screw	Wrench			
KSTB SR16/20 CCET215	●	0.866	2.000	2.250	1.875	1.073	Fig.1	SB-2560TR	FT-8	CCET CCGT	215	SR16, SR20
KSTB SR16/20 CCET325	●	0.866	2.000	2.250	1.875	1.073	Fig.1	SB-4085TR	FT-15		325	SR16, SR20
KSTB SR32J CCET325	●	0.866	2.000	2.625	2.125	0.980	Fig.2	SB-4085TR	FT-15		325	SR32J

KSTB...DCET

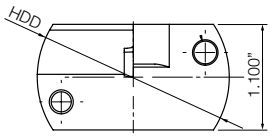


Fig.1

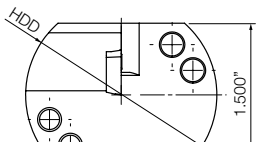
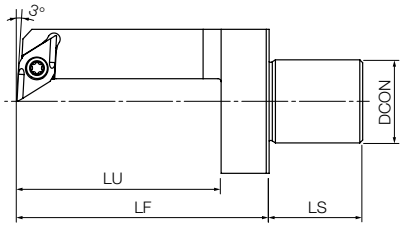


Fig.2



Toolholder Dimensions

Part Number	Stock	Dimensions (in)					Drawing	Spare Parts		Applicable Inserts ➔ B62~B71		Reference Machine
		DCON	HDD	LF	LU	LS		Clamp Screw	Wrench			
KSTB SR16/20 DCET215	●	0.866	2.000	2.250	1.875	1.073	Fig.1	SB-2560TR	FT-8	DCET DCGT	215	SR16, SR20
KSTB SR16/20 DCET325	●	0.866	2.000	2.250	1.875	1.073	Fig.1	SB-4085TR	FT-15		325	SR16, SR20
KSTB SR32J DCET325	●	0.866	2.000	2.625	2.125	0.980	Fig.2	SB-4085TR	FT-15		325	SR32J

KSTB...VBET

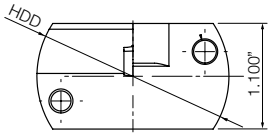


Fig.1

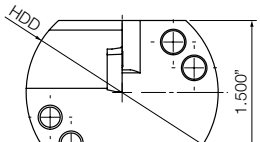
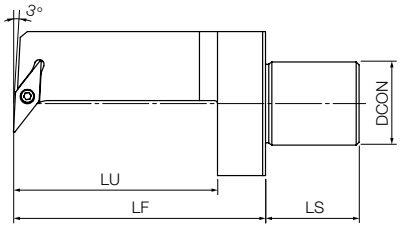


Fig.2



Toolholder Dimensions

Part Number	Stock	Dimensions (in)					Drawing	Spare Parts		Applicable Inserts ➔ B89~B90		Reference Machine
		DCON	HDD	LF	LU	LS		Clamp Screw	Wrench			
KSTB SR16/20 VBET22	●	0.866	2.000	2.250	1.875	1.073	Fig.1	SB-2570TR	FT-8	VBET	22	SR16, SR20
KSTB SR32J VBET22	●	0.866	2.000	2.625	2.125	0.980	Fig.2	SB-2570TR	FT-8		22	SR32J

Note: All KSTB holders are right-hand, which require neutral or left-hand inserts

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Contact your local Kyocera sales engineer to upgrade old products to new technology

KSTB...TGF

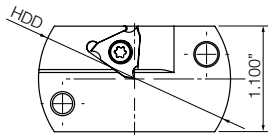


Fig.1

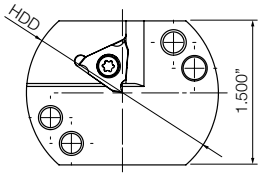
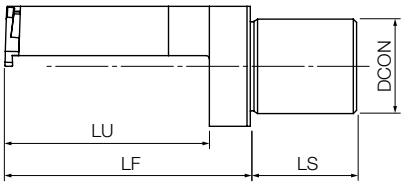


Fig.2



Toolholder Dimensions

Part Number	Stock	Dimensions (in)					Drawing	Spare Parts		Applicable Inserts	Reference Machine
		DCON	HDD	LF	LU	LS		Clamp Screw	Wrench		
KSTB SR16/20 TGF32	●	0.866	2.000	2.250	1.875	1.073	Fig.1	SB-4070TRS	FT-10	TGF32L..	SR16, SR20
KSTB SR32J TGF32	●	0.866	2.000	2.625	2.125	0.980	Fig.2	SB-4070TRS	FT-10		SR32J

KSTB...TT

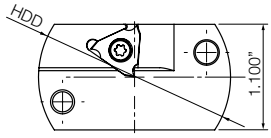


Fig.1

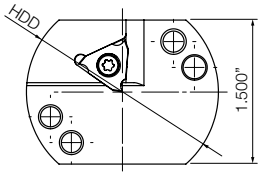
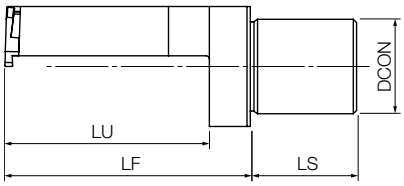


Fig.2

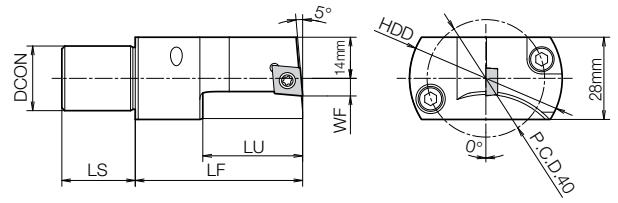


Toolholder Dimensions

Part Number	Stock	Dimensions (in)					Drawing	Spare Parts		Applicable Inserts	Reference Machine
		DCON	HDD	LF	LU	LS		Clamp Screw	Wrench		
KSTB SR16/20 TT32	●	0.866	2.000	2.250	1.875	1.073	Fig.1	SB-4070TRS	FT-10	TT32..	SR16, SR20
KSTB SR32J TT32	●	0.866	2.000	2.625	2.125	0.980	Fig.2	SB-4070TRS	FT-10		SR32J

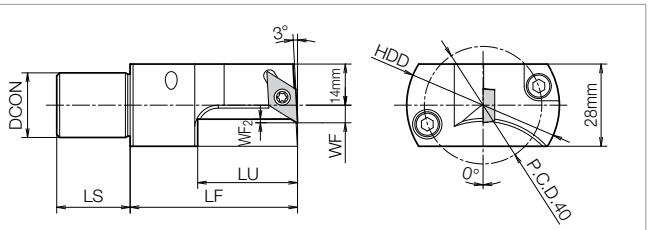
Note: All KSTB holders are right-hand, which require neutral or left-hand inserts

SF22F-SCLC (External / Facing) [for CC..32.. Inserts B53~B60]



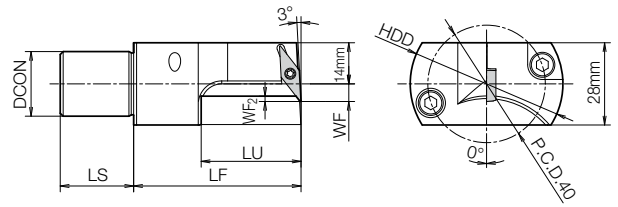
• Left-hand Shown

SF22F-SDUC (External / Facing) [for DC..32.. Inserts B62~B71]



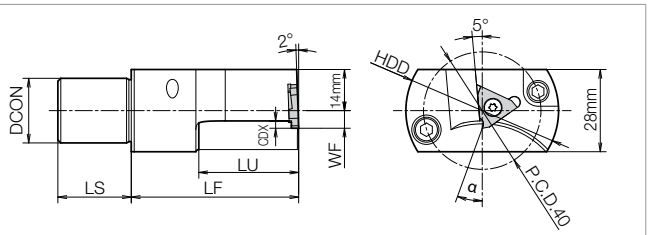
• Left-hand Shown

SF22F-SVUB (External / Copying) [for VB..22.. Inserts B89~B91]



• Left-hand Shown

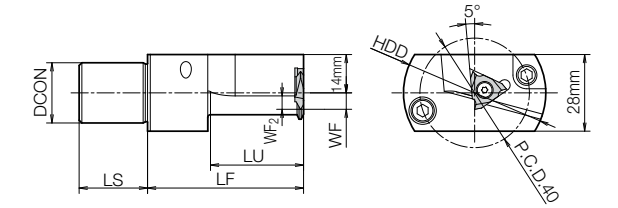
SF22F-KTGF (External Grooving) [for TGF32R... Inserts G21]



• Left-hand Shown

*Dimension **CDX** shows the available grooving depth

SF22F-KTTX (External Threading) [for TTX32R... Inserts J29]



• Left-hand Shown

α (°)	Insert Grade
20°	PR1115, PR1215 PR930, KW10
11°	KPD001
6°	TC40

Toolholder Dimensions

Part Number	Stock	Dimensions (mm)							Standard Corner-R (RE)	Spare Parts					
		DCON	HDD	LF	LS	LU	WF	WF_2 CDX		Insert Screw	Wrench	Mounting Bolt	Wrench	Adjustment Screw	Wrench
SF22F-SCLCL09-40P	△	22	52	57	25	34	6	-	0.2	SB-4085TR	FT-15	HH5X30	LW-4	HS3X4	LW-1.5
SF22F-SDUCL11-40P	△							1.5	0.2						
SF22F-SVUBL11-40P	△							3.0	0.2	SB-2570TR	FT-8				
SF22F-KTGFL16-40P	△							2.5	-	SB-4070TRS	FT-10				
SF22F-KTTXL16-40P	△							4.0	-	SB-4070TRW	FT-8				

Note: All SF22F holders are left-hand, which require neutral or right-hand inserts

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Recommended Cutting Conditions - External Turning (Positive Insert)

[D.O.C. Indicates Radius]

ISO Classification	Workpiece Material	Hardness	Cutting Range	Application	Recommended Chipbreaker	Recommended Grade	Corner-R (RE)	Lower Limit - **Recommendation** - Upper Limit		
								Vc (sfm)	D.O.C. (in)	Feed Rate f (ipr)
※P	Low-carbon Steel Low-carbon Alloy	HB ≦ 300	Precision Finishing	Continuous	F	PR1725	0.002	330 - **490** - 660	0.002 - **0.003** - 0.006	0.001 - **0.002** - 0.004
				Interrupted		PR1725	0.008	260 - **390** - 520	0.002 - **0.004** - 0.008	0.001 - **0.004** - 0.006
			Precision Finishing (Molded Chipbreaker)	Continuous	CF	PR1725	0.008	330 - **490** - 660	0.001 - **0.002** - 0.004	0.001 - **0.002** - 0.005
			Finishing	Continuous	GF	PR1725	0.008	330 - **460** - 590	0.008 - **0.020** - 0.039	0.002 - **0.004** - 0.008
				Interrupted		PR1725	1/64	260 - **390** - 520	0.008 - **0.020** - 0.039	0.002 - **0.004** - 0.008
			Finishing-Medium	Continuous	GQ	PR1725	0.008	260 - **390** - 520	0.031 - **0.118** - 0.197	0.001 - **0.002** - 0.004
				Interrupted		PR1725	1/64	200 - **330** - 460	0.031 - **0.079** - 0.118	0.001 - **0.002** - 0.004
			Low Feed & Large D.O.C.	Continuous	J, U	PR1725	0.008	260 - **330** - 460	0.020 - **0.079** - 0.138	0.001 - **0.002** - 0.004
	Medium-carbon Steel Medium-carbon Alloy	HB ≦ 330	Precision Finishing	Continuous	F	PR1725	0.002	330 - **490** - 660	0.002 - **0.003** - 0.006	0.001 - **0.002** - 0.004
				Interrupted		PR1725	0.008	260 - **390** - 520	0.002 - **0.004** - 0.008	0.001 - **0.004** - 0.006
			Precision Finishing (Molded Chipbreaker)	Continuous	CF	PR1725	0.008	330 - **490** - 660	0.001 - **0.002** - 0.004	0.001 - **0.002** - 0.005
			Finishing	Continuous	GF	PR1725	0.008	330 - **460** - 590	0.008 - **0.020** - 0.039	0.002 - **0.004** - 0.008
				Interrupted		PR1725	1/64	260 - **390** - 520	0.008 - **0.020** - 0.039	0.002 - **0.004** - 0.008
			Finishing-Medium	Continuous	GQ	PR1725	0.008	260 - **390** - 520	0.031 - **0.118** - 0.197	0.001 - **0.002** - 0.004
				Interrupted		PR1725	1/64	200 - **330** - 460	0.031 - **0.079** - 0.118	0.001 - **0.002** - 0.004
			Low Feed & Large D.O.C.	Continuous	J, U	PR1725	0.008	260 - **330** - 460	0.020 - **0.079** - 0.138	0.001 - **0.002** - 0.004
	High-carbon Alloy	HB ≦ 280	Precision Finishing	Continuous	F	PR1725	0.002	330 - **490** - 660	0.002 - **0.003** - 0.006	0.001 - **0.002** - 0.004
				Interrupted		PR1725	0.008	260 - **390** - 520	0.002 - **0.004** - 0.008	0.001 - **0.004** - 0.006
			Precision Finishing (Molded Chipbreaker)	Continuous	CF	PR1725	0.008	330 - **490** - 660	0.001 - **0.002** - 0.004	0.001 - **0.002** - 0.005
			Finishing	Continuous	GF	PR1725	0.008	330 - **460** - 590	0.008 - **0.020** - 0.039	0.002 - **0.004** - 0.008
				Interrupted		PR1725	1/64	260 - **390** - 520	0.008 - **0.020** - 0.039	0.002 - **0.004** - 0.008
			Finishing-Medium	Continuous	GQ	PR1725	0.008	260 - **390** - 520	0.012 - **0.059** - 0.118	0.001 - **0.002** - 0.004
				Interrupted		PR1725	1/64	200 - **330** - 460	0.012 - **0.039** - 0.079	0.001 - **0.002** - 0.004
			Low Feed & Large D.O.C.	Continuous	J, U	PR1725	0.008	260 - **330** - 460	0.020 - **0.079** - 0.138	0.001 - **0.002** - 0.004
M	Stainless Steel (Austenitic)	HB ≦ 220	Finishing	Continuous	GF	PR1225	0.008	260 - **330** - 390	0.004 - **0.012** - 0.020	0.001 - **0.002** - 0.004
				Interrupted		PR1535	1/64	200 - **260** - 330	0.012 - **0.020** - 0.039	0.002 - **0.004** - 0.006
			Medium	Continuous	GQ	PR1225	0.008	260 - **330** - 390	0.020 - **0.059** - 0.118	0.001 - **0.003** - 0.005
				Interrupted		PR1535	1/64	200 - **260** - 330	0.020 - **0.039** - 0.079	0.002 - **0.004** - 0.006
	Stainless Steel (Precipitation Hardend)	HB ≦ 300	Finishing	Continuous	GF	PR1225	0.008	130 - **200** - 260	0.004 - **0.012** - 0.020	0.001 - **0.002** - 0.004
				Interrupted		PR1535	1/64	100 - **160** - 230	0.012 - **0.020** - 0.039	0.002 - **0.004** - 0.006
			Medium	Continuous	GQ	PR1225	0.008	130 - **200** - 260	0.020 - **0.039** - 0.079	0.001 - **0.003** - 0.005
				Interrupted		PR1535	1/64	100 - **160** - 230	0.020 - **0.039** - 0.059	0.002 - **0.004** - 0.006
K	Gray Cast Iron	HB ≦ 250	Finishing	Continuous	Standard	CA310	1/64	330 - **390** - 490	0.008 - **0.020** - 0.039	0.004 - **0.006** - 0.008
				Interrupted		CA315	1/64	260 - **330** - 390	0.008 - **0.020** - 0.039	0.002 - **0.004** - 0.006
			Medium	Continuous	Standard	CA310	1/64	330 - **390** - 490	0.020 - **0.039** - 0.079	0.004 - **0.006** - 0.008
				Interrupted		CA315	1/32	260 - **330** - 390	0.020 - **0.039** - 0.079	0.002 - **0.004** - 0.006
	Nodular Cast Iron	HB ≦ 270	Finishing	Continuous	Standard	CA310	1/64	260 - **330** - 390	0.008 - **0.020** - 0.039	0.004 - **0.006** - 0.008
				Interrupted		CA315	1/64	200 - **260** - 330	0.008 - **0.020** - 0.039	0.002 - **0.004** - 0.006
			Medium	Continuous	Standard	CA315	1/64	260 - **330** - 390	0.020 - **0.039** - 0.079	0.004 - **0.006** - 0.008
				Interrupted		CA320	1/32	200 - **260** - 330	0.020 - **0.039** - 0.079	0.002 - **0.004** - 0.006
N	Non-ferrous Metals Copper Alloy Aluminum Alloy (Si 10% Under) etc.	HB ≦ 100	High Speed Finishing (Glossy Surface Finish)	Continuous	Without Chipbreaker	KPD001	0.008	490 - **820** - 1150	0.002 - **0.004** - 0.012	0.002 - **0.004** - 0.006
			Finishing (Long Tool Life)	Continuous	F	PDL025	0.008	330 - **490** - 660	0.002 - **0.012** - 0.020	0.001 - **0.003** - 0.004
				Interrupted		PDL025	1/64	330 - **490** - 660	0.002 - **0.012** - 0.020	0.001 - **0.003** - 0.004
			Finishing	Continuous	F	KW10	0.008	330 - **490** - 660	0.002 - **0.012** - 0.020	0.001 - **0.003** - 0.004
				Interrupted		KW10	1/64	330 - **490** - 660	0.002 - **0.012** - 0.020	0.001 - **0.003** - 0.004
			Medium	Continuous	U	KW10	0.008	330 - **490** - 660	0.008 - **0.020** - 0.059	0.001 - **0.004** - 0.008
				Interrupted		KW10	1/64	330 - **490** - 660	0.008 - **0.020** - 0.059	0.001 - **0.004** - 0.008
S	Titanium Alloys	HB ≦ 400	Precision Finishing (Glossy Surface Finish)	Continuous	Without Chipbreaker	KPD001	0.008	330 - **390** - 490	0.002 - **0.004** - 0.012	0.001 - **0.003** - 0.004
				Interrupted		KPD001	1/64	230 - **330** - 390	0.002 - **0.004** - 0.012	0.001 - **0.003** - 0.004
			Medium	Continuous	F, U	KW10	1/64	100 - **160** - 230	0.004 - **0.020** - 0.039	0.001 - **0.004** - 0.008
				Interrupted		KW10	1/64	100 - **160** - 230	0.004 - **0.020** - 0.039	0.001 - **0.004** - 0.008
	Heat-restistant Alloys	HB ≦ 350	Finishing	Continuous	F, U	KW10	1/64	30 - **100** - 160	0.004 - **0.012** - 0.020	0.001 - **0.002** - 0.004
				Interrupted	Without Chipbreaker	KW10	1/32	30 - **100** - 160	0.008 - **0.020** - 0.028	0.001 - **0.002** - 0.004
			Finishing	Continuous	MQ	PR1535	1/64	130 - **200** - 260	0.004 - **0.012** - 0.020	0.001 - **0.002** - 0.004
				Interrupted		PR1535	1/32	130 - **200** - 260	0.004 - **0.012** - 0.020	0.001 - **0.002** - 0.004
H	Hardened Steel Hard Materials	40 ~ 50 HRC	Finishing	Continuous	GK	PR1425	0.008	130 - **200** - 260	0.004 - **0.012** - 0.020	0.001 - **0.003** - 0.004
				Interrupted		PR1425	1/64	130 - **200** - 260	0.004 - **0.012** - 0.020	0.001 - **0.003** - 0.004
		50 ~ 68 HRC	Finishing	Continuous	ME MET	KBN05M	0.008	260 - **390** - 490	0.004 - **0.012** - 0.020	0.001 - **0.003** - 0.004
				Interrupted		KBN05M	1/64	200 - **330** - 390	0.004 - **0.012** - 0.020	0.001 - **0.003** - 0.004

※ For machining free-cutting steels, use PR1005 at Vc=650sfm or less. For D.O.C. and feed rate (f), refer to specs for low carbon steels.

Recommended Cutting Conditions - Back Turning

KTKF E12

Workpiece Material		MEGACOAT NANO PLUS PR1725 Grooving	MEGACOAT NANO PLUS PR1725 Turning	MEGACOAT NANO PR1535 Grooving	MEGACOAT NANO PR1535 Turning	MEGACOAT NANO PR1425 Grooving	MEGACOAT NANO PR1425 Turning	MEGACOAT PR1225 Grooving	MEGACOAT PR1225 Turning	Notes
Carbon Steel / Alloy Steel	Vc (sfm)	★ 200 ~ 660		☆ 200 ~ 500		☆ 250 ~ 650		☆ 200 ~ 500		Wet
	Feed (ipr)	0.0004 ~ 0.0012	0.0008 ~ 0.0059	0.0004 ~ 0.0012	0.0008 ~ 0.0059	0.0004 ~ 0.0012	0.0008 ~ 0.0059	0.0004 ~ 0.0012	0.0008 ~ 0.0059	
Stainless Steel	Vc (sfm)	☆ 200 ~ 490		★ 200 ~ 425		☆ 200 ~ 500		☆ 200 ~ 425		
	Feed (ipr)	0.0004 ~ 0.0008	0.0008 ~ 0.0039	0.0004 ~ 0.0008	0.0008 ~ 0.0039	0.0004 ~ 0.0008	0.0008 ~ 0.0039	0.0004 ~ 0.0008	0.0008 ~ 0.0039	

Workpiece Material		PVD Coated Carbide PR1025 Grooving	PVD Coated Carbide PR1025 Turning	Carbide KW10 Grooving	Carbide KW10 Turning	PCD KPD001 Grooving	PCD KPD001 Turning	Notes
Carbon Steel / Alloy Steel	Vc (sfm)	☆ 200 ~ 500		-		-		Wet
	Feed (ipr)	0.0004 ~ 0.0012	0.0008 ~ 0.0059	-		-		
Stainless Steel	Vc (sfm)	☆ 175 ~ 400		-		-		
	Feed (ipr)	0.0004 ~ 0.0008	0.0008 ~ 0.0039	-		-		
Cast Iron	Vc (sfm)	-		175 ~ 325		-		
	Feed (ipr)	-		0.0004 ~ 0.0012	0.0008 ~ 0.00395	-		
Aluminum	Vc (sfm)	-		650 ~ 1475		200 ~ 500		
	Feed (ipr)	-		0.0004 ~ 0.0012	0.0008 ~ 0.00395	0.0004 ~ 0.0012	0.0008 ~ 0.00395	
Brass	Vc (sfm)	-		325 ~ 650		200 ~ 425		
	Feed (ipr)	-		0.0004 ~ 0.0008	0.0008 ~ 0.0039	0.0004 ~ 0.0008	0.0008 ~ 0.0039	

KTKF (GTP Chipbreaker) E12

Workpiece Material		MEGACOAT NANO PLUS PR1725 Grooving	MEGACOAT NANO PLUS PR1725 Turning	MEGACOAT NANO PR1535 Grooving	MEGACOAT NANO PR1535 Turning	Notes
Carbon Steel / Alloy Steel	Vc (sfm)	★ 200 ~ 660		☆ 200 ~ 490		Wet
	Feed (ipr)	0.001 ~ 0.003	0.002 ~ 0.006	0.001 ~ 0.003	0.002 ~ 0.006	
Stainless Steel	Vc (sfm)	☆ 200 ~ 490		★ 200 ~ 430		
	Feed (ipr)	0.001 ~ 0.002	0.001 ~ 0.004	0.001 ~ 0.002	0.001 ~ 0.004	

KTKF (GQ Chipbreaker) E12

Workpiece Material		MEGACOAT NANO PLUS PR1725 Grooving	MEGACOAT NANO PLUS PR1725 Turning	MEGACOAT NANO PR1535 Grooving	MEGACOAT NANO PR1535 Turning	MEGACOAT NANO PR1425 Grooving	MEGACOAT NANO PR1425 Turning	MEGACOAT PR1225 Grooving	MEGACOAT PR1225 Turning	Notes
Carbon Steel / Alloy Steel	Vc (sfm)	★ 200 ~ 660		☆ 200 ~ 500		☆ 250 ~ 650		☆ 200 ~ 500		Wet
	Feed (ipr)	0.0004 ~ 0.0016	0.0008 ~ 0.0059	0.0004 ~ 0.0015	0.0008 ~ 0.0059	0.0004 ~ 0.0015	0.0008 ~ 0.0059	0.0004 ~ 0.0015	0.0008 ~ 0.0059	
Stainless Steel	Vc (sfm)	☆ 200 ~ 490		★ 200 ~ 425		☆ 200 ~ 500		☆ 200 ~ 425		
	Feed (ipr)	0.0004 ~ 0.0012	0.0008 ~ 0.0039	0.0004 ~ 0.0012	0.0008 ~ 0.0039	0.0004 ~ 0.0012	0.0008 ~ 0.0039	0.0004 ~ 0.0012	0.0008 ~ 0.0039	

KTKF (AGT Chipbreaker) E12

Workpiece Material		PCD KPD001 Grooving	PCD KPD001 Turning	Notes
Aluminum	Vc (sfm)	660 ~ 1,640		Wet
	Feed (ipr)	0.001 ~ 0.006	0.001 ~ 0.008	
Brass	Vc (sfm)	330 ~ 1,150		
	Feed (ipr)	0.001 ~ 0.006	0.001 ~ 0.008	

ABS15, ABW15, ABW23 E19~E21

Workpiece Material		MEGACOAT NANO PLUS PR1725 Grooving	MEGACOAT NANO PLUS PR1725 Turning	MEGACOAT NANO PLUS PR1705 Grooving	MEGACOAT NANO PLUS PR1705 Turning	MEGACOAT NANO PR1425 Grooving	MEGACOAT NANO PR1425 Turning	MEGACOAT PR1225 Grooving	MEGACOAT PR1225 Turning	PVD Coated Carbide PR930 Grooving	PVD Coated Carbide PR930 Turning	Notes
Carbon Steel / Alloy Steel	Vc (sfm)	★ 200 ~ 590		☆ 260 ~ 660		☆ 250 ~ 600		☆ 200 ~ 500		☆ 250 ~ 325		Wet
	Feed (ipr)	0.0008	0.0008~0.0028	0.0008	0.0008~0.0028	0.0008	0.0008~0.0028	0.0008	0.0008~0.0028	0.0008	0.0008~0.0028	
Stainless Steel	Vc (sfm)	☆ 100 ~ 430		☆ 130 ~ 490		☆ 125 ~ 425		★ 125 ~ 400		☆ 100 ~ 175		
	Feed (ipr)	0.0008	0.0008~0.0020	0.0008	0.0008~0.0020	0.0008	0.0008~0.0020	0.0008	0.0008~0.0020	0.0008	0.0008~0.0020	

Workpiece Material		Carbide KW10 Grooving	Carbide KW10 Turning	Notes
Aluminum	Vc (sfm)	500 ~ 650		Wet
	Feed (ipr)	0.0008	0.0008 ~ 0.0039	
Brass	Vc (sfm)	325 ~ 525		
	Feed (ipr)	0.0012	0.0008 ~ 0.0059	

★ : 1st Recommendation
☆ : 2nd Recommendation

New Part Description (Change in Overall Length) Reference Table for Small Tools (Back Clamp)

Conventional Toolholder						New Swiss Length Toolholder			
Insert Shape	Part Number	Overall Length	Spare Parts: Anchor Pin	Spare Parts: Lock Screw	Spare Parts: Wrench	Part Number	Overall Length	Notes	Ref. to Page
ABS15	AABSR6-15CF	5.00"	LPA-11	HSB4X8R	FH-2	AABSR6-15JXF	4.75"		E19
	AABSR8-15DF	6.00"	LPA-13			AABSR8-15JXF	4.75"		
	-	-	LPA-17			AABSR10-15JXF	4.75"		
	AABSR0810K-40F	125mm	LPA-11	HSB4x8R	FH-2	-	-	No Alternative	-
	AABSR1010K-40F	125mm				AABSR1010JX-40F	120mm		E19
	AABSR1212M-40F	150mm	LPA-13			AABSR1212JX-40F	120mm		
	AABSR1616M-40F	150mm	LPA-17			AABSR1616JX-40F	120mm		
ABW15	AABWR6-15CF	5.00"	LPA-11	HSB4X8R	FH-2	AABWR6-15JXF	4.75"		E20
	AABWR8-15DF	6.00"	LPA-13			AABWR8-15JXF	4.75"		
	-	-	LPA-17			AABWR10-15JXF	4.75"		
	AABWR0810K-40F	125mm	LPA-11	HSB4x8R	FH-2	-	-	No Alternative	-
	AABWR1010K-40F	125mm				AABWR1010JX-40F	120mm		E20
	AABWR1212M-40F	150mm	LPA-13			AABWR1212JX-40F	120mm		
	AABWR1616M-40F	150mm	LPA-17			AABWR1616JX-40F	120mm		
ABW23	AABWR6-23CF	5.00"	LPA-11	HSB4X8R	FH-2	AABWR6-23JXF	4.75"		E21
	AABWR8-23DF	6.00"	LPA-13			AABWR8-23JXF	4.75"		
	-	-	LPA-17			AABWR10-23JXF	4.75"		
	AABWR0810K-50F	125mm	LPA-11	HSB4x8R	FH-2	-	-	No Alternative	-
	AABWR1010K-50F	125mm				AABWR1010JX-50F	120mm		E21
	AABWR1212M-50F	150mm	LPA-13			AABWR1212JX-50F	120mm		
	AABWR1616M-50F	150mm	LPA-17			AABWR1616JX-50F	120mm		
CC..	ACLC□6-2CF	5.00"	LPF-11	HSB4X8□	FH-2	ACLC□6-2JXFF	4.75"		E24
	-	-	LPF-13			ACLC□6-3JXFF	4.75"		
	ACLC□8-3DF	6.00"				ACLC□8-3JXFF	4.75"		
	-	-	LPF-17			ACLC□10-3JXFF	4.75"		
	ACLC□0810K-06F	125mm	LPF-11	HSB4x8R (Right-hand toolholder) HSB4x8L (Left-hand toolholder)	FH-2	SCLC□0808F-06FF	120mm	Clamping system is different.	E24
	ACLC□1010K-06F	125mm				ACLC□1010JX-06FF	120mm		
	ACLC□1010K-09F	125mm	LPF-13			ACLC□1010JX-09FF	120mm		
	ACLC□1212M-09F	150mm				ACLC□1212JX-09FF	120mm		
	ACLC□1616M-09F	150mm	LPF-17			ACLC□1616JX-09FF	120mm		
DC..	ADJC□6-2CF	5.00"	LPF-11	HSB4X8□	FH-2	ADJC□6-2JXFF	4.75"		E27
	-	-	LPF-13			ADJC□6-3JXFF	4.75"		
	ADJC□8-3DF	6.00"				ADJC□8-3JXFF	4.75"		
	-	-	LPF-17			ADJC□10-3JXFF	4.75"		
	ADNCR6-2CF	5.00"	-	-	-	-	-	No Alternative	-
	ADNC□8-3DF	6.00"	-	-	-	-	-	No Alternative	
	ADJC□0810K-07F	125mm	LPF-11	HSB4x8R (Right-hand toolholder) HSB4x8L (Left-hand toolholder)	FH-2	SDJC□0808F-07FF	120mm	Clamping system is different.	E27
	ADJC□1010K-07F	125mm				ADJC□1010JX-07FF	120mm		
	ADJC□1010K-11F	125mm	LPF-13			ADJC□1010JX-11FF	120mm		
	ADJC□1212M-11F	150mm				ADJC□1212JX-11FF	120mm		
	ADJC□1616M-11F	150mm	LPF-17			ADJC□1616JX-11FF	120mm		
	ADNCR0810K-07F	125mm	LPF-11	HSB4x8R	FH-2	-	-	No Alternative	-
	ADNCR1010K-07F	125mm				SDNCN1010JX-07	120mm	Clamping system is different. Neutral	E33
	ADNCR1010K-11F	125mm	LPF-13			SDNCN1010JX-11	120mm		
	ADNCR1212M-11F	150mm				SDNCN1212JX-11	120mm		
	ADNCR1616M-11F	150mm	LPF-17			SDNCN1616JX-11	120mm		
VB..	AVJB□6-2CF	5.00"	LPF-11	HSB4X8□	FH-2	AVJB□6-2JXFF	4.75"		E36
	AVJB□8-2DF	6.00"	LPF-1113			AVJB□8-2JXFF	4.75"		
	-	-	LPF-1117			AVJB□10-2JXFF	4.75"		
	AVJB□1010K-11F	125mm	LPF-11	HSB4x8R (Right-hand toolholder) HSB4x8L (Left-hand toolholder)	FH-2	AVJB□1010JX-11FF	120mm		E36
	AVJB□1212M-11F	150mm	LPF-1113			AVJB□1212JX-11FF	120mm		
	AVJB□1616M-11F	150mm	LPF-1117			AVJB□1616JX-11FF	120mm		
	AVVB□1010K-11F	125mm	LPF-11	HSB4x8R (Right-hand toolholder) HSB4x8L (Left-hand toolholder)	FH-2	SVVBN1010JX-11	120mm	Clamping system is different. Neutral	E39
	AVVB□1212M-11F	150mm	LPF-1113			SVVBN1212JX-11	120mm		
	AVVB□1616M-11F	150mm	LPF-1117			SVVBN1616JX-11	120mm		

Note) The corresponding alternative toolholder may be different from the conventional toolholder in insert clamping system or insert size.
Make sure of their specifications by referring to the catalog or other documents.

New Part Description (Change in Overall Length) Reference Table for Small Tools (Screw Clamp)

Conventional Toolholder					New Swiss Length Toolholder			
Insert Shape	Part Number	Overall Length	Spare Parts: Clamp Screw	Spare Parts: Wrench	Part Number	Overall Length	Notes	Ref. to Page
	SABSR6-15CF	5.00"	SB-3080TR	FT-10	SABSR6-15JXF	4.75"		E19
	SABSR8-15DF	6.00"			SABSR8-15JXF	4.75"		
	-	-			SABSR10-15JXF	4.75"		
ABS15	SABSR0810K-40F	125mm	SB-3080TR	FT-10	-	-	No Alternative	-
	SABSR1010K-40F	125mm			SABSR1010JX-40F	120mm		E19
	SABSR1212M-40F	150mm			SABSR1212JX-40F	120mm		
	SABSR1616M-40F	150mm			SABSR1616JX-40F	120mm		
	SABWR6-15CF	5.00"	SB-3080TR	FH-2	SABWR6-15JXF	4.75"		E20
	SABWR8-15DF	6.00"			SABWR8-15JXF	4.75"		
	-	-			SABWR10-15JXF	4.75"		
ABW15	SABWR0810K-40F	125mm	SB-3080TR	FT-10	-	-	No Alternative	-
	SABWR1010K-40F	125mm			SABWR1010JX-40F	120mm		E20
	SABWR1212M-40F	150mm			SABWR1212JX-40F	120mm		
	SABWR1616M-40F	150mm			SABWR1616JX-40F	120mm		
	SABWR6-23CF	5.00"	SB-3080TR	FT-10	SABWR6-23JXF	4.75"		E21
	SABWR8-23DF	6.00"			SABWR8-23JXF	4.75"		
	-	-			SABWR10-23JXF	4.75"		
ABW23	SABWR0810K-50F	125mm	SB-3080TR	FT-10	-	-	No Alternative	-
	SABWR1010K-50F	125mm			SABWR1010JX-50F	120mm		E21
	SABWR1212M-50F	150mm			SABWR1212JX-50F	120mm		
	SABWR1616M-50F	150mm			SABWR1616JX-50F	120mm		
	SCLC□6-2X	3.00"	SB-2570TR	FT-8	SCLC□6-2JXFF	4.75"		E24
	SCAC□6-2C	5.00"	-	-	-	-	Cutting edge angle is different	
	SCGCR6-2X	3.00"	-	-	-	-		
	-	-	SB-4085TR	FT-15	SCLC□6-3JXFF	4.75"		
	SCLC□8-3A	4.00"			SCLC□8-3JXFF	4.75"	No Alternative	
	SCAC□8-3D	6.00"	-	-	-	-	Cutting edge angle is different	
	SCGCR8-3A	4.00"	-	-	-	-		
	SCLC□10-3C	5.00"	SB-4085TR	FT-15	SCLC□10-3JXFF	4.75"		
CC..	SCGCR10-3C	5.00"	-	-	-	-	Cutting edge angle is different	
	SCLC□12-3C	5.00"	-	-	-	←	No Alternative	
	SCAC□0808K-06	125mm	SB-2570TR	FT-8	SCLC□0808F-06FF	85mm	Cutting edge angle is different.	E24
	SCAC□1010K-06	125mm			SCLC□1010JX-06FF	120mm		
	SCAC□1010K-09	125mm	SB-4085TR	FT-15	SCLC□1010JX-09FF	120mm		
	SCAC□1212M-09	150mm			SCLC□1212JX-09FF	120mm		
	SCAC□1616M-09	150mm			SCLC□1616JX-09FF	120mm		
	SCACR1212F-09FF	85mm	SB-4085TR	FT-15	SCLCR1212JX-09FF	120mm		
	SCLC□0808E-06	70mm	SB-2570TR	FT-8	SCLC□0808F-06FF	85mm		
	SDJC□6-2CF	5.00"	SB-2570TR	FT-8	SDJC□6-2JXFF	4.75"		E27
	SDJC□6-2X	3.00"	-	-	-	-		
	-	-	SB-4085TR	FT-15	SDJC□6-3JXFF	4.75"		
	SDJC□8-3DF	6.00"			SDJC□8-3JXFF	4.75"		
	SDJC□8-3A	4.00"	-	-	-	-		
	SDJC□10-3C	5.00"	SB-4085TR	FT-15	SDJC□10-3JXFF	4.75"		
	SDJC□12-3C	5.00"	-	-	-	-	No Alternative	
DC..	-	-	SB-4085TR	FT-15	SDJCR52-3JX-F3	4.75"		E22
					SDJCR52-3JX-F9	4.75"		
					SDJCR62.5-3JX-F3	4.75"		
					SDJCR62.5-3JX-F9	4.75"		
	SDJC□0808F-07F	80mm	SB-2570TR	FT-8	SDJC□0808F-07FF	85mm		E27
	SDJC□1010F-07F	80mm			SDJC□1010JX-07FF	120mm		
	SDJC□1010F-11F	80mm	SB-4085TR	FT-15	SDJC□1010JX-11FF	120mm		
	SDJC□1212H-11F	100mm			SDJC□1212JX-11FF	120mm		
	SDJC□1616H-11F	100mm			SDJC□1616JX-11FF	120mm		
	-	-	SB-2570TR	FT-8	SDLC□6-2JXFF	4.75"		E32

Note) The corresponding alternative toolholder may be different from the conventional toolholder in insert clamping system or insert size.
Make sure of their specifications by referring to the catalog or other documents.

New Part Description (Change in Overall Length) Reference Table for Small Tools (Screw Clamp)

Conventional Toolholder					New Swiss Length Toolholder			
Insert Shape	Part Number	Overall Length	Spare Parts: Clamp Screw	Spare Parts: Wrench	Part Number	Overall Length	Notes	Ref. to Page
DC..	-	-	SB-4085TR	FT-15	SDLC□6-3JXFF	4.75"		E32
		-			SDLC□8-3JXFF	4.75"		
		-			SDLC□10-3JXFF	4.75"		
	SDLC□1010F-07FF	80mm	SB-2570TR	FT-8	SDLC□1010JX-07FF	120mm		E32
	SDLC□1212H-07FF	100mm			SDLC□1212F-07FF	85mm	Short length type	
					SDLC□1212JX-07FF	120mm		
	SDLC□1616H-07FF	100mm			SDLC□1616JX-07FF	120mm		
	SDLC□1212H-11FF	100mm	SB-4085TR	FT-15	SDLC□1212JX-11FF	120mm		
	SDLCL1616H-11FF	100mm			SDLCL1616JX-11FF	120mm		
	SDNC□6-2CF	5.00"	SB-2570TR	FT-8	SDNC□6-2JXF	4.75"		E33
	SDNCN6-2X	3.00"			SDNCN6-2JX	4.75"		
	-	-	SB-4085TR	FT-15	SDNCN6-3JX	4.75"		
		-	SB-2570TR	FT-8	SDNCN8-2JX	4.75"		
	SDNC□8-3DF	6.00"	SB-4085TR	FT-15	SDNCN8-3JX	4.75"		
	SDNCN8-3A	4.00"	-	-	-	-		
	SDNCN10-3C	5.00"	SB-4085TR	FT-15	SDNCN10-3JX	4.75"		
	SDNCN12-3C	5.00"	-	-	-	-	No Alternative	
	SDNC□1010F-07F	80mm	SB-2570TR	FT-8	SDNC□1010JX-07F	120mm		E33
	SDNC□1010F-11F	80mm	SB-4085TR	FT-15	SDNC□1010JX-07F	120mm	Insert size is different.	
					SDNCN1010JX-11	120mm	Neutral	
	SDNC□1212H-11F	100mm	SB-4085TR	FT-15	SDNCN1212F-11	85mm	Neutral Short length type	
					SDNCN1212JX-11	120mm	Neutral	
	SDNC□1616H-11F	100mm	SB-4085TR	FT-15	SDNCN1616JX-11	120mm	Neutral	
	SDNCN0808E-07	70mm	SB-2570TR	FT-8	SDNCN0808F-07	85mm		
	SDNCN1010F-07	80mm			SDNCN1010JX-07	120mm		
	SDNCN1212H-07	100mm			SDNCN1212JX-07	120mm		
	SDNCN1212H-11	100mm	SB-4085TR	FT-15	SDNCN1212F-11	85mm		
					SDNCN1212JX-11	120mm	Short length type	
	SDXC□1010F-07	80mm	SB-2570TR	FT-8	SDXC□1010JX-07	120mm		E32
	SDXC□1010F-11	80mm	SB-4085TR	FT-15	SDXC□1010JX-11	120mm		
	SDXC□1212H-11	100mm			SDXC□1212JX-11	120mm		
	SDXC□1616H-11	100mm			SDXC□1616JX-11	120mm		
DP..	-	-	SB-2570TR	FT-8	SDLP□6-2JXFF	4.75"		E34
		-	SB-4085TR	FT-15	SDLP□6-3JXFF	4.75"		
		-			SDLP□8-3JXFF	4.75"		
		-			SDLP□10-3JXFF	4.75"		
	SDLP□0808F-07F	80mm	SB-2570TR	FT-8	SDLP□0808F-07FF	85mm		E34
	SDLP□1010F-07F	80mm			SDLP□1010JX-07FF	120mm		
	SDLP□1010F-11F	80mm	SB-4085TR	FT-15	SDLP□1010JX-11FF	120mm		
	SDLP□1212H-11F	100mm			SDLP□1212JX-11FF	120mm		
	SDLP□1616H-11F	100mm			SDLP□1616JX-11FF	120mm		
VB..	SVJB□6-2CF	5.00"	SB-2570TR	FT-8	SVJB□6-2JXFF	4.75"		E36
	SVJB□6-2X	3.00"	-	-	-	-		
	SVJB□8-2DF	6.00"	SB-2570TR	FT-8	SVJB□8-2JXFF	4.75"		
	SVJB□8-2A	4.00"	-	-	-	4.75"		
	-		SB-2570TR	FT-8	SVJB□10-2JXFF	4.75"		
	SVJB□12-3C	5.00"	-	-	-	-	No Alternative	
	SVJB□1010F-11F	80mm	SB-2570TR	FT-8	SVJB□1010JX-11FF	120mm		E34
	SVJB□1212H-11F	100mm			SVJB□1212JX-11FF	120mm		
	SVJB□1616H-11F	100mm			SVJB□1616JX-11FF	120mm		
	SVPB□1010F-11	80mm	SB-2570TR	FT-8	SVPB□1010JX-11	120mm		E38
	SVPB□1212H-11	100mm			SVPB□1212JX-11	120mm		
	SVPB□1616H-11	100mm			SVPB□1616JX-11	120mm		

Note) The corresponding alternative toolholder may be different from the conventional toolholder in insert clamping system or insert size.
Make sure of their specifications by referring to the catalog or other documents.

New Part Description (Change in Overall Length) Reference Table for Small Tools (Screw Clamp)

Conventional Toolholder					New Swiss Length Toolholder			
Insert Shape	Part Number	Overall Length	Spare Parts: Clamp Screw	Spare Parts: Wrench	Part Number	Overall Length	Notes	Ref. to Page
VB..	-	-	SB-2570TR	FT-8	SVVBN6-2JX	4.75"		E39
		-			SVVBN8-2JX	4.75"		-
		-			SVVBN10-2JX	4.75"		
	SVVBN1212H-11	100mm	SB-2570TR	FT-8	SVVBN1212JX-11	120mm		E39
VP..	-	-	SB-2570TR	FT-8	SVJP□8-2JXFF	4.75"		
		-			SVJP□10-2JXFF	4.75"		
		-	SB-2550TR	FT-6	SVLP□6-15JXFF	4.75"		E42
		-			SVLP□8-15JXFF	4.75"		
		-			SVLP□10-15JXFF	4.75"		
		-	SB-2570TR	FT-8	SVLP□8-2JXFF	4.75"		
		-			SVLP□10-2JXFF	4.75"		
		-	SB-2570TR	FT-15	SVLPR52-2JX-F9	4.75"		E23
		-			SVLPR62.5-2JX-F9	4.75"		
	SVLP□1010F-08FF	80mm	SB-2050TR	FT-6	SVLP□1010JX-08FF	120mm		E42
	SVLP□1212H-08FF	100mm			SVLP□1212F-08FF	85mm	Short length type	
					SVLP□1212JX-08FF	120mm		
	SVLP□1616H-08FF	100mm			SVLP□1616JX-08FF	120mm		
	SVLP□1010F-11F	80mm	SB-2570TR	FT-8	SVLP□1010JX-08FF	120mm	Insert size is different.	
	SVLP□1212H-11F	100mm			SVLP□1212F-11FF	85mm	Short length type	
					SVLP□1212JX-11FF	120mm		
	SVLP□1616H-11F	100mm			SVLP□1616JX-11FF	120mm		
	-	-	SB-2570TR	FT-8	SVPPR6-2JXFF	4.75"		E44
		-			SVPPR8-2JXFF	4.75"		
		-			SVPPR10-2JXFF	4.75"		
		-	SB-2050TR	FT-6	SVPPR6-15JXFF	4.75"		
		-			SVPPR8-15JXFF	4.75"		
		-			SVPPR10-15JXFF	4.75"		
	SVPPR1010F-11	80mm	SB-2570TR	FT-8	SVPBR1010JX-11	120mm	Insert relief angle is different.	E38
					SVPPR1010JX-11FF	120mm	Without Offset	E44
	SVPPR1212H-11	100mm			SVPBR1212JX-11	120mm	Insert relief angle is different.	E38
					SVPPR1212JX-11FF	120mm	Without Offset	E44
	SVPPR1616H-11	100mm			SVPBR1616JX-11	120mm	Insert relief angle is different.	E38
					SVPPR1616JX-11FF	120mm	Without Offset	E44
	SVPPL1616H-11	100mm	SB-2570TR	FT-8	SVPBL1616JX-11	120mm	Insert relief angle is different.	E38
TC..	STGCR6-1.5X	3.00"	-	-	-	-	No Alternative	-
	STGC□8-2A	4.00"	-	-		-		
WP..	SWLP□8-2A	4.00"	-	-		-	No Alternative	
	SWLPR12-3C	5.00"	-	-		-		

Note) The corresponding alternative toolholder may be different from the conventional toolholder in insert clamping system or insert size.
Make sure of their specifications by referring to the catalog or other documents.

New Part Description Reference Table for Small Tools (Screw Clamp) Toolholders for Back Turning

Conventional Toolholder					New Swiss Length Toolholder		
Insert Shape	Part Number	Overall length	Clamp Screw	Wrench	Part Number	Overall length	Ref. to Page
TKFB..	KTKF□1010K-12	125mm	SB-4590TRWN	LTW-10S	KTKF□1010JX-12	120mm	E12
	KTKF□1212M-12	150mm			KTKF□1212JX-12	120mm	
	KTKF□1616M-12	150mm			KTKF□1616JX-12	120mm	
	KTKF□1010K-16	125mm			KTKF□1010JX-16	120mm	
	KTKF□1212M-16	150mm			KTKF□1212JX-16	120mm	
	KTKF□1616M-16	150mm			KTKF□1616JX-16	120mm	

Note) The corresponding alternative toolholder may be different from the conventional toolholder in insert clamping system or insert size.
Make sure of their specifications by referring to the catalog or other documents.