

Now available with **direct through-coolant toolholder system** for Swiss-type machines



INDUSTRY 4.0
FEED the SPEED!



ACCELERATED MACHINING



Jet coolant **improves chip control**, and significantly **prolongs inserts tool life**.

Optimized two streams of high-pressure coolant jets to maximize productivity

New

DIRECT^{TUNG}TJET system

Tube-free design streamlines tool setups

Through-coolant supply enables high productivity

Conventional tube connections



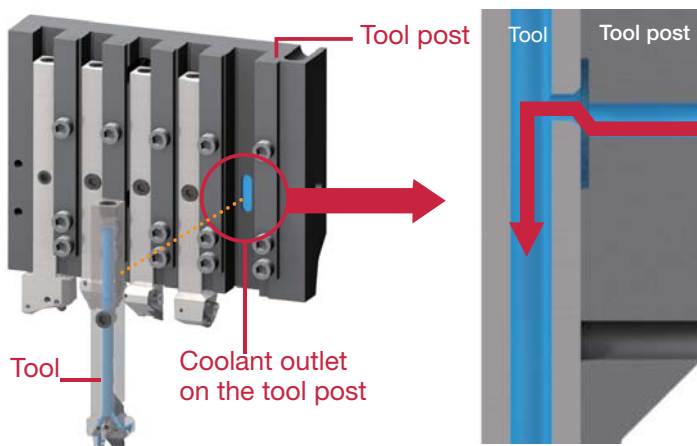
- Mountable to varieties types of machines
- Flexible tube connections

Direct coolant supply

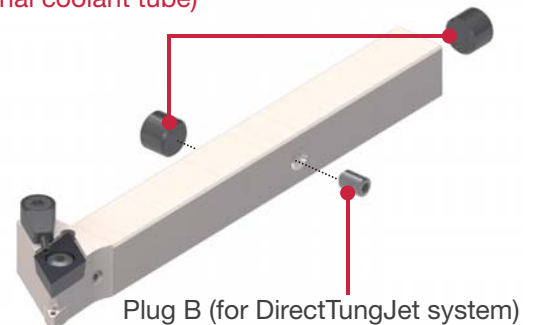


- No tubes needed
- No chip tangling
- Easy tool change-over

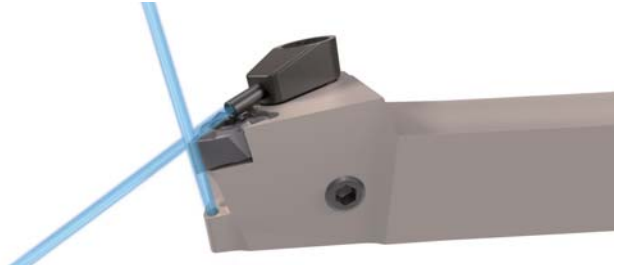
Coolant is supplied from the tool post directly to the tools



Plug A
(for connecting an external coolant tube)



Use a non-coolant-through tool when a coolant supply is not needed through the tool.



Top Jet improves

Chip flow and reduce machine downtime !

External coolant in normal pressure (**1.5 MPa**)



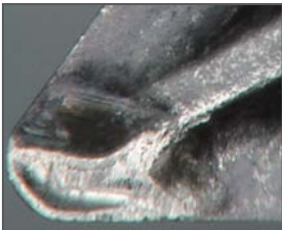
Frequent machine stoppages due to chip entanglement

High pressure coolant (**>7 MPa**)

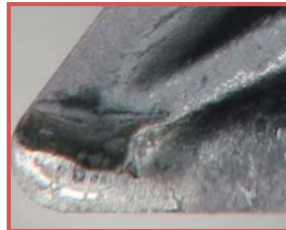


Improved machining stability due to chip breaking

Reduced crater wear



Crater wear under normal pressure
(**1.5 MPa**)



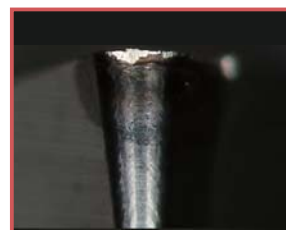
High pressure coolant
(**>7 MPa**)

Bottom Jet improves

Notch and flank wears



External coolant in normal pressure
(**1.5 MPa**)

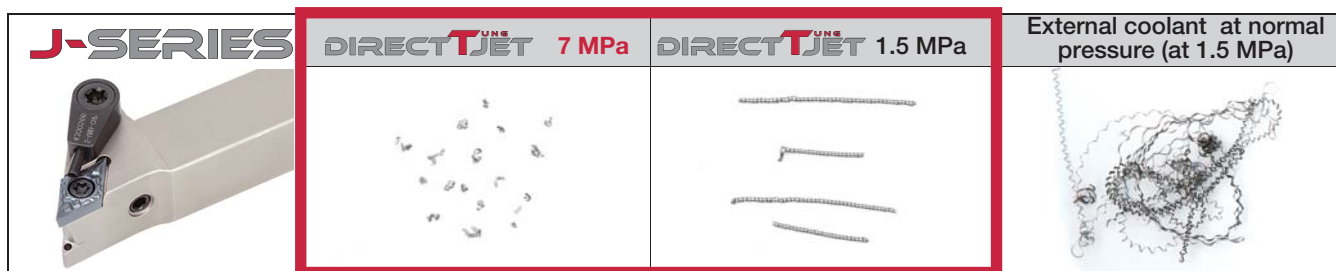


High pressure coolant
(**>7 MPa**)

Improvement of chip control with Direct Tung Jet system

M Stainless steel: External turning (SUS304)

Material : SUS304
Holder : JSDJ2CR1212X11-CHP
Insert : DCGT11T302FN-JS SH725
Cutting speed : $V_c = 80$ m/min
Feed rate : $f = 0.03$ mm/rev
Depth of cut : $a_p = 1.5$ mm
Coolant type : Oil



S Titanium alloy: External turning (Ti-6Al-4V)

Material : Ti-6Al-4V
Holder : STCR1212X18-CHP
Insert : TCP18R200F-010 SH725
Cutting speed : $V_c = 100$ m/min
Feed rate : $f = 0.05$ mm/rev
Groove width : 2 mm
Groove depth : 2.5 mm
Coolant type : Oil



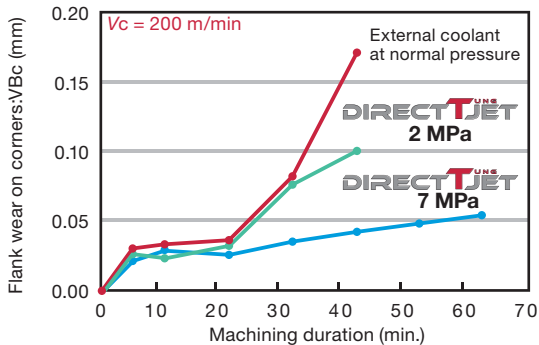
M Stainless steel: Parting -off (SUS304)

Material : SUS304
Holder : JSXXL1212X09-CHP
Insert : JXPG16L20F SH725
Rotation : $V_c = 100$ m/min
Feed rate : $f = 0.03$ mm/rev
Coolant type : Oil

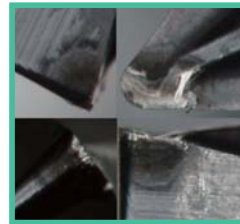


New**DIRECTT^{UNG}JET** system**Tool Wear reduction with DirectTungJet system****M** **Stainless steel: External turning (SUS304)**

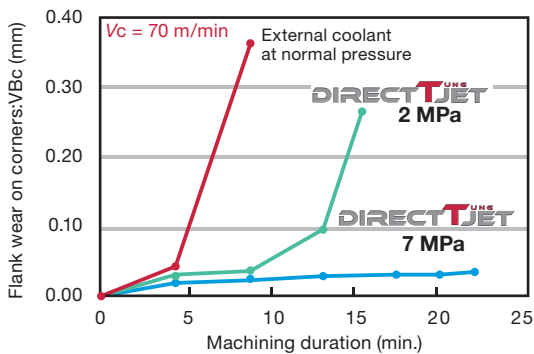
Material : SUS304
 Holder : JSDJ2CR1212X11-CHP
 Insert : DCGT11T302FN-JS SH725
 Cutting speed : $V_c = 200$ m/min
 Feed rate : $f = 0.1$ mm/rev
 Depth of cut : $a_p = 0.5$ mm
 Coolant type : Oil

**J-SERIES****After machining for 40 min.**

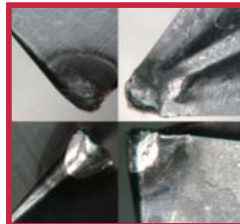
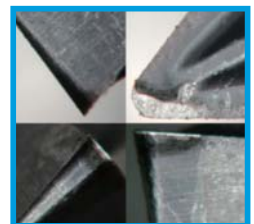
External coolant at normal pressure

**DIRECTT^{UNG}JET (2 MPa)****DIRECTT^{UNG}JET (7 MPa)****S** **Titanium alloy: External turning (Ti-6Al-4V)**

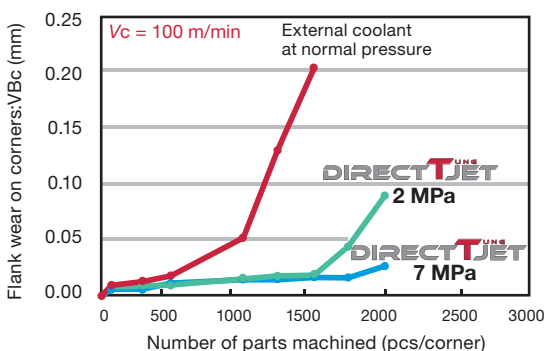
Material : Ti-6Al-4V
 Holder : JSDJ2CR1212X11-CHP
 Insert : DCGT11T302FN-JS SH725
 Cutting speed : $V_c = 70$ m/min
 Feed rate : $f = 0.1$ mm/rev
 Depth of cut : $a_p = 0.5$ mm
 Coolant type : Oil

**J-SERIES****After machining for 10 min.**

External coolant at normal pressure

**DIRECTT^{UNG}JET (2 MPa)****DIRECTT^{UNG}JET (7 MPa)****M** **Stainless steel: Parting -off (SUS304)**

Material : SUS304
 Holder : JSXXL1212X09-CHP
 Insert : JXPG16L20F SH725
 Work dia : $\phi 16$
 Cutting speed : $V_c = 100$ m/min
 Feed rate : $f = 0.03$ mm/rev
 Coolant type : Oil

**DUOJUST**

External coolant at normal pressure

**DIRECTT^{UNG}JET (2 MPa)****DIRECTT^{UNG}JET (7 MPa)**

When using with the DirectTungJet system

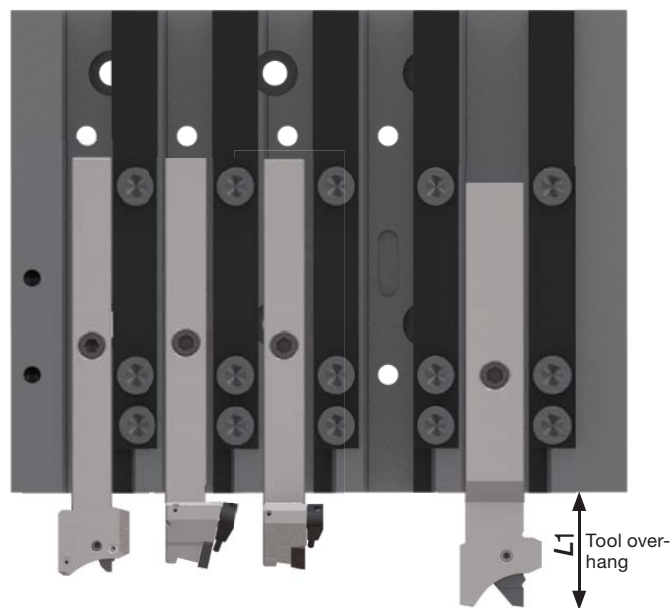
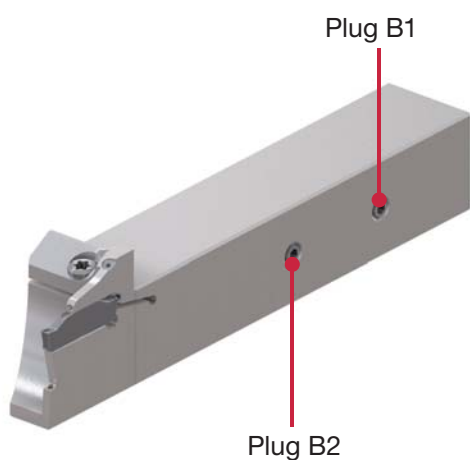
- Adjust the tool overhang length as specified in Table1 below.
- Remove the plug as specified in Table 1 below when using with the directl coolant system.

Table1

Machine model	Tool settings for a 20 x 20 mm square shank ⁽¹⁾		Tool settings for a 16 x 16 mm square shank ⁽¹⁾		Tool settings for a 12 x 12 mm square shank	
	Overhang L1 (mm)	Coolant plug to remove	Overhang L1 (mm)	Coolant plug to remove	Overhang L1 (mm)	Coolant plug to remove
L20	-	-	30	B1	20 ⁽²⁾	B1
D25	25	B1	25	B1	-	-

(1): 20 x 20 mm and 16 x 16 mm square shanks of DuoJustCut and TungCut have both Plug B1 and Plug B2 on the shank body. Others have only Plug B1.

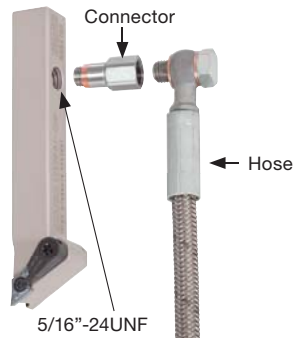
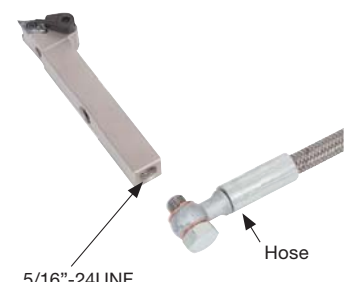
(2): The overhang length for the 12 x 12 mm TungCut shank should be 30 mm. (used in Tool Post #1 only)



Connecting tools (with hoses)

Requires external coolant subassembly

For small lathes (J-type)

Designation	Toolholders for Direct Tung Jet		
Shank size	≤ 16 mm		
Connection	Back	Front	Back end
Example of connection			
Connector for toolholder	CHP-CONNECTOR5/16-G1/8	-	-
Hose	CHP-HOSE-G1/8-7/16-200BS ⁽¹⁾	-	CHP-HOSE-5/16-7/16-200BS ⁽¹⁾
	CHP-HOSE-G1/8-7/16-250BS ⁽¹⁾	-	-
	CHP-HOSE-G1/8-G1/8-200BB ⁽²⁾	-	-
	CHP-HOSE-G1/8-G1/8-250BB ⁽²⁾	-	-
Connector for machine ⁽³⁾	CHP-NIPPLE-G1/8-7/16UNF	-	CHP-NIPPLE-G1/8-7/16UNF
Washer for machine ⁽³⁾	CHP-COPPER-SEAL1/8	-	CHP-COPPER-SEAL1/8

(1): The tube thread type on the machine side is 7/16" -20UNF, female thread.

Therefore, use both Nipple (3) and Washer (3) to connect to the machine G1/8 femail thread.

(2): The thread type on the machine side is G1/8" -28 BSPP, male thread.

Requires external coolant subassembly

High pressure coolant provides excellent chip control for difficult-to-cut materials

Short chips formed in machining of Inconel, titanium and other heat-resistant alloys



TUNGTURNJET 7 MPa

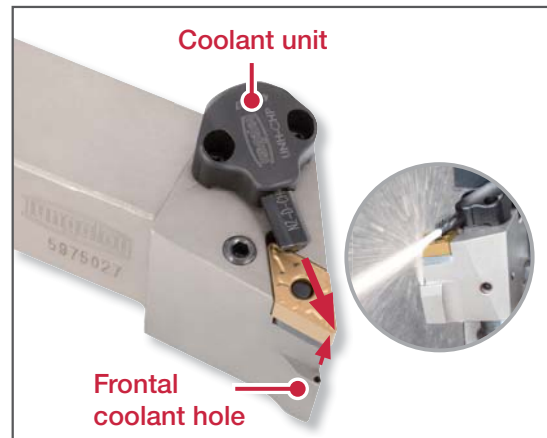


Normal pressure coolant
(External supply)



Coolant from two directions maximizes productivity and drastically reduces tooling cost

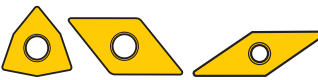
- Up to 200% increase in cutting speed when machining heat-resistant alloys
- Tool life increases even when machining alloy steel or stainless steel
- Nozzle tube delivers coolant directly to the cutting edge



High pressure coolant disperses the cutting heat during machining, which prevents damage on cutting edges

Optimized nozzle tube designs for different insert types increases machining stability

Coolant flow rates

Insert type	Coolant hole	Coolant unit	Flow rate l/min.		
			7 MPa	10 MPa	14 MPa
		CU-CW-CHP	17	20	24
		CU-D-CHP	16	19	22
 Tools for small lathes		S-CU-CHP	4	4.8	5.7
Frontal coolant hole		-	1.8 - 2.6	2.1 - 3.4	2.5 - 3.6

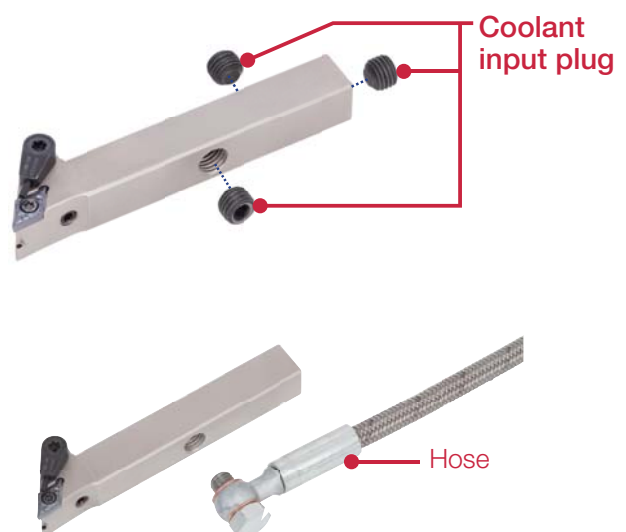
Simple coolant subassembly for easy connection

Easy set-up for high pressure internal coolant

For general lathes



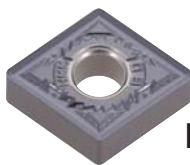
For small lathes



Excellent chip control with high pressure coolant

S

Heat-resistant alloys
(Inconel 718)



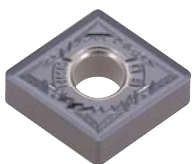
HMM

Toolholder : PCLNL2525M12-CHP
Insert : CNMG120408-HMM AH905
Cutting speed : $V_c = 60$ m/min
Feed : $f = 0.2$ mm/rev
Depth of cut : $a_p = 1$ mm

TUNG ^{TURN} TJET 14 MPa	TUNG ^{TURN} TJET 7 MPa	Normal pressure coolant 1.5 MPa
		

S

Titanium alloys
(Ti-6Al-4V)



HMM

Toolholder : PCLNL2525M12-CHP
Insert : CNMG120408-HMM AH905
Cutting speed : $V_c = 60$ m/min
Feed : $f = 0.25$ mm/rev
Depth of cut : $a_p = 2$ mm

TUNG ^{TURN} TJET 14 MPa	TUNG ^{TURN} TJET 7 MPa	Normal pressure coolant 1.5 MPa
		

M

Stainless steel
(SUS304 / X5CrNi18-9)



SM

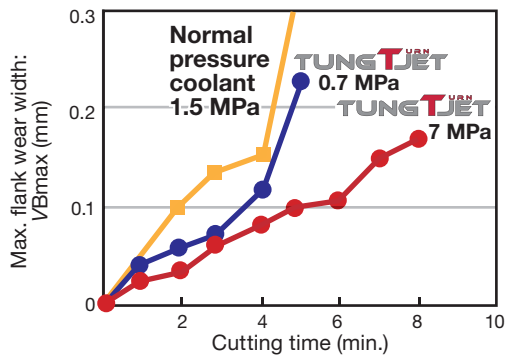
Toolholder : PCLNL2525M0904-CHP
Insert : CNMG090408E-SM T6120
Cutting speed : $V_c = 150$ m/min
Feed : $f = 0.1$ mm/rev
Depth of cut : $a_p = 1$ mm

TUNG ^{TURN} TJET 14 MPa	TUNG ^{TURN} TJET 7 MPa	Normal pressure coolant 1.5 MPa
		

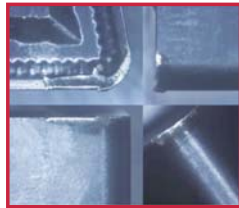
Drastically improved tool life with high pressure coolant

S Heat-resistant alloys (Inconel 718)

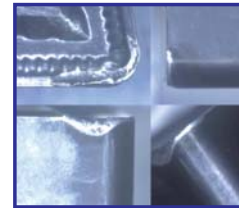
Toolholder : PCLNL2525M12-CHP
Insert : CNMG120408-HMM AH905
Cutting speed : $V_c = 50$ m/min
Feed : $f = 0.2$ mm/rev
Depth of cut : $a_p = 2$ mm



TUNG T_{JET}
7 MPa (5 min.)



TUNG T_{JET}
0.7 MPa (5 min.)

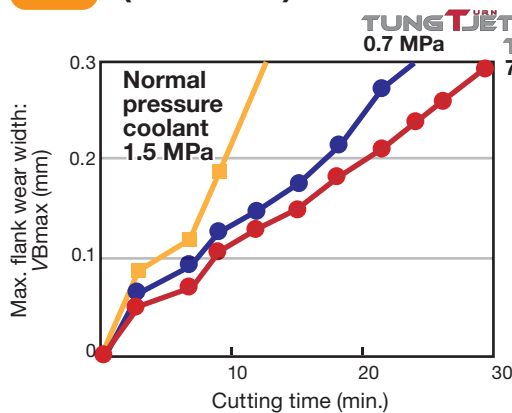


Normal pressure coolant (5 min.)



S Titanium alloys (Ti-6Al-4V)

Toolholder : PCLNL2525M12-CHP
Insert : CNMG120408-HMM AH905
Cutting speed : $V_c = 120$ m/min
Feed : $f = 0.15$ mm/rev
Depth of cut : $a_p = 0.25$ mm



TUNG T_{JET}
7 MPa (20 min.)



TUNG T_{JET}
0.7 MPa (20 min.)

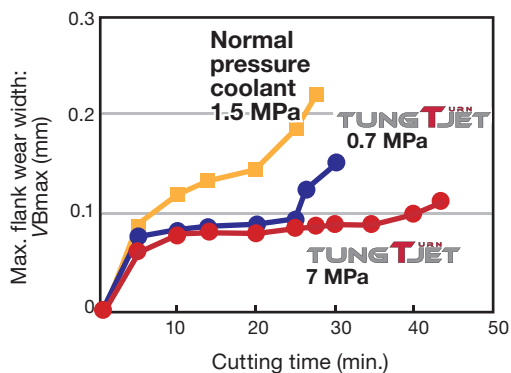


Normal pressure coolant (15 min.)



M Stainless steel (SUS304 / X5CrNi18-9)

Toolholder : PCLNL2525M0904-CHP
Insert : CNMG090408E-SM T6120
Cutting speed : $V_c = 200$ m/min
Feed : $f = 0.3$ mm/rev
Depth of cut : $a_p = 2$ mm



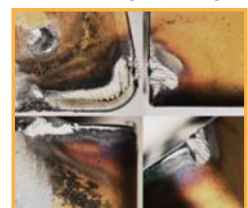
TUNG T_{JET}
7 MPa (30 min.)



TUNG T_{JET}
0.7 MPa (30 min.)



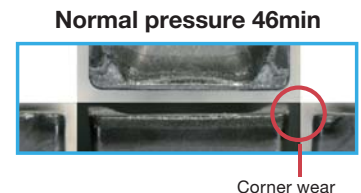
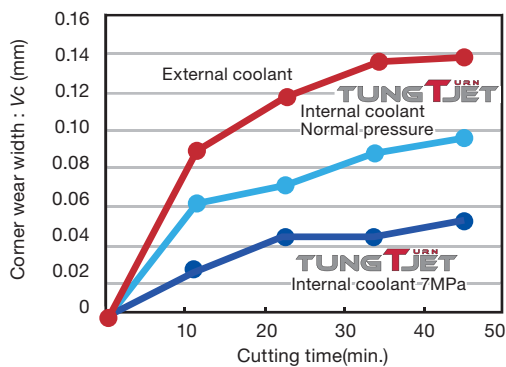
Normal pressure coolant (27 min.)



Drastically improved tool life with high pressure coolant

P Steel : External grooving
(S45C / C45 , 245HB)

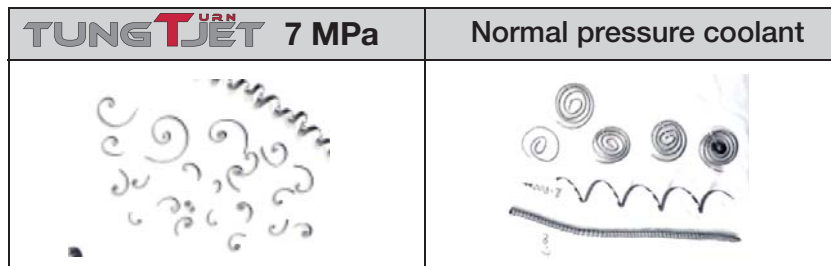
Material : S45C
Toolholder : CHSL2525-CHP + CAEL-3T20-CHP
Insert : DGM3-020 AH7025
Cutting speed : $V_c = 180$ m/min
Feed : $f = 0.12$ mm/rev
Groove width : $CW = 3$ mm



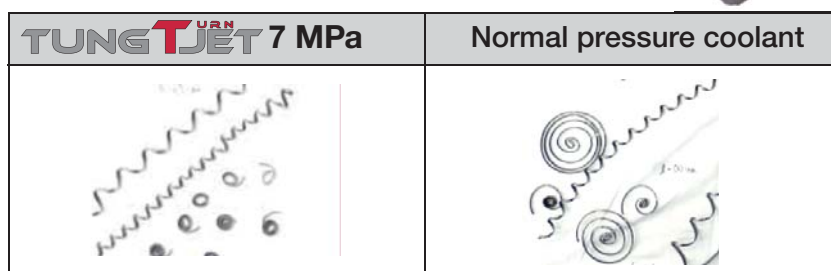
Excellent chip control with high pressure coolant

P Steel : External Grooving
(S45C / C45 , 245HB)

DGS



DTX



Material : S45C
Holder : CHSL2525-CHP + CAEL-3T20-CHP
Insert : DGS3-020 AH7025
DTX3-030 AH7025
Cutting speed : $V_c = 180$ m/min
Feed rate : $f = 0.05$ mm/rev
Groove width : $CW = 3$ mm

Excellent chip control with high pressure coolant

S Titanium alloy : Grooving
(Ti-6Al-4V)

DGS



Material : Inconel718
Holder : C6CHSL45050 + CAEL-3T20-CHP
Insert : DGS3-020 AH7025
DGG300-020 KS05F
Cutting speed : $V_c = 40$ m/min
Feed rate : $f = 0.05$ mm/rev
Groove width : CW = 3 mm

TUNG T _{URN} JET 7 MPa	Normal pressure coolant

DGG



TUNG T _{URN} JET 7 MPa	Normal pressure coolant

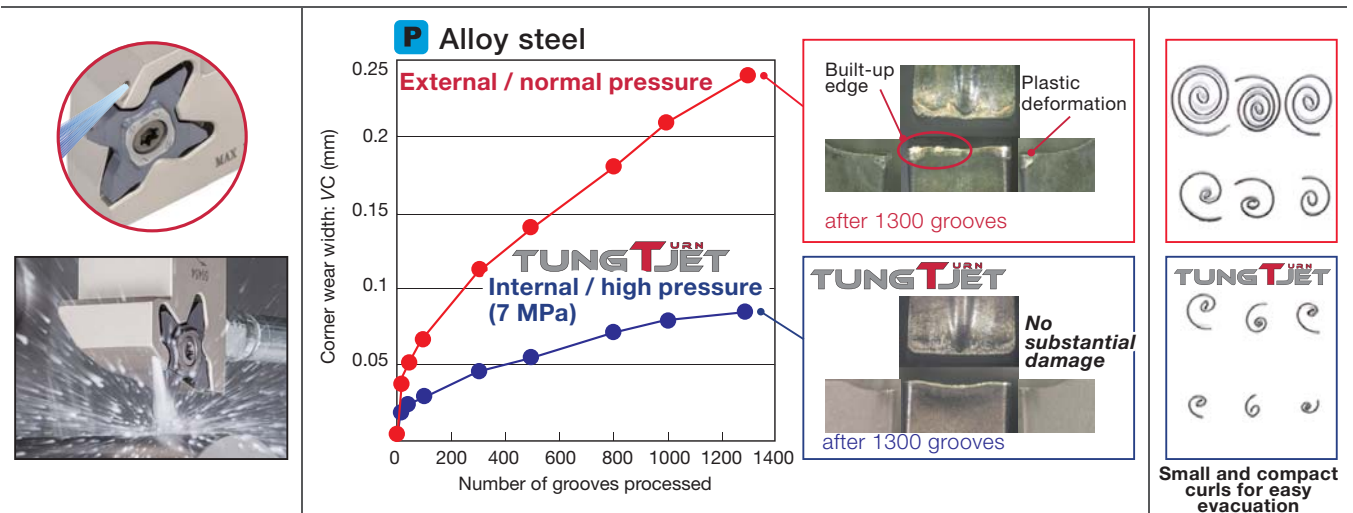
Benefits of using high pressure coolant

Coolant pressure comparison

Workpiece material : STCR2525-27-CHP
Toolholder : TCS27-200-020 AH725
Insert : SCM440 / 42CrMo4
Cutting speed : $V_c = 180$ m/min
Feed : $f = 0.12$ mm/rev
Groove width : CW = 2 mm
Groove depth : ar = 5 mm

Tool life

Chip form



DIRECT^{UNG}TJET



J-SERIES **New**

General ISO external turning series

 Without offset

P.20



MINI^{FORCE}TURN **New**

OD turning tool series, with double-sided insert in light cutting geometry

 Without offset

P.21



TETRA^MCUT **New**

External grooving and threading tools, with 4 cutting edged insert with secure clamping

 Without offset

P.23



TUNG^{CUT} **New**

External grooving and parting tools, with secure insert clamping

 Without offset

P.23



DUO^{JUST}CUT **New**

Parting and threading tools, with secure insert clamping

 Without offset

P.24



TUNG^{THREAD} **New**

Threading tool, with 3 cutting edged insert

 Without offset

P.25

TUNG^{URN}TJET With coolant tube connection



ISO^{co}ETURN

Economical, general OD turning series



P.26



TUNGTURN

General OD turning series



P.26



TUNG^{New}CUT

External grooving and parting tools, with secure insert clamping



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TETRA^{FORCE}CUT

External grooving tool, with 4 cutting edged insert in chipbreakers with secure clamping



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EASY^{ULTI}MCUT

Face grooving tool, for deep grooving



P.43

Tube connection parts list P.52

TUNG^{URN}TJET With coolant tube connection



For Swiss machines

J-SERIES

General ISO external turning series



Without offset

P.46



For Swiss machines

MINIFORCE

OD turning tool, with double-sided insert in light cutting geometry



Without offset

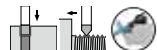
P.47



For Swiss machines

TETRAMCUT **New**

External grooving and threading tools, with 4 cutting edged insert with secure clamping



Without offset

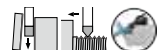
P.48



For Swiss machines

DUOJUST **New**

Parting and threading tools, with secure insert clamping



Without offset

P.49



For Swiss machines

TUNGTHREAD **New**

Threading tool, with 3 cutting edged insert



Without offset

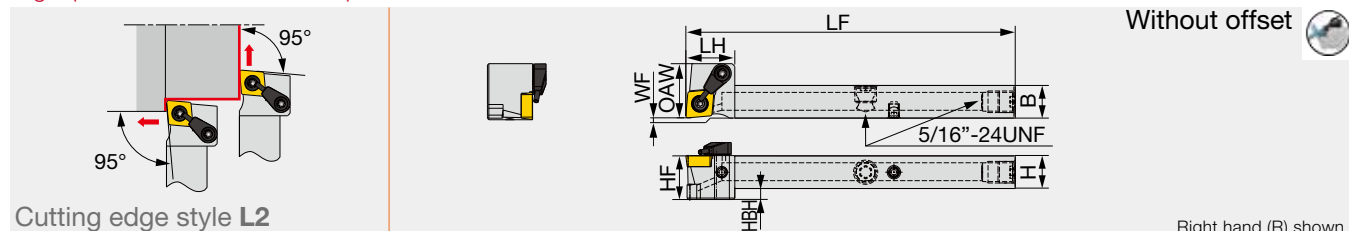
P.50

Tube connection parts list P.52

100

JSCL2CR-CHP

Screw-on toolholder without offset, 95° approach angle for positive 80° rhombic inserts, high pressure coolant compatible



Designation	H	B	LF	LH	HF	HBH	WF	OAW	RE	Insert	Torque*
JSCL2CR1212X09-CHP***	12	12	120	18	12	4	0	20	0.2	CC**09T3	1.2
New JSCL2CR1212X09B-CHP	12	12	120	18	12	1.5	0	20	0.2	CC**09T3	1.2
JSCL2CR1616X09-CHP	16	16	120	18	16	0	0	20	0.2	CC**09T3	1.2

*Torque: Recommended torque (N-m) for clamping **RE: Standard corner radius

Note: Right-hand toolholders (R) are used with right-hand inserts (R). Left-hand toolholders (L) are used with left-hand inserts (L).

***: To be replaced with the new design

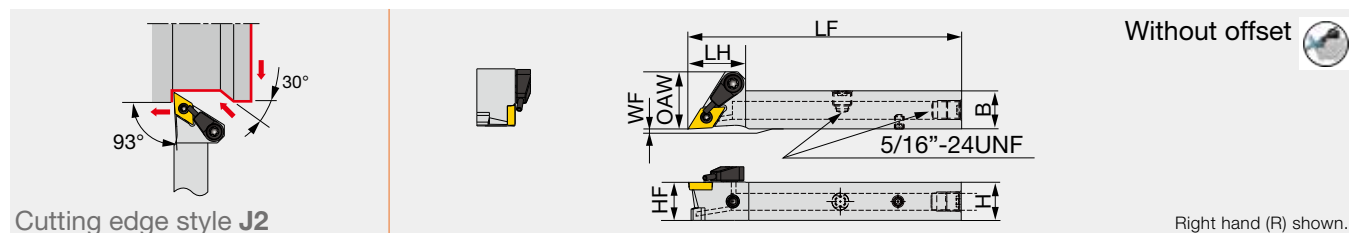
SPARE PARTS

Designation	Clamping screw	Coolant unit	Wrench	Coolant plug	Wrench	DirectJet plug	Wrench
JSCL2CR**-CHP	CSTB-4SD	S-CU-CHP	T-8F	SR5/16UNFTL360	P-4	SSHM4-6-TB	P-2

See page 8 for the proper tool overhang and plug settings.

JSDJ2CR-CHP

Screw-on toolholder without offset, 93° approach angle for positive 55° rhombic inserts, high pressure coolant compatible



Designation	H	B	LF	LH	HF	WF	OAW	RE	Insert	Torque*
JSDJ2CR1212X11-CHP	12	12	120	19	12	0	20.5	0.2	DC**11T3	1.2
JSDJ2CR1616X11-CHP	16	16	120	19	16	0	20.5	0.2	DC**11T3	1.2

*Torque: Recommended torque (N-m) for clamping **re: Standard corner radius

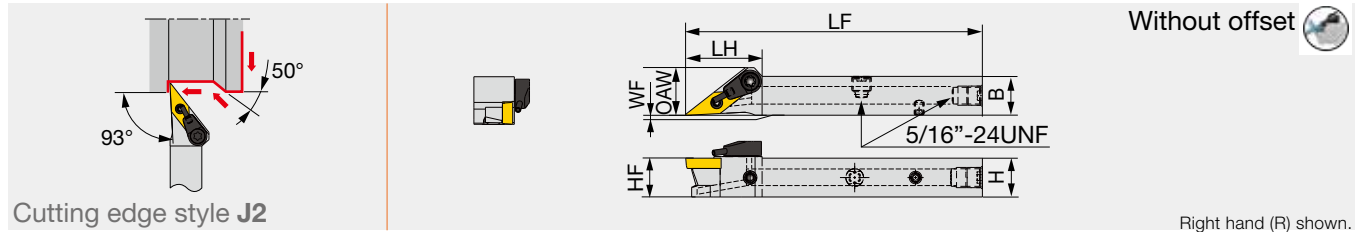
SPARE PARTS

Designation	Clamping screw	Coolant unit	Wrench	Coolant plug	Wrench	DirectJet plug	Wrench
JSDJ2CR**11-CHP	CSTB-4SD	S-CU-CHP	T-8F	SR5/16UNFTL360	P-4	SSHM4-6-TB	P-2

See page 8 for the proper tool overhang and plug settings.

JSVJ2BR-CHP**DIRECTT^{UNE}J-SERIES**

Screw-on toolholder without offset, 93° approach angle for positive 35° rhombic inserts, high pressure coolant compatible



Designation	H	B	LF	LH	HF	WF	OAW	RE	Insert	Torque*
JSVJ2BR1212X11-CHP	12	12	120	23.6	12	0	14.7	0.2	VB**1103	1.2
JSVJ2BR1616X11-CHP	16	16	120	23.6	16	0	16	0.2	VB**1103	1.2

*Torque: Recommended torque (N-m) for clamping **RE: Standard corner radius

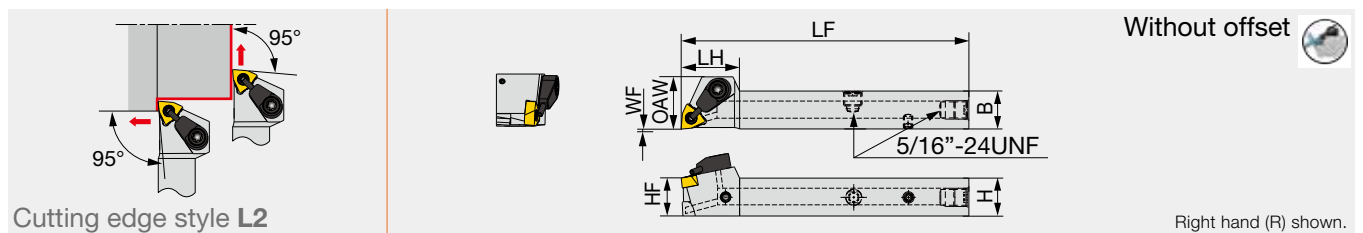
SPARE PARTS

Designation	Clamping screw	Coolant unit	Wrench	Coolant plug	Wrench	DirectJet plug	Wrench
JSVJ2B**11-CHP	CSTB-2.5	S-CU-CHP	T-8F	SR5/16UNFTL360	P-4	SSH4-6-TB	P-2

See page 8 for the proper tool overhang and plug settings.

JSWL2XR-CHP**DIRECTT^{UNE} MINIF^{ORCE}TURN**

Screw-on toolholder without offset, 95° approach angle, for WXGU inserts, high pressure coolant compatible



Designation	H	B	LF	LH	HF	WF	OAW	RE**	Insert	Torque*
JSWL2XR1212X04-CHP	12	12	120	18.5	12	0	16.5	0.2	WXGU0403**L	0.9
JSWL2XR1616X04-CHP	16	16	120	18.5	16	0	16.5	0.2	WXGU0403**L	0.9

*Torque: Recommended torque (N-m) for clamping **RE: Standard corner radius

Note: Right-hand toolholders (R) are used with left-hand inserts (L).

SPARE PARTS

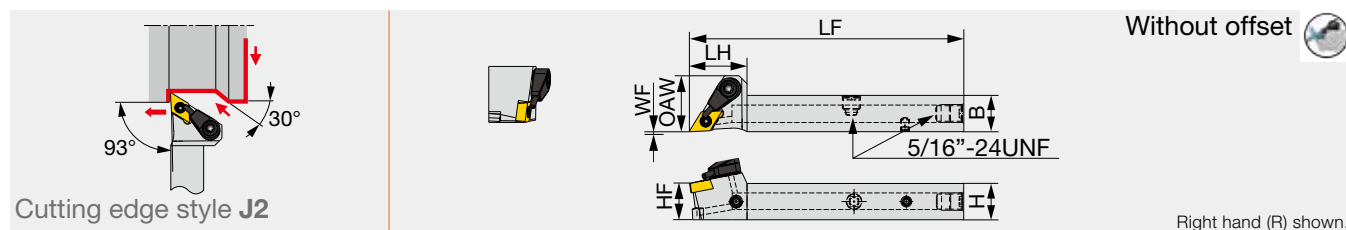
Designation	Clamping screw	Coolant unit	Wrench	Coolant plug	Wrench	DirectJet plug	Wrench
JSWL2XR**04-CHP	SR34-514	S-CU-CHP	T-7F	SR5/16UNFTL360	P-4	SSH4-6-TB	P-2

See page 8 for the proper tool overhang and plug settings.

JSDJ2XR-CHP

DIRECTT^{UNE}JET MINIF^{ORCE}TURN

Screw-on toolholder without offset, 93° approach angle, for DXGU inserts, high pressure coolant compatible



Designation	H	B	LF	LH	HF	WF	OAW	RE**	Insert	Torque*
JSDJ2XR1212X07-CHP	12	12	120	19	12	0	18.5	0.2	DXGU0703**L	0.9
JSDJ2XR1616X07-CHP	16	16	120	19	16	0	18.5	0.2	DXGU0703**L	0.9

*Torque: Recommended torque (N-m) for clamping **RE: Standard corner radius
Note: Right-hand toolholders (R) are used with left-hand inserts (L).

SPARE PARTS

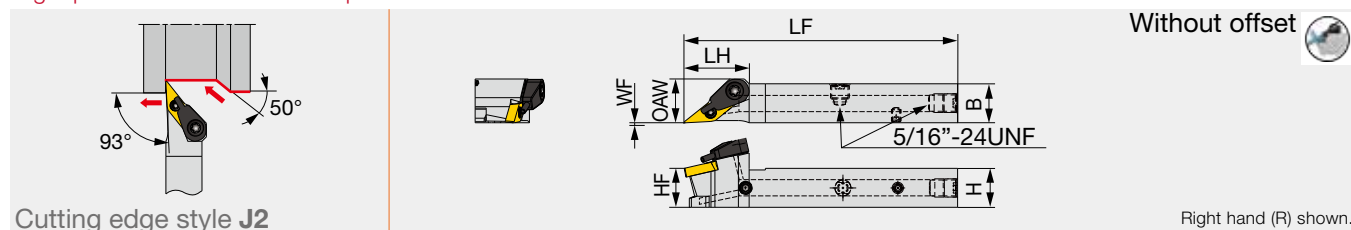
Designation	Clamping screw	Coolant unit	Wrench	Coolant plug	Wrench	DirectJet plug	Wrench
JSDJ2XR**07-CHP	SR34-514	S-CU-CHP	T-7F	SR5/16UNFTL360	P-4	SSHM4-6-TB	P-2

See page 8 for the proper tool overhang and plug settings.

JSVJ2XR-CHP

DIRECTT^{UNE}JET MINIF^{ORCE}TURN

Screw-on toolholder without offset, 93° approach angle, for VXGU inserts, high pressure coolant compatible



Designation	H	B	LF	LH	HF	WF	OAW	RE**	Insert	Torque*
JSVJ2XR1212X09-CHP	12	12	120	19.5	12	0	13.4	0.2	VXGU09T2**L	0.9
JSVJ2XR1616X09-CHP	16	16	120	19.5	16	0	16	0.2	VXGU09T2**L	0.9

*Torque: Recommended torque (N-m) for clamping **RE: Standard corner radius
Note: Right-hand toolholders (R) are used with left-hand inserts (L).

SPARE PARTS

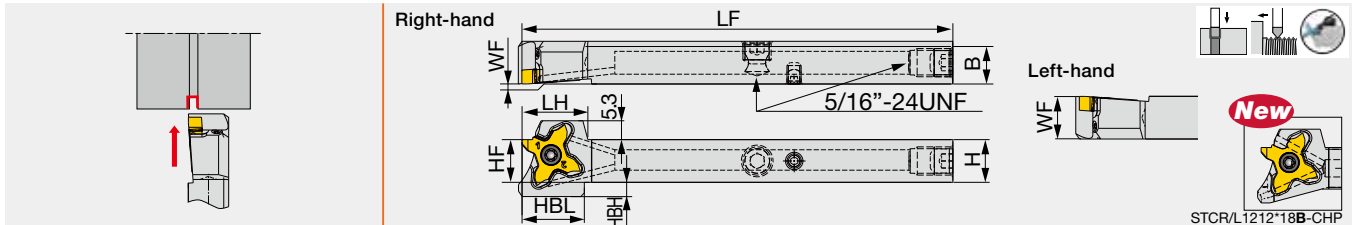
Designation	Clamping screw	Coolant unit	Wrench	Coolant plug	Wrench	DirectJet plug	Wrench
JSVJ2XR**F09-CHP	SR34-508	S-CU-CHP	T-7F	SR5/16UNFTL360	P-4	SSHM4-6-TB	P-2

See page 8 for the proper tool overhang and plug settings.

STCR/L-18-CHP

DIRECTT^{UNE}JET TETRAMCUT

External grooving and threading toolholder, high pressure coolant compatible



Designation	CW	H	B	LF	LH	HBL	HF	WF	HBH	Insert	Torque*
STCR/L1212X18-CHP***	0.33 - 3	12	12	120	18.5	17.5	12	0/12	4	TC**18	1.2
New STCR/L1212X18B-CHP	0.33 - 3	12	12	120	18.5	17.5	12	0/12	4	TC**18	1.2
STCR/L1616X18-CHP	0.33 - 3	16	16	120	18.5	-	16	0/16	0	TC**18	1.2

• The right hand insert (TC*18R**) is used for the right hand toolholders (STCR**), and the left hand insert (TC*18L**) is used for the left hand toolholders (STCL**).

*Torque: Recommended torque (N-m) for clamping

***: To be replaced with the new design

SPARE PARTS

Designation	Clamping screw	Wrench	Coolant plug	Wrench	DirectJet plug	Wrench
STCL**18-CHP	CSTC-4L100DR	T-1008/5	SR5/16UNFTL360	P-4	SSH4-6-TB	P-2
STCR**18-CHP	CSTC-4L100DL	T-1008/5	SR5/16UNFTL360	P-4	SSH4-6-TB	P-2

Groove width range : 0.33 ~ 3.0 mm

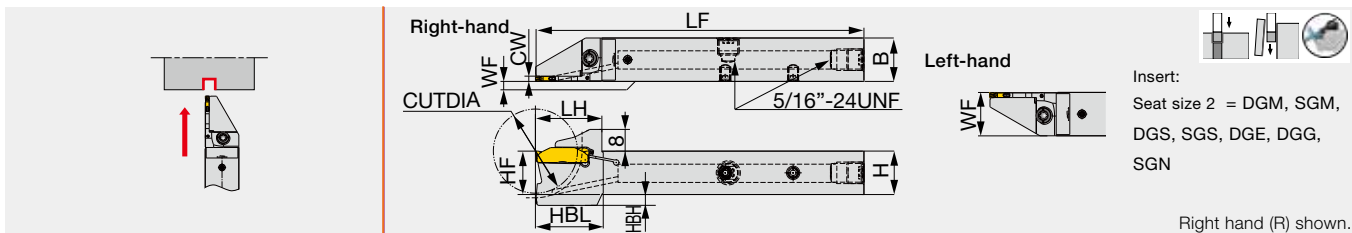
Threading pitch range : 0.8 ~ 3.0 mm

See page 8 for the proper tool overhang and plug settings.

JCTER/L-CHP

DIRECTT^{UNE}JET TUNG CUT

External grooving and parting-off toolholder, high pressure coolant compatible



Designation	CW	Seat size	CUTDIA	H	B	LF	LH	HBL	HF	WF ⁽¹⁾	HBH	Torque*
JCTER/L1212X2T12-CHP	2	2	25	12	12	120	24.5	25.4	12	0/12	5	3.0
New JCTER/L1616X2T12-CHP	2	2	25	16	16	120	24.5	25.4	16	0/16	1	3.0
JCTER/L1616X2T16-CHP	2	2	32	16	16	120	24.5	25.4	16	0/16	4	3.0
JCTER/L2020X2T16-CHP	2	2	32	20	20	120	24.5	25.4	20	0/20	0	3.0

(1) "WF" value is calculated with groove width "CW" shown in the table. • CUTDIA: Max. parting off dia.

*Torque: Recommended torque (N-m) for clamping

SPARE PARTS

Designation	Clamping screw	Wrench	Coolant plug	Wrench	DirectJet plug	Wrench
JCTER/L...	CSHB-4-A	T-15F	SR5/16UNFTL360	P-4	SSH4-6-TB	P-2

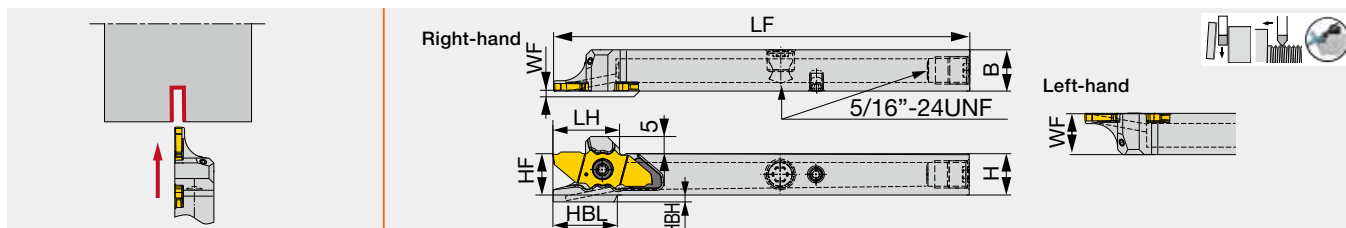
Parting-off width : 2.0 mm

See page 8 for the proper tool overhang and plug settings.

JSXXR/L-CHP

DIRECTTJET DUOJUST

Parting and threading toolholder, high pressure coolant compatible



Designation	CW	H	B	WF	LF*	HF	HBH	LH	HBL	Insert	Torque*
JSXXR/L1212X09-CHP	1 - 2	12	12	0.2/11.8	≤ 120	12	2	≤ 19.4	18.8	JX*G06...,12...,16..., 20...	1.2
JSXXR/L1616X09-CHP***	1 - 2	16	16	0.2/15.8	≤ 120	16	2.5	≤ 19.4	18.7	JX*G06...,12...,16..., 20...	1.2
New JSXXR/L1616X09B-CHP	1 - 2	16	16	0.2/15.8	≤ 120	16	0	≤ 19.4	18.7	JX*G06...,12...,16..., 20...	1.2

*Torque: Recommended torque (N·m) for clamping

LF (Functional Length) LH (Head Length), and HBL (Head-bottom Offset Length) values shown above are true with JXPG16* insert. LF, LH, and HBL will all be 2 mm shorter than the above values with JX*G12** and JXPG20*** inserts, and 4 mm shorter for JXPG06*** insert.

***To be replaced with the new design

Note: Use the right-hand insert (JX*G**R**) for a right-hand holder (JSXXR**); the left-hand insert (JX*G**L**) for a left-hand holder (JSXXL**).

SPARE PARTS

Designation	Clamping screw	Wrench	Coolant plug	Wrench	DirectJet plug	Wrench
JSXXR...	CSTC-4L100DL	T-1008/5	SR5/16UNFTL360	P-4	SSHM4-6-TB	P-2
JSXXL...	CSTC-4L100DR	T-1008/5	SR5/16UNFTL360	P-4	SSHM4-6-TB	P-2

Parting-off widths : 1.0 mm and 1.5 mm (for a max parting diameter of ø6 mm)

: 1.5 mm and 2.0 mm (for max parting diameters of ø12 mm, ø16 mm, ø20mm)

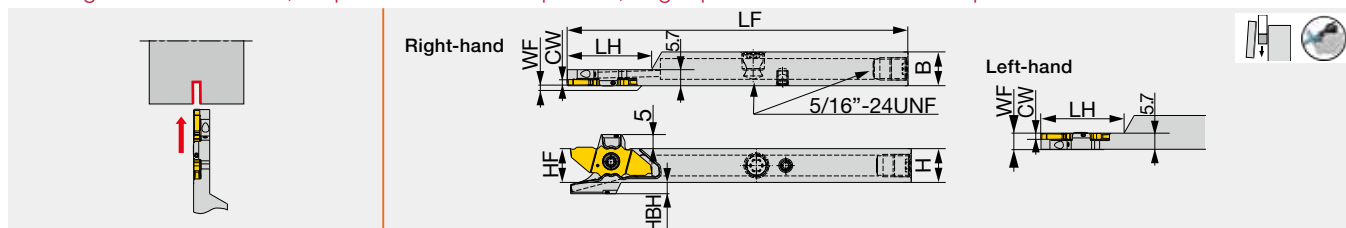
Threading pitch range : 0.2 ~ 1.5 mm

See page 8 for the proper tool overhang and plug settings.

JSXXR/L-S-CHP

DIRECTTJET DUOJUST

Parting-off tool holder, capable with sub spindle, high-pressure coolant compatible



Designation	CW	H	B	WF	LF*	HF	HBH	LH	Insert	Torque*
JSXXR/L1212X09-S-CHP***	1 - 2	12	12	0.2/5.5	≤ 85	12	4	30	JX*G06...,12...,16..., 20...	1.2
New JSXXR/L1212X09B-S-CHP	1 - 2	12	12	0.2/5.5	≤ 85	12	2	30	JX*G06...,12...,16..., 20...	1.2
JSXXR/L1616X09-S-CHP***	1 - 2	16	16	0.2/5.5	≤ 120	16	1.5	30	JX*G06...,12...,16..., 20...	1.2
New JSXXR/L1616X09B-S-CHP	1 - 2	16	16	0.2/5.5	≤ 120	16	0	30	JX*G06...,12...,16..., 20...	1.2

*Torque: Recommended torque (N·m) for clamping

LF (Overall Tool Length) and LH (Head Length) values shown above are true with JXPG16* insert. Both LF and LH will be 2 mm shorter than the above value with JX*G12** and JXPG20*** inserts; 4 mm shorter with JXPG06*** insert.

***To be replaced with the new design

Note: Use the right-hand insert (JX*G**R**) for a right-hand holder (JSXXR**); the left-hand insert (JX*G**L**) for a left-hand holder (JSXXL**).

SPARE PARTS

Designation	Clamping screw	Wrench	Coolant plug	Wrench	DirectJet plug	Wrench
JSXXR**09-S-CHP	CSTC-4L055DL	T-1008/5	SR5/16UNFTL360	P-4	SSHM4-6-TB	P-2
JSXXL**09-S-CHP	CSTC-4L055DR	T-1008/5	SR5/16UNFTL360	P-4	SSHM4-6-TB	P-2

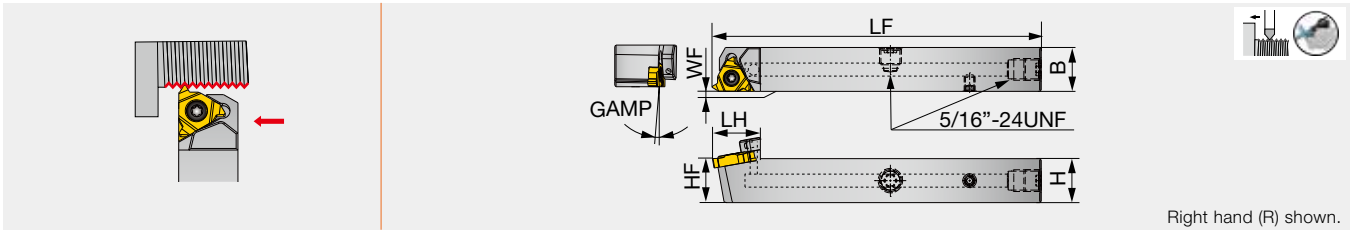
Parting-off widths : 1.0 mm and 1.5 mm (for a max parting diameter of ø6 mm)

: 1.5 mm and 2.0 mm (for max parting diameters of ø12 mm, ø16 mm, ø20mm)

See page 8 for the proper tool overhang and plug settings.

JSER-16-CHP

External threading. High-pressure coolant capability, including DirectTungJet system.



Designation	H	B	LF	LH	HF	WF	GAMP	Insert
JSE2R1212X16-CHP	12	12	120	19	12	0	1°	16ER...
JSE2R1616X16-CHP	16	16	120	19	16	0	1°	16ER...

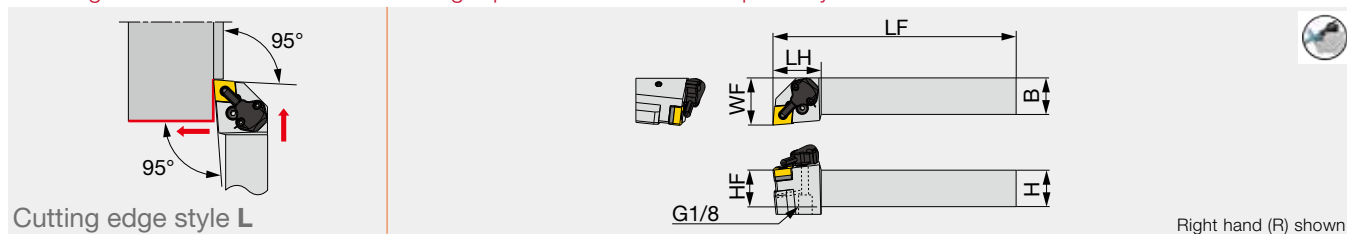
						
Designation	Clamping screw	Wrench	Coolant plug	Wrench	DirectJet plug	Wrench
JSE2R**16-CHP	CSTB-3.5	T-15F	SR5/16UNFTL360	P-4	SSH4-6-TB	P-2

See page 8 for the proper tool overhang and plug settings.

PCLNR/L-CHP

Lever lock toolholders – 95° approach angle.

For negative 80° rhombic insert. High-pressure coolant capability.



ISO^{ET}TURN

Designation	H	B	LF	LH	HF	WF	RE**	Insert	Torque*
PCLNR/L2020K0904-CHP	20	20	125	33	20	32	0.8	CN**0904...	2
PCLNR/L2525M0904-CHP	25	25	150	33	25	32	0.8	CN**0904...	2

*Torque: Recommended torque (N·m) for clamping

**RE: Standard corner radius

TUNGTURN

Designation	H	B	LF	LH	HF	WF	RE**	Insert	Torque*
PCLNR/L2020K12-CHP	20	20	125	33	20	32	0.8	CN**1204...	3
PCLNR/L2525M12-CHP	25	25	150	33	25	32	0.8	CN**1204...	3

*Torque: Recommended torque (N·m) for clamping

**RE: Standard corner radius

SPARE PARTS

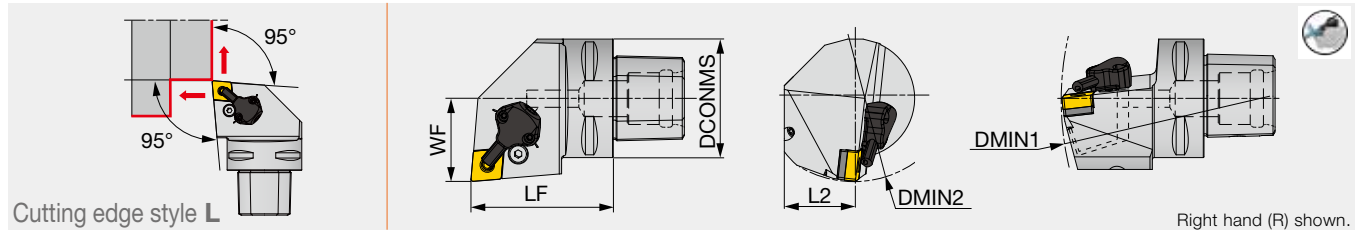
Designation	Shim	Clamping screw	Wrench 1	Spring pin	Lever
PCLNR/L**0904-CHP	LSC317	LCS3	P-2.5	LSP3	LCL33
PCLNR/L**12-CHP	LSC42	LCS4	P-3	LSP4	LCL4

SPARE PARTS

Designation	Coolant unit	Mounting screw	Wrench 2	O-ring	Coolant screw	Wrench 3
PCLNR/L**0904-CHP	CU-CW-CHP	SRM3	T-8F	OR6.4X0.9N	SRM4X4TL360	P-2
PCLNR/L**12-CHP	CU-CW-CHP	SRM3	T-8F	OR6.4X0.9N	SRM4X4TL360	P-2

C-PCLNR/L-CHP**ISO^{ET}TURN TUNG^{CA}P**

Lever lock toolholders with TungCap connection – 95° approach angle.
For negative 80° rhombic insert. High-pressure coolant capability.

**ISO^{ET}TURN**

Designation	DCONMS	LF	L2	WF	DMIN1	DMIN2	RE**	Insert	Torque*
C4PCLNR/L27050-0904-CHP	40	50	27	140	140	110	0.8	CN**0904...	2
C6PCLNR/L45065-0904-CHP	63	65	45	190	190	125	0.8	CN**0904...	2

*Torque: Recommended torque (N·m) for clamping

Applicable for 14 MPa pressure coolant

**RE: Standard corner radius

TUNG^{CA}P

Designation	DCONMS	LF	L2	WF	DMIN1	DMIN2	RE**	Insert	Torque*
C4PCLNR/L27050-12-CHP	40	50	27	140	140	110	0.8	CN**1204...	3
C5PCLNR/L35060-12-CHP	50	60	35	165	165	110	0.8	CN**1204...	3
C6PCLNR/L45065-12-CHP	63	65	45	190	190	125	0.8	CN**1204...	3

*Torque: Recommended torque (N·m) for clamping

Applicable for 14 MPa pressure coolant

**RE: Standard corner radius

SPARE PARTS

Designation	Shim	Clamping screw	Wrench 1	Spring pin	Lever
C*PCLNR/L**0904-CHP	LSC317	LCS3	P-2.5	LSP3	LCL33
C*PCLNR/L**-12-CHP	LSC42	LCS4	P-3	LSP4	LCL4

SPARE PARTS

Designation	Coolant unit	Mounting screw	Wrench 2	O-ring
C*PCLNR/L**0904-CHP	CU-CW-CHP	SRM3	T-8F	OR6.4X0.9N
C*PCLNR/L**-12-CHP	CU-CW-CHP	SRM3	T-8F	OR6.4X0.9N

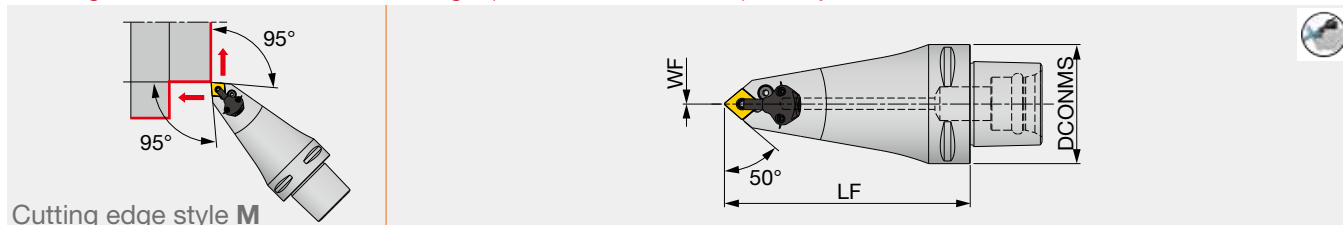
New

C-PCMNN-CHP

TUNGCAP

Lever lock toolholder with TungCap connection.

For negative 80° rhombic insert. High-pressure coolant capability.



Cutting edge style M

Designation	DCONMS	LF	WF	RE**	Insert	Torque*
C6PCMNN00130-12-CHP	63	115	0	0.8	CN**1204...	3

*Torque: Recommended torque (N-m) for clamping

Applicable for 14 MPa pressure coolant

**RE: Standard corner radius

For external turning only.

SPARE PARTS

Designation	Shim	Clamping screw	Wrench 1	Spring pin	Lever
C6PCMNN00130-12-CHP	LSC42	LCS4	P-3	LSP4	LCL4

SPARE PARTS

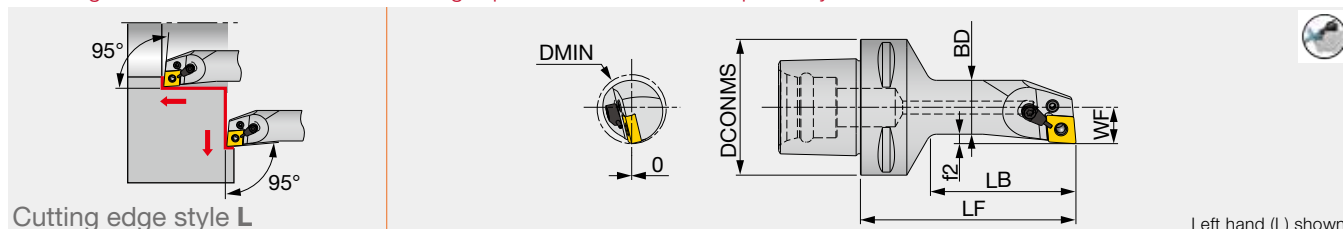
Designation	Coolant unit	Mounting screw	Wrench 2	O-ring
C6PCMNN00130-12-CHP	CU-CW-CHP	SRM3	T-8F	OR6.4X0.9N

C-PCLNL-CHP

TUNGCAP

Lever lock internal toolholder with TungCap connection – 95° approach angle.

For negative 80° rhombic insert. High-pressure coolant capability.



Cutting edge style L

Designation	DMIN	DCONMS	BD	LF	LB	WF	f2	RE**	Insert	Torque*
C6PCLNL17100-12-CHP	32	63	25	100	67.5	17	4.5	0.8	CN**1204...	3

*Torque: Recommended torque (N-m) for clamping

Applicable for 14 MPa pressure coolant

**RE: Standard corner radius

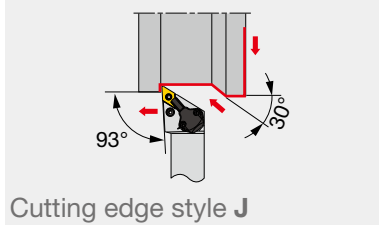
SPARE PARTS

Designation	Clamping screw	Coolant unit	Wrench	Lever
C6PCLNL17100-12-CHP	LCS43	S-CU-CHP	P-2.5F	LCL43N

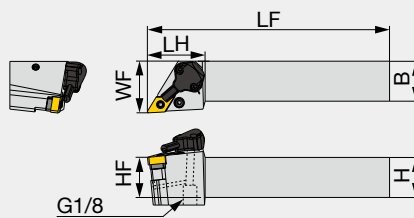
PDJNR/L-CHP**ISO^ETURN TUNGTURN**

Lever lock toolholders – 93° approach angle.

For negative 55° rhombic insert. High-pressure coolant capability.



Cutting edge style J



Right hand (R) shown.

ISO^ETURN

Designation	H	B	LF	LH	HF	WF	RE**	Insert	Torque*
PDJNR/L2020K1104-CHP	20	20	125	36	20	32	0.8	DN**1104...	2
PDJNR/L2525M1104-CHP	25	25	150	36	25	32	0.8	DN**1104...	2

*Torque: Recommended torque (N·m) for clamping

**RE: Standard corner radius

TUNGTURN

Designation	H	B	LF	LH	HF	WF	RE**	Insert	Torque*
PDJNR/L2020K15-CHP	20	20	125	36	20	32	0.8	DN**1504...	3
PDJNR/L2525M15-CHP	25	25	150	36	25	32	0.8	DN**1504...	3

*Torque: Recommended torque (N·m) for clamping

**RE: Standard corner radius

SPARE PARTS

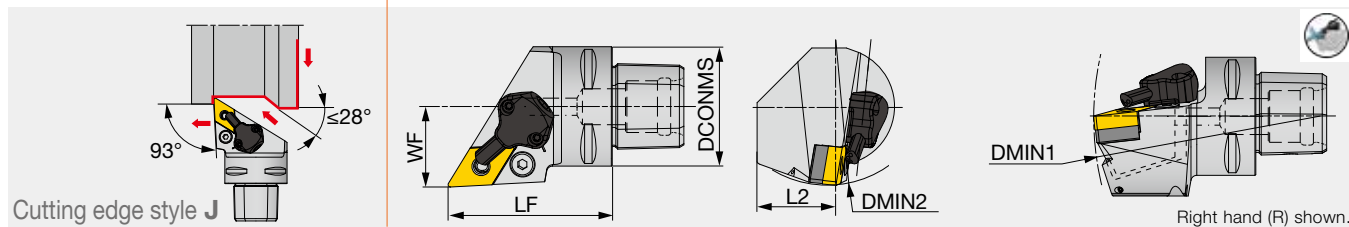
Designation	 Shim	 Clamping screw	 Wrench 1	 Spring pin	 Lever
PDJNR/L**1104-CHP	ELSD32	LCS3	P-2.5	LSP3	LCL33L
PDJNR/L**15-CHP	LSD43A	LCS4	P-3	LSP4	LCL4

SPARE PARTS

Designation	 Coolant unit	 Mounting screw	 Wrench 2	 O-ring	 Coolant screw	 Wrench 3
PDJNR/L**1104-CHP	CU-D-CHP	SRM3	T-8F	OR6.4X0.9N	SRM4X4TL360	P-2
PDJNR/L**15-CHP	CU-D-CHP	SRM3	T-8F	OR6.4X0.9N	SRM4X4TL360	P-2

C-PDJNR/L-CHP

Lever lock toolholders with TungCap connection – 93° approach angle.
For negative 55° rhombic insert. High-pressure coolant capability.



ISO^{ET}URN

Designation	DCONMS	LF	L2	WF	DMIN1	DMIN2	RE**	Insert	Torque*
C4PDJNR/L27050-1104-CHP	40	50	27	140	140	110	0.8	DN**1104...	2
C6PDJNR/L45065-1104-CHP	63	65	45	190	190	110	0.8	DN**1104...	2

*Torque: Recommended torque (N-m) for clamping

Applicable for 14 MPa pressure coolant

**RE: Standard corner radius

TUNGTURN

Designation	DCONMS	LF	L2	WF	DMIN1	DMIN2	RE**	Insert	Torque*
C4PDJNR/L27050-15-CHP	40	50	27	140	140	110	0.8	DN**1504(06)...	3
C5PDJNR/L35060-15-CHP	50	60	35	165	165	110	0.8	DN**1504(06)...	3
C6PDJNR/L45065-15-CHP	63	65	45	190	190	110	0.8	DN**1504(06)...	3

*Torque: Recommended torque (N-m) for clamping

Applicable for 14 MPa pressure coolant

**RE: Standard corner radius

SPARE PARTS

Designation	Shim	Clamping screw	Wrench 1	Spring pin	Lever
C*PDJNR/L**1104-CHP	ELSD32	LCS3	P-2.5	LSP3	LCL33L
C*PDJNR/L**15-CHP	LSD43A	LCS4	P-3	LSP4	LCL4

Option: LSD42A (Shim for DN**1506...), LSP4S (Spring pin for DN**1506...)

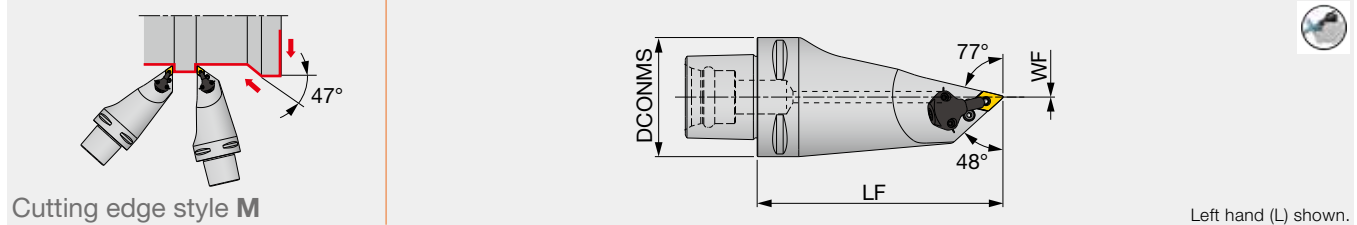
SPARE PARTS

Designation	Coolant unit	Mounting screw	Wrench 2	O-ring
C*PDJNR/L**1104-CHP	CU-D-CHP	SRM3	T-8F	OR6.4X0.9N
C*PDJNR/L**15-CHP	CU-D-CHP	SRM3	T-8F	OR6.4X0.9N

C-PDMNL-CHP

Lever lock toolholder with TungCap connection.

For negative 55° rhombic insert. High-pressure coolant capability.



Designation	DCONMS	LF	WF	RE **	Insert	Torque*
C6PDMNL00130-1104-CHP	63	130	0	0.8	DN**1104...	2

*Torque: Recommended torque (N-m) for clamping

Applicable for 14 MPa pressure coolant

**RE: Standard corner radius

For external turning only.

SPARE PARTS

Designation	Shim	Clamping screw	Wrench 1	Spring pin	Lever
C6PDMNL00130-1104-CHP	ELSD32	LCS3	P-2.5	LSP3	LCL33L

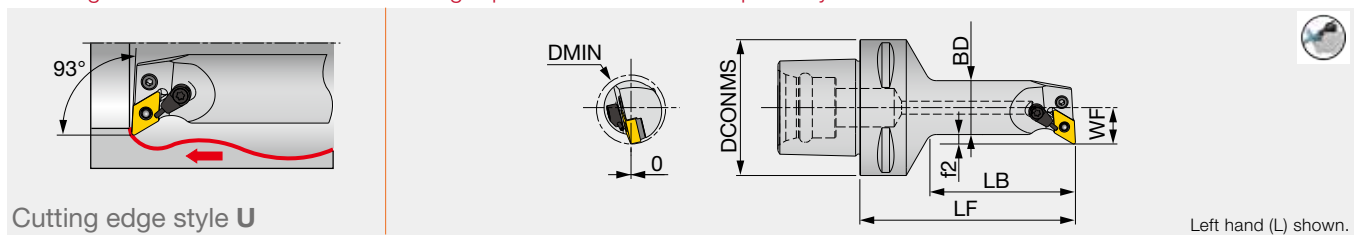
SPARE PARTS

Designation	Coolant unit	Mounting screw	Wrench 2	O-ring
C6PDMNL00130-1104-CHP	CU-D-CHP	SRM3	T-8F	OR6.4X0.9N

C-PDUNL-CHP

Lever lock internal toolholder with TungCap connection – 93° approach angle.

For negative 55° rhombic insert. High-pressure coolant capability.



Designation	DMIN	DCONMS	BD	LF	LB	WF	f2	RE **	Insert	Torque*
C6PDUNL17100-1104-CHP	32	63	25	100	67.5	17	4.5	0.8	DN**1104...	2

*Torque: Recommended torque (N-m) for clamping

Applicable for 14 MPa pressure coolant

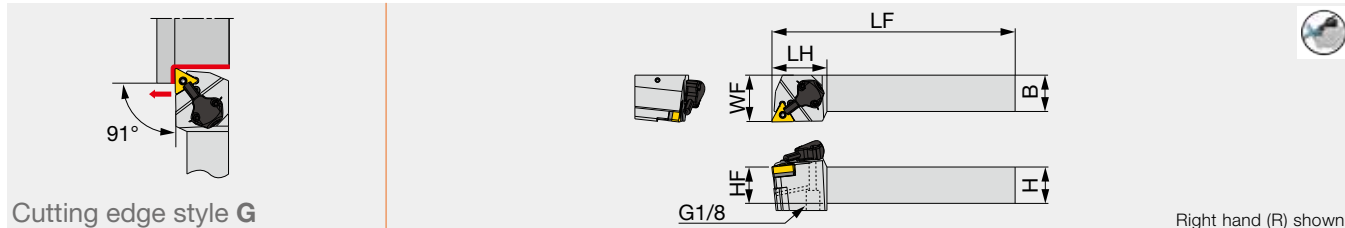
**RE: Standard corner radius

SPARE PARTS

Designation	Shim	Clamping screw	Coolant unit	Wrench	Spring pin	Lever
C6PDUNL17100-1104-CHP	ELSD317BL	LCS43	S-CU-CHP	P-2.5	LSP3	LCL33L

PTG NR/L-CHP

Lever lock toolholders – 91° approach angle.
For negative triangle insert. High-pressure coolant capability.



Cutting edge style G

Right hand (R) shown.

ISO TURN

Designation	H	B	LF	LH	HF	WF	RE**	Insert	Torque*
PTG NR/L2020K1104-CHP	20	20	125	38	20	32	0.8	TN**1104...	2
PTG NR/L2525M1104-CHP	25	25	150	38	25	32	0.8	TN**1104...	2

*Torque: Recommended torque (N·m) for clamping

**RE: Standard corner radius

TUNGTURN

Designation	H	B	LF	LH	HF	WF	RE**	Insert	Torque*
PTG NR/L2020K16-CHP	20	20	125	38	20	32	0.8	TN**1604...	2
PTG NR/L2525M16-CHP	25	25	150	38	25	32	0.8	TN**1604...	2

*Torque: Recommended torque (N·m) for clamping

**RE: Standard corner radius

SPARE PARTS

Designation					
PTG NR/L**1104-CHP	-	LCS23A	P-2.5	LSP3	LCL23
PTG NR/L**16-CHP	LST317	LCS3	P-2.5	LSP3	LCL3

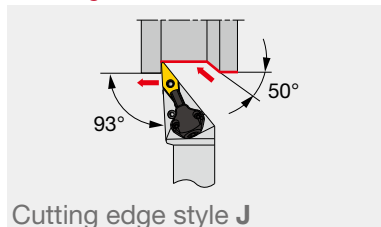
SPARE PARTS

Designation						
PTG NR/L**1104-CHP	CU-CW-CHP	SRM3	T-8F	OR6.4X0.9N	SRM4X4TL360	P-2
PTG NR/L**16-CHP	CU-CW-CHP	SRM3	T-8F	OR6.4X0.9N	SRM4X4TL360	P-2

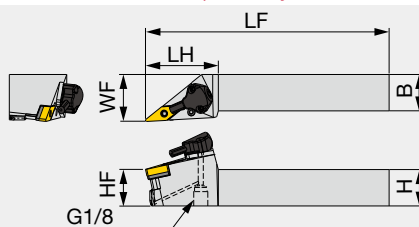
PVJNR/L-CHP**ISO^ETURN TUNGTURN**

Lever lock toolholders – 93° approach angle.

For negative 35° or 25° rhombic insert. High-pressure coolant capability.



Cutting edge style J



Right hand (R) shown.

ISO^ETURN

Designation	H	B	LF	LH	HF	WF	RE**	Insert	Torque*
PVJNR/L2020K1204-CHP	20	20	125	50	25	32	0.8	VN**1204...	2
PVJNR/L2525M1204-CHP	25	25	150	50	25	32	0.8	VN**1204...	2

*Torque: Recommended torque (N.m) for clamping

**RE: Standard corner radius

TUNGTURN

Designation	H	B	LF	LH	HF	WF	RE**	Insert	Torque*
PVJNR/L2020K16-CHP	20	20	125	50	20	32	0.8	V/YN**1604...	2
PVJNR/L2525M16-CHP	25	25	150	50	25	32	0.8	V/YN**1604...	2

*Torque: Recommended torque (N.m) for clamping

**RE: Standard corner radius

SPARE PARTS

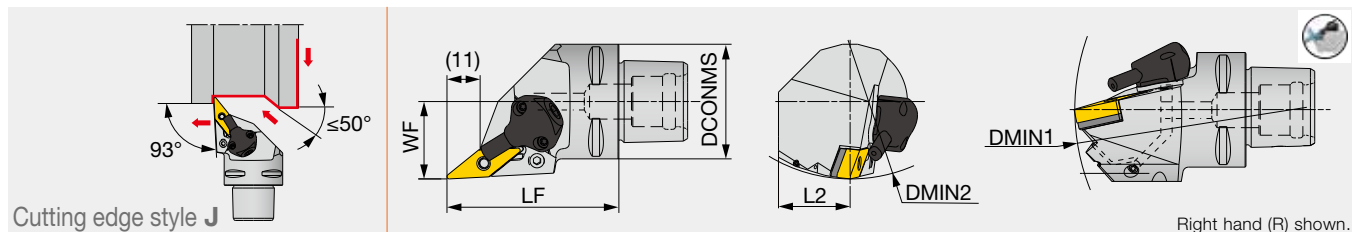
Designation	Shim	Clamping screw	Wrench 1	Spring pin	Lever
PVJNR/L**1204-CHP	LSV212	LCS3V	P-2.5	LSP3	LCL3V
PVJNR/L**16-CHP	LSV317	LCS3V	P-2.5	LSP3	LCL3V

SPARE PARTS

Designation	Coolant unit	Mounting screw	Wrench 2	O-ring	Coolant screw	Wrench 3
PVJNR/L**1204-CHP	CU-V-CHP	SRM3	T-8F	OR6.4X0.9N	SRM4X4TL360	P-2
PVJNR/L**16-CHP	CU-V-CHP	SRM3	T-8F	OR6.4X0.9N	SRM4X4TL360	P-2

C-PVJNR/L-CHP

Lever lock toolholders with TungCap connection – 93° approach angle.
For negative 35° or 25° rhombic insert. High-pressure coolant capability.



ISO^{ET}TURN

Designation	DCONMS	LF	L2	WF	DMIN1	DMIN2	RE**	Insert	Torque*
C4PVJNR/L27060-1204-CHP	40	60	20	27	140	90	0.8	VN**1204...	2
C6PVJNR/L45065-1204-CHP	63	65	31.5	45	190	81	0.8	VN**1204...	2

*Torque: Recommended torque (N·m) for clamping
Applicable for 14 MPa pressure coolant.

TUNGTURN

Designation	DCONMS	LF	L2	WF	DMIN1	DMIN2	RE**	Insert	Torque*
C4PVJNR/L27060-16-CHP	40	60	20	27	140	110	0.8	V/YN**1604...	2
C6PVJNR/L45065-16-CHP	63	65	31.5	45	190	81	0.8	V/YN**1604...	2

*Torque: Recommended torque (N·m) for clamping
Applicable for 14 MPa pressure coolant

**RE: Standard corner radius

SPARE PARTS

Designation	Shim	Clamping screw	Wrench 1	Spring pin	Lever
C*PVJNR/L**1204-CHP	LSV212	LCS3V	P-2.5	LSP3	LCL3V
C*PVJNR/L...16-CHP	LSV317	LCS3V	P-2.5	LSP3	LCL3V

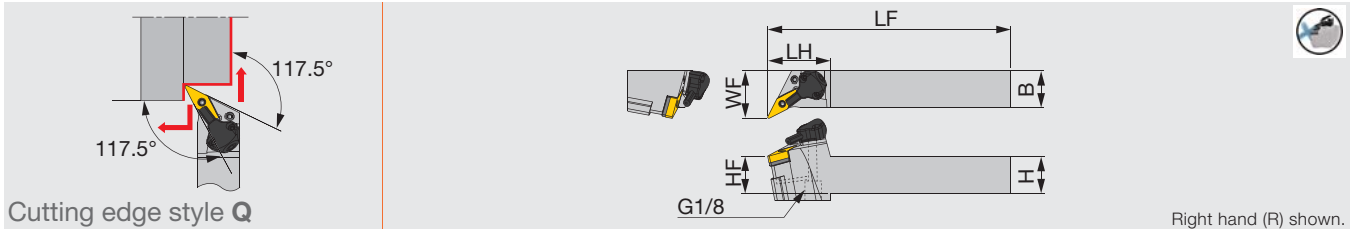
SPARE PARTS

Designation	Coolant unit	Mounting screw	Wrench 2	O-ring
C*PVJNR/L**1204-CHP	CU-V-CHP	SRM3	T-8F	OR6.4X0.9N
C*PVJNR/L...16-CHP	CU-V-CHP	SRM3	T-8F	OR6.4X0.9N

PVQNR/L-CHP

Lever lock toolholders – 117.5° approach angle.

For negative 35° or 25° rhombic insert. High-pressure coolant capability.



Right hand (R) shown.

Designation	H	B	LF	LH	HF	WF	RE **	Insert	Torque*
PVQNR/L2020K16-CHP	20	20	125	42.5	20	32	0.8	V/YN**1604...	2
PVQNR/L2525M16-CHP	25	25	150	42.5	25	32	0.8	V/YN**1604...	2

*Torque: Recommended torque (N·m) for clamping

**RE: Standard corner radius

SPARE PARTS

Designation	Shim	Clamping screw	Wrench 1	Spring pin	Lever
PVQNR/L**16-CHP	LSV317	LCS3V	P-2.5	LSP3	LCL3V

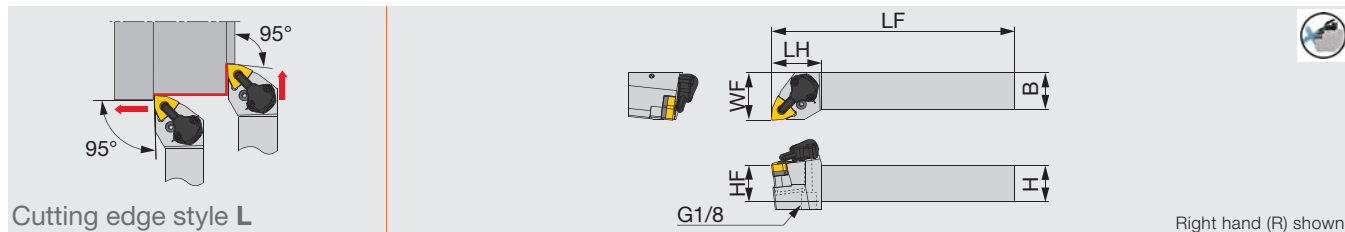
SPARE PARTS

Designation	Coolant unit	Mounting screw	Wrench 2	O-ring	Coolant screw	Wrench 3
PVQNR/L**16-CHP	CU-V-CHP	SRM3	T-8F	OR6.4X0.9N	SRM4X4TL360	P-2

PWLNR/L-CHP

Lever lock toolholders – 95° approach angle.

For negative 80° trigon insert. High-pressure coolant capability.



ISO ETURN

Designation	H	B	LF	LH	HF	WF	RE**	Insert	Torque*
PWLNR/L2020K0604-CHP	20	20	125	34	20	32	0.8	WN**0604...	2
PWLNR/L2525M0604-CHP	25	25	150	34	25	32	0.8	WN**0604...	2

*Torque: Recommended torque (N·m) for clamping

**RE: Standard corner radius

TUNGTURN

Designation	H	B	LF	LH	HF	WF	RE**	Insert	Torque*
PWLNR/L2020K08-CHP	20	20	125	34	20	32	0.8	WN**0804...	3
PWLNR/L2525M08-CHP	25	25	150	34	25	32	0.8	WN**0804...	3

*Torque: Recommended torque (N·m) for clamping

**RE: Standard corner radius

SPARE PARTS

Designation	Shim	Clamping screw	Wrench 1	Spring pin	Lever
PWLNR/L**0604-CHP	LSW312	LCS3	P-2.5	LSP3	LCL3
PWLNR/L**08-CHP	LSW42	LCS4	P-2.5	LSP4	LCL4

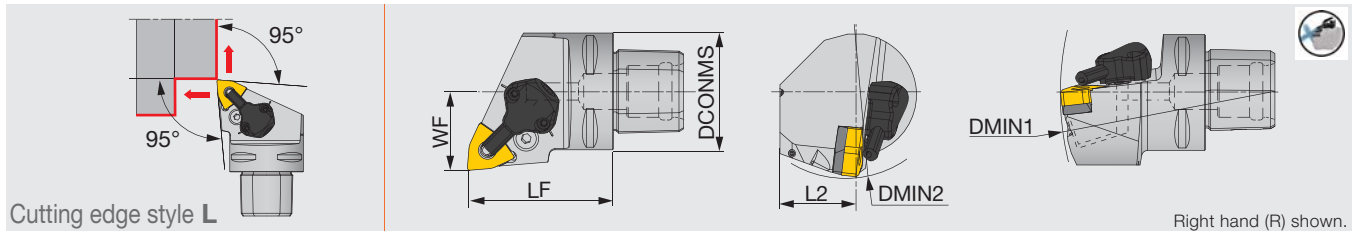
SPARE PARTS

Designation	Coolant unit	Mounting screw	Wrench 2	O-ring	Coolant screw	Wrench 3
PWLNR/L**0604-CHP	CU-CW-CHP	SRM3	T-8F	OR6.4X0.9N	SRM4X4TL360	P-2
PWLNR/L**08-CHP	CU-CW-CHP	SRM3	T-8F	OR6.4X0.9N	SRM4X4TL360	P-2

ISO^ETURN TUNG[®]CAP

C-PWLNLR/L-CHP

Lever lock toolholders with TungCap connection – 95° approach angle.
For negative 80° trigon insert. High-pressure coolant capability.

ISO^ETURN

Designation	DCONMS	LF	L2	WF	DMIN1	DMIN2	RE**	Insert	Torque*
C4PWLNLR/L27050-0604-CHP	40	50	25	27	140	110	0.8	WN**0604...	2

*Torque: Recommended torque (N·m) for clamping

Applicable for 14 MPa pressure coolant

**RE: Standard corner radius

TUNG[®]TURN

Designation	DCONMS	LF	L2	WF	DMIN1	DMIN2	RE**	Insert	Torque*
C4PWLNLR/L27050-08-CHP	40	50	25	27	140	110	0.8	WN**0804...	3
C6PWLNLR/L45065-08-CHP	63	65	41	45	190	110	0.8	WN**0804...	3

*Torque: Recommended torque (N·m) for clamping

Applicable for 14 MPa pressure coolant

**RE: Standard corner radius

SPARE PARTS

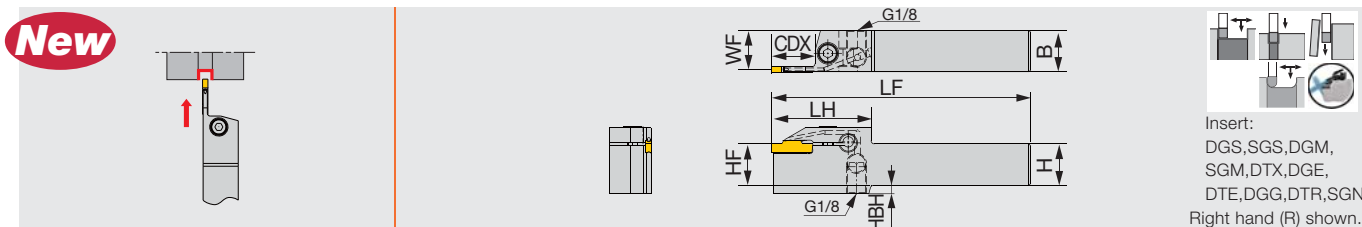
Designation	Shim	Clamping screw	Wrench 1	Spring pin	Lever
C*PWLNLR/L**0604-CHP	LSW312	LCS3	P-2.5	LSP3	LCL3
C*PWLNLR/L**-08-CHP	LSW42BL	LCS4	P-3	LSP4	LCL4

SPARE PARTS

Designation	Coolant unit	Mounting screw	Wrench 2	O-ring
C*PWLNLR/L**0604-CHP	CU-CW-CHP	SRM3	T-8F	OR6.4X0.9N
C*PWLNLR/L**-08-CHP	CU-CW-CHP	SRM3	T-8F	OR6.4X0.9N

CTER/L-CHP

Modular blade for parting & grooving, with channels for high pressure coolant



Designation	CW	Seat size	CDX	HF	B	H	LF	WF	HBH	LH	Torque*
CTER/L2020-2T17-CHP	2	2	17	20	20	20	125	19.1	4	45	5.5
CTER/L2525-2T17-CHP	2	2	17	25	25	25	150	24.1	-	45	5.5
CTER/L2020-3T20-CHP	3	3	20	20	20	20	125	18.8	4	48	5.5
CTER/L2525-3T20-CHP	3	3	20	25	25	25	150	23.8	-	48	5.5
CTER/L2525-3T25-CHP	3	3	25	25	25	25	150	23.8	-	51	5.5
CTER/L2525-4T25-CHP	4	4	25	25	25	25	150	23.5	-	55	8
CTER/L2525-5T20-CHP	5	5	20	25	25	25	150	23.08	-	49	8
CTER/L2525-6T20-CHP	6	6	20	25	25	25	150	22.58	7	52	12

- Always use 1 cutting edged insert when the working depth exceeds the total insert length minus 1.5 mm.

*Torque: Recommended torque (N·m) for clamping

SPARE PARTS

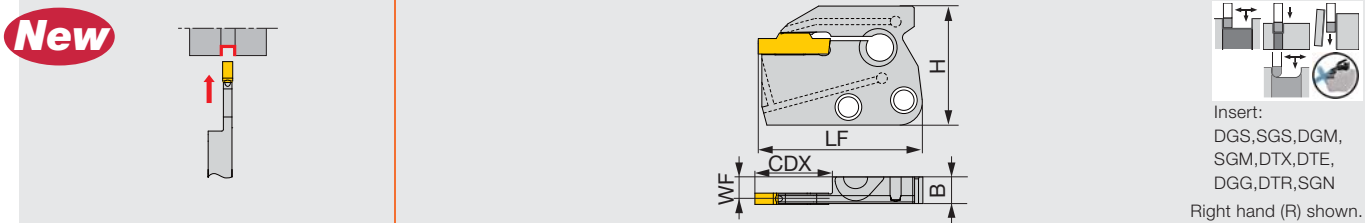


Designation	Clamping screw	Wrench
CTER/L2020-2T17-CHP	CM5x0.8x20-A	P-4
CTER/L2525-2T17-CHP	CM5x0.8x25-A	P-4
CTER/L2020-3T20-CHP	CM5x0.8x20-A	P-4
CTER/L2525-3T20-CHP	CM5x0.8x25-A	P-4
CTER/L2525-3T25-CHP	CM5x0.8x25-A	P-4
CTER/L2525-4T25-CHP	CM6x1x25-A	P-5
CTER/L2525-5T20-CHP	CM6x1x25-A	P-5
CTER/L2525-6T20-CHP	CM8x1.25x25-A	P-6

See page 52 for tube connections

CAER/L-CHP

Modular blade for parting & grooving, with channels for high pressure coolant

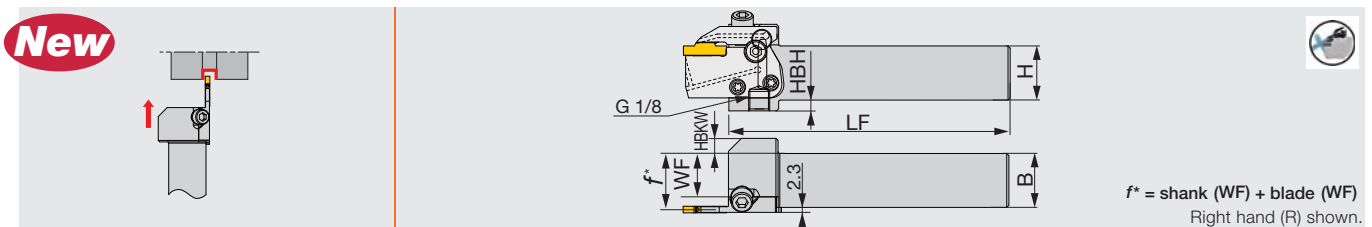


Designation	CW	Seat size	CDX	WF	H	LF	B
CAER/L-3T20-CHP	3	3	20	5.95	33	45.7	7.2
CAER/L-4T20-CHP	4	4	20	5.95	33	45.7	7.2

- Always use 1 cutting edged insert when the working depth exceeds the total insert length minus 1.5 mm.

CHSR/L-CHP

Shank for CAER/L-CHP, with channels for high pressure coolant



Designation	H	B	LF	WF	HBKW	HBH
CHSR/L2020-CHP	20	20	130	15.1	16.5	10
CHSR/L2525-CHP	25	25	130	20.1	11.5	5

- Always use 1 cutting edged insert when the working depth exceeds the total insert length minus 1.5 mm.

SPARE PARTS

Designation	Screw	Wrench	Clamping screw	Clamping screw	Wrench	O-ring	Plug
CHSR/L...-CHP	SRM5-04451	T-20/5	SRM6X12DIN6912	SRM6X20-XT	HW5.0	OR5X1N	PLGG1/8ISO1179

Recommended torque for clamping

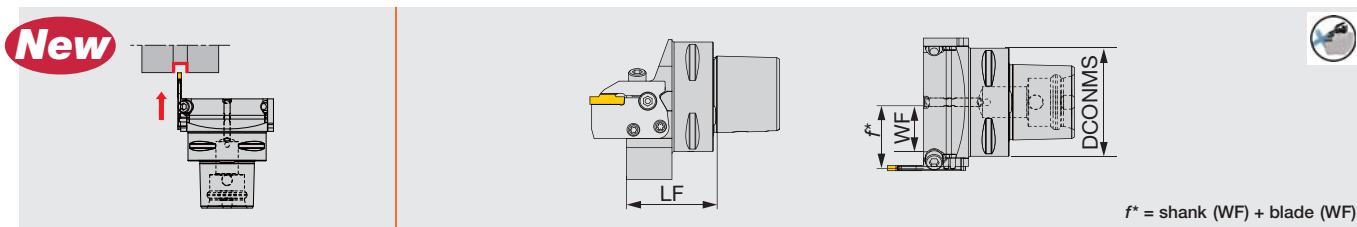
Screw	Torque (N.m)
SRM5-04451	5
SRM6X12DIN6912	8.5
SRM6X20-XT	8.5

See page 41 for instruction on installing and removing the blade and insert

See page 52 for tube connections

C*CHSN-CHP

PSC body for CAER/L-CHP, with channels for high pressure coolant



Designation	DCONMS	LF	WF
C4CHSN21047-CHP	40	46.5	21
C5CHSN26047-CHP	50	47	26
C6CHSN33050-CHP	63	50	32.5

- Always use 1 cutting edged insert when the working depth exceeds the total insert length minus 1.5 mm.

SPARE PARTS

Designation	Clamping screw	Wrench	Clamping screw	Clamping screw	Wrench	O-ring
C*CHSN...-CHP	SRM5-04451	T-20/5	SRM6X12DIN6912	SRM6X20-XT	HW5.0	OR5X1N

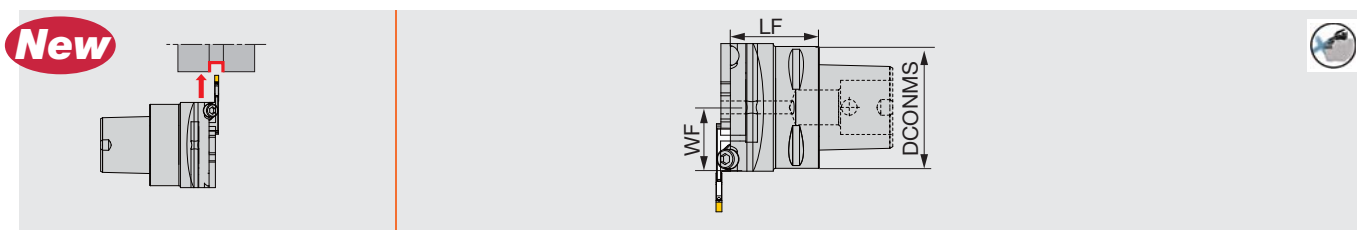
Recommended torque for clamping

Screw	Torque (N·m)
SRM5-04451	5
SRM6X12DIN6912	8.5
SRM6X20-XT	8.5

See page 41 for instruction on installing and removing the blade and insert

C*CHFVN-CHP

PSC body for CAER/L-CHP, with channels for high pressure coolant



Designation	DCONMS	LF	WF
C4CHFVN26046-CHP	40	46	26
C5CHFVN26046-CHP	50	46	26
C6CHFVN33046-CHP	63	46	33

- Always use 1 cutting edged insert when the working depth exceeds the total insert length minus 1.5 mm.

SPARE PARTS

Designation	Clamping screw	Wrench	Clamping screw	Clamping screw	Wrench	O-ring
C*CHFVN...-CHP	SRM5-04451	T-20/5	SRM6X12DIN6912	SRM6X20-XT	HW5.0	OR5X1N

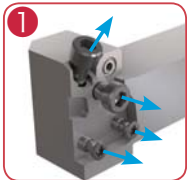
Recommended torque for clamping

Screw	Torque (N·m)
SRM5-04451	5
SRM6X12DIN6912	8.5
SRM6X20-XT	8.5

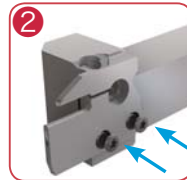
See page 41 for instruction on installing and removing the blade and insert

How to install and remove the blade and insert **TUNG**CUT

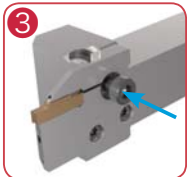
Installing the insert



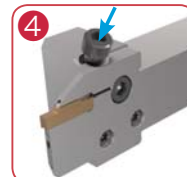
1 Remove all 4 screws and ensure the O rings are all in place.



2 Place the blade in the place and tighten 2 bottom clamping screws.



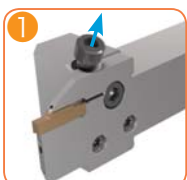
3 Place the insert in the pocket and tighten the fixing screw in the center.



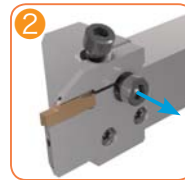
4 Place the long screw in the angular direction and tighten to clamp the insert.

Please follow the installation order as shown above. When the screws are tightened in the 4→3 order, the insert clamping may be insufficient and unstable.

Removing the insert

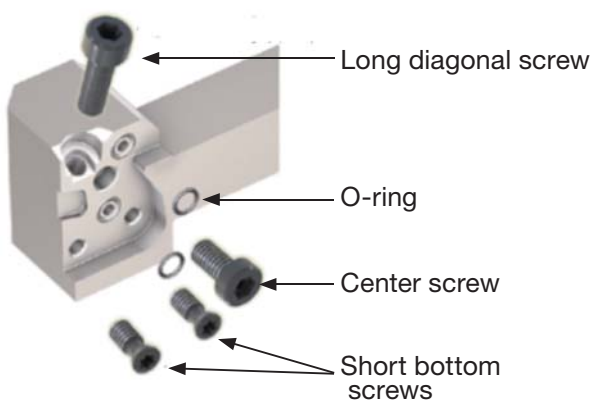


1 First loosen the long screw in the angular direction.



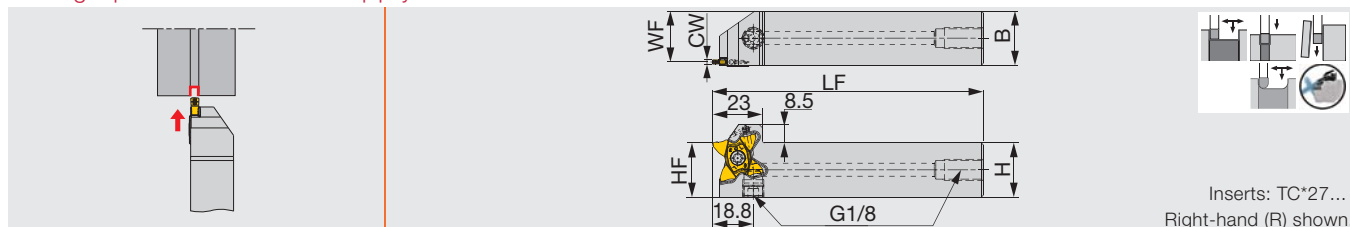
2 Loosen the Fixing screw in the center and remove the insert.

Loosening the long screw alone may not release the insert.



STCR/L-CHP

Precision grooving tools with uniquely shaped insert with 4 cutting edges and channel for high pressure coolant supply



Designation	CW	HF	B	H	LF	WF	Torque*
STCR/L2525-27-CHP	0.5 - 3.18	25	25	25	125	23.5	2.5

*Torque: Recommended torque (N·m) for clamping

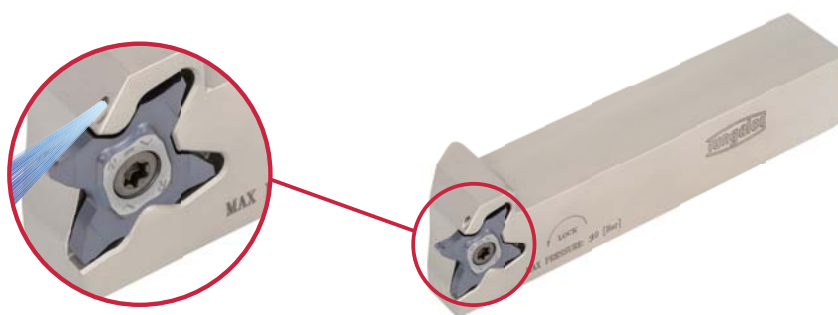
SPARE PARTS



Designation	Screw	Wrench
STCR...-27-CHP	SR16-212-01397L	T-2010/5
STCL...-27-CHP	SR16-212-01397	T-2010/5

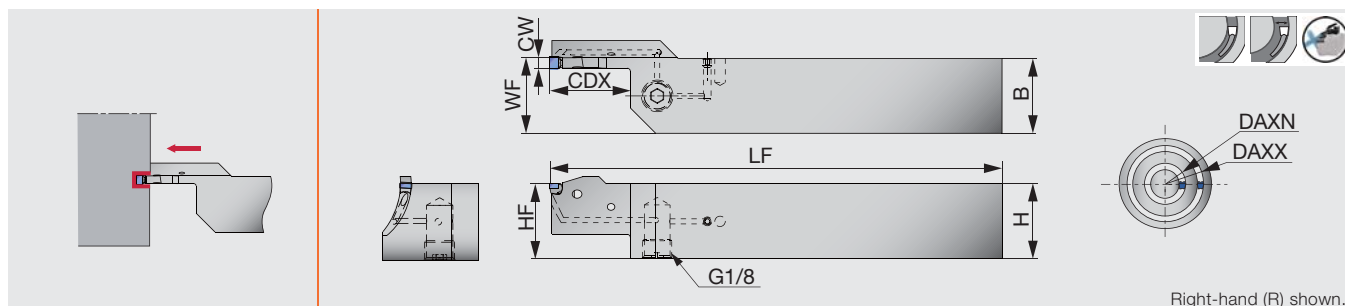
CHP type toolholders for high-pressure coolant

The coolant is supplied to the cutting edge providing good chip control and long tool life.



ETFR-CHP

Toolholders for face grooving & turning with channels for high-pressure coolant



Designation	CW	DAXN	DAXX	CDX	H	B	LF	HF	WF	Insert
ETFR2525-4T15-030035-CHP	4	30	35	15	25	25	150	25	25.5	E**4
ETFR2525-4T22-035045-CHP	4	35	45	22	25	25	150	25	25.5	E**4
ETFR2525-4T25-045055-CHP	4	45	55	25	25	25	150	25	25.5	E**4
ETFR2525-4T25-055075-CHP	4	55	75	25	25	25	150	25	25.5	E**4
ETFR2525-4T25-075120-CHP	4	75	120	25	25	25	150	25	25.5	E**4
ETFR2525-4T25-120200-CHP	4	120	200	25	25	25	150	25	25.5	E**4
ETFR2525-4T25-200500-CHP	4	200	500	25	25	25	150	25	25.5	E**4

SPARE PARTS

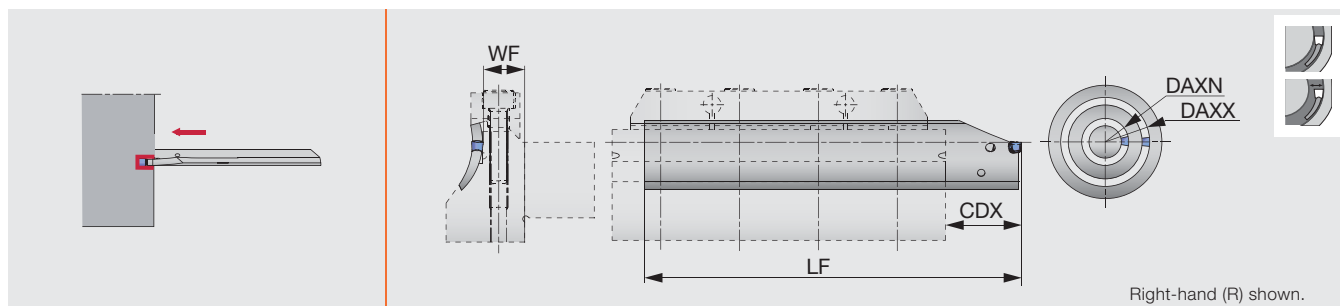


Designation	Wrench*
ETFR...-CHP	ECW-456EF

*Optional parts

EFPR/L

Adjustable blade for face grooving



Designation	CW	DAXN	DAXX	WF	LF	Min.CDX	Max.CDX	Insert
EFPR/L-4-030035	4	30.0	35.0	13.6	125.0	18	50	E**4
EFPR-4-035045	4	35.0	45.0	13.6	125.0	18	50	E**4
EFPR-4-045055	4	45.0	55.0	13.6	125.0	18	50	E**4
EFPR-4-055075	4	55.0	75.0	13.6	125.0	18	50	E**4
EFPR-4-075120	4	75.0	120.0	13.6	140.0	18	65	E**4
EFPR-4-120200	4	120.0	200.0	13.6	140.0	18	65	E**4
EFPR-4-200500	4	200.0	500.0	13.6	140.0	18	65	E**4
EFPR-5-035045	5	35.0	45.0	13.6	125.0	19	50	ETX5
EFPR-5-045055	5	45.0	55.0	13.6	125.0	19	50	ETX5
EFPR-5-055075	5	55.0	75.0	13.6	125.0	19	50	ETX5
EFPR-5-075120	5	75.0	120.0	13.6	140.0	19	65	ETX5
EFPR-5-120200	5	120.0	200.0	13.6	140.0	19	65	ETX5
EFPR-5-200500	5	200.0	500.0	13.6	140.0	19	65	ETX5
EFPR-6-045055	6	45.0	55.0	13.6	125.0	20	50	ETX6
EFPR-6-055075	6	55.0	75.0	13.6	125.0	20	50	ETX6
EFPR-6-075120	6	75.0	120.0	13.6	140.0	20	65	ETX6
EFPR-6-120200	6	120.0	200.0	13.6	140.0	20	65	ETX6
EFPR/L-6-200500	6	200.0	500.0	13.6	140.0	20	65	ETX6

SPARE PARTS

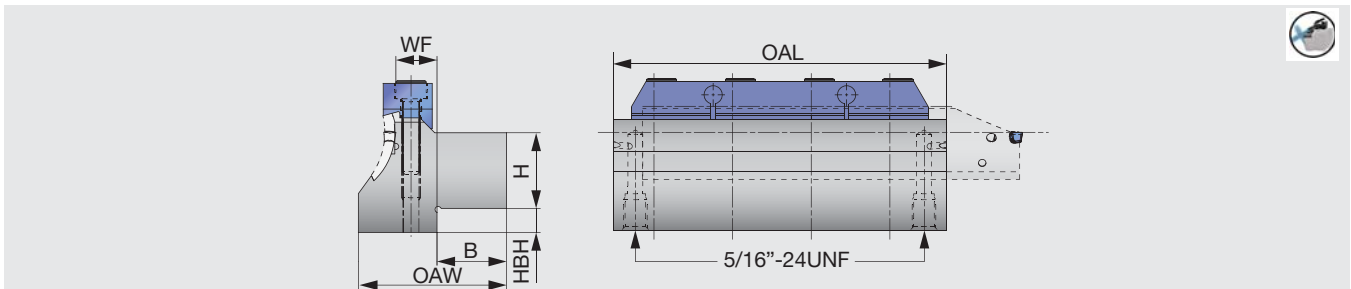


Designation	Wrench*
EFPR/L...	ECW-456I

*Optional parts

CTBU-CHP for EFPR/L

Tool block for EasyMulti-Cut face blade series with channels for high-pressure coolant



Designation	CW	DAXN	H	B	HBH	OAW	OAL	Blade
CTBU25-030-4-CHP	4	30.0	25.0	23.0	8	26.0	110.0	EFPR/L-4-030035
CTBU25-035-4/5-CHP	4, 5	35.0	25.0	23.0	8	26.0	110.0	EFPR/L-4/5-035045
CTBU25-045-4/5-CHP	4, 5	45.0	25.0	23.0	8	26.0	110.0	EFPR/L-4/5-045055
CTBU25-055-4/5-CHP	4, 5	55.0	25.0	23.0	8	24.0	110.0	EFPR/L-4/5-055075
CTBU25-075-4/5-CHP	4, 5	75.0	25.0	23.0	8	22.0	110.0	EFPR/L-4/5-075120
CTBU25-120-4/5-CHP	4, 5	120.0	25.0	23.0	8	21.0	110.0	EFPR/L-4/5-120200
CTBU25-200-4/5-CHP	4, 5	200.0	25.0	23.0	8	18.5	110.0	EFPR/L-4/5-200500
CTBU25-045-6-CHP	6	45.0	25.0	23.0	8	28.0	110.0	EFPR/L-6-045055
CTBU25-055-6-CHP	6	55.0	25.0	23.0	8	26.0	110.0	EFPR/L-6-055075
CTBU25-075-6-CHP	6	75.0	25.0	23.0	8	24.0	110.0	EFPR/L-6-075120
CTBU25-120-6-CHP	6	120.0	25.0	23.0	8	23.0	110.0	EFPR/L-6-120200
CTBU25-200-6-CHP	6	200.0	25.0	23.0	8	20.5	110.0	EFPR/L-6-200500

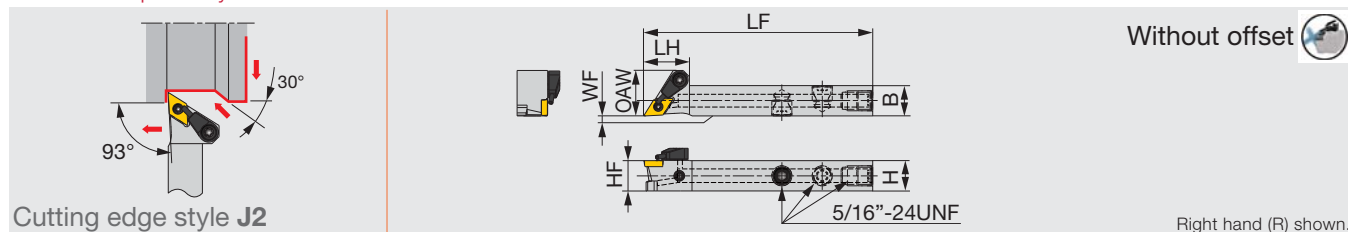
SPARE PARTS



Designation	Clamping screw	Clamp	Wrench
CTBU...-CHP	CM6X30-S	CT-110	P-5

JSDJ2CR/L-CHP

Screw-on toolholders without offset – 93° approach angle. For positive 55° rhombic insert. High-pressure coolant capability.



Designation	H	B	LF	LH	HF	WF	OAW	RE**	Insert	Torque*
JSDJ2CR/L1212F07-CHP	12	12	85	18	12	0	18	0.2	DC**0702...	0.9
JSDJ2CR/L1212F11-CHP	12	12	85	19	12	0	20.5	0.2	DC**11T3...	0.9

*Torque: Recommended torque (N-m) for clamping

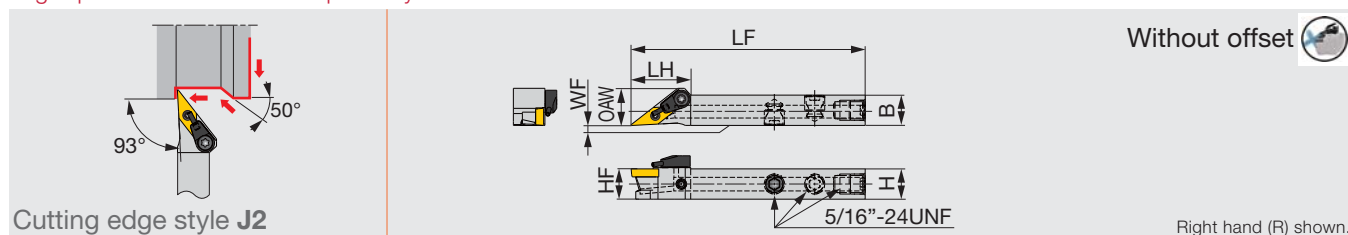
**RE: Standard corner radius

SPARE PARTS

Designation	Clamping screw	Coolant unit	Wrench	Coolant plug	Wrench
JSDJ2CR**11-CHP	CSTB-4SD	S-CU-CHP	T-8F	SR5/16UNFTL360	P-4

JSVJ2BR/L-CHP

Screw-on toolholder without offset – 93° approach angle. For positive 35° rhombic insert. High-pressure coolant capability.



Designation	H	B	LF	LH	HF	WF	OAW	RE**	Insert	Torque*
JSVJ2BR/L1212F11-CHP	12	12	85	23.6	12	0	14.7	0.2	VB**1103...	1.2

*Torque: Recommended torque (N-m) for clamping

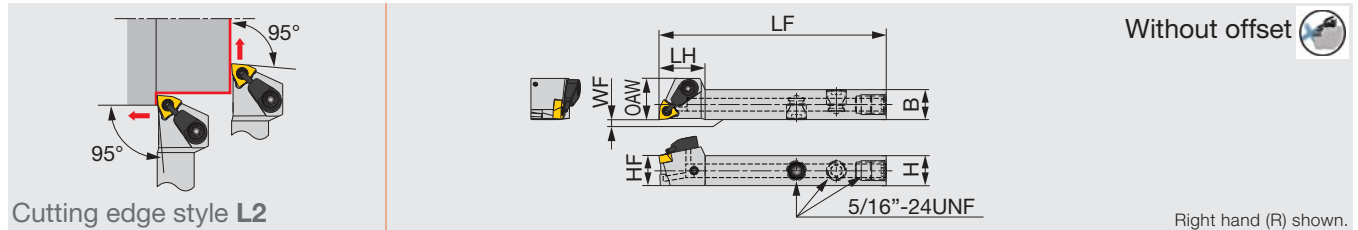
**RE: Standard corner radius

SPARE PARTS

Designation	Clamping screw	Coolant unit	Wrench	Coolant plug	Wrench
JSVJ2B**11-CHP	CSTB-2.5	S-CU-CHP	T-8F	SR5/16UNFTL360	P-4

JSWL2XR/L-CHP

Screw-on toolholder without offset – 95° approach angle. For WXGU insert. High-pressure coolant capability.



Designation	H	B	LF	LH	HF	WF	OAW	RE **	Insert	Torque*
JSWL2XR/L1212F04-CHP	12	12	85	18	12	0	16.5	0.2	WXGU0403**/L/R...	0.9

*Torque: Recommended torque (N·m) for clamping

**RE: Standard corner radius

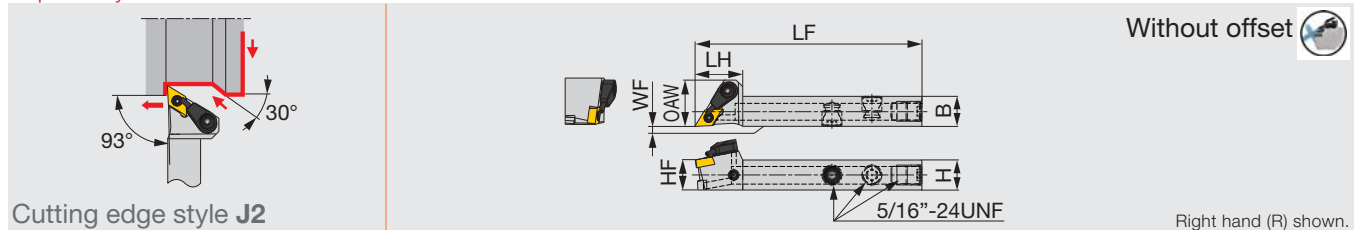
Note: Right-hand toolholders (R) are used with left-hand inserts (L). Left-hand toolholders (L) are used with right-hand inserts (R).

SPARE PARTS

Designation	Clamping screw	Coolant unit	Wrench	Coolant plug	Wrench
JSWL2XR/L1212F04-CHP	SR34-514	S-CU-CHP	T-7F	SR5/16UNFTL360	P-4

JSDJ2XR/L-CHP

Screw-on toolholder without offset – 93° approach angle. For DXGU insert. High-pressure coolant capability.



Designation	H	B	LF	LH	HF	WF	OAW	RE **	Insert	Torque*
JSDJ2XR/L1212F07-CHP	12	12	85	19	12	0	18.5	0.2	DXGU0703**/L/R...	0.9

*Torque: Recommended torque (N·m) for clamping

**RE: Standard corner radius

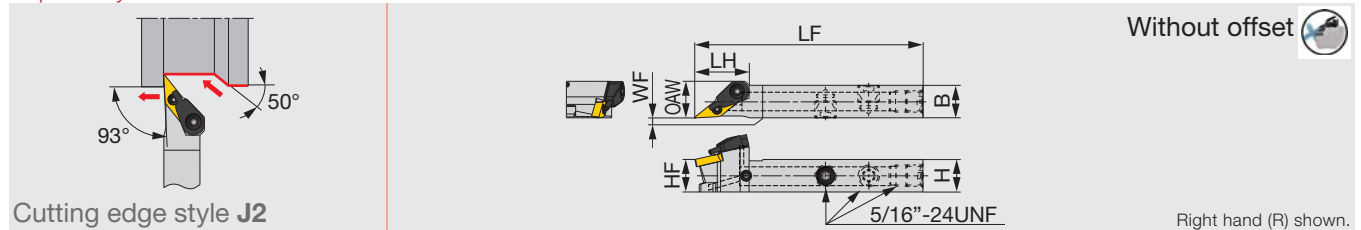
Note: Right-hand toolholders (R) are used with left-hand inserts (L). Left-hand toolholders (L) are used with right-hand inserts (R).

SPARE PARTS

Designation	Clamping screw	Coolant unit	Wrench	Coolant plug	Wrench
JSDJ2XR/L1212F07-CHP	SR34-514	S-CU-CHP	T-7F	SR5/16UNFTL360	P-4

JSVJ2XR/L-CHP

Screw-on toolholder without offset – 93° approach angle. For VXGU insert. High-pressure coolant capability.



Designation	H	B	LF	LH	HF	WF	OAW	RE**	Insert	Torque*
JSVJ2XR/L1212F09-CHP	12	12	85	20	12	0	13.5	0.2	VXGU09T2**L/R...	0.9

*Torque: Recommended torque (N-m) for clamping

**RE: Standard corner radius

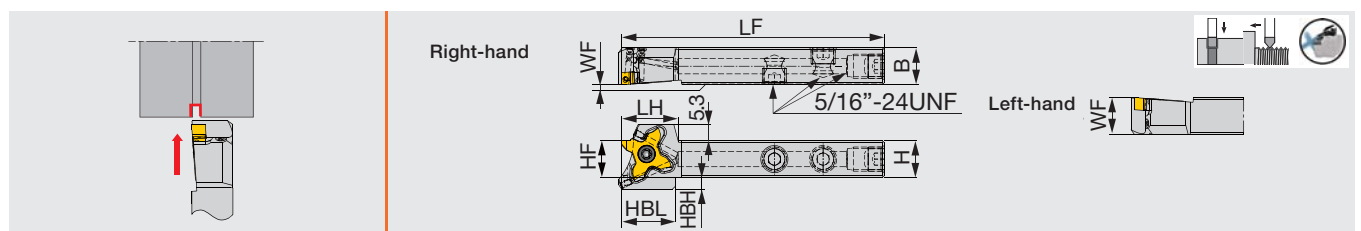
Note: Right-hand toolholders (R) are used with left-hand inserts (L). Left-hand toolholders (L) are used with right-hand inserts (R).

SPARE PARTS

Designation	Clamping screw	Coolant unit	Wrench	Coolant plug	Wrench
JSVJ2XR**F09-CHP	SR34-508	S-CU-CHP	T-7F	SR5/16UNFTL360	P-4

STCR/L-18-CHP

External grooving and threading toolholder. High pressure coolant capability.



Designation	CW	H	B	LF	LH	HBL	HF	WF	HBH	Insert	Torque*
STCR/L1212F18-CHP	0.33-3	12	12	85	18.5	17.5	12	0/12	4	TC**18	1.2

• The right hand insert (TC*18R***) is used for the right hand toolholders (STCR***), and the left hand insert (TC*18L***) is used for the left hand toolholders (STCL***).

(1) "0/12" for the WF dimension indicates WF = 0 for the right handed tool, WF = 12 for the left handed tool.

*Torque: Recommended torque (N-m) for clamping

SPARE PARTS

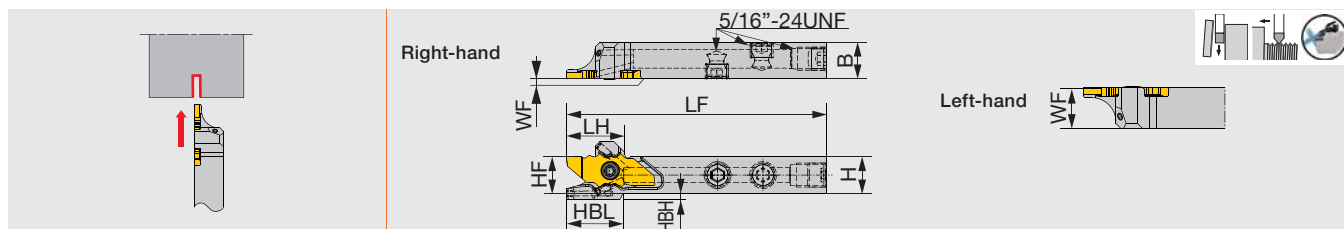
Designation	Clamping screw	Wrench	Coolant plug	Wrench
STCL**18-CHP	CSTC-4L100DR	T-1008/5	SR5/16UNFTL360	P-4
STCR**18-CHP	CSTC-4L100DL	T-1008/5	SR5/16UNFTL360	P-4

Groove width range : 0.33 ~ 3.0 mm

Threading pitch range 0.8 ~ 3.0 mm

JSXXR/L-CHP

Parting-off and threading toolholder. High pressure coolant capability.



Designation	CW	H	B	WF ⁽¹⁾	LF *	HF	HBH	LH *	HBL	Insert	Torque*
JSXXR/L1212F09-CHP	1-2	12	12	0.2/11.8	≤ 85	12	2	≤ 19.4	18.65	JX*G06...,12...,16..., 20...	1.2

*Torque: Recommended torque (N-m) for clamping

LF (Functional Length) LH (Head Length), and HBL (Head-bottom Offset Length) values shown above are true with JXPG16* insert. LF, LH, and HBL will all be 2 mm shorter than the above values with JX*G12** and JXPG20*** inserts, and 4 mm shorter for JXPG06*** insert.

Note: Use the right-hand insert (JX*G**R***) for a right-hand holder (JSXXR***); the left-hand insert (JX*G**L***) for a left-hand holder (JSXXL***).

SPARE PARTS

Designation	Clamping screw	Wrench	Coolant plug	Wrench
JSXXR...	CSTC-4L100DL	T-1008/5	SR5/16UNFTL360	P-4
JSXXL...	CSTC-4L100DR	T-1008/5	SR5/16UNFTL360	P-4

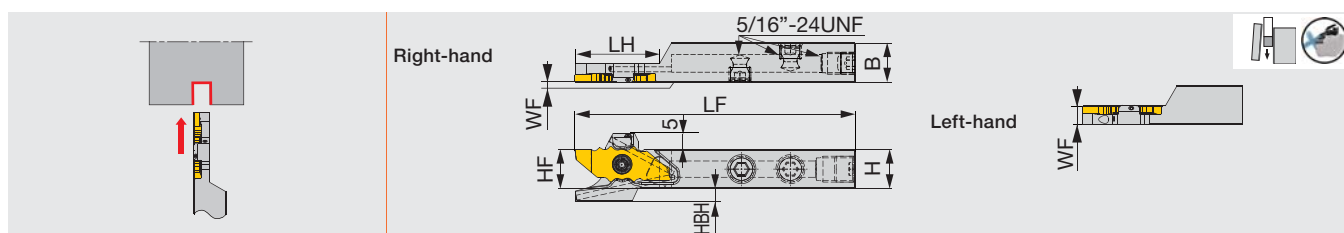
Parting-off widths : 1.0 mm and 1.5 mm (for a max parting diameter of ø6 mm)

: 1.5 mm and 2.0 mm (for max parting diameters of ø12 mm, ø16 mm, ø20 mm)

Threading pitch range : 0.2 - 1.5 mm

JSXXR/L-F-S-CHP

Parting-off toolholder for sub-spindle, with high pressure coolant capability.



Designation	CW	H	B	WF ⁽¹⁾	LF *	HF	HBH	LH *	Insert	Torque*
JSXXR/L1212F09-S-CHP***	1-2	12	12	0.2/5.5	≤ 85	12	4	26	JX*G06...,12...,16..., 20...	1.2
New JSXXR/L1212F09B-S-CHP	1-2	12	12	0.2/5.5	≤ 85	12	2	26	JX*G06...,12...,16..., 20...	1.2

*Torque: Recommended torque (N-m) for clamping

LF (Overall Tool Length) and LH (Head Length) values shown above are true with JXPG16* insert. Both LF and LH will be 2 mm shorter than the above value with JX*G12** and JXPG20*** inserts; 4 mm shorter with JXPG06*** insert.

***To be replaced with the new design

Note: Use the right-hand insert (JX*G**R***) for a right-hand holder (JSXXR***); the left-hand insert (JX*G**L***) for a left-hand holder (JSXXL***).

SPARE PARTS

Designation	Clamping screw	Wrench	Coolant plug	Wrench
JSXXR...	CSTC-4L100DL	T-1008/5	SR5/16UNFTL360	P-4
JSXXL...	CSTC-4L100DR	T-1008/5	SR5/16UNFTL360	P-4

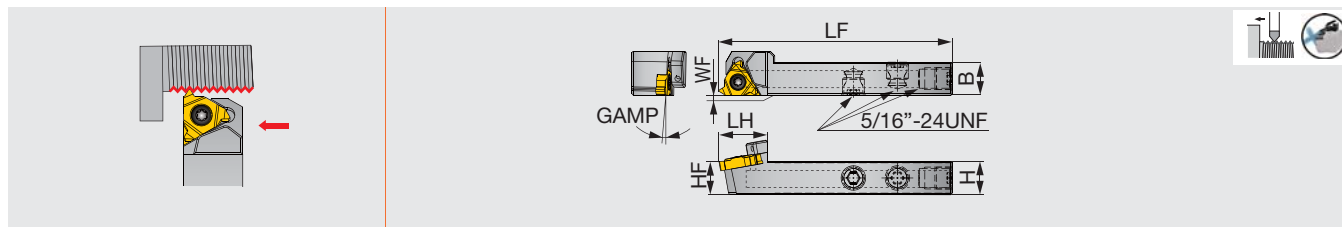
Parting-off widths : 1.0 mm and 1.5 mm (for a max parting diameter of ø6 mm)

: 1.5 mm and 2.0 mm (for max parting diameters of ø12 mm, ø16 mm, ø20 mm)

Threading pitch range : 0.2 - 1.5 mm

JSER/L-16-CHP

External threading toolholder, with high pressure coolant capability



Designation	H	B	LF	LH	HF	WF	GAMP	Insert
JSE2R1212F16-CHP	12	12	85	19	12	0	1°	16ER...

SPARE PARTS

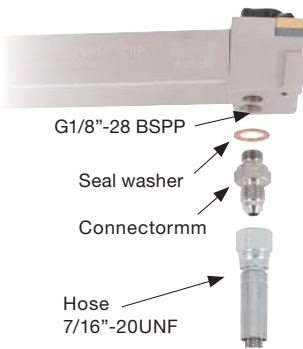
Designation	Clamping screw	Wrench	Coolant plug	Wrench
JSE2R**16-CHP	CSTB-3.5	T-15F	SR5/16UNFTL360	P-4

100

CONNECTION OF TOOLHOLDER AND COOLANT HOSE

- Toolholder in the size of over 20 mm: Hose on the bottom of the head
- Toolholder in the size of less than 16 mm: Hose on the back, front, or back end side

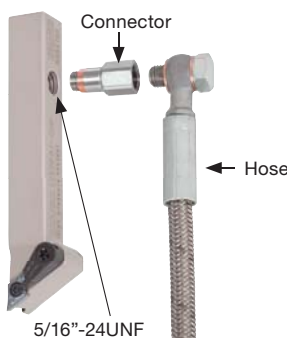
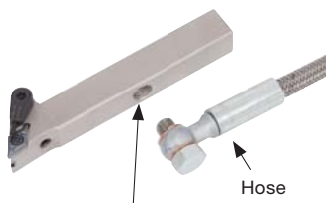
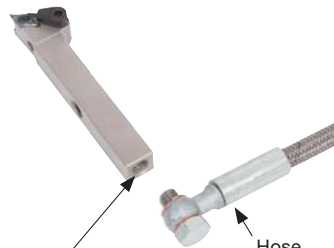
For general lathes (P-type)

Designation	PCLN... / PDJN... / PTGN... / PV*N... / PWLN...
Shank size	Over 20 mm
Example of connection	 G1/8"-28 BSPP Seal washer Connectormm Hose 7/16"-20UNF
Washer	CHP-COPPER-SEAL1/8
Connector	CHP-NIPPLE-G1/8-7/16UNF
Hose	CHP-HOSE-G1/8-7/16-200BS ⁽¹⁾
	CHP-HOSE-G1/8-7/16-250BS ⁽¹⁾
	CHP-HOSE-5/16-7/16-200BS ⁽²⁾

Thread size of hose for machine: ⁽¹⁾G1/8"-28 BSPP, ⁽²⁾5/16"-24UNF



For small lathes (J-type)

Designation	JSDJ2X... / JSWL2X... / JSVJ2X... / JSDJ2C... / JSVJ2B...		
Shank size	≤ 16 mm		
Connection	Back	Front	Back end
Example of connection	 Connector Hose 5/16"-24UNF	 5/16"-24UNF Hose	 5/16"-24UNF Hose
Connector for toolholder	CHP-CONECTOR5/16-G1/8	-	-
Hose	CHP-HOSE-G1/8-7/16-200BS ⁽³⁾	CHP-HOSE-5/16-7/16-200BS ⁽³⁾	CHP-HOSE-5/16-7/16-200BS ⁽³⁾
	CHP-HOSE-G1/8-7/16-250BS ⁽³⁾	-	-
	CHP-HOSE-G1/8-G1/8-200BB ⁽⁴⁾	-	-
	CHP-HOSE-G1/8-G1/8-250BB ⁽⁴⁾	-	-
Connector for machine ⁽⁵⁾	CHP-NIPPLE-G1/8-7/16UNF	CHP-NIPPLE-G1/8-7/16UNF	CHP-NIPPLE-G1/8-7/16UNF
Washer for machine ⁽⁵⁾	CHP-COPPER-SEAL1/8	CHP-COPPER-SEAL1/8	CHP-COPPER-SEAL1/8

(1): The tube thread type on the machine side is 7/16"-20UNF, female thread. Therefore, use both Nipple (5) and Washer (5) to connect to the machine G1/8 female thread. (2): The thread type on the machine side is G1/8"-28 BSPP, male thread.

PARTS FOR COOLANT HOSE

Connecting hose

Fig. 1

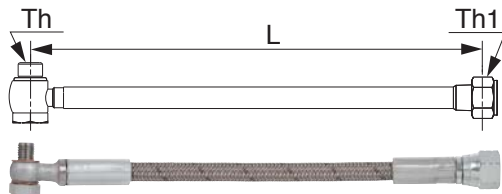
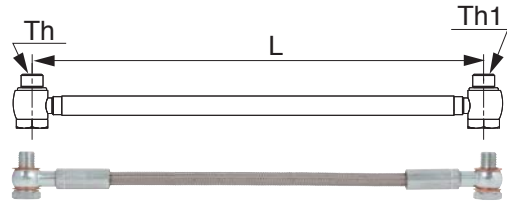
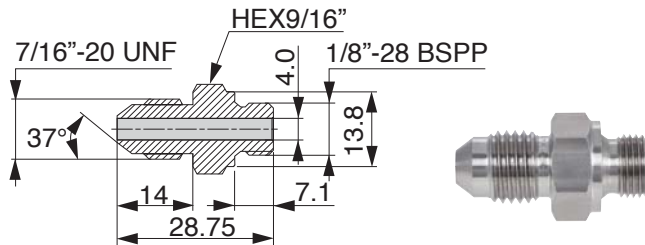


Fig. 2



Designation	Length L	Threading size		Max. pressure (Mpa)	Fig.
		Th	Th1		
CHP-HOSE-G1/8"-7/16"-200BS	200	G1/8"-28 BSPP	7/16"-20 UNF	26	1
CHP-HOSE-G1/8"-7/16"-250BS	250	G1/8"-28 BSPP	7/16"-20 UNF	26	1
CHP-HOSE-5/16"-7/16"-200BS	200	5/16"-24UNF	7/16"-20 UNF	20	1
CHP-HOSE-5/16"-G1/8"-200BS	200	5/16"-24UNF	G1/8"-28 BSPP	20	1
CHP-HOSE-G1/8"-G1/8"-200BB	200	G1/8"-28 BSPP	G1/8"-28 BSPP	26	2
CHP-HOSE-G1/8"-G1/8"-250BB	250	G1/8"-28 BSPP	G1/8"-28 BSPP	26	2

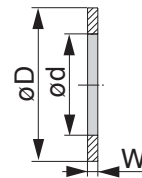
Connector



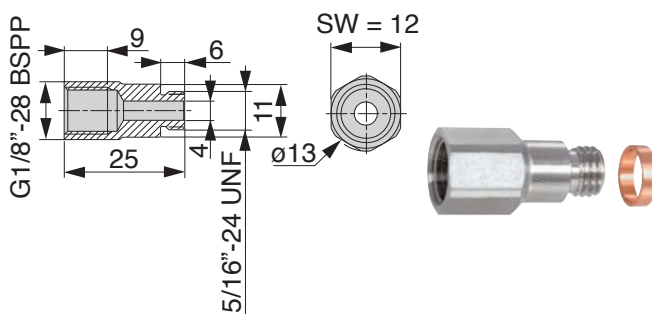
Designation

CHP-NIPPLE-G1/8-7/16UNF

Seal washer



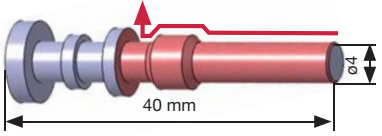
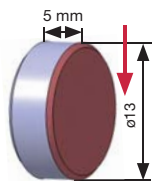
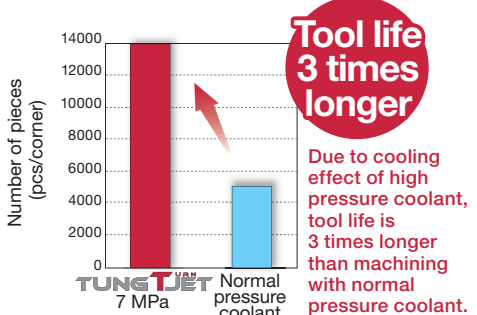
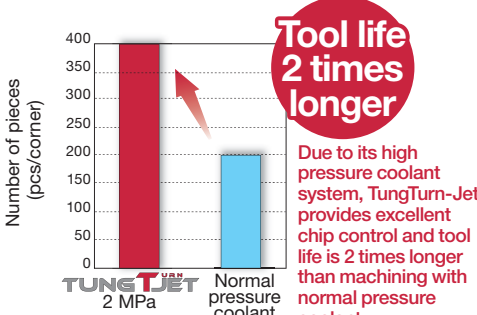
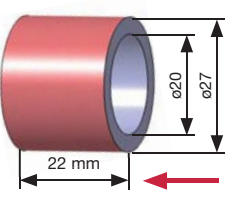
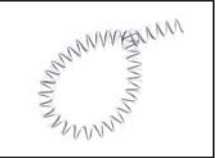
Designation	øD	ød	W
CHP-COPPER-SEAL1/8	15	8	1
CHP-COPPER-SEAL5/16	11	8	1
CHP-COPPER-SEAL5/16-2.5	11	8	2.5

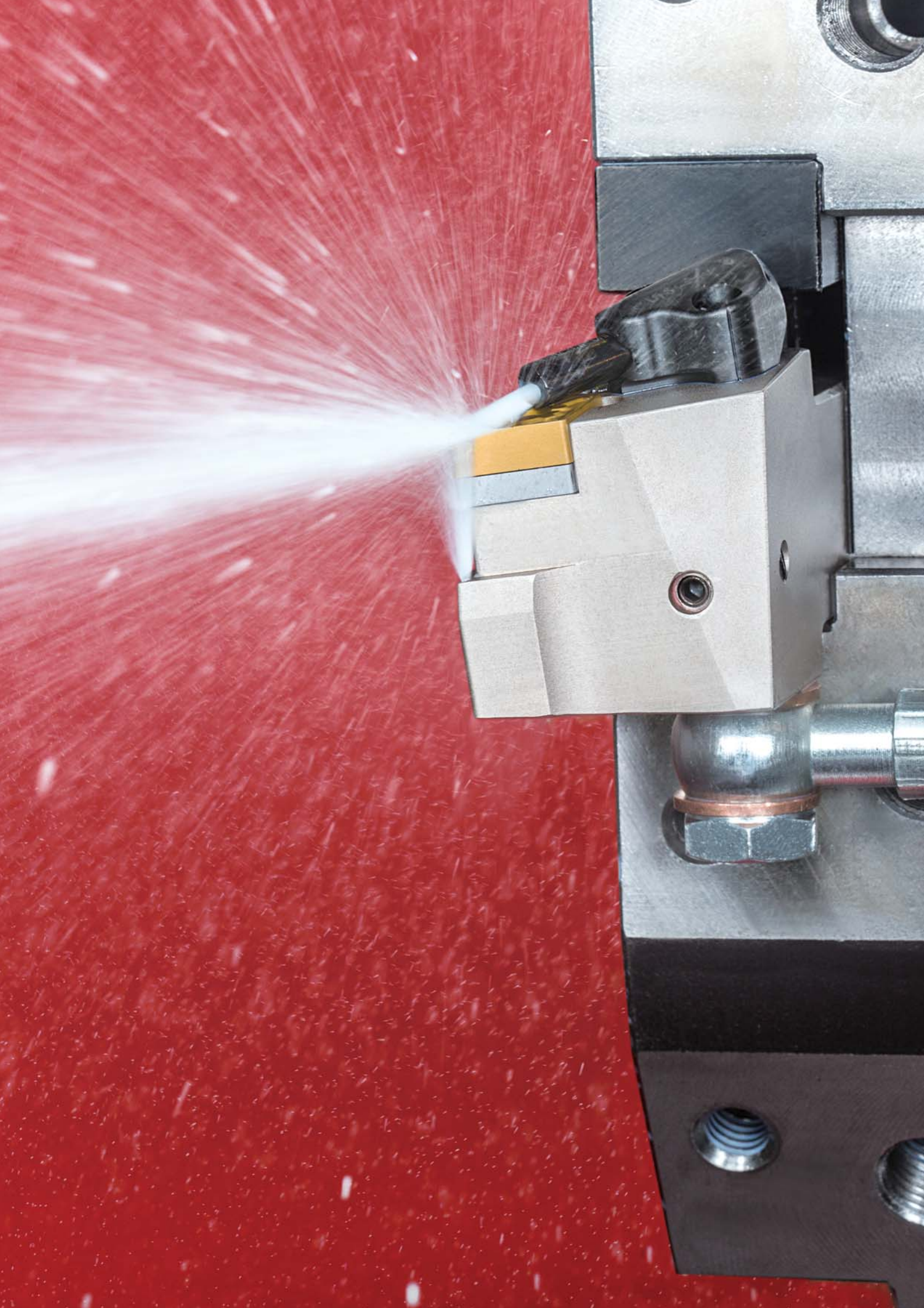
Connector for small lathe
with seal washer

Designation

CHP-CONECTOR/5/16-G1/8

PRACTICAL EXAMPLES

Workpiece type		Shaft	Valve cap parts
Toolholder		JSDJ2CR1212F11-CHP	JSDJ2CR1212F11-CHP
Insert		DCGT11T301FN-JS	DCMT11T304-PSS
Grade		SH730	AH905
Workpiece material		S45C / C45	SUH660 / Austenitic heat-resistant steel
		 P	 M
Cutting conditions	Cutting speed : Vc(m/min)	100	50
	Feed : f (mm/rev)	0.02	0.05
	Depth of cut : ap (mm)	2	0.15
	Machining	External turning	Face turning
	Coolant	Wet	Wet
Results		 Tool life 3 times longer Due to cooling effect of high pressure coolant, tool life is 3 times longer than machining with normal pressure coolant.	 Tool life 2 times longer Due to its high pressure coolant system, TungTurn-Jet provides excellent chip control and tool life is 2 times longer than machining with normal pressure coolant.
Workpiece type		Valve cap parts	
Toolholder		PCLNR2525M12-CHP	
Insert		CNMG120408-HMM	
Grade		AH905	
Workpiece material		Inconel 718	
		 S	
Cutting conditions	Cutting speed : Vc(m/min)	60	
	Feed : f (mm/rev)	0.15	
	Depth of cut : ap (mm)	0.2	
	Machining	External turning	
	Coolant	Wet	
Results		Excellent chip control! High pressure coolant system forms short chips in machining and reduces machine downtime caused by long, entangled chips.   TUNG T^{URN}JET Normal pressure coolant	



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