

Turning Tools for Small Lathes

J-SERIES

Expanded Items for All Types of Machining



FEATURES OF J-SERIES TURNING TOOLS FOR SMALL LATHES

New free-cutting chipbreakers for burrless machining.

Sharp cutting edges just fit for low-feed machining inherent to small-lathe turning.

Honed-edges completely prevent the insert from chipping.

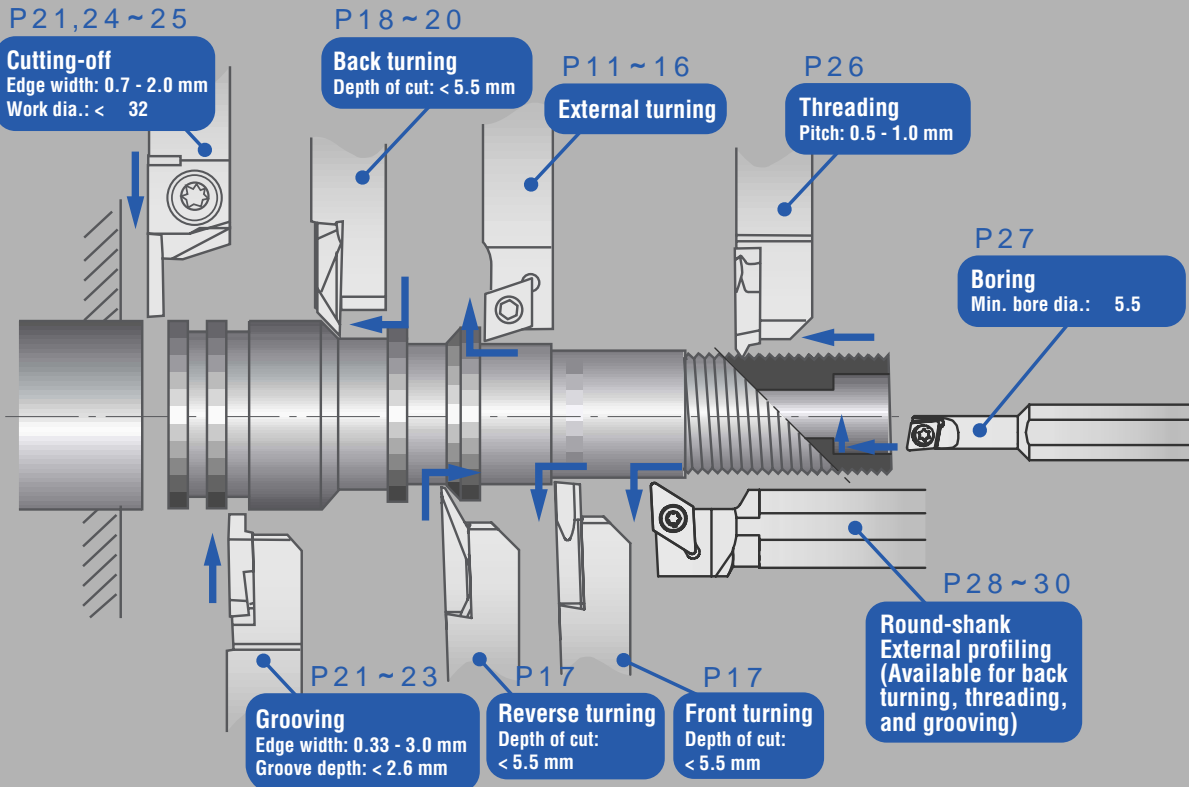
Four surfaces of the shank are ground for maintaining highly accurate machining.

The type numbers starting from "J" allow easy selection of the insert and the toolholder.

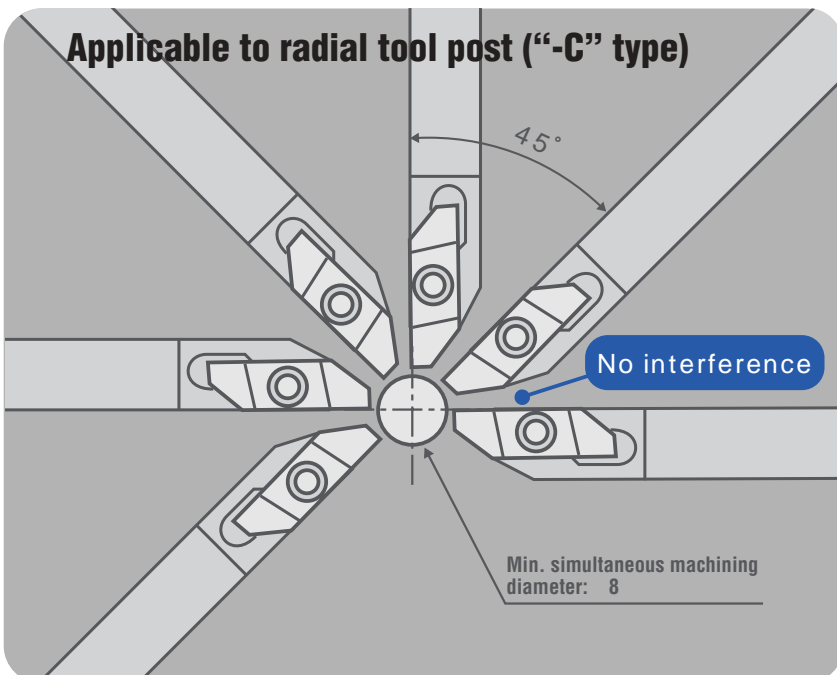
The highly rigid tool design has realized precision machining at deep cuts.

In the back-clamping type tools, the insert can be changed and indexed from back side of the toolholder.

Applicable to a variety of operations such as front turning, back turning, grooving, threading, cutting-off, and boring.



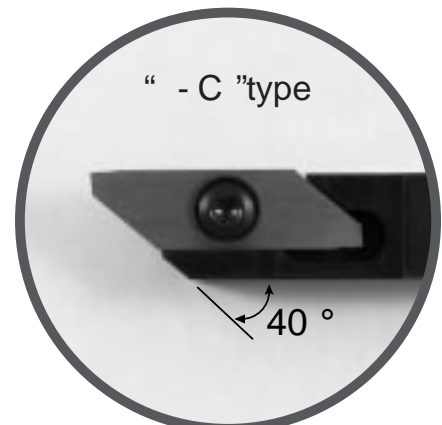
Applicable to radial tool post ("C" type)



The toolholders whose final letter of the Cat.No.is " - C "are applicable to radial tool post tooling.

Work diameters down to 8 can be simultaneously machined.

" - C "type toolholders are available for front turning, reverse turning, threading, cutting-off, and grooving.

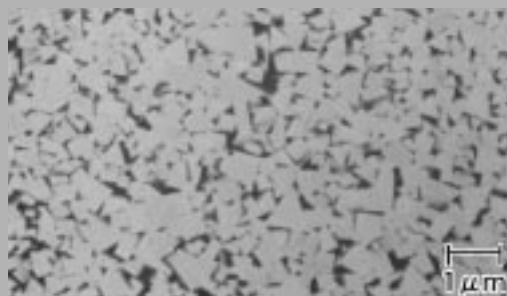


JSXG type

INSERT GRADES FOR J-SERIES

Features of J740

A optimum combination of the micro-grain cemented carbide substrate and special thin-film coating "J-Coat" has realized the cutting-edge sharpness and long tool life.

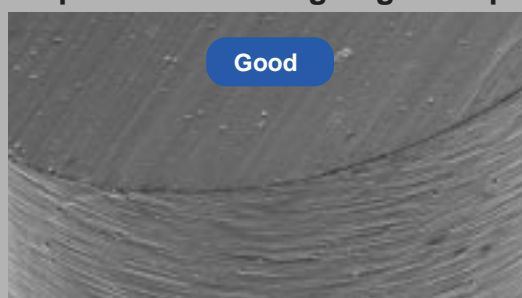


J740

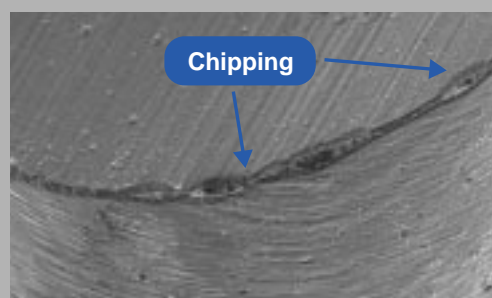


Conventional cemented carbide

Comparison of cutting-edge sharpness



J-series



Competitor's grade

Features of Grades

Grades	Material type	Features
J740	Micro-grain cemented carbide + PVD coating	<ul style="list-style-type: none"> All-rounder for general steels to stainless steels and free-cutting steels. The cutting edge sharpness and "J-Coat" realizing long tool life contribute to the outstanding cutting performance in the surface finish and wear resistance.
NS530	Cermet	<ul style="list-style-type: none"> Applicable to high-speed cutting of general steel to stainless steels. Excellent surface finish inherent to cermet.
J530	Cermet + PVD coating	<ul style="list-style-type: none"> The cutting edge sharpness and "J-Coat" realizing long tool life contribute to the outstanding cutting performance in the wear resistance.
TH10	Cemented carbide	Long tool life in machining of aluminum alloys, brass, and difficult-to-cut materials.

Standard Cutting Conditions

Work materials	Applications	Chipbreakers	Grades	Depth of cut a_p (mm)	Feed f (mm/rev)	Cutting Speed V (m/min)
General steels Free-cutting steels	Precision finishing	01	J530	0.05-0.5	0.03-0.15	100-300
			J740			10-100
	Finishing	J	NS530	0.1-5.0	0.01-0.3	80-300
			J530			10-100
Stainless steels	Precision finishing	01	J530	0.05-0.5	0.03-0.15	100-200
			J740			10-100
	Finishing	J	NS530	0.1-5.0	0.01-0.1	100-200
			J530			10-100
Cast irons	Finishing	J	TH10	0.1-5.0	0.01-0.1	20-100
Nonferrous metals	Finishing	J	TH10	0.1-5.0	0.01-0.1	100-1000
Difficult-to-cut materials	Finishing	J	TH10	0.1-5.0	0.01-0.1	10-150
Hard materials	Finishing	J	TH10	0.1-5.0	0.01-0.1	10-60

New BACK-CLAMPING TOOLHOLDERS (Negative types have been added to the existing positive types.)

Wrenching from the back side of the toolholder allows easy indexing and changing of the insert.



The back-clamping mechanism for easy changing and indexing of the insert on an automatic lathe.

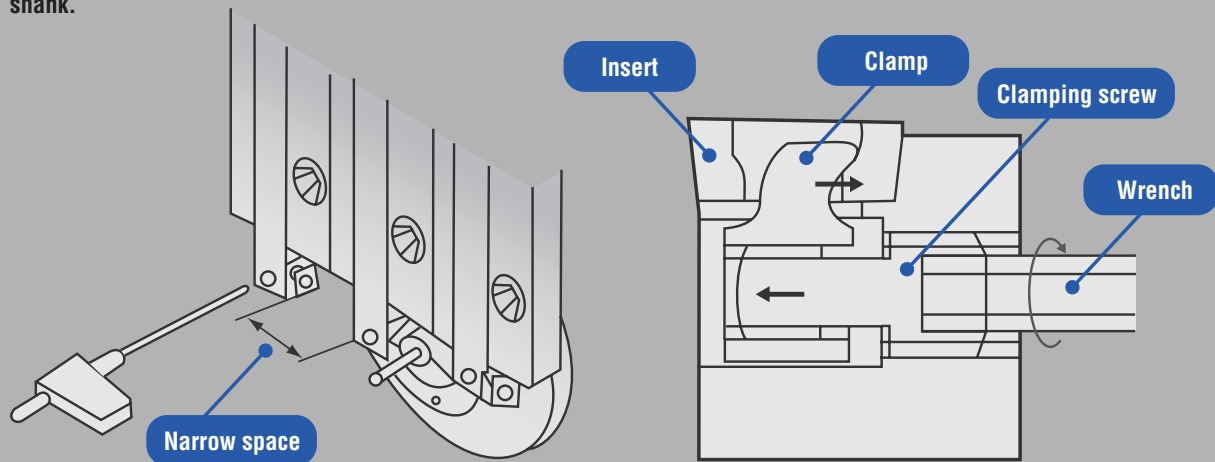
No parts apart from the shank when indexing or changing the insert.

Ensures precise positioning of the insert.

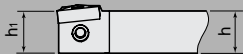
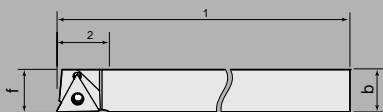
Newly added negative rake toolholders allow use of a variety of three-dimensional chipbreaker inserts, resulting in improved chip control and machining efficiency.

Use of negative inserts which excel in the number of available cutting edges allows reducing of machining costs.

Because of the narrow spacing between the adjacent tools on a gang tool post, it is not easy to change or index the insert on a conventional screw-on type toolholder. Whereas, the back-clamping toolholder allows easy indexing or changing of the insert by wrenching from back side of the shank.

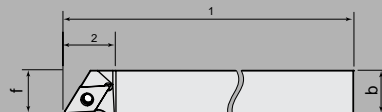


For external turning JTTAN type (Negative, back clamping)



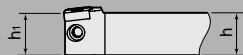
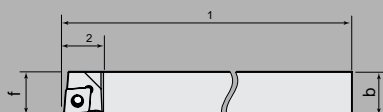
Applicable insert	Shank size (mm)	Shank size (mm)	
		h	b
TN 1604	12 16	16	16

For external profiling JTDJ2N type (Negative, back clamping)



Applicable insert	Shank size (mm)	Shank size (mm)	
		h	b
DN 1104	12 16	16	16

For external turning and facing JTCL2N type (Negative, back clamping)



Applicable insert	Shank size (mm)	Shank size (mm)	
		h	b
CN 0903	12 16	16	16

Note : For positive back-clamping toolholders, see page 11.

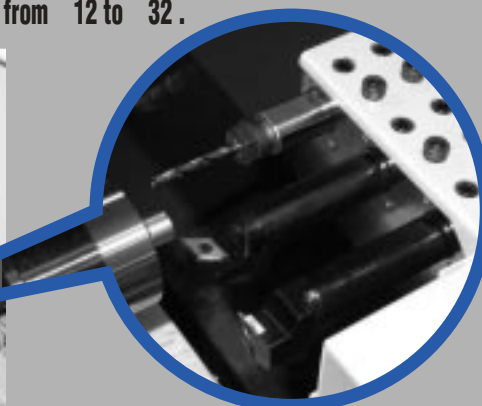
New ROUND-SHANK TOOLHOLDERS

Can resolve a shortage of the number of tools installed on a machine in machining of complex parts.

By installing round-shank tools in sleeve holders on the front and back side tool posts, enabling front and back turning, grooving, and threading, the number of tools installed in external machining process can be increased.

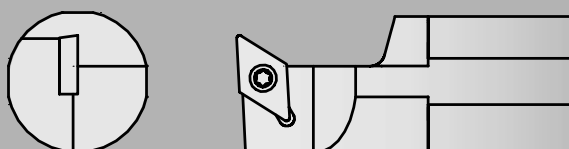


Applicable to the machines of the maximum machining diameters from 12 to 32.



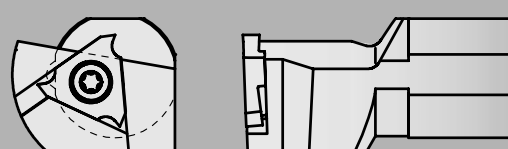
Available shank size: 19.05, 20.0, 22.0, and 25.4.

For external profiling JS-SDUCL type



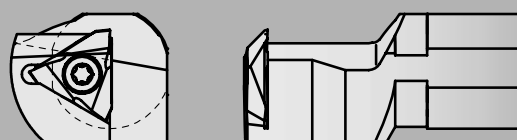
Applicable inserts	Shank diameter
DC 0702	19.05 ~ 22.0
DC 11T3	19.05 ~ 25.4

For grooving JS-TGL3 type



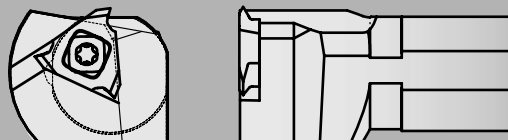
Applicable inserts	Shank diameter	Groove width	Groove depth
JTGR3	19.05 ~ 25.4	0.33 ~ 3.0mm	0.7 ~ 2.6mm

For back turning JS-TBL3 type



Applicable inserts	Shank diameter	Max. depth of cut
JTBR30	19.05 ~ 25.4	2.5mm

For threading JS-TTL3 type






Applicable inserts	Shank diameter	Pitch range
JTTR30	19.05 ~ 25.4	60° 55° 0.5 ~ 1.0mm





TAC INSERTS FOR GENERAL TURNING

Positive Inserts for J-series





01-type chipbreaker for precision finishing

Appearance	Insert Cat. No.	Dimensions (mm)				Stocked grades			
		I.C. dia.	Thickness	Hole dia.	Corner radius	Coated		Cermet	Uncoated
						J530	J740	NS530	TH10
	CCGT060202-01	6.350	2.38	2.8	0.2				
	CCGT09T302-01	9.525	3.97	4.4	0.2				
	DCGT070202-01	6.350	2.38	2.8	0.2				
	DCGT11T302-01	9.525	3.97	4.4	0.2				
	TCGT110202-01	6.350	2.38	2.8	0.2				

J-type chipbreaker for finishing(Sharp edge)

Appearance	Insert Cat. No.	Dimensions (mm)				Stocked grades					
		I.C. dia.	Thickness	Hole dia.	Corner radius	Coated		Cermet	Uncoated		
						J530	J740	NS530	TH10		
	CCGT060200FR/L-J10	6.350	2.38	2.8	0.03						
	CCGT060201FR/L-J10				0.1						
	CCGT060202FR/L-J10				0.2						
	CCGT09T300FR/L-J10				0.03						
	CCGT09T301FR/L-J10	9.525	3.97	4.4	0.1						
	CCGT09T302FR/L-J10				0.2						
	DCGT070200FR/L-J10				6.350	2.38	2.8	0.03			
	DCGT070201FR/L-J10							0.1			
DCGT070202FR/L-J10	0.2										
DCGT11T300FR/L-J10	9.525	3.97	4.4	0.03							
DCGT11T301FR/L-J10				0.1							
DCGT11T302FR/L-J10				0.2							
				TCGT080200FR/L-J08	4.760	2.38	2.2	0.03			
	TCGT080201FR/L-J08	0.1									
	TCGT080202FR/L-J08	0.2									
	TCGT110200FR/L-J10	6.350	2.38	2.8				0.03			
TCGT110201FR/L-J10	0.1										
TCGT110202FR/L-J10	0.2										
TCGT110300FR/L-J10	6.350				3.18	2.8	0.03				
TCGT110301FR/L-J10		0.1									
TCGT110302FR/L-J10		0.2									
		VBGT110300FR/L-J10	6.350	3.18			2.8	0.03			
	VBGT110301FR/L-J10	0.1									
	VBGT110302FR/L-J10	0.2									
	VBGT110304FR/L-J10	0.4									





J-type chipbreaker for finishing(Honed)

Appearance	Insert Cat. No.	Dimensions (mm)				Stocked grades					
		I.C. dia.	Thickness	Hole dia.	Corner radius	Coated		Cermet	Uncoated		
						J530	J740	NS530	TH10		
	CCGT060201R/L-J10	6.350	2.38	2.8	0.1						
	CCGT060202R/L-J10				0.2						
	CCGT09T301R/L-J10				9.525	3.97	4.4	0.1			
	CCGT09T302R/L-J10							0.2			
	DCGT070201R/L-J10	6.350	2.38	2.8				0.1			
	DCGT070202R/L-J10							0.2			
DCGT11T301R/L-J10	9.525				3.97	4.4	0.1				
DCGT11T302R/L-J10							0.2				
		TCGT080201R/L-J08	4.760	2.38			2.2	0.1			
		TCGT080202R/L-J08						0.2			
	TCGT110201R/L-J10	6.350			2.38	2.8		0.1			
	TCGT110202R/L-J10							0.2			
TCGT110301R/L-J10	6.350		3.18	2.8			0.1				
TCGT110302R/L-J10							0.2				
		VBGT110301R/L-J10			6.350	3.18	2.8	0.1			
		VBGT110302R/L-J10						0.2			
	VBGT110304R/L-J10	0.4									







Stock status : Stocked item

General Purpose Positive Inserts





PF-type chipbreaker for finishing

Appearance	Insert Cat. No.	Dimensions (mm)				Stocked grades					
		I.C. dia.	Thickness	Hole dia.	Corner radius	Coated					Cermet
						T9015	T9025	T6020	T6030	GH730	NS530
	CCMT060202-PF	6.350	2.38	2.8	0.2						
	CCMT060204-PF				0.4						
	CCMT060208-PF				0.8						
	CCMT09T302-PF	9.525	3.97	4.4	0.2						
	CCMT09T304-PF				0.4						
	CCMT09T308-PF				0.8						
	DCMT070202-PF	6.350	2.38	2.8	0.2						
	DCMT070204-PF				0.4						
	DCMT070208-PF				0.8						
	DCMT11T302-PF	9.525	3.97	4.4	0.2						
	DCMT11T304-PF				0.4						
	DCMT11T308-PF				0.8						

PS-type chipbreaker for finishing to medium cutting

Appearance	Insert Cat. No.	Dimensions (mm)				Stocked grades						
		I.C. dia.	Thickness	Hole dia.	Corner radius	Coated					Cermet	
						T9015	T9025	T6020	T6030	GH730	NS530	AT530
	CCMT060202-PS	6.350	2.38	2.8	0.2							
	CCMT060204-PS				0.4							
	CCMT060208-PS				0.8							
	CCMT09T302-PS	9.525	3.97	4.4	0.2							
	CCMT09T304-PS				0.4							
	CCMT09T308-PS				0.8							
	DCMT070202-PS	6.350	2.38	2.8	0.2							
	DCMT070204-PS				0.4							
	DCMT070208-PS				0.8							
	DCMT11T302-PS	9.525	3.97	4.4	0.2							
	DCMT11T304-PS				0.4							
	DCMT11T308-PS				0.8							
	TCMT110202-PS	6.350	2.38	2.8	0.2							
	TCMT110204-PS				0.4							
	TCMT110208-PS				0.8							
	VBMT110302-PS	6.350	3.18	2.8	0.2							
	VBMT110304-PS				0.4							
	VBMT110308-PS				0.8							




PM-type chipbreaker for medium cutting

Appearance	Insert Cat. No.	Dimensions (mm)				Stocked grades					
		I.C. dia.	Thickness	Hole dia.	Corner radius	Coated					Cermet
						T9015	T9025	T6020	T6030	GH730	NS530
	CCMT060204-PM	6.350	2.38	2.8	0.4						
	CCMT060208-PM				0.8						
	CCMT09T304-PM				0.4						
	CCMT09T308-PM	9.525	3.97	4.4	0.8						
	CCMT09T312-PM				1.2						
	DCMT070204-PM				0.4						
	DCMT070208-PM	6.350	2.38	2.8	0.8						
	DCMT11T304-PM				0.4						
	DCMT11T308-PM				0.8						
	DCMT11T312-PM	9.525	3.97	4.4	1.2						
	TCMT110204-PM				0.4						
	TCMT110208-PM				0.8						
	TCMT16T304-PM	6.350	2.38	2.8	0.4						
	TCMT16T308-PM				0.8						
	TCMT16T312-PM				1.2						


Stock status : Stocked item

General Purpose Negative Inserts


01-type chipbreaker for precision finishing

Appearance	Insert Cat. No.	Dimensions (mm)				Stocked grades														
		I.C. dia.	Thickness	Hole dia.	Corner radius	Coated				Cermet		Uncoated								
						T9005	T9015	T9025	T9035	T6020	T6030	GH110	NS530	GT530	TH10	TX20				
	CNGG090302-01 CNGG090304-01 CNGG090308-01	9.525	3.18	3.81	0.2															
					0.4															
					0.8															
	DNGG110402-01 DNGG110404-01 DNGG110408-01	9.525	4.76	3.81	0.2															
					0.4															
					0.8															
	TNGG160402-01 TNGG160404-01 TNGG160408-01 TNGG160412-01	9.525	4.76	3.81	0.2															
					0.4															
					0.8															
					1.2															


C-type chipbreaker for precision finishing

Appearance	Insert Cat. No.	Dimensions (mm)				Stocked grades														
		I.C. dia.	Thickness	Hole dia.	Corner radius	Coated				Cermet		Uncoated								
						T9005	T9015	T9025	T9035	T6020	T6030	GH110	NS530	GT530	TH10	TX20				
	TNGG160400R-C TNGG160400L-C TNGG160402R-C TNGG160402L-C TNGG160404R-C TNGG160404L-C TNGG160408R-C TNGG160408L-C	9.525	4.76	3.81	0.03															
					0.2															
					0.4															
					0.8															

TS-type chipbreaker for finishing

Appearance	Insert Cat. No.	Dimensions (mm)				Stocked grades												
		I.C. dia.	Thickness	Hole dia.	Corner radius	Coated				Cermet		Uncoated						
						T9005	T9015	T9025	T9035	T6020	T6030	GH110	NS530	GT530	TH10	TX20		
	TNMG160404-TS TNMG160408-TS TNMG160412-TS	9.525	4.76	3.81	0.4													
					0.8													
					1.2													

P-type chipbreaker for medium cutting

Appearance	Insert Cat. No.	Dimensions (mm)				Stocked grades												
		I.C. dia.	Thickness	Hole dia.	Corner radius	Coated				Cermet		Uncoated						
						T9005	T9015	T9025	T9035	T6020	T6030	GH110	NS530	GT530	TH10	TX20		
	TNGG160402R-P TNGG160402L-P TNGG160404R-P TNGG160404L-P TNGG160408R-P TNGG160408L-P	9.525	4.76	3.18	0.2													
					0.4													
					0.8													

Stock status : Stocked item

Standard cutting conditions and grades for general purpose chipbreaker inserts

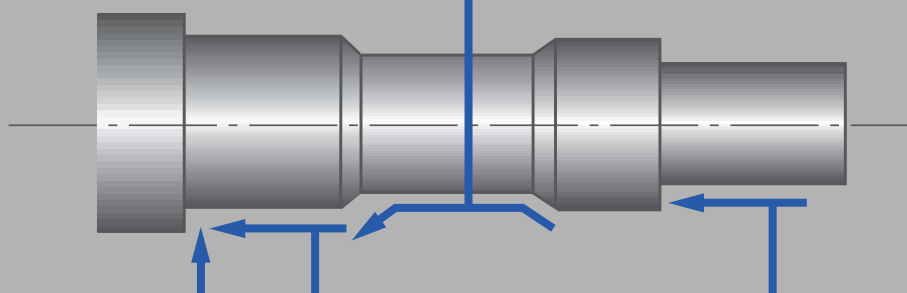
Chipbreaker	Depth of cut ap (mm)	Feed f (mm/rev)
PF	0.3-1.5	0.05-0.25
PS	0.3-2.0	0.08-0.3
PM	0.5-3.0	0.15-0.3
C	0.5-3.0	0.1-0.3
TS	0.3-1.5	0.08-0.2
P	1.0-4.0	0.2-0.5

Applicable work materials	Insert grades	Cutting speed V_c (m/min)
General steels Free-cutting steels	T9005	100-400
	T9015	80-350
	T9025	80-300
	T9035	50-200
	GH730	50-150
Stainless steels	NS530	80-300
	T6020	100-200
	T6030	50-150
	GH730	50-120
Cast irons	NS530	100-200
	GH110	30-150

J-SERIES TOOLHOLDERS FOR GENERAL EXTERNAL TURNING

For External Profiling

Positive rake							Negative rake
JTDJ2CR/L (P 11) Shank size 8 ~ 16 mm Back side clamping Without offset	JSDJ2CR/L (P 13) Shank size 10 ~ 12 mm Screw-on clamping Without offset	JSDJCR/L (P 13) Shank size 8 ~ 16 mm Screw-on clamping With offset	JSVJBR/L (P 13) Shank size 10 ~ 16 mm Screw-on clamping With offset	JSDNCN (P 14) Shank size 8 ~ 16 mm Screw-on clamping With offset	JSDN3CR/L (P 14) Shank size 12 ~ 16 mm Screw-on clamping With offset	JS-SDUCL (P 28) Shank dia. 19.05 ~ 25.4 Screw-on clamping New	JTDJ2NR/L (P 16) Shank size 12 ~ 16 mm Back side clamping Without offset



For External Turning

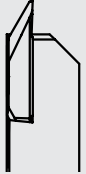
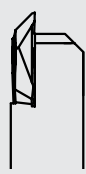
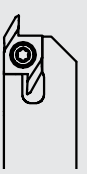
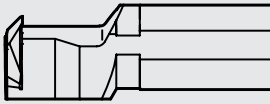
Positive rake	Negative rake	
JTTACR/L (P 11) Shank size 8 ~ 16 mm Back side clamping Without offset	JSTACR/L (P 12) Shank size 8 ~ 16 mm Screw-on clamping Without offset	JTTANR/L (P 16) Shank size 12 ~ 16 mm Back side clamping Without offset New

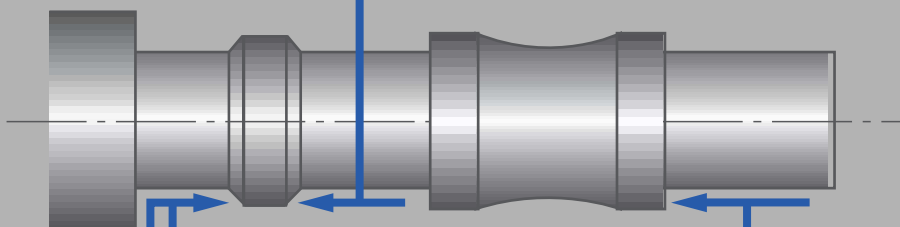
For External Turning and Facing

Positive rake							Negative rake
JTCL2CR/L (P 11) Shank size 8 ~ 16 mm Back side clamping Without offset	JSCL2CR/L (P 12) Shank size 10 ~ 12 mm Screw-on clamping Without offset	JSCLCR/L (P 12) Shank size 8 ~ 16 mm Screw-on clamping With offset	JSCGCR/L (P 14) Shank size 12 ~ 16 mm Screw-on clamping With offset	JSCACR/L (P 15) Shank size 8 ~ 12 mm Screw-on clamping Without offset	JSCFCR/L (P 15) Shank size 12 ~ 16 mm Screw-on clamping With offset	JSDFCR/L (P 15) Shank size 12 ~ 16 mm Screw-on clamping With offset	JTCL2NR/L (P 16) Shank size 12 ~ 16 mm Back side clamping Without offset

J-SERIES TOOLHOLDERS FOR FRONT, BACK, AND REVERSE TURNING

For Back Turning

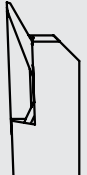
<p>JSXBR/L (P 18) Shank size 10 ~ 25 mm</p> <p>Max. depth of cut : 5.5 mm</p> 	<p>JSTBR/L (P 19) Shank size 10 ~ 16 mm</p> <p>Max. depth of cut : 2.5 mm</p> 	<p>JSEGR/L (P 20) Shank size 10 ~ 16 mm</p> <p>Max. depth of cut : 3.0 mm</p> 	<p>JS-TBL3 (P 28) New</p> <p>Shank dia. 19.05 ~ 25.4</p> <p>Max. depth of cut : 2.5 mm</p> 
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For Reverse Turning

JSXGR/L
(P 17)
Shank size
10 ~ 25 mm


Max. depth of cut : 5.5 mm



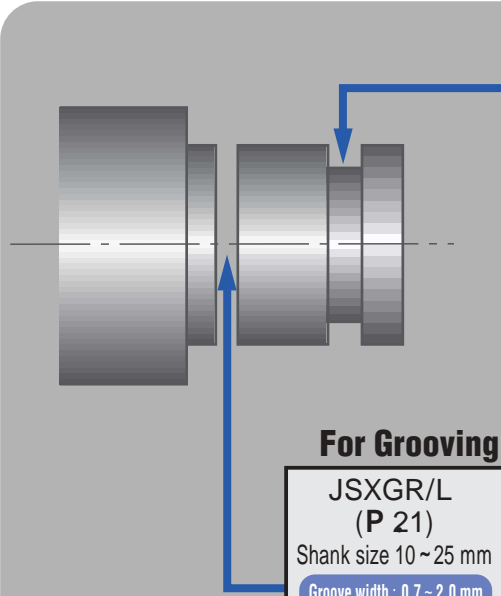
For Front Turning

JSXGR/L
(P 17)
Shank size
10 ~ 25 mm


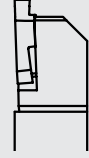
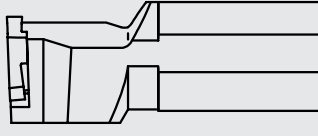
Max. depth of cut : 5.5 mm



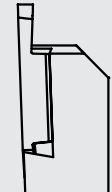
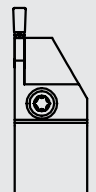
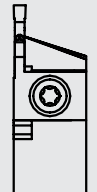

J-SERIES TOOLHOLDERS FOR GROOVING AND PARTING-OFF



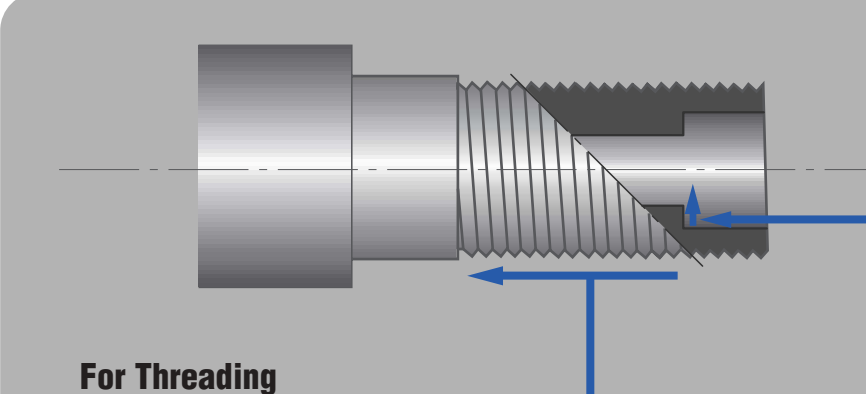
For Grooving

<p>JSVGR/L (P 22)</p> <p>Shank size 10 ~ 16 mm</p> <p>Groove width : 0.33 ~ 2.0 mm Max. groove depth : 0.7 ~ 5.5 mm</p> 	<p>JSTGR/L (P 23)</p> <p>Shank size 10 ~ 16 mm</p> <p>Groove width : 0.33 ~ 3.0 mm Max. groove depth : 0.7 ~ 2.6 mm</p> 	<p>JS-TGL3 (P 29) New</p> <p>Shank dia. 19.05 ~ 25.4</p> <p>Groove width : 0.33 ~ 3.0 mm Max. groove depth : 0.7 ~ 2.6 mm</p> 
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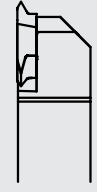

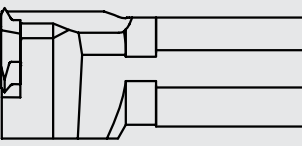
For Grooving and Parting-off

<p>JSXGR/L (P 21)</p> <p>Shank size 10 ~ 25 mm</p> <p>Groove width : 0.7 ~ 2.0 mm Max. parting dia. : 9 ~ 12</p> 	<p>JCGSSR/L (P 24)</p> <p>Shank size 10 ~ 16 mm</p> <p>Groove width : 2.0 mm Max. parting dia. : 20 ~ 32</p> 	<p>JCCWSR/L (P 24)</p> <p>Shank size 10 ~ 25 mm</p> <p>Groove width : 2.0 mm Max. parting dia. : 20</p> 	<p>JCGWSR/L (P 25)</p> <p>Shank size 10 ~ 16 mm</p> <p>Groove width : 2.0 mm Max. parting dia. : 20</p> 
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J-SERIES TOOLHOLDERS FOR THREADING AND BORING



For Threading

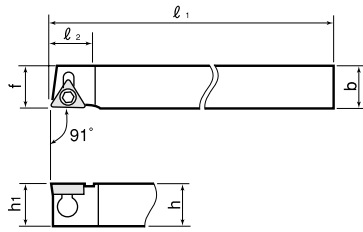
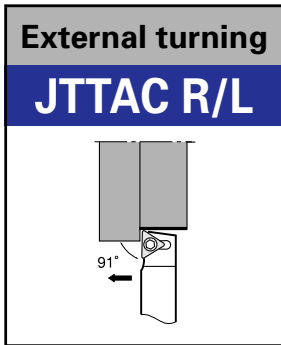
<p>JSTTR/L (P 26)</p> <p>Shank size 10 ~ 16 mm</p> <p>Applicable pitch range: 0.5 ~ 1 mm</p> 	<p>JSXBR/L (P 26)</p> <p>Shank size 10 ~ 25 mm</p> <p>Applicable pitch range: 0.5 ~ 1 mm</p> 	<p>JS-TTL3 (P 30) New</p> <p>Shank dia. 19.05 ~ 25.4</p> <p>Applicable pitch range: 0.5 ~ 1 mm</p> 
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For Boring

<p>JS08H-SEXPR/L (P 27) New</p> <p>Shank dia. 8</p> <p>Min. bore dia. 5.5 ~ 7</p> 

J-SERIES TOOLHOLDERS FOR GENERAL EXTERNAL TURNING

JT-type (Positive, back-side clamping)



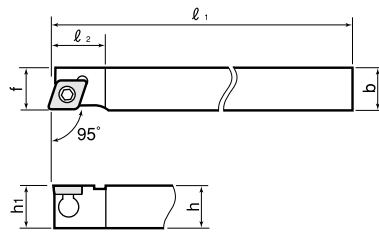
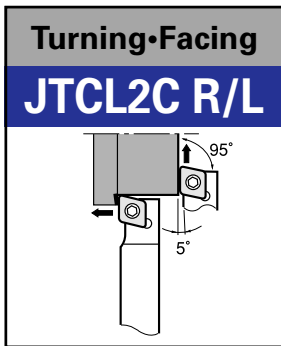
Without offset Right hand (R) shown.

Recommended chipbreaker

Application	Prec. finishing	Finish to medium	Medium cutting	Stainless
Chipbreaker	01	PS	PM	SS
Shape	(11)	(11)	(11)	(11)
Application	Aluminum	Prec. finishing		
Chipbreaker	PP	J		
Shape	(11)	(08, 11)		

Toolholder Cat. No.	Stock		Applicable insert.	Dimensions (mm)					
	R	L		h	b	l ₁	l ₂	h ₁	f
JTTACR/L0810K08			TC 0802	8	10	125	10	8	10
JTTACR/L1010K08			TC 0802	10	10	125	10	10	10
JTTACR/L1212M11			TC 1102	12	12	150	12	12	12
JTTACR/L1616M11			TC 1102	16	16	150	12	16	16

Clamp	Clamping screw	Wrench
	.	
JCP-1	JDS-3525	P-2F
JCP-2	JDS-3525	P-2F



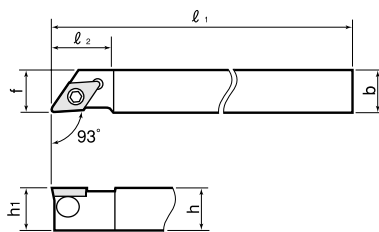
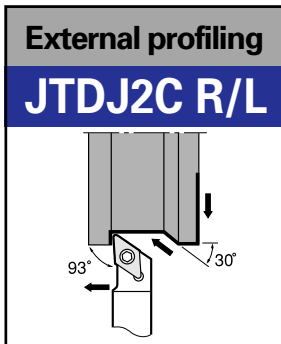
Without offset Right hand (R) shown.

Recommended chipbreaker

Application	Prec. finishing	Finishing	Finish to medium	Medium cutting
Chipbreaker	01	PF	PS	PM
Shape	(06, 09)	(06, 09)	(06, 09)	(06, 09)
Application	Aluminum	Aluminum	Prec. finishing	Finish to medium
Chipbreaker	PP	(T-DIA)	J	-
Shape	(06, 09)	(06, 09)	(06, 09)	(06, 09)

Toolholder Cat. No.	Stock		Applicable insert.	Dimensions (mm)					
	R	L		h	b	l ₁	l ₂	h ₁	f
JTCL2CR/L0810K06			CC 0602	8	10	125	12	8	10
JTCL2CR/L1010K06			CC 0602	10	10	125	12	10	10
JTCL2CR/L1212M09			CC 09T3	12	12	150	16	12	12
JTCL2CR/L1616M09			CC 09T3	16	16	150	16	16	16

Clamp	Clamping screw	Wrench
	.	
JCP-2	JDS-3525	P-2F
JCP-3	JDS-5040	P-2.5F



Without offset Right hand (R) shown.

Recommended chipbreaker

Application	Prec. finishing	Finishing	Finish to medium	Medium cutting
Chipbreaker	01	PF	PS	PM
Shape	(07, 11)	(07, 11)	(07, 11)	(07, 11)
Application	Aluminum	Aluminum	Prec. finishing	Finish to medium
Chipbreaker	PP	(T-DIA)	J	-
Shape	(07, 11)	(07, 11)	(07, 11)	(07, 11)

Toolholder Cat. No.	Stock		Applicable insert.	Dimensions (mm)					
	R	L		h	b	l ₁	l ₂	h ₁	f
JTDJ2CR/L0810K07			DC 0702	8	10	125	14	8	10
JTDJ2CR/L1010K07			DC 0702	10	10	125	14	10	10
JTDJ2CR/L1212M11			DC 11T3	12	12	150	18	12	12
JTDJ2CR/L1616M11			DC 11T3	16	16	150	18	16	16

Clamp	Clamping screw	Wrench
	.	
JCP-2	JDS-3525	P-2F
JCP-3	JDS-5040	P-2.5F

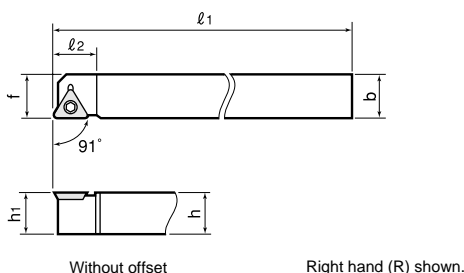
Stock status : Stocked item

J-SERIES TOOLHOLDERS FOR GENERAL EXTERNAL TURNING

J-type (Positive, screw-on clamping)

External turning

JSTAC R/L



Recommended chipbreaker

Application	Prec. finishing	Finish to medium	Medium cutting	Stainless
Chipbreaker	01	PS	PM	SS
Shape	(11)	(11)	(11)	(11)
Application	Aluminum	Prec. finishing		
Chipbreaker	PP	J		
Shape	(11)	(08, 11)		

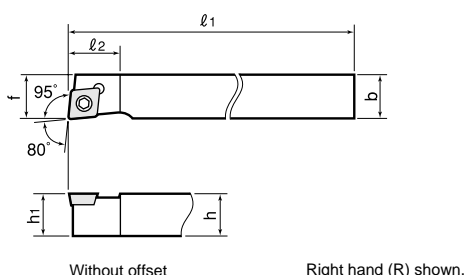
Toolholder Cat. No.	Stock		Applicable insert.	Dimensions (mm)					
	R	L		h	b	l ₁	l ₂	h ₁	f
JSTACR/L 0808K08			TC 0802	8	8	125	10	8	8
JSTACR/L 1010K08			TC 0802	10	10	125	10	10	10
JSTACR/L 1212K11			TC 1102	12	12	125	12	12	12
JSTACR/L 1616H11			TC 1102	16	16	100	12	16	16

Clamping screw	Wrench	
CSTB-2L	T-6F	(T-6L)
CSTB-2.5	T-8F	(T-8L)

() : Optional parts

Turning·Facing

JSCL2C R/L



Recommended chipbreaker

Application	Prec. finishing	Finishing	Finish to medium	Medium cutting
Chipbreaker	01	PF	PS	PM
Shape	(06)	(06)	(06)	(06)
Application	Aluminum	Aluminum	Prec. finishing	Finish to medium
Chipbreaker	PP	(T-DIA)	J	-
Shape	(06)	(06)	(06)	(06)

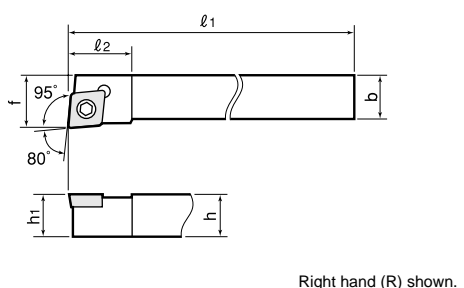
Toolholder Cat. No.	Stock		Applicable insert.	Dimensions (mm)					
	R	L		h	b	l ₁	l ₂	h ₁	f
JSCL2CR/L 1010K06			CC 0602	10	10	125	12	10	10
JSCL2CR/L 1212K06			CC 0602	12	12	125	12	12	12

Clamping screw	Wrench	
CSTB-2.5	T-8F	(T-8L)

() : Optional parts

Turning·Facing

JSCLC R/L



Recommended chipbreaker

Application	Prec. finishing	Finishing	Finish to medium	Medium cutting
Chipbreaker	01	PF	PS	PM
Shape	(06, 09)	(06, 09)	(06, 09)	(06, 09)
Application	Aluminum	Aluminum	Prec. finishing	Finish to medium
Chipbreaker	PP	(T-DIA)	J	-
Shape	(06, 09)	(06, 09)	(06, 09)	(06, 09)

Toolholder Cat. No.	Stock		Applicable insert.	Dimensions (mm)					
	R	L		h	b	l ₁	l ₂	h ₁	f
JSCLCR/L0808H06			CC 0602	8	8	100	12	8	10
JSCLCR/L1010H06			CC 0602	10	10	100	12	10	12
JSCLCR/L1212H09			CC 09T3	12	12	100	16	12	16
JSCLCR/L1616H09			CC 09T3	16	16	100	16	16	20

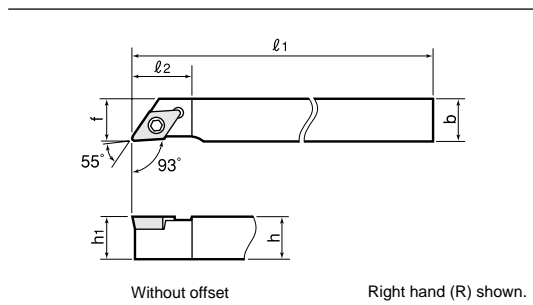
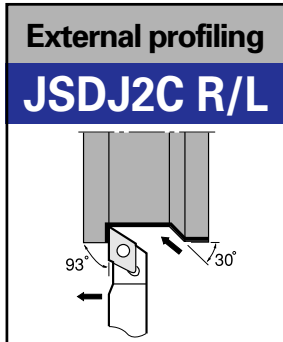
Clamping screw	Wrench	
CSTB-2.5	T-8F	(T-8L)
CSTB-4SD		

() : Optional parts

Stock status : Stocked item

J-SERIES TOOLHOLDERS FOR GENERAL EXTERNAL TURNING

J-type (Positive, screw-on clamping)



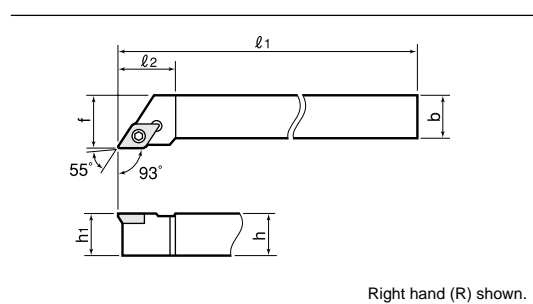
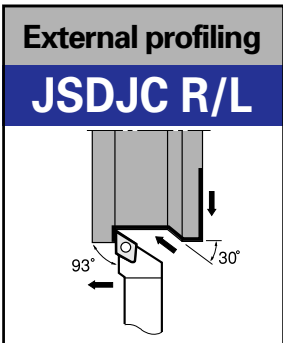
Recommended chipbreaker

Application	Prec. finishing	Finishing	Finish to medium	Medium cutting
Chipbreaker	01	PF	PS	PM
Shape				
	(07)	(07)	(07)	(07)
Application	Aluminum	Aluminum	Prec. finishing	Finish to medium
Chipbreaker	PP	(T-DIA)	J	-
Shape				
	(07)	(07)	(07)	(07)

Toolholder Cat. No.	Stock		Applicable insert.	Dimensions (mm)					
	R	L		h	b	l ₁	l ₂	h ₁	f
JSDJ2CR/L 1010K07			DC 0702	10	10	125	14	10	10
JSDJ2CR/L 1212K07				12	12	125	14	12	12

Clamping screw	Wrench	
CSTB-2.5	T-8F	(T-8L)

(): Optional parts



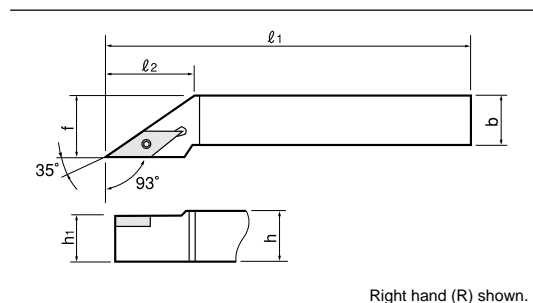
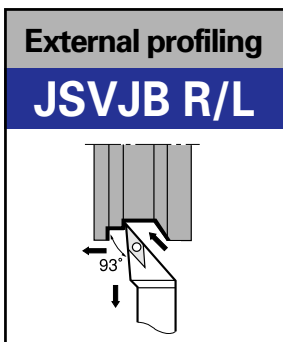
Recommended chipbreaker

Application	Prec. finishing	Finishing	Finish to medium	Medium cutting
Chipbreaker	01	PF	PS	PM
Shape				
	(07, 11)	(07, 11)	(07, 11)	(07, 11)
Application	Aluminum	Aluminum	Prec. finishing	Finish to medium
Chipbreaker	PP	(T-DIA)	J	-
Shape				
	(07, 11)	(07, 11)	(07, 11)	(07, 11)

Toolholder Cat. No.	Stock		Applicable insert.	Dimensions (mm)					
	R	L		h	b	l ₁	l ₂	h ₁	f
JSDJCR/L 0808H07			DC 0702	8	8	100	14	8	10
JSDJCR/L 1212H07				12	12	100	14	12	16
JSDJCR/L 1010H11			DC 11T3	10	10	100	18	10	12
JSDJCR/L 1212H11				12	12	100	18	12	16
JSDJCR/L 1616H11				16	16	100	18	16	20

Clamping screw	Wrench	
CSTB-2.5	T-8F	(T-8L)
CSTB-4SD		

(): Optional parts



Recommended chipbreaker

Application	Prec. finishing	Finishing		
Chipbreaker	PS	J		
Shape				
	(11)	(11)		
Application				
Chipbreaker				
Shape				

Toolholder Cat. No.	Stock		Applicable insert.	Dimensions (mm)					
	R	L		h	b	l ₁	l ₂	h ₁	f
JSVJBR/L 1010H11			VB 1103	10	10	100	20	10	12
JSVJBR/L 1212H11				12	12	100	22	12	16
JSVJBR/L 1616H11				16	16	100	22	16	20

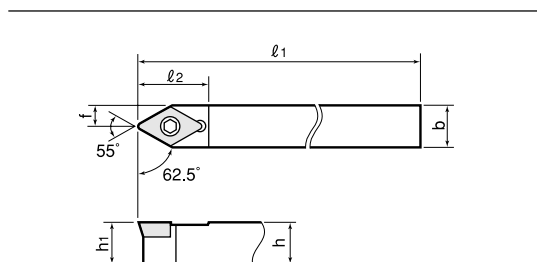
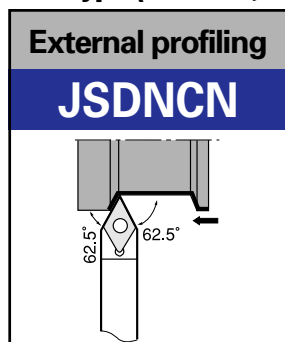
Clamping screw	Wrench	
CSTB-2.5	T-8F	(T-8L)

(): Optional parts

Stock status : Stocked item

J-SERIES TOOLHOLDERS FOR GENERAL EXTERNAL TURNING

J-type (Positive, screw-on clamping)



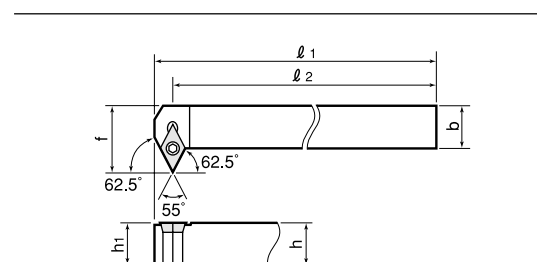
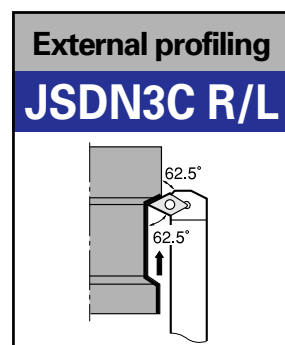
Toolholder Cat. No.	Stock	Applicable insert.	Dimensions (mm)					
			h	b	l ₁	l ₂	h ₁	f
JSDNCN 0808H07		DC 0702	8	8	100	14	8	4
JSDNCN 1010K07			10	10	125	14	10	5
JSDNCN 1212K07			12	12	125	14	12	6
JSDNCN 1212H11		DC 11T3	12	12	100	21	12	6
JSDNCN 1616H11			16	16	100	21	16	8

Recommended chipbreaker

Application	Prec. finishing	Finishing	Finish to medium	Medium cutting
Chipbreaker	01	PF	PS	PM
Shape				
	(07, 11)	(07, 11)	(07, 11)	(07, 11)
Application	Aluminum	Aluminum	Prec. finishing	Finish to medium
Chipbreaker	PP	(T-DIA)	J	-
Shape				
	(07, 11)	(07, 11)	(07, 11)	(07, 11)

Clamping screw	Wrench	
CSTB-2.5	T-8F	(T-8L)
CSTB-4SD		

() : Optional parts



Right hand (R) shown.

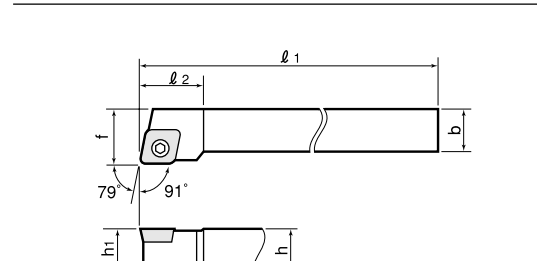
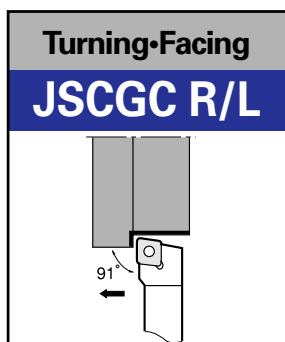
Toolholder Cat. No.	Stock		Applicable insert.	Dimensions (mm)					
	R	L		h	b	l ₁	l ₂	h ₁	f
JSDN3CR/L 1212H07			DC 0702	12	12	105	100	12	18
JSDN3CR/L 1616H11			DC 11T3	16	16	107	100	16	25

Recommended chipbreaker

Application	Prec. finishing	Finishing	Finish to medium	Medium cutting
Chipbreaker	01	PF	PS	PM
Shape				
	(07, 11)	(07, 11)	(07, 11)	(07, 11)
Application	Aluminum	Aluminum	Prec. finishing	Finish to medium
Chipbreaker	PP	(T-DIA)	J	-
Shape				
	(07, 11)	(07, 11)	(07, 11)	(07, 11)

Clamping screw	Wrench	
CSTB-2.5	T-8F	(T-8L)
CSTB-4SD		

() : Optional parts



Right hand (R) shown.

Toolholder Cat. No.	Stock		Applicable insert.	Dimensions (mm)					
	R	L		h	b	l ₁	l ₂	h ₁	f
JSCGCR/L 1212H06			CC 0602	12	12	100	12	12	16
JSCGCR/L 1616H09			CC 09T3	16	16	100	16	16	20

Recommended chipbreaker

Application	Prec. finishing	Finishing	Finish to medium	Medium cutting
Chipbreaker	01	PF	PS	PM
Shape				
	(06, 09)	(06, 09)	(06, 09)	(06, 09)
Application	Aluminum	Aluminum	Prec. finishing	Finish to medium
Chipbreaker	PP	(T-DIA)	J	-
Shape				
	(06, 09)	(06, 09)	(06, 09)	(06, 09)

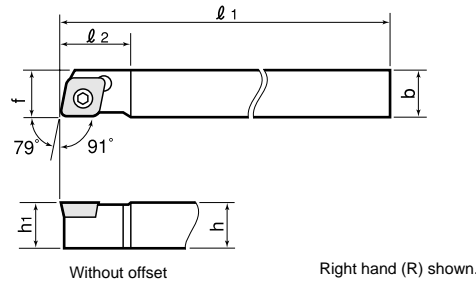
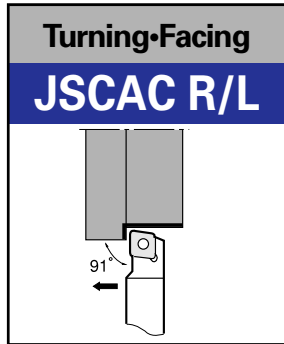
Clamping screw	Wrench	
CSTB-2.5	T-8F	(T-8L)
CSTB-4SD		

() : Optional parts

Stock status : Stocked item

J-SERIES TOOLHOLDERS FOR GENERAL EXTERNAL TURNING

J-type (Positive, screw-on clamping)



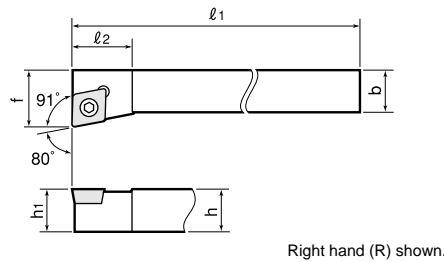
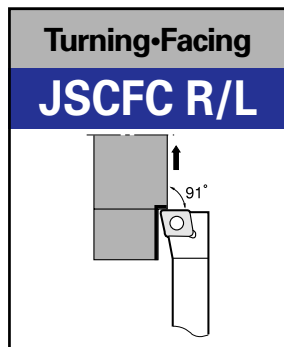
Recommended chipbreaker

Application	Prec. finishing	Finishing	Finish to medium	Medium cutting
Chipbreaker	01	PF	PS	PM
Shape				
	(06, 09)	(06, 09)	(06, 09)	(06, 09)
Application	Aluminum	Aluminum	Prec. finishing	Finish to medium
Chipbreaker	PP	(T-DIA)	J	-
Shape				
	(06, 09)	(06, 09)	(06, 09)	(06, 09)

Toolholder Cat. No.	Stock		Applicable insert.	Dimensions (mm)					
	R	L		h	b	l ₁	l ₂	h ₁	f
JSCACR/L 0808H06			CC 0602	8	8	100	12	8	8
JSCACR/L 1010H06			CC 0602	10	10	100	12	10	10
JSCACR/L 1212H09			CC 09T3	12	12	100	16	12	12

Clamping screw	Wrench	
CSTB-2.5	T-8F	(T-8L)
CSTB-4SD		

() : Optional parts



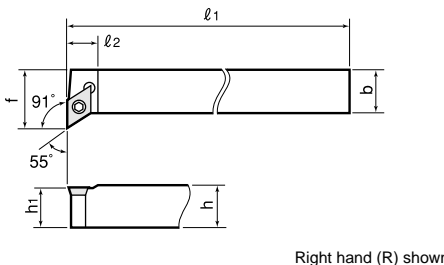
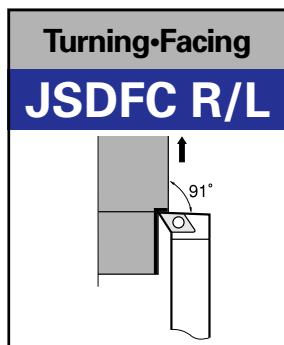
Recommended chipbreaker

Application	Prec. finishing	Finishing	Finish to medium	Medium cutting
Chipbreaker	01	PF	PS	PM
Shape				
	(06, 09)	(06, 09)	(06, 09)	(06, 09)
Application	Aluminum	Aluminum	Prec. finishing	Finish to medium
Chipbreaker	PP	(T-DIA)	J	-
Shape				
	(06, 09)	(06, 09)	(06, 09)	(06, 09)

Toolholder Cat. No.	Stock		Applicable insert.	Dimensions (mm)					
	R	L		h	b	l ₁	l ₂	h ₁	f
JSCFCR/L 1212H06			CC 0602	12	12	100	16	12	16
JSCFCR/L 1616H09			CC 09T3	16	16	100	16	16	20

Clamping screw	Wrench	
CSTB-2.5	T-8F	(T-8L)
CSTB-4SD		

() : Optional parts



Recommended chipbreaker

Application	Prec. finishing	Finishing	Finish to medium	Medium cutting
Chipbreaker	01	PF	PS	PM
Shape				
	(07, 11)	(07, 11)	(07, 11)	(07, 11)
Application	Aluminum	Aluminum	Prec. finishing	Finish to medium
Chipbreaker	PP	(T-DIA)	J	-
Shape				
	(07, 11)	(07, 11)	(07, 11)	(07, 11)

Toolholder Cat. No.	Stock		Applicable insert.	Dimensions (mm)					
	R	L		h	b	l ₁	l ₂	h ₁	f
JSDFCR/L 1212H07			DC 0702	12	12	100	8	12	16
JSDFCR/L 1616H11			DC 11T3	16	16	100	10.5	16	22

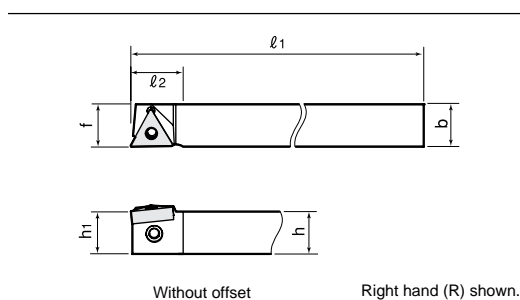
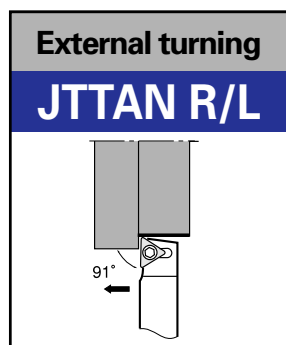
Clamping screw	Wrench	
CSTB-2.5	T-8F	(T-8L)
CSTB-4SD		

() : Optional parts

Stock status : Stocked item

New J-SERIES TOOLHOLDERS FOR GENERAL EXTERNAL TURNING

JT-type (Negative, back-side clamping)

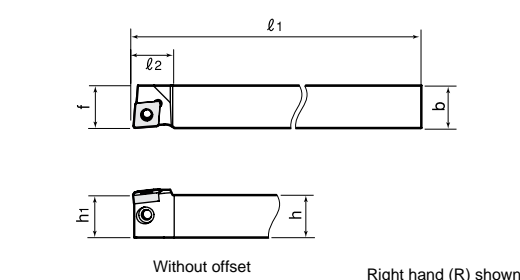
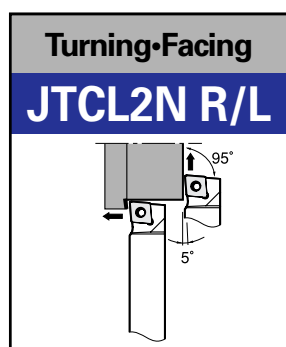


Recommended chipbreaker

Application Chipbreaker	Prec. finishing 01	Prec. finishing C	Finishing P	Finishing TS
Shape				
Application Chipbreaker				
Shape				

Toolholder Cat. No.	Stock		Applicable insert.	Dimensions (mm)					
	R	L		h	b	l ₁	l ₂	h ₁	f
JTTANR/L 1216K16			TN 1604	12	16	125	19.8	12	16
JTTANR/L 1616K16				16	16	125	19.8	16	16

Clamp	Clamping screw	Wrench
	.	
JCP-3N	JDS-5040	P-2.5F

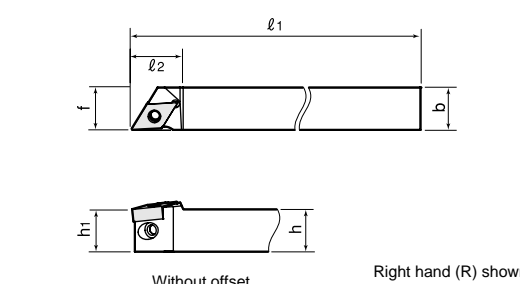
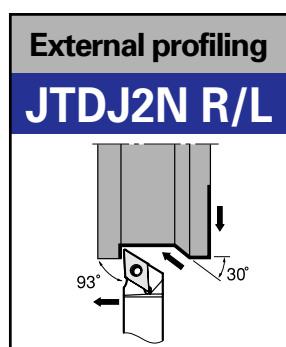


Recommended chipbreaker

Application Chipbreaker	Prec. finishing 01			
Shape				
Application Chipbreaker				
Shape				

Toolholder Cat. No.	Stock		Applicable insert.	Dimensions (mm)					
	R	L		h	b	l ₁	l ₂	h ₁	f
JTCL2NR/L 1216K09			CN 0903	12	16	125	15.6	12	16
JTCL2NR/L 1616K09				16	16	125	15.6	16	16

Clamp	Clamping screw	Wrench
	.	
JCP-3N	JDS-5040	P-2.5F



Recommended chipbreaker

Application Chipbreaker	Prec. finishing 01			
Shape				
Application Chipbreaker				
Shape				

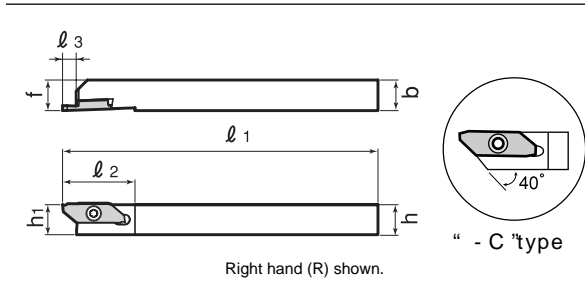
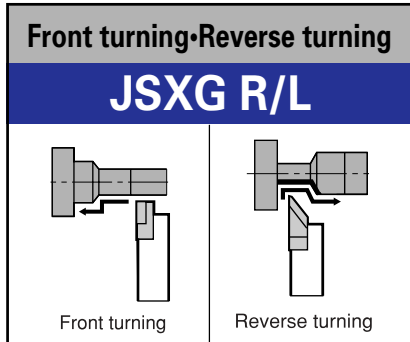
Toolholder Cat. No.	Stock		Applicable insert.	Dimensions (mm)					
	R	L		h	b	l ₁	l ₂	h ₁	f
JTDJ2NR/L 1216K11			DN 1104	12	16	125	15.6	12	16
JTDJ2NR/L 1616K11				16	16	125	15.6	16	16

Clamp	Clamping screw	Wrench
	.	
JCP-3N	JDS-5040	P-2.5F

Stock status : Stocked item

J-SERIES TOOLHOLDERS FOR FRONT AND REVERSE TURNING

JSXG-type (Commonly used for grooving and parting-off)



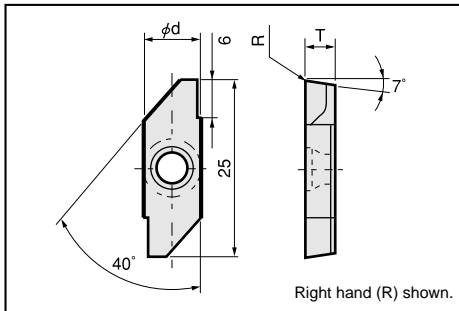
Can be wrenched from back side with double-socket Torx screw.

Toolholder Cat. No.	Stock		Applicable insert.	Dimensions (mm)						Clamping screw	Wrench		
	R	L		h	b	l ₁	l ₂	l ₃	h1		f		
JSXGR/L1010K8-C			JXFR/L8 JXRR/L8	10	10	125	29	6.7	10	10	CSTB-4SD	T-8F	(T-8L)
JSXGR/L1212K8-C				12	12	125	29	6.7	12	12			
JSXGR/L1616K8				16	16	125	29	6.5	16	16			
JSXGR/L2020K8				20	20	125	29	6.5	20	20			
JSXGR/L2525K8				25	25	125	29	6.5	25	25			

Note: These toolholders can be also used for JXG-type grooving and parting-off inserts.

(): Optional parts

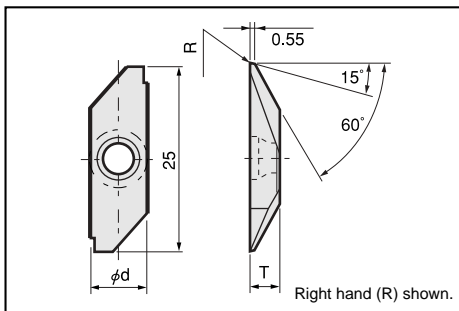
Inserts



JXF-type inserts for front turning (With sharp edge)

Insert Cat. No.	Dimensions (mm)				Stocked grades					
	d	T	R	Max. depth of cut	Coated		Cermet		Uncoated	
					J740	NS530	TH10	R	L	R
JXFR/L8000F	8	3.97	0.03	5.5						
JXFR/L8010F			0.1							

Inserts



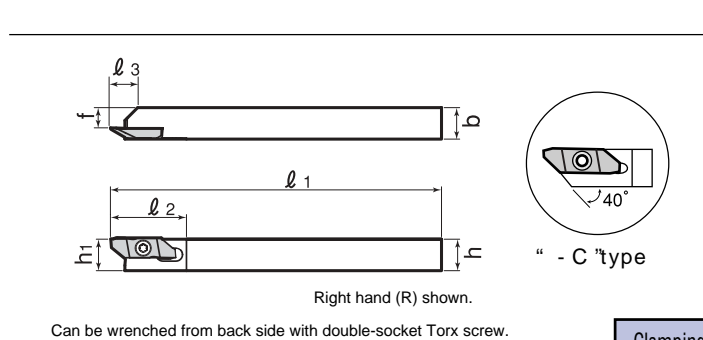
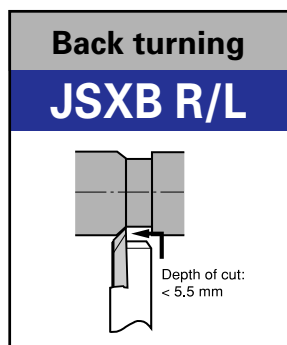
JXR-type inserts for reverse turning (With sharp edge)

Insert Cat. No.	Dimensions (mm)				Stocked grades					
	d	T	R	Max. depth of cut	Coated		Cermet		Uncoated	
					J740	NS530	TH10	R	L	R
JXRR/L8000F	8	3.97	0.03	5.5						
JXRR/L8010F			0.1							

Stock status : Stocked item

J-SERIES TOOLHOLDERS FOR BACK TURNING

JSXB-type (Commonly used for threading)

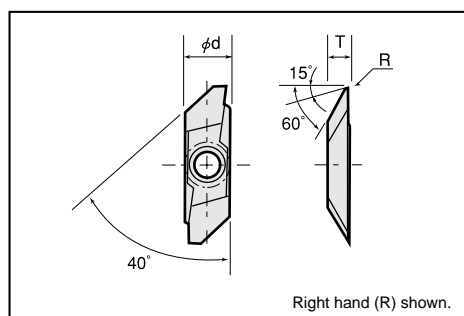


Toolholder Cat. No.	Stock		Applicable insert.	Dimensions (mm)							Clamping screw	Wrench		
	R	L		h	b	l_1	l_2	l_3	h_1	f		T-8F		(T-8L)
JSXBR/L1010K8-C			JXBR/L8	10	10	125	29	6.7	10	5.7	CSTB-4SD	T-8F		(T-8L)
JSXBR/L1212K8-C				12	12	125	29	6.7	12	7.7				
JSXBR/L1616K8				16	16	125	29	6.4	16	11.7				
JSXBR/L2020K8				20	20	125	29	6.4	20	15.7				
JSXBR/L2525K8				25	25	125	29	6.4	25	20.7				

Note: These toolholders can be also used for JXT-type threading inserts.

(): Optional parts

Inserts



JXB-type inserts (with sharp edges)

Insert Cat. No.	Dimensions (mm)				Stocked grades						
	d	T	R	Max. depth of cut	Coated		Cermet		Uncoated		
					J740	NS530	TH10	R	L	R	L
JXBR/L8000F	8	3.97	0.03	5.5							
JXBR/L8005F			0.05								
JXBR/L8010F			0.1								
JXBR/L8015F			0.15								

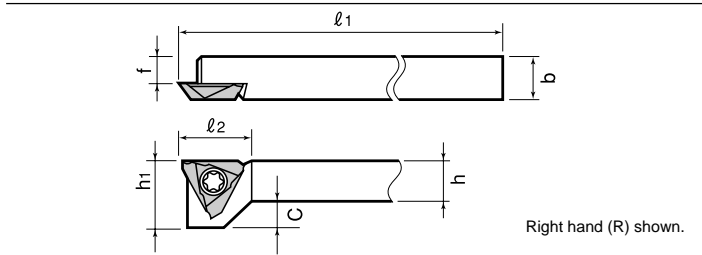
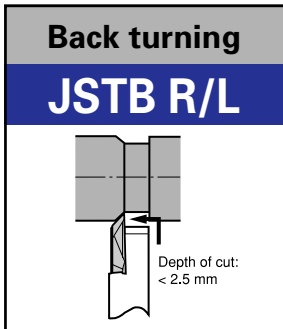
JXB-type inserts (with honed edges)

Insert Cat. No.	Dimensions (mm)				Stocked grades					
	d	T	R	Max. depth of cut	Coated		Cermet		Uncoated	
					J740	NS530	TH10	R	L	R
JXBR/L8005	8	3.97	0.05	5.5						
JXBR/L8010			0.1							
JXBR/L8015			0.15							


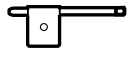
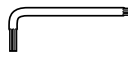
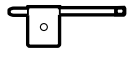
Stock status : Stocked item

J-SERIES TOOLHOLDERS FOR BACK TURNING

JSTB-type

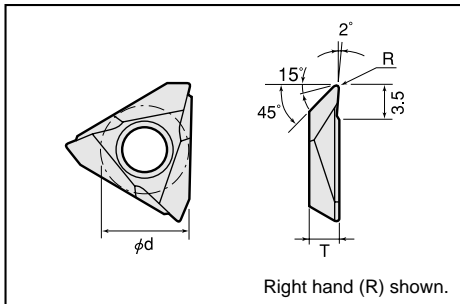


Can be wrenched from back side with double-socket Torx screw.

Toolholder Cat. No.	Stock		Applicable insert.	Dimensions (mm)						Clamping screw	Wrench		
	R	L		h	b	l ₁	l ₂	h ₁	f	c			
JSTBR/L1010K3			JTBR/L3	10	10	125	15	10	6	5	CSTB-4SD		(T-8L)
JSTBR/L1212K3				12	12	125	15	12	8	3			
JSTBR/L1616K3				16	16	125	15	16	12	-			

() : Optional parts

Inserts



JTB-type inserts (with sharp edges)

Insert Cat. No.	Dimensions (mm)				Stocked grades						
	d	T	R	Max. depth of cut	Coated		Cermet		Uncoated		
					J740	NS530	TH10	R	L	R	L
JTBR/L3000F	9.438	3.18	0.03	2.5							
JTBR/L3005F			0.05								
JTBR/L3010F			0.1								
JTBR/L3015F			0.15								

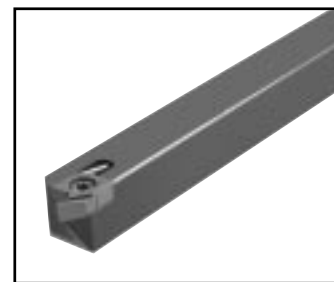
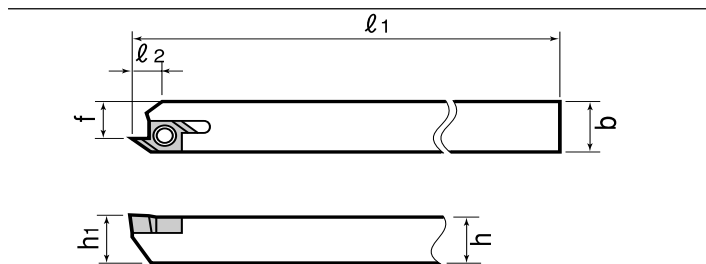
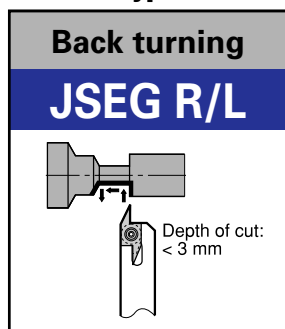
JTB-type inserts (with honed edges)

Insert Cat. No.	Dimensions (mm)				Stocked grades							
	d	T	R	Max. depth of cut	Coated				Cermet		Uncoated	
					J530	J740	NS530	TH10	R	L	R	L
JTBR/L3005	9.438	3.18	0.05	2.5								
JTBR/L3010			0.1									
JTBR/L3015			0.15									

Stock status : Stocked item

J-SERIES TOOLHOLDERS FOR BACK TURNING

JSEG-type



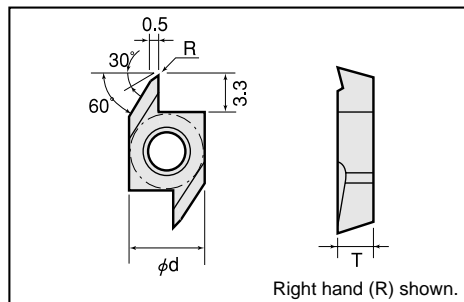
Right hand (R) shown.

Clamping screw	Wrench	
CSTB-2.5	T-8F	(T-8L)

Toolholder Cat. No.	Stock		Applicable insert.	Dimensions (mm)					
	R	L		h	b	l ₁	l ₂	h ₁	f
JSEGR/L1010K10			J10ER/L B	10	10	125	-	10	7.5
JSEGR/L1212K10				12	12	125	-	12	9.5
JSEGR/L1616K10				16	16	125	-	16	13.5

() : Optional parts

Inserts



J10E-type inserts (with sharp edges)

Insert Cat. No.	Dimensions (mm)				Stocked grades									
	d	T	R	Max. depth of cut	Coated				Cermet		Uncoated			
					J530		J740		NS530		TH10			
R	L	R	L	R	L	R	L	R	L					
J10ER/L005BF	6.35	3.18	0.05	< 3										
J10ER/L010BF			0.1											
J10ER/L015BF			0.15											

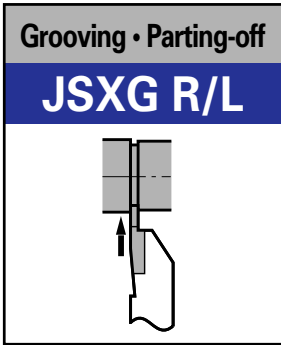
J10E-type inserts (with honed edges)

Insert Cat. No.	Dimensions (mm)				Stocked grades									
	d	T	R	Max. depth of cut	Coated				Cermet		Uncoated			
					J530		J740		NS530		TH10			
R	L	R	L	R	L	R	L	R	L					
J10ER/L005B	6.35	3.18	0.05	< 3										
J10ER/L010B			0.1											
J10ER/L015B			0.15											

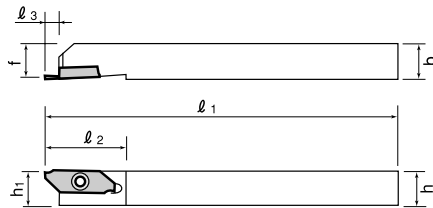
Stock status : Stocked item

J-SERIES TOOLHOLDERS FOR GROOVING

JSXG-type



(2-corner type)



“ - C ” type

Right hand (R) shown.

Can be wrenched from back side with double-socket Torx screw.

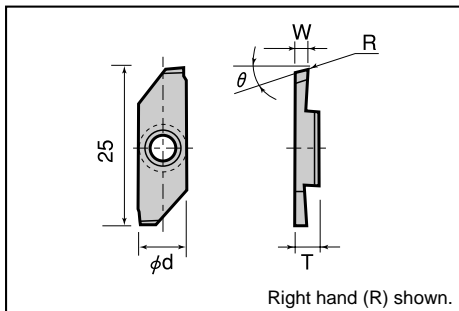


Toolholder Cat. No.	Stock		Applicable insert.	Dimensions (mm)						Clamping screw	Wrench			
	R	L		h	b	l ₁	l ₂	l ₃	h ₁	f				
JSXGR/L1010K8-C			JXGR/L8	10	10	125	29	6.7	10	10	CSTB-4SD		T-8F	(T-8L)
JSXGR/L1212K8-C				12	12	125	29	6.7	12	12				
JSXGR/L1616K8				16	16	125	29	6.5	16	16				
JSXGR/L2020K8				20	20	125	29	6.5	20	20				
JSXGR/L2525K8				25	25	125	29	6.5	25	25				

These toolholders are also used for JXF- and JXR-type inserts.

() : Optional parts

Inserts



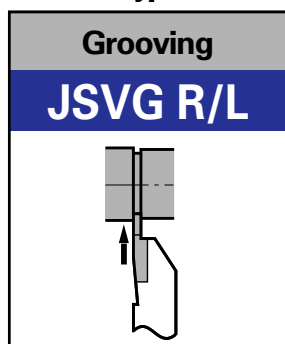
JXG-type inserts (with sharp edges)

Insert Cat. No.	Dimensions (mm)					Stocked grades								
	d	T	W ^{0.05}	Max. groove depth	R	Coated		Cermet		Uncoated				
						J740	NS530	TH10	TH10					
JXGR/L8070FA	8	3.97	0.7	4.5	0									
JXGR/L8070FA-005														
JXGR/L8100FA						1	6	0						
JXGR/L8100FA-005								0.05						
JXGR/L8100FA45						4.5	4.5	0						
JXGR/L8100FA45-005								0.05						
JXGR/L8120FA						1.2	6	0						
JXGR/L8150FA								0						
JXGR/L8150FA-005						1.5	6	0.05						
JXGR/L8150FA50								0						
JXGR/L8150FA50-005						5	0.05	0						
JXGR/L8180FA								0						
JXGR/L8180FA-005						1.8	0.05	0						
JXGR/L8200FA								0						
JXGR/L8200FA-005						2	6	0.05						
JXGR/L8200FN								0						
JXGR/L8200FN-005						0°	0.05							

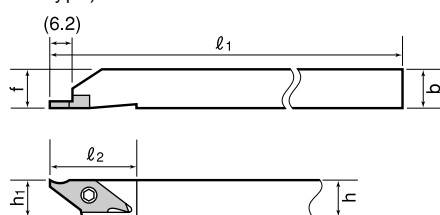
Stock status : Stocked item

J-SERIES TOOLHOLDERS FOR GROOVING

JSVG-type




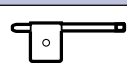
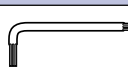
(2-corner type)



" - C "type

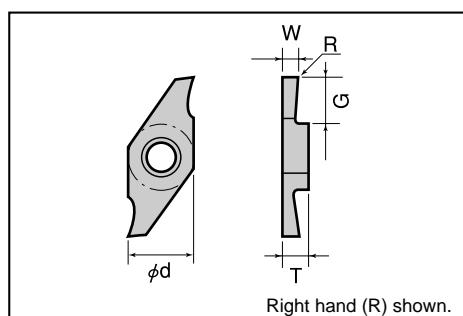
Right hand (R) shown.



Toolholder Cat. No.	Stock		Applicable insert.	Dimensions (mm)					Clamping screw	Wrench		
	R	L		h	b	l ₁	l ₂	h ₁	f			
JSVGR/L1010K-C			JVGR/L	10	10	125	23	10	10	CSTB-3S	T-9F	(T-9L)
JSVGR/L1212K-C				12	12	125	23	12	12			
JSVGR/L1616K				16	16	125	23	16	16			

() : Optional parts

Inserts



JVGR-type inserts (with sharp edges)

Insert Cat. No.	Dimensions (mm)						Stocked grades							
	d	T	W ^{0.05}	G	Max. groove depth	R	Coated		Cermet		Uncoated			
							J740	NS530	TH10	R	L	R	L	R
JVGR/L033F	7.94	3.18	0.95	0.33	0.8	0.7								
JVGR/L050F				0.5	1.2	1.1								
JVGR/L075F				0.75	2	1.9								
JVGR/L095F				0.95										
JVGR/L100F				1	6	5.5								
JVGR/L125F				1.25	5.5	5								
JVGR/L150F				1.5	6	5.5								
JVGR/L200F				2										

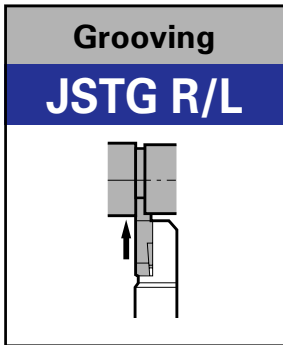
Stock status : Stocked item

Standard cutting conditions (Grooving)

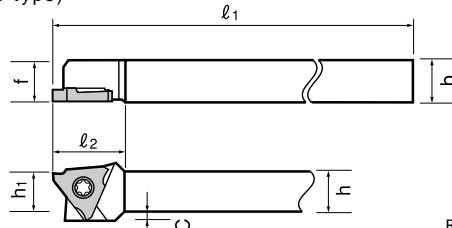
Grade	Work material	Cutting speed Vc (m/min)	Feed f (mm/rev)
J740	General steels	10-50-100	0.01-0.05-0.1
	Stainless steels		
	Free-cutting steels		
NS530 J530	General steels	50-80-150	0.01-0.05-0.1
	Stainless steels		
TH10	Aluminum, copper alloys	10-80-200	0.01-0.05-0.1
	Difficult-to-cut materials such as titanium alloys	10-20-30	0.01-0.05-0.1

J-SERIES TOOLHOLDERS FOR GROOVING

JSTG-type

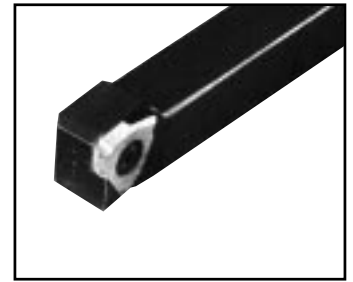



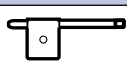
(3-corner type)



Right hand (R) shown.

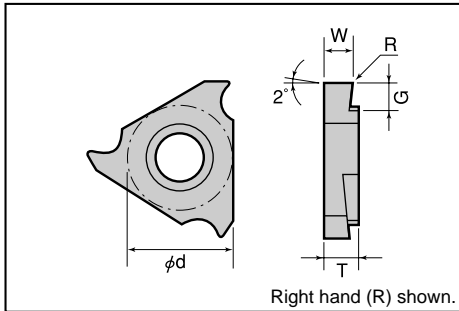
Can be wrenched from back side with double-socket Torx screw.



Toolholder Cat. No.	Stock		Applicable insert.	Dimensions (mm)						Clamping screw	Wrench		
	R	L		h	b	l ₁	l ₂	h ₁	f		c		
JSTGR/L1010K3			JTGR/L3	10	10	125	18.5	10	10	2	CSTB-4SD	T-8F	(T-8L)
JSTGR/L1212K3				12	12	125	18.5	12	12	-			
JSTGR/L1616K3				16	16	125	18.5	16	16	-			

() : Optional parts

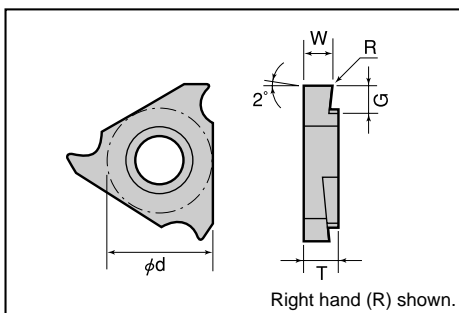
Inserts



JTG-type inserts (with sharp edges)

Insert Cat. No.	Dimensions (mm)						Stocked grades												
	d	T	W ₀ ^{+0.05}	G	Max. groove depth	R	Coated				Cermet		Uncoated						
							J530	J740	NS530	TH10	R	L	R	L					
JTGR/L3033F	9.525	3.18	0.33	0.8	0.7	0.03													
JTGR/L3043F			0.43	1.2	1.1														
JTGR/L3050F			0.5	1.2	1.1														
JTGR/L3065F			0.65	2	1.9														
JTGR/L3075F			0.75																
JTGR/L3080F			0.8																
JTGR/L3085F			0.85																
JTGR/L3095F			0.95																
JTGR/L3100F			1.0																
JTGR/L3110F			1.1																
JTGR/L3120F			1.2																
JTGR/L3125F			1.25																
JTGR/L3130F			1.3																
JTGR/L3140F			1.4	2.2	2.1														
JTGR/L3145F			1.45																
JTGR/L3150F			1.5																
JTGR/L3175F			1.75																
JTGR/L3180F			1.8																
JTGR/L3200F			2.0																
JTGR/L3225F			2.25																
JTGR/L3250F	2.5	2.7	2.6																
JTGR/L3275F	2.75																		
JTGR/L3300F	3.0																		

Inserts



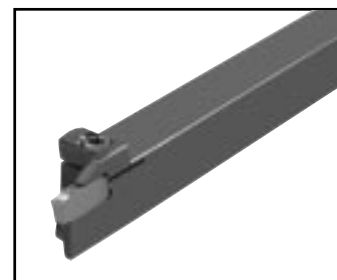
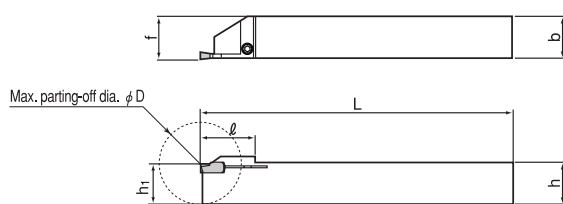
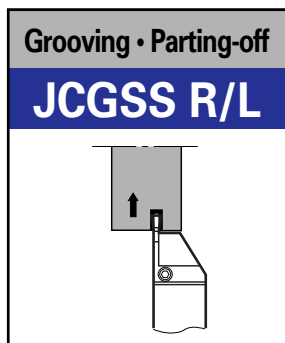
JTG-type inserts (with honed edges)

Insert Cat. No.	Dimensions (mm)						Stocked grades										
	d	T	W ₀ ^{+0.05}	G	Max. groove depth	R	Coated				Cermet		Uncoated				
							J530	J740	NS530	TH10	R	L	R	L			
JTGR/L3033	9.525	3.18	0.33	0.8	0.7	0.03											
JTGR/L3050			0.5	1.2	1.1												
JTGR/L3075			0.75	2	1.9												
JTGR/L3095			0.95														
JTGR/L3100			1														
JTGR/L3125			1.25														
JTGR/L3145			1.45	2.2	2.1												
JTGR/L3150			1.5														
JTGR/L3175			1.75														
JTGR/L3200			2														
JTGR/L3250			2.5	2.7	2.6												

Stock status : Stocked item

J-SERIES TOOLHOLDERS FOR GROOVING AND PARTING-OFF

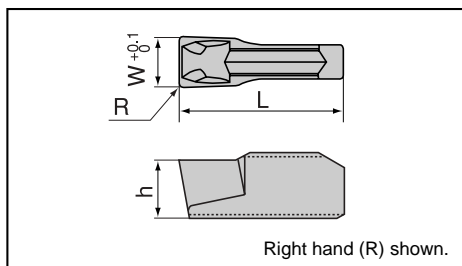
JCGSS-type



Right hand (R) shown.

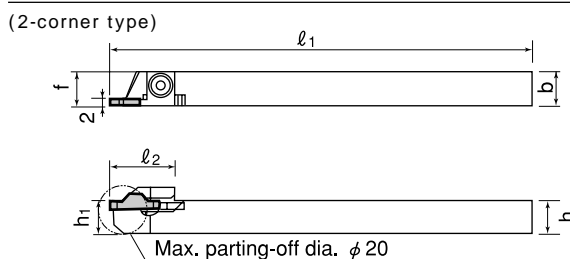
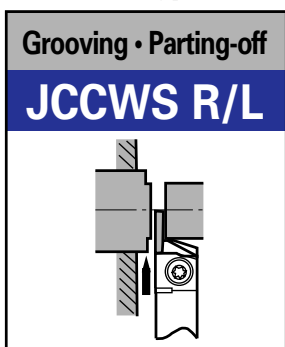
Groove width	Toolholder Cat. No.	Stock		Applicable insert.	Dimensions (mm)								Clamping screw	Wrench
		R	L		b	h	h ₁	L	ℓ	f	Max. parting-off dia. φD			
2	JCGSSR/L1010-20			GE20	10	10	10	125	15	10.2	20	CSTB-3		
	JCGSSR/L1212-20				12	12	12	125	19	12.2	25			
	JCGSSR/L1616-20				16	16	16	125	22.5	16.2	32			

Inserts



Insert Cat. No.	Dimensions (mm)				Stocked grades		
	W	L	h	R	Coated		Cermet
					T9025	GH730	NS530
GE20	2	10	3.5	0.2			

JCCWS-type

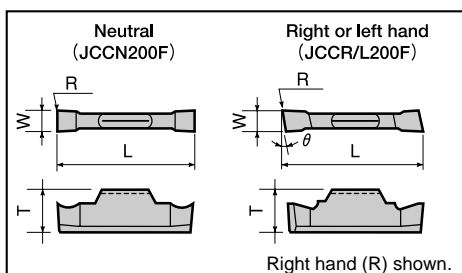


Right hand (R) shown.

Toolholder Cat. No.	Stock		Applicable insert.	Dimensions (mm)								Clamping screw	Wrench	
	R	L		h	b	ℓ ₁	ℓ ₂	h ₁	f	Max. parting-off dia. φD				
JCCWSR/L1010K2			JCC 200	10	10	125	19	10	10	20	CSTB-4S		(T-15L)	
JCCWSR/L1212K2				12	12	125	19	12	12	20				
JCCWSR/L1616K2				16	16	125	19	16	16	20				
JCCWSR/L2020K2				20	20	125	19	20	20	20				
JCCWSR/L2525K2				20	25	125	19	25	25	20				

() : Optional parts

Inserts



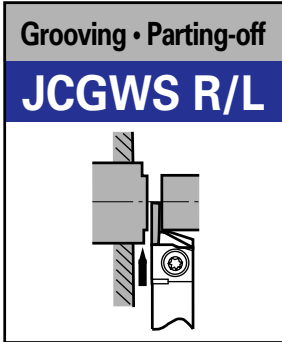
JCC-type inserts (with sharp edge)

Insert Cat. No.	Dimensions (mm)					Stocked grades			
	T	W	L	R		Coated		Cermet	Uncoated
						J530	J740	NS530	TH10
JCCN200F	4.8	2	15	0	15°				
JCCN200F-005				0.05					
JCCR/L200F				0					
JCCR/L200F-005				0.05					

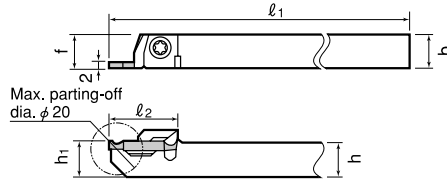
Stock status : Stocked item

J-SERIES TOOLHOLDERS FOR GROOVING AND PARTING-OFF

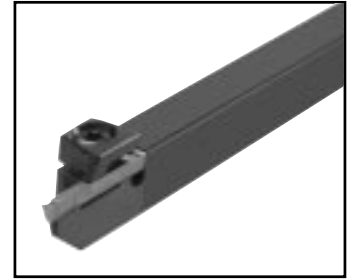
JCGWS-type


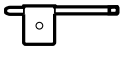
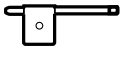
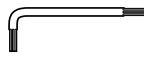


(2-corner type)



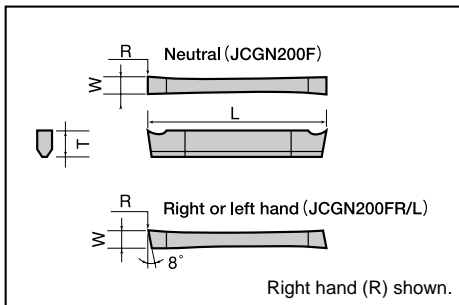
Right hand (R) shown.



Toolholder Cat. No.	Stock		Applicable insert.	Dimensions (mm)							Clamping screw 	Wrench 	
	R	L		h	b	l ₁	l ₂	h ₁	f	Max. parting dia. D			
JCGWSR/L1010K2			JCGN200	10	10	125	19.5	10	10	20	CSTB-4S	T-15F	(T-15L)
JCGWSR/L1212K2				12	12	125	19.5	12	12	20			
JCGWSR/L1616K2				16	16	125	19.5	16	16	20			

(): Optional parts

Inserts



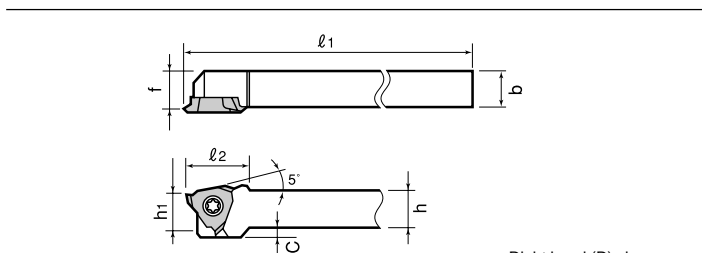
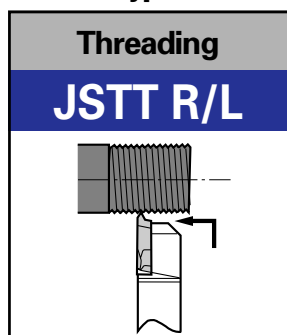
JCG-type inserts (with sharp edges)

Insert Cat. No.	Dimensions (mm)				Stocked grades								
	T	W	L	R	Coated				Cermet		Uncoated		
					J530	J740	NS530	TH10	R	L	R	L	
JCGN200F	3	2	20	0.05									
JCGN200FR/L													

Stock status : Stocked item

J-SERIES TOOLHOLDERS FOR THREADING

JSTT-type



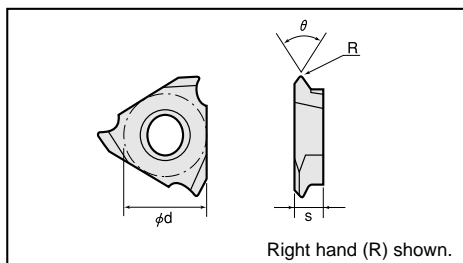
Right hand (R) shown.

Can be wrenched from back side with double-socket Torx screw.

Toolholder Cat. No.	Stock		Applicable insert.	Dimensions (mm)						Clamping screw	Wrench		
	R	L		h	b	l ₁	l ₂	h ₁	f		c		
JSTTR/L1010K3			JTTR/L30	10	10	125	16.5	10	9.5	2	CSTB-4SD	T-8F	(T-8L)
JSTTR/L1212K3				12	12	125	16.5	12	11.5	-			
JSTTR/L1616K3				16	16	125	16.5	16	15.5	-			

(): Optional parts

Inserts



Right hand (R) shown.

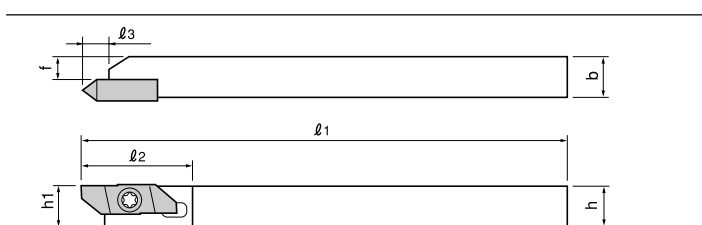
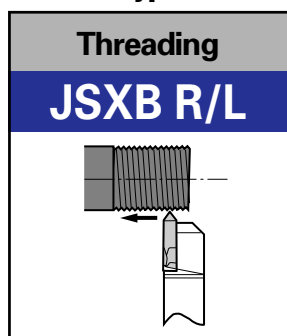
JTT-type inserts (with sharp edges)

Insert Cat. No.	Dimensions (mm)			Stocked grades					
	d	S	R	Coated		Cermet		Uncoated	
				J530	J740	NS530	TH10		
JTTR/L3005F	60°	9.525	3.18	0.05					
JTTR/L3010F					0.10				
JTTR/L3005F-55	55°			0.05					

Machinable pitch range P=0.5 - 1.0 mm

Stock status : Stocked item

JSXB-type



Right hand (R) shown.

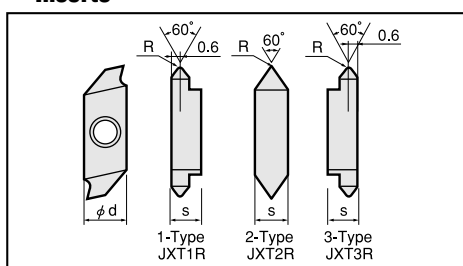
Can be wrenched from back side with double-socket Torx screw.

Toolholder Cat. No.	Stock		Applicable insert.	Dimensions (mm)						Clamping screw	Wrench		
	R	L		h	b	l ₁	l ₂	l ₃	h ₁		f		
JSXBR/L1010K8-C			JXT R/L	10	10	125	29	6.7	10	5.7	CSTB-4SD	T-8F	(T-8L)
JSXBR/L1212K8-C				12	12	125	29	6.7	12	5.7			
JSXBR/L1616K8				16	16	125	29	6.4	16	11.7			
JSXBR/L2020K8				20	20	125	29	6.4	20	15.7			
JSXBR/L2525K8				25	25	125	29	6.4	25	20.7			

These toolholders are also used for back turning.

(): Optional parts

Inserts



JXT-type inserts (with sharp edges)

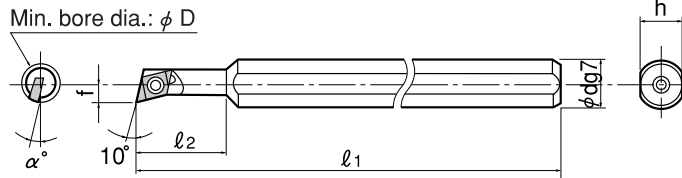
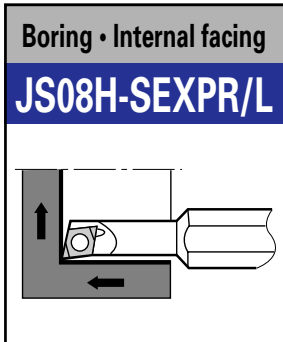
Insert Cat. No.	Dimensions (mm)			Stocked grades					
	d	S	R	Coated		Cermet		Uncoated	
				J530	J740	NS530	TH10		
JXT1R/L6000F	60°	8	3.97	0.03					
JXT2R/L6000F									
JXT3R/L6000F									

Figures at left show right hand (R) inserts. Right hand toolholders use right hand insert and left hand toolholders use left hand insert.

Stock status : Stocked item

New J-SERIES TOOLHOLDERS FOR BORING

Steel-shank S-type (Positive, screw-on clamping)



Right hand (R) shown.

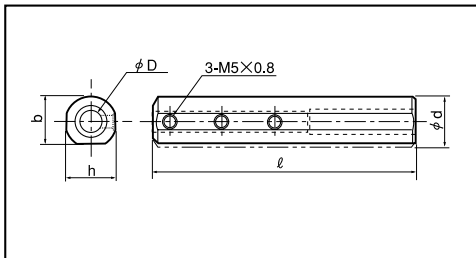


Toolholder Cat. No.	Stock		Applicable insert	Min. bore dia. D	Std. corner rc	Dimensions (mm)							Clamping screw	Wrench	
	R	L				d	f	l ₁	l ₂	h	b	°			a
JS08H-SEXPR/L045			EP 0401	5.5	0.4	8	2.7	100	16	7	-	12°	-	CSTB-2	T-6F
JS08H-SEXPR/L047				7	0.4	8	3.55	100	20	7	-	12°	-		

Inserts

Appearance	Insert Cat. No.	Dimensions (mm)				Stocked grades	
		I.C. dia.	Thickness	Hole dia.	Corner R	Coated	
						J740	
R	L						
	EPGT040100R/L-J08	3.97	1.59	2.3	0.03		
	EPGT040102R/L-J08				0.2		
	EPGT040104R/L-J08				0.4		

Applicable sleeves



BLM type sleeves (Round shank)

Sleeve Cat. No.	Stock	Applicable shank dia. D	Dimensions (mm)			
			d	l	b	h
BLM19-08		8	19.05	100	18	18
BLM20-08			20	100	19	18
BLM22-08			22	125	21	21
BLM254-08			25.4	125	24	24

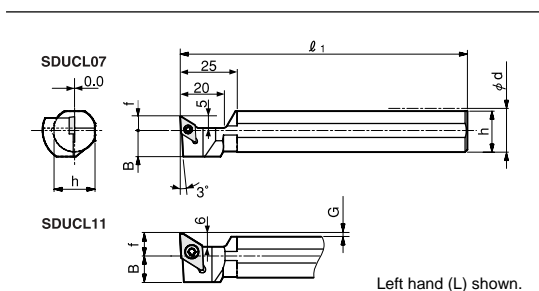
Stock status : Stocked item

New J-SERIES TOOLHOLDERS FOR EXTERNAL PROFILING (ROUND SHANK)

JS-SDUCL-type

External profiling

JS-SDUCL



Recommended chipbreaker

Application	Prec. finishing	Finishing	Finish to medium	Medium cutting
Chipbreaker	01	PF	PS	PM
Shape				
	(07, 11)	(07, 11)	(07, 11)	(07, 11)
Application	Aluminum	Aluminum	Prec. finishing	Finish to medium
Chipbreaker	PP	(T-DIA)	J	-
Shape				
	(07, 11)	(07, 11)	(07, 11)	(07, 11)

Toolholder Cat. No.	Stock		Applicable insert	Dimensions (mm)					Clamping screw	Wrench	
	R	L		d	f	l ₁	h	B			G
JS19K-SDUCL07			DC 0702	19.05	6	125	18	11.5	-	CSTB-2.5	T-8F
JS20K-SDUCL07				20.00	6	125	19	11.5	-		
JS22K-SDUCL07				22.00	6	125	21	11.5	-		
JS19K-SDUCL11			DC 11T3	19.05	10	125	18	11.5	1.525	CSTB-4SD	
JS20K-SDUCL11				20.00	10	125	19	11.5	1.000		
JS22K-SDUCL11				22.00	11	125	21	11.5	1.000		
JS25K-SDUCL11				25.40	12	125	24	12.7	0.700		

Stock status : Stocked item

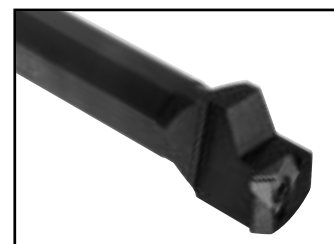
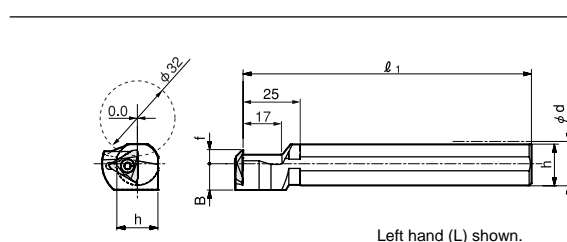
New J-SERIES TOOLHOLDERS FOR BACK TURNING (ROUND SHANK)

JS-TBL3-type

Back turning

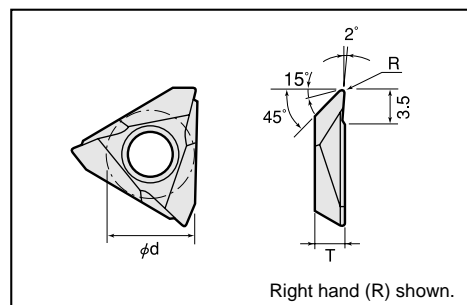
JS-TBL3

Depth of cut: < 2.5 mm



Toolholder Cat. No.	Stock		Applicable insert.	Dimensions (mm)					Clamping screw	Wrench
	R	L		d	f	l ₁	h	B		
JS19K-TBL3			JTBR30	19.05	6	125	18	11.5	CSTB-4S	T-15F
JS20K-TBL3				20.00	6	125	19	11.5		
JS22K-TBL3				22.00	6	125	21	11.5		
JS25K-TBL3				25.40	10	125	24	12.7		

Inserts



Note:
Left hand (L) toolholders use right hand (R) insert and right hand (R) toolholders use left hand insert.

JTB-type inserts (with sharp edges)

Insert Cat. No.	Dimensions (mm)				Stocked grades					
	d	T	R	Max. depth of cut	Coated		Cermet		Uncoated	
					J740	NS530	TH10	R	L	R
JTBR/L3000F	9.438	3.18	0.03	2.5						
JTBR/L3005F										
JTBR/L3010F										
JTBR/L3015F										

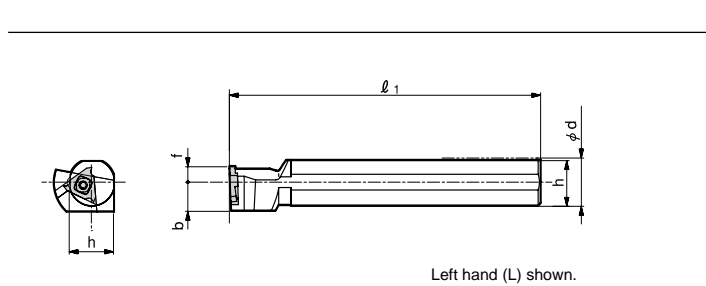
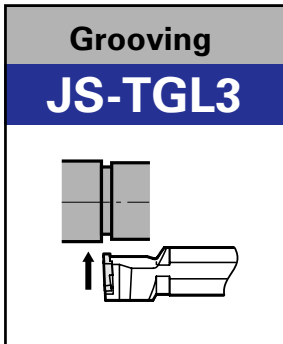
JTB-type inserts (with honed edges)


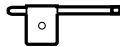
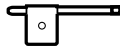
Insert Cat. No.	Dimensions (mm)				Stocked grades							
	d	T	R	Max. depth of cut	Coated		Cermet		Uncoated			
					J530	J740	NS530	TH10	R	L	R	L
JTBR/L3005	9.438	3.18	0.05	2.5								
JTBR/L3010			0.1									
JTBR/L3015			0.15									

Stock status : Stocked item 28

New J-SERIES TOOLHOLDERS FOR GROOVING (ROUND SHANK)

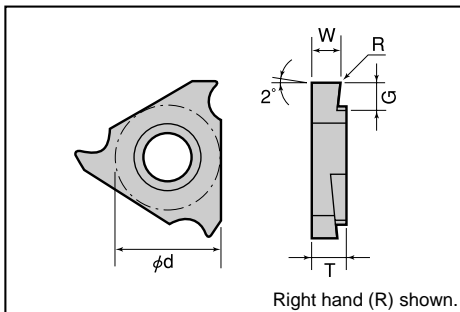
JS-TGL3-type



Toolholder Cat. No.	Stock		Applicable insert	Dimensions (mm)					Clamping screw	Wrench
	R	L		d	f	l_1	h	b		
JS19K-TGL3			JTGR3	19.05	6	125	18	11.5	CSTB-4S	
JS20K-TGL3				20.00	6	125	19	11.5		
JS22K-TGL3				22.00	6	125	21	11.5		
JS25K-TGL3				25.40	10	125	24	12.7		

(): Optional parts

Inserts

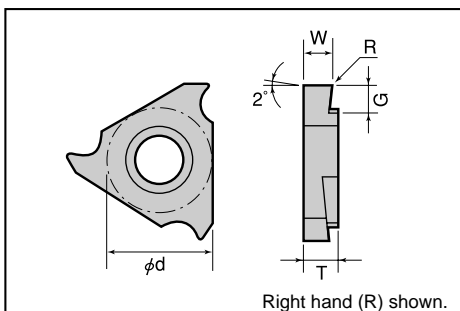


Note:
Left hand (L) toolholders use right hand (R) insert and right hand (R) toolholders use left hand insert.

JTG-type inserts (with sharp edges)

Insert Cat. No.	Dimensions (mm)						Stocked grades					
	d	T	$W_0^{+0.05}$	G	Machinable groove depth	R	Coated		Cermet		Uncoated	
							J530	J740	NS530	TH10	R	L
JTGR/L3033F	9.525	3.18	0.33	0.8	0.7	0.03						
JTGR/L3043F			0.43									
JTGR/L3050F			0.5	1.2	1.1							
JTGR/L3065F			0.65									
JTGR/L3075F			0.75	2	1.9							
JTGR/L3080F			0.8									
JTGR/L3085F			0.85									
JTGR/L3095F			0.95									
JTGR/L3100F			1.0	0.05	2.1							
JTGR/L3110F			1.1									
JTGR/L3120F			1.2									
JTGR/L3125F			1.25									
JTGR/L3130F			1.3			2.2	2.1					
JTGR/L3130F			1.3									
JTGR/L3140F			1.4									
JTGR/L3145F			1.45									
JTGR/L3150F			1.5									
JTGR/L3175F			1.75									
JTGR/L3180F			1.8									
JTGR/L3200F			2.0	2.7	2.6							
JTGR/L3225F	2.25											
JTGR/L3250F	2.5											
JTGR/L3275F	2.75											
JTGR/L3300F	3.0											

Inserts



Note:
Left hand (L) toolholders use right hand (R) insert and right hand (R) toolholders use left hand insert.

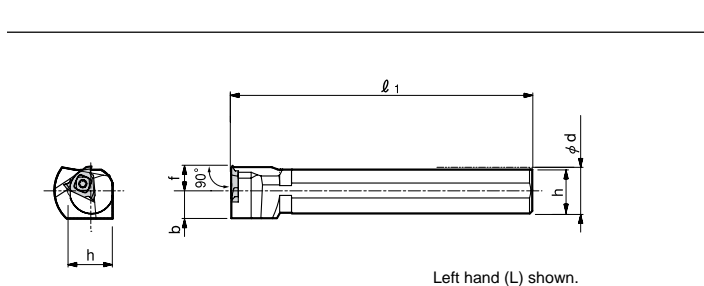
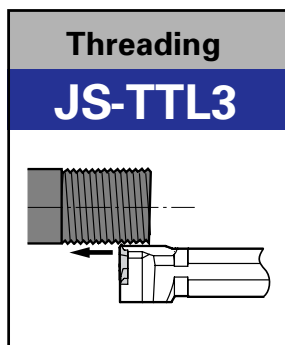
JTG-type inserts (with honed edges)

Insert Cat. No.	Dimensions (mm)						Stocked grades					
	d	T	$W_0^{+0.05}$	G	Machinable groove depth	R	Coated		Cermet		Uncoated	
							J530	J740	NS530	TH10	R	L
JTGR/L3033	9.525	3.18	0.33	0.8	0.7	0.03						
JTGR/L3050			0.5				1.2	1.1				
JTGR/L3075			0.75	2	1.9							
JTGR/L3095			0.95									
JTGR/L3100			1	0.05	2.1							
JTGR/L3125			1.25									
JTGR/L3145			1.45			2.2	2.1					
JTGR/L3150			1.5									
JTGR/L3175			1.75									
JTGR/L3200			2			2.7	2.6					
JTGR/L3250			2.5									

Stock status : Stocked item


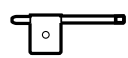
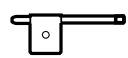
New J-SERIES TOOLHOLDERS FOR THREADING (ROUND SHANK)

JS-TTL3-type



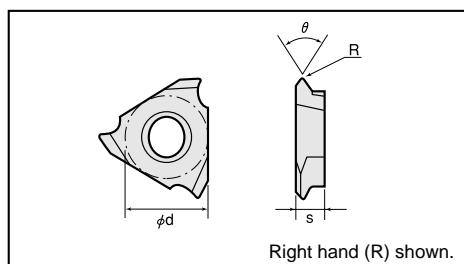
Left hand (L) shown.



Toolholder Cat. No.	Stock		Applicable insert	Dimensions (mm)					Clamping screw	Wrench
	R	L		d	f	l ₁	h	b		
JS19K-TTL3			JTTR30	19.05	10	125	18	11.5	CSTB-4S	
JS20K-TTL3				20.00	10	125	19	11.5		
JS22K-TTL3				22.00	10	125	21	11.5		
JS25K-TTL3				25.40	10	125	24	12.7		

() : Optional parts

Inserts



Right hand (R) shown.

Note:

Left hand (L) toolholders use right hand (R) insert and right hand (R) toolholders use left hand insert.

JTT-type inserts (with sharp edges)

Insert Cat. No.	Dimensions (mm)			Stocked grades									
	Cutting angle	d	S	R	Coated				Cermet		Uncoated		
					J530	J740	NS530	TH10	R	L	R	L	
JTTR/L3005F	60°	9.525	3.18	0.05									
JTTR/L3010F				0.10									
JTTR/L3005F-55	55°			0.05									

Machinable pitch range: P=0.5 ~ 1.0 mm

Stock status : Stocked item



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