

Turning tools

J-series

Precision tools for small turning lathes



J-series

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Features

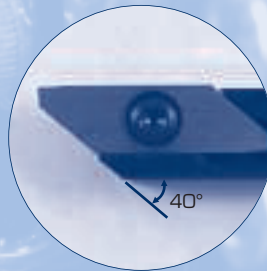
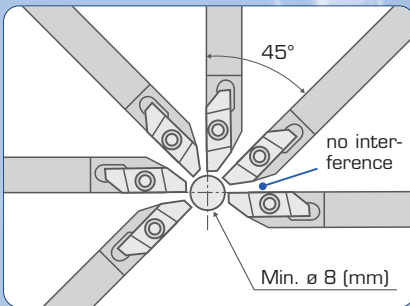
Tungaloy's newly developed J-series for CNC and automatic small lathes offers complete tooling for a wide range of machining operations. Highest precision and multifunctional application are the most outstanding characteristics. General turning, back turning, grooving, parting as well as threading are covered and the superior edge sharpness guarantees for highest performance and extended tool life.

The all around ground toolholder, combined with specially developed insert chipbreaker, provide for highest precision. Excellent cutting edge sharpness and the positive rake angle reduce cutting forces to a minimum. Especially with low cutting speed resulting from the small part-diameter, build-up cutting edge and burring are almost non-existent and the load on the main cutting edge is minimised. The

resulting outstanding tool life is a guarantee for highly economic and process stable machining.

Tungaloy
Keeping the Customer First

-C type



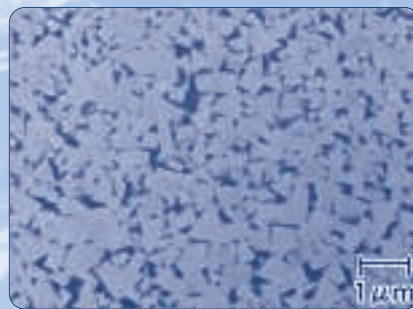
Specially suited for cam style small lathes

Multi-functional Applications:

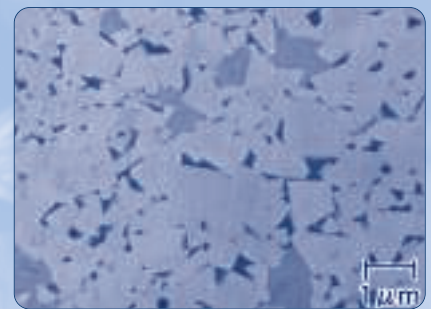
- External turning
- Facing
- Back turning
- Front and Reverse turning
- Grooving and Parting
- Threading

J740

PVD coated ultra fine grain substrate for extremely sharp cutting edges



J740

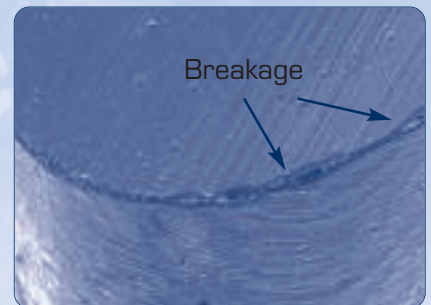


Conventional carbide

Design of cutting edge



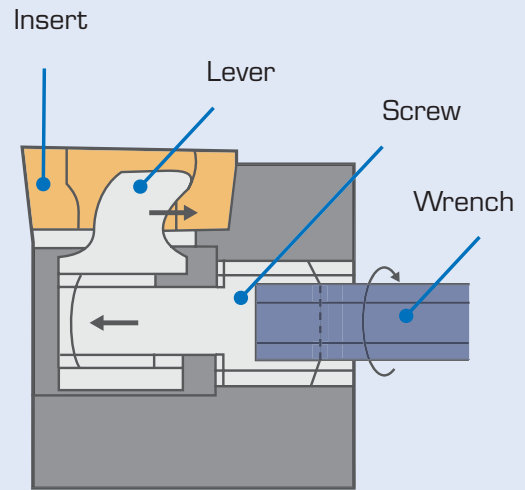
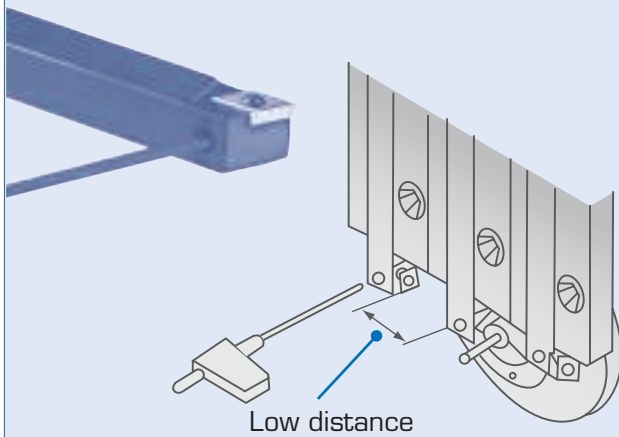
J740



Conventional carbide

Toolholder with side-clamping

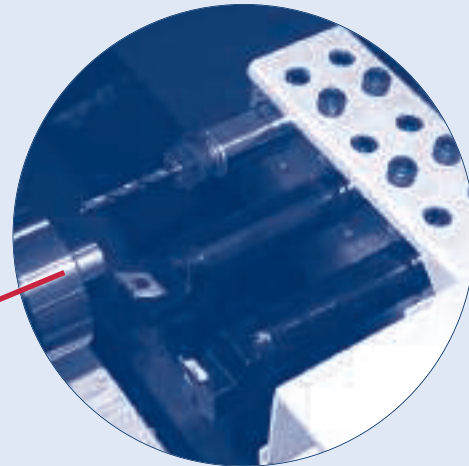
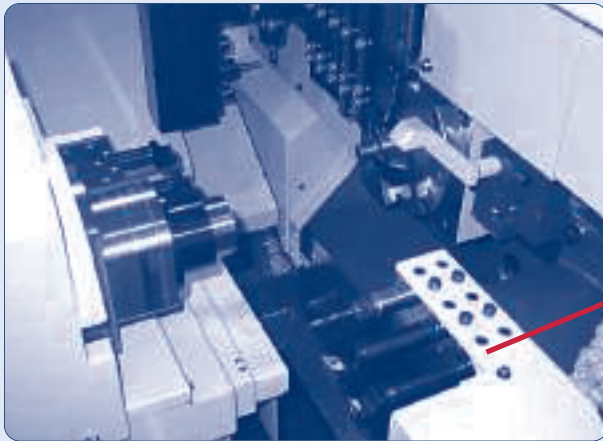
Innovative clamping system for stable clamping of the insert. Easy and quick changing of insert, as the toolholder does not have to be removed.



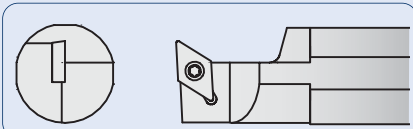
For negative inserts
- JTTAN type: p.15

For positive inserts
- JTDJ2C type: p.12 - JTTAC type: p.12
- JTCL2C type: p.12

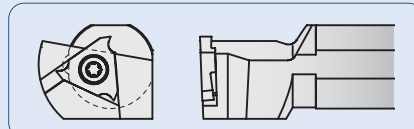
External holder



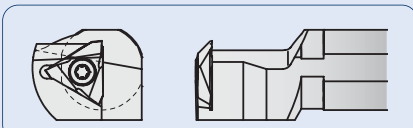
JS-SDUCL External turning: p. 23



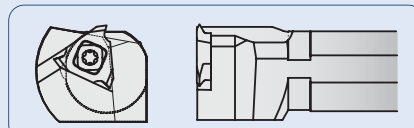
JS-TGL3 Grooving: p. 24



JS-TBL Back turning: p. 23

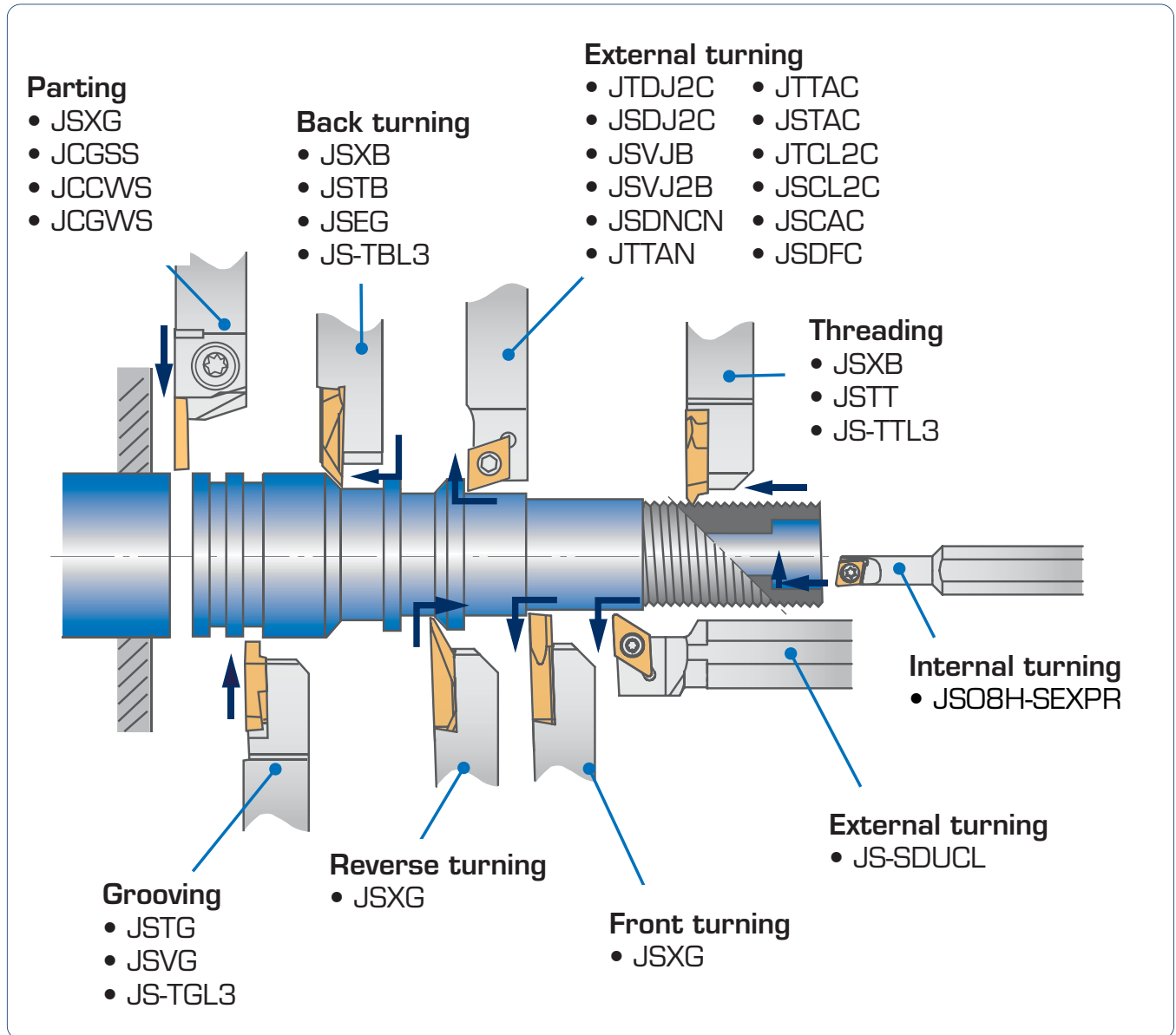


JS-TTL3 Threading: p. 25



J-series

Applications



Grade (for J-series)

Grade	Grade	Features
T9025 	CVD coated carbide	Universal grade for medium to roughing applications of steels in medium cutting speed range (P20 - P30)
NS530 	Cermet	Wear resistant grade for general application with well balanced toughness
J740 	PVD coated fine grain carbide	Excellent sharp cutting edge Outstanding toughness and cutting edge stability for machining of steels and stainless steels
J530 	PVD coated Cermet	New „J-coat“ coating especially for small part machining Sharp cutting edge for superb surface quality Extremely wear-resistant and minimum edge build-up
TH10 	Uncoated carbide	Applicable for a wide range of work materials

Cutting conditions (for J-series)

Work material	Application	Chipbreaker	Grade	Cutting depth ap (mm)	Feed f (mm/rev)	Cutting speed Vc (m/min)
P Steel	Precision finishing	01	J740	0.05 - 0.50	0.03 - 0.15	10 - 100
			J530			100 - 300
	Finishing	J	NS530	0.10 - 5.00	0.01 - 0.30	80 - 300
			J740			10 - 100
M Stainless steel	Precision finishing	01	J530	0.05 - 0.50	0.03 - 0.15	100 - 200
			NS530			10 - 100
	Finishing	J	TH10	0.10 - 5.00	0.01 - 0.10	20 - 100
						100 - 1000
K Cast iron	Finishing	J	TH10	0.10 - 5.00	0.01 - 0.10	10 - 150
N Non-ferrous metals						10 - 60
S Difficult-to-cut materials						
H Hardened steel						

Cutting conditions (for basic grades and chipbreaker)

Work material	Grade					Cutting speed Vc (m/min)
	CVD	PVD	Cermet	Cerm. coated	uncoated	
P Steel	T9005					100 - 400
	T9015					80 - 350
	T9025					80 - 300
	T9035					50 - 200
		GH730				50 - 150
				GT730		80 - 300
			NS530	GT530		
M Stainless steel	T6020					100 - 200
	T6030					50 - 150
		GH730				50 - 120
				GT730		100 - 200
			NS530	GT530		
K Cast iron		GH110			KS05F	30 - 150

Chip-breaker	Cutting depth ap (mm)	Feed f (mm/rev)
PF	0.3 - 1.5	0.05 - 0.25
PS	0.3 - 2.0	0.08 - 0.30
PM	0.5 - 3.0	0.15 - 0.30
C		0.10 - 0.30
TSF	0.3 - 1.5	0.08 - 0.40
TS		0.08 - 0.20
P	1.0 - 4.0	0.20 - 0.50
AL	0.5 - 4.0	0.10 - 0.50



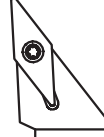


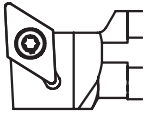
Cutting conditions for grooving (JSXG: p. 16/JSVG: p. 19)

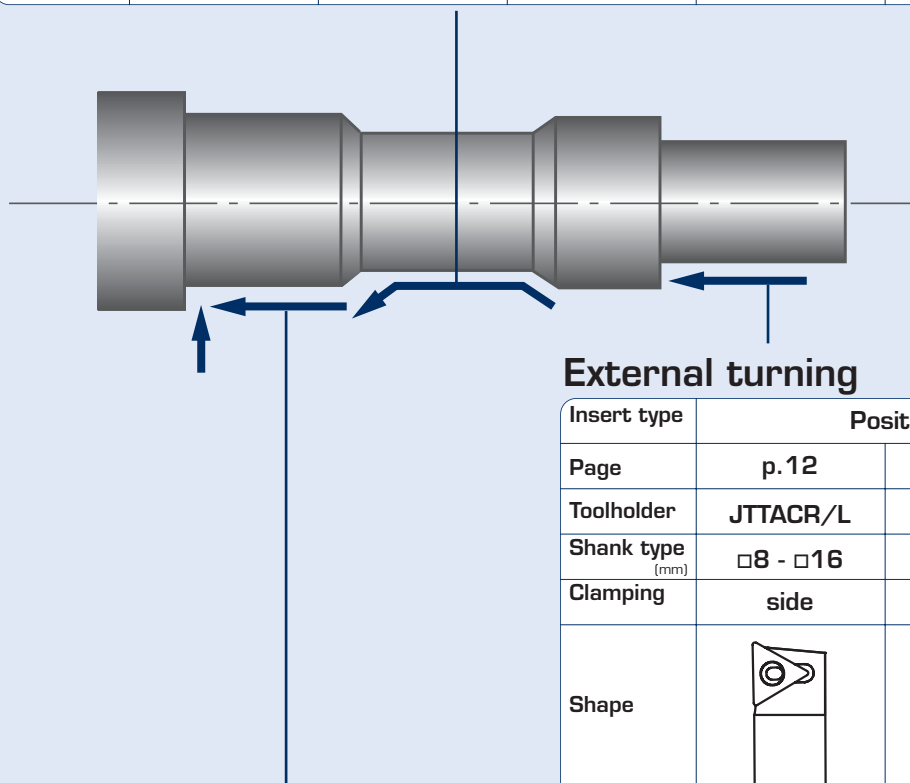
Work material	Grade	Feed f (mm/rev)	Cutting speed Vc (m/min)
P Steel	J740	0.01 - 0.05 - 0.1	10 - 50 - 100
	NS530	0.01 - 0.05 - 0.1	50 - 80 - 150
M Stainless steel	J530		
N Aluminium, Brass etc.	TH10	0.01 - 0.05 - 0.1	10 - 80 - 200
S Difficult-to-cut materials Titanium alloys etc.	TH10	0.01 - 0.05 - 0.1	10 - 20 - 30

J-series



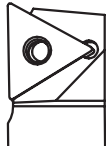
External turning

External turning & Profiling




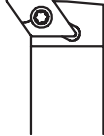
Insert type	Positive					
Page	p.12	p.13	p.14	p.14	p.14	p.23
Toolholder	JTDJ2CR/L	JSDJ2CR/L	JSVJBR/L	JSVJ2BR/L	JSDNCN	JS-SDUCL
Shank type (mm)	□8 - □16	□10 - □12	□10 - □16	□10 - □16	□8 - □16	∅19.05 - ∅25.4
Clamping	side	screw-on	screw-on	screw-on	screw-on	screw-on
Shape						






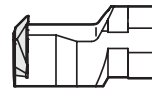
External turning

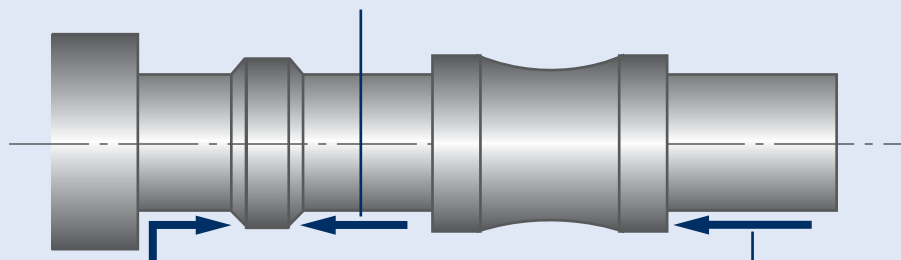
Insert type	Positive		Negative
Page	p.12	p.13	p.15
Toolholder	JTTACR/L	JSTACR/L	JTTANR/L
Shank type (mm)	□8 - □16	□8 - □16	□12 - □16
Clamping	side	screw-on	side
Shape			

External turning & Facing

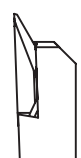
Insert type	Positive			
Page	p.12	p.13	p.15	p.15
Toolholder	JTCL2CR/L	JSCL2CR/L	JSCACR/L	JSDFCR/L
Shank type (mm)	□8 - □16	□10 - □12	□8 - □12	□12 - □16
Clamping	side	screw-on	screw-on	screw-on
Shape				

Back turning

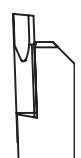
Page	p. 17	p. 18	p. 18	p. 23
Toolholder	JSXBR/L	JSTBR/L	JSEGR/L	JS-TBL3
Shank type (mm)	□10 - □25	□10 - □16	□10 - □16	∅19.05 - ∅25.4
Max. ap (mm)	5.5	2.5	3.0	2.5
Shape				



Reverse turning

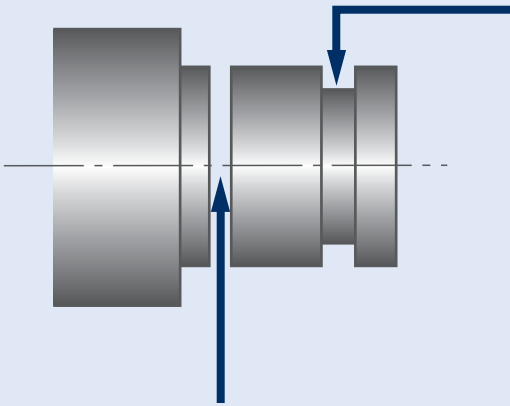
Page	p. 16
Toolholder	JSXGR/L
Shank type (mm)	□10 - □25
Max. ap (mm)	5.5
Shape	

Front turning

Page	p. 16
Toolholder	JSXGR/L
Shank type (mm)	□10 - □25
Max. ap (mm)	5.5
Shape	

J-series

External grooving



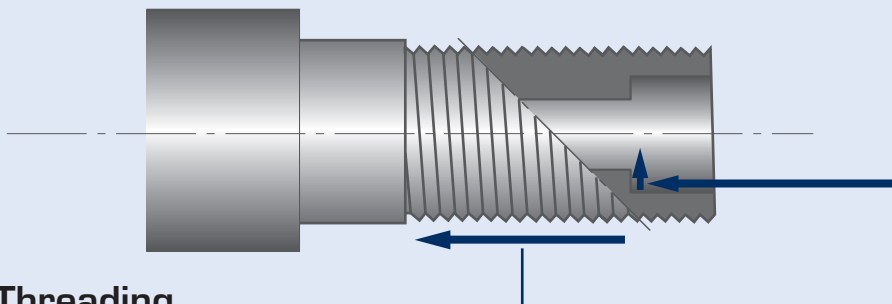
Grooving

Page	p. 19	p. 20	p. 24
Toolholder	JSVGR/L	JSTGR/L	JS-TGL3
Shank type (mm)	□10 - □25	□10 - □16	∅19.05 - ∅25.4
Grooving width (mm)	0.33 - 2.0	0.33 - 3.0	0.33 - 3.0
Max. grooving depth (mm)	0.7 - 5.5	0.7 - 2.6	0.7 - 2.6
Shape			

Parting

Page	p. 16	p. 20	p. 21	p. 21
Toolholder	JSXGR/L	JCGSSR/L	JCCWSR/L	JCGWSR/L
Shank type (mm)	□10 - □25	□10 - □16	□10 - □25	□10 - □16
Grooving width (mm)	0.7 - 2.0	2.0	2.0	2.0
Max. parting-∅ (mm)	∅9 - 12	∅20 - 32	∅20	∅20
Shape				

Threading and internal turning



Internal turning

Page	p. 22
Toolholder	JS08H-SEXPR
Shank type (mm)	∅8.0
Min. bore-∅ (mm)	∅5.5 - 7.0
Shape	

Threading




Page	p. 22	p. 17	p. 24
Toolholder	JSTTR/L	JSXBR/L	JS-TTL3
Shank type (mm)	□10 - □16	□10 - □25	∅19.05 - ∅25.4
Pitch (mm)	0.5 - 1.0	0.5 - 1.0	0.5 - 1.0
Shape			

Inserts for external turning

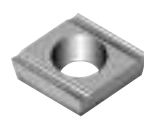
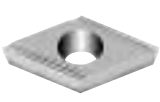
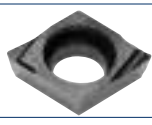


J-series (positive)

-01 chipbreaker for precision finishing

● Standard stock in Europe ○ Standard stock in Japan

Shape	Item code	Dimensions (mm)				Grade		
		Inner circle ø	Thickness	Hole-ø	Corner radius	Coated J740	Coated J530	Cermet NS530
	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* * chipbreaker for finishing (sharp cutting edge)

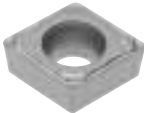

Shape	Item code	Dimensions (mm)				Grade		
		Inner circle ø	Thickness	Hole-ø	Corner radius	Coated J740	Cermet NS530	Carbide TH10
	CCGT060200FR/L-J10	6.350	2.38	2.8	0.03	●	●	○
	CCGT060201FR/L-J10				0.10	●	●	○
	CCGT060202FR/L-J10				0.20	●	●	○
	CCGT09T300FR/L-J10	9.525	3.97	4.4	0.03	●	●	○
	CCGT09T301FR/L-J10				0.10	●	●	○
	CCGT09T302FR/L-J10				0.20	●	●	○
	DCGT070200FR/L-J10	6.350	2.38	2.8	0.03	●	●	○
	DCGT070201FR/L-J10				0.10	●	●	○
	DCGT070202FR/L-J10				0.20	●	●	○
	DCGT11T300-FR/L-J10	9.525	3.97	4.4	0.03	●	●	○
	DCGT11T301-FR/L-J10				0.10	●	●	○
	DCGT11T302-FR/L-J10				0.20	●	●	○
	EPGT04100L-J08	3.97	1.59	2.3	0.03	●		
	EPGT04102L-J08				0.20	●		
	EPGT04104L-J08				0.40	●		
	TCGT080200-FR/L-J08	4.760	2.38	2.2	0.03	●	●	○
	TCGT080201-FR/L-J08				0.10	●	●	○
	TCGT080202-FR/L-J08				0.20	●	●	○
	TCGT110200-FR/L-J10	6.350	2.38	2.8	0.03	●	●	○
	TCGT110201-FR/L-J10				0.10	●	●	○
	TCGT110202-FR/L-J10				0.20	●	●	○
	VBGT110300-FR/L-J10	6.350	3.18	2.8	0.03	●	●	○
	VBGT110301-FR/L-J10				0.10	●	●	○
	VBGT110302-FR/L-J10				0.20	●	●	○
	VBGT110304-FR/L-J10				0.40	●	●	○

J-series





Basic inserts (positive)

-PF chipbreaker for finishing

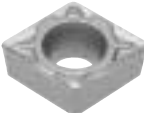
● Standard stock in Europe ○ Standard stock in Japan

Shape	Item code	Dimensions (mm)				Grade						
		Inner circle ϕ	Thickness	Hole- ϕ	Corner radius	Coated					Cermet	
						T9015	T9025	T6020	T6030	GH730	NS530	NS730
	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 chipbreaker for finishing to medium cutting

Shape	Item code	Dimensions (mm)				Grade							
		Inner circle ϕ	Thickness	Hole- ϕ	Corner radius	Coated					Cermet		C.c.
						T9015	T9025	T6020	T6030	GH730	NS530	NS730	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 chipbreaker for medium cutting


Shape	Item code	Dimensions (mm)				Grade						
		Inner circle ϕ	Thickness	Hole- ϕ	Corner radius	Coated					Cermet	
						T9015	T9025	T6020	T6030	GH730	NS530	NS730
	CCMT060204-PM	6.350	2.38	2.8	0.4	●	●	●	●	○	●	○
	CCMT060208-PM				0.8	●	●	●	●	○	●	○
	CCMT09T304-PM	9.525	3.97	4.4	0.4	●	●	●	●	○	●	○
	CCMT09T308-PM				0.8	●	●	●	●	○	●	○
	CCMT09T312-PM				1.2	●	●	●	●		●	○

● Standard stock in Europe ○ Standard stock in Japan


Shape	Item code	Dimensions (mm)				Grade						
		Inner circle ø	Thickness	Hole-ø	Corner radius	Coated					Cermets	
						T9015	T9025	T6020	T6030	GH730	NS530	NS730
	DCMT070204-PM	6.350	2.38	2.8	0.4	●	●	●	●	○	●	○
	DCMT070208-PM				0.8	●	●	●	●	○	●	○
	DCMT11T304-PM	9.525	3.97	4.4	0.4	●	●	●	●	○	●	○
	DCMT11T308-PM				0.8	●	●	●	●	○	●	○
	DCMT11T312-PM				1.2	●	●	●	●		●	○
	TCMT110204-PM	6.350	2.38	2.8	0.4	●	●	●	●		●	○
	TCMT110208-PM				0.8	●	●	●	●		●	○

Basic inserts (negative)


-01 chipbreaker for precision finishing

Shape	Item code	Dimensions (mm)				Grade			
		Inner circle ø	Thickness	Hole-ø	Corner radius	Coated	Cermet	Cermet	Carbide
						GH110	NS530	NS520	TH10
	TNGG160402-01	9.525	4.76	3.81	0.2	○	●	●	○
	TNGG160404-01				0.4	○	●	●	○
	TNGG160408-01				0.8	○	○	○	
	TNGG160412-01				1.2		○	○	


-C chipbreaker for precision finishing

Shape	Item code	Dimensions (mm)				Grade			
		Inner circle ø	Thickness	Hole-ø	Corner radius	Coated	Cermet	Besch. Cermet	Carbide
						GH110	NS530	GT530	TH10
	TNGG160400R-C	9.525	4.76	3.81	0.03		○		
	TNGG160400L-C						○		
	TNGG160402R-C				0.2	●	○	○	
	TNGG160402L-C					●	○		
	TNGG160404R-C				0.4	○	●	○	○
	TNGG160404L-C					○	●	○	○
	TNGG160408R-C				0.8	○	○	○	○
	TNGG160408L-C					○	●	○	○

-TS chipbreaker for finishing

Shape	Item code	Dimensions (mm)				Grade						
		Inner circle ø	Thickness	Hole-ø	Corner radius	Coated					Cermets	
						T9005	T9015	T9025	T9035	T6030	NS530	GT530
	TNMG160404-TS	9.525	4.76	3.81	0.4	●	●	●	○	○	●	●
	TNMG160408-TS				0.8	●	●	●	○	○	●	●
	TNMG160412-TS				1.2	●	●	●	○		●	

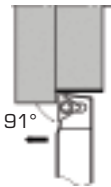
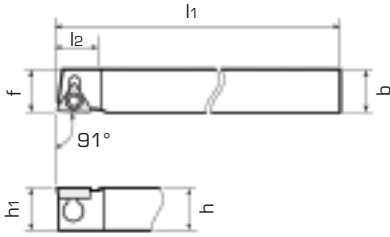
-P chipbreaker for medium cutting

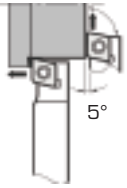
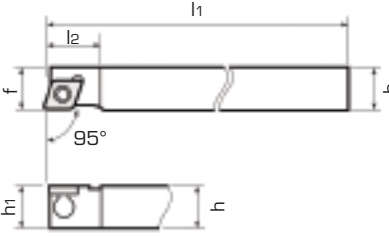
Shape	Item code	Dimensions (mm)				Grade			
		Inner circle ø	Thickness	Hole-ø	Corner radius	Coated	Cermet	Coated Cermet	Carbide
						GH110	NS530	GT530	TH10
	TNGG160402R-P	9.525	4.76	3.81	0.2	●	●		●
	TNGG160402L-P					○	●		●
	TNGG160404R-P				0.4	●	●		●
	TNGG160404L-P					●	●		●
	TNGG160408R-P				0.8	○	●		●
	TNGG160408L-P					○	●		●

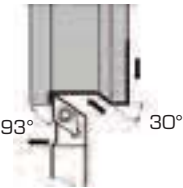
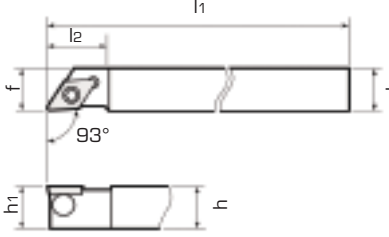
J-series

Toolholder with side-clamping (positive)

● Standard stock in Europe ○ Standard stock in Japan

External turning		Stock		Inserts	Dimensions (mm)				Lever	Screw	Wrench																																	
JTTAC R/L		R	L		h	b	l ₁	l ₂	h ₁	f																																		
				Right hand (R) shown							<table border="1"> <tr> <th>Application</th> <th>Precision finishing</th> <th>Finishing to medium cutting</th> <th>Medium cutting</th> <th>Finishing to medium cutting</th> </tr> <tr> <td>Type</td> <td>O1</td> <td>PS</td> <td>PM</td> <td>SS</td> </tr> <tr> <td>Shape</td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td>Application</td> <td>Finishing</td> <td>Aluminium</td> <td></td> <td></td> </tr> <tr> <td>Type</td> <td>J**</td> <td>AL</td> <td></td> <td></td> </tr> <tr> <td>Shape</td> <td></td> <td></td> <td></td> <td></td> </tr> </table>	Application	Precision finishing	Finishing to medium cutting	Medium cutting	Finishing to medium cutting	Type	O1	PS	PM	SS	Shape					Application	Finishing	Aluminium			Type	J**	AL			Shape							
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Type	O1	PS	PM	SS																																								
Shape																																												
Application	Finishing	Aluminium																																										
Type	J**	AL																																										
Shape																																												
Item code	●	●	TC**0802**	8	10	125	10	8	10	JCP-1	JDS-3525	P-2F																																
JTTACR/L0810K08	●	●		10	10	125	10	10	10																																			
JTTACR/L1212M11	●	●		12	12	150	12	12	12	JCP-2																																		
JTTACR/L1616M11	●	●		16	16	150	12	16	16																																			

External turning & Facing		Stock		Inserts	Dimensions (mm)				Lever	Screw	Wrench																																							
JTCL2C R/L		R	L		h	b	l ₁	l ₂	h ₁	f																																								
				Right hand (R) shown							<table border="1"> <tr> <th>Application</th> <th>Precision finishing</th> <th>Finishing</th> <th>Finishing to medium cutting</th> <th>Medium cutting</th> <th></th> </tr> <tr> <td>Type</td> <td>O1</td> <td>PF</td> <td>PS</td> <td>PM</td> <td></td> </tr> <tr> <td>Shape</td> <td></td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td>Application</td> <td>Precision finishing</td> <td>Finishing</td> <td>Finishing to medium cutting</td> <td>Finishing to medium cutting</td> <td>Aluminium</td> </tr> <tr> <td>Type</td> <td>CBN/PCD</td> <td>J**</td> <td>W**</td> <td>-</td> <td>AL</td> </tr> <tr> <td>Shape</td> <td></td> <td></td> <td></td> <td></td> <td></td> </tr> </table>	Application	Precision finishing	Finishing	Finishing to medium cutting	Medium cutting		Type	O1	PF	PS	PM		Shape						Application	Precision finishing	Finishing	Finishing to medium cutting	Finishing to medium cutting	Aluminium	Type	CBN/PCD	J**	W**	-	AL	Shape								
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Type	CBN/PCD	J**	W**	-	AL																																													
Shape																																																		
Item code	●	●	CC**0602**	8	10	125	12	8	10	JCP-2	JDS-3525	P-2F																																						
JTCL2CR/L0810K06	●	●		10	10	125	12	10	10																																									
JTCL2CR/L1212M09	●	●		12	12	150	16	12	12	JCP-3																																								
JTCL2CR/L1616M09	●	●		16	16	150	16	16	16																																									

External turning & Profiling		Stock		Inserts	Dimensions (mm)				Lever	Screw	Wrench																																							
JTDJ2C R/L		R	L		h	b	l ₁	l ₂	h ₁	f																																								
				Right hand (R) shown							<table border="1"> <tr> <th>Application</th> <th>Precision finishing</th> <th>Finishing</th> <th>Finishing to medium cutting</th> <th>Medium cutting</th> <th></th> </tr> <tr> <td>Type</td> <td>O1</td> <td>PF</td> <td>PS</td> <td>PM</td> <td></td> </tr> <tr> <td>Shape</td> <td></td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td>Application</td> <td>Precision finishing</td> <td>Finishing</td> <td>Finishing to medium cutting</td> <td>Finishing to medium cutting</td> <td>Aluminium</td> </tr> <tr> <td>Type</td> <td>CBN/PCD</td> <td>J**</td> <td>W**</td> <td>-</td> <td>AL</td> </tr> <tr> <td>Shape</td> <td></td> <td></td> <td></td> <td></td> <td></td> </tr> </table>	Application	Precision finishing	Finishing	Finishing to medium cutting	Medium cutting		Type	O1	PF	PS	PM		Shape						Application	Precision finishing	Finishing	Finishing to medium cutting	Finishing to medium cutting	Aluminium	Type	CBN/PCD	J**	W**	-	AL	Shape								
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Type	CBN/PCD	J**	W**	-	AL																																													
Shape																																																		
Item code	●	●	DC**0702**	8	10	125	14	8	10	JCP-2	JDS-3525	P-2F																																						
JTDJ2CR/L0810K07	●	●		10	10	125	14	10	10																																									
JTDJ2CR/L1212M11	●	●		12	12	150	18	12	12	JCP-3																																								
JTDJ2CR/L1616M11	●	●		16	16	150	18	16	16																																									

Toolholder with screw-on clamping (positive)

● Standard stock in Europe ○ Standard stock in Japan

External turning		JSTAC R/L							<table border="1"> <tr> <td>Application</td> <td>Precision finishing</td> <td>Finishing to medium cutting</td> <td>Medium cutting</td> <td>Finishing to medium cutting</td> </tr> <tr> <td>Type</td> <td>O1</td> <td>PS</td> <td>PM</td> <td>SS</td> </tr> <tr> <td>Shape</td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td>Application</td> <td>Finishing</td> <td>Aluminium</td> <td></td> <td></td> </tr> <tr> <td>Type</td> <td>J**</td> <td>AL</td> <td></td> <td></td> </tr> <tr> <td>Shape</td> <td></td> <td></td> <td></td> <td></td> </tr> </table>					Application	Precision finishing	Finishing to medium cutting	Medium cutting	Finishing to medium cutting	Type	O1	PS	PM	SS	Shape					Application	Finishing	Aluminium			Type	J**	AL			Shape				
Application	Precision finishing	Finishing to medium cutting	Medium cutting	Finishing to medium cutting																																							
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Item code	Stock		Inserts	Dimensions (mm)					Clamping screw	Wrench																																	
	R	L		h	b	l1	l2	h1		f																																	
JSTACR/L0808K08	●	●	TC**0802**	8	8	125	10	8	8	CSTB-2L	T-6F	(T-6L)																															
JSTACR/L1010K08	●	●		10	10	125	10	10	10																																		
JSTACR/L1212K11	●	●	TC**1102**	12	12	125	12	12	12	CSTB-2.5	T-8F	(T-8L)																															
JSTACR/L1616H11	●	●		16	16	100	12	16	16																																		

External turning & Facing		JSCL2C R/L							<table border="1"> <tr> <td>Application</td> <td>Precision finishing</td> <td>Finishing</td> <td>Finishing to medium cutting</td> <td>Medium cutting</td> <td></td> </tr> <tr> <td>Type</td> <td>O1</td> <td>PF</td> <td>PS</td> <td>PM</td> <td></td> </tr> <tr> <td>Shape</td> <td></td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td>Application</td> <td>Precision finishing</td> <td>Finishing</td> <td>Finishing to medium cutting</td> <td>Finishing to medium cutting</td> <td>Aluminium</td> </tr> <tr> <td>Type</td> <td>CBN/PCD</td> <td>J**</td> <td>W**</td> <td>-</td> <td>AL</td> </tr> <tr> <td>Shape</td> <td></td> <td></td> <td></td> <td></td> <td></td> </tr> </table>					Application	Precision finishing	Finishing	Finishing to medium cutting	Medium cutting		Type	O1	PF	PS	PM		Shape						Application	Precision finishing	Finishing	Finishing to medium cutting	Finishing to medium cutting	Aluminium	Type	CBN/PCD	J**	W**	-	AL	Shape					
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Item code	Stock		Inserts	Dimensions (mm)					Clamping screw	Wrench																																							
	R	L		h	b	l1	l2	h1		f																																							
JSCL2CR/L1010K06	●	●	CC**0602**	10	10	125	12	10	10	CSTB-2.5	T-8F	(T-8L)																																					
JSCL2CR/L1212K06	●	●		12	12	125	12	12	12																																								

External turning & Profiling		JSDJ2C R/L							<table border="1"> <tr> <td>Application</td> <td>Precision finishing</td> <td>Finishing</td> <td>Finishing to medium cutting</td> <td>Medium cutting</td> <td></td> </tr> <tr> <td>Type</td> <td>O1</td> <td>PF</td> <td>PS</td> <td>PM</td> <td></td> </tr> <tr> <td>Shape</td> <td></td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td>Application</td> <td>Precision finishing</td> <td>Finishing</td> <td>Finishing to medium cutting</td> <td>Finishing to medium cutting</td> <td>Aluminium</td> </tr> <tr> <td>Type</td> <td>CBN/PCD</td> <td>J**</td> <td>W**</td> <td>-</td> <td>AL</td> </tr> <tr> <td>Shape</td> <td></td> <td></td> <td></td> <td></td> <td></td> </tr> </table>					Application	Precision finishing	Finishing	Finishing to medium cutting	Medium cutting		Type	O1	PF	PS	PM		Shape						Application	Precision finishing	Finishing	Finishing to medium cutting	Finishing to medium cutting	Aluminium	Type	CBN/PCD	J**	W**	-	AL	Shape					
Application	Precision finishing	Finishing	Finishing to medium cutting	Medium cutting																																													
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Application	Precision finishing	Finishing	Finishing to medium cutting	Finishing to medium cutting	Aluminium																																												
Type	CBN/PCD	J**	W**	-	AL																																												
Shape																																																	
Item code	Stock		Inserts	Dimensions (mm)					Clamping screw	Wrench																																							
	R	L		h	b	l1	l2	h1		f																																							
JSDJ2CR/L1010K07	●	●	DC**0702**	10	10	125	14	10	10	CSTB-2.5	T-8F	(T-8L)																																					
JSDJ2CR/L1212K07	●	●		12	12	125	14	12	12																																								

J-series

● Standard stock in Europe ○ Standard stock in Japan

External turning & Profiling		Stock		Inserts	Dimensions (mm)				Clamping screw	Wrench			
JSVJB R/L		R	L		h	b	l ₁	l ₂		h ₁	f	(Optional)	
					h	b	l ₁	l ₂		h ₁	f		
					10	10	100	20		10	12		
		12	12	100	20	12	16	CSTB-2.5	T-8F	(T-8L)			
		16	16	100	20	16	20						

External turning & Profiling		Stock		Inserts	Dimensions (mm)				Clamping screw	Wrench			
JSVJ2B R/L		R	L		h	b	l ₁	l ₂		h ₁	f	(Optional)	
					h	b	l ₁	l ₂		h ₁	f		
					10	10	100	20		10	10		
		12	12	100	22	12	12	CSTB-2.5	T-8F	(T-8L)			
		16	16	100	22	16	16						

External turning & Profiling		Stock		Inserts	Dimensions (mm)				Clamping screw	Wrench			
JSDNCN		R	L		h	b	l ₁	l ₂		h ₁	f	(Optional)	
					h	b	l ₁	l ₂		h ₁	f		
					10	10	125	14		10	5		
		12	12	125	14	12	6	CSTB-2.5	T-8F	(T-8L)			
		16	16	100	21	16	8				CSTB-4SD		

● Standard stock in Europe ○ Standard stock in Japan

External turning & Facing		Stock		Inserts	Dimensions (mm)				Clamping screw	Wrench			
JSCAC R/L		R	L		h	b	l ₁	l ₂		h ₁	f		(Optional)
				CC**0602**	8	8	100	12	8	8	CSTB-2.5	T-8F	(T-8L)
					10	10	100	12	10	10			
					12	12	100	16	12	12			
Item code		●	●	CC**09T3**									

External turning & Facing		Stock		Inserts	Dimensions (mm)				Clamping screw	Wrench			
JSDFC R/L		R	L		h	b	l ₁	l ₂		h ₁	f		(Optional)
				DC**0702**	12	12	100	8	12	16	CSTB-2.5	T-8F	(T-8L)
					16	16	100	10.5	16	22			
Item code		●	●	DC**11T3**									

Toolholder with side-clamping (negative)

External turning		Stock		Inserts	Dimensions (mm)				Lever	Screw	Wrench		
JTTAN R/L		R	L		h	b	l ₁	l ₂				h ₁	f
				TN**1604**	12	16	125	19.8	12	16	JCP-3N	JDS-5040	P-2.5F
					16	16	125	19.8	16	16			
Item code		●	●										

J-series

● Standard stock in Europe ○ Standard stock in Japan

Front and Reverse turning		JSXG R/L		C-type		Right hand (R) shown		Clamping screw		Wrench		
Item code	Stock		Inserts	Dimensions (mm)						Clamping screw	Wrench	
	R	L		h	b	l ₁	l ₂	h ₁	f			(Optional)
JSXGR/L1010K8-C	●	●	JXFR/L8*** JXRR/L8*** JXGR/L8*** for Parting	10	10	125	29	10	9.9	CSTB-4SD	T-8F	(T-8L)
JSXGR/L1212K8-C	●	●		12	12	125	29	12	11.9			
JSXGR/L1616K8	●	●		16	16	125	29	16	15.9			
JSXGR/L2020K8	○	○		20	20	125	29	20	19.9			
JSXGR/L2525K8	○	○		25	25	125	29	25	24.9			

Note: C-type toolholders are marked

R: Reverse turning

F: Front turning

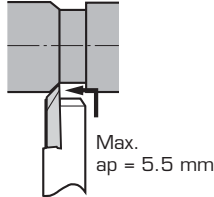



C: Parting (deep-grooving)

JXF-type inserts for front turning (sharp cutting edge)		Dimensions (mm)		Grade						
Item code	Ød	T	R	Max. cutting depth ap	Coated J740		Cermet NS530		Carbide TH10	
					R	L	R	L	R	L
JXFR/L8000F	8	3.97	0.03	5.5	●		○		○	
JXFR/L8010F	8	3.97	0.10	5.5	●		○		○	

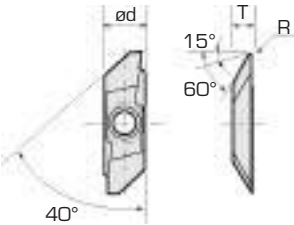
JXR-type inserts for reverse turning (sharp cutting edge)		Dimensions (mm)		Grade						
Item code	Ød	T	R	Max. cutting depth ap	Coated J740		Cermet NS530		Carbide TH10	
					R	L	R	L	R	L
JXRR/L8000F	8	3.97	0.03	5.5	●		○		○	
JXRR/L8010F	8	3.97	0.10	5.5	●		○		○	

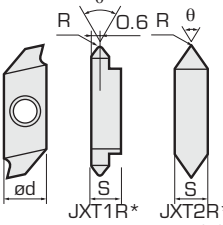
JXG-type inserts for parting (sharp cutting edge)		Dimensions (mm)		Grade								
Item code	Ød	T	W ^{+0.025}	θ	Max. grooving depth ap	R	Coated J740		Cermet NS530		Carbide TH10	
							R	L	R	L	R	L
JXGR/L8070FA	8	3.97	0.7	15°	4.5	0	●	●	●	●	○	○
JXGR/L8100FA							●	●	●	●	○	○
JXGR/L8100FA45							●				○	
JXGR/L8120FA												
JXGR/L8150FA							●	●	●	●	○	○
JXGR/L8150FA50							●				○	
JXGR/L8180FA							●				○	
JXGR/L8200FA							●	●	●	●	○	○

● Standard stock in Europe ○ Standard stock in Japan

Back turning JSXB R/L		Stock		Inserts	Dimensions (mm)					Clamping screw	Wrench		
 Max. ap = 5.5 mm		R	L		h	b	l ₁	l ₂	h ₁	f			
				JXBR/L8*** JXT*R/L for threading	10	10	125	29	10	5.7	CSTB-4SD	T-8F	(T-8L)
					12	12	125	29	12	7.7			
					16	16	125	29	16	11.7			
					20	20	125	29	20	15.7			
					25	25	125	29	25	20.7			

Note: C-type toolholders are marked B: Back turning
T: Threading


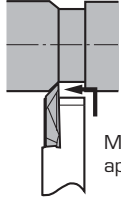
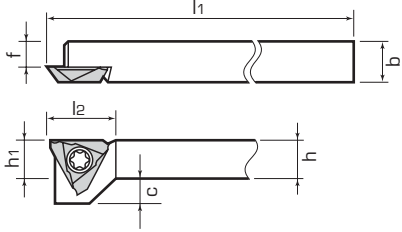


 Right hand (R) shown		JXB-type inserts for back turning									
		Item code	Honing	Dimensions (mm)				Grade			
				ød	T	R	Max. cutting depth ap	Coated J740		Cermet NS530	
JXBR/L8000F	without	8	3.97	0.03	5.5	●	●	○		○	○
JXBR/L8005F						●	●			○	○
JXBR/L8010F						●	●	○		○	○
JXBR/L8015F						●	●			○	○
JXBR/L8005	with	8	3.97	0.05	5.5	○	○				
JXBR/L8010				0.10		○	○				
JXBR/L8015				0.15		○	○				

 Right hand (R) shown		JXT-type inserts for threading (sharp cutting edge)								
		Item code	Dimensions (mm)				Grade			
			ød	S	R	θ	Coated J740		Cermet NS530	
JXT1R/L6000F	8	3.97	0.03	60°	●		○		●	
JXT2R/L6000F	8	3.97	0.03	60°	●		○		●	


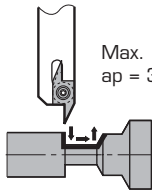
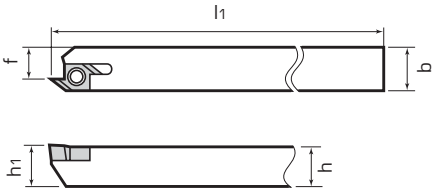


Notes: for pitches of 0.5 to 1.0 mm
right toolholder with right insert,
left toolholder with left insert

J-series

● Standard stock in Europe ○ Standard stock in Japan

Back turning														
JSTB R/L														
 <p>Max. ap = 2.5 mm</p>		 <p>Right hand (R) shown</p>												
Item code	Stock		Inserts	Dimensions (mm)						Clamping screw	Wrench			
	R	L		h	b	l ₁	l ₂	h ₁	f		c		 (Optional)	
JSTBR/L1010K3	●	●	JTBR/L3***	10	10	125	15	10	6	5	CSTB-4SD	T-8F	(T-8L)	
JSTBR/L1212K3	●	●		12	12	125	15	12	8	3				
JSTBR/L1616K3	●	●		16	16	125	15	16	12	-				

JTBR-type inserts for back turning											
Item code	Honing	Dimensions (mm)				Grade					
		ød	T	R	Max. cutting depth ap	Coated J740		Cermet NS530		Carbide TH10	
						R	L	R	L	R	L
JTBR/L3000F	without	9.438	3.18	0.03	2.5	●	●	●	●	○	○
JTBR/L3005F						●	●	●	●	○	○
JTBR/L3010F						●	●	●	●	○	○
JTBR/L3015F						○					
JTBR/L3005	with	9.438	3.18	0.05	2.5	○	○				
JTBR/L3010				0.10		○	○				
JTBR/L3015				0.15							

Back turning														
JSEGR R/L														
 <p>Max. ap = 3 mm</p>		 <p>Right hand (R) shown</p>												
Item code	Stock		Inserts	Dimensions (mm)						Clamping screw	Wrench			
	R	L		h	b	l ₁	l ₂	h ₁	f			 (Optional)		
JSEGR/L1010K10	●	●	J10ER/L***B*	10	10	125	-	10	7.5	CSTB-2.5	T-8F	(T-8L)		
JSEGR/L1212K10	●	●		12	12	125	-	12	9.5					
JSEGR/L1616K10	●	●		16	16	125	-	16	13.5					

J10E-type inserts for back turning											
Item code	Honing	Dimensions (mm)				Grade					
		ød	T	R	Max. cutting depth ap	Coated J740		Cermet NS530		Carbide TH10	
						R	L	R	L	R	L
J10ER/L005BF	without	6.35	3.18	0.05	3	●	●	●	●	○	○
J10ER/L010BF						●	●	●	●	○	○
J10ER/L015BF											
J10ER/L005B	with	6.35	3.18	0.05	3	○	○				
J10ER/L010B				0.10		○	○				
J10ER/L015B				0.15							

Parting: JSXG; see p. 16

● Standard stock in Europe ○ Standard stock in Japan

Grooving										Clamping screw		Wrench	
Item code	Stock		Inserts	Dimensions (mm)									
	R	L		h	b	l1	l2	h1	f		R	L	
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				

Note: C-type toolholders are marked G: Grooving

	JVGR-type inserts for grooving (sharp cutting edge)												
	Item code	Dimensions (mm)						Grade					
		ød	T	W ^{+0.025}	G	Max. grooving depth ap	R	Coated		Cermet		Carbide	
								J740		NS530		TH10	
R	L	R	L	R	L								
JVGR/L033F	7.94	3.18	0.33	0.8	0.7	0	●		●		●		
JVGR/L050F							●		●		●		
JVGR/L075F							●		●		●		
JVGR/L095F							●		●		●		
JVGR/L100F							●		●	●	●	●	
JVGR/L125F							●		●		●		
JVGR/L150F							●		●	●	●	●	
JVGR/L200F							●		●		●		

Right hand (R) shown

Cutting conditions for grooving; see p. 5

J-series

● Standard stock in Europe ○ Standard stock in Japan

Grooving		JSTG R/L											
Item code	Stock	Inserts		Dimensions (mm)						Clamping screw	Wrench		
	R L			h	b	l1	l2	h1	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	-			

<p>Right hand (R) shown</p>	JTG-type inserts for grooving (sharp cutting edge)												
	Item code	Dimensions (mm)						Grade					
		ød	T	W ^{+0.025}	G	Max. grooving depth ap	R	Coated		Cermet		Carbide	
								J740	NS530	TH10	TH10	TH10	TH10
R	L	R	L	R	L	R	L						
JTGR/L3033F	9.525	3.18	0.33	0.8	0.7	0.03	●	●	●	●	○	○	
JTGR/L3050F			0.50	1.2	1.1		●	●	●	●	○	○	
JTGR/L3075F			0.75	2.0	1.9		●	●	●	●	○	○	
JTGR/L3095F			0.95	2.0	1.9		●	●	●	●	○	○	
JTGR/L3100F			1.00	2.2	2.1	0.05	●	●	●	●	○	○	
JTGR/L3125F			1.25				●	●	●	●	○	○	
JTGR/L3145F			1.45				●	●	●	●	○	○	
JTGR/L3150F			1.50				●	●	●	●	○	○	
JTGR/L3175F			1.75				●	●	●	●	○	○	
JTGR/L3200F			2.00				●	●	●	●	○	○	
JTGR/L3250F	2.50	2.7	2.6	●	●	●	●	○	○				

Parting & Grooving		JCGSS R/L											
Grooving width W (mm)	Item code	Stock	Inserts		Dimensions (mm)						Clamping screw	Wrench	
		R L			h	b	l1	l2	h1	f	Max. Parting øD		
2	JCGSSR/L1010-20	● ●	GE20		10	10	125	15	10	10.2	ø20	CSTB-3	T-9F
	JCGSSR/L1212-20	● ●			12	12	125	19	12	12.2	ø25		
	JCGSSR/L1616-20	● ●			16	16	125	22.5	16	16.2	ø32		

<p>GE20 GE20-AL</p>	GE-type inserts for parting and grooving										
	Item code	Dimensions (mm)				Grade					
		W	L	h	R	Coated		Cermet		Carbide	
						T9025	GH730	NS530	KS05F		
GE20	2	10	3.5	0.2	●	●	●				
GE20-AL	2	10	3.5	0.2						○	

● Standard stock in Europe ○ Standard stock in Japan

Parting												Clamping screw		Wrench	
JCCWS R/L															
		Right hand (R) shown													
Item code	Stock		Inserts	Dimensions (mm)						Max. parting-ø	Clamping screw	Wrench			
	R	L		h	b	l1	l2	h1	f						
JCCWSR/L1010K2	●	●	JCC*200F	10	10	125	19	10	10	ø20	CSTB-4S	T-15F	(T-15L)		
JCCWSR/L1212K2	●	●		12	12	125	19	12	12						
JCCWSR/L1616K2	●	●		16	16	125	19	16	16						
JCCWSR/L2020K2	○	○		20	20	125	19	20	20						
JCCWSR/L2525K2	○	○		25	25	125	19	25	25						

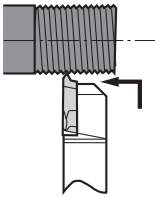
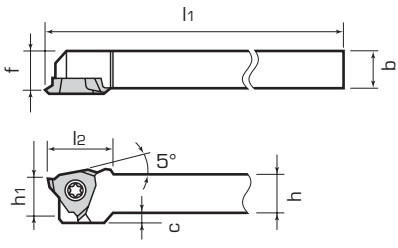



Parting		JCC-type inserts for parting (sharp cutting edge)											
JCCWS R/L													
		Right hand (R) shown											
Item code	Stock		Inserts	Dimensions (mm)						Max. parting-ø	Clamping screw	Wrench	
	R	L		h	b	l1	l2	h1	f				
JCCWSR/L1010K2	●	●	JCC*200F	10	10	125	19	10	10	ø20	CSTB-4S	T-15F	(T-15L)
JCCWSR/L1212K2	●	●		12	12	125	19	12	12				
JCCWSR/L1616K2	●	●		16	16	125	19	16	16				
JCCWSR/L2020K2	○	○		20	20	125	19	20	20				
JCCWSR/L2525K2	○	○		25	25	125	19	25	25				

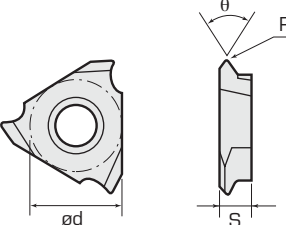
Parting		JCC-type inserts for parting (sharp cutting edge)											
JCGWS R/L													
		Right hand (R) shown											
Item code	Stock		Inserts	Dimensions (mm)						Max. parting-ø	Clamping screw	Wrench	
	R	L		h	b	l1	l2	h1	f				
JCGWSR/L1010K2			JCGN200*	10	10	125	20	10	10	ø20	CSTB-4S	T-15F	(T-15L)
JCGWSR/L1212K2				12	12	125	20	12	12				
JCGWSR/L1616K2				16	16	125	20	16	16				

Parting		JCG-type inserts for parting (sharp cutting edge)											
JCGWS R/L													
		Right hand (R) shown											
Item code	Stock		Inserts	Dimensions (mm)						Max. parting-ø	Clamping screw	Wrench	
	R	L		h	b	l1	l2	h1	f				
JCGWSR/L1010K2			JCGN200*	10	10	125	20	10	10	ø20	CSTB-4S	T-15F	(T-15L)
JCGWSR/L1212K2				12	12	125	20	12	12				
JCGWSR/L1616K2				16	16	125	20	16	16				

J-series

● Standard stock in Europe ○ Standard stock in Japan

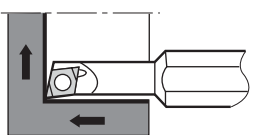
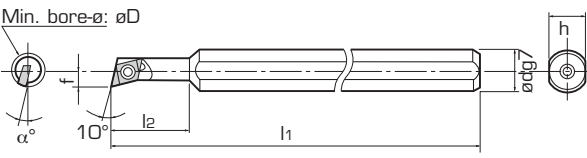
Threading													
JSTT R/L													
													
		Right hand (R) shown											
Item code	Stock		Inserts	Dimensions (mm)						Clamping screw	Wrench		
	R	L		h	b	l1	l2	h1	f		c		 (Optional)
JSTTR/L1010K3	●		JTTR/L3****	10	10	125	16.5	10	9.5	2	CSTB-4SD	T-8F	(T-8L)
JSTTR/L1212K3	●			12	12	125	16.5	12	11.5	-			
JSTTR/L1616K3	●			16	16	125	16.5	16	15.5	-			

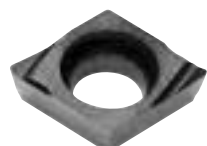
JTT-type inserts for threading (sharp cutting edge)		Dimensions (mm)				Grade					
Item code		ød	S	R	θ	Coated		Cermet		Carbide	
						J740	NS530	TH10			
						R	L	R	L	R	L
JTTR/L3005F		9.525	3.18	0.05	60°	●		●		●	
JTTR/L3010F				0.10		●		●			
JTTR/L3005F-55				0.05	55°	○					

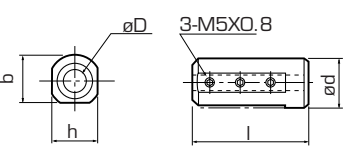
Note: for pitches of 0.5 to 1.0 mm

Threading: JSXB; see p. 17

Boring toolholder with screw-on clamping (positive)

Internal turning & Facing												
JS08H-SEXP R												
										Right hand (R) shown		
Item code	Stock	Inserts	Min. bore-øD	Std. nose rc	Dimensions (mm)						Clamping screw	Wrench
					ød	f	l1	l2	h	α°		
JS08H-SEXP045	●	EP**0401**	5.5	0.4	8	2.75	100	16	7	12	CSTB-2	T-6F
JS08H-SEXP047	●		7.0	0.4	8	3.6	100	20	7	12		

Inserts for internal turning and facing		Dimensions (mm)				Grade	
Item code		Inner circle ø	Thickness	Hole-ø	Corner radius	Coated	
						J740	
EPGT040100L-J08		3.97	1.59	2.3	0.03	●	
EPGT040102L-J08					0.2	●	
EPGT040104L-J08					0.4	●	

Sleeves		Dimensions (mm)					Stock
Item code		Shank-øD	ød	l	b	h	
							BLM19-08
BLM20-08		20	100	19	18	●	
BLM22-08		22	125	21	21	●	
BLM254-08		25.4	125	24	24	●	

● Standard stock in Europe ○ Standard stock in Japan

External turning & Profiling																																																													
JS-SDUCL										<table border="1"> <tr> <td>Applica-tion</td> <td>Precision finishing</td> <td>Finishing</td> <td>Finishing to medium cutting</td> <td>Medium cutting</td> <td></td> </tr> <tr> <td>Type</td> <td>O1</td> <td>PF</td> <td>PS</td> <td>PM</td> <td></td> </tr> <tr> <td>Shape</td> <td></td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td></td> <td>(07, 11)</td> <td>(07, 11)</td> <td>(07, 11)</td> <td>(07, 11)</td> <td></td> </tr> <tr> <td>Applica-tion</td> <td>Precision finishing</td> <td>Finishing</td> <td>Finishing to medium cutting</td> <td>Finishing to medium cutting</td> <td>Aluminium</td> </tr> <tr> <td>Type</td> <td>CBN/PCD</td> <td>J**</td> <td>W**</td> <td>-</td> <td>AL</td> </tr> <tr> <td>Shape</td> <td></td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td></td> <td>(07, 11)</td> <td>(07, 11)</td> <td>(07, 11)</td> <td>(07, 11)</td> <td>(07, 11)</td> </tr> </table>		Applica-tion	Precision finishing	Finishing	Finishing to medium cutting	Medium cutting		Type	O1	PF	PS	PM		Shape							(07, 11)	(07, 11)	(07, 11)	(07, 11)		Applica-tion	Precision finishing	Finishing	Finishing to medium cutting	Finishing to medium cutting	Aluminium	Type	CBN/PCD	J**	W**	-	AL	Shape							(07, 11)	(07, 11)	(07, 11)	(07, 11)	(07, 11)	<p>Left hand (L) shown</p>	
Applica-tion	Precision finishing	Finishing	Finishing to medium cutting	Medium cutting																																																									
Type	O1	PF	PS	PM																																																									
Shape																																																													
	(07, 11)	(07, 11)	(07, 11)	(07, 11)																																																									
Applica-tion	Precision finishing	Finishing	Finishing to medium cutting	Finishing to medium cutting	Aluminium																																																								
Type	CBN/PCD	J**	W**	-	AL																																																								
Shape																																																													
	(07, 11)	(07, 11)	(07, 11)	(07, 11)	(07, 11)																																																								
Item code	Stock		Inserts	Min. bore- øD	Dimensions (mm)					Clamping screw	Wrench																																																		
	R	L			f	l1	l2	h	b			g																																																	
JS19K-SDUCL07		●	DC**0702**	19.05	6	125	20	18	11.5	-	CSTB-2.5	T-8F																																																	
JS20K-SDUCL07		●		20.00	6	125	20	19	11.5	-																																																			
JS22K-SDUCL07		●		22.00	6	125	20	21	11.5	-																																																			
JS19K-SDUCL11		●	DC**11T3**	19.05	10	125	20	18	11.5	1.525	CSTB-4SD																																																		
JS20K-SDUCL11		●		20.00	10	125	20	19	11.5	1.000																																																			
JS22K-SDUCL11		●		22.00	11	125	20	21	11.5	1.000																																																			
JS25K-SDUCL11		●		25.40	12	125	20	24	12.7	0.700																																																			

Back turning											
JS-TBL3											
Item code	Stock		Inserts	Dimensions (mm)					Clamping screw	Wrench	
	R	L		ød	f	l1	l2	h			b
JS19K-TBL3		●	JTBR30**	19.05	6	125	17	18	11.5	CSTB-4S	T-15F
JS20K-TBL3		●		20.00	6	125	17	19	11.5		
JS22K-TBL3		●		22.00	6	125	17	21	11.5		
JS25K-TBL3		●		25.40	10	125	17	24	12.7		

JTB-type inserts for back turning												
Item code	Honing	Dimensions (mm)				Grade						
		ød	T	R	Max. cutting depth ap	Coated		Cermet		Carbide		
						J740	NS530	TH10	TH10			
R	L	R	L	R	L							
JTBR/L3000F	without	9.438	3.18	0.03	2.5	●	●	●	●	○	○	
JTBR/L3005F				0.05		●	●	●	●	○	○	
JTBR/L3010F				0.10		●	●	●	●	○	○	
JTBR/L3015F	with			0.15		○						
JTBR/L3005				0.05		○	○					
JTBR/L3010				0.10		○	○					
JTBR/L3015				0.15								

Right hand (R) shown

Note: right toolholder with left insert, left toolholder with right insert

● Standard stock in Europe ○ Standard stock in Japan

Grooving		JS-TGL3									
				Left hand (L) shown							
Item code	Stock		Inserts	Dimensions (mm)						Clamping screw	Wrench
	R	L		ød	f	l1	l2	h	b		
JS19K-TGL3	●		JTGR3***	19.05	6	125	20	18	11.5	CSTB-4S	T-15F
JS20K-TGL3	●			20.00	6	125	20	19	11.5		
JS22K-TGL3	●			22.00	6	125	20	21	11.5		
JS25K-TGL3	●			25.40	10	125	20	24	12.7		

JTG-type inserts for grooving (sharp cutting edge)		Dimensions (mm)						Grade					
Item code	ød	T	W ^{±0.025}	G	Max. grooving depth ap	R	Coated		Cermet		Carbide		
							J740		NS530		TH10		
							R	L	R	L	R	L	
JTGR/L3033F	9.525	3.18		0.33	0.8	0.7	0.03	●	●	●	●	○	○
JTGR/L3050F								●	●	●	●	○	○
JTGR/L3075F								●	●	●	●	○	○
JTGR/L3095F								●	●	●	●	○	○
JTGR/L3100F								●	●	●	●	○	○
JTGR/L3125F								●	●	●	●	○	○
JTGR/L3145F								●	●	●	●	○	○
JTGR/L3150F								●	●	●	●	○	○
JTGR/L3175F								●	●	●	●	○	○
JTGR/L3200F								●	●	●	●	○	○
JTGR/L3250F	●	●	●	●	○	○							

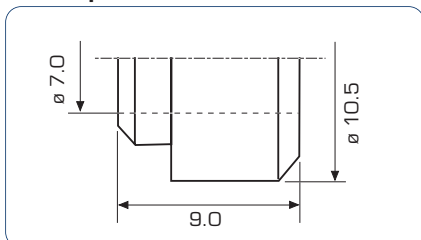
Threading		JS-TTL3									
				Left hand (L) shown							
Item code	Stock		Inserts	Dimensions (mm)						Clamping screw	Wrench
	R	L		ød	f	l1	l2	h	b		
JS19K-TTL3	●		JTTR30**	19.05	10	125	-	18	11.5	CSTB-4S	T-15F
JS20K-TTL3	●			20.00	10	125	-	19	11.5		
JS22K-TTL3	●			22.00	10	125	-	21	11.5		
JS25K-TTL3	●			25.40	10	125	-	24	12.7		

JTT-type inserts for threading (sharp cutting edge)		Dimensions (mm)				Grade				
Item code	ød	S	R	θ	Coated		Cermet		Carbide	
					J740		NS530		TH10	
					R	L	R	L	R	L
JTTR/L3005F	9.525	3.18	0.05	60°	●		●		●	
JTTR/L3010F					●		●		●	
JTTR/L3005F-55					○					

Notes: for pitches of 0.5 to 1.0 mm
left toolholder with right insert

Practical examples

Parting and chamfering of brake parts (ABS)

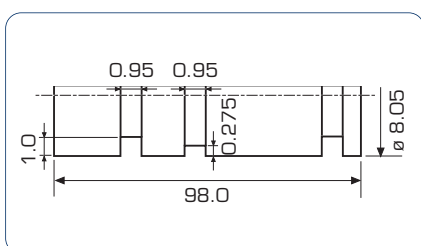


Work material: Carbon steel (Ck45)
 Insert: JCGN200FR J740
 Toolholder: JCGWSR1616K2
 Cutting speed: $V_c = 50$ m/min
 No. of rev.: $n = 1500$ rpm
 Feed: $f = 0.05$ mm/rev
 Cutting fluid: Cutting oil
 Machine: Small CNC lathe

Results:

The tool life of J740 inserts was 1.5 times the competitor's (3000 pcs. per corner vs 2000 pcs.). Sharp cutting edge of J-series eliminated burr removal operation completely. Parting tool of J-series has 2 cutting edges so customer could save costs.

External grooving of motor shaft

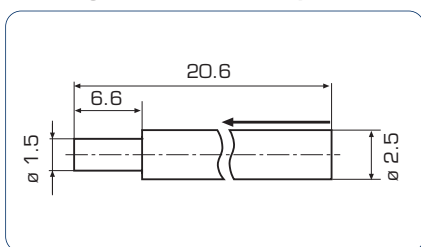


Work material: Construction steel
 Insert: JTGR3095F J740
 Toolholder: JSTGR1010K3
 Cutting speed: $V_c = 88$ m/min
 No. of rev.: $N = 3500$ rpm
 Feed: $f = 0.02$ mm/rev
 Cutting fluid: Cutting oil
 Machine: Small CNC lathe

Results:

The tool life of J740 inserts was 3500 pcs. per edge compared to 2400 pcs. of competitive insert.

Turning of automobile parts

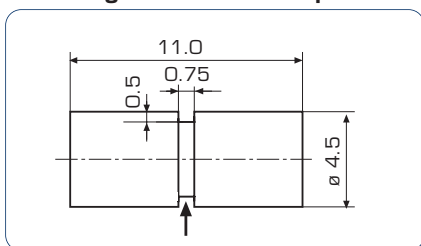


Work material: Stainless steel (X8CrNiS18-9)
 Insert: CCGT060202FR-J10 NS530
 Cutting speed: $V_c = 43$ m/min
 No. of rev.: $N = 5500$ rpm
 Depth of cut: $d = 1.5$ mm
 Feed: $f = 0.007 - 0.01$ mm/rev
 Cutting fluid: Water insoluble cutting fluid
 Machine: NC automatic lathe

Results:

Life of the NS530 inserts was about 4000 pcs. per edge, compared to 3000 pcs. for competitive cermet inserts. The surface finish was also improved.

Grooving of automobile parts



Work material: Stainless steel (X10Cr13)
 Insert: JTGR3075F TH10
 Cutting speed: $V_c = 100$ m/min
 No. of rev.: $N = 6000$ rpm
 Feed: $f = 0.04$ mm/rev
 Cutting fluid: Water insoluble cutting fluid
 Machine: Special purpose machine

Results:

TH10 inserts machined 9500 pcs. per edge compared to 6000 pcs. for competitive insert and showed no edge breakage.



J-series

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