

TURNLINE J series: Cutting Tools for Small Lathes**JS/JRP/JPP/JSP** type

Extended version
with toolholders and
inserts

Excellent chip control, high quality finishes & productivity levels

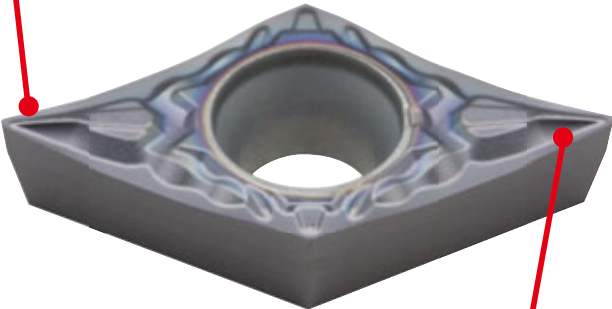


JS type New 3 dimensional chipbreaker

Excellent cutting performance for Superalloys

Dynamic inclination

- Excellent chip control
- Lowers cutting force



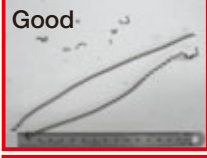
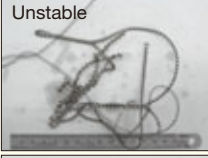




Steep protrusion

- Breaks chips at small depths of cut
- Improves chip coiling at large depth of cut

M Stainless
Work material : Stainless steels (SUS316L)
Insert : DCGT11T301-**
Cutting speed : $V_c = 50$ m/min
Feed : $f = 0.02$ mm/rev

Excellent chip control

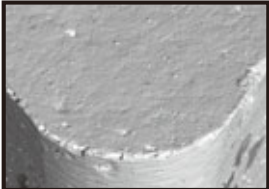
	JS type	Competitor
Depth of cut $a_p = 0.5$ mm	Good 	Uncontrolled 
Depth of cut $a_p = 1.5$ mm	Good 	Unstable 
Depth of cut $a_p = 2.0$ mm	Good 	Chip packing 

Super fine cutting edge

JS type
Fine edge, no chipping



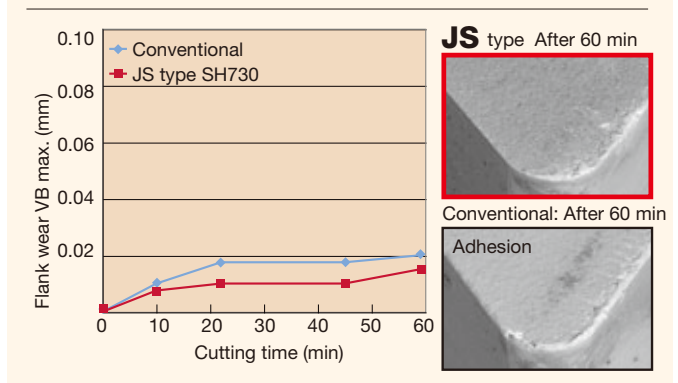
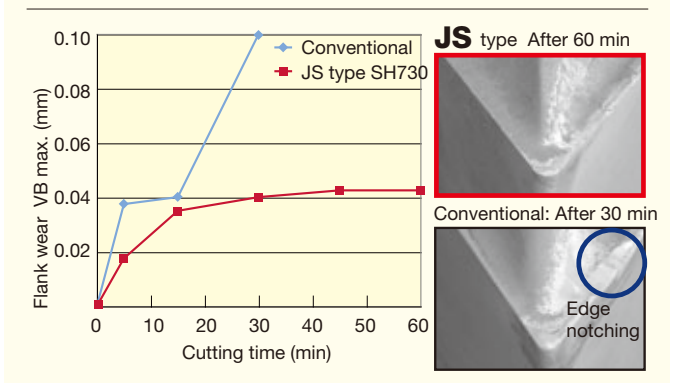
Competitor A
Micro chipping



Long tool life and excellent stability

M Stainless
Work Material: Stainless Steels (SUS316L)
Inserts : DCGT11T301-**
Cutting Speed : $V_c = 50$ m/min
Depth of cut : $a_p = 0.5 \sim 2.0$ mm
Feed : $f = 0.015 \sim 0.03$ mm/rev

S Superalloys
Work Material: Titanium Alloys (Ti-6Al-4V)
Inserts : DCGT11T301-**
Cutting Speed : $V_c = 50$ m/min
Depth of cut : $a_p = 0.5 \sim 2.0$ mm
Feed : $f = 0.015 \sim 0.03$ mm/rev



JRP / JPP / JSP type

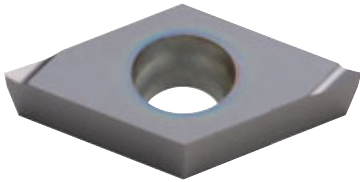
High Tolerance Inserts



3 types of ground chipbreaker available

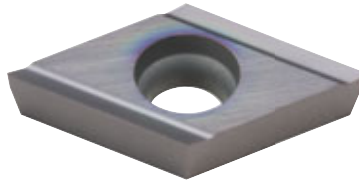
JRP type

Lead (Ramp) type chipbreaker
For excellent chip control



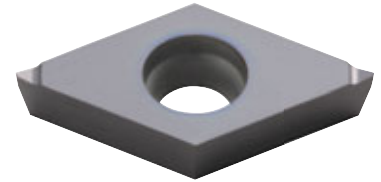
JPP type

Parallel type chipbreaker
Suitable for profiling



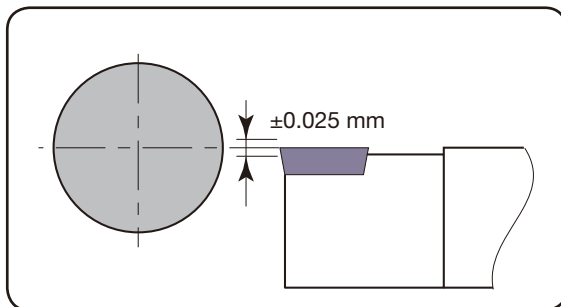
JSP type

Neutral (symmetric) type chipbreaker



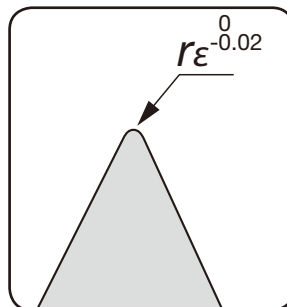
Tolerance of inserts

Height of cutting edge:
 ± 0.025 mm



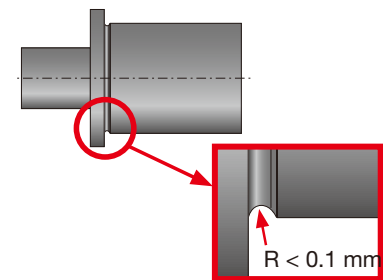
Tolerance of corner radius:

Minus tolerance



Example:
Electrical equipment

Effective performance for the specified corner radius (see below)



Grades

New PVD coated grade

SH730



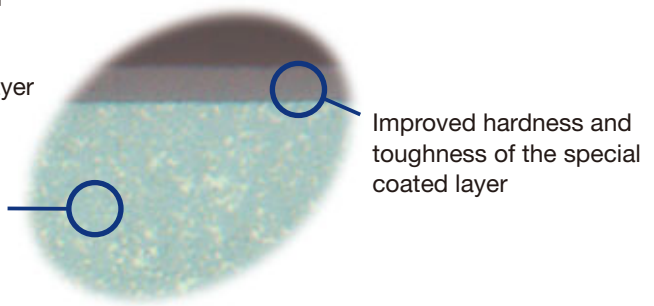
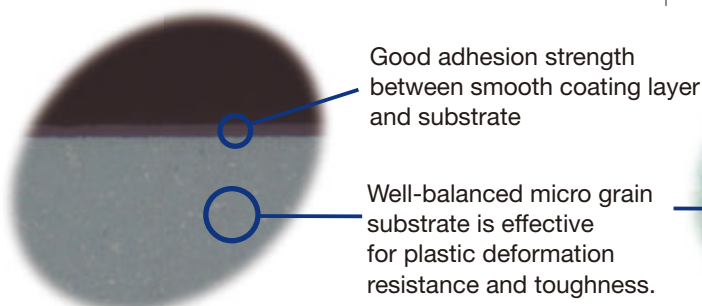
The unique (Ti,Al)N coating layer increases the welding resistance. The SH730 also has an excellent balance between sharpness and chipping resistance.

New PVD coated grade

AH725



The special (Ti,Al)N coating layer and substrate improve features such as wear resistance and toughness.



Inserts (JS type)

80° Rhombic, 7° Positive

Application	Chipbreaker Appearance (Cross section)	f - ap	Insert Cat. No.	Dimensions (mm)				Grades	
				I.C.dia. Ød	Thickness s	Hole dia Ød1	Corner radius r _ε	Coated	
								SH730	AH725
For external turning on small lathes Sharp edge	JS 		CCGT060200FN-JS	6.35	2.38	2.8	0.03	●	
			CCGT060201FN-JS				0.1	●	
			CCGT060202FN-JS				0.2	●	
			CCGT060204FN-JS				0.4	●	
			CCGT09T300FN-JS	9.525	3.97	4.4	0.03	●	
			* CCGT09T301FN-JS				0.1	●	
			CCGT09T302FN-JS				0.2	●	
CCGT09T304FN-JS				0.4	●				
For external turning on small lathes	JS 		CCGT060201N-JS	6.35	2.38	2.8	0.1		●
			CCGT060202N-JS				0.2		●
			CCGT060204N-JS				0.4		●
			* CCGT09T301N-JS	9.525	3.97	4.4	0.1		●
			CCGT09T302N-JS				0.2		●
			CCGT09T304N-JS				0.4		●
NEW For internal turning on small lathes	JS 		CCGT03X101-JS	3.57	1.39	1.9	0.1	●	
			CCGT03X102-JS				0.2	●	
			CCGT03X104-JS				0.4	●	
			* CCGT04T101-JS	4.37	1.79	2.3	0.1	●	
			CCGT04T102-JS				0.2	●	
			CCGT04T104-JS				0.4	●	

55° Rhombic, 7° Positive

Application	Chipbreaker Appearance (Cross section)	f - ap	Insert Cat. No.	Dimensions (mm)				Grades	
				I.C.dia. Ød	Thickness s	Hole dia Ød1	Corner radius r _ε	Coated	
								SH730	AH725
For external turning on small lathes Sharp edge	JS 		DCGT070200FN-JS	6.35	2.38	2.8	0.03	●	
			DCGT070201FN-JS				0.1	●	
			DCGT070202FN-JS				0.2	●	
			DCGT11T300FN-JS				9.525	3.97	4.4
			* DCGT11T301FN-JS	0.1	●				
			DCGT11T302FN-JS	0.2	●				
			DCGT11T304FN-JS				0.4	●	
For external turning on small lathes	JS 		DCGT070201N-JS	6.35	2.38	2.8	0.1		●
			DCGT070202N-JS				0.2		●
			* DCGT11T301N-JS	9.525	3.97	4.4	0.1		●
			DCGT11T302N-JS				0.2		●
			DCGT11T304N-JS				0.4		●

75° Rhombic, 11° Positive

Application	Chipbreaker Appearance (Cross section)	f - ap	Insert Cat. No.	Dimensions (mm)				Grades	
				I.C.dia. Ød	Thickness s	Hole dia Ød1	Corner radius r _ε	Coated	
								SH730	AH725
NEW For internal turning on small lathes	JS 		EPGT03X101-JS	3.57	1.39	1.9	0.1	●	
			EPGT03X102-JS				0.2	●	
			EPGT03X104-JS				0.4	●	
			* EPGT040101-JS	4.37	1.59	2.3	0.1	●	
			EPGT040102-JS				0.2	●	
			EPGT040104-JS				0.4	●	

Note: Chipbreaker Cross section is marked * next to the Cat. No.

● : Stocked items

60° Triangular, 7° positive

Application	Chipbreaker Appearance (Cross section)	$f - ap$	Insert Cat. No.	Dimensions (mm)				Grades	
				I.C.dia. $\varnothing d$	Thickness s	Hole dia $\varnothing d1$	Corner radius r_{ϵ}	Coated SH730 AH725	
For external turning on small lathes Sharp edge	JS 		TCGT110200FN-JS	6.35	2.38	2.8	0.03	●	
			* TCGT110201FN-JS				0.1	●	
			TCGT110202FN-JS				0.2	●	
			TCGT110204FN-JS				0.4	●	
For external turning on small lathes	JS 		* TCGT110201N-JS	6.35	2.38	2.8	0.1		●
			TCGT110202N-JS				0.2		●
			TCGT110204N-JS				0.4		●

60° Triangular, 11° positive

Application	Chipbreaker Appearance (Cross section)	$f - ap$	Insert Cat. No.	Dimensions (mm)				Grades	
				I.C.dia. $\varnothing d$	Thickness s	Hole dia $\varnothing d1$	Corner radius r_{ϵ}	Coated SH730 AH725	
For internal turning on small lathes	JS 		* TPGT070101-JS	4.37	1.59	2.58	0.1	●	
			TPGT070102-JS				0.2	●	
			TPGT070104-JS				0.4	●	

NEW

35° Rhombic, 5° Positive

Application	Chipbreaker Appearance (Cross section)	$f - ap$	Insert Cat. No.	Dimensions (mm)				Grades	
				I.C.dia. $\varnothing d$	Thickness s	Hole dia $\varnothing d1$	Corner radius r_{ϵ}	Coated SH730 AH725	
For external turning on small lathes Sharp edge	JS 		VBGT110300FN-JS	6.35	3.18	2.8	0.03	●	
			* VBGT110301FN-JS				0.1	●	
			VBGT110302FN-JS				0.2	●	
			VBGT110304FN-JS				0.4	●	
For external turning on small lathes	JS 		* VBGT110301N-JS	6.35	3.18	2.8	0.1		●
			VBGT110302N-JS				0.2		●
			VBGT110304N-JS				0.4		●

80° Trigon, 5° positive

Application	Chipbreaker Appearance (Cross section)	$f - ap$	Insert Cat. No.	Dimensions (mm)				Grades	
				I.C.dia. $\varnothing d$	Thickness s	Hole dia $\varnothing d1$	Corner radius r_{ϵ}	Coated SH730 AH725	
For internal turning on small lathes	JS 		* WBGT030101R-JS	3.97	1.59	2.3	0.1	●	
			WBGT030101L-JS				0.1	●	
			WBGT030102R-JS				0.2	●	
			WBGT030102L-JS				0.2	●	
			WBGT030104R-JS				0.4	●	
			WBGT030104L-JS				0.4	●	

NEW

Note: Chipbreaker Cross section is marked * next to the Cat. No.

● : Stocked items

Standard cutting conditions JS types

Work material	chip-breaker	Grades	Cutting speed Vc (m/min)	Depth of cut ap (mm)	Feed f (mm/rev)			
					rε = 0.03	rε = 0.1	rε = 0.2	rε = 0.4
Steels S45C, SCM435 etc. (C45, 34CrMo4 etc.)	JS	AH725	120 (50 - 180)	1.5 (0.1 - 3.0)	-	0.03 (0.01 - 0.05)	0.06 (0.02 - 0.1)	0.1 (0.05 - 0.2)
Stainless steels SUS303, SUS304 etc. (X10CrNiS18-9, etc.)		SH730	100 (30 - 150)	1.2 (0.1 - 3.0)	0.01 (0.005 - 0.02)			0.1 (0.05 - 0.15)
		AH725	120 (50 - 150)		-			0.1 (0.05 - 0.2)
Titanium alloys (Ti-6AL-4v etc.)		SH730	60 (30 - 100)	1.5 (0.1 - 3.0)	0.01 (0.005 - 0.02)			0.1 (0.05 - 0.15)
	AH725	-			0.1 (0.05 - 0.2)			

Inserts (JRP / JPP / JSP type)

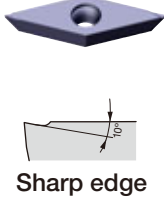
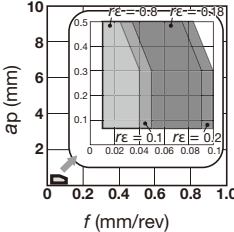
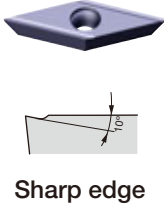
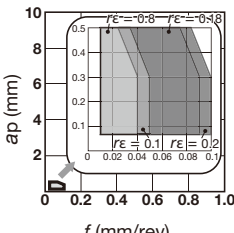
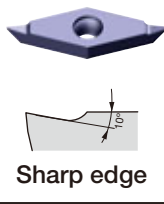
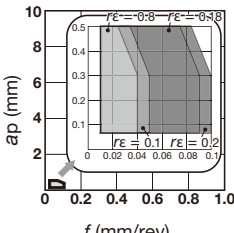
55° Rhombic, 7° Positive

Application	Chipbreaker	f - ap	Insert Cat. No.	Dimensions (mm)				Grades				
	Appearance (Cross section)			I.C.dia. Ød	Thickness s	Hole dia Ød1	Corner radius rε	Coated SH730				
For external turning on small lathes	JRP		DCET0702008MFR-JRP	6.35	2.38	2.8	0.08	●				
	DCET0702008MFL-JRP		●									
	DCET070201 MFR-JRP		0.10					●				
	DCET070201 MFL-JRP							●				
	DCET0702018MFR-JRP		0.18					●				
	DCET0702018MFL-JRP							●				
	DCET070202 MFR-JRP		0.20					●				
	DCET070202 MFL-JRP							●				
	DCET11T3008MFR-JRP		9.525					3.97	4.4	0.08	●	
	DCET11T3008MFL-JRP										●	
	DCET11T301 MFR-JRP										0.10	●
	DCET11T301 MFL-JRP											●
	DCET11T3018MFR-JRP										0.18	●
	DCET11T3018MFL-JRP											●
* DCET11T302 MFR-JRP	0.20	●										
DCET11T302 MFL-JRP		●										
For external turning on small lathes	JPP			DCET0702008MFR-JPP	6.35	2.38	2.8				0.08	●
	DCET0702008MFL-JPP			●								
	DCET070201 MFR-JPP			0.10								●
	DCET070201 MFL-JPP											●
	DCET0702018MFR-JPP			0.18								●
	DCET0702018MFL-JPP											●
	DCET070202 MFR-JPP		0.20	●								
	DCET070202 MFL-JPP			●								
	DCET11T3008MFR-JPP		9.525	3.97				4.4	0.08	●		
	DCET11T3008MFL-JPP									●		
	DCET11T301 MFR-JPP									0.10		●
	DCET11T301 MFL-JPP											●
	DCET11T3018MFR-JPP									0.18		●
	DCET11T3018MFL-JPP											●
* DCET11T302 MFR-JPP	0.20	●										
DCET11T302 MFL-JPP		●										
For external turning on small lathes	JSP				DCET0702008MFN-JSP	6.35	2.38			2.8	0.08	●
	DCET070201 MFN-JSP				●							
	DCET0702018MFN-JSP				0.18							●
	DCET070202 MFN-JSP											●
	DCET11T3008MFN-JSP				9.525	3.97	4.4			0.08	●	
	DCET11T301 MFN-JSP										0.10	●
	DCET11T3018MFN-JSP		0.18	●								
	* DCET11T302 MFN-JSP			0.20				●				

Note: Chipbreaker Cross section is marked * next to the Cat. No.

● : Stocked items

35° Rhombic, 11° Positive

Application	Chipbreaker	$f - ap$	Insert Cat. No.	Dimensions (mm)				Grades		
	Appearance (Cross section)			I.C.dia. $\varnothing d$	Thickness s	Hole dia $\varnothing d1$	Corner radius r_{ϵ}	Coated SH730		
For external turning on small lathes	JRP	 	VPET0802008MFR-JRP	4.76	2.38	2.3	0.08	●		
	VPET0802008MFL-JRP		●							
	VPET080201 MFR-JRP		0.10				●			
	VPET080201 MFL-JRP						●			
	VPET0802018MFR-JRP						0.18	●		
	VPET0802018MFL-JRP		●							
	VPET080202 MFR-JRP		0.20				●			
	VPET080202 MFL-JRP						●			
	VPET1103008MFR-JRP		6.35				3.18	2.8	0.08	●
	VPET1103008MFL-JRP			●						
	VPET110301 MFR-JRP			0.10	●					
	VPET110301 MFL-JRP				●					
	VPET1103018MFR-JRP				0.18	●				
	VPET1103018MFL-JRP			●						
	* VPET110302 MFR-JRP			0.20	●					
	VPET110302 MFL-JRP				●					
	For external turning on small lathes			JPP	 	VPET0802008MFR-JPP			4.76	2.38
			VPET0802008MFL-JPP	●						
VPET080201 MFR-JPP		0.10	●							
VPET080201 MFL-JPP			●							
VPET0802018MFR-JPP			0.18	●						
VPET0802018MFL-JPP		●								
VPET080202 MFR-JPP		0.20	●							
VPET080202 MFL-JPP			●							
VPET1103008MFR-JPP		6.35	3.18	2.8		0.08	●			
VPET1103008MFL-JPP							●			
VPET110301 MFR-JPP						0.10	●			
VPET110301 MFL-JPP							●			
VPET1103018MFR-JPP							0.18	●		
VPET1103018MFL-JPP						●				
* VPET110302 MFR-JPP						0.20	●			
VPET110302 MFL-JPP							●			
For external turning on small lathes						JSP	 	VPET0802008MFN-JSP	4.76	2.38
		VPET080201 MFN-JSP	0.10	●						
	VPET0802018MFN-JSP	0.18	●							
	VPET080202 MFN-JSP	0.20	●							
	VPET1103008MFN-JSP	6.35	3.18	2.8	0.08	●				
	VPET110301 MFN-JSP				0.10	●				
	VPET1103018MFN-JSP				0.18	●				
	* VPET110302 MFN-JSP				0.20	●				

Note: Chipbreaker Cross section is marked * next to the Cat. No.

● : Stocked items

Standard cutting conditions JPP / JRP / JSP types

Work material	chip-breaker	Grade	Cutting speed V_c (m/min)	Depth of cut ap (mm)	Feed f (mm/rev)			
					$r_{\epsilon} = 0.08$	$r_{\epsilon} = 0.10$	$r_{\epsilon} = 0.18$	$r_{\epsilon} = 0.20$
Steels S45C, SCM435 etc. (C45, 34CrMo4 etc.)	JPP JRP JSP	SH730	100 (50 - 150)	0.3 (0.1 - 0.5)	0.025 (0.01 - 0.04)	0.03 (0.01 - 0.05)	0.055 (0.02 - 0.09)	0.06 (0.02 - 0.1)
Stainless steels SUS303, SUS304 etc. (X10CrNiS18-9, etc.)			100 (30 - 150)					
Titanium alloys (Ti-6AL-4v etc.)			60 (30 - 100)					

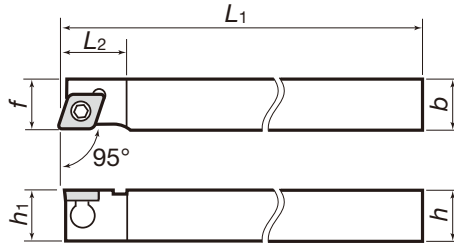
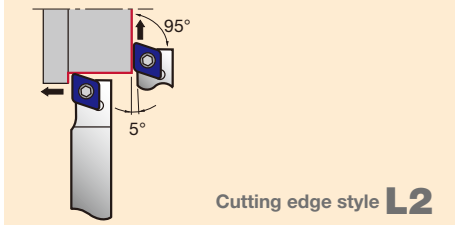
● : Stocked items

Toolholder

External turning / Positive rake

JTCL2C R/L Turning & facing

JT-type (Positive rake, back clamping system)



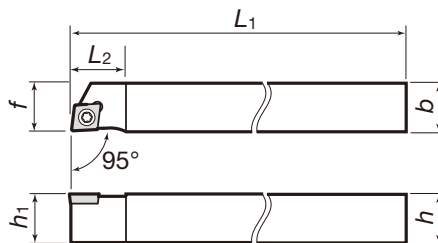
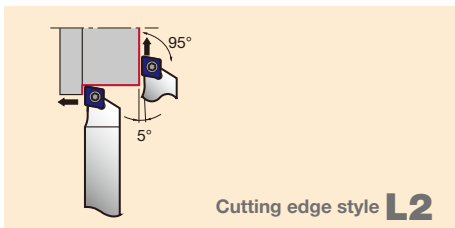
Without offset

Right hand (R) shown

Cat. No.	Stock		Dimensions (mm)					Standard corner radius $r\epsilon$	Applicable inserts	Parts		
	R	L	h	b	L_1	L_2	h_1			Clamp	Clamping screw	Wrench
JTCL2CR/L0810K06	●	●	8	10	125	12	8	10	CC□□0602	JCP-2	JDS-3525	P-2F
JTCL2CR/L1010K06	●	●	10	10	125	12	10	10				
JTCL2CR/L1212M09	●	●	12	12	150	16	12	12	CC□□09T3	JCP-3	JDS-5040	P-2.5F
JTCL2CR/L1616M09	●	●	16	16	150	16	16	16				

JSCL2C R/L Turning & facing

J-type (Positive rake, screw-on system)



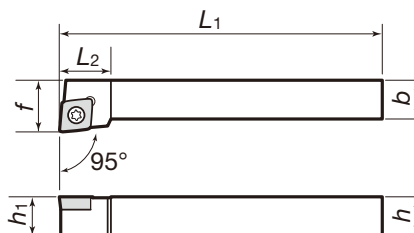
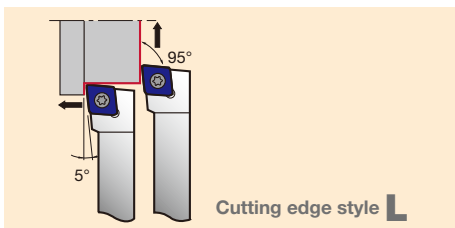
Without offset

Right hand (R) shown

Cat. No.	Stock		Dimensions (mm)					Standard corner radius $r\epsilon$	Applicable inserts	Parts		Torque (N·m)
	R	L	h	b	L_1	L_2	h_1			f	Clamping screw	
JSCL2CR/L1010K06	●	●	10	10	125	12	10	10	CC□□0602	CSTB-2.5	T-8F	1.2
JSCL2CR/L1212K06	●	●	12	12	125	12	12	12				

JSCLC R/L Turning & facing

J-type (Positive rake, screw-on system)



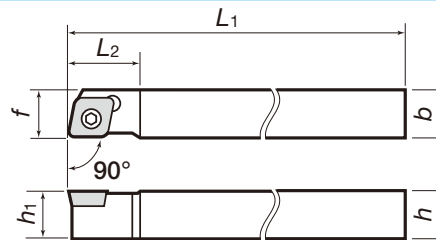
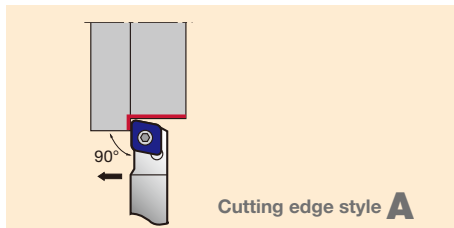
Right hand (R) shown

Cat. No.	Stock		Dimensions (mm)					Standard corner radius $r\epsilon$	Applicable inserts	Parts		Torque (N·m)
	R	L	h	b	L_1	L_2	h_1			f	Clamping screw	
JSCLCR/L0808H06	●	●	8	8	100	12	8	10	CC□□0602	CSTB-2.5	T-8F	1.2
JSCLCR/L1010H06	●	●	10	10	100	12	10	12				
JSCLCR/L1212H09	●	●	12	12	100	16	12	16	CC□□09T3	CSTB-4SD	T-8F	1.2
JSCLCR/L1616H09	●	●	16	16	100	16	16	20				

● : Stocked items

JSCAC R/L Turning

J-type (Positive rake, screw-on system)



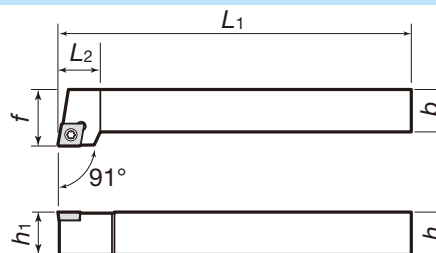
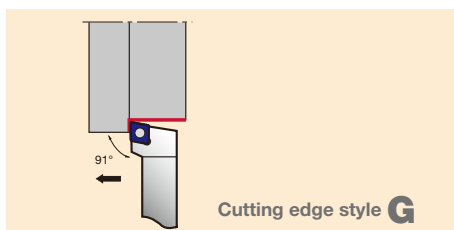
Without offset

Right hand (R) shown

Cat. No.	Stock		Dimensions (mm)					Standard corner radius r_E	Applicable inserts	Parts			Torque (N·m)
	R	L	h	b	L_1	L_2	h_1			f	Clamping screw	Wrench	
JSCACR/L0808H06	●	●	8	8	100	12	8	8	CC□□0602	CSTB-2.5	T-8F	1.2	
JSCACR/L1010H06	●	●	10	10	100	12	10	10					
JSCACR/L1212H09	●	●	12	12	100	16	12	12	CC□□09T3	CSTB-4SD	T-8F	1.2	

JSCGC R/L Turning

J-type (Positive rake, screw-on system)

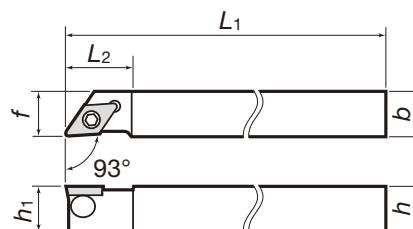
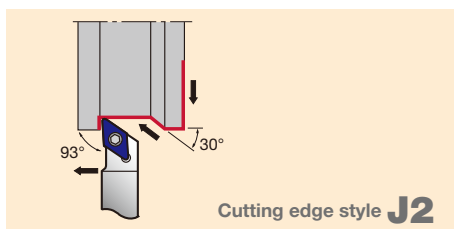


Right hand (R) shown

Cat. No.	Stock		Dimensions (mm)					Standard corner radius r_E	Applicable inserts	Parts			Torque (N·m)
	R	L	h	b	L_1	L_2	h_1			f	Clamping screw	Wrench	
JSCGCR/L1212H06	●	●	12	12	100	12	12	16	CC□□0602	CSTB-2.5	T-8F	1.2	
JSCGCR/L1616H09	●	●	16	16	100	16	16	20					

JTDJ2C R/L Turning & profiling

JT-type (Positive rake, back clamping system)



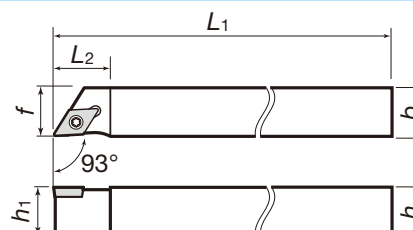
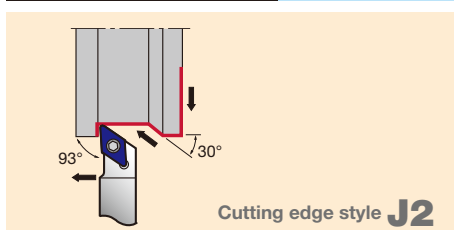
Without offset

Right hand (R) shown

Cat. No.	Stock		Dimensions (mm)					Standard corner radius r_E	Applicable inserts	Parts		
	R	L	h	b	L_1	L_2	h_1			f	Clamp	Clamping screw
JTDJ2CR/L0810K07	●	●	8	10	125	14	8	10	DC□□0702	JCP-2	JDS-3525	P-2F
JTDJ2CR/L1010K07	●	●	10	10	125	14	10	10				
JTDJ2CR/L1212M11	●	●	12	12	150	18	12	12	DC□□11T3	JCP-3	JDS-5040	P-2.5F
JTDJ2CR/L1616M11	●	●	16	16	150	18	16	16				

JSDJ2C R/L Profiling

J-type (Positive rake, screw-on system)



Without offset

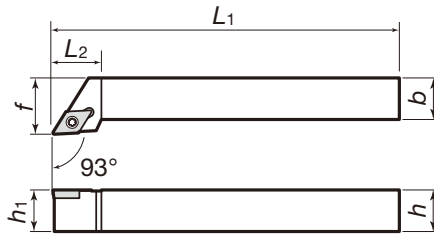
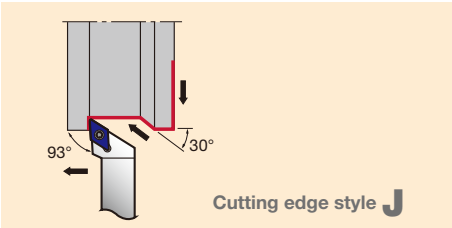
Right hand (R) shown

Cat. No.	Stock		Dimensions (mm)					Standard corner radius r_E	Applicable inserts	Parts			Torque (N·m)
	R	L	h	b	L_1	L_2	h_1			f	Clamping screw	Wrench	
JSDJ2CR/L1010K07	●	●	10	10	125	14	10	10	DC□□0702	CSTB-2.5	T-8F	1.2	
JSDJ2CR/L1212K07	●	●	12	12	125	14	12	12					

● : Stocked items

External turning / Positive rake

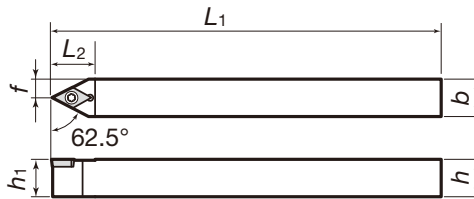
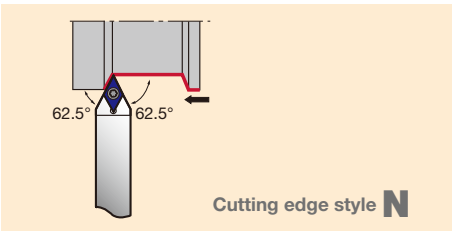
JSDJC R/L Profiling J-type (Positive rake, screw-on system)



Right hand (R) shown

Cat. No.	Stock		Dimensions (mm)						Standard corner radius r_E	Applicable inserts	Parts		Torque (N·m)
	R	L	h	b	L_1	L_2	h_1	f			Clamping screw	Wrench	
JSDJCR/L0808H07	●	●	8	8	100	14	8	10	0.4	DC□□0702	CSTB-2.5	T-8F	1.2
JSDJCR/L1212H07	●	●	12	12	100	14	12	16	0.4				
JSDJCR/L1010H11	●	●	10	10	100	18	10	12	0.8	DC□□11T3	CSTB-2.5	T-8F	1.2
JSDJCR/L1212H11	●	●	12	12	100	18	12	16	0.8				
JSDJCR/L1616H11	●	●	16	16	100	18	16	20	0.8				

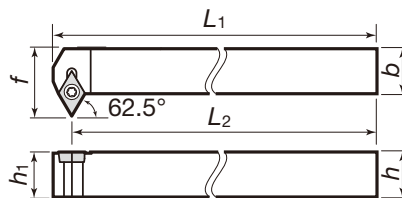
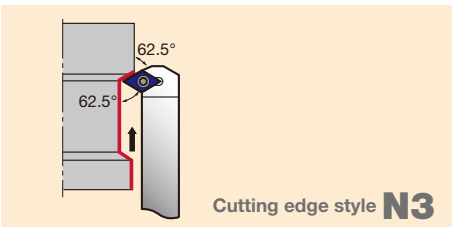
JSDNC N Profiling J-type (Positive rake, screw-on system)



Without offset

Cat. No.	Stock		Dimensions (mm)						Standard corner radius r_E	Applicable inserts	Parts		Torque (N·m)
	R	L	h	b	L_1	L_2	h_1	f			Clamping screw	Wrench	
JSDNCN0808H07	●		8	8	100	14	8	4	0.4	DC□□0702	CSTB-2.5	T-8F	1.2
JSDNCN1010K07	●		10	10	125	14	10	5	0.4				
JSDNCN1212K07	●		12	12	125	14	12	6	0.4				
JSDNCN1212H11	●		12	12	100	21	12	6	0.8	DC□□11T3	CSTB-4SD	T-8F	1.2
JSDNCN1616H11	●		16	16	100	21	16	8	0.8				

JSDN3C R/L Profiling J-type (Positive rake, screw-on system)



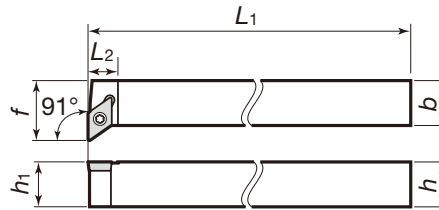
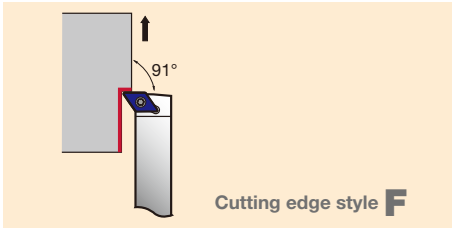
Right hand (R) shown

Cat. No.	Stock		Dimensions (mm)						Standard corner radius r_E	Applicable inserts	Parts		Torque (N·m)
	R	L	h	b	L_1	L_2	h_1	f			Clamping screw	Wrench	
JSDN3CR/L1212H07	●	●	12	12	105	100	12	18	0.4	DC□□0702	CSTB-2.5	T-8F	1.2
JSDN3CR/L1616H11	●	●	16	16	107	100	16	25	0.8	DC□□11T3	CSTB-4SD	T-8F	1.2

● : Stocked items

JSDFC R/L Facing

J-type (Positive rake, screw-on system)

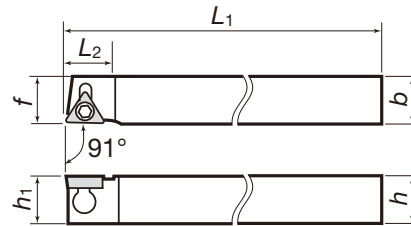
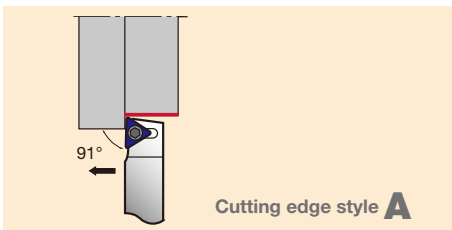


Right hand (R) shown

Cat. No.	Stock		Dimensions (mm)						Standard corner radius r_E	Applicable inserts	Parts		Torque (N·m)
	R	L	h	b	L_1	L_2	h_1	f			Clamping screw	Wrench	
JSDFCR/L1212H07	●	●	12	12	100	8	12	16	0.4	DC□□0702	CSTB-2.5	T-8F	1.2
JSDFCR/L1616H11	●	●	16	16	100	10.5	16	22	0.8	DC□□11T3	CSTB-4SD	T-8F	1.2

JTTAC R/L Turning

JT-type (Positive rake, back clamping system)



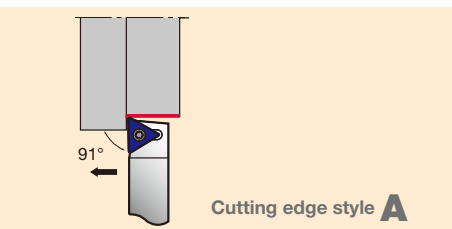
Without offset

Right hand (R) shown

Cat. No.	Stock		Dimensions (mm)						Standard corner radius r_E	Applicable inserts	Parts		
	R	L	h	b	L_1	L_2	h_1	f			Clamp	Clamping screw	Wrench
JTTACR/L0810K08	●	●	8	10	125	10	8	10	0.2	TC□□0802	JCP-1	JDS-3525	P-2F
JTTACR/L1010K08	●	●	10	10	125	10	10	10	0.2		JCP-1	JDS-3525	P-2F
JTTACR/L1212M11	●	●	12	12	150	12	12	12	0.4	TC□□1102	JCP-2	JDS-3525	P-2F
JTTACR/L1616M11	●	●	16	16	150	12	16	16	0.4		JCP-2	JDS-3525	P-2F

JSTAC R/L Turning

J-type (Positive rake, screw-on system)



Without offset

Right hand (R) shown

Cat. No.	Stock		Dimensions (mm)						Standard corner radius r_E	Applicable inserts	Parts		Torque (N·m)
	R	L	h	b	L_1	L_2	h_1	f			Clamping screw	Wrench	
JSTACR/L0808K08	●	●	8	8	125	10	8	8	0.2	TC□□0802	CSTB-2L	T-6F	0.6
JSTACR/L1010K08	●	●	10	10	125	10	10	10	0.2		CSTB-2L	T-6F	0.6
JSTACR/L1212K11	●	●	12	12	125	12	12	12	0.4	TC□□1102	CSTB-2.5	T-8F	1.2
JSTACR/L1616H11	●	●	16	16	100	12	16	16	0.4		CSTB-2.5	T-8F	1.2

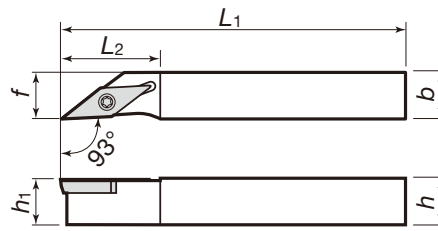
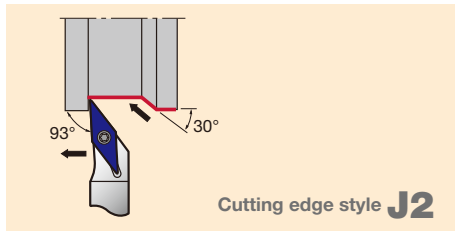
● : Stocked items

External turning / Positive rake

NEW

JSVJ2B R/L Profiling

J-type (Positive rake, screw-on system)



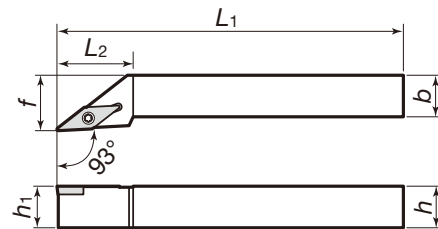
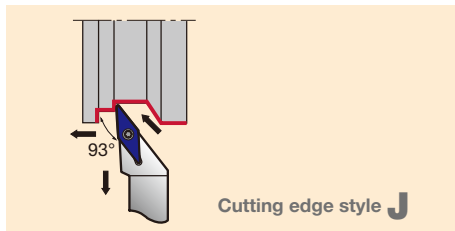
Without offset

Right hand (R) shown

Cat. No.	Stock		Dimensions (mm)						Standard corner radius r_E	Applicable inserts	Parts		Torque (N·m)
	R	L	h	b	L_1	L_2	h_1	f			Clamping screw	Wrench	
JSVJ2BR/L1010K11	●	●	10	10	125	21	10	10	0.2	VB□□1103	CSTB-2.5	T-8F	1.2
JSVJ2BR/L1212K11	●	●	12	12	125	21	12	12	0.2				
JSVJ2BR/L1616K11	●	●	16	16	125	21	16	16	0.2				

JSVJB R/L Profiling

J-type (Positive rake, screw-on system)



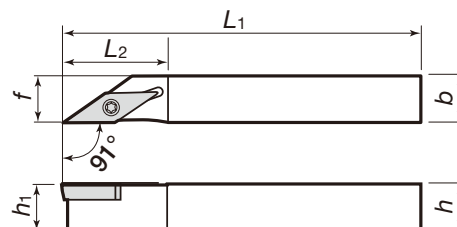
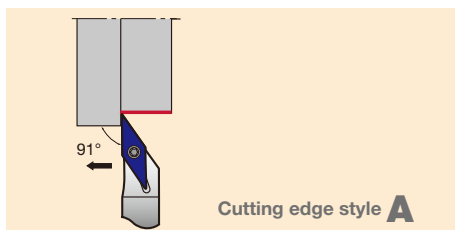
Right hand (R) shown

Cat. No.	Stock		Dimensions (mm)						Standard corner radius r_E	Applicable inserts	Parts		Torque (N·m)
	R	L	h	b	L_1	L_2	h_1	f			Clamping screw	Wrench	
JSVJBR/L1010H11	●	●	10	10	100	20	10	12	0.4	VB□□1103	CSTB-2.5	T-8F	1.2
JSVJBR/L1212H11	●	●	12	12	100	22	12	16	0.4				
JSVJBR/L1616H11	●	●	16	16	100	22	16	20	0.4				

NEW

JSVAB R/L Turning

J-type (Positive rake, screw-on system)



Without offset

Right hand (R) shown

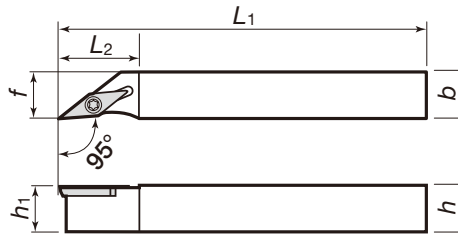
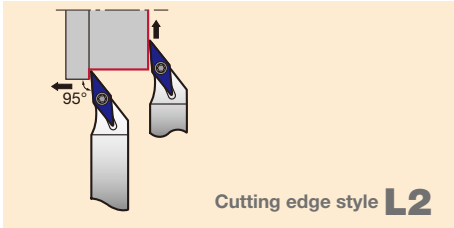
Cat. No.	Stock		Dimensions (mm)						Standard corner radius r_E	Applicable inserts	Parts		Torque (N·m)
	R	L	h	b	L_1	L_2	h_1	f			Clamping screw	Wrench	
JSVABR/L1010K11	●	●	10	10	125	21	10	10	0.2	VB□□1103	CSTB-2.5	T-8F	1.2
JSVABR/L1212K11	●	●	12	12	125	21	12	12	0.2				
JSVABR/L1616K11	●	●	16	16	125	21	16	16	0.2				

● : Stocked items

NEW

JSVL2P R/L Turning & facing

J-type (Positive rake, screw-on system)



Without offset

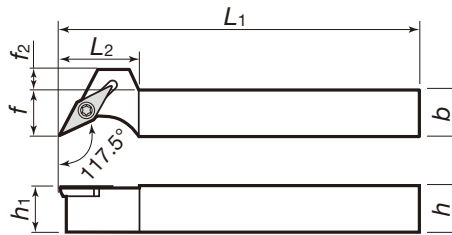
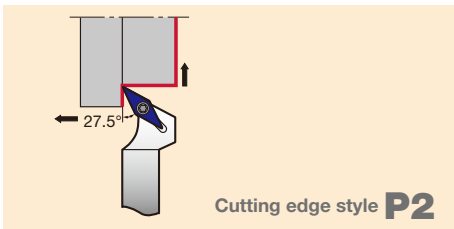
Right hand (R) shown

Cat. No.	Stock		Dimensions (mm)						Standard corner radius r_E	Applicable inserts	Parts		Torque (N·m)
	R	L	h	b	L_1	L_2	h_1	f			Clamping screw	Wrench	
JSVL2PR/L1010K08	●	●	10	10	125	16	10	10	0.2	VP□□0802	CSTB-2L	T-6F	0.6
JSVL2PR/L1212K08	●	●	12	12	125	16	12	12	0.2				
JSVL2PR/L1616K08	●	●	16	16	125	16	16	16	0.2				

NEW

JSVP2P R/L Profiling

J-type (Positive rake, screw-on system)



Without offset

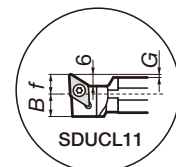
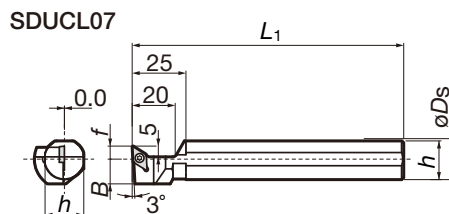
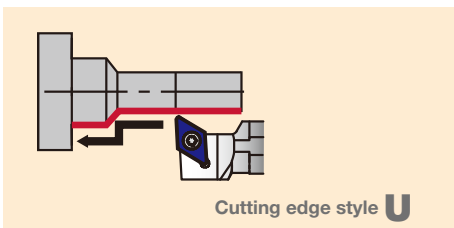
Right hand (R) shown

Cat. No.	Stock		Dimensions (mm)							Standard corner radius r_E	Applicable inserts	Parts		Torque (N·m)
	R	L	h	b	L_1	L_2	h_1	f	f_2			Clamping screw	Wrench	
JSVP2PR/L1010K08	●	●	10	10	125	16	10	10	4	0.2	VP□□0802	CSTB-2L	T-6F	0.6
JSVP2PR/L1212K08	●	●	12	12	125	16	12	12	2	0.2				
JSVP2PR/L1616K08	●	●	16	16	125	16	16	16	2	0.2				
JSVP2PR/L1010K11	●	●	10	10	125	20	10	10	8	0.2	VP□□1103	CSTB-2.5	T-8F	1.2
JSVP2PR/L1212K11	●	●	12	12	125	20	12	12	6	0.2				
JSVP2PR/L1616K11	●	●	16	16	125	20	16	16	6	0.2				

External turning / Positive rake / Round shank

JS-SDUC L Profiling

J-type (Positive rake, screw-on system)



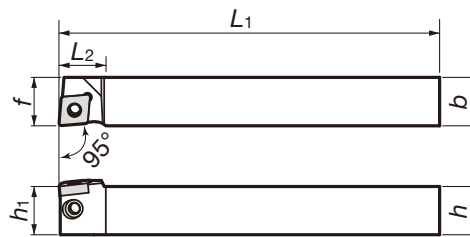
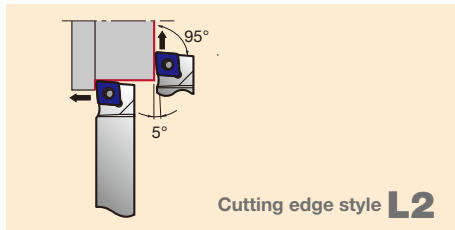
Left hand (L) shown

Cat. No.	Stock	Dimensions (mm)								Standard corner radius r_E	Applicable inserts	Parts		Torque (N·m)
		ϕD_s	f	L_1	L_2	h	B	G	Clamping screw			Wrench		
JS19K-SDUCL07	●	19.05	6	125	-	18	11.5	-	0.4	DC□□0702	CSTB-2.5	T-8F	1.2	
JS20K-SDUCL07	●	20	6	125	-	19	11.5	-	0.4					
JS22K-SDUCL07	●	22	6	125	-	21	11.5	-	0.4					
JS19K-SDUCL11	●	19.05	10	125	-	18	11.5	1.525	0.8	DC□□11T3	CSTB-4SD	T-8F	1.2	
JS20K-SDUCL11	●	20	10	125	-	19	11.5	1.0	0.8					
JS22K-SDUCL11	●	22	11	125	-	21	11.5	1.0	0.8					
JS25K-SDUCL11	●	25.4	12	125	-	24	12.7	0.7	0.8					

● : Stocked items

External turning / Negative rake

JTCL2N R/L Turning & facing JT-type (Negative rake, back clamping system)

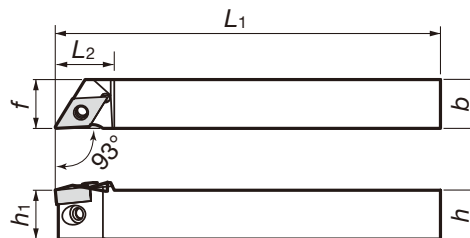
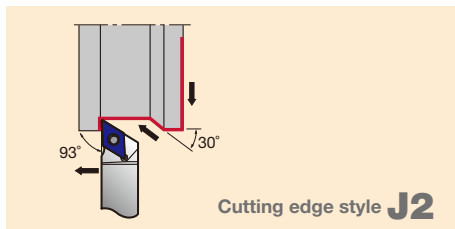


Without offset

Right hand (R) shown

Cat. No.	Stock		Dimensions (mm)					Standard corner radius r _E	Applicable inserts	Parts			
	R	L	h	b	L ₁	L ₂	h ₁			f	Clamp	Clamping screw	Wrench
JTCL2NR/L1216K09			12	16	125	15.6	12	16	0.4	CN□□0903	JCP-3N	JDS-5040	P-2.5F
JTCL2NR/L1616K09			16	16	125	15.6	16	16	0.4				

JTDJ2N R/L Turning & profiling JT-type (Negative rake, back clamping system)

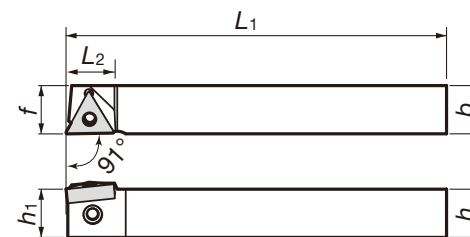
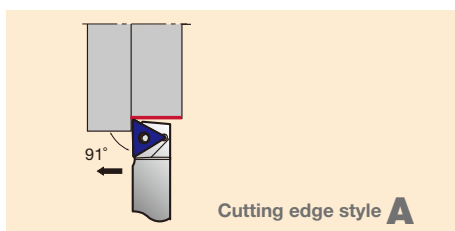


Without offset

Right hand (R) shown

Cat. No.	Stock		Dimensions (mm)					Standard corner radius r _E	Applicable inserts	Parts			
	R	L	h	b	L ₁	L ₂	h ₁			f	Clamp	Clamping screw	Wrench
JTDJ2NR/L1216K11			12	16	125	15.6	12	16	0.4	DN□□1104	JCP-3N	JDS-5040	P-2.5F
JTDJ2NR/L1616K11			16	16	125	15.6	16	16	0.4				

JTTAN R/L Turning JT-type (Negative rake, back clamping system)



Without offset

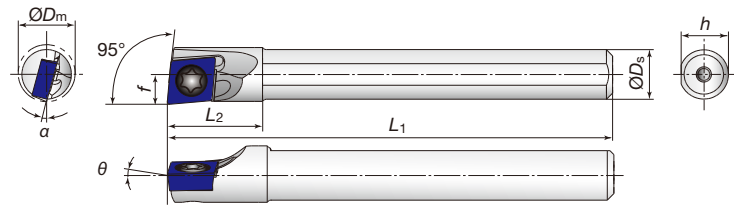
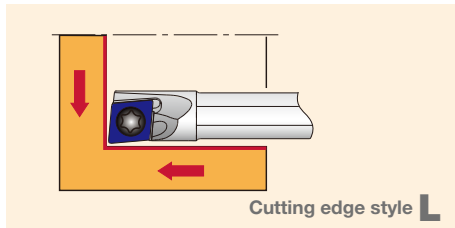
Right hand (R) shown

Cat. No.	Stock		Dimensions (mm)					Standard corner radius r _E	Applicable inserts	Parts			
	R	L	h	b	L ₁	L ₂	h ₁			f	Clamp	Clamping screw	Wrench
JTTANR/L1216K16	●	●	12	16	125	19.8	12	16	0.4	TN□□1604	JCP-3N	JDS-5040	P-2.5F
JTTANR/L1616K16	●	●	16	16	125	19.8	16	16	0.4				

● : Stocked items

Internal turning / Positive rake

SCLCR/L Boring & internal facing S-type (Positive, screw-on)



Right hand (R) shown

Steel shank

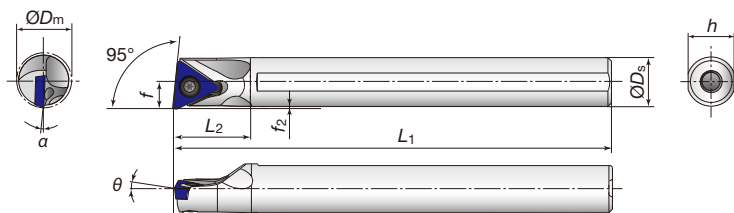
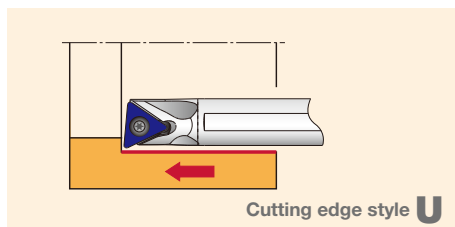
Toolholder Cat. No.	Stock		Min. bore dia. ϕD_m	Dimensions (mm)							Std. corner radius r_E	Applicable inserts	Parts		Torque (N-m)	
	R	L		ϕD_s	f	L_1	L_2	h	f_2	θ			α	Clamping screw		Wrench
A04F-SCLCR/L03-D050	●	●	5	4	2.5	80	8	3.8	-	0°	-15°	0.2	CC□□03X1	CSTA-1.6	T-6F	0.6
A05F-SCLCR/L03-D060	●	●	6	5	3	80	9	4.8	-	0°	-13°	0.2	CC□□03X1	CSTA-1.6	T-6F	0.6
A06G-SCLCR/L04-D070	●	●	7	6	3.5	90	11	5.75	-	0°	-13°	0.2	CC□□04T1	CSTB-2	T-6F	0.6
A07G-SCLCR/L04-D080	●	●	8	7	4	90	12	6.75	-	0°	-11°	0.2	CC□□04T1	CSTB-2	T-6F	0.6

Carbide shank

Toolholder Cat. No.	Stock		Min. bore dia. ϕD_m	Dimensions (mm)							Std. corner radius r_E	Applicable inserts	Parts		Torque (N-m)	
	R	L		ϕD_s	f	L_1	L_2	h	f_2	θ			α	Clamping screw		Wrench
E04G-SCLCR/L03-D050	●	●	5	4	2.5	90	9	3.8	-	0°	-15°	0.2	CC□□03X1	CSTA-1.6	T-6F	0.6
E05G-SCLCR/L03-D060	●	●	6	5	3	90	10	4.8	-	0°	-13°	0.2	CC□□03X1	CSTA-1.6	T-6F	0.6
E06H-SCLCR/L04-D070	●	●	7	6	3.5	100	12	5.75	-	0°	-13°	0.2	CC□□04T1	CSTB-2	T-6F	0.6
E07H-SCLCR/L04-D080	●	●	8	7	4	100	14	6.75	-	0°	-11°	0.2	CC□□04T1	CSTB-2	T-6F	0.6

When using a right or left hand insert, the right hand insert is used for the left hand toolholder (SCLCL □□ type), and the left hand insert is used for the right hand toolholder (SCLCR □□ type).

STUPR/L Boring S-type (Positive, screw-on)



Right hand (R) shown

Steel shank

Toolholder Cat. No.	Stock		Min. bore dia. ϕD_m	Dimensions (mm)							Std. corner radius r_E	Applicable inserts	Parts		Torque (N-m)	
	R	L		ϕD_s	f	L_1	L_2	h	f_2	θ			α	Clamping screw		Wrench
A07G-STUPR/L07-D080	●	●	8	7	4	90	12	6.75	0.4	$+5^\circ$	-10°	0.4	TP□□0701	CSTB-2.2L038	T-7F	0.9

Carbide shank

Toolholder Cat. No.	Stock		Min. bore dia. ϕD_m	Dimensions (mm)							Std. corner radius r_E	Applicable inserts	Parts		Torque (N-m)	
	R	L		ϕD_s	f	L_1	L_2	h	f_2	θ			α	Clamping screw		Wrench
E07H-STUPR/L07-D080	●	●	8	7	4	100	14	6.75	0.3	$+5^\circ$	-10°	0.4	TP□□0701	CSTB-2.2L038	T-7F	0.9

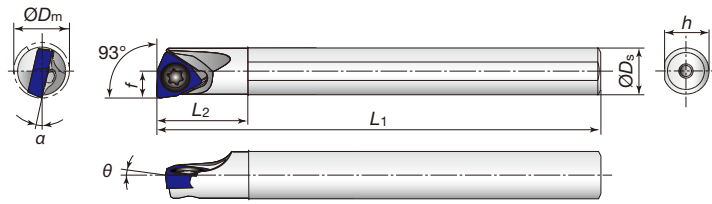
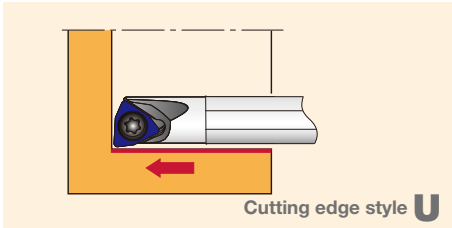
When using a right or left hand insert, the right hand insert (R) is used for the left hand toolholder (STUPL □□ type), and the left hand insert (L) is used for the right hand toolholder (STUPR □□ type).

● : Stocked in Japan

SWUBR/L

Boring

S-type (Positive, screw-on)



Steel shank

Right hand (R) shown

Toolholder Cat. No.	Stock		Min bore dia. ϕD_m	Dimensions (mm)							Std. corner radius $r\epsilon$	Applicable inserts	Parts		Torque (N·m)	
	R	L		ϕD_s	f	L_1	L_2	h	f_2	θ			α	Clamping screw		Wrench
A05F-SWUBR/L03-D060	●	●	6	5	3	80	9	4.8			-13°	0.4	WB□□0301	CSTB-2	T-6F	0.6
A06G-SWUBR/L03-D070	●	●	7	6	3.5	90	11	5.75	-	0°	-12°					
A07G-SWUBR/L03-D080	●	●	8	7	4	90	12	6.75			-11°					

Carbide shank

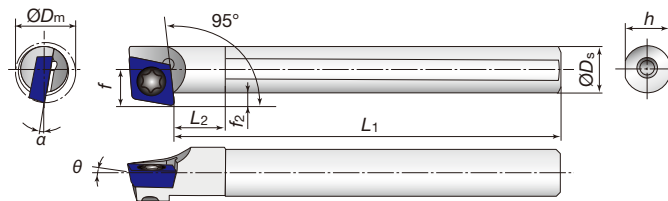
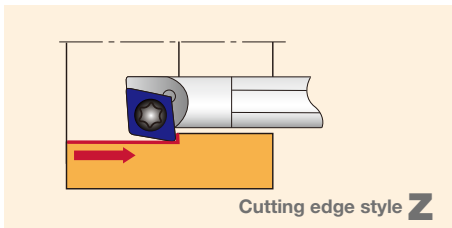
Toolholder Cat. No.	Stock		Min bore dia. ϕD_m	Dimensions (mm)							Std. corner radius $r\epsilon$	Applicable inserts	Parts		Torque (N·m)	
	R	L		ϕD_s	f	L_1	L_2	h	f_2	θ			α	Clamping screw		Wrench
E05G-SWUBR/L03-D060	●	●	6	5	3	90	10	4.8			-13°	0.4	WB□□0301	CSTB-2	T-6F	0.6
E06H-SWUBR/L03-D070	●	●	7	6	3.5	100	12	5.75	-	0°	-12°					
E07H-SWUBR/L03-D080	●	●	8	7	4	100	14	6.75			-11°					

When using a right or left hand insert, the right hand insert (R) is used for the left hand toolholder (SWUBL □□ type), and the left hand insert (L) is used for the right hand toolholder (SWUBR □□ type).

SEZPR/L

Internal retracting

S-type (Positive, screw-on)



Steel shank

Right hand (R) shown

Toolholder Cat. No.	Stock		Min bore dia. ϕD_m	Dimensions (mm)							Std. corner radius $r\epsilon$	Applicable inserts	Parts		Torque (N·m)	
	R	L		ϕD_s	f	L_1	L_2	h	f_2	θ			α	Clamping screw		Wrench
A04F-SEZPR/L03-D055	●	●	5.5	4	3.2	80	4	3.8			-8°	0.2	EP□□03X1	CSTA-1.6	T-6F	0.6
A05F-SEZPR/L03-D065	●	●	6.5	5	3.7	80	5	4.8	1.2	0°	-6°					

Carbide shank

Toolholder Cat. No.	Stock		Min bore dia. ϕD_m	Dimensions (mm)							Std. corner radius $r\epsilon$	Applicable inserts	Parts		Torque (N·m)	
	R	L		ϕD_s	f	L_1	L_2	h	f_2	θ			α	Clamping screw		Wrench
E04G-SEZPR/L03-D055	●	●	5.5	4	3.2	90	5	3.8			-8°	0.2	EP□□03X1	CSTA-1.6	T-6F	0.6
E05G-SEZPR/L03-D065	●	●	6.5	5	3.7	90	6	4.8	1.2	0°	-6°					

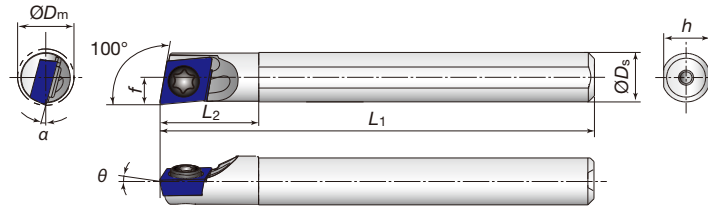
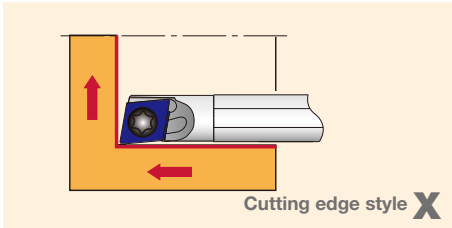
When using a right or left hand insert, the right hand insert (R) is used for the right hand toolholder (SEZPR □□ type), and the left hand insert (L) is used for the left hand toolholder (SEZPL □□ type).

● : Stocked in Japan

SEXPR/L

Boring & internal facing

S-type (Positive, screw-on)



Right hand (R) shown

Steel shank

Toolholder Cat. No.	Stock		Min. bore dia. ϕD_m	Dimensions (mm)							Std. corner radius $r\epsilon$	Applicable inserts	Parts		Torque (N-m)	
	R	L		ϕD_s	f	L_1	L_2	h	f_2	θ			a	Clamping screw		Wrench
A04F-SEXPR/L03-D045	●	●	4.5	4	2.3	80	8	3.8	-	0°	-15°	0.2	EP□□03X1	CSTA-1.6	T-6F	0.6
A04F-SEXPR/L03-D050	●	●	5	4	2.5	80	8	3.8	-	0°	-13°					
A05F-SEXPR/L04-D055	●	●	5.5	5	2.75	80	9	4.8	-	0°	-12°	0.4	EP□□0401	CSTB-2	T-6F	0.6
A06G-SEXPR/L04-D070	●	●	7	6	3.6	90	11	5.75	-	0°	-12°					

Carbide shank

Toolholder Cat. No.	Stock		Min. bore dia. ϕD_m	Dimensions (mm)							Std. corner radius $r\epsilon$	Applicable inserts	Parts		Torque (N-m)	
	R	L		ϕD_s	f	L_1	L_2	h	f_2	θ			a	Clamping screw		Wrench
E04G-SEXPR/L03-D045	●	●	4.5	4	2.3	90	9	3.8	-	0°	-15°	0.2	EP□□03X1	CSTA-1.6	T-6F	0.6
E04G-SEXPR/L03-D050	●	●	5	4	2.5	90	9	3.8	-	0°	-13°					
E05G-SEXPR/L04-D055	●	●	5.5	5	2.75	90	10	4.8	-	0°	-12°	0.4	EP□□0401	CSTB-2	T-6F	0.6
E06H-SEXPR/L04-D070	●	●	7	6	3.6	100	12	5.75	-	0°	-12°					

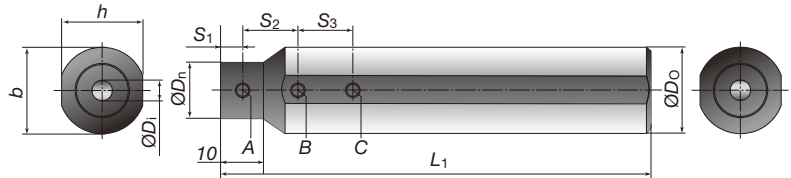
When using a right or left hand insert, the right hand insert (R) is used for the left hand toolholder (SEXPL □□ type), and the left hand insert (L) is used for the right hand toolholder (SEXPR □□ type).

● : Stocked in Japan

Sleeves

BLM type

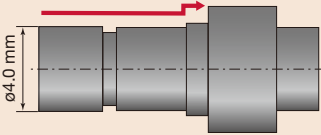
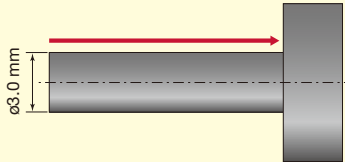




(Round shank for Stream Jet Bar MINI)

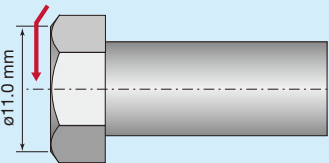








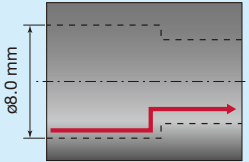
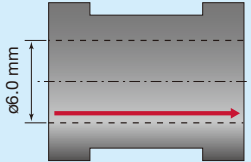




Cat. No.	Stock	Dimensions (mm)									Replacement parts						
		ϕD_o	ϕD_i	ϕD_n	L_1	h	b	S_1	S_2	S_3	Clamping screws			Wrench	Seal cap (Inner screw)		
		A	B	C													
BLM159-04	●	15.875	4	15	100	15	15.875	5	15	15	SSH4-4	SSH4-4	SSH4-4	P-2	CA-16 (M6)		
BLM159-05	●		5						15	15							
BLM159-06	●		6						15	15						20	20
BLM159-07	●		7						15	15						20	20
BLM16-04	●	16	4	15	100	15	16	5	15	15	SSH4-4	SSH4-4	SSH4-4	P-2	CA-16 (M6)		
BLM16-05	●		5						15	15							
BLM16-06	●		6						15	15						20	20
BLM16-07	●		7						15	15						20	20
BLM19-04	●	19.05	4	18	100	18	19.05	5	15	15	SSH4-4	SSH4-6	SSH4-6	P-2	CA-16 (M6)		
BLM19-05	●		5						18	15		SSH4-4	SSH4-4			SSH4-4	
BLM19-06	●		6						18	15		SSH4-4	SSH4-4			SSH4-4	
BLM19-07	●		7						18	15		SSH4-4	SSH4-4			SSH4-4	
BLM20-04	●	20	4	13	100	19	20	5	15	15	SSH4-4	SSH4-6	SSH4-6	P-2	CA-16 (M6)		
BLM20-05	●		5						13	15		SSH4-4	SSH4-6			SSH4-6	
BLM20-06	●		6						13	15		SSH4-4	SSH4-4			SSH4-4	
BLM20-07	●		7						13	15		SSH4-4	SSH4-4			SSH4-4	
BLM22-04	●	22	4	13	125	21	22	5	15	15	SSH4-4	SSH4-6	SSH4-6	P-2	CA-16 (M6)		
BLM22-05	●		5						13	15		SSH4-4	SSH4-6			SSH4-6	
BLM22-06	●		6						13	15		SSH4-4	SSH4-6			SSH4-6	
BLM22-07	●		7						13	15		SSH4-4	SSH4-6			SSH4-6	
BLM25-04	●	25	4	13	125	24	25	5	15	15	SSH4-4	SSH4-8	SSH4-8	P-2	CA-16 (M6)		
BLM25-05	●		5						13	15		SSH4-4	SSH4-8			SSH4-8	
BLM25-06	●		6						13	15		SSH4-4	SSH4-6			SSH4-6	
BLM25-07	●		7						13	15		SSH4-4	SSH4-6			SSH4-6	
BLM254-04	●	25.4	4	13	125	24	25.4	5	15	15	SSH4-4	SSH4-8	SSH4-8	P-2	CA-16 (M6)		
BLM254-05	●		5						13	15		SSH4-4	SSH4-8			SSH4-8	
BLM254-06	●		6						13	15		SSH4-4	SSH4-6			SSH4-6	
BLM254-07	●		7						13	15		SSH4-4	SSH4-6			SSH4-6	

*Seal cap (optional)

Practical Examples

Name of workpiece		Medical parts	Machine component
Toolholder		JTDJ2CR1010K07	JTDJ2CR1212M11
Insert		DCGT070201FN-JS	DCGT11T301FN-JS
Grade		SH730	SH730
Workpiece material		Titanium alloy / Ti-6Al-4V	Stainless steel / SUS304
			
Cutting conditions	Cutting speed: V_c (m/min)	30	20
	Feed: f (mm/rev)	0.2	0.03
	Depth of cut: a_p (mm)	0.75	2.5
	Method of machining	External turning	External turning
	Coolant	Oil	Oil
	Machine	CNC lathes	CNC lathes
Results		<ul style="list-style-type: none"> Number of parts/corner <p>25% tool life improvement!</p> <p>JS type (SH730)  200 pcs.</p> <p>Current insert  150 pcs.</p> <p>- Excellent surface finish and chip control.</p>	<ul style="list-style-type: none"> Tool failure after machining <p>Current insert</p> <p> 200 pcs / corner</p> <p> 150 ~ 200 pcs / corner</p> <p>- Stable tool life! - Excellent chipping and wear resistance</p>

Name of workpiece		Automotive component	Electrical Components
Toolholder		JTDJ2CR1212M11	JSDJ2CR1212K07
Insert		DCGT11T302N-JS	DCET070201MFR-JRP
Grade		AH725	SH730
Workpiece material		Alloy steels	Stainless steel SUS420
			
Cutting conditions	Cutting speed: V_c (m/min)	100	40 ~ 60
	Feed: f (mm/rev)	0.1	0.01
	Depth of cut: a_p (mm)	0.3	0.05
	Method of machining	Facing	External turning and facing
	Coolant	Oil	Oil
	Machine	CNC lathes	CNC lathes
Results		<ul style="list-style-type: none"> Tool failure after machining 1000 pcs / corner <p>JS type (AH725)  Current insert </p> <p>Chip shapes of JS </p> <p>- Excellent chip control - Good wear resistance</p>	<ul style="list-style-type: none"> Number of parts/corner <p>100% tool life improvement!</p> <p>JRP type (SH730)  4000 pcs.</p> <p>Current insert  2000 pcs.</p> <p>- Improved wear resistance - Reduced down-time</p>

Name of workpiece		Micro bearing	Machine component
Toolholder		A05F-SWUBR03-D060	A04F-SEXP03-D050
Insert		WBGT030102L-JS	EPGT03X102-JS
Grade		SH730	SH730
Workpiece material		Carbon steel (JIS S45C)	Alloy Steel (JIS SCM435)
			
Cutting conditions	Cutting speed: V_c (m/min)	30	60
	Feed: f (mm/rev)	0.05	0.03
	Depth of cut: a_p (mm)	0.3	0.2
	Method of machining	Internal turning (continuous)	Internal turning (continuous)
	Coolant	Water soluble	Water soluble
Machine		CNC lathes	CNC lathes
Results		<p>■ Number of work piece</p> <p>100% tool life improvement!</p> <p>JS type  1,000 pcs.</p> <p>competitor  500 pcs.</p> <p>- Tool life and chip control were improved drastically.</p>	<p>■ Number of pieces</p> <p>130% tool life improvement!</p> <p>JS type  230 pcs.</p> <p>competitor  100 pcs.</p> <p>- Chip control and surface finish were improved.</p>



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