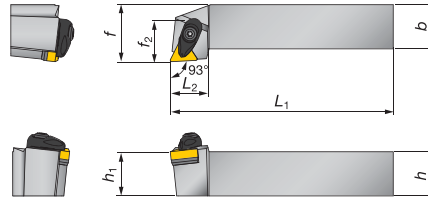
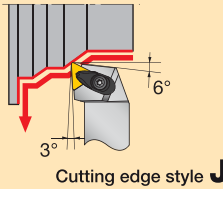


Turning • External Profiling



Right hand (R) shown.

Toolholders Cat. No.	Stock		Dimensions (mm)						Std. Corner r_ϵ	Applicable inserts	Page	
	R	L	h	b	L_1	L_2	h_1	f				f_2
ATJNR/L2020K16-A	●	●	20	20	125	22	20	25	23	0.8	TN□□1604□□	2-70 ~ 3-8 ~ T-CBN 3-21 ~ T-DIA
ATJNR/L2525M16-A	●	●	25	25	150	22	25	32	25			

*Recommend clamping torque: 3.0 N·m

4

TAC External Toolholders

Basic Selection Chipbreakers TN□□1604□□-□□

 	Operation	Precision finishing	Finishing	Finishing to medium cutting	Medium cutting
	Grade	NS730	GT730	T9115	T9115
	Page	2-70	2-71	2-74	2-77
	Chipbreaker				
	V_c (m/min)	200 (150-250)	200 (150-300)	200 (150-300)	220 (150-300)
	a_p (mm)	0.3 (0.05-0.5)	1.0 (0.3-1.5)	3.0 (1.0-5.0)	4.0 (3.0-6.0)
f (mm/rev)	0.1 (0.03-0.15)	0.15 (0.08-0.3)	0.3 (0.2-0.5)	0.3 (0.2-0.5)	
r_ϵ (mm)	0.4	0.4	0.8	1.2	

 	Operation	Finishing	Finishing to medium cutting	Medium cutting
	Grade	T6020	T6030	T6030
	Page	2-71	2-74	2-77
	Chipbreaker			
	V_c (m/min)	150 (100-200)	120 (70-150)	120 (70-150)
	a_p (mm)	1.0 (0.5-3.0)	2.0 (0.5-4.0)	3.0 (3.0-6.0)
f (mm/rev)	0.1 (0.03-0.15)	0.3 (0.2-0.4)	0.3 (0.2-0.3)	
r_ϵ (mm)	0.4	0.8	1.6	

 	Operation	Precision finishing	Finishing	Finishing to medium cutting	Medium cutting
	Grade	BX930	T5115	T5115	T5115
	Page	3-8	2-72	2-75	2-77
	Chipbreaker				
	V_c (m/min)	700 (300-1200)	270 (140-400)	270 (150-400)	270 (140-400)
	a_p (mm)	0.3 (0.05-0.5)	1.0 (0.5-2.0)	2.0 (1.0-5.0)	4.0 (2.0-6.0)
f (mm/rev)	0.1 (0.05-0.2)	0.15 (0.05-0.2)	0.3 (0.15-0.4)	0.4 (0.2-0.6)	
r_ϵ (mm)	0.4	0.4	0.8	1.2	

 	Operation	Precision finishing	Finishing	Finishing to medium cutting
	Grade	DX120	GH110	GH110
	Page	3-21	2-70	2-77
	Chipbreaker			
	V_c (m/min)	1500 (500-2500)	600 (100-1000)	600 (100-1000)
	a_p (mm)	0.5 (0.05-1.0)	0.5 (0.05-1.0)	2.0 (0.5-4.0)
f (mm/rev)	0.1 (0.05-0.2)	0.1 (0.03-0.15)	3.0 (0.2-0.5)	
r_ϵ (mm)	0.4	0.4	0.8	

 	Operation	Precision finishing	Finishing	Finishing to medium cutting	Medium cutting
	Grade	BX470	KS20	AH905	AH120
	Page	3-8	2-71	2-75	2-76
	Chipbreaker				
	V_c (m/min)	200 (100-280)	50 (30-70)	50 (20-100)	50 (20-80)
	a_p (mm)	0.3 (0.1-0.5)	1.0 (0.5-3.0)	1.5 (0.5-3.0)	2.0 (1.0-4.0)
f (mm/rev)	0.1 (0.05-0.2)	0.1 (0.03-0.15)	0.2 (0.1-0.3)	0.3 (0.2-0.5)	
r_ϵ (mm)	0.4	0.4	0.8	0.8	

 	Operation	Precision finishing	Finishing
	Grade	BXM10	BXM20
	Page	3-8	3-8
	Chipbreaker		
	V_c (m/min)	200 (150-350)	150 (70-220)
	a_p (mm)	0.1 (0.05-0.30)	0.2 (0.05-0.30)
f (mm/rev)	0.1 (0.03-0.18)	0.1 (0.05-0.25)	
r_ϵ (mm)	0.4	0.4	

For other machining types, see "Selection System"



● : Stocked items.