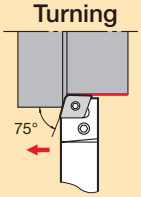
P-type

PCBNR/L

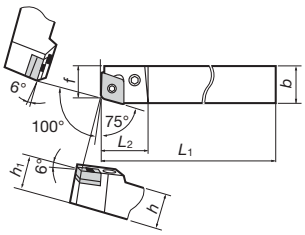
Applicable inserts
CN□□

Negative rake
Lever-lock system

Turning



Cutting edge style **B**



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			
PCBNR/L2020K12E	●	●	20	20	125	28	20	17	–	0.8	CN□□1204□□	2-42 ~
PCBNR/L2525M12E	●	●	25	25	150	28	25	22	–			
PCBNR/L2525M16E	●		25	25	150	35	25	22	–	1.2	CN□□1606□□	2-45 ~
PCBNR/L3225P16E			32	25	170	35	32	22	–			
PCBNR/L3232P16E			32	32	170	35	32	27	–			
PCBNR/L3232P19E	●		32	32	170	40	32	27	–	1.2	CN□□1906□□	2-45 ~

*100° corners are used.

● : Stocked items.

Basic Selection Chipbreakers CN□□1204□□-□□

P Steel — Continuous

Operation	Precision finishing	Finishing	Finishing to medium cutting	Medium cutting
Grade	**NS730**	**GT730**	**T9115**	**T9115**
Page	2-42	2-42	2-45	2-49
Chipbreaker	**TF**	**TSF**	**TM**	**TH**
Vc (m/min)	**200** (150-250)	**200** (150-300)	**220** (150-300)	**220** (150-300)
ap (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** (0.2-0.6)
rε (mm)	0.4	0.4	0.8	1.2

M Stainless — Continuous

Operation	Finishing	Finishing to medium cutting	Medium cutting
Grade	**T6020**	**T6030**	**T6030**
Page	2-43	2-45	2-49
Chipbreaker	**SS**	**SM**	**TH**
Vc (m/min)	**150** (100-200)	**120** (70-150)	**120** (70-150)
ap (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** (0.2-0.5)	**0.3** (0.2-0.5)
rε (mm)	0.4	0.8	1.6

K Cast Iron — Continuous

Operation	Precision finishing	Finishing	Finishing to medium cutting	Medium cutting
Grade	**BX930**	**T5115**	**T5115**	**T5115**
Page	3-7	2-43	2-46	2-48
Chipbreaker	**T-CBN**	**CF**	**CM**	**CH**
Vc (m/min)	**700** (300-1200)	**270** (140-400)	**270** (150-400)	**270** (140-400)
ap (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)
rε (mm)	0.4	0.4	0.8	1.2

N Non-ferrous — Continuous

Operation	Precision finishing	Finishing	Finishing to medium cutting
Grade	**DX120**	**TH10**	**GH110**
Page	3-21	2-42	2-48
Chipbreaker	**T-DIA** With chipbreaker	**01**	**P**
Vc (m/min)	**1500** (500-2500)	**600** (100-1000)	**600** (100-1000)
ap (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)	**0.3** (0.2-0.5)
rε (mm)	0.4	0.4	0.8

S Superalloys — Continuous

Operation	Precision finishing	Finishing to medium cutting	Medium cutting
Grade	**BX470**	**AH905**	**AH120**
Page	3-7	2-47	2-48
Chipbreaker	**T-CBN**	**HMM**	**SA**
Vc (m/min)	**200** (100-280)	**50** (20-100)	**50** (20-80)
ap (mm)	**0.3** (0.1-0.5)	**1.5** (0.5-3.0)	**2.0** (1.0-4.0)
f (mm/rev)	**0.1** (0.05-0.2)	**0.2** (0.1-0.3)	**0.3** (0.2-0.5)
rε (mm)	0.4	0.8	0.8

H Hard Materials — Continuous

Operation	Precision finishing	Finishing
Grade	**BXM10**	**BXM20**
Page	3-7	3-7
Chipbreaker	**T-CBN**	**T-CBN**
Vc (m/min)	**200** (150-350)	**150** (70-220)
ap (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)
rε (mm)	0.4	0.4

For other machining types, see “Selection System” 2-4 ~

Relating pages
Parts (14–1~)