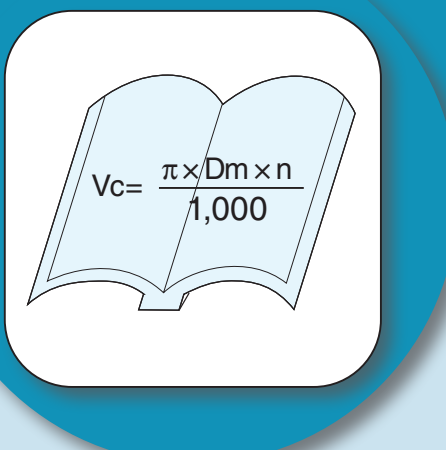


Technical Information

R1~R44


$$V_c = \frac{\pi \times D_m \times n}{1,000}$$

R

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SI Unit Conversion Table / Cutting Symbol

SI Derived Units Conversion Chart

(Bold lined units are the ones by SI Derived Unit.)

(Extracted from JIS Handbook "Iron & Steel")

● Force

N	kgf	dyn
1	$1.019\ 72 \times 10^{-1}$	1×10^5
9.806 65	1	$9.806\ 65 \times 10^5$
1×10^{-5}	$1.019\ 72 \times 10^{-6}$	1

● Stress

1Pa=1N/m², 1MPa=1N/mm²

Pa or N/m ²	MPa or N/mm ²	kgf/mm ²	kgf/cm ²	kgf/m ²
1	1×10^{-6}	$1.019\ 72 \times 10^{-7}$	$1.019\ 72 \times 10^{-5}$	$1.019\ 72 \times 10^{-1}$
1×10^6	1	$1.019\ 72 \times 10^{-1}$	$1.019\ 72 \times 10$	$1.019\ 72 \times 10^5$
$9.806\ 65 \times 10^6$	9.806 65	1	1×10^2	1×10^6
$9.806\ 65 \times 10^4$	$9.806\ 65 \times 10^{-2}$	1×10^{-2}	1	1×10^4
9.806 65	$9.806\ 65 \times 10^{-6}$	1×10^{-6}	1×10^{-4}	1

● Pressure

1Pa=1N/m²

Pa	kPa	MPa	bar	kgf/cm ²
1	1×10^{-3}	1×10^{-6}	1×10^{-5}	$1.019\ 72 \times 10^{-5}$
1×10^3	1	1×10^{-3}	1×10^{-2}	$1.019\ 72 \times 10^{-2}$
1×10^6	1×10^3	1	1×10	$1.019\ 72 \times 10$
1×10^5	1×10^2	1×10^{-1}	1	1.019 72
$9.806\ 65 \times 10^4$	$9.806\ 65 \times 10$	$9.806\ 65 \times 10^{-2}$	$9.806\ 65 \times 10^{-1}$	1

Cutting Symbol

● Cutting conditions below are indicated by the new symbols listed in 2nd column.

1) Turning

Cutting Conditions	Symbol	(Previous Symbol)	Unit
Cutting Speed	Vc	V	m/min
Feed Rate	f	f	mm/rev
Depth of Cut	ap	d	mm
Edge Width	W	W	mm
Workpiece Dia.	Dm	D	mm
Required Power	Pc	Pkw	kW
Specific Cutting Force	kc	Ks	MPa
Theoretical Surface Roughness	h	Rz	μm
Corner Radius	re	R	mm
Revolution	n	N	min ⁻¹

Note: 're' is read as 'r epsilon'

3) Drilling

Cutting Conditions	Symbol	(Previous Symbol)	Unit
Cutting Speed	Vc	V	m/min
Feed Speed	Vf	F	mm/min
Feed Rate	f	f	mm/rev
Drill Dia.	Dc	D (Ds)	mm
Required Power	Pc	Pkw	kW
Specific Cutting Force	kc	Ks	MPa
Drilling Depth	H	d	mm
Revolution	n	N	min ⁻¹

2) Milling

Cutting Conditions	Symbol	(Previous Symbol)	Unit
Cutting Speed	Vc	V	m/min
Feed Speed	Vf	F	mm/min
Feed per tooth	fz	f	mm/t
Feed Rate	f	f	mm/rev
No. of Inserts	Z	Z	teeth
Depth of Cut	ap	d	mm
Width of Cut	ae	w	mm
Pick feed	Pf	Pf	mm
Required Power	Pc	Pkw	kW
Specific Cutting Force	kc	Ks	MPa
Chip Removal Volume	Q	Q	cm ³ /min
Revolution	n	N	min ⁻¹

R



Technical
Information

Surface Roughness (JIS B 0601-2001)

Theoretical (Geometrical) Surface Roughness

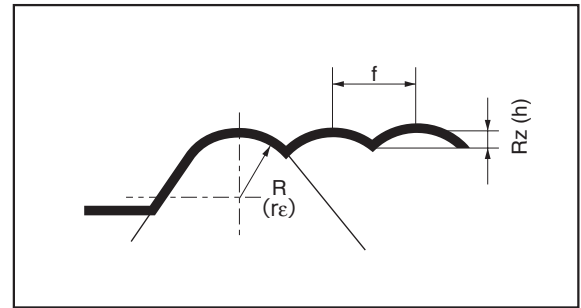
Theoretical surface roughness for turning indicates the minimum roughness value from the cutting conditions and it is shown by the formula as follows.

$$Rz(h) = \frac{f^2}{8R(r\epsilon)} \times 10^3$$

Rz(h): Theoretical Surface Roughness [μm]

f: Feed Rate [mm/rev]

R(r ϵ): Corner Radius of Insert [mm]



How to Obtain Surface Roughness Values

Type	Symbol	How to Obtain	Explanation
Max. Height Roughness	Rz	Rz is a mean value in micron meter obtained from the distance of the highest peaks and the lowest valleys within the range of sampled reference length ("l") in the direction of the center line of the roughness curve. Note) When calculating Rz, extraordinarily high or low threads are considered as damages and excluded from the calculation, and only standard lengths are used. $Rz = Rp + Rv$	
Ten Points Mean Roughness	RzJIS	RzJIS is a mean value in micron meter obtained from the distance of 5 highest peaks (Yp) and the 5 lowest valleys (Yv) measured from the center line of the roughness curve within the range of sampled reference length "l". $RzJIS = \frac{(Yp1 + Yp2 + Yp3 + Yp4 + Yp5) + (Yv1 + Yv2 + Yv3 + Yv4 + Yv5)}{5}$	 Yp1, Yp2, Yp3, Yp4, Yp5: Distance from the mean line to the highest 5 peaks in the range of sampled reference length "l" Yv1, Yv2, Yv3, Yv4, Yv5: Distance from the mean line to the lowest 5 valleys in the range of sampled reference length "l"
Arithmetical Mean Roughness	Ra	Ra is obtained from the following formula in micron meter, the roughness curve is expressed by $y=f(x)$, the X-axis is in the direction of the center line and the Y-axis is the vertical magnification of the roughness curve in the range of sampled reference length "l". $Ra = \frac{1}{l} \int_0^l f(x) dx$	

Relationship with Triangle Symbol

Arithmetical Mean Roughness Ra (μm)	Max. Height Roughness Rz (μm)	Ten Points Mean Roughness RzJIS (μm)	* (Triangle Symbol)
0.025	0.1	0.1	▽▽▽▽
0.05	0.2	0.2	
0.1	0.4	0.4	
0.2	0.8	0.8	
0.4	1.6	1.6	▽▽▽
0.8	3.2	3.2	
1.6	6.3	6.3	
3.2	12.5	12.5	▽▽
6.3	25	25	
12.5	50	50	▽
25	100	100	

* Finishing symbol (Triangle ▽ and wave-) was removed from JIS standard in the 1994 Revision.

How to Indicate

- (1) When Ra is 1.6 μm → 1.6 μm Ra
- (2) When Rz is 6.3 μm → 6.3 μm Rz
- (3) When RzJIS is 6.3 μm → 6.3 μm RzJIS

Indication in JIS Standard

Example of Ra Indication		Example of Rz Indication	
(1) When indicating the upper limit only (when upper limit is 6.3 μm Ra)		(1) When indicating the upper limit only indicate surface roughness following the parameter symbol.	
(2) When indicating both lower and upper limit (when upper limit is 6.3 μm Ra, lower limit is 1.6 μm Ra)		(2) When indicating both lower and upper limit indicate surface roughness as (upper limit ~ lower limit) following the parameter symbol.	

Note: The indications of Ra and Rz are different.

Caution-Symbols for Surface Roughness

The above information is based on JIS B 0601-2001.

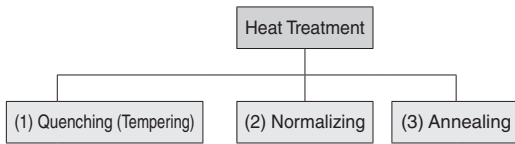
However, some symbols were revised as shown in the right table in accordance with ISO Standard from JIS B 0601-2001 version.

Ten Points Mean Roughness (Rz) was eliminated from 2001 version but it still remains as RzJIS reference, since it was popular in Japan.

Type	Symbol of JIS B 0601-1994	Symbol of JIS B 0601-2001
Max. Height Roughness	Ry	Rz
Ten Points Mean Roughness	Rz	(RzJIS)
Arithmetical Mean Roughness	Ra	Ra

Heat Treatment

One of the ways to determine the hardness of steel is the heat treatment and it is classified to 3 types.



Heat Treatment Method	Detail	Effect
	-Quenching (Tempering) After heating to over 727°C , cool rapidly down to 550°C in water or oil.	Quenching makes steel hard because it cools down red-hot steel very rapidly in water or oil, but it may promote internal stress. In order to remove such internal stress, tempering is used. (After cooled down once, reheat it to 200°C~600°C)
	-Normalizing After heating to over 727°C , cool down rapidly to 600°C and then to normal temperature.	It miniaturizes the crystals. (Steel is also composed of small cells.) It is used to improve the mechanical character or machinability.
	-Annealing After heating to over 727°C , cool down very slowly to 600°C , then to normal temperature.	It miniaturizes the crystals like the process of normalizing, but the crystal size is bigger than that of normalizing. It targets machinability improvement and distortion correction.

Hardness Expression

Hardness	Reference Standard	Example	Explanation of Example
Brinell Hardness	JIS Z 2243:1992	250HB	Hardness Value :250, Hardness Symbol : HB
		200~250HB	When the hardness has the range
Vickers Hardness	JIS Z 2244:1998	640HV	Hardness Value :640, Hardness Symbol : HV
Rockwell Hardness	JIS Z 2245:1992	60HRC	Hardness Value :60, Hardness Symbol : HRC
Shore Hardness	JIS Z 2246:1992	50HS	Hardness Value :50, Hardness Symbol : HS

Vickers Hardness Conversion Chart

Vickers Hardness (HV)	Brinell Hardness 10mm Dia. Ball Load: 3,000kgf (HB)		Rockwell Hardness ²⁾			Shore Hardness (HS)	Tensile Strength MPa ⁽¹⁾
	Standard Ball	Tungsten Carbide Ball	A Scale Load: 60kgf Diamond Point (HRA)	B Scale Load: 100kgf 1.6mm (1/16in) ball (HRB)	C Scale Load: 150kgf Diamond Point (HRC)		
940	-	-	85.6	-	68.0	97	
920	-	-	85.3	-	67.5	96	
900	-	-	85.0	-	67.0	95	
880	-	(767)	84.7	-	66.4	93	
860	-	(757)	84.4	-	65.9	92	
840	-	(745)	84.1	-	65.3	91	
820	-	(733)	83.8	-	64.7	90	
800	-	(722)	83.4	-	64.0	88	
780	-	(710)	83.0	-	63.3	87	
760	-	(698)	82.6	-	62.5	86	
740	-	(684)	82.2	-	61.8	84	
720	-	(670)	81.8	-	61.0	83	
700	-	(656)	81.3	-	60.1	81	
690	-	(647)	81.1	-	59.7	-	
680	-	(638)	80.8	-	59.2	80	
670	-	630	80.6	-	58.8	-	
660	-	620	80.3	-	58.3	79	
650	-	611	80.0	-	57.8	-	
640	-	601	79.8	-	57.3	77	
630	-	591	79.5	-	56.8	-	
620	-	582	79.2	-	56.3	75	
610	-	573	78.9	-	55.7	-	
600	-	564	78.6	-	55.2	74	
590	-	554	78.4	-	54.7	-	2055
580	-	545	78.0	-	54.1	72	2020
570	-	535	77.8	-	53.6	-	1985
560	-	525	77.4	-	53.0	71	1950
550	505	517	77.0	-	52.3	-	1905
540	496	507	76.7	-	51.7	69	1860
530	488	497	76.4	-	51.1	-	1825
520	480	488	76.1	-	50.5	67	1795
510	473	479	75.7	-	49.8	-	1750
500	465	471	75.3	-	49.1	66	1705
490	456	460	74.9	-	48.4	-	1660
480	448	452	74.5	-	47.7	64	1620
470	441	442	74.1	-	46.9	-	1570
460	433	433	73.6	-	46.1	62	1530
450	425	425	73.3	-	45.3	-	1495
440	415	415	72.8	-	44.5	59	1460
430	405	405	72.3	-	43.6	-	1410
420	397	397	71.8	-	42.7	57	1370
410	388	388	71.4	-	41.8	-	1330
400	379	379	70.8	-	40.8	55	1290
390	369	369	70.3	-	39.8	-	1240
380	360	360	69.8	(110.0)	38.8	52	1205
370	350	350	69.2	-	37.7	-	1170
360	341	341	68.7	(109.0)	36.6	50	1130
350	331	331	68.1	-	35.5	-	1095
340	322	322	67.6	(108.0)	34.4	47	1070
330	313	313	67.0	-	33.3	-	1035

Vickers Hardness (HV)	Brinell Hardness 10mm Dia. Ball Load: 3,000kgf (HB)		Rockwell Hardness ²⁾			Shore Hardness (HS)	Tensile Strength MPa ⁽¹⁾
	Standard Ball	Tungsten Carbide Ball	A Scale Load: 60kgf Diamond Point (HRA)	B Scale Load: 100kgf 1.6mm (1/16in) ball (HRB)	C Scale Load: 150kgf Diamond Point (HRC)		
320	303	303	66.4	(107.0)	32.2	45	1005
310	294	294	65.8	-	31.0	-	980
300	284	284	65.2	(105.5)	29.8	42	950
295	280	280	64.8	-	29.2	-	935
290	275	275	64.5	(104.5)	28.5	41	915
285	270	270	64.2	-	27.8	-	905
280	265	265	63.8	(103.5)	27.1	40	890
275	261	261	63.5	-	26.4	-	875
270	256	256	63.1	(102.0)	25.6	38	855
265	252	252	62.7	-	24.8	-	840
260	247	247	62.4	(101.0)	24.0	37	825
255	243	243	62.0	-	23.1	-	805
250	238	238	61.6	99.5	22.2	36	795
245	233	233	61.2	-	21.3	-	780
240	228	228	60.7	98.1	20.3	34	765
230	219	219	-	96.7	(18.0)	33	730
220	209	209	-	95.0	(15.7)	32	695
210	200	200	-	93.4	(13.4)	30	670
200	190	190	-	91.5	(11.0)	29	635
190	181	181	-	89.5	(8.5)	28	605
180	171	171	-	87.1	(6.0)	26	580
170	162	162	-	85.0	(3.0)	25	545
160	152	152	-	81.7	(0.0)	24	515
150	143	143	-	78.7	-	22	490
140	133	133	-	75.0	-	21	455
130	124	124	-	71.2	-	20	425
120	114	114	-	66.7	-	-	390
110	105	105	-	62.3	-	-	-
100	95	95	-	56.2	-	-	-
95	90	90	-	52.0	-	-	-
90	86	86	-	48.0	-	-	-
85	81	81	-	41.0	-	-	-

Extracted from JIS Handbook Iron & Steel (SAE J 417)

Note 1) 1MPa = 1N/mm²

2) Value in () is not in practical use, but reference only.

R



Technical Information

Material List (JIS)

Ferrous Materials

Classification	Name of JIS Standard	Symbol	
Structural Steel	Rolled Steel for Welded Structure	SM	
	Re-Rolled Steel	SRB	
	Rolled Steel for General Structure	SS	
	Light Gauge Steel for General Structure	SSC	
	Hot-Rolled Steel Plate, Sheet and Strip for Automobile Structural Use	SAPH	
Steel Sheet	Cold-Rolled Steel Plate, Sheet and Strip	SPC	
	Hot-Rolled Soft Steel Plate, Sheet and Strip	SPH	
Steel Pipe	Carbon Steel Pipe for Ordinary Piping	SGP	
	Carbon Steel Pipe for Boiler / Heat Exchanger	STB	
	Seamless Steel Pipe for High Pressure Gas Cylinder	STH	
	Carbon Steel Pipe for General Structural Use	STK	
	Carbon Steel Pipe for Machine Structural Use	STKM	
	Alloy Steel Pipe for Structural Use	STKS	
	Stainless Steel Pipe for Machine Structural Use	SUS-TK	
	Steel Square Pipe for General Structural Use	STKR	
	Alloy Steel Pipe for Ordinary Piping	STPA	
	Carbon Steel Pipe for Pressure Service	STPG	
	Carbon Steel Pipe for High-Temperature Service	STPT	
	Carbon Steel Pipe for High-Pressure Service	STS	
	Stainless Steel Pipe for Ordinary Piping	SUS-TP	
	Machine Structural Steel	Carbon Steel for Machine Structural Use	SxxC,SxxCK
		Aluminium Chromium Molybdenum Steel	SACM
Chromium Molybdenum Steel		SCM	
Chromium Steel		SCr	
Nickel Chromium Steel		SNC	
Nickel Chromium Molybdenum Steel		SNCM	
Manganese Steel and Manganese Chromium Steel for Machine Structural Use		SMn,SMnC	
Special Steel	Tool Steel	Carbon Tool Steel	SK
		Hollow Drill Steel	SKC
		Alloy Tool Steel	SKS,SKD,SKT
		High Speed Tool Steel	SKH
		Free Cutting Carbon Steel	SUM
	Special Steel	High Carbon Chromium Bearing Steel	SUJ
		Spring Steel	SUP
		Stainless Steel Bar	SUS-B
	Stainless Steel	Hot-Rolled Stainless Steel Plate, Sheet and Strip	SUS-HP,SUS-HS
		Cold-Rolled Stainless Steel Plate, Sheet and Strip	SUS-CP,SUS-CS
		Heat-Resisting Steel Bar	SUH-B,SUH-CB
	Heat-Resisting Steel	Heat-Resisting Steel Plate and Sheet	SUH-HP,SUH-CP
		Superalloy	Corrosion-Resisting and Heat-Resisting Superalloy Bar
	Corrosion-Resisting and Heat-Resisting Superalloy Plate and Sheet		NCF-P
	Forged Steel	Carbon Steel Forging	SF
Chromium Molybdenum Steel Forging		SFCM	
Nickel Chromium Molybdenum Steel Forging		SFNCM	
Cast Iron	Gray Cast Iron	FC	
	Spheroidal Graphite Cast Iron	FCD	
	Blackheart Malleable Cast Iron	FCMB	
	Whiteheart Malleable Cast Iron	FCMW	
	Pearlitic Malleable Cast Iron	FCMP	
Cast Steel	Carbon Cast Steel	SC	
	High Tensile Strength Carbon Cast Steel & Low Alloy Cast Steel	SCC	
	Stainless Cast Steel	SCS	
	Heat-Resisting Cast Steel	SCH	
	High Manganese Cast Steel	SCMnH	
	Cast Steel for High Temperature and High Pressure Service	SCPH	

Non-ferrous Metals

Classification	Name of JIS Standard	Symbol
Copper	Copper and Copper Alloy Sheet / Strip	CxxxxP CxxxxPP CxxxxR
	Copper and Copper Alloy Rod and Bar	CxxxxBD CxxxxBDS CxxxxBE
Aluminum Alloys and Aluminum Alloys Expanded Material	Aluminum and Al. Alloy Sheet / Strip	AxxxxP AxxxxPC
	Aluminum and Al. Alloy Rod, Bar, and Wire	AxxxxBE AxxxxBES AxxxxBD AxxxxBDS AxxxxW AxxxxWS
	Aluminum and Al. Alloy Extruded Shape	AxxxxS
	Aluminum and Al. Alloy Forging	AxxxxFD AxxxxFH
Magnesium Alloy Expanded Material	Magnesium Alloy Sheet and Plate	MP
	Magnesium Alloy Rod and Bar	MB
Nickel Alloy	Nickel Copper Alloy Sheet and Plate	NCuP
	Nickel Copper Alloy Rod and Bar	NCuB
Titanium Expanded Material	Titanium Rod and Bar	TB
Casting	Brass Casting	CAC20x
	High Strength Brass Casting	CAC30x
	Bronze Casting	CAC40x
	Phosphoric Bronze Casting	CAC50x
	Aluminum Bronze Casting	CAC70x
	Aluminum Alloy Casting	AC
	Magnesium Alloy Casting	MC
	Zinc Alloy Die Casting	ZDCx
	Aluminum Alloy Die Casting	ADC
	Magnesium Alloy Die Casting	MD
White Metal	WJ	

R



Technical Information

Material Cross Reference Table

● Steel

Classification	Japan	China	USA	UK	Germany	France	Russia
	JIS	GB	AISI / SAE	BS	DIN	NF	ГОСТ
Carbon Steel for Machine Structural Use	S10C	08 10	1010	040A10 045A10 045M10	C10E C10R	XC10	
	S12C		1012	040A12		XC12	
	S15C	15	1015	055M15	C15E C15R		
	S17C		1017			XC18	
	S20C	20	1020	070M20 C22 C22E C22R	C22 C22E C22R	C22 C22E C22R	
	S22C		1023				
	S25C	25	1025	C25 C25E C22R	C25 C25E C25R	C25 C25E C25R	
	S28C		1029				25Г
	S30C	30	1030	080A30 080M30 C30 C30E C30R	C30 C30E C30R	C30 C30E C30R	30Г
	S33C						30Г
	S35C	35	1035	C35 C35E C35R	C35 C35E C35R	C35 C35E C35R	35Г
	S38C		1038				35Г
	S40C	40	1039 1040	080M40 C40 C40E C40R	C40 C40E C40R	C40 C40E C40R	40Г
	S43C		1042 1043	080A42			40Г
	S45C	45	1045 1046	C45 C45E C45R	C45 C45E C45R	C45 C45E C45R	45Г
	S48C			080A47			45Г
	S50C	50	1049	080M50 C50 C50E C50R	C50 C50E C50R	C50 C50E C50R	50Г
	S53C		1050 1053				50Г
	S55C	55	1055	070M55 C55 C55E C55R	C55 C55E C55R	C55 C55E C55R	
	S58C	60	1059 1060	C60 C60E C60R	C60 C60E C60R	C60 C60E C60R	60Г
	S09CK			045A10 045M10	C10E	XC10	
S15CK	15F			C15E	XC12		
S20CK					XC18		

R



Technical Information

Material Cross Reference Table

● Steel

Classification	Japan	China	USA	UK	Germany	France	Russia
	JIS	GB	AISI / SAE	BS	DIN	NF	ГОСТ
Nickel Chromium Steel	SNC236				36NiCr6		40XH
	SNC415	12CrNi2			14NiCr10		
	SNC631	30CrNi3			36NiCr10		30XH3A
	SNC815	12Cr2Ni4		655M13	15NiCr13		
	SNC836	37CrNi3			31NiCr14		
Nickel Chromium Molybdenum Steel	SNCM220	20CrNiMo	8615	805A20	20NiCrMo2 20NiCrMoS2	20NCD 2	
			8617	805M20			
			8620	805A22			
			8622	805M22			
	SNCM240		8637		40NiCrMo2-2		
			8640				
	SNCM415						
	SNCM420	18CrNiMnMoA	4320		17NiCrMo6-4		20XH2M (20XHM)
	SNCM431				30CrNiMo8		
	SNCM439	40CrNiMoA	4340		40NiCrMo6		
	SNCM447				34CrNiMo6		
SNCM616							
SNCM625							
SNCM630							
SNCM815							
Chromium Steel	SCr415	15Cr			17Cr3		15X
		15CrA			17CrS3		15XA
	SCr420	20Cr	5120				20X
	SCr430	30Cr	5130	34Cr4	34Cr4	34Cr4	30X
			5132	34CrS4	34CrS4	34CrS4	
	SCr435	35Cr	5132	37Cr4	37Cr4	37Cr4	35X
37CrS4				37CrS4	37CrS4		
SCr440	40Cr	5140	530M40	41Cr4	41Cr4	40X	
			41Cr4	41CrS4	41CrS4		
SCr445	45Cr					45X	
	50Cr						
Chromium Molybdenum Steel	SCM415	15CrMo			15CrMo4		
	SCM418	20CrMo			18CrMo4		20XM
					18CrMoS4		
	SCM420			708M20	20CrMo5		20XM
	SCM421						
	SCM430	30CrMo	4130				30XM
		30CrMoA					30XMA
	SCM432						
	SCM435	35CrMo	4137	34CrMo4	34CrMo4	34CrMo4	35XM
34CrMoS4				34CrMoS4	34CrMoS4		
SCM440	42CrMo	4140 4142	708M40	42CrMo4	42CrMo4		
			709M40	42CrMoS4	42CrMoS4		
			42CrMo4	42CrMoS4	42CrMoS4		
SCM445		4145					
		4147					
SCM822							

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Technical Information

● Steel

Classification	Japan	China	USA	UK	Germany	France	Russia
	JIS	GB	AISI / SAE	BS	DIN	NF	ГОСТ
Manganese Steel Manganese Chromium Steel	SMn420	20Mn2	1522	150M19	20Mn5		
	SMn433	30Mn2 35Mn2	1536	150M36	34Mn5		30Г2 35Г2
	SMn438	40Mn2	1541	150M36	36Mn5		35Г2 40Г2
	SMn443	45Mn2	1541				40Г2 45Г2
	SMnC420	15CrMn	5115		16MnCr5		
	SMnC443	40CrMn	5140				
Structural Steel with Specified Hardenability Band	SMn420H		1522H				
	SMn433H						
	SMn438H		1541H				
	SMn443H		1541H				
	SMnC420H						
	SMnC443H						
	SCr415H	15CrH			17Cr3 17CrS3		15X
	SCr420H	20Cr1H	5120H		17Cr3		20X
	SCr430H		5130H 5132H	34Cr4 34CrS4	34Cr4 34CrS3	34Cr4 34CrS4	30X
	SCr435H		5135H	37Cr4 37CrS4	37Cr4 34CrS4	37Cr4 37CrS4	35X
	SCr440H	40CrH	5140H	41Cr4 41CrS4	41Cr4 41CrS4	41Cr4 41CrS4	40X
	SCM415H	15CrMoH	4118H		15CrMo5		
	SCM418H				18CrMo4 18CrMoS4		
	SCM420H	20CrMoH	4118H	708H20	18CrMo4		
	SCM435H		4135H 4137H	34CrMo4 34CrMoS4	34CrMo4 34CrMoS4	34CrMo4 34CrMoS4	
	SCM440H	42CrMoH	4140H 4142H	42CrMo4 42CrMoS4	42CrMo4 42CrMoS4	42CrMo4 42CrMoS4	
	SCM445H		4145H 4147H				
	SCM822H						
	SNC415H						
	SNC631H						
	SNC815H	12Cr2Ni4H			655H13	15NiCr13	
	SNCM220H	20CrNiMoH	8617H 8620H 8622H	805H17 805H20 805H22		21NiCrMo2	20N CD 2
	SNCM420H	20CrNi2MoH	4320H			20NiCrMoS6-4	

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Technical Information

Material Cross Reference Table

● Steel

Classification	Japan	China	USA		UK	Germany	France	Russia
	JIS	GB	UNS	AISI	BS	DIN	NF	ГОСТ
Stainless Steel	SUS 201	1Cr17Mn6Ni5N	S20100	201			Z12CMN17-07Az	
	SUS 202	1Cr18Mn8Ni5N	S20200	202	284S16			12X17Г9АH4
	SUS 301	1Cr18Mn10Ni5Mo3N 1Cr17Ni7	S30100	301	301S21	X12CrNi17 7	Z11CN17-08	07X16H6
	SUS 301L		S30153			X2CrNiN18-7		
	SUS 301J1					X12CrNi17 7		
	SUS 302	1Cr18Ni9	S30200	302	302S25		Z12CN18-09	12X18H9
	SUS 302B		S30215	302B				
	SUS 303	Y1Cr18Ni9	S30300	303	303S21	X10CrNiS18 9	Z8CNF18-09	
	SUS 303Se	Y1Cr18Ni9Se	S30323	303Se	303S41			12X18H10E
	SUS 304	0Cr18Ni9	S30400	304	304S31	X5CrNi 18 10	Z7CN18-09	08X18H10
	SUS 304L	00Cr18Ni10	S30403	304L	304S11	X2CrNi19 11	Z3CN19-11	03X18H11
	SUS 304N1	0Cr18Ni9N	S30451	304N			Z6CN19-09Az	
	SUS 304N2	0Cr19Ni10NbN	S30452					
	SUS 304LN	00Cr18Ni10N	S30453	304LN		X2CrNiN18 10	Z3CN18-10Az	
	SUS 304J1							
	SUS 304J2							
	SUS 304J3		S30431	S30431				
	SUS 305	1Cr18Ni12	S30500	305	305S19	X5CrNi18 12	Z8CN18-12	06X18H11
	SUS 305J1							
	SUS 309S	0Cr23Ni13	S30908	309S			Z10CN24-13	
	SUS 310S	0Cr25Ni20	S31008	310S	310S31		Z8CN25-20	10X23H18
	SUS 316	0Cr17Ni12Mo2	S31600	316	316S31	X5CrNiMo17 12 2	Z7CND17-12-02	
	SUS 316F					X5CrNiMo17 13 3	Z6CND18-12-03	
	SUS 316L	00Cr17Ni14Mo2	S31603	316L	316S11	X2CrNiMo17 13 2	Z3CND17-12-02	
						X2CrNiMo17 14 3	Z3CND17-13-03	03X17H14M3
	SUS 316N	0Cr17Ni12Mo2N	S31651	316N				
	SUS 316LN	00Cr17Ni13Mo2N	S31653	316LN		X2CrNiMoN17 12 2	Z3CND17-11Az	
						X2CrNiMoN17 13 3	Z3CND17-12Az	
	SUS 316Ti		S31635			X6CrNiMoTi17 12 2	Z6CNDT17-12	08X17H13M2T
	SUS 316J1	0Cr18Ni12Mo2Cu2						
	SUS 316J1L	00Cr18Ni14Mo2Cu2						
	SUS 317	0Cr19Ni13Mo3	S31700	317	317S16			
SUS 317L	00Cr19Ni13Mo3	S31703	317L	317S12	X2CrNiMo18 16 4	Z3CND19-15-04		
SUS 317LN		S31753				Z3CND19-14Az		
SUS 317J1	0Cr18Ni16Mo5							
SUS 317J2								
SUS 317J3L								
SUS 836L		N08367						
SUS 890L		N08904	N08904	904S14		Z2NCDU25-20		
SUS 321	1Cr18Ni9Ti 0Cr18Ni10Ti	S32100	321	321S31	X6CrNiTi18 10	Z6CNT18-10	08X18H10T	
SUS 347	0Cr18Ni11Nb	S34700	347	347S31	X6CrNiNb18 10	Z6CNNb18-10	08X18H12b	
SUS 384		S38400	384			Z6CN18-16		
SUS XM7	0Cr18Ni9Cu3	S30430	304Cu	394S17		Z2CNU18-10		
SUS XM15J1	0Cr18Ni13Si4	S38100				Z15CNS20-12		
SUS 329J1	0Cr26Ni5Mo2	S32900	329					
SUS 329J3L		S39240	S31803			Z3CNDU22-05Az	08X21H6M2T	
SUS 329J4L		S39275	S31260			Z3CNDU25-07Az		

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Technical Information

● Steel

Classification	Japan	China	USA		UK	Germany	France	Russia
	JIS	GB	UNS	AISI	BS	DIN	NF	ГОСТ
Stainless Steel	SUS 405	0Cr13Al 0Cr13	S40500	405	405S17	X6CrAl13	Z8CA12	
	SUS 410L	00Cr12					Z3C14	
	SUS 429		S42900	429				
	SUS 430	1Cr17	S43000	430	430S17	X6Cr17	Z8C17	12X17
	SUS 430F	Y1Cr17	S43020	430F		X7CrMoS18	Z8CF17	
	SUS 430LX		S43035			X6CrTi17	Z4CT17	
	SUS 430J1L					X6CrNb17	Z4CNb17	
	SUS 434	1Cr17Mo	S43400	434	434S17	X6CrMo17 1	Z8CD17-01	
	SUS 436L		S43600	436				
	SUS 436J1L							
	SUS 444		S44400	444			Z3CDT18-02	
	SUS 447J1	00Cr30Mo2	S44700					
	SUS XM27	00Cr27Mo	S44627				Z1CD26-01	
	SUS 403	1Cr12	S40300	403				
	SUS 410	1Cr13	S41000	410	410S21	X10Cr13	Z13C13	
	SUS 410S		S41008	410S	403S17	X6Cr13	Z8C12	08X13
	SUS 410F2							
	SUS 410J1	1Cr13Mo 1Cr12Mo	S41025			X12CrS13		
	SUS 416	Y1Cr13	S41600	416	416S21		Z11CF13	
	SUS 420J1	2Cr13	S42000	420	420S29	X20Cr13	Z20C13	20X13
	SUS 420J2	3Cr13	S42000	420	420S37	X30Cr13	Z33C13	30X13
	SUS 420F	Y3Cr13	S42020	420F			Z30CF13	
	SUS 420F2							
SUS 429J1								
SUS 431	1Cr17Ni2	S43100	431	431S29	X20CrNi17 2	Z15CN16-02	20X17H2	
SUS 440A	7Cr17	S44002	440A			Z70C15		
SUS 440B	8Cr17	S44003	440B					
SUS 440C	9Cr18 11Cr17 9Cr18Mo	S44004	440C			Z100CD17	95X18	
SUS 440F	Y11Cr17	S44020	S44020					
SUS 630	0Cr17Ni4CuNb	S17400	S17400		X5CrNiCuNb16-4	Z6CNU17-04		
SUS 631	0Cr17Ni7Al	S17700	S17700		X7CrNiAl17 7	Z9CNA17-07	09X17H7 IO	
SUS 632J1								

● Representative Classification of Stainless Steel

• Stainless Steel (Austenitic related)

JIS	
SUS201	SUS309S
SUS202	SUS310S
SUS301	SUS316
SUS302	SUS316L
SUS302B	SUS316N
SUS303	SUS317
SUS303Se	SUS317L
SUS304	SUS321
SUS304L	SUS347
SUS304N1	SUS384
SUS304N2	SUSXM7
SUS305	SUSXM15J1
SUS308	

• Stainless Steel (Ferritic related)

JIS
SUS405
SUS429
SUS430
SUS430F
SUS434
SUSXM27

• Stainless Steel (Martensitic related)

JIS
SUS403
SUS410
SUS410S
SUS416
SUS420J1
SUS420F
SUS431
SUS440A
SUS440B
SUS440C
SUS440F

• Stainless Steel (Precipitation Hardening)

JIS
SUS630
SUS631

Material Cross Reference Table

● Steel

Classification	Japan	China	USA		UK	Germany	France	Russia
	JIS	GB	UNS	AISI	BS	DIN	NF	ГОСТ
Heat-Resisting Steel	SUH 31				331S42		Z35CNWS14-14	45X14H14B2M
	SUH 35				349S52		Z52CMN21-09Az	
	SUH 36	5Cr21Mn9Ni4N	S63008		349S54	X53CrMnNi21 9	Z55CMN21-09Az	55X20 Г 9AH4
	SUH 37	2Cr21Ni12N	S63017		381S34			
	SUH 38							
	SUH 309	2Cr23Ni13	S30900	309	309S24		Z15CN24-13	
	SUH 310	2Cr25Ni20	S31000	310	310S24	CrNi2520	Z15CN25-20	20X25H20C2
	SUH 330	1Cr16Ni35	N08330	N08330			Z12NCS35-16	
	SUH 660	0Cr15Ni25Ti2MoAlNb	S66286				Z6NCTV25-20	
	SUH 661		R30155					
	SUH 21					CrAl1205		
	SUH 409		S40900	409	409S19	X6CrTi12	Z6CT12	
	SUH 409L						Z3CT12	
	SUH 446	2Cr25N	S44600	446			Z12C25	15X28
	SUH 1	4Cr9Si2	S65007		401S45	X45CrSi9 3	Z45CS9	
	SUH 3	4Cr10Si2Mo					Z40CSD10	40X10C2M
	SUH 4	8Cr20Si2Ni			443S65		Z80CSN20-02	
	SUH 11							40X 9C2
SUH 600	2Cr12MoVNbN						20X12BHMБФП	
SUH 616	2Cr12NiMoWV	S42200						

● Representative Classification of Heat-Resisting Steel

- Heat-Resisting Steel (Austenitic related)

JIS
SUH31
SUH35
SUH36
SUH37
SUH38
SUH309
SUH310
SUH330
SUH660
SUH661

- Heat-Resisting Steel (Ferritic related)

JIS
SUH21
SUH409
SUH446

- Heat-Resisting Steel (Martensitic related)

JIS
SUH1
SUH3
SUH4
SUH11
SUH600
SUH616

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Technical Information

● Steel

Classification	Japan	China	USA	UK	Germany	France	Russia
	JIS	GB	AISI/ASTM	BS	DIN	NF	ГОСТ
Carbon Tool Steel	SK140 (SK1)	T13				C140E3U	Y13
	SK120 (SK2)	T12	W1-11½			C120E3U	Y12
	SK105 (SK3)	T11	W1-10		C105W1	C105E2U	Y11
	SK95 (SK4)	T10	W1-9			C90E2U	Y10
	SK85 (SK5)	T8Mn T9	W1-8		C80W1	C90E2U C80E2U	Y8Г Y9
	SK75 (SK6)	T8			C80W1	C80E2U C70E2U	Y8
	SK65 (SK7)	T7			C70W2	C70E2U	Y7
High Speed Tool Steel	SKH2	W18Cr4V	T1	BT1		HS18-0-1	P18
	SKH3	W18Cr4VCo5	T4	BT4	S18-1-2-5	HS18-1-1-5	P18K5Φ2
	SKH4	W18Cr4V2Co8	T5	BT5		HS18-0-2-9	P18K5Φ
	SKH10	W12Cr4V5Co5	T15	BT15	S12-1-4-5	HS12-1-5-5	
	SKH51	W6Mo5Cr4V2	M2	BM2	S6-5-2	HS6-5-2	P6M5
	SKH52	CW6Mo5Cr4V2 W6Mo5Cr4V3	M3-1				P6M5Φ3
	SKH53	CW6Mo5Cr4V3	M3-2		S6-5-3	HS6-5-3	P6M5Φ3
	SKH54		M4	BM4		HS6-5-4	
	SKH55	W6Mo5Cr4V2Co5 W7Mo5Cr4V2Co5	M35 M41	BM35	S6-5-2-5	HS6-5-2-5HC	P6M5K5
	SKH56		M36				
	SKH57			BT42	S10-4-3-10	HS10-4-3-10	
	SKH58	W2Mo9Cr4V2	M7			HS2-9-2	
	SKH59	W2Mo9Cr4VCo8	M42	BM42	S2-10-1-8	HS2-9-1-8	
Alloy Tool Steel	SKS11		F2				XB4
	SKS2				105WCr6	105WCr5	XBГ
	SKS21	W					
	SKS5						
	SKS51		L6				
	SKS7						
	SKS8	Cr06				C140E3UCr4	13X
	SKS4	5CrW2Si 6CrW2Si	S1				6XB2C 5XB2CΦ
	SKS41	4CrW2Si	S1				4XB2C
	SKS43		W2-9½	BW2		100V2	
	SKS44		W2-8				
	SKS3	9CrWMn					9XBГ
	SKS31	CrWMn			105WCr6	105WCr5	XBГ
	SKS93						
	SKS94						
	SKS95	8MnSi					
	SKD1	Cr12	D3	BD3	X210Cr12	X200Cr12	X12
	SKD10	Cr12Mo1V1	D2		X153CrMoV12		X12MΦ
	SKD11	Cr12MoV	D2	BD2	X153CrMoV12	X160CrMoV12	
	SKD12	Cr5Mo1V	A2	BA2		X100CrMoV5	
	SKD4					X32WCrV3	
	SKD5	3Cr2W8V	H21	BH21	X30WCrV9-3	X30WCrV9	
SKD6	4Cr5MoSiV	H11	BH11	X38CrMoV51	X38CrMoV5	4X5MΦC	
SKD61	4Cr5MoSiV1	H13	BH13	X40CrMoV51	X40CrMoV5	4X5MΦ1C	
SKD62		H12	BH12		X35CrWMoV5	3X3M3Φ	
SKD7	4Cr3Mo3SiV	H10	BH10	X32CrMoV33	32CrMoV12-18		
SKD8		H19	BH19				
SKT3					55CrNiMoV4		
SKT4	5CrNiMo		BH224/5	55NiCrMoV6	55NiCrMoV7	5XHM	

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Technical Information

Material Cross Reference Table

● Steel

Classification	Japan	China	USA	UK	Germany	France	Russia
	JIS	GB	AISI/ASTM	BS	DIN	NF	ГОСТ
Spring Steel	SUP3		1075 1078				75 80 85
	SUP6	55Si2Mn			56SiCr7	60Si7	60C2
	SUP7	60Si2Mn 60Si2MnA	9260		61SiCr7	60Si7	60C2Г
	SUP9	55CrMnA	5155		55Cr3	55Cr3	
	SUP9A	60CrMnA	5160		55Cr3	60Cr3	
	SUP10	50CrVA	6150	735A51, 735H51	50CrV4	51CrV4	XΦA50XΓΦA
	SUP11A	60CrMnBA	51B60		51CrV4		50XΓP
	SUP12		9254	685A57, 685H57	54SiCr6	54SiCr6	
SUP13	60CrMnMoA	4161	705A60, 705H60	60CrMn3-2	60CrMo4		
Free Cutting Carbon Steel	SUM11		1110				
	SUM12	Y12	1108				
	SUM21		1212				
	SUM22	Y15	1213	(230M07)	9SMn28	S250	
	SUM22L	Y12Pb	12L13		9SMnPb28	S250Pb	
	SUM23		1215				
	SUM23L						
	SUM24L	Y15Pb	12L14		9SMnPb28	S250Pb	
	SUM25				9SMn36	S300	
	SUM31		1117		15S10		
	SUM31L						
	SUM32	Y20		210M15, 210A15		(13MF4)	
	SUM41	Y30 Y35	1137			(35MF6)	
	SUM42	Y40Mn	1141			(45MF6.1)	
SUM43		1144	(226M44)		(45MF6.3)		
High Carbon Chromium Bearing Steel	SUJ1	GCr4	51100				
	SUJ2	GCr15	52100		100Cr6	100Cr6	ШХ15
	SUJ3	GCr15SiMn	ASTM A 485 Grade 1				
	SUJ4	GCr15SiMo					
	SUJ5	GCr18Mo					

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Technical
Information

● Cast Iron

Classification	Japan	China	USA	UK	Germany	France	Russia
	JIS	GB	AISI/SAE	BS	DIN	NF	ГОСТ
Gray Cast Iron	FC100	HT100	NO.20	100	GG10		CY10
	FC150	HT150	NO.30	150	GG15	FGL150	CY15
	FC200	HT200	NO.35	200	GG20	FGL200	CY20
	FC250	HT250	NO.45	250	GG25	FGL250	CY25
	FC300	HT300	NO.50	300	GG30	FGL300	CY30
	FC350	HT350	NO.60	350	GG35	FGL350	CY35
					GG40	FGL400	CY40
Nodular Cast Iron	FCD400	QT400-18	60-40-18	400/17	GGG40	FGS370-17	BY40
	FCD450	QT450-10	65-45-12	420/12		FGS400-12	BY45
	FCD500	QT500-7	70-50-05	500/7	GGG50	FGS500-7	BY50
	FCD600	QT600-3	80-60-03	600/7	GGG60	FGS600-2	BY60
	FCD700	QT700-2	100-70-03	700/2	GGG70	FGS700-2	BY70
	FCD800	QT800-2	120-90-02	800/2	GGG80	FGS800-2	BY80
		QT900-2		900/2			BY100

● Non-ferrous Metals

Classification	Japan	China	USA	UK	Germany	France	Russia
	JIS	GB	ASTM	BS	DIN	NF	ГОСТ
Aluminum Alloys		1A99	1199		A199.99R		A99
		1A97			A199.98R		A97
		1A95					A95
	A1080	1A80		1080(1A)	A199.90	1080A	A8
	A1050	1A50	1050	1050(1B)	A199.50	1050A	A5
	A5052	5A02	5052	NS4	AlMg2.5	5052	Amg
		5A03		NS5			AMg3
	A5056	5A05	5056	NB6	AlMg5		AMg5V
	A5556	5A30	5456	NG61		5957	
	A2117	2A01	2036		AlCu2.5Mg0.5	2117	D18
	A2017	2A11		HF15	AlCuMg1	2017S	D1
	A2024	2A12	2124		AlCuMg2	2024	D16AVTV
		2B16	2319				
	A2N01	2A80					AK4
	A2018	2A90	2218				AK2
A2014	2A14	2014		AlCuSiMn	2014	AK8	
A7075	7A09	7175		AlZnMgCu1.5	7075	V95P	
Aluminum Alloy Casting	AC4C	ZAlSi7Mn	356.2	LM25	G-AlSi7Mg		
	AC3A	ZAlSi12	413.2	LM6	G-Al12	A-S12-Y4	AL2
		ZAlSi5Cu1Mg	355.2				AL5
	AC8A	ZAlSi2Cu2Mg1	413.0		G-Al12(Cu)		
		ZAlCu5Mn					AL19
		ZAlCu5MnCdVA	201.0				
		ZAlMg10	520.2	LM10	G-AlMg10	AG11	AL8
	ZAlMg5Si			G-AlMg5Si		AL13	

Insert Grades Cross Reference Table

CVD Coated Carbide (Turning)

This table is Kyocera's own estimation based on publications and is not authorized by companies mentioned in it.

Classification		Kyocera	Dijet	Mitsubishi Hitachi Tool	Mitsubishi	NTK	Sandvik	Seco	Sumitomo	Tungaloy	Kennametal	Iscar
Classification	Symbol											
P (Steel)	P01	CA510 CA5505	JC110V	HG8010 HC5000 HG3305	UE6105 UE6005 UE6015		GC4305 GC4005 GC4205	TP0501 TP0500 TP1000	AC700G AC810P	T9005 T9105	KCP05B KCP05 KC9105	IC8150 IC9150
	P10	CA510 CA515 CA5505 CA5515	JC110V JC215V	GM10 GM20 GM8015 HG8010	MC6015 UE6105 UE6110 UE6005 UE6010 UE6020	CP2 CP5 CP7	GC4205 GC4015 GC3115 GC4215 GC4315	TP1501 TP1000 TP1500 TP100	AC700G AC2000 AC810P AC820P	T9005 T9105 T9015 T9115	KCP10B KCP10 KC9010 KC9110	IC8150 IC9150 IC9250
	P20	CA525 CA5515 CA5525 CR9025	JC110V JC215V	GM20 GM8020 HG8025	MC6025 UC6010 UE6110 UE6020	CP2 CP5 CP7	GC4025 GC4215 GC4220 GC4225 GC4325	TP2501 TP2000 TP2500 TP200	AC2000 AC3000 AC820P AC830P	T9015 T9115 T9025 T9125	KCP25B KCP25 KC9125 KC9225 KC9325	IC8250 IC9125 IC9250 IC9350
	P30	CA525 CA5525 CA530 CA5535 CR9025	JC215V JC325V	GM25 GM8035 HG8025	MC6025 UE6020 UE6035 UH6400		GC4225 GC4230 GC4235 GC2135	TP2501 TP2500 TP2000 TP3500 TP200	AC3000 AC630M AC830P ACP100	T9125 T9035 T9135 T3130	KCP30B KCP30 KC9040 KC9140	IC635 IC8350 IC9350
	P40	CA530 CA5535	JC325V JC450V JC540V	GX30	UE6035 UH6400		GC4035 GC4235 GC4240	TP40	AC630M AC830P ACP100	T9035 T3130	KCP40B KCP40 KC9140 KC9240	IC635
M (Stainless Steel)	M10	CA6515	JC110V	GM10	MC7015 US7020	CP2 CP5	GC2015	TP1500 TP100	AC610M	T9015 T9115	KCM15B KCM15 KC9010 KC9110 KC9210	IC8250 IC9250 IC9350
	M20	CA6525	JC110V JC215V	GM8020 HG8025	US7020 MC7025	CP2 CP5	GC1515 GC2015 GC2025	TM2000 TP200	AC6030M AC610M AC630M AC830P	T6020 T6120 T9115 T9125	KCM25B KCM25 KC9025 KC9125 KC9225	IC6015 IC8350 IC9250 IC9350
	M30		JC215V JC325V JC525X	GM25 GM8035	MC7025 US735		GC2040 GC235	TM4000 TP300	AC6030M AC630M AC830P	T6030 T6130 T9125	KCM35B KCM35 KC9240	IC6025 IC8350 IC9350 IC4050
	M40		JC525X	GX30	US735			TP40			KC9045 KC9245	IC635
K (Cast Iron)	K01	CA4010 CA4505 CA5505	JC105V JC605X JC605W JC050W	HG3305 HG3315 HX3505 HX3515	MC5005 UC5105 UC5015	CP1	GC3205 GC3210	TK1000 TH1000 TK1001	AC405K AC410K AC300G	T5105 T5010	KC9105 KC9315 KCK05B KCK05	IC5005 IC428 IC9007 IC9150
	K10	CA4010 CA4115 CA4505 CA4515 CA5505	JC050W JC110V JC605X JC605W JC108W	GM8015 HX3515 HG8010 HG3315	UC5015 UC5105 UC5115 UE6010 MC5015	CP1 CP2 CP5	GC3205 GC3210 GC3215 GC3115	TK1000 TK2000 TK2001 MK1500	AC410K AC415K AC700G	T515 T5105 T5115 T5010	KC9110 KC9120 KC9315 KCK15B KCK15	IC5010 IC418 IC428 IC9015 IC9007
	K20	CA4115 CA4120 CA4515	JC110V JC215V JC605X JC605W	GM8020 HG8025	MC5015 MY5015 UE6010 UC5115 UE6110	CP2 CP5	GC4225 GC3215 GC3220 GC3225	TK2000 TX150 TP200	AC420K AC700G AC820P	T5115 T5125 T5020	KC9125 KC9320 KC9325 KCK20B KCK20	IC418 IC9015
	K30		JC215V	GM25	UE6110		GC3040	TP2500 TP200		T5125 T9125	KCP25B KC9320	

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Technical
Information

PVD Coated Carbide (Turning)

This table is Kyocera's own estimation based on publications and is not authorized by companies mentioned in it.

Classification		Kyocera	Dijet	Mitsubishi Hitachi Tool	Mitsubishi	NTK	Sandvik	Seco	Sumitomo	Tungaloy	Kennametal	Iscar
Classification	Symbol											
P (Steel)	P01	PR1005	JC5003						ACZ150		KC5510	
	P10	PR930 PR1005 PR1025 PR1115 PR1215 PR1425 PR1225	JC5003 JC5030	CY15 CY150 IP2000	VP10MF	VM1 TM1 TA1 TAS DT4 DM4	GC1025	CP200	ACZ150 ACZ310 AC520U	AH710	KC5010 KC5510 KU10T	IC507 IC807 IC907
	P20	PR930 PR1025 PR1115 PR1215 PR1425 PR1225	JC5015 JC5030 JC5040	CY150 IP2000	VP10RT VP15TF VP20MF UP20M VP20RT	QM1 VM1 TA1 TAS	GC1020 GC1025 GC4125 GC1125	CP250	ACZ310 ACZ330 AC520U	AH710 AH725 AH730 SH725 SH730	KC5025 KC5525 KC7215 KC7315 KU25T	IC507 IC907 IC908
	P30	PR1025 PR1225	JC5015 JC5040	CY250 CY9020 HC844 IP3000	VP10RT VP15TF VP20MF UP20M	ZM3 QM3 TAS	GC1125 GC1145 GC1115 GC1105	CP500	ACZ330 ACZ350 AC530U	GH330 AH120 AH740	KC7015 KC7020 KC7235 KU25T	IC328 IC928 IC3028
	P40		JC5040	CY250 HC844		ZM3 QM3 TAS	GC1145 GC2145	CP500	ACZ350	AH140 AH740 J740	KC7030 KC7040 KC7140	IC328 IC3028
M (Stainless Steel)	M10	PR1025 PR1215 PR1225	JC5003	IP050S	VP10MF VP10RT	VM1 TM1 TA1	GC1005 GC1025 GC1105 GC15	TS2000 CP200 CP250	EH510Z ACZ150 AC510U	AH710	KC5010 KC5510 KC6005 KCU10	IC507 IC520 IC807 IC907
	M20	PR930 PR1025 PR1125 PR1215 PR1425 PR1225	JC5015 JC5030 JC5040 JC8015	IP100S GX30	VP10RT VP15TF VP20MF UP20M VP20RT	QM1 VM1 TA1 TAS DT4 DM4	GC1025 GC1115 GC4125 GC1125 GC30	TS2500 CP200 CP250 CP500	EH520Z ACZ150 ACZ310 AC520U	AH630 AH725 AH730 GH330 GH730 SH725 SH730	KC5025 KC5525 KC7020 KC7025 KCU25	IC308 IC507 IC907 IC908 IC3028
	M30	PR1125 PR1535	JC5015 JC5030 JC5040	CY250 CY9020	VP15TF VP20MF UP20M MP7035	ZM3 QM3 TAS	GC1020 GC2035 GC2030	CP500	ACZ330 ACZ350 AC530U AC6040M	AH120 AH725	KC7030 KC7225	IC908 IC1008 IC1028 IC3028
	M40				MP7035	ZM3 QM3 TAS	GC2145 GC1145		AC6040M ACZ350	J740 AH140 AH645		IC228 IC928 IC328
K (Cast Iron)	K01		JC5003						EH10Z	AH110	KC5515	IC910
	K10	PR905 PR1215	JC5003 JC5015	CY100H CY10H	VP05RT	TA1 TM1	GC1010	TS2000 CP200	EH10Z EH510Z AC510U	GH110 AH110	KC5010 KC7210	IC807 IC910 IC507 IC908
	K20	PR905 PR1215	JC5015	IP2000 CY9020	VP10RT VP15TF VP20RT	QM1 TA1	GC1020 GC1120	TS2500 CP200 CP250	EH20Z ACZ310 AC520U AC530U	AH120 AH725	KC5025 KC5525 KC7015 KC7215 KC7315	IC508 IC908
	K30				VP15TF VP20RT	QM3 TA3	GC1030	CP500	ACZ310		KC7225	IC508 IC908
S (Difficult-to-Cut Material)	S01	PR1305	JC5003		MP9005 VP05RT					AH8005 AH905		
	S10	PR1305 PR1310	JC5015 JC8015	JP9105	MP9005 MP9015 VP10RT		GC1105 GC1005 GC1025	CP200 TS2000	AC510U	AH8015 AH905 SH730 AH110	KC5010 KC5510	IC807 IC808 IC907 IC908
	S20	PR1310 PR1325 PR1535	JC5015 JC8015	JP9115	MP9015 MT9015 VP20RT		GC1025 GC1125	CP250 TS2500	AC510U AC520U	AH8015 AH120 AH725	KC5025 KC5525	IC806 IC808 IC908
	S30	PR1535			VP15TF		GC1125		AC520U	AH725		IC328

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Technical Information

Insert Grades Cross Reference Table

Cermet (Turning)

This table is Kyocera's own estimation based on publications and is not authorized by companies mentioned in it.

Classification		Kyocera	Dijet	Mitsubishi Hitachi Tool	Mitsubishi	NTK	Sandvik	Seco	Sumitomo	Tungaloy	Kennametal	Iscar
Classification	Symbol											
P (Steel)	P01	TN610 TN6010 PV710 PV7010	LN10 CX50	CH350	AP25N VP25N NX1010	T3N T15 Q15			T110A T1000A	NS520 GT530 GT720 J530	KT1120 KT125 HTX	IC20N IC520N
	P10	TN610 TN6010 TN620 TN6020 TN60 PV710 PV7010 PV720 PV7025	LN10 CX50 CX75 NIT PX75	CH350 CZ25	NX2525 AP25N VP25N	T15 C7Z Z15	CT5015 CT525	TP1020 CM CMP	T1500Z T2000Z T1200A T1500A	NS9530 NS520 GT9530 GT530 GT730	KT315 KT175 HT2	IC20N IC520N IC530N IC75T
	P20	TN620 TN90 TN6020 PV720 PV7025	CX50 CX75 CX90 NAT PX90	CH550 CH7030 CZ1025 CZ25	MP3025 NX2525 NX3035 AP25N VP45N	T15 C7X C7Z	CT525 CT530 GC1525	TP1020 C15M TP1030	T1200A T1500A T1500Z T2000Z T3000Z	NS9530 NS530/730 GT9530 GT530/730	PS5 KT5020	IC20N IC520N IC530N IC75T IC30N
	P30		CX90 CX99 SUZ		NX4545 VP45N	N40 C7X	CT530 GC1525	TP1030	T3000Z T250A	NS740		IC75T IC30N
M (Stainless Steel)	M10	TN620 TN60 TN6020 PV720 PV7020 PV7025	LN10	CH350	NX2525 AP25N VP25N	T15 C7X C7Z Z15	CT5015 CT525	CM CMP	T110A T1000A T2000Z	NS520 J530	KT1120 KT315 KT125	IC20N IC520N
	M20	TN620 TN90 TN6020 PV720 PV7020 PV7025	CX50 CX75 PX75 NIT NAT	CH550 CH7030 CZ1025	NX2525 NX3025 AP25N VP25N	C7X C7Z Q15	CT530 GC1525	TP1020 C15M	T1500A T2000Z	NS530 NS730 GT530 GT730	KT175 HT2 PS5 KT5020	IC30N IC530N
	M30		CX75 CX90 PX90 CX99 SUZ	CZ25	NX4545	C7X		TP1030	T3000Z T250A	NS740		
K (Cast Iron)	K01	PV7005	LN10		AP25N VP25N	T3N T15 Q15			T110A T1000A	NS520	KT1120	
	K10	TN610 TN6010 PV710 PV7010 PV7005	LN10	CH350	NX2525 AP25N VP25N	T15 C7X C7Z Z15	CT5015		T1200A T1500A T2000Z	NS530 NS730 GT530 GT730	KT315 HTX	
	K20		NIT	CZ25	NX2525 AP25N VP25N				T3000Z		KT5020	

• Boldface grade shows PVD Coated Cermet.

Carbide

Classification		Kyocera	Dijet	Mitsubishi Hitachi Tool	Mitsubishi	NTK	Sandvik	Seco	Sumitomo	Tungaloy	Kennametal	Iscar
Classification	Symbol											
P (Steel)	P10		SRT	WS10	STi10T		S1P		ST10P	TX10S	K2885	IC70
	P20		SRT DX30	EX35	STi20 UTi20T		SMA	S10M	ST20E	TX20 TX25	K125M	IC70 IC50M
	P30		SR30 DX30 DX35	EX35 EX40	UTi20T		SM30	S25M	A30N A30 ST30E	TX30 UX30	KMF	IC50M IC54
	P40		SR30 DX35	EX45			S6	S60M	ST40E	TX40	PVA	IC54
K (Cast Iron)	K01		KG03	WH02 WH05	HTi05T		H1P		H1 H2	TH03 KS05F	K68 K10	IC04
	K10	KW10 GW15	KG10 KT9	WH10	HTi10	KM1	H1P H10 HM	890	EH10 EH510	G1F TH10 H10T	KMI K8735 K313	IC20
	K20	GW25	CR1 KG20	WH20	HTi20T UTi20T	KM3	H13A	883 890 HX	G10E EH20 EH520	G2F KS15F KS20	KMF	IC20 IC10
	K30		KG30					883	G3 G10E	G3 UX30	THR	IC10 IC28
V (Wear and Shock Resistant Tool)	V40		G5 GD195	WH50	GTi30				G5	D40		
	V50	VW50	MH3 MH4 GD174 GD201	WH60	GTi35 GTi40 GTi30S				G6	D50		
	V60		MH5 MH7 MH8 GD206	WB60	GTi40S GTi50S				G7 G8	D60		

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Technical Information

Coated Carbide (Milling)

This table is Kyocera's own estimation based on publications and is not authorized by companies mentioned in it.

Classification		Kyocera	Dijet	Mitsubishi Hitachi Tool	Mitsubishi	NTK	Sandvik	Seco	Sumitomo	Tungaloy	Kennametal	Iscar
Classification	Symbol											
P (Steel)	P10	PR830 PR1025 PR1225	JC5003 JC5030 JC8003	JP4105 JX1020 JP4005	F7010		GC1025 GC1010		ACP100		KC715M	
	P20	PR1525 PR830 PR1025 PR1225 PR1230	JC730U JC5015 JC5030 JC8015	JP4120 JS4045 JP4020 TB6020 JX1015 GX2140	MP6120 F7030 UP20M	TM1 DT4 DM4	GC1130 GC1030 GC4220 GC4020 GC4030	MP1500 T250M T25M T20M	ACP200	T313W AH725	KC522M KC525M KCPM20	IC330 IC250 IC520M IC950 IC5400
	P30	PR1230	JC5015 JC5040	CY250 CY9020 TB6045 JX1045 JM4060 GX2160	MP6130 F7030 VP15TF VP30RT	ZM3	GC1130 GC4040 GC4230	MP2500 T250M T25M F25M F30M	AC230 ACP300	T3130 GH330 AH120 AH330 AH730	KC994M KC725M KC792M KC530M KCPK30	IC330 IC328 IC635 IC830 IC908 IC928
	P40		JC5040	CY250 HC844 TB6060 JX1060	VP30RT		GC4040 GC4240	MP3000 T350M T60M T25M	AC230 ACZ330 ACZ350	AH140	KC735M	IC635 IC928 IC4050
M (Stainless Steel)	M10	PR1025 PR1225		CY9020 JX1020 JP4020	F7010		GC1025 GC1030		ACM100 ACM200 EH10Z		KC522M	
	M20	PR1525 PR1025 PR1225	JC730U JC1341 JC5015 JC5030 JC5040 JC7560	CY150 TB6020 JX1015 CY250	F7030 UP20M VP15TF VP20RT MP7030 MP7130	DT4 DM4	GC2030	MP2500 T250M T25M F20M F25M F30M	ACM200 ACP200 EH20Z	GH330 AH330 AH120 AH130 AH725	KC730M KC525M	IC380 IC908 IC928
	M30	CA6535 PR1535	JC5015 JC5030 JC5040	JM4160 JM4060 TB6045 JX1045 GX2160	F7030 VP30RT MP7140	ZM3	GC1040 GC2040	T350M T250M F40M	ACM300 ACP300 ACZ350	T3130 AH130	KC994M KC725M KCPK30	IC380 IC328 IC330
	M40		JC8050		VP30RT			MM4500	ACZ350	AH140		IC830
K (Cast Iron)	K01		JC8003	TB6005				MH1000		AH110		IC5100 IC4100
	K10	PR1510 PR905 PR1210	JC600 JC610 JC605W	JP4005 CY10H CY100H CY9020	MP8010 MC5020 VP10RT		GC1010 GC3220 K15W	MK1500 T150M F15M	ACK200 AC211	T1015 T1115 AH110	KCK15 KC915M	IC5100 IC4010 IC910 DT7150 IC810
	K20	CA420M PR905 PR1210	JC605X JC610 JC5015 JC8015	CY150 TB6020 JX1015	VP15TF VP20RT		GC1020 GC3020 K20W/K20D GC3330	MP1500 T150M T250M MK2000 MK2050	EH20Z ACZ310 ACK300	AH120 AH725	KC520M KC920M KC925M KC992M	IC810 IC910 IC928
	K30		JC5080				GC3040 GC4040	MK3000 T250M		GH130	KC930M	IC928
S (Difficult-to-Cut Material)	S10	CA6535 PR1535 PR1210	IC8015 IC5015	PCS08M PTH13S JS1025	MP9120 VP15TF		GC1030 GC1025	MS2050	ACM100 ACM200 ACK300		KC510M	IC903 IC807 IC808 IC908
	S20	CA6535 PR1535 PR1210	IC8015 IC5015 JC8050 JC7560	CY100H CY10H	MP9120 VP15TF MP9130 MP9030		GC1030 GC2030 S30T		ACM200		KC525M	IC903 IC807 IC808 IC908 IC830 IC928
	S30	PR1535	JC8050 JC7560				GC2040 S40T	F40M	ACM300		KC725M	IC328 IC330

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Technical Information

Insert Grades Cross Reference Table

Cermet (Milling)

This table is Kyocera's own estimation based on publications and is not authorized by companies mentioned in it.

Classification		Kyocera	Dijet	Mitsubishi Hitachi Tool	Mitsubishi	NTK	Sandvik	Seco	Sumitomo	Tungaloy	Kennametal	Iscar
Classification	Symbol											
P (Steel)	P10	TN60	NIT CX75	CH550	NX2525			C15M		NS530 NS730	KT530M KT195M	
	P20	TN60 TN100M	NAT CX75 CX90	CH570 CH7030 MZ1000	NX2525	C7X C7Z	CT530	C15M MP1020	T250A T1500A	NS530 NS730 NS740	HT7 KT530M KT605M	IC30N
	P30		CX90 CX99 SC30	CH7035	NX4545				T4500A	NS540		IC30N
M (Stainless Steel)	M10	TN60			NX2525			C15M				
	M20	TN60 TN100M	NIT CX75 NAT	CH550 CH570 CH7030	NX2525		CT530	C15M	T250A	NS530	KT7 KT530M KT605M	IC30N
	M30		CX75 CX90 CX99 SC30		NX4545				T4500A	NS740 N308		
K (Cast Iron)	K01		LN10									
	K10		LN10 CX75	CH550	NX2525							IC30N
	K20		NIT	CH7030 CH7035	NX2525							

Ceramic

Classification		Kyocera	Dijet	Nippon Tungsten	Mitsubishi	NTK	Sandvik	Seco	Sumitomo	Tungaloy	Kennametal	Iscar
Classification	Symbol											
K (Cast Iron)	K01	KA30 A65 KT66 PT600M CS7050				SE1 HC1 HC2 HC5 HC6 HW2	CC620 CC650		NB90S NB90M WX120		KW80 KY1615 AC5	
	K10	A65 KT66 A66N PT600M CS7050 KS6050		NX NXA Whiskal WIN		WA1 HC2 HC6 HC7	CC6090 CC6190 GC1690		WX120 NS260C	LX11 LX21	KYK10 KYK25 KB90 KY1320 KY3000 KY3400	
	K20	KS6050				SX6 SX9 SP9	CC6090 CC6190 GC1690		WX120	WG300 FX105 CX710	KYK35 KY3400 KY3500	
S (Difficult-to-Cut Material)	S01						CC650				KY2100	
	S10	CF1 KS6030 KS6040	CA200	Whiskal WIN		WA1 WA5 SX7 SX9	CC670 CC6060 CC6065		WX120	WG300	KYS25 KY4300 KY1525 KY1540	
	S20								WX120		KYS30	
H (Hard Materials)	H01	A65 KT66 A66N PT600M		NPC-A2		HC4 HC7 ZC7	CC650 CC670 CC6050		NB100C	LX11 LX21	KY4400	
	H10	A65 KT66 A66N PT600M		NPC-A2 Whiskal WIN		ZC7 WA1 WA5	CC670			WG300	KY4300	

Boldface grade shows PVD Coated Ceramic.

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Technical Information

CBN

.This table is Kyocera's own estimation based on publications and is not authorized by companies mentioned in it.

Classification		Kyocera	Dijet	Mitsubishi Hitachi Tool	Mitsubishi	NTK	Sandvik	Seco	Sumitomo	Tungaloy	Kennametal	Iscar
Classification	Symbol											
K (Cast Iron)	K01	KBN475	JBN795		MB710	B20 B22 B30	CB7525 CB50 CB7050	CBN050C CBN300P	BN500 BNC500	BX910 BX930 BX950		IB50 IB85
	K10	KBN60M KBN900	JBN330	BH200	MB710 MB5015 MB4020	B22 B23	CB50 CB7050	CBN20 CBN200 CBN300	BN600 BN700 BN7000	BX950 BXC90 BX470	KB1630 KB9610	IB55 IB90
	K20	KBN900		BH250	MB730 MBS140 BC5030	B16 B40		CBN350 CBN500 CBN600	BN7000 BNS800	BX950 BXC90 BX90S	KB9640	
H (Hard Materials)	H01	KBN510 KBN05M KBN10M	DH102		BC8110 MBC010 MB810	B24 B52	CB20	CBN050C CBN010 CBN10 CBN100	BN1000 BNX10 BNC100 BNC160 BNC2010	BXA30 BX310 BXC30 BXM10	KB1610	IB20H IB25HC IB50
	H10	KBN525 KBN05M KBN25M	JC6102 JC8003 JBN500	BH200	BC8120 MBC020 BC8020 MB8025 MB825	B24 B36 B54 B52	CB7015 CB7050 CB50	CBN150 CBN060K CBN200 CBN160C	BNC160 BNX20 BN2000 BNC200 BNC2020	BXM10 BXA40 BX330 BX360 BXC50	KB1615 KB1625 KB5610 KB9610	IB50
	H20	KBN30M KBN35M KBN900	JC8003 JC5015 JBN245	BH250	BC8120 MBC020 BC8020 MB8025	B22 B36	CB7025 CB7525	CBN350 CBN300P CBN400C CBN500	BNX25 BN350 BNC300	BX380 BXC50 BXM20	KB1340 KB5625 KB9640	IB55 IB25HA
Sintered Steel	-	KBN65B KBN570 KBN65M KBN70M	JBN795 JBN500		MB4020			CBN200	BN350 BN7000 BN7500	BX450 BX470 BX480		

.Boldface grade shows PVD Coated CBN.

PCD

Classification		Kyocera	Dijet	Mitsubishi Hitachi Tool	Mitsubishi	NTK	Sandvik	Seco	Sumitomo	Tungaloy	Kennametal	Iscar
Classification	Symbol											
N (Non-ferrous Metals)	N01	KPD001	JDA30 JDA735		MD205	PD1	CD05 CD10	PCD05 PCD10	DA90 DA1000 DA2200	DX180 DX160	PD100 KD1400 KD1405	
	N10	KPD001 KPD010 KPD230 KPD250	JDA40 JDA745		MD220	PD2	CD10	PCD10 PCD20	DA150 DA1000 DA2200	DX140	KD100 KD1400 KD1415	ID5
	N20	KPD001 KPD010 KPD230 KPD250	JDA10 JDA715		MD230			PCD30 PCD30M	DA1000 DA2200	DX110 DX120	KD1425	

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Technical Information

Molded Chipbreaker Cross Reference Table

Molded Chipbreaker Cross Reference Table

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Negative Inserts

Cutting Range		Kyocera		Dijet	Mitsubishi Hitachi Tool	Mitsubishi	NTK	Sandvik	Seco	Sumitomo	Tungaloy	Kennametal	Iscar
		General Chipbreaker	Chipbreaker for Sticky Material / Soft Steel										
Carbon Steel / Alloy Steel	Finishing (With Wiper Edge)	WP	-	-	-	SW	-	WL WF	W-MF2	SEW LUW	AFW FW	FW	-
	Finishing-Medium (With Wiper Edge)	WQ	-	-	-	MW	-	WM WMX	W-M3 W-M5	GUW	ASW SW	MW	WG
	Finishing	DP GP PP	XF XP	F1 FA FT PF	BE BH FE	F FH FS FY PK	UL WM ZF1	XF QF	FF1	FP SP FA FL LU	TF 01 AS TSF	FF UF FS	F3P SF
	Finishing - Medium	HQ PQ CQ CJ VC VF	XQ	UA UT	AB B CE CT	SH C SA LP SY	WV WR	LC PF	FF2 MF2	SU EX SJ SX UJ SE	TS NS CB 11 17 27 ZF	RP FN	NF
	Medium - Roughing	PG GS PS	XS	UR UB	AE DE AH	MV MP MA MH	Z5 ZW1	XM QM SM SMC PM	M3 MF3	UA UG GE GU	AM DM NM TM ZM	MN	M3P TF
	Medium - Roughing High Feed Rate	PT GT	-	GC PQ	AR AY	GH RP	GS	MR XMR	M5 MR5 MR6	MU UX ME	TH 32Y 32 37	RP RN	R3P NR
	Roughing	Standard PH	-	GG LG GQ	RE	MT Standard	G	Standard 23	MR7	MC MU MX UZ	31 33 F-K THS	PR MG	GN
	Roughing Single Sided High Feed Rate	PX	-	GS RM UC UP	H HX HE TE UE	HV HR HX HZ HL HM	-	QR PR HR	R4 R5 R6 R7 RR6 RP	HG HP MP HF	TU 57 65 TUS	RH RM	TNM
Stainless Steel	Finishing	GU MQ	-	SF	BH MP	FS SH FJ LM	ZF1	MF	-	SU EF	SF SS	FP	F3M
	Medium - Roughing	MS MU TK	-	GP SZ	DE SE PV	MS MA GM MJ MM ES MH GH GJ RM	ZP WS	MM MMC MR XMR SMR	MF1 MF3 A3 A5 M5 56 R8 RR9	EG EX MU UP EM	HMM SM SA S SH	P MP MS	TF PP M3M R3M
Cast Iron	Medium	C Standard	-	-	AH VA VY	LK MF Standard	-	KF KM	-	UZ UX UJ	Standard 33 CF	FN	-
	Roughing	GC ZS	-	-	-	GH RK	-	KR KRR	-	GZ	CM CH	RP UN	-
Non-ferrous Metals	Medium - Roughing	AH	-	-	-	-	-	AL	95	AG	P	GP MS	PP

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Technical Information

● Positive Inserts

Cutting Range		Kyocera		Dijet	Mitsubishi Hitachi Tool	Mitsubishi	NTK	Sandvik	Seco	Sumitomo	Tungaloy	Kennametal	Iscar
		General Chipbreaker	Chipbreaker for Sticky Material / Soft Steel										
Carbon Steel / Alloy Steel	Minute ap	CF	-	-	-	-	-	-	-	-	01	-	-
	Finishing (With Wiper Edge)	WP	-	-	-	SW	-	WF WK	W-F1	LUW SDW	-	FW	WF
	Finishing	DP GP PP VF	XP	ASF	-	FV SQ FP SMG	AZ3 AMX AZ7	PF UF XF	FF1	FB FC FK FP LU	PF PSF 23	11 GF UF FP	PF SM
	Finishing - Medium (1)	HQ	XQ	ACB FT	JE	MQ MV LP	AF1	PM UM SMC	F1	LB SF SU	PS PSS 24	LF	14
	Finishing - Medium (2)	GK	-	BM	JQ	Without Indication	QD CL	PF PM XM	MF2	-	-	-	-
	Medium	Standard	-	-	J	MP Standard	AM3	PR UR KM XR	F2	MU SC	PM	GM MP MR	Standard
Stainless Steel	Finishing	MQ	-	-	MP	FM FV SV LM	-	MF MMC	-	LU	JS PF PSF	FW FP MW	WF
Non-ferrous Metals	Finishing - Medium	AH	-	ALU	-	AZ	-	AL	AL	AG AW	AL	HP	AF AS

● Positive Inserts (for Automatic Lathe)

Cutting Range		Kyocera	Dijet	Mitsubishi Hitachi Tool	Mitsubishi	NTK	Sandvik	Seco	Sumitomo	Tungaloy	Kennametal	Iscar
Carbon Steel / Alloy Steel	Minute ap	CF	-	-	-	-	-	-	-	01	-	-
	Finishing	CK GF	ASF	JQ	FP FV SMG	AZ7 AMX ZR	PF XF	FF1	SI FC	PF	11 UF FP	PF SM
	Finishing - Medium	GQ SK	ACB FT	JE	LP AM MV	AM3 YL	PM XM	F1 MF2	SU	PS	LF	14
	Medium	GK	-	J	MP Standard	QD CL	PR	F2	SC	PM	MF MP	Standard
Stainless Steel	Finishing	MQ	-	MP	FM FV SV LM	-	MF	-	LU	JS PF PSF	FW FP MW	WF
Non-ferrous Metals	Finishing - Medium	AH	ALU	-	AZ	-	AL	AL	AG AW	AL	HP	AF AS



Milling Insert Description Cross Reference Table

Milling Insert Description Cross Reference Table

This table is Kyocera's own estimation based on publications and is not authorized by companies mentioned in it.

Kyocera	Class	Applications	Mitsubishi Hitachi Tool	Mitsubishi	Sandvik	Sumitomo	Tungaloy	Iscar
SDMR1203AUER-H SDKR1203AUEN-S	M K		SDKR42TN	(SDNR1203AEEN-JS)		SDMR1203AEEN SDMR1203AETN	SDMR1203AETN-MJ SDKR1203AESR-MJ SDKR1203AETN-MJ SDKR1203AEPN-MS SDKR42ZSR-MJ SDKR42ZPN-MS	SDKR1203AUTR-HS SDKR1203AUN-76
SDCN1203AUTN	C	Steel	(SDE42TN-C9)				SDCN1203AETN-12 SDCN42ZTN (SDEN1203AETNCR) (SDEN42ZTNCR)	
SDKN1203AUTN	K		SDK42TN-C9	SDKN1203AEN SDKN1203AETN (SDNN1203AETN1)		SDKN42MT (SDNN1203AETN)	SDKN1203AETN-12 SDKN42ZTN	SDKN1203AETN
SDKN1203AUFN	K	Cast Iron	SDK42FN-C9			SDKN42M (SDNN1203AEEN)	SDKN1203AEFN-12 SDKN42ZFN	
		Non-ferrous Metals				SDKN42M	(SDCN1203AEFN-D) (SDCN42ZFN-DIA)	
SDCN1504AUTN	C		SDC53TN-C9				SDCN1504AETN SDCN53ZTN	
SDKN1504AUTN	K	Steel	SDK53TN-C9	SDKN1504AEN SDKN1504AETN		SDKN53MT	SDKN1504AETN SDKN53ZTN	SDKN1504AETN
SEMR1203AFER-H SEKR1203AFEN-S	M K		SEKR42TN	(SEER1203AFEN-JS)	SEKR1203AZ-WM (SEER1203AZ-WL)	SEMR1203AFEN (SEER1203AFEN)	SEMR1203AFTN-MJ SEKR1203AFSR-MJ SEKR1203AFTN-MJ SEKR1203AFPN-MS	SEKR1203AFTR-HS SEKR1203AFR-HS SEKR1203AFN-76 SEKR1203AFN-42
SEMR1204AFER-H	M	Steel			(SEKR1204AZ-WM) (SEER1204AZ-WL)	SEMR1204AFEN (SEER1204AFEN)		(SEKR1204AFTR-HS) (SEKN1204AFTN)
SEEN1203AFTN	E		SEE42TN-C9	SEEN1203AFTN1		SEEN42MT	SEEN1203AFTNCR-14	
SEKN1203AFTN	K		SEK42TN-C9	SEKN1203AFTN1 (SENN1203AFTN1)	SEKN1203AZ (SEMN1203AZ)	SEKN42MT (SENN1203AFTN)	SEKN1203AFTN SEKN1203AFTN-16 SEKN42AFTN SEKN42AFTN16	
SEKN1203AFFN	K	Cast Iron	SEK42FN-C9	(SEEN1203AFFN1)	SEKN1203AZ (SEMN1203AZ)	SEKN42M (SENN1203AFEN)	SEKN1203AFFN SEKN42AFFN	
SEEN1203AFFN	E	Non-ferrous Metals	SEE42FN-C9	(SECN1203AFFR1)				
SEKN1203EFTR	K	Steel	SEK42TR-G3	SEKN1203EFTR1	(SECN1203EER)		SEKN1203EFTR (SECN1203EFTR) (SEEN1203EFTR) (SECN42EFTRCR) (SEEN42EFTRCR)	
SEKN1504AFTN	K	Steel	SEK53TN-C9		SEKN1504AZ	SEKN53MT		SEKN1504AFTN
SPEN1203EESR	E	Cast Iron	(SPK42FR-A3E)	SPEN42EFSR1 SPEN1203EESR1 SPEN1203EEER1 (SPNN1203EEER1)				
SPMR1203EDER-H SPKR1203EDER-S	M K			(SPER1203EDER-JS)	SPKN1203EDR-WH		SPKR1203EDSR-MJ SPKR42SSR-MJ	SPKR1203EDR-76 SPKR1203EDTR-HS
SPCN1203EDTR	C	Steel		(SPEN1203EDR)	(SPAN1203EDR)	SPCH42TR-R	SPCN1203EDTR SPCN42STR	
SPKN1203EDTR	K		SPK42TR-A3	SPKN1203EDR	SPKN1203EDR	(SPCH42TR) (SPCH42TR-R)	SPKN1203EDTR SPKN42STR (SPEN1203EDTR) (SPEN42STR)	SPKN1203EDTR SPKN1203EDTR-42
SPKN1203EDFR	K	Cast Iron	SPK42FR-A3		SPKN1203EDR	(SPCH42R)	SPKN1203EDFR SPKN42SFR	SPKN1203EDFR
SPKN1504EDTR	K	Steel	SPK53TR-A3	SPKN1504EDR	SPKN1504EDR	(SPCH53TR-R)	SPKN1504EDTR SPKN53STR (SPCN1504EDTR) (SPCN53STR)	SPKN1504EDTR
SPKN1504EDFR	K	Cast Iron	SPK53FR-A3			(SPCH53R-R) (SPCH53TR-R)	SPKN1504EDFR SPKN53SFR	SPKN1504EDFR

Note 1. Tolerance class is different for description in ().

2. Since edge shape of Milling insert is slightly different by each maker, please adjust edges (Z axis direction) during operation.

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Technical Information

Milling Insert Description Cross Reference Table

This table is Kyocera's own estimation based on publications and is not authorized by companies mentioned in it.

Kyocera	Class	Applications	Mitsubishi Hitachi Tool	Mitsubishi	Sandvik	Sumitomo	Tungaloy	Iscar
SPCN1203XPTR	C		SPC42TR-A5				SPCN1203ZPTR SPCN42ZTR	
SPKN1203XPTR	K	Steel	SPK42TR-A5				SPKN1203ZPTR SPKN42ZTR (SPEN1203ZPTR) (SPEN42ZTR)	
SPKN1203XPFR	K	Cast Iron	SPK42FR-A5				SPKN1203ZPFR SPKN42ZFR	
SPKN1504XETR	K	Steel		SPK53C2SR				
TPMR1603PDER-H	M			(TPER1603PPER-JS)	(TPKN1603PPR-WH)			(TPKR1603PPTR-HS)
TPKN1603PDTR	K	Steel	TPK32TR-E0 TPK32TR-G0	TPKN1603PPR (TPEN1603PPR)	TPKN1603PPR	TPKN32TR		TPKN1603PPTR
TPKN1603PDFR	K	Cast Iron	TPK32FR-E0		TPKN1603PPR	TPKN32R		TPKN1603PPFR
TPMR2204PDER-H TPKR2204PDER-S	M K			(TPER2204PDER-JS)	TPKN2204PDR-WH		TPMR2204PDSR-MJ TPKR2204PDSR-MJ TPKR43ZSR-MJ	TPKR2204PDTR-HS TPKR2204PD-R-76
TPKN2204PDTR	K	Steel	TPK43TR-E0 TPK43TR-G0	TPKN2204PDR (TPEN2204PDR)	TPKN2204PDR	(TPCH43TR)	TPKN2204PPTR TPKN43ZTR (TPCN2204PPTR) (TPCN43ZTR)	TPKN2204PDTR TPKN2204PDTR-42
TPKN2204PDFR	K	Cast Iron	TPK43FR-E0			(TPCH43R)	TPKN2204PPFR TPKN43ZFR (TPCN2204PPFR) (TPCN43ZFR) (TPEN2204PPTR-16) (TPEN43ZTR)	TPKN2204PDFR
TEMR1603PTER-H	M			(TEER1603PEER-JS)			(TEKR1603PEPR-MS)	
TEKN1603PTTR	K	Steel	TEK32TR-G0 (TEE32TR-G0)	(TEEN1603PETR1)		TEKN32TR	(TECN1603PETR) (TEEN1603PETR) (TECN32ZTR) (TEEN32ZTR)	
TEKN1603PTFR	K	Cast Iron	TEK32FR-G0 (TEE32FR-G0)	(TEEN1603PEFR1)		TEKN32R	(TEEN1603PEFR) (TEEN32ZFR)	
TEEN1603PTFR	E	Non-ferrous Metals		(TECN1603PEFR1)		TEEN32R	(TECN1603PEFR-D) (TECN32ZFR-DIA)	
TEMR2204PTER-H TEKR2204PTER-S	M K			(TEER2204PEER-JS)			TEKR2204PEPR-MS	
TEEN2204PTTR	E	Steel	TEE43TR-G0E (TEK43TR-G0E)	TEEN2204PETR1		TEEN43TR	TEEN2204PETR (TECN2204PETR) TEEN43ZTR (TECN43ZTR)	
TEKN2204PTTR	K		TEK43TR-G0E	TEKN2204PETR1		TEKN43TR	(TEEN2204PETR) (TECN2204PETR) (TEEN43ZTR) (TECN43ZTR)	
TEKN2204PTFR	K	Cast Iron	TEK43FR-G0E	(TEEN2204PEFR1)		TEKN43R	(TEEN2204PEFR) (TEEN43ZFR)	
		Non-ferrous Metals		(TECN2204PEFR1)		(TEEN43R)	(TECN2204PEFR-D) (TECN43ZFR-DIA)	
SNCN1204XNTN	C	Steel	SNC43TN-D5	SNC43B2S		(CSN43MT)	SNCN1204ZNTN SNCN43ZTN	
SNKN1204XNTN	K		SNK43TN-D5	SNK43B2S		(CSN43MT)	SNKN1204ZNTN SNKN43ZTN	
SNCN1204ENTN	C	Steel		(SNKN1204EN)	(SNKN1204ENN)			
SNMF1204XNTN	M	Steel	(SNKF43TN-D5)	(SNKF43B2S)		(CSNB43MT)	(SNKF1204ZNTN) (SNKF43ZFN)	

Note 1. Tolerance class is different for description in ().







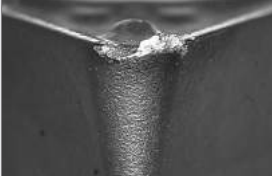



2. Since edge shape of Milling insert is slightly different by each maker, please adjust edges (Z axis direction) during operation.

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Technical Information

Cutting Edges Figuration and Countermeasures

Typical Cutting Edge Figuration	Observation	Causes	Countermeasures
Nose wear	 · Deterioration of surface roughness and dimensional accuracy	· Too high Vc · End of tool life	· Reduce Vc · Change to higher wear resistant grade
Notching	 · Burr formation · Cutting force increase	· Too high f and Vc	· Sharper cutting performance · Reduce Vc · Change to higher heat resistant grade
Crater wear	 · Chip control deterioration · Surface finish deterioration (peeled surface)	· Too high Vc	· Reduce Vc · Change to high speed type like Cermet or Al ₂ O ₃ coated insert grade
Plastic Deformation	 · Workpiece dimension changes · Crack at nose	· Too high cutting load · Inappropriate insert grade	· Change to harder grade · Reduce f and ap
Crack from Wear	 · Surface finish's sudden deterioration · Workpiece dimension changes	· Too high Vc	· Change the tool earlier · Change to higher wear resistant grade
Chipping	 · Cutting force increase · Surface roughness deterioration	· Too high f · Chattering · Lack of insert toughness	· Reduce f and ap · Change to more rigid toolholder · Change to tougher grade
Crack from Welding or Built-up Edge	 · Surface finish deterioration · Cutting force increase	· Too low Vc	· Increase Vc · Improve sharp cutting performance (rake angle, chamfer)
Mechanical Fracture	 · Sudden cracking · Unstable tool life	· Too high f and ap · Chattering	· Change to tougher grade · Enlarge chamfer · Enlarge Corner-R(r_c) · Change to more rigid toolholder
Fracture from Thermal Crack	 · Cracking by heat cycle · Possible in interrupted machining and milling	· Too high Vc and f	· Reduce f · Reduce Vc · Change to dry cutting
Flaking	 · Possible in hard materials machining · Possible in machining with chattering	· Lack of insert toughness · Poor rigidity of toolholder	· Change to tougher grade (TiC-base ceramic to CBN.) · Change to more rigid toolholder · Change edge preparation

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Technical Information

Turning

Trouble	Countermeasures	Check Item	Insert Grades				Cutting Conditions				Tool Geometry					Setting			Machine		
			Change to Harder Grade	Change to Tougher Grade	Change to More Thermal Shock Resistant Grade	Change to More Welding Resistant Grade	Vc	f	ap	Coolant	Tool Path Review	Chipbreaker Review	Rake Angle	Corner-R(r _c)	Approach Angle	Edge Strength / Honing	Change to Higher Tolerance (M→G)	Toolholder Rigidity	Workpiece / Tool Installation	Overhang Length	Power, Rigidity
Unstable Dimension	Unstable Workpiece Dimension	Unsuitable Insert Tolerance														●					
		Tool and Workpiece Evacuation									●	●↑	●↓	●↓			●	●	●	●	
	Frequent Offset during Machining	Flank Wear Increase	●										●↑								
		Unsuitable Cutting Conditions					●↓	●↑													
Surface roughness deterioration	Poor Surface Roughness	Built-up Edge			●	●↑															
		Poor Cutting by Tool Wear	●		●	●↓			●		●	●↑	●↑	●↓	●						
		Chipping		●			●↓	●↓			●		●↑	●↑				●	●	●	
		Welding, Built-up Edge			●	●↑			●		●	●↑		●↓	●						
		Unsuitable Cutting Conditions					●↑	●↓	●↓	●											
		Unsuitable Tool Geometry									●		●↑	●↓	●						
Heat	Deterioration of Accuracy or Tool Life by Cutting Heat	Vibration, Chattering		●		●↓	*1	●↓		●	●↑	●↓	●↓	●↓		●	●	●	●		
		Unsuitable Cutting Conditions					●↓	●↓	●↓	●											
Burr, Workpiece Chip Off and Scuffing	Burr	Unsuitable Insert Grades and Tool Geometry	●							●	●↑		●↓								
		Unsuitable Cutting Conditions					●↓	●↑		●	●										
	Workpiece Chip Off	Unsuitable Cutting Conditions					●↓	●↓	●								●	●	●	●	
		Unsuitable Insert Grades and Tool Geometry	●								●	●↑	●↑	●↑	●↓		●	●	●	●	
	Scuffing	Unsuitable Cutting Conditions					●↑	*2	●↓		●										
Unsuitable Insert Grades and Tool Geometry		●		●						●	●↑		●↓								
Edge Damage	Wear Increase at Relief Face, Rake Face	Flank Wear	●			●↓			●	●	●↑	●↑	●↓								
		Rake Face Wear	●			●↓	●↓	●↓	●	●	●↑		●↑								
	Notching			●	●↓			●													
	Chipping		●			●↓	●↓			●		●↑	●↑		●	●	●	●	●		
	Crack		●	●		●↓	●↓			●		●↑	●↑	●↑		●	●	●	●		
	Thermal Crack			●		●↓	●↓	●↓	●	●	●↑		●↓								
	Edge Nose Deformation	●				●↓	●↓	●↓		●	●↓	●↑	●↑	●↑							
Chip Control	Long, Tangling Chips	Work Hardness, Unsuitable Insert Grades and Cutting Conditions			●	●↑	●↑		●		●	●↑	●↓	●							
		Unsuitable Cutting Conditions					*3	●↑	●↑	●											
	Chips scattering	Unsuitable Cutting Conditions					●↓	●↓		●											
		Unsuitable Tool Geometry								●		●↑	●↑								

*1) To prevent chattering, the higher f may be suitable.

*2) To prevent scuffing, the higher f may be suitable.

*3) When using X-chipbreaker insert for soft steel and low carbon steel, the higher Vc cuts chips short.



Trouble shooting

Milling

Trouble	Check Item	Insert Grades				Cutting Conditions				Tool Geometry						Setting		Machine									
		Countermeasures	Change to Harder Grade	Change to Tougher Grade	Change to More Thermal Shock Resistant Grade	Change to More Welding Resistant Grade	Vc	fz	ap	Cutter Dia. Cutting Width Review	Tool Path Review	Coolant		Relief Angle	Corner Angle	Edge Strength / Honing	No. of Inserts		Chip pocket	Wiper Edge (Relief Angle) Review	Insert Runout Check	Cutter Rigidity	Workpiece / Tool Installation	Overhang Length	Power, Rigidity		
												Usage of Mist	Dry													Larger Smaller	More Less
Edge Damage	Flank Wear Increase	Unsuitable Cutting Conditions				●↓						●															
		Unsuitable Tool Geometry	●											●↑		●↓				●							
	Rake Face Wear Increase	Unsuitable Cutting Conditions				●↓	●↓	●↓				●															
		Unsuitable Tool Geometry	●											●↑	●↑	●↓											
	Chipping, Cracking	Unsuitable Cutting Conditions					●↓	●↓		●	●																
		Unsuitable Tool Geometry		●											●↓	●↑	●↑				●	●	●	●	●	●	●
	Edge Breakage by Thermal Shock	Unsuitable Cutting Conditions				●↓	●↓	●↓																			
		Unsuitable Tool Geometry			●										●↑		●↓										
	Built-up Edge	Unsuitable Cutting Conditions				●↑	●↑						●														
		Unsuitable Tool Geometry						●							●↑		●↓										
	Cutting Accuracy	Poor Surface Finish	Unsuitable Cutting Conditions				●↑	●↓	●↓				●														
			Unsuitable Tool Geometry	●		●											●↓	●↓			●	●		●	●	●	●
Burr formation		Unsuitable Cutting Conditions				●↓	●↓	●↓	●	●																	
		Unsuitable Tool Geometry												●↑	●↓	●↓				●							
Workpiece Chip Off		Unsuitable Cutting Conditions					●↓	●↓				●															
		Unsuitable Tool Geometry												●↑	●↑	●↓	●↑			●							
Poor Planeness / Parallelness	Tool and Workpiece Evacuation					●↓	●↓					*5●		●	●↑	●↓	●↓	●↓		●	●	●	●	●	●		
Others	Heavy Chattering, Vibration	Unsuitable Cutting Conditions, Installation				●↓	*1↓	*2↓		●	*4●			●	●↑	●↓	●↓	●↓				●	●	●	●	●	
		Unsuitable Cutting Conditions				●↑	*3↓			●			*6●	●													
	Damaging Chips	Unsuitable Tool Geometry												●	●↑			●↓	●↑								

- *1) To prevent chattering, the higher fz may be suitable.
- *2) To prevent chattering, the larger ap may be suitable.
- *3) Higher fz may be suitable.
- *4) Down-cut method is recommended for helical end milling.
- *5) If the surface is warped by cutting heat.
- *6) Compressed air is recommended.

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Technical Information

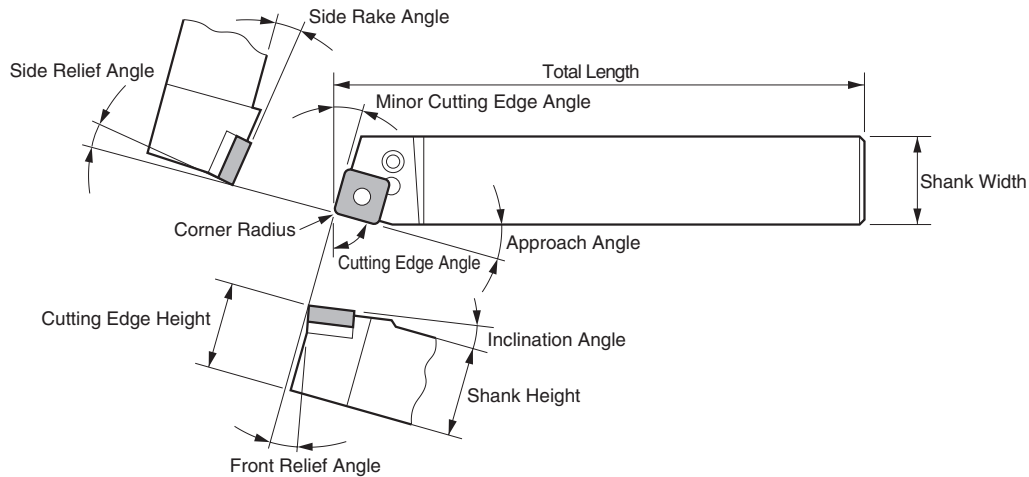
Drilling

Trouble	Countermeasures	Check Item		Insert Grades		Cutting Conditions		Tool Geometry			Setting			Machine
		Change to Harder Grade	Change to Tougher Grade	Vc	f	Coolant Discharge Condition	Chipbreaker Review	Inner Edge's Center Height Check (Core Dia. Check)	Toolholder Rigidity Improvement (Short Type)	Workpiece / Tool Installation	Insert Installation	Offset Check	Adjustable Sleeve Usage	Power, Rigidity
Trouble Item														
Edge Damage	Unusual Wear	Unsuitable Cutting Speed (too high)	●		● ↓									
		Unsuitable Cutting Speed (too low)		●	● ↑									
		Unsuitable Coolant Discharge					●							
		Poor Rigidity of Machine / Workpiece								●				●
		Small Hole Dia.										↑1	●	
		Unsuitable Insert Grade	●											
	Inner Edge Cracking	No core, Too Small Core							● ↑					
		Poor Rigidity of Machine / Workpiece								●	●			●
		Unstable Drilling Start				● ↓								
		High Hardness Workpiece	●		● ↓	● ↓								
		Clogged Chips			● ↑				● ↓					
		Unstable Insert Installation									●			
	Outer Edge Cracking	Poor Rigidity of Machine / Workpiece									●			●
		Unstable Drilling Start				● ↓								
		High Hardness Workpiece	●		● ↓	● ↓								
Poor Chip Control			●	● ↑										
Unstable Insert Installation										●				
Toolholder, Others	Scratches on Tool Body	Poor Rigidity of Machine / Workpiece								●				●
		Inaccurate Tool Installment										↑1	●	
		Clogged Chips			● ↑	● ↓								
		Unstable Drilling Start				● ↓								
	Poor Hole Dia. Accuracy / Surface Finish	Poor Rigidity of Machine / Workpiece									●			●
		Poor Rigidity of Toolholder								●	●			
		Inaccurate Tool Installment										↑1	●	
		Clogged Chips			● ↑	● ↓			● ↓					
		Large Core Dia.							● ↓					
		Unstable Drilling Start				● ↓								
		Unsuitable Coolant Discharge					●				●			
	Large Vibration / Chattering	Unsuitable Cutting Conditions, Installation			● ↑	● ↓					●	●		●
		Unsuitable Cutting Conditions			● ↑									
Long Chips	Unsuitable Chipbreaker							●						
	Lack of Machine Power			● ↓	● ↓			●					●	

*1) For lathe operation

Terms and Angles of Toolholder

Terms and Angles of Turning Toolholder



Function of Tool Angle

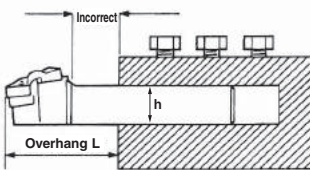
Tool Angle	Name	Function	Effect
Rake Angle	Side Rake Angle	Affects cutting force, cutting heat, chip evacuation and tool life.	·If it is positive (+) angle, sharper cutting performance is obtained. (less cutting force, less edge strength) ·Positive (+) angle is recommended for easy to machine workpieces or thin workpieces. ·Smaller rake angle or negative (-) angle is recommended when a stronger edge is required like scale machining or interrupted machining.
	Inclination Angle		
Relief Angle	Front Relief Angle	Prevents the tool's contact to the workpiece surface, except the cutting edge.	When it is small, the cutting edge becomes strong, but the wear at relief faces may shorten the tool life.
	Side Relief Angle		
Cutting Edge Angle	Cutting Edge Angle	Affects chip control and the direction of cutting force.	When it is large, chip thickness becomes thick and chip control improves.
	Approach Angle	Affects chip control and the direction of cutting force.	When it is large, chip thickness becomes thin and chip control worsens, but cutting force is dispersed and edge strength improves. When it is small, chip control ability improves.
	Minor Cutting Edge Angle	Prevents friction between cutting edge and workpiece surface.	When it is large, edge strength deteriorates.

R

Toolholder Rigidity

1. Flexure of Toolholder

$$\delta = \frac{4 \times F \times L^3}{E \times b \times h^3} = \frac{4 \times k \times a_p \times f \times L^3}{E \times b \times h^3}$$



Symbol	Name	Unit
δ (Delta)	Deflection	mm
b	Shank Width	mm
h	Shank Height	mm
E	Young ratio	N/mm ²
a_p	Depth of Cut	mm
f	Feed Rate	mm/rev
k	Specific Cutting Force	N/mm ²
L	Overhang	mm
F	Cutting force	N

(F=k×ap×f)

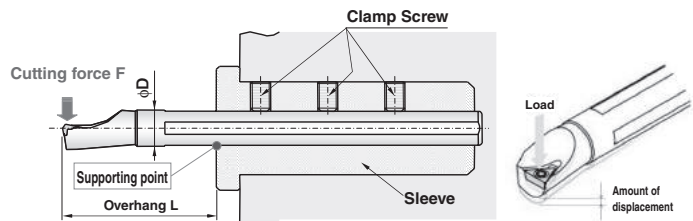
The flexural strength of toolholder will decrease by increasing of shank height by third root and will decrease of reducing overhang by third root. Minimizing toolholder shank overhang as much as possible is important as well as shank's sectional square measure.

2. Flexure of Boring Bar

$$\delta = \frac{64 \times F \times L^3}{3 \times E \times \pi \times D^4} = \frac{64 \times k \times a_p \times f \times L^3}{3 \times E \times \pi \times D^4}$$

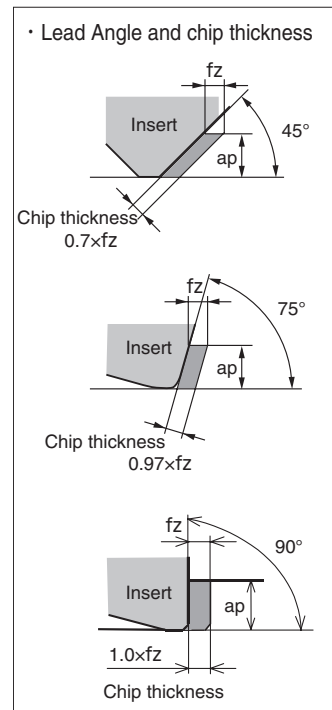
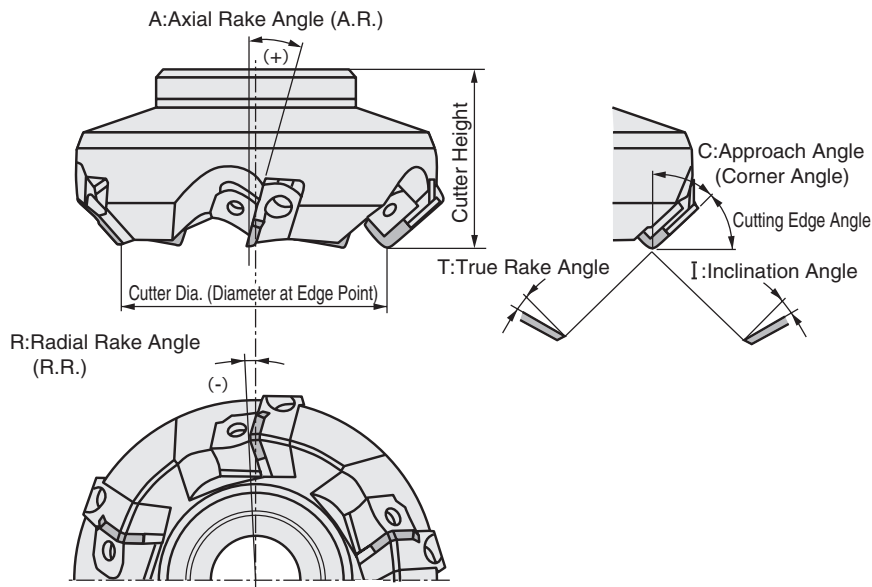
Symbol	Name	Unit
δ (Delta)	Deflection	mm
D	Shank Dia.	mm
E	Young ratio	N/mm ²
a_p	Depth of Cut	mm
f	Feed Rate	mm/rev
k	Specific Cutting Force	N/mm ²
L	Overhang	mm
F	Cutting force	N

(F=k×ap×f)



Technical Information

Terms and Angles of Milling Cutter



Function of Tool Angle

Symbol	Name	Function	Effect
A	Axial Rake Angle (A.R.)	Controls chip flow direction and cutting force	When it is positive ... Good cutting performance and less chip welding
R	Radial Rake Angle (R.R.)	Controls chip flow direction and cutting force	When it is negative ... Good chip evacuation
C	Approach Angle	Controls chip thickness and chip flow direction	When it is large ... Thinner chip thickness Lower cutting load
T	True Rake Angle	Actual rake angle	When it is positive ... Good cutting performance and less chip welding, but lower edge strength When it is negative ... Higher edge strength but easier to weld
I	Inclination Angle	Controls chip flow direction	When it is positive ... Good chip evacuation Less cutting force Lower edge stability of the corner part

The Formula for True Rake Angle : $\tan T = \tan R \times \cos C + \tan A \times \sin C$

The Formula for Inclination Angle : $\tan I = \tan A \times \cos C + \tan R \times \sin C$

No. of Inserts (Z)

1) If the number of stage is one

If the number of stage is one, it is not indicated on the catalogue.
Please use "No. of inserts" of the catalogue for "Z" of the formula to calculate cutting conditions.

2) If the number of stages is more than two

If the number of stages is more than two, it is indicated on the catalogue.
Please use "No. of flutes" of the catalogue for "Z" of the formula to calculate cutting conditions.

MECX End Mill

Toolholder Dimensions

Description	Std.	No. of Inserts	φD
MECX 08-S10-07-1T	●	1	8

$fz = \frac{Vf}{Z \times n} \Rightarrow Vf = fz \times Z \times n$

MSR

Toolholder Dimensions (Metric)

Description	Std.	No. of Inserts	No. of Flutes	No. of Stages	φD	φD1	φd
MSR 063R-1M	●	4	1	1	63	50	27
063R-2M	●	8	2	2			
080R-1M	●	4	1	1			

$fz = \frac{Vf}{Z \times n} \Rightarrow Vf = fz \times Z \times n$

R



Technical Information

Basic Formulas

Turning

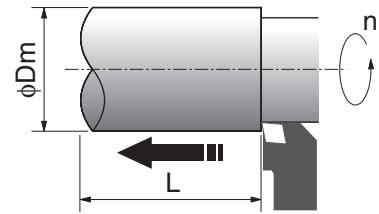
Cutting Speed

$$V_c = \frac{\pi \times D_m \times n}{1,000}$$

V_c : Cutting speed [m/min]

D_m : Workpiece Dia. [mm]

n : Spindle Revolution [min^{-1}]



Power Requirement

$$P_c = \frac{K_s \times V_c \times a_p \times f}{6,120 \times \eta}$$

P_c : Power Requirement [kW]

P_{HP} : Power Requirement (Horse Power) [HP]

V_c : Cutting speed [m/min]

a_p : Depth of Cut [mm]

f : Feed Rate [mm/rev]

K_s : Specific Cutting Force [kgf/mm²]

η : Mechanical Efficiency (0.7~0.8)

Ks Figure (kgf/mm ²)	
Low Carbon Steel	190
Medium Carbon Steel	210
High Carbon Steel	240
Low Alloy Steel	190
High Alloy Steel	245
Cast Iron	93
Malleable Cast Iron	120
Bronze, Brass	70

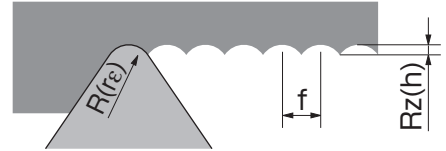
Theoretical Surface Roughness

$$R_z(h) = \frac{f^2}{8 \times R(r\epsilon)} \times 1,000$$

$R_z(h)$: Theoretical Surface Roughness [μm]

f : Feed Rate [mm/rev]

$R(r\epsilon)$: Corner Radius of Insert [mm]



Chip Removal Volume

$$Q = V_c \times a_p \times f$$

Q : Chip Removal Volume [$\text{cm}^3/\text{min} = \text{cc}/\text{min}$]

V_c : Cutting speed [m/min]

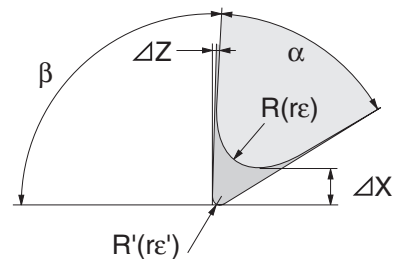
a_p : Depth of Cut [mm]

f : Feed Rate [mm/rev]

Edge Position Compensation

$$\Delta X = (R - R') \times \left\{ \frac{\cos\left(\frac{\alpha}{2} + (\beta - 90^\circ)\right)}{\sin\frac{\alpha}{2}} - 1 \right\}$$

$$\Delta Z = (R - R') \times \left\{ \frac{\sin\left(\frac{\alpha}{2} + (\beta - 90^\circ)\right)}{\sin\frac{\alpha}{2}} - 1 \right\}$$



ΔX : X-axis Direction Edge Position Compensation [mm]

ΔZ : Z-axis Direction Edge Position Compensation [mm]

R : Corner-R before Change [mm]

R' : Corner-R after Change [mm]

α : Insert Corner Angle [°]

β : Toolholder's Cutting Edge Angle [°]

Toolholder Type	Insert Corner Angle α	Cutting Edge Angle β	ΔX	ΔZ
DCLN/PCLN	80°	95°	$0.100 \times (R - R')$	$0.100 \times (R - R')$
DTGN/PTGN	60°	91°	$0.714 \times (R - R')$	$0.030 \times (R - R')$
DDJN/PDJN	55°	93°	$0.866 \times (R - R')$	$0.099 \times (R - R')$
DDHN/PDHN	55°	107.5°	$0.531 \times (R - R')$	$0.531 \times (R - R')$
DVLN/PVLN	35°	95°	$2.072 \times (R - R')$	$0.273 \times (R - R')$
DVPN/PVPN	35°	117.5°	$1.351 \times (R - R')$	$1.351 \times (R - R')$
DSBN/PSBN	90°	75°	$0.225 \times (R - R')$	$-0.293 \times (R - R')$

Example: Compensation when changing corner-R from 0.8 to 0.4, using PCLN type toolholder,

$$\Delta X = 0.100 \times (0.8 - 0.4) = 0.04(\text{mm})$$

$$\Delta Z = 0.100 \times (0.8 - 0.4) = 0.04(\text{mm})$$

R



Technical
Information

Turning (Cutting Time)

Cutting Time (External Turning Case 1: 1 Pass machining)

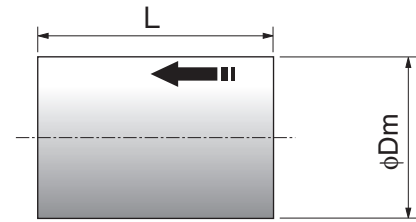
- At Constant Revolution

$$T = \frac{60 \times L}{f \times n}$$

- At Constant Cutting Speed

$$T = \frac{60 \times \pi \times L \times D_m}{1,000 \times f \times V_c}$$

T : Cutting Time [second]
 L : Cutting Length [mm]
 f : Feed Rate [mm/rev]
 n : Spindle Revolution [min^{-1}]
 D_m : Workpiece Dia. [mm]
 V_c : Cutting speed [m/min]



Cutting Time (External Turning Case 2: Multi-Pass machining)

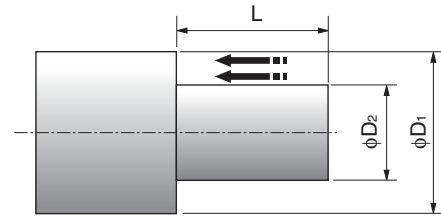
- At Constant Revolution

$$T = \frac{60 \times L}{f \times n} \times N$$

- At Constant Cutting Speed

$$T = \frac{60 \times \pi \times L \times (D_1 + D_2)}{2 \times 1,000 \times f \times V_c} \times N$$

T : Cutting Time [second]
 L : Cutting Length per Pass [mm]
 a_p : Depth of Cut per Pass [mm]
 f : Feed Rate [mm/rev]
 n : Spindle Revolution [min^{-1}]
 D_1 : Max. Dia. of Workpiece [mm]
 D_2 : Min. Dia. of Workpiece [mm]
 V_c : Cutting speed [m/min]
 N : Number of Passes = $(D_1 - D_2) / a_p / 2$
 (if it is indivisible, obtain integer by rounding up one place of decimals.)



Cutting Time (Facing)

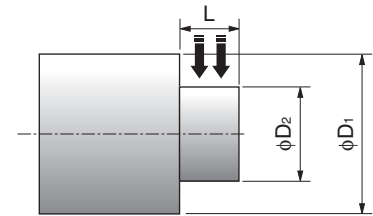
- At Constant Revolution

$$T = \frac{60 \times (D_1 - D_2)}{2 \times f \times n} \times N$$

- At Constant Cutting Speed

$$T = \frac{60 \times \pi \times (D_1 + D_2) \times (D_1 - D_2)}{4,000 \times f \times V_c} \times N$$

T : Cutting Time [second]
 T_1 : Cutting Time before reaching
 Max. Spindle Revolution [second]
 L : Cutting Length [mm]
 a_p : Depth of Cut per Pass [mm]
 f : Feed Rate [mm/rev]
 n : Spindle Revolution [min^{-1}]
 D_1 : Max. Dia. of Workpiece [mm]
 D_2 : Min. Dia. of Workpiece [mm]
 V_c : Cutting speed [m/min]
 N : Number of Passes = L / a_p
 (if it is indivisible, obtain integer by rounding up one place of decimals.)



Cutting Time (Grooving)

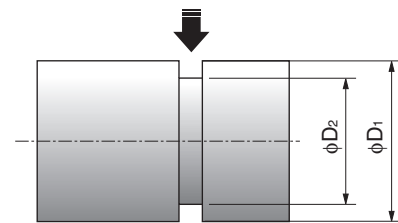
- At Constant Revolution

$$T = \frac{60 \times (D_1 - D_2)}{2 \times f \times n}$$

- At Constant Cutting Speed

$$T = \frac{60 \times \pi \times (D_1 + D_2) \times (D_1 - D_2)}{4,000 \times f \times V_c}$$

T : Cutting Time [second]
 T_1 : Cutting Time before reaching
 Max. Spindle Revolution [second]
 L : Cutting Length [mm]
 f : Feed Rate [mm/rev]
 n : Spindle Revolution [min^{-1}]
 D_1 : Max. Dia. of Workpiece [mm]
 D_2 : Min. Dia. of Workpiece [mm]
 V_c : Cutting speed [m/min]



Cutting Time (Cut-Off)

- At Constant Revolution

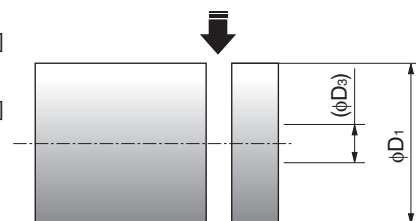
$$T = \frac{60 \times D_1}{2 \times f \times n}$$

- At Constant Cutting Speed

$$T_1 = \frac{60 \times \pi \times (D_1 + D_3) \times (D_1 - D_3)}{4,000 \times f \times V_c}$$

$$T_3 = T_1 + \frac{60 \times D_3}{2 \times f \times n_{\max}}$$

T : Cutting Time [second]
 T_1 : Cutting Time before reaching
 Max. Spindle Revolution [second]
 T_3 : Cutting Time when reaching
 Max. Spindle Revolution [second]
 f : Feed Rate [mm/rev]
 n : Spindle Revolution [min^{-1}]
 n_{\max} : Max. Spindle Revolution [min^{-1}]
 D_1 : Max. Dia. of Workpiece [mm]
 D_3 : Diameter when reaching
 Max. Spindle Revolution [mm]
 V_c : Cutting speed [m/min]



R



Technical Information

Basic Formulas

Milling

Cutting Speed

$$V_c = \frac{\pi \times D_c \times n}{1,000}$$

V_c : Cutting speed [m/min]

D_c : Cutter Dia. [mm]

n : Spindle Revolution [min^{-1}]

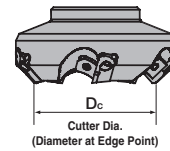


Table Feed & Feed per Tooth

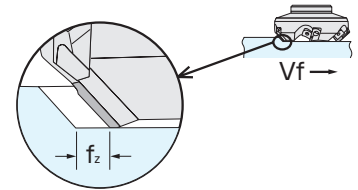
$$f_z = \frac{V_f}{Z \times n}$$

f_z : Feed per Tooth [mm/t]

V_f : Table Feed [mm/min]

Z : No. of Inserts

n : Spindle Revolution [min^{-1}]



Power Requirement

$$P_c = \frac{K_s \times Q}{6,120 \times \eta} = \frac{K_s \times a_e \times V_f \times a_p}{6,120,000 \times \eta}$$

$$= \frac{K_s \times a_e \times f_z \times Z \times n \times a_p}{6,120,000 \times \eta}$$

$$P_{HP} = \frac{6,120}{4,500} \times P_c$$

P_c : Power Requirement [kW]

P_{HP} : Power Requirement (Horse Power) [HP]

a_e : Width of Cut [mm]

V_f : Table Feed [mm/min]

f_z : Feed per Tooth [mm/t]

Z : No. of Inserts

n : Spindle Revolution [min^{-1}]

a_p : Depth of Cut [mm]

K_s : Specific Cutting Force [kgf/mm²]

η : Mechanical Efficiency (0.7~0.8)

Q : Chip Removal Volume [cm³/min=cc/min]

Ks Figure (kgf/mm ²)	
Low Carbon Steel	190
Medium Carbon Steel	210
High Carbon Steel	240
Low Alloy Steel	190
High Alloy Steel	245
Cast Iron	93
Malleable Cast Iron	120
Bronze, Brass	70

Chip Removal Volume

$$Q = \frac{a_e \times V_f \times a_p}{1,000} = \frac{a_e \times f_z \times Z \times n \times a_p}{1,000}$$

Q : Chip Removal Volume [cm³/min=cc/min]

a_e : Width of Cut [mm]

V_f : Table Feed [mm/min]

f_z : Feed per Tooth [mm/t]

Z : No. of Inserts

n : Spindle Revolution [min^{-1}]

a_p : Depth of Cut [mm]

Cutting Time

$$T = \frac{60 \times L'}{V_f} = \frac{60 \times L'}{f_z \times Z \times n}$$

T : Cutting Time [second]

L' : Total Table Transfer Length [mm]
($=L + D_s + 2\alpha$)

L : Workpiece Length [mm]

D_s : Cutter Dia. [mm]

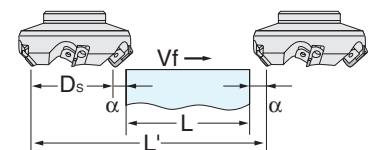
α : Idling Distance [mm]

V_f : Table Feed [mm/min]

f_z : Feed per Tooth [mm/t]

Z : No. of Inserts

n : Spindle Revolution [min^{-1}]



R



Technical Information

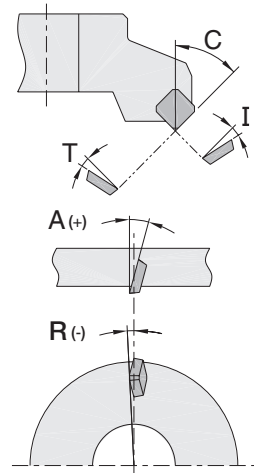
● True Rake Angle

$$\tan T = \tan R \times \cos C + \tan A \times \sin C$$

● Inclination Angle

$$\tan I = \tan A \times \cos C - \tan R \times \sin C$$

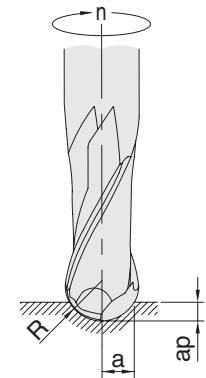
- A : Axial Rake Angle (A.R.) [°] (-90° < A < 90°)
- R : Radial Rake Angle (R.R.) [°] (-90° < R < 90°)
- C : Approach Angle [°] (0° < C < 90°)
- T : True Rake Angle [°] (-90° < T < 90°)
- I : Inclination Angle [°] (-90° < I < 90°)



● Ball-Nose End Mill Cutting Speed & Revolution

$$n = \frac{1,000 \times V_a}{2 \times \pi \times \sqrt{a(2R - a)}}$$

- n : Revolution [min⁻¹]
- R : Radius of Ball-Nose End Mill (Ball Part's radius [mm])
- a_p : Depth of Cut [mm]
- V_a : Cutting Speed at Point "a" [m/min]



■ Drilling

● Cutting Speed

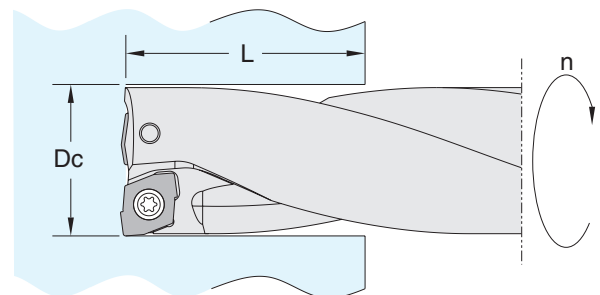
$$V_c = \frac{\pi \times D_c \times n}{1,000}$$

- V_c : Cutting speed [m/min]
- D_c : Drill Dia. [mm]
- n : Spindle Revolution [min⁻¹]

● Feed Rate (Milling)

$$V_f = f_z \times Z \times n$$

- V_f : Table Feed [mm/min]
- f_z : Feed per Tooth [mm/t]
- Z : No. of Inserts (No. of Insert = 1)
- n : Spindle Revolution [min⁻¹]



● Cutting Time

$$T = \frac{60 \times L}{f \times n} = \frac{60 \times \pi \times D_c \times L}{1,000 \times V_c \times f}$$

- T : Cutting Time [second]
- L : Drilling Depth [mm]
- f : Feed Rate [mm/rev]
- n : Spindle Revolution [min⁻¹]
- D_c : Drill Dia. [mm]
- V_c : Cutting speed [m/min]

● Power Requirement (Reference Value)

$$P_c = \frac{D_c}{20} \times \frac{V_c}{100} \times \left(1 + \left(\frac{2.5 \times f}{0.1} \right) \right)$$

- P_c : Power Requirement [kW]
- D_c : Drill Dia. [mm]
- V_c : Cutting speed [m/min]
- f : Feed Rate [mm/rev]

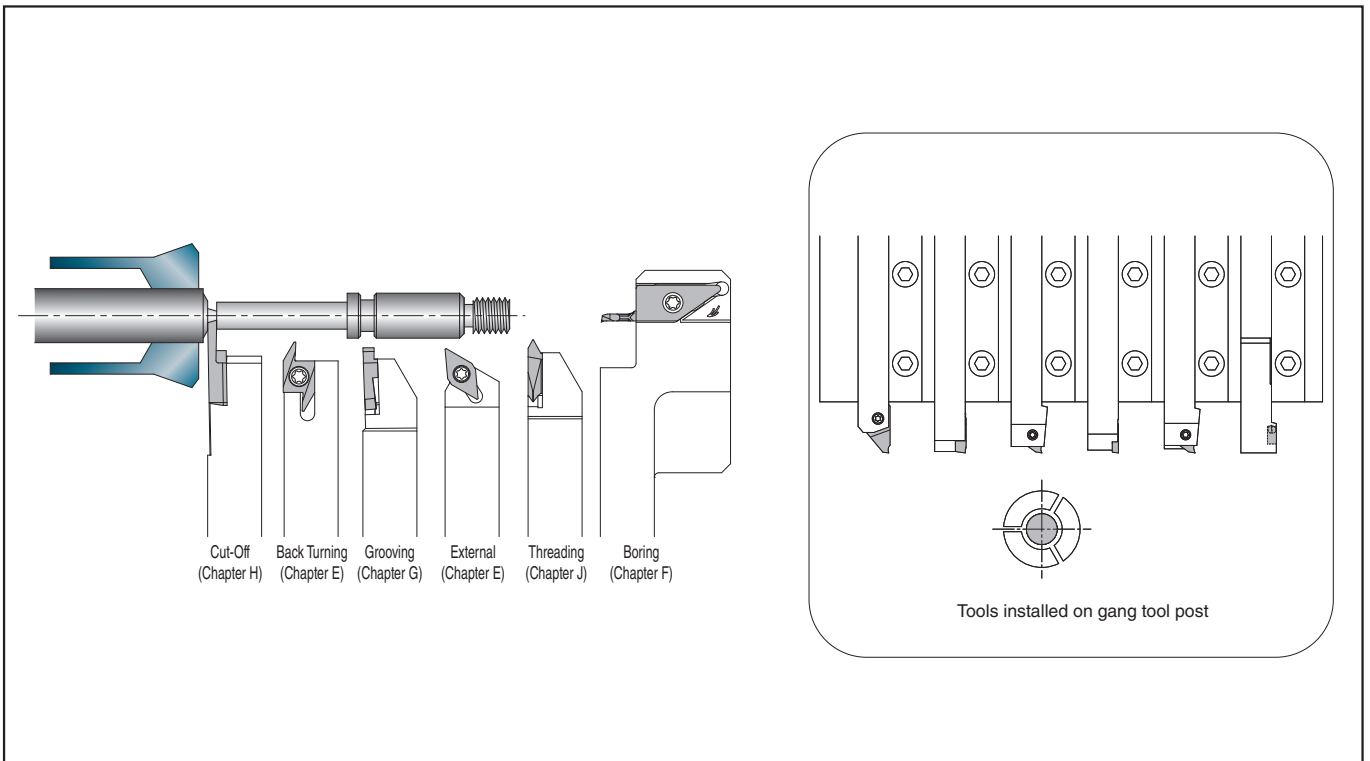
R



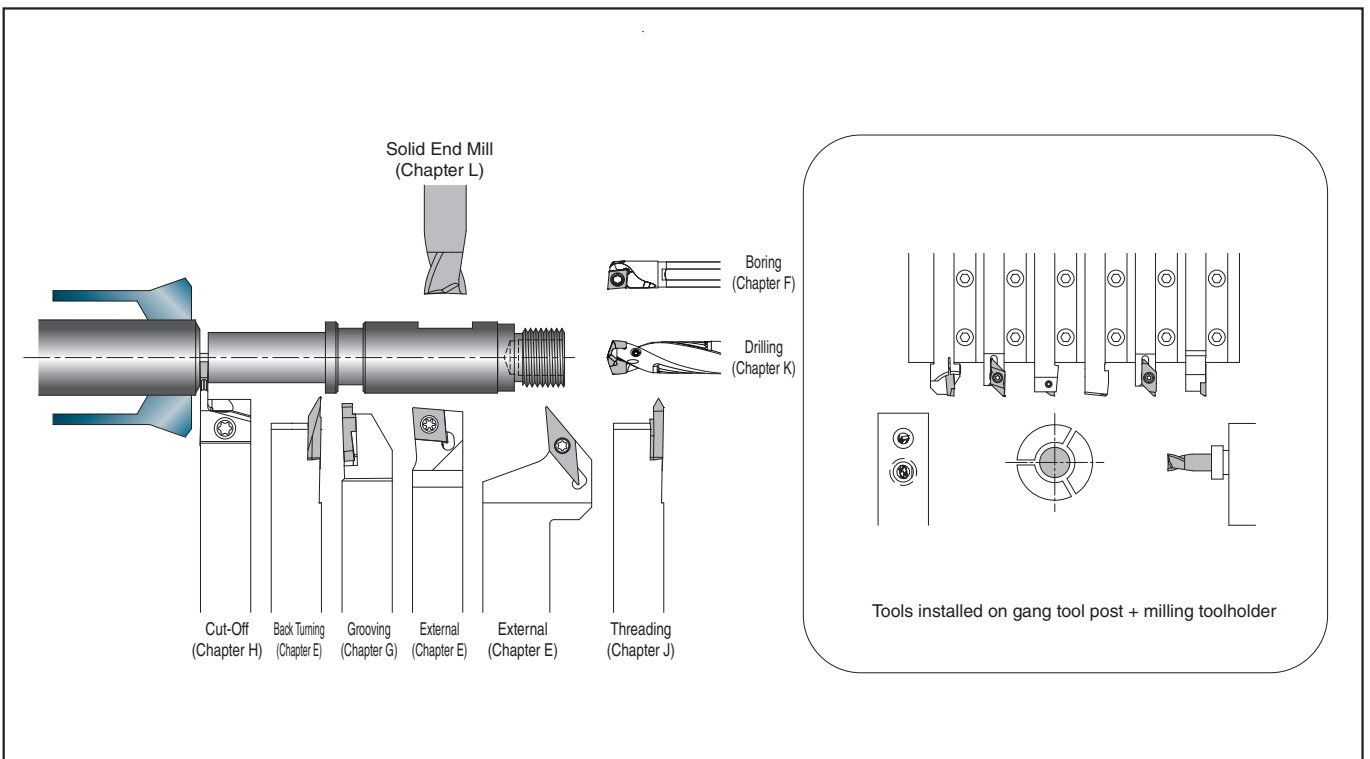
Technical Information

Tooling Examples of Small Tools

Tooling Example (1) CNC Automatic lathe (Gang Type)



Tooling Example (2) CNC Automatic lathe (Gang Type)

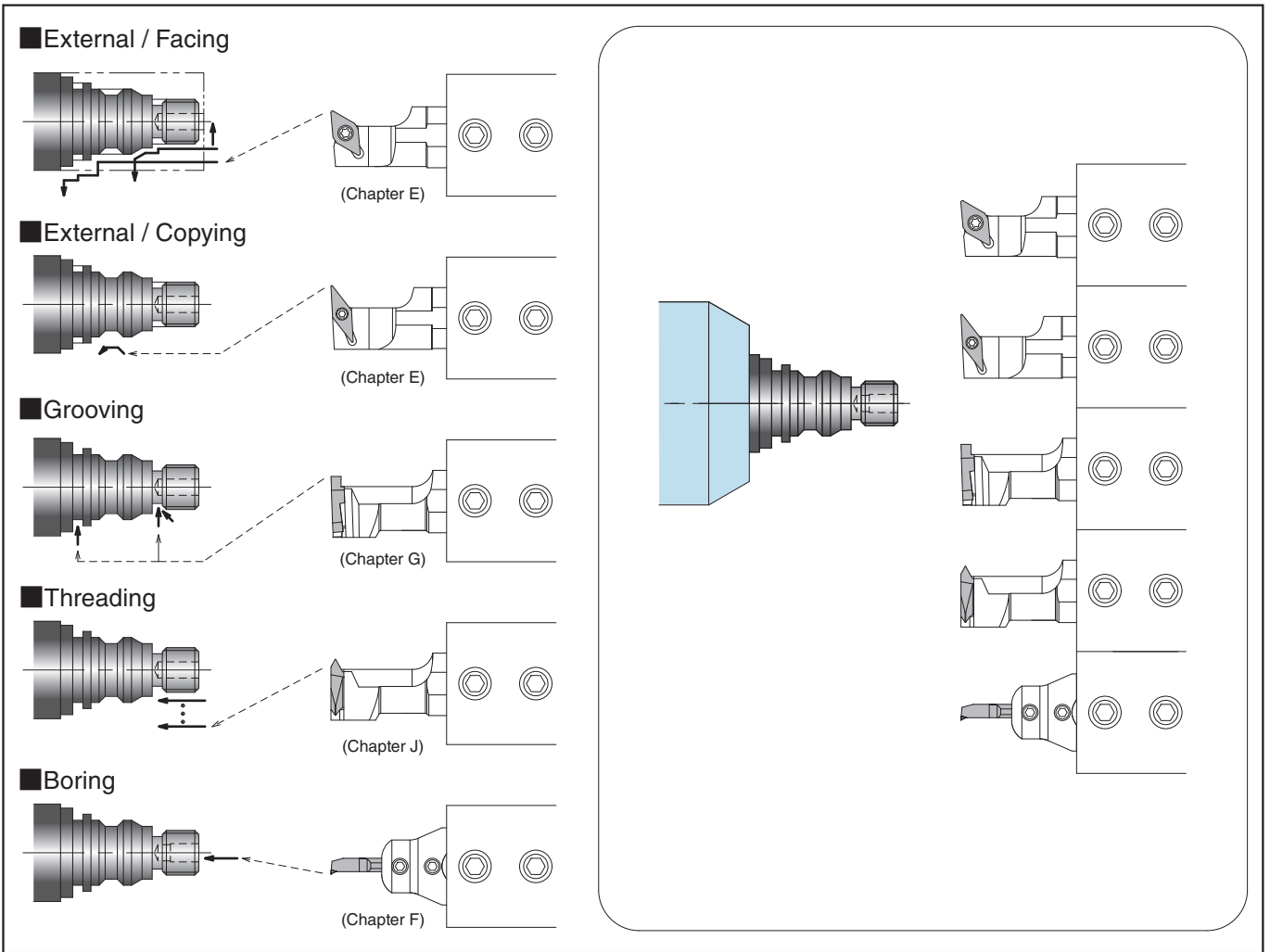


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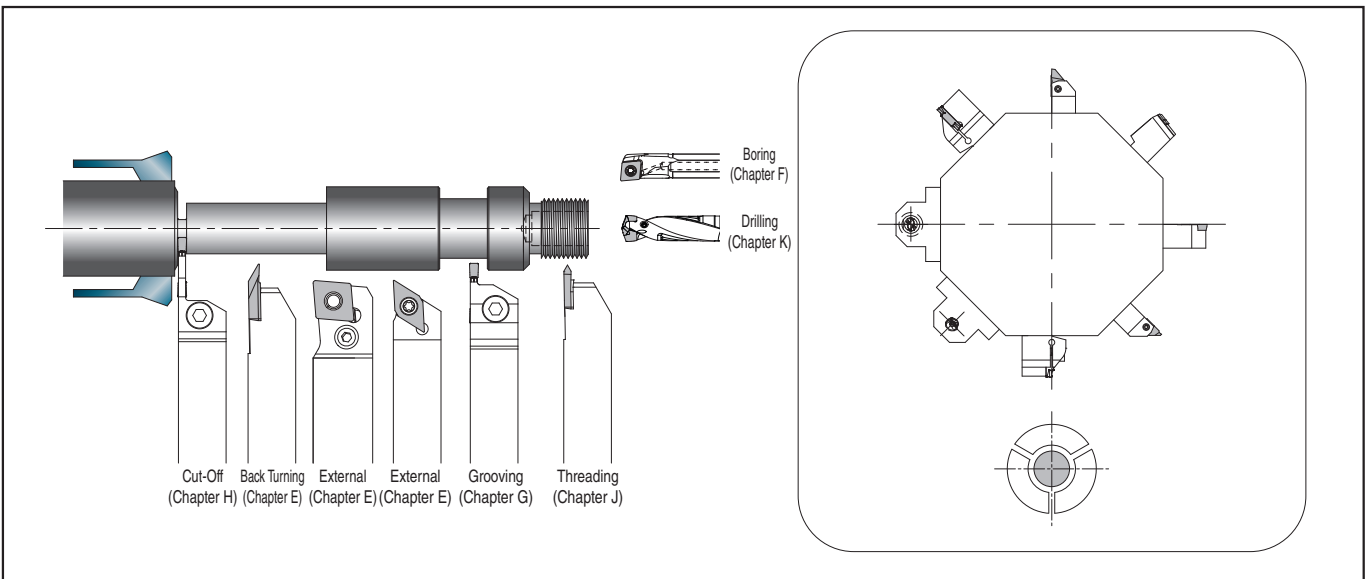


Technical Information

■ Tooling Example (3) CNC Automatic Lathe (Opposed Gang Type)



■ Tooling Example (4) CNC Automatic lathe (Turret Type)



Ref. to Page [R36~R43](#) for Tooling Layout and Automatic Lathe List by Manufacturer.

R



Technical Information

Automatic Lathe List by Manufacturer

Citizen Machinery (Cincom Products)

Model	Toolholder Dimensions (Gang tool post)	Number of tools	Toolholder Dimensions (Turret tool post)	Number of tools	Sleeve Dia. (Horizontal/ Opposed)	Number of tools	Max. Cutting Dia.	Remarks
A12/16	10×10×100	5			φ19.05/φ20		φ12/φ16	
A20	12(13)×12(13)×120 * Cut-off toolholder : □16mm	6			φ25.4		φ20	
A20Ⅶ	12(13)×12(13)×120 * Cut-off toolholder : □16mm	6			φ25.4		φ20	
A32	16×16×150	6			φ25.4		φ32	
B12	10×10×100	5			φ19.05/φ20		φ12	
B12E/B16E	10×10×120(60)	5			φ19.05(φ20 ^{OP})		φ12/φ16	
B20	12(13)×12(13)×120	6			φ19.05/φ20		φ20	
BL12	10×10×60~120	5			φ20(φ19.05)		φ12	
BL20/25	12(13)×12(13)×120	4~7			φ20(φ19.05)		φ20/φ25	
C12/16	10×10×120	6			φ19.05		φ12/φ16	
C32	16×16×130	5			φ25.4		φ32	
E16			10×10×60	20	φ19.05		φ16	
E20			16×16×90	20	φ25.4		φ20	
E25			16×16×90	20	φ25.4		φ25	
E32			16(19)×16(13)×90	20	φ25.4		φ32	
F10			10×10×60	10	φ19.05		φ10	
F12			10×10×60	10	φ19.05		φ12	
F16			10×10×60	10	φ19.05		φ16	
F20			16(19)×16(13)×90	10	φ25.4		φ20	
F25			16(19)×16(13)×90	10	φ25.4		φ25	
FL25			16×16×90	12	φ16		φ25	
FL42			16×16×90	12	φ16		φ42	
G32			16(19)×16(19)×90	10	-		φ32	
K12/16	12(10)×12(10)×100	6(7)			φ19.05/φ20		φ12/φ16	
K12E/K16E	12×12×120	6			φ19.05/φ20		φ12/φ16	
L10	8×8×100~130	5			φ15.875		φ10	
L12	10×10×100	6			φ19.05		φ12	
L16	12(10)×12(10)×130	5			φ19.05		φ16	
L20,L20E	12×12×130 * Cut-off toolholder : □16mm	5			φ19.05		φ20	
L20X,L220	12(13,16)×12(13,16)×120 * Cut-off toolholder : □16mm	5~7			φ19.05/φ25		φ20	
L25	16×16×130	5			φ25.4		φ25	
L32	16×16×130	5			φ25.4		φ32	
M ₂ 12,M ₃ 12	10×10×120	5	10×10×60	10+α	φ19.05		φ12	
M ₂ 16,M ₃ 16	10×10×120	5	10×10×60	10+α	φ19.05		φ16	
M ₂ 20,M ₃ 20	16×16×130	5	16×16×90	10+α	φ25.4		φ20	
M ₂ 32,M ₃ 32,M ₄ 32	16×16×130	5	16×16×90	10+α	φ25.4		φ32	
M ₄ 16	10×10×100	5	10×10×60	10+α	φ19.05		φ16	
M20	13(12)×13(12)×130	5	10×10×60	10+α	φ19.05		φ20	
MC20	12×12×120,13×13×120	2+2+2			φ19.05/φ31.0		φ20	
MSL12	10×10×120				-		φ12	
R04	8×8×120	5			φ15.875		φ4	
R07	8×8×120	5			φ15.875		φ7	
RL01	10(8)×10(8)×90				φ16(φ20)		φ10	
RL02	16×16×90				φ20		φ20	
RL21	10(12)×10(12)×90				φ19.05		φ35	

-Manufacturers are in no particular order.

R



Technical
Information

Citizen Machinery (Miyano Products)

Model	Toolholder Dimensions (Gang tool post)	Number of tools	Toolholder Dimensions (Turret tool post)	Number of tools	Sleeve Dia. (Horizontal/ Opposed)	Number of tools	Max. Cutting Dia.	Remarks
ABX-51SY2			20×20×125(100)	24	φ25	48	φ51	
ABX-51SYY2			20×20×125(100)	24	φ25	48	φ51	
ABX-51TH5			20×20×125(100)	36	φ25	72	φ51	
ABX-51THY2			20×20×125(100)	36	φ25	72	φ51	
ABX-64SY2			20×20×125(100)	24	φ25	48	φ64	
ABX-64SYY2			20×20×125(100)	24	φ25	48	φ64	
ABX-64TH5			20×20×125(100)	36	φ25	72	φ64	
ABX-64THY2			20×20×125(100)	36	φ25	72	φ64	
BNA-34C/C2			20×20×125(100)	8(16)	φ25	24	φ34	
BNA-34DHY			20×20×125(100)	14(22)	φ25	27	φ34	
BNA-34DHY2			20×20×125(100)	14(22)	φ25	27	φ34	
BNA-34S/S2			20×20×125(100)	8(16)	φ25	24	φ34	
BNA-42C/C2			20×20×125(100)	8(16)	φ25	24	φ42	
BNA-42DHY			20×20×125(100)	14(22)	φ25	27	φ42	
BNA-42DHY2			20×20×125(100)	14(22)	φ25	27	φ42	
BNA-42GTY	20×20×125(100)	3	20×20×125(100)	8(16)	φ25	24(7)	φ42	
BNA-42MSY2			20×20×125(100)	8(16)	φ25	24	φ42	
BNA-42S/S2			20×20×125(100)	8(16)	φ25	24	φ42	
BNC-42C7			20×20×125(100)	8(16)	φ25	24	φ42	
BND-51C2			20×20×125(100)	12	φ25	24	φ51	
BND-51S2			20×20×125(100)	12	φ25	24	φ51	
BND-51SY2			20×20×125(100)	12	φ25	24	φ51	
BNE-34S6			20×20×125(100)	24	φ25	48	φ34	
BNE-34SY6			20×20×125(100)	24	φ25	48	φ34	
BNE-42S6			20×20×125(100)	24	φ25	48	φ42	
BNE-42SY6			20×20×125(100)	24	φ25	48	φ42	
BNE-51S6			20×20×125(100)	24	φ25	48	φ51	
BNE-51SY6			20×20×125(100)	24	φ25	48	φ51	
BNE-51MSY			20×20×125(100)	24	φ25	48	φ51	
BNJ-34S3/S5			20×20×125(100)	18	φ25	30	φ34	
BNJ-34SY3			20×20×125(100)	18	φ25	30	φ34	
BNJ-34SY5			20×20×125(100)	18	φ25	30	φ34	
BNJ-42S3			20×20×125(100)	18	φ25	30	φ42	
BNJ-42S5			20×20×125(100)	18	φ25	30	φ34	
BNJ-42S6			20×20×125(100)	20	φ25	40	φ42	
BNJ-42SY3			20×20×125(100)	18	φ25	30	φ42	
BNJ-42SY5			20×20×125(100)	18	φ25	30	φ42	
BNJ-42SY6			20×20×125(100)	20	φ25	40	φ42	
BNJ-51S3/S5			20×20×125(100)	18	φ25	30	φ51	
BNJ-51SY3			20×20×125(100)	18	φ25	30	φ51	
BNJ-51SY5			20×20×125(100)	18	φ25	30	φ51	
BNJ-51SY6			20×20×125(100)	20	φ25	40	φ51	
GN-3200	12(16)×12(16)×70~120	4~5			φ20	4~5	φ40	
GN-3200W	12(16)×12(16)×70~120	4~5			φ20	4~5	φ40	
GN-4200	12(16)×12(16)×70~120	7~8			φ20	7~8	φ40	
LX-06E2			20×20×125(100)	8	φ32	8	φ31	
LX-08C			25×25×150	10	φ40	10	φ51	
LX-08E2			25×25×150	8	φ40	8	φ51	
LX-08R			20×20×125(100)	10	φ25	20	φ51	
LZ-01R2			20×20×125(100)	12	φ25	24	φ31	
LZ-01RY2			20×20×125(100)	12	φ25	24	φ31	
LZ-02R2			20×20×125(100)	10	φ25	20	φ51	
LZ-02RY2			20×20×125(100)	10	φ25	20	φ51	
RL01 III	10×10×70~120	2~3			φ16	2~3	φ10	
RL01 V	10×10×70~120	2~3			φ16	2~3	φ10	
RL03	12(16)×12(16)×70~120	4~5			φ20	4~5	φ40	

* Number of tools shown in parentheses is the maximum number of toolholder mountable including φ25 sleeves.

·Manufacturers are in no particular order.

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Automatic Lathe List by Manufacturer

Star Micronics

Model	Toolholder Dimensions (Gang tool post)	Number of tools	Toolholder Dimensions (Turret tool post)	Number of tools	Sleeve Dia. (Horizontal/Opposed)	Number of tools	Max. Cutting Dia.	Remarks
ECAS-12	10×10×95~150	6			φ22		φ13	
ECAS-20T			16×16×60~78(80~88)		φ22/φ32		φ20	
ECAS-32T			16×16×60~78(80~88)	10	φ22/φ32		φ32	
JNC-10			8×8×65	6			φ10	
JNC-16			10×10×80	6			φ16	
JNC-25/32			10×10×78~120	10	φ22		φ25/32	
KJR-16B/25B			16×16×78	12/16	φ22/φ32			
KNC-16/20			16×16×68	16	φ22			
KNC-25 II /32 II			16×16×78	20	φ22/φ32			
RNC-10	10×10×80~120	5			φ22			
RNC-16	10×10×80~120	5			φ22			
SA-16R	10×10×95~120	6			φ22			
SB-16 (A/C/D/E)	12×12×95~130	5			φ22/(φ22)	4/4		Only D/E for back clamp sleeves
	12(10)×12(10)×95~130	6			φ22/(φ22)	4/4		
SB-12 II (C/E)	12×12×95~130	6			φ22/(φ22)	4/4		Only E for back clamp sleeves
SB-16 II (C/E)	12(10)×12(10)×95~130	6			φ22/(φ22)	4/4		
SB-20 A/C/E	12×12×95~130	6			φ22/φ22	4/4		
SB-12R typeG	12×12×95~130	6			φ22/φ22	4/4	φ13	
	10×10×95~130	7			φ22/φ22	4/4		
SB-16R/20R typeN	12×12×95~130	6			φ22/φ22	4/4	φ16/φ23	
	10×10×95~130	7			φ22/φ22	4/4		
SB-16R/20R typeG	12×12×95~130	6			φ22/φ22	4/4	φ16/φ23	
	10×10×95~130	7			φ22/φ22	4/4		
SC20	12×12×95~130	5			φ22/-	4		
	10×10×95~130	6				4/4		
SE-12B/16B	10×10×95~120	5			φ22		φ13/16	
SG-42			16×16×84~88(71~82)		φ22/φ32		φ42	
			20×20×84~88					
SH-7	8×8×95~120	5			φ22		φ7	
SH-12/16	10×10×95~120	5			φ22		φ13/16	
SI-12/12C	10×10×80~130	6			φ22		φ13	
SR-10J	8×8×67~110 (Spacer is needed)	6			φ16	4		
SR-20R II	12×12×100~135	6		4	φ22/φ22	6/12	φ23	Toolpost for 2 toolholders (deep boring) on the front side
SR-20 III	12×12×95~135	6			φ22/φ22	6/12	φ23	
SR-20 IV typeA	12×12×100~130	7			φ22/φ22	6/12	φ23	
SR-20 IV typeB	12×12×100~130	7			φ22/φ22	6/12	φ23	
SR-25J/32J	16×16×95~155	6		4	φ22+φ32/φ22		φ32	
SR-38 typeB	16×16×95~135	4			φ22+φ32	5/ 13	φ38	
	16×16×100	2						
	20×20×105~135(Cut-Off)	1						
ST-20			12×12×73~79		φ22/φ32		φ20	
			12×12×65~73(Cut-Off)					
			16×16×64~73					
			16×16×65~73(Cut-Off)					
ST-38			16×16×83~88		φ22/φ32		φ32/φ38	
			16×16×71~82					
			16×16×84~88(Cut-Off)					
			20×20×84~88					
			20×20×84~88(Cut-Off)					
SV-38R	16×16×105~135	4	16×16×84~88		φ22/φ32	- / 8	φ32/φ38	
	20×20×115~135(Cut-Off)	1	16×16×71~82					
			20×20×84~88					
SV-12/20	12×12×95~135	5	12×12×70~78		φ22/φ32			
	16×16×95~135	4	16×16×65~70					
SV-32	16×16×95~135	4	16×16×60~78(80~88)		φ22/φ32		φ7	
SW-7	8×8×80~120	6						
SW-12R II	10×10×95~115	7			φ16/φ16+φ22	4/8	φ13	
SW-20	12×12×80~150	6			φ22	4/8	φ23	
	16×16×80~144							

Manufacturers are in no particular order.

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Tsugami

Model	Toolholder Dimensions (Gang tool post)	Number of tools	Toolholder Dimensions (Turret tool post)	Number of tools	Sleeve Dia. (Horizontal/Opposed)	Number of tools	Max. Cutting Dia.	Remarks
B0123-III	12×12×85	9			φ20/-	4/-	φ12	
B0124/125/126-III	12×12×85	9			φ20/φ20	4/4	φ12	
B0128W	12×12×85	9			φ20/φ20	4/4	φ12	
B0203-III	12×12×85	9			φ20/φ20	4/4	φ20	
B0204/205/206-III	12×12×85	9			φ20/φ20	4/4	φ20	
B0208W	12×12×85	9			φ20/φ20	4/4	φ20	
BW207J	12×12×85/16×16×85	5/2			φ20/φ20	5/4	φ20	
BW208J	12×12×85/16×16×85	5/2			φ20/φ20	5/4	φ20	
BW208ZJ	12×12×85/16×16×85	5/2			φ20/φ20	5/4	φ20	
BW209ZJ	12×12×85/16×16×85	5/2			φ20/φ20	5/4	φ20	
B0265/265B/266-II	16×16×100	12			φ25/φ25	5/4	φ26	
B0325/325B/326-II	16×16×100	12			φ25/φ25	5/4	φ32	
B0385/385L	20×20×125	8			φ32/φ32	3/5	φ38	
B038T			20×20×125	St.8	φ32/φ25		φ38	
B073/074-II	8×8×85	9			φ20	4	φ7	
BH20/BH20Z	12×12×85	4	12×12×85	St.12	φ25/φ32		φ20	
BH38	16×16×125	5	20×20×125	St.12	φ25/φ32		φ38.1	
BM163-III	12×12×85	9			φ20/-	4/-	φ16	
BM164/165-III	12×12×85	9			φ20/φ20	4/4	φ16	
C150/CH154	12×12×60~100	4~6					φ80	
C180	12×12×60~100	4~6					φ120	
C220/220T	12×12×60~100	6~8					φ120	
C300-IV	16×16×100~130	6~10					φ165	
C300H	16×16×100~130	6~10					φ165	
P013	8×8×100~120	6			φ16/-	3/-	φ1	
P013-II	8×8×100~120	6			φ16/-	3/-	φ1	
P014	8×8×100~120	6			φ16/φ16	3/3	φ1	
P014-II	8×8×100~120	6			φ16/φ16	3/3	φ1	
P033	8×8×100~120	6			φ16/-	3/-	φ3	
P033-II	8×8×100~120	6			φ16/-	3/-	φ3	
P034	8×8×100~120	6			φ16/φ16	3/3	φ3	
P034-II	8×8×100~120	6			φ16/φ16	3/3	φ3	
S205/206/SS207	12×12×100	8			φ22/φ20	5/4	φ20	
SS26	16×16×100	7			φ22/φ20	5/4	φ26	
SS32/32L	16×16×100	7			φ22/φ20	5/4	φ32	
SS20M					-/φ20	-/1	φ20	
SS267	16×16×100	7			φ22/φ20	5/4	φ26	
SS327	16×16×100	7			φ22/φ20	5/4	φ32	
MB25			20×20×90	2×St.8	φ20/φ32	5/4	φ25	
M42J/M42SD			20×20×125	St.12	φ25/φ32		φ42	
M50J/M50SY-III			20×20×100	St.12	φ20/φ32		φ51	
M06JC			20×20×125	St.8	φ25		φ220/φ42	
M06J-II			25×25×150	St.8	φ32/φ40		φ260/φ51	
M08J-II			25×25×150	St.8	φ32/φ40		φ280/φ65	
M06D			25×25×150	St.12	φ40		φ260/φ51	
M08D			25×25×150	St.12	φ40		φ280/φ65	
M06SD			25×25×150	St.12	φ40		φ260/φ51	
M08SD			25×25×150	St.12	φ40		φ280/φ65	
M06SY			25×25×150	St.12	φ40		φ260/φ51	
M08SY			25×25×150	St.12	φ40		φ280/φ65	
TMU1	20×20×100~125	1	20×20×125	St.16	φ32/φ32		φ38	
TMB2	20×20×100~125	1	20×20×125	St.16	φ32/φ32		φ51	
TMA8-IV	20×20×100~125	1			φ32/φ32		φ65	
TMA8J	20×20×100~125	1			φ32/φ32		φ65	
TMA8H	20×20×100~125	1			φ32/φ32		φ65	

·Manufacturers are in no particular order.

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Automatic Lathe List by Manufacturer

Nomura DS

Model	Toolholder Dimensions (Gang tool post)	Number of tools	Toolholder Dimensions (Turret tool post)	Number of tools	Sleeve Dia. (Horizontal/ Opposed)	Number of tools	Max. Cutting Dia.	Remarks
NN-10C	10×10×130	6			φ17		φ10	
NN-10CS	10×10×130	5			φ17	4	φ10	
NN-10S II	10×10×130	5			φ23		φ10	
NN-10SB5	10×10×130	5			φ23		φ13	
NN-10T	10×10×130	7			φ23		φ10	
NN-16H III	12×12×130	6			φ23		φ16	
NN-16J	12.7×12.7×130	6			φ23		φ16	
NN-16SB5	10×10×130	5			φ23		φ16	
NN-16SB6 Type1	12.7×12.7×130	7			φ17(φ22)	4	φ16	
NN-16SB6 Type2	12.7×12.7×130	5			φ17(φ22)	4	φ16	
NN-16SB6 Type2.5	12.7×12.7×130	6			φ17(φ22)	5	φ16	
NN-16SB6 Type3	12.7×12.7×130	5			φ17(φ22)	4	φ16	
NN-16SB7	12.7×12.7×130	5			φ16	4	φ16	
NN-16U III	12×12×130	5			φ23		φ16	
NN-16UB5	12×12×130	5			φ23		φ16	
NN-20CS	12.7×12.7×130	5(6)			φ22	4	φ20(φ25)	
NN-20H III	12×12×130	6			φ23		φ20	
NN-20J	12.7×12.7×130	6			φ23		φ20	
NN-20J2	12.7×12.7×130	6			φ22	4	φ20	
NN-20U III	12×12×130	5			φ23		φ20	
NN-20U5	12.7×12.7×150	5(6)			φ22	4	φ20(φ25)	
NN-20UB5	12×12×130	5			φ23		φ20	
NN-20UB7	12×12×130	6			φ23		φ20	
NN-20UB8	12.7×12.7×150	5(6)			φ22	4	φ20(φ25)	
NN-20YB	12×12×130	6			φ23		φ20	
NN-25YB/32YB	16×16×130	5			φ23/φ32		φ25/φ32	
NN-32UB8	16×16×130	2			φ22	3	φ32	
	12.7×12.7×150	3(4)			φ32	1		
NN-32YB2	16×16×130	5			φ22/φ32	4	φ32	
NN-32YB2 XB	16×16×130	6			φ22/φ32	5/1	φ32	

·Manufacturers are in no particular order.

Eguro

Model	Toolholder Dimensions (Gang tool post)	Number of tools	Toolholder Dimensions (Turret tool post)	Number of tools	Sleeve Dia. (Horizontal/ Opposed)	Number of tools	Max. Cutting Dia.	Remarks
SANAX-6	12×12	5 (MAX.)		5	φ16		φ15	
SANAX-8	16×16	5 (MAX.)		5	φ25/φ30		φ20	
	12×12	7 (MAX.)		5	φ25/φ30		φ20	
SANAX-10	16×16	5 (MAX.)		5	φ25/φ30		φ25.5	
EBN-10EX	12×12	6 (MAX.)			φ20		φ25.5	
NUCBOY-8EX	12×12	6 (MAX.)			φ20		φ20	
NUCLET-10EX	16×16	10 (MAX.)			φ20		φ25.5	
NUCPAL-10EX	16×16	10 (MAX.)			φ20		φ25.5	

·Manufacturers are in no particular order.

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List of Instruments and Applicable Small Tools and Toolholders

List of Instruments and Applicable Small Tools and Toolholders

Models of major machine tool manufacturers				
Manufacturer	Model (Automatic Lathe)	Toolholder Size	Total Length of Attached Toolholder (MAX.)	Applicable Toolholders
Citizen Machinery	A12,A16,B12,L12,M416,RL01,RL21	10×10	100	...1010F-...
	K12,K16	12×12		...1212F-...
	RL02	16×16		...1616H-...
	B12E,B16E,BL12,C12,C16,M212,M216 M312,M316,MSL12	10×10	120	...1010JX-...
	A20,A20VII,B20,BL20,BL25,K12E,K16E L20X,L220	12×12		...1212JX-...
	L16,L20,L20E	12×12	130	...1212JX-...
	C32,L25,L32,M20,M220,M232 M320,M332,M432	16×16		...1616JX-...
Star Micronics	RNC-10,RNC-16,SA-16R,SE-12B/16B SH-12/16	10×10	120	...1010JX-...
	SI-12,SI-12C	10×10	130	...1010JX-...
	SB-16A,SB-16C,SB-16D,SC20	12×12	130	...1212JX-...
	SR20R II,SR20 III,SV12,SV20	12×12	135	...1212JX-...
	SV32,SV32J,SV32J II	16×16		...1616JX-...
	ECAS-12	10×10	150	...1010JX-...
	ECAS-20	12×12		...1212JX-...
	SR25J,SR32J	16×16		...1616JX-...
Tsugami	B007	10×10	85	...1010F-...
	B0,BA,BC,BH20,BM,BU12,BU20 BS12,BS18,BS20,BW2	12×12		...1212F-...
	C004,C150,C180,C220	12×12	100	...1212F-...
	BH38,BS26,BS32,BU26,BU38	16×16		...1616H-...
Nomura DS	NN-10C,NN-10CS,NN-10S II NN-10SB5,NN-10S II,NN-10T,NN-16SB5	10×10	130	...1010JX-...
	NN-16H III,NN-16UB5,NN-16U III,NN-16J NN-20H III,NN-20U III,NN-20UB5,NN-20YB	12×12		...1212JX-...
	NN-25YB,NN-32YB2 XB	16×16		...1616JX-...

·Manufacturers are in no particular order.

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Parts Compatibility of Lever Lock Toolholders

Parts Compatibility of Lever Lock Toolholders

- 1) For better usability of lever lock toolholders, some levers, lock screws and shims are modified.
- 2) It is highly recommended to use only new parts. However, they are compatible with conventional parts and can be used together with them.
- 3) It is possible to use new parts only with a toolholder which has been in use.
- 4) When purchasing replacements, order them stating the new numbers.
- 5) Some of the shims remain unmodified.

Classification	Ref. to Page	Toolholder Description		Spare Parts						
				Lever		Lock Screw		Shim		
				New No.	Conventional	New No.	Conventional	New No.	Conventional	
External Toolholder	D8	PCLN ^{R/L}09	LL-1N	LL-1	LS-1N	LS-1	LC-32N	LC-32	
		12	LL-2N	LL-2	LS-2N	LS-2	LC-42N	LC-42	
		16	LL-5N	LL-5	LS-4N	LS-4	LC-53N	LC-53	
	D11	PDJN ^{R/L}11	LL-1DN	LL-1D	LS-1N	LS-1	LD-32N	LD-32	
		15	LL-3N	LL-3	LS-2N	LS-2	LD-42		
	D12	PSBN ^{R/L}09	LL-1N	LL-1	LS-1N	LS-1	LS-32		
		12	LL-2N	LL-2	LS-2N	LS-2	LS-42		
		PSKN ^{R/L}09	LL-1N	LL-1	LS-1N	LS-1	LS-32		
	D13	PSSN ^{R/L}12	LL-2N	LL-2	LS-2N	LS-2	LS-42		
		09	LL-1N	LL-1	LS-1N	LS-1	LS-32		
		PSDNN09	LL-1N	LL-1	LS-1N	LS-1	LS-32		
	D14	PTGN ^{R/L}	1212F-11	LL-03N	LL-03	LS-03N	LS-03	-		
		11	LL-03TN	LL-03T	LS-03SN	LS-03S	-		
		16	LL-1N	LL-1	LS-1N	LS-1	LT-32N	LT-32	
		PTFN ^{R/L}	1212F-11	LL-03N	LL-03	LS-03N	LS-03	-		
		11	LL-03TN	LL-03T	LS-03SN	LS-03S	-		
		16	LL-1N	LL-1	LS-1N	LS-1	LT-32N	LT-32	
	D19	PRGC ^{R/L}12	LL-1CN	LL-1C	LS-1N	LS-1	LR-12C		
		12	LL-2N	LL-2	LS-2N	LS-2	LR-81		
		PRGN ^{R/L}09	LL-1N	LL-1	LS-1N	LS-1	LR-80		
D20	PWLN ^{R/L}12	LL-2N	LL-2	LS-2N	LS-2	LW-32N	LW-32		
	08	LL-2N	LL-2	LS-2N	LS-2	LW-42N	LW-42		
Boring Bars	F68	<input type="checkbox"/> 16M- PCLN ^{R/L}	09-20	LL-03SN	LL-03S	LS-03SN	LS-03S	-		
		<input type="checkbox"/> 20Q-	09-27	LL-1N	LL-1	LS-1SN	LS-1S	LC-32N	LC-32	
		<input type="checkbox"/> 25R-	09-32	LL-2N	LL-2	LS-2N	LS-2	LC-42N ^{R/L}	LC-42 ^{R/L}	
	F69	PCLN ^{R/L}	12-...	LL-2N	LL-2	LS-2N	LS-2	LD-32N	LD-32
	F75	PDUN ^{R/L}	11-...	LL-1DN	LL-1D	LS-1SN	LS-1S	-	
		PTUN ^{R/L}	11-...	LL-03TN	LL-03T	LS-03SN	LS-03S	-	
		S25R-	PTUN ^{R/L}	16-30	LL-03SN	LL-03S	LS-03SN	LS-03S	-	
	F76	S32S-	16-40	LL-1N	LL-1	LS-1N	LS-1	LT-32N	LT-32	
		S40T-	16-50	LL-03SN	LL-03S	LS-03SN	LS-03S	-		
		<input type="checkbox"/> 16M- PWLN ^{R/L}	06-20	LL-03SN	LL-03S	LS-03SN	LS-03S	-		
F78	<input type="checkbox"/> 20Q-	06-27	LL-1N	LL-1	LS-1SN	LS-1S	LW-32N	LW-32		
	<input type="checkbox"/> 25R-	06-32	LL-2N	LL-2	LS-2N	LS-2	LW-42N ^{R/L}	LW-42 ^{R/L}		
Turning Mill	N5	T63H- PCLN ^{R/L}	-DX12	LL-2N	LL-2	LS-2N	LS-2	LC-42N	LC-42	
		T63H- PCMNN	-□12	LL-3N	LL-3	LS-2N	LS-2	LD-42		
		T63H- PDJN ^{R/L}	-DX15	LL-1N	LL-1	LS-1N	LS-1	LT-32N	LT-32	
	N6	T63H- PDNNN	-□15	LL-2N	LL-2	LS-2N	LS-2	LW-42N	LW-42	
		T63H- PTGN ^{R/L}	-DX16	LL-1N	LL-1	LS-1N	LS-1	LT-32N	LT-32	
N7	T63H- PWLN ^{R/L}	-DX08	LL-2N	LL-2	LS-2N	LS-2	LW-42N	LW-42		

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Technical Information