

TAC J-Series Turning Toolholder for Small Lathes

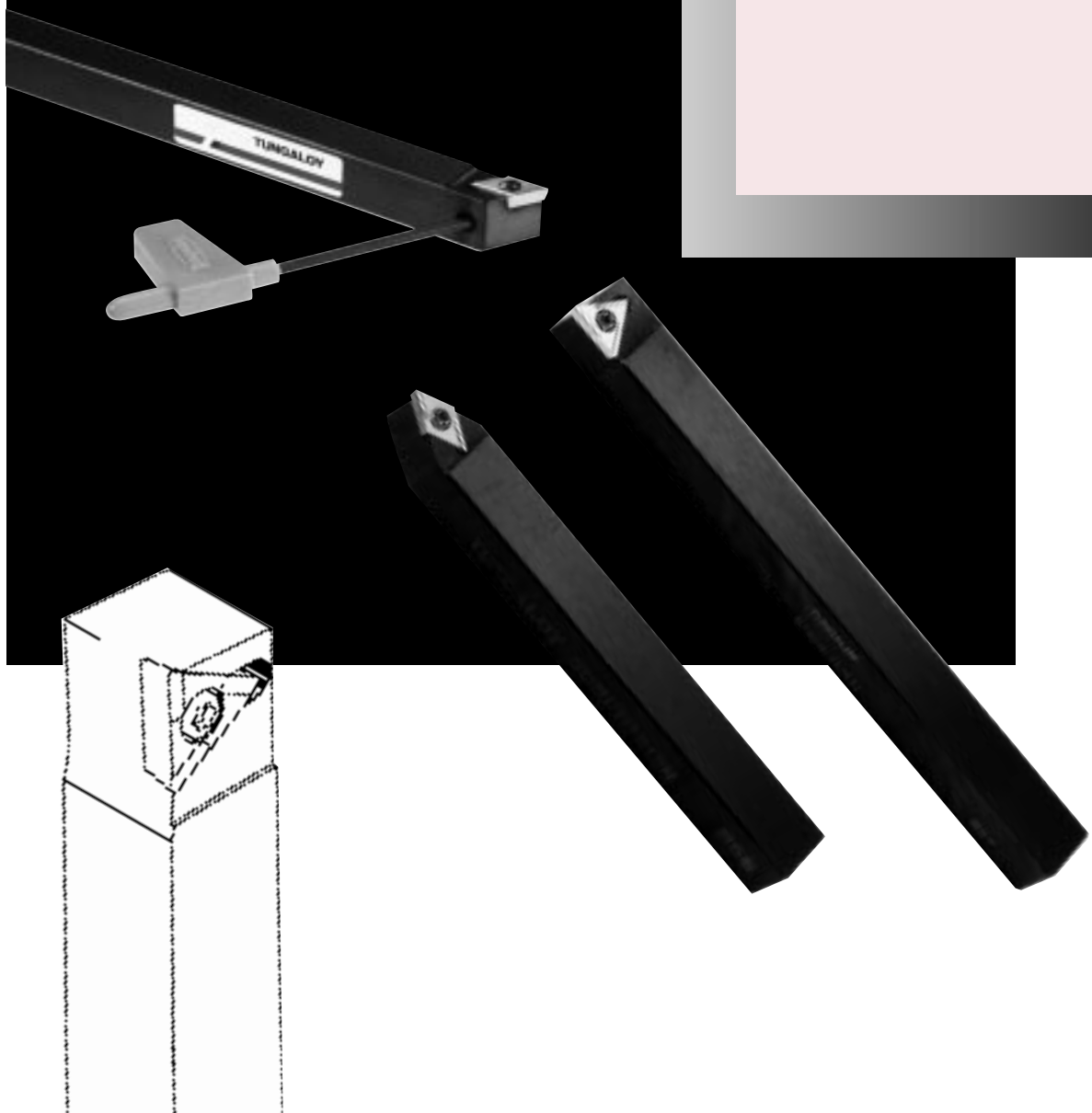
Selection Guides

■ Application of J-series 266

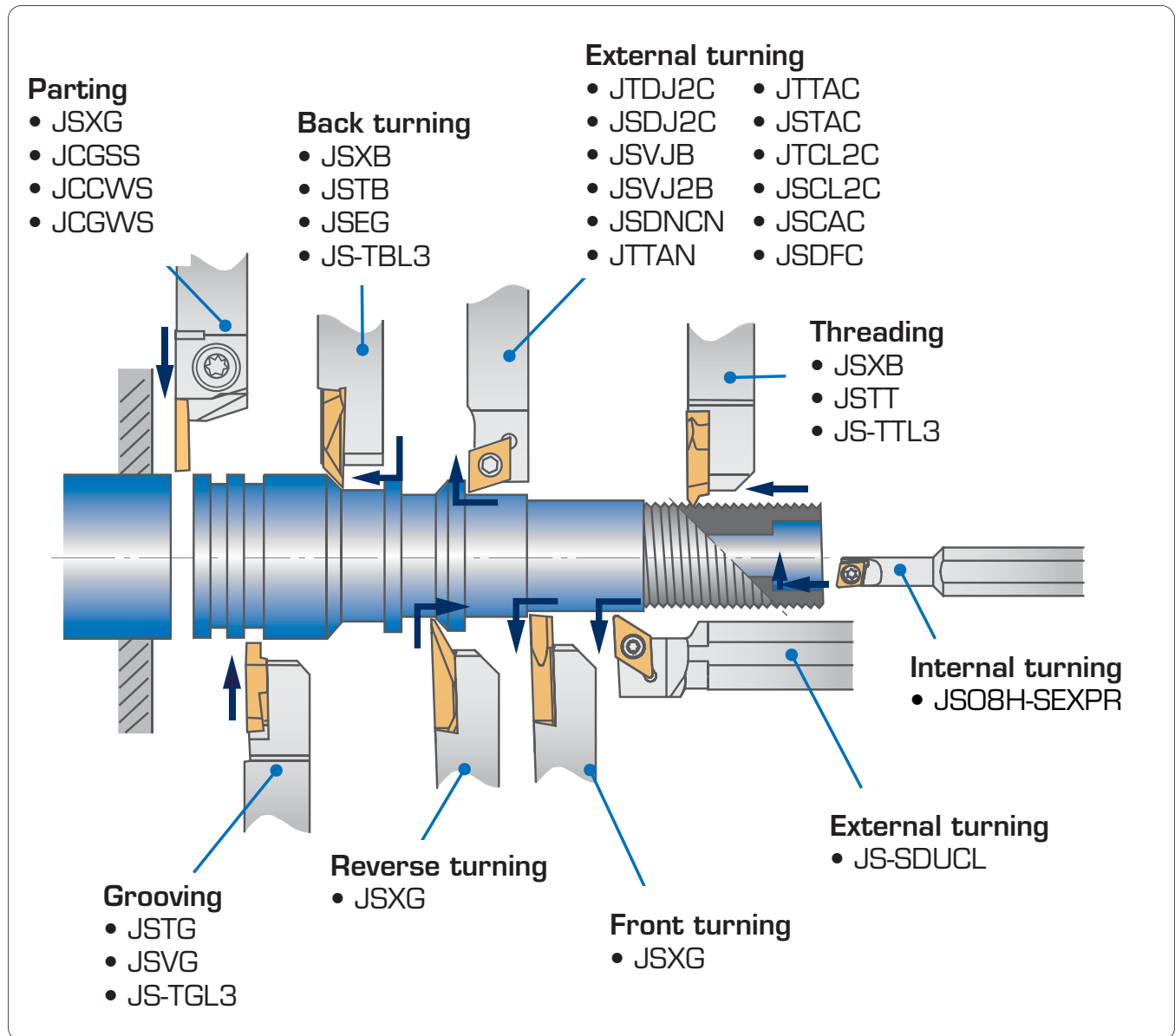
Specifications

- For General Turning 271
- For Front & Reverse Turning and Parting 276
- For Back Turning 277
- For Grooving and Parting 279
- For Threading 282
- Boring Toolholder 282

6788



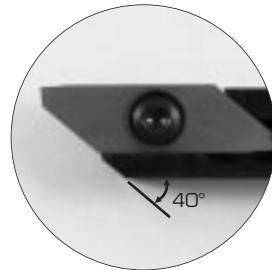
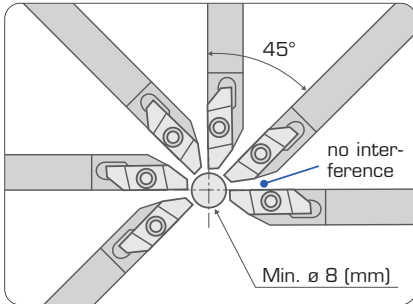
Applications



Grade (for J-series)

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

-C type



Specially suited for cam style small lathes

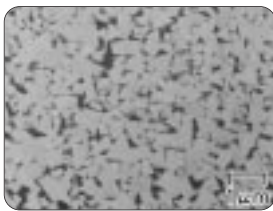
Multi-functional Applications:

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

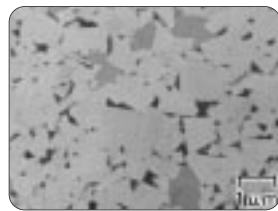
J740

PVD coated ultra fine grain substrate for extremely sharp cutting edges

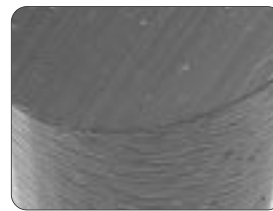
Design of cutting edge



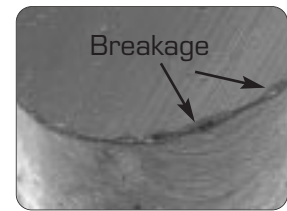
J740



Conventional carbide



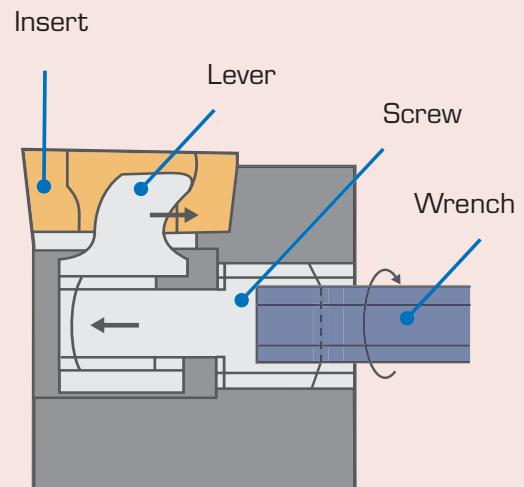
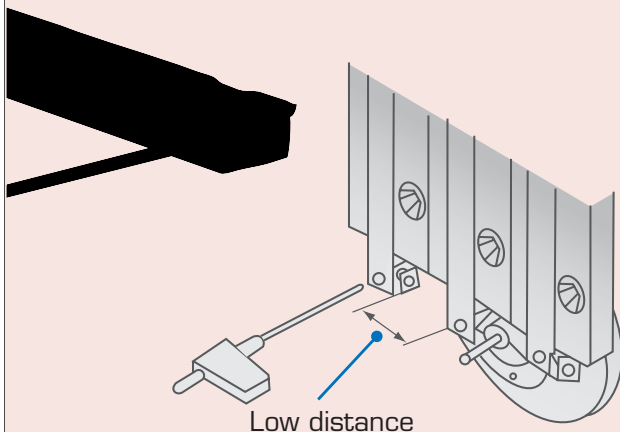
J740



Conventional carbide

Toolholder with side-clamping



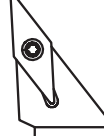



Innovative clamping system for stable clamping of the insert. Easy and quick changing of insert, as the toolholder does not have to be removed.

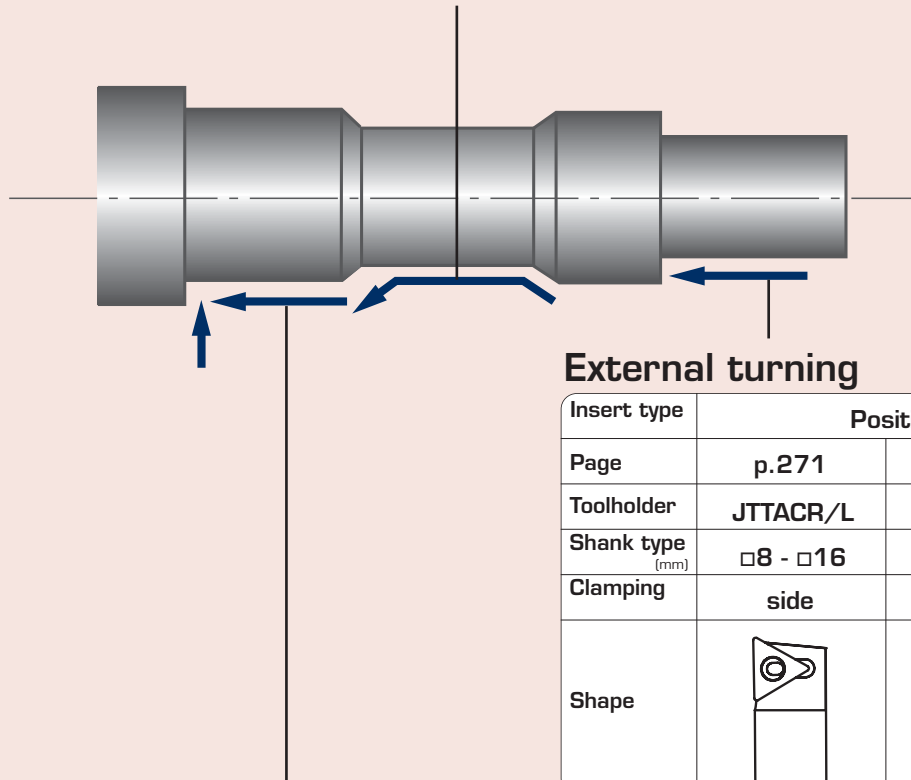


- NEW** For negative inserts
 - JTTAN type: p.274
 For positive inserts
 - JTDJ2C type: p.271 - JTTAC type: p.271
 - JTCL2C type: p.271

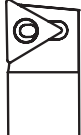

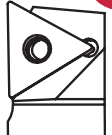
External turning

External turning & Profiling





Insert type	Positive					
Page	p.271	p.272	p.273	p.273	p.273	p.283
Toolholder	JTDJ2CR/L	JSDJ2CR/L	JSVJBR/L	JSVJ2BR/L	JSDNCN	JS-SDUCL
Shank type (mm)	□8 - □16	□10 - □12	□10 - □16	□10 - □16	□8 - □16	∅19.05 - ∅25.4
Clamping	side	screw-on	screw-on	screw-on	screw-on	screw-on
Shape						







External turning

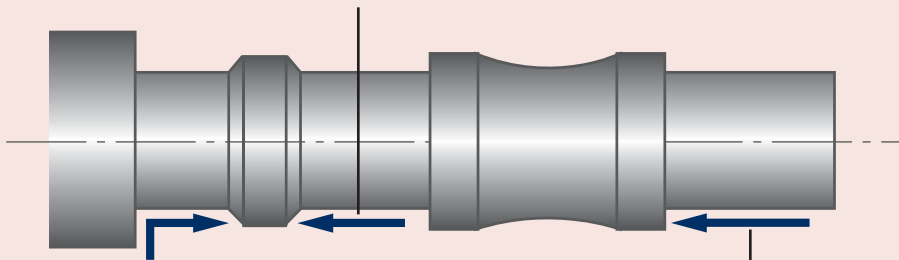
Insert type	Positive		Negative
Page	p.271	p.272	p.274
Toolholder	JTTACR/L	JSTACR/L	JTTANR/L
Shank type (mm)	□8 - □16	□8 - □16	□12 - □16
Clamping	side	screw-on	side
Shape			

External turning & Facing


Insert type	Positive			
Page	p.271	p.272	p.274	p.274
Toolholder	JTCL2CR/L	JSCL2CR/L	JSCACR/L	JSDFCR/L
Shank type (mm)	□8 - □16	□10 - □12	□8 - □12	□12 - □16
Clamping	side	screw-on	screw-on	screw-on
Shape				

Back turning

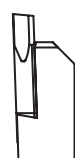
Page	p.277	p.278	p.278	p.283
Toolholder	JSXBR/L	JSTBR/L	JSEGR/L	JS-TBL3
Shank type (mm)	□10 - □25	□10 - □16	□10 - □16	∅19.05 - ∅25.4
Max. ap (mm)	5.5	2.5	3.0	2.5
Shape				



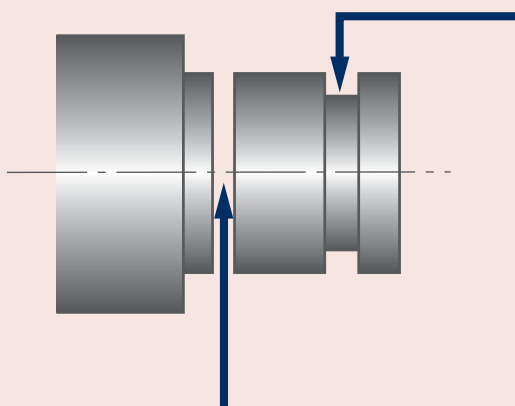
Reverse turning

Page	p.276
Toolholder	JSXGR/L
Shank type (mm)	□10 - □25
Max. ap (mm)	5.5
Shape	

Front turning

Page	p.276
Toolholder	JSXGR/L
Shank type (mm)	□10 - □25
Max. ap (mm)	5.5
Shape	

External grooving



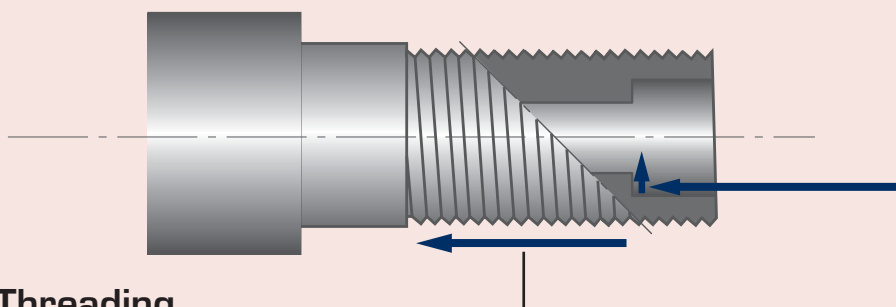
Grooving

Page	p.279	p.280	p.284
Toolholder	JSVGR/L	JSTGR/L	JS-TGL3
Shank type (mm)	□10 - □25	□10 - □16	∅19.05 - ∅25.4
Grooving width (mm)	0.33 - 2.0	0.33 - 3.0	0.33 - 3.0
Max. grooving depth (mm)	0.7 - 5.5	0.7 - 2.6	0.7 - 2.6
Shape			

Parting

Page	p.276	p.280	p.281	p.281
Toolholder	JSXGR/L	JCGSSR/L	JCCWSR/L	JCGWSR/L
Shank type (mm)	□10 - □25	□10 - □16	□10 - □25	□10 - □16
Grooving width (mm)	0.7 - 2.0	2.0	2.0	2.0
Max. parting- ∅ (mm)	∅9 - 12	∅20 - 32	∅20	∅20
Shape				

Threading and internal turning



Threading

Page	p.282	p.277	p.284
Toolholder	JSTTR/L	JSXBR/L	JS-TTL3
Shank type (mm)	□10 - □16	□10 - □25	∅19.05 - ∅25.4
Pitch (mm)	0.5 - 1.0	0.5 - 1.0	0.5 - 1.0
Shape			

Internal turning

Page	p.282
Toolholder	JS08H-SEXPR
Shank type (mm)	∅8.0
Min. bore-∅ (mm)	∅5.5 - 7.0
Shape	

Toolholder with side-clamping (positive)

● Standard stock in Europe ○ Standard stock in Japan

External turning									<table border="1"> <tr> <td>Application</td> <td>Precision finishing</td> <td>Finishing to medium cutting</td> <td>Medium cutting</td> <td>Finishing to medium cutting</td> </tr> <tr> <td>Type</td> <td>O1</td> <td>PS</td> <td>PM</td> <td>SS</td> </tr> <tr> <td>Shape</td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td>Application</td> <td>Finishing</td> <td>Aluminium</td> <td></td> <td></td> </tr> <tr> <td>Type</td> <td>J**</td> <td>AL</td> <td></td> <td></td> </tr> <tr> <td>Shape</td> <td></td> <td></td> <td></td> <td></td> </tr> </table>					Application	Precision finishing	Finishing to medium cutting	Medium cutting	Finishing to medium cutting	Type	O1	PS	PM	SS	Shape					Application	Finishing	Aluminium			Type	J**	AL			Shape				
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JTTACR/L0810K08	●	●	TC**0802**	8	10	125	10	8	10	JCP-1	JDS-3525	P-2F																															
JTTACR/L1010K08	●	●		10	10	125	10	10	10																																		
JTTACR/L1212M11	●	●	TC**1102**	12	12	150	12	12	12	JCP-2																																	
JTTACR/L1616M11	●	●		16	16	150	12	16	16																																		

External turning & Facing									<table border="1"> <tr> <td>Application</td> <td>Precision finishing</td> <td>Finishing</td> <td>Finishing to medium cutting</td> <td>Medium cutting</td> <td></td> </tr> <tr> <td>Type</td> <td>O1</td> <td>PF</td> <td>PS</td> <td>PM</td> <td></td> </tr> <tr> <td>Shape</td> <td></td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td>Application</td> <td>Precision finishing</td> <td>Finishing</td> <td>Finishing to medium cutting</td> <td>Finishing to medium cutting</td> <td>Aluminium</td> </tr> <tr> <td>Type</td> <td>CBN/PCD</td> <td>J**</td> <td>W**</td> <td>-</td> <td>AL</td> </tr> <tr> <td>Shape</td> <td></td> <td></td> <td></td> <td></td> <td></td> </tr> </table>					Application	Precision finishing	Finishing	Finishing to medium cutting	Medium cutting		Type	O1	PF	PS	PM		Shape						Application	Precision finishing	Finishing	Finishing to medium cutting	Finishing to medium cutting	Aluminium	Type	CBN/PCD	J**	W**	-	AL	Shape					
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JTCL2CR/L0810K06	●	●	CC**0602**	8	10	125	12	8	10	JCP-2	JDS-3525	P-2F																																					
JTCL2CR/L1010K06	●	●		10	10	125	12	10	10																																								
JTCL2CR/L1212M09	●	●	CC**09T3**	12	12	150	16	12	12	JCP-3			JDS-5040	P-2.5F																																			
JTCL2CR/L1616M09	●	●		16	16	150	16	16	16																																								

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JTDJ2CR/L1010K07	●	●		10	10	125	14	10	10																																								
JTDJ2CR/L1212M11	●	●	DC**11T3**	12	12	150	18	12	12	JCP-3			JDS-5040	P-2.5F																																			
JTDJ2CR/L1616M11	●	●		16	16	150	18	16	16																																								

Toolholder with screw-on clamping (positive)

● Standard stock in Europe ○ Standard stock in Japan

External turning									<table border="1"> <tr> <td>Application</td> <td>Precision finishing</td> <td>Finishing to medium cutting</td> <td>Medium cutting</td> <td>Finishing to medium cutting</td> </tr> <tr> <td>Type</td> <td>O1</td> <td>PS</td> <td>PM</td> <td>SS</td> </tr> <tr> <td>Shape</td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td>Application</td> <td>Finishing</td> <td>Aluminium</td> <td></td> <td></td> </tr> <tr> <td>Type</td> <td>J**</td> <td>AL</td> <td></td> <td></td> </tr> <tr> <td>Shape</td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td></td> <td>(08, 11)</td> <td>(11)</td> <td></td> <td></td> </tr> </table>				Application	Precision finishing	Finishing to medium cutting	Medium cutting	Finishing to medium cutting	Type	O1	PS	PM	SS	Shape					Application	Finishing	Aluminium			Type	J**	AL			Shape						(08, 11)	(11)		
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	R	L		h	b	l1	l2	h1		f																																					
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JSTACR/L1212K11	●	●	TC**1102**	12	12	125	12	12	12	CSTB-2.5	T-8F	(T-8L)																																			
JSTACR/L1616H11	●	●		16	16	100	12	16	16																																						

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JSCL2CR/L1010K06	●	●	CC**0602**	10	10	125	12	10	10	CSTB-2.5	T-8F	(T-8L)																																											
JSCL2CR/L1212K06	●	●		12	12	125	12	12	12																																														

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JSDJ2CR/L1010K07	●	●	DC**0702**	10	10	125	14	10	10	CSTB-2.5	T-8F	(T-8L)																																											
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● Standard stock in Europe ○ Standard stock in Japan

External turning & Profiling												
JSVJB R/L												
				Application		Finishing to medium cutting		Finishing				
		35°		Type		PS		J**				
		93°		Shape								
		Right hand (R) shown										
Item code	Stock		Inserts	Dimensions (mm)					Clamping screw	Wrench		
	R	L		h	b	l1	l2	h1		f		
JSVJBR/L1010H11	●	●	VB*T1103**	10	10	100	20	10	12	CSTB-2.5	T-8F	(T-8L)
JSVJBR/L1212H11	●	●		12	12	100	20	12	16			
JSVJBR/L1616H11	●	●		16	16	100	20	16	20			

External turning & Profiling												
JSVJ2B R/L												
				Application		Finishing to medium cutting		Finishing				
		35°		Type		PS		J**				
		93°		Shape								
		Right hand (R) shown										
Item code	Stock		Inserts	Dimensions (mm)					Clamping screw	Wrench		
	R	L		h	b	l1	l2	h1		f		
JSVJ2BR/L1010H11	●	●	VB*T1103**	10	10	100	20	10	10	CSTB-2.5	T-8F	(T-8L)
JSVJ2BR/L1212H11	●	●		12	12	100	22	12	12			
JSVJ2BR/L1616H11	●	●		16	16	100	22	16	16			

External turning & Profiling												
JSDNCN												
				Application		Precision finishing		Finishing		Finishing to medium cutting		
		55°		Type		O1		PF		PS		
		62.5°		Shape								
		Right hand (R) shown										
Item code	Stock		Inserts	Dimensions (mm)					Clamping screw	Wrench		
	R	L		h	b	l1	l2	h1		f		
JSDNCN1010K07	●	○	DC**0702**	10	10	125	14	10	5	CSTB-2.5	T-8F	(T-8L)
JSDNCN1212K07	●	○		12	12	125	14	12	6			
JSDNCN1616H11	●	○	DC**11T3**	16	16	100	21	16	8	CSTB-4SD		

● Standard stock in Europe ○ Standard stock in Japan

NEW

External turning & Facing
JSCAC R/L

Application	Precision finishing	Finishing	Finishing to medium cutting	Medium cutting	
Type	O1	PF	PS	PM	
Shape					
Application	Precision finishing	Finishing	Finishing to medium cutting	Finishing to medium cutting	Aluminium
Type	CBN/PCD	J**	W**	-	AL
Shape					

Right hand (R) shown

Item code	Stock		Inserts	Dimensions (mm)						Clamping screw	Wrench	
	R	L		h	b	l1	l2	h1	f			
JSCACR/L0808H06	●	●	CC**0602**	8	8	100	12	8	8	CSTB-2.5	T-8F	(T-8L)
JSCACR/L1010H06	●	●		10	10	100	12	10	10			
JSCACR/L1212H09	●	●	CC**09T3**	12	12	100	16	12	12	CSTB-4SD		

External turning & Facing
JSDFC R/L

Application	Precision finishing	Finishing	Finishing to medium cutting	Medium cutting	
Type	O1	PF	PS	PM	
Shape					
Application	Precision finishing	Finishing	Finishing to medium cutting	Finishing to medium cutting	Aluminium
Type	CBN/PCD	J**	W**	-	AL
Shape					

Right hand (R) shown

Item code	Stock		Inserts	Dimensions (mm)						Clamping screw	Wrench	
	R	L		h	b	l1	l2	h1	f			
JSDFCR/L1212H07	●	●	DC**0702**	12	12	100	8	12	16	CSTB-2.5	T-8F	(T-8L)
JSDFCR/L1616H11	●	●	DC**11T3**	16	16	100	10.5	16	22			

TAC Turning Toolholder for Small Lathes

Toolholder with side-clamping (negative)

NEW







External turning
JTTAN R/L

Application	Precision finishing	Precision finishing	Medium cutting	Finishing
Type	O1	C	P	TS
Shape				




Right hand (R) shown

Item code	Stock		Inserts	Dimensions (mm)						Lever	Screw	Wrench
	R	L		h	b	l1	l2	h1	f			
JTTANR/L1216K16	●	●	TN**1604**	12	16	125	19.8	12	16	JCP-3N	JDS-5040	P-2.5F
JTTANR/L1616K16	●	●		16	16	125	19.8	16	16			

Cutting conditions (for J-series)

Work material	Application	Chipbreaker	Grade	Cutting depth ap (mm)	Feed f (mm/rev)	Cutting speed Vc (m/min)
 Steel	Precision finishing	O1	J740	0.05 - 0.50	0.03 - 0.15	10 - 100
			J530			100 - 300
	Finishing	J	NS530	0.10 - 5.00	0.01 - 0.30	80 - 300
			J740			10 - 100
 Stainless steel	Precision finishing	O1	J740	0.05 - 0.50	0.03 - 0.15	10 - 100
			J530			100 - 200
	Finishing	J	NS530	0.10 - 5.00	0.01 - 0.10	100 - 200
			J740			10 - 100
 Cast iron	Finishing	J	TH10	0.10 - 5.00	0.01 - 0.10	20 - 100
 Non-ferrous metals	Finishing	J	TH10			100 - 1000
 Difficult-to-cut materials	Finishing	J	TH10			10 - 150
 Hardened steel	Finishing	J	TH10			10 - 60

Cutting conditions (for basic grades and chipbreaker)

Work material	Grade				Cutting speed Vc (m/min)	Chipbreaker	Cutting depth ap (mm)	Feed f (mm/rev)	
	CVD	PVD	Cermet	Cerm. coated					
 Steel	T9005				100 - 400	PF	0.3 - 1.5	0.05 - 0.25	
	T9015				80 - 350	PS	0.3 - 2.0	0.08 - 0.30	
	T9025				80 - 300	PM	0.5 - 3.0	0.15 - 0.30	
	T9035				50 - 200	C	0.5 - 3.0	0.10 - 0.30	
			GH730			50 - 150	TS	0.3 - 1.5	0.08 - 0.20
				NS530	GT530	80 - 300	P	1.0 - 4.0	0.20 - 0.50
 Stainless steel	T6020				100 - 200				
	T6030				50 - 150				
			GH730			50 - 120			
				NS530	GT530	100 - 200			
 Cast iron			GH110		30 - 150				

● Standard stock in Europe ○ Standard stock in Japan

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

Note: C-type toolholders are marked

R: Reverse turning

F: Front turning

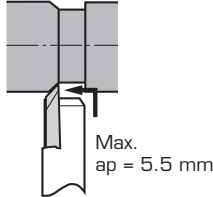



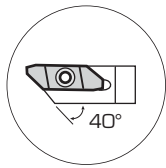
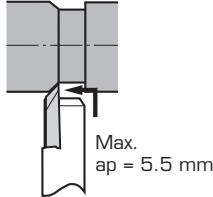
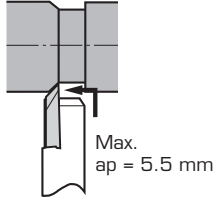
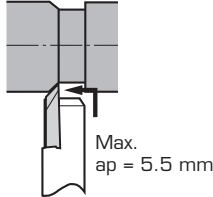
C: Parting (deep-grooving)

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

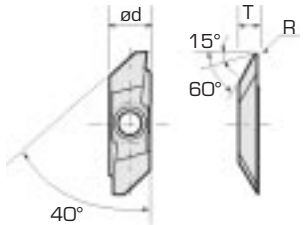
	JXR-type inserts for reverse turning (sharp cutting edge)										
	Item code	Dimensions (mm)				Grade					
		ød	T	R	Max. cutting depth ap	Coated J740		Cermet NS530		Carbide TH10	
					R	L	R	L	R	L	
	JXRR/L8000F	8	3.97	0.03	5.5	●		○		○	
	JXRR/L8010F	8	3.97	0.10	5.5	●		○		○	

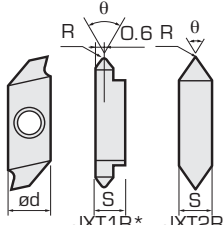
	JXG-type inserts for parting (sharp cutting edge)												
	Item code	Dimensions (mm)						Grade					
		ød	T	W _{±0.025}	θ	Max. grooving depth ap	R	Coated J740		Cermet NS530		Carbide TH10	
								R	L	R	L	R	L
JXGR/L8070FA	8	3.97	0.7	15°	4.5	0	●	●	●	●	○	○	
JXGR/L8100FA							●	●	●	●	○	○	
JXGR/L8100FA45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

● Standard stock in Europe ○ Standard stock in Japan

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

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

		JXB-type inserts for back turning											
		Item code	Honing	Dimensions (mm)				Grade					
				ød	T	R	Max. cutting depth ap	Coated J740		Cermet NS530		Carbide TH10	
Right hand (R) shown		JXBR/L8000F	without	8	3.97	0.03	5.5	●	●	○		○	○
		JXBR/L8005F				0.05		●	●			○	○
		JXBR/L8010F				0.10		●	●	○		○	○
		JXBR/L8015F				0.15		●	●			○	○
		JXBR/L8005	with			0.05		○	○				
		JXBR/L8010				0.10		○	○				
		JXBR/L8015				0.15		○	○				
		JXBR/L8015				0.15		○	○				

		JXT-type inserts for threading (sharp cutting edge)										
		Item code	Dimensions (mm)				Grade					
			ød	S	R	θ	Coated J740		Cermet NS530		Carbide TH10	
Right hand (R) shown		JXT1R/L6000F	8	3.97	0.03	60°	●		○		●	
		JXT2R/L6000F	8	3.97	0.03	60°	●		○		●	

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

● Standard stock in Europe ○ Standard stock in Japan

Back turning
JSTB R/L

Max. ap = 2.5 mm

Right hand (R) shown

Item code	Stock		Inserts	Dimensions (mm)						Clamping screw	Wrench		
	R	L		h	b	l1	l2	h1	f		c		
JSTBR/L1010K3	●	●	JTBR/L3***	10	10	125	15	10	6	5	CSTB-4SD	T-8F	(T-8L)
JSTBR/L1212K3	●	●		12	12	125	15	12	8	3			
JSTBR/L1616K3	●	●		16	16	125	15	16	12	-			

JTB-type inserts for back turning

Right hand (R) shown

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

Back turning
JSEGR R/L

Max. ap = 3 mm

Right hand (R) shown

Item code	Stock		Inserts	Dimensions (mm)						Clamping screw	Wrench	
	R	L		h	b	l1	l2	h1	f			
JSEGR/L1010K10	●	●	J10ER/L***B*	10	10	125	-	10	7.5	CSTB-2.5	T-8F	(T-8L)
JSEGR/L1212K10	●	●		12	12	125	-	12	9.5			
JSEGR/L1616K10	●	●		16	16	125	-	16	13.5			

J10E-type inserts for back turning

Right hand (R) shown

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

Parting: JSXG; see p. 276

● Standard stock in Europe ○ Standard stock in Japan

Grooving										Clamping screw		Wrench	
Item code	Stock		Inserts	Dimensions (mm)									
	R	L		h	b	l1	l2	h1	f		R	L (optional)	
JSVGR/L1010K-C	●	●	JVGR/L***	10	10	125	23	10	10	CSTB-3S	T-9F	[T-9L]	
JSVGR/L1212K-C	●	●		12	12	125	23	12	12				
JSVGR/L1616K	●	●		16	16	125	23	16	16				

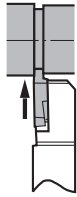
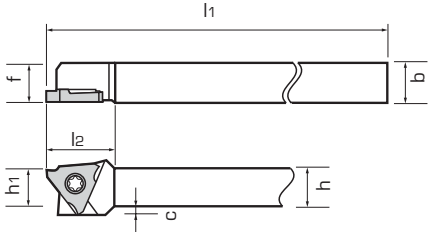
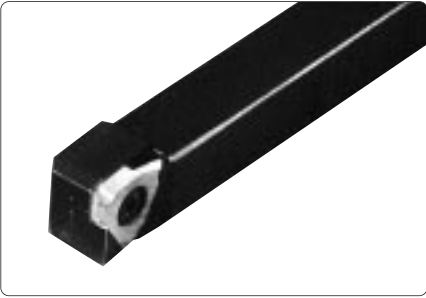


Note: C-type toolholder are marked G: Grooving

		JVGR-type inserts for grooving (sharp cutting edge)							Grade						
		Item code	Dimensions (mm)						R	Coated		Cermet		Carbide	
			ød	T	W ^{+0.025}	G	Max. grooving depth ap	0		J740		NS530		TH10	
										R	L	R	L	R	L
JVGR/L033F	7.94	3.18	0	0.33	0.8	0.7	●		●		●				
JVGR/L050F				0.50	1.2	1.1	●		●		●				
JVGR/L075F				0.75	2.0	1.9	●		●		●				
JVGR/L095F				0.95			●		●		●				
JVGR/L100F				1.00	6.0	5.5	●		●	●	●	●			
JVGR/L125F				1.25	5.5	5.0	●		●		●				
JVGR/L150F				1.50	6.0	5.5	●		●	●	●	●			
JVGR/L200F				2.00			●		●		●				

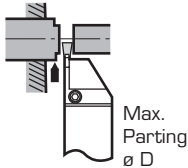
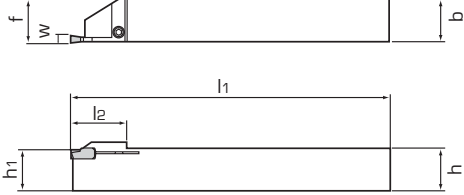
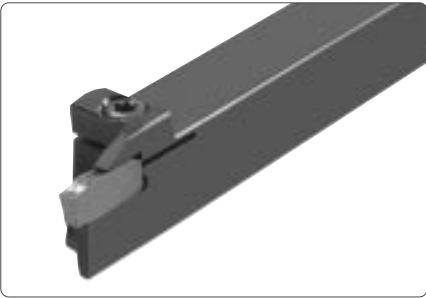
Cutting conditions for grooving (JSXG: p. 276 / JSVG: p. 279)

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

● Standard stock in Europe ○ Standard stock in Japan

Grooving													
JSTG R/L													
													
				Right hand (R) shown									
Item code	Stock		Inserts	Dimensions (mm)						Clamping screw	Wrench		
	R	L		h	b	l1	l2	h1	f		c		 (optional)
JSTGR/L1010K3	●	●	JTGR/L3***	10	10	125	18.5	10	10	2	CSTB-4SD	T-8F	(T-8L)
JSTGR/L1212K3	●	●		12	12	125	18.5	12	12	-			
JSTGR/L1616K3	●	●		16	16	125	18.5	16	16	-			

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

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

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

TAC Turning Toolholder for Small Lathes

● Standard stock in Europe ○ Standard stock in Japan

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

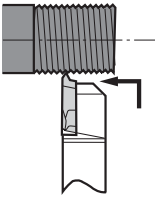
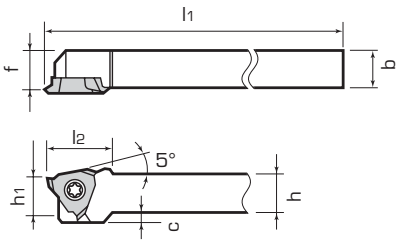



		JCC-type inserts for parting (sharp cutting edge)										
		Item code	Dimensions (mm)					Grade				
			T	W	L	R	θ	Coated		Carbide		
								J740	J530	TH10		
							R	L	R	L	R	L
<p>(JCCN200F)</p>		JCCN200F	4.8	2	15	0	-		●	●	●	
<p>(JCCR/L200F)</p>							15°		●	●	●	●

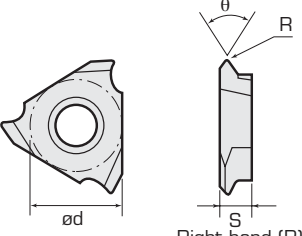
Parting													
JCGWS R/L													
<p>Max. Parting \varnothing 20 mm</p>						Right hand (R) shown							
Item code	Stock		Inserts	Dimensions (mm)						Clamping screw	Wrench		
	R	L		h	b	l1	l2	h1	f		Max. parting- \varnothing		
JCGWSR/L1010K2			JCGN200*	10	10	125	20	10	10	\varnothing 20	CSTB-4S	T-15F	(T-15L)
JCGWSR/L1212K2				12	12	125	20	12	12				
JCGWSR/L1616K2				16	16	125	20	16	16				

		JCG-type inserts for parting (sharp cutting edge)									
		Item code	Dimensions (mm)				Grade				
			T	W	L	R	Coated		Carbide		
							J740	J530	TH10		
						R	L	R	L	R	L
<p>(JCGN200F)</p>		JCGN200F	3	2	20	0.05		●	●	●	
<p>(JCGN200FR/L)</p>						●	●	●	●	●	●

TAC Turning Toolholder for Small Lathes

● Standard stock in Europe ○ Standard stock in Japan

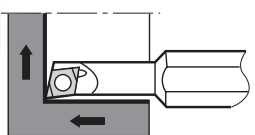
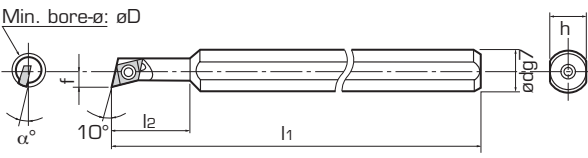

Threading		JSTT R/L								Right hand (R) shown			
													
Item code	Stock		Inserts	Dimensions (mm)						Clamping screw	Wrench		
	R	L		h	b	l1	l2	h1	f		c		 (optional)
JSTTR/L1010K3	●		JTTR/L3****	10	10	125	16.5	10	9.5	2	CSTB-4SD	T-8F	(T-8L)
JSTTR/L1212K3	●			12	12	125	16.5	12	11.5	-			
JSTTR/L1616K3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

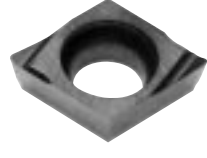
JTTR-type inserts for threading (sharp cutting edge)		Dimensions (mm)				Grade					
Item code		ød	S	R	θ	Coated J740		Cermet NS530		Carbide TH10	
						R	L	R	L	R	L
JTTR/L3005F		9.525	3.18	0.05	60°	●		●		●	
JTTR/L3010F				0.10		●		●		●	
JTTR/L3005F-55				0.05	55°	○					

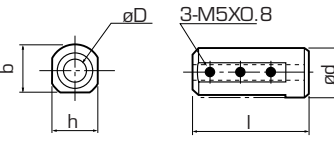
Note: for pitches of 0.5 to 1.0 mm

Threading: **JSXB**; see p. 277

Boring toolholder with screw-on clamping (positive)

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

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

Sleeves		Dimensions (mm)					Stock
Item code		Shank-ød	ød	l	b	h	
		BLM19-08	8	8	19.05	100	18
BLM20-08	20	100			19	18	●
BLM22-08	22	125			21	21	●
BLM254-08	25.4	125			24	24	●

NEW

● Standard stock in Europe ○ Standard stock in Japan

NEW

External turning & Profiling		JS-SDUCL								Application		Precision finishing		Finishing		Finishing to medium cutting		Medium cutting						
Item code		Stock		Inserts	Min. bore- ϕ D	Dimensions (mm)					Clamping screw	Wrench	Type	01	PF	PS	PM	Type	CBN/PCD	J**	W**	-	AL	
R	L	f	l ₁			l ₂	h	b	g	Shape			(07, 11)	(07, 11)	(07, 11)	(07, 11)	Shape	(07, 11)	(07, 11)	(07, 11)	(07, 11)	(07, 11)	(07, 11)	(07, 11)
JS19K-SDUCL07	●	●	DC**0702**	19.05	6	125	20	18	11.5	-	CSTB-2.5	T-8F	●	●	●	●	●	●	●	●	●	●	●	
JS20K-SDUCL07	●	●	DC**0702**	20.00	6	125	20	19	11.5	-														
JS22K-SDUCL07	●	●	DC**0702**	22.00	6	125	20	21	11.5	-														
JS19K-SDUCL11	●	●	DC**11T3**	19.05	10	125	20	18	11.5	1.525	CSTB-4SD	T-8F	●	●	●	●	●	●	●	●	●	●	●	
JS20K-SDUCL11	●	●		DC**11T3**	20.00	10	125	20	19	11.5														1.000
JS22K-SDUCL11	●	●		DC**11T3**	22.00	11	125	20	21	11.5														1.000
JS25K-SDUCL11	●	●		DC**11T3**	25.40	12	125	20	24	12.7														0.700

NEW

Back turning		JS-TBL3								Application		Precision finishing		Finishing		Finishing to medium cutting		Medium cutting					
Item code		Stock		Inserts	Dimensions (mm)					Clamping screw	Wrench	Type	01	PF	PS	PM	Type	CBN/PCD	J**	W**	-	AL	
R	L	ϕ d	f		l ₁	l ₂	h	b	Shape			(07, 11)	(07, 11)	(07, 11)	(07, 11)	Shape	(07, 11)	(07, 11)	(07, 11)	(07, 11)	(07, 11)	(07, 11)	(07, 11)
JS19K-TBL3	●	●	JTBR30**	19.05	6	125	17	18	11.5	CSTB-4S	T-15F	●	●	●	●	●	●	●	●	●	●	●	
JS20K-TBL3	●	●		JTBR30**	20.00	6	125	17	19														11.5
JS22K-TBL3	●	●		JTBR30**	22.00	6	125	17	21														11.5
JS25K-TBL3	●	●		JTBR30**	25.40	10	125	17	24														12.7

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

TAC Turning Toolholder for Small Lathes

● Standard stock in Europe ○ Standard stock in Japan

NEW

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

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

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

NEW

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

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

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

TAC Turning Toolholder for Small Lathes