

TurnLine

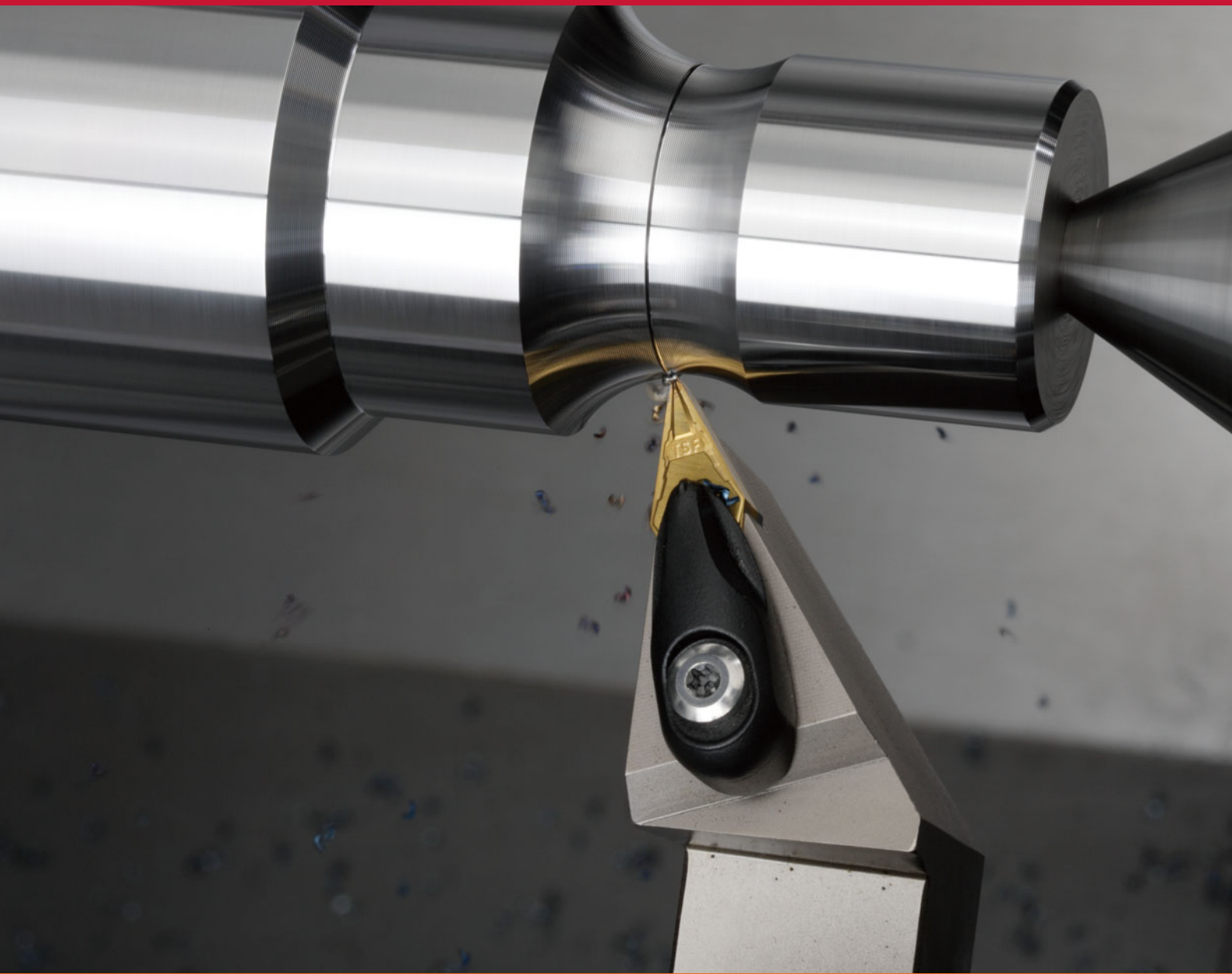
TURNINGA

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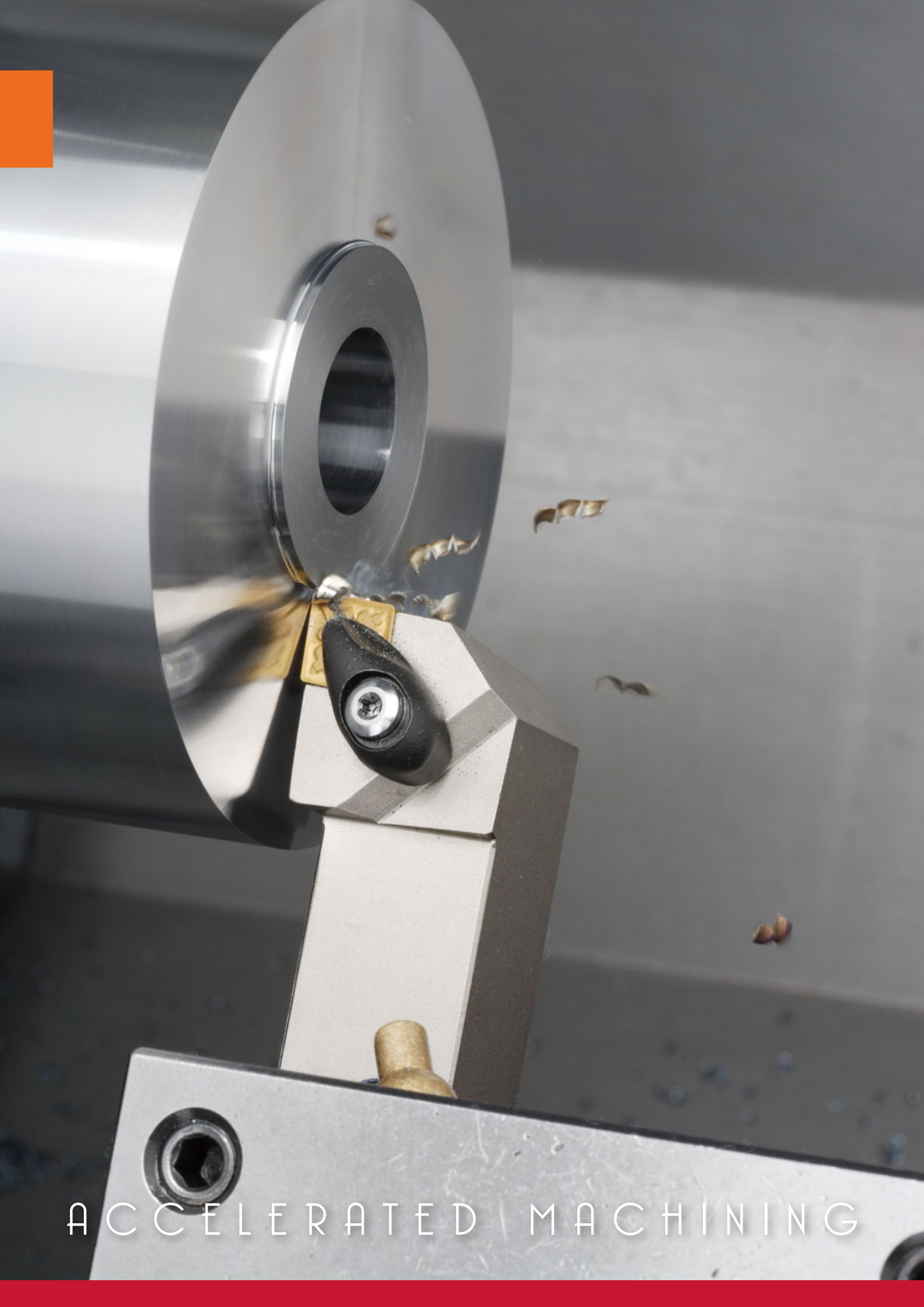
Tungaloy Report No. 365-G

Member IMC Group
Tungaloy

Higher indexing accuracy and clamping rigidity with a double clamping system



INDUSTRY 4.0
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ACCELERATED MACHINING



TurnLine

TURNINGA
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TUNG ACCELERATED MACHINING **FORCE** **TURN**



Now offers short shank holders readily suited
for the latest CNC turret designs

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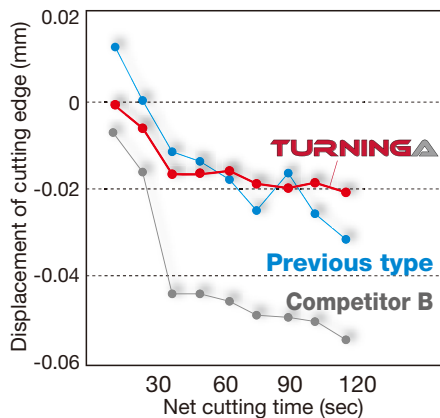
Highly rigid “Double-Clamp” system provides remarkable stability and high accuracy!

Simple and strong double-clamp system

Provides strong clamping force with one screw

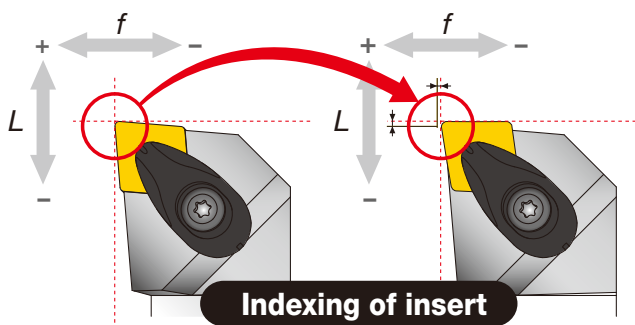
Only one screw and one action delivers double clamping force by simultaneously pushing down and pulling. This strong clamping force provides high stability for the cutting edge.

■ Comparison of cutting edge stability




Toolholder : AVJNR2525M16-A
 Insert : VNMG160408-ZM
 Work material : Carbon steel (JIS S45C)
 Machining mode : Continuous
 Cutting speed : $V_c = 150$ m/min
 Depth of cut : $a_p = 1.0 \sim 2.0$ mm
 Feed : $f = 0.3$ mm/rev

Higher indexing accuracy

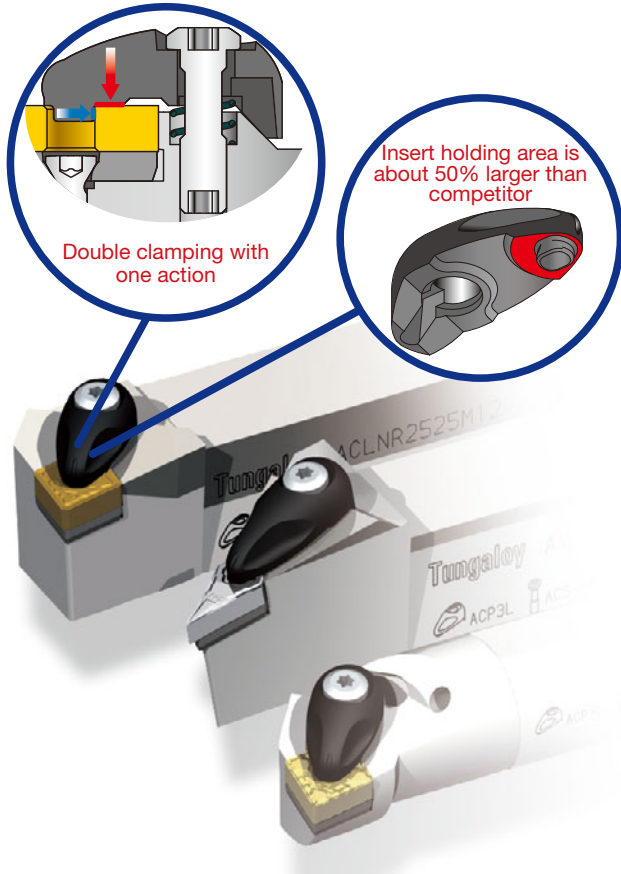


■ Indexing accuracy

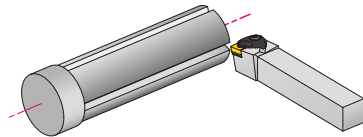
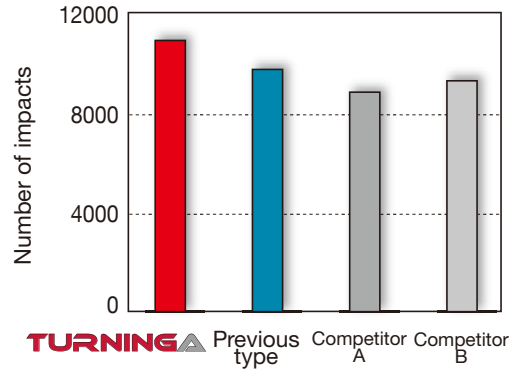
	f direction (μm)	L direction (μm)
TURNING 	0.8	1.4
Previous type	1.1	2.2
Competitor A	2.8	7.7
Competitor B	3.8	1.5
Competitor C	1.0	2.2

Unique clamp improves rigidity

Larger holding area enhances clamping force drastically. Higher rigidity provides excellent stability and reduces vibration.



Comparison of impact resistance

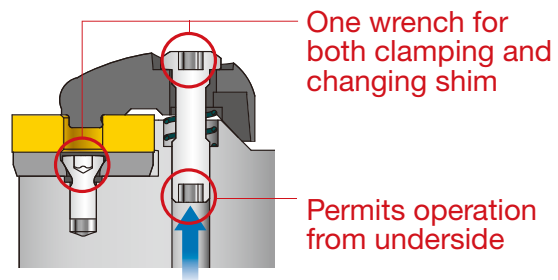


Toolholder : ACLNR2525M12-A
 Insert : CNMG120408-TM
 Grade : T9115
 Work material : Carbon steel (JIS S45C)
 Machining mode : Interrupted
 Cutting speed : $V_c = 200$ m/min
 Depth of cut : $a_p = 1.0 \sim 2.0$ mm
 Feed : $f = 0.3$ mm/rev

Easy handling and maintenance

Only one wrench required

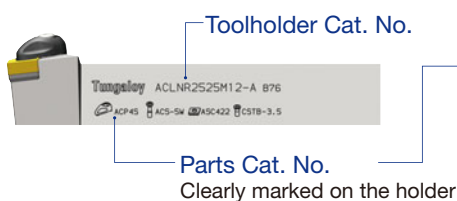
Only one wrench is required for the clamping screw and the shim screw.
Easy maintenance!



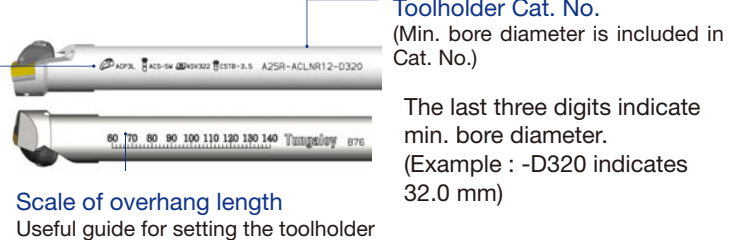
Marking

Parts Cat. No. are marked on the holder.

External-use toolholder

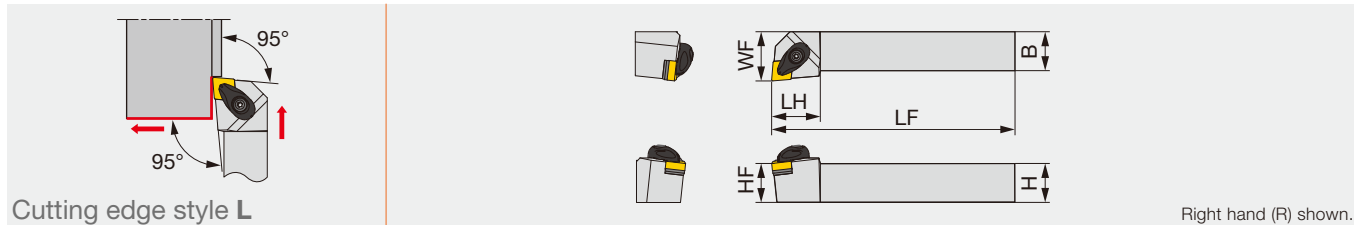


Internal-use toolholders



ACLNR/L

Double-clamp toolholders – 95° approach angle. For negative 80° rhombic insert



TURNINGA

	Designation	H	B	LF	LH	HF	WF	RE**	Insert	Torque*
New	ACLNR/L2020H12-A	20	20	100	26	20	25	0.8	CN**1204...	3
	ACLNR/L2020K12-A	20	20	125	26	20	25	0.8	CN**1204...	3
	ACLNR/L2525M12-A	25	25	150	30	25	32	0.8	CN**1204...	3
	ACLNR/L3225P12-A	32	25	170	30	32	32	0.8	CN**1204...	3
New	ACLNR/L2525K12-A	25	25	125	30	25	32	0.8	CN**1204...	3
	ACLNR/L2525M16-A	25	25	150	31	25	32	1.2	CN**1606...	6.4
	ACLNR/L3225P16-A	32	25	170	31	32	32	1.2	CN**1606...	6.4
	ACLNR/L3232P16-A	32	32	170	31	32	40	1.2	CN**1606...	6.4
	ACLNR/L3232P19-A	32	32	170	40	32	40	1.2	CN**1906...	6.4
	ACLNR/L4040S19-A	40	40	250	40	40	50	1.2	CN**1906...	6.4

*Torque: Recommended torque (N·m) for clamping RE**: Standard corner radius

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	Designation	H	B	LF	LH	HF	WF	RE**	Insert	Torque*
	ACLNR/L2020K0904-A	20	20	125	25	20	25	0.8	CN**0904...	3
	ACLNR/L2525M0904-A	25	25	150	25	25	32	0.8	CN**0904...	3

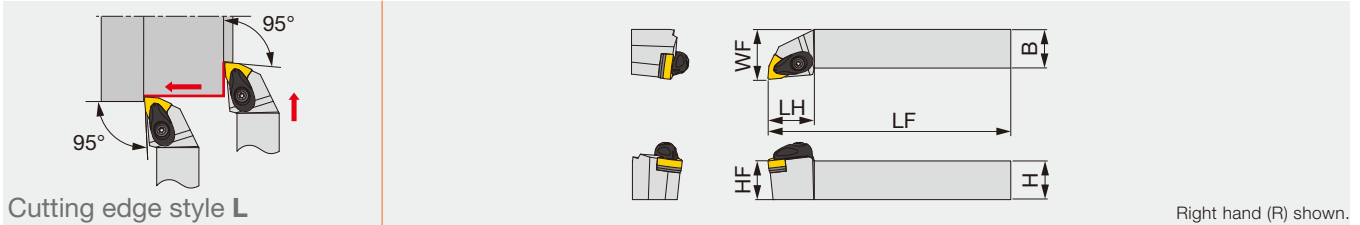
*Torque: Recommended torque (N·m) for clamping RE**: Standard corner radius

SPARE PARTS

Designation	Clamp	Clamp screw	Spring	Spring pin	Shim	Shim screw	Wrench1	Wrench2
ACLNR/L**12-A	ACP4S	ACS-5W	BP-7	SP-2.5	ASC422	CSTB-3.5	T-15F	-
ACLNR/L**16-A	ACP5S	ACS-6W	BP-8.8	SP-2.5	ASC533	CSTB-5	-	KEYV-T20
ACLNR/L**19-A	ACP6S	ACS-6W	BP-8.8	SP-2.5	ASC634	CSTB-5	-	KEYV-T20
ACLNR/L**0904-A	ACP3S-E	ACS-5W	BP-7	SP-2.5	ASC322	CSTB-3.5	T-15F	-

AWLNR/L

Double-clamp toolholders – 95° approach angle. For negative 80° trigon insert



TURNING

	Designation	H	B	LF	LH	HF	WF	RE**	Insert	Torque*
New	AWLNR/L2020H08-A	20	20	100	30	20	25	0.8	WN**0804...	3
	AWLNR/L2020K06-A	20	20	125	27	20	25	0.8	WN**0604...	3
	AWLNR/L2020K08-A	20	20	125	30	20	25	0.8	WN**0804...	3
	AWLNR/L2525M06-A	25	25	150	27	25	32	0.8	WN**0604...	3
New	AWLNR/L2525K08-A	25	25	125	30	25	32	0.8	WN**0804..	3
	AWLNR/L2525M08-A	25	25	150	30	25	32	0.8	WN**0804...	3
	AWLNR/L3225P08-A	32	25	170	30	25	32	0.8	WN**0804...	3

*Torque: Recommended torque (N·m) for clamping RE**: Standard corner radius

ISO ETURN

	Designation	H	B	LF	LH	HF	WF	RE**	Insert	Torque*
	AWLNR/L2020K0604-A	20	20	125	27	20	25	0.8	WN**0604...	3
	AWLNR/L2525M0604-A	25	25	150	27	25	32	0.8	WN**0604...	3

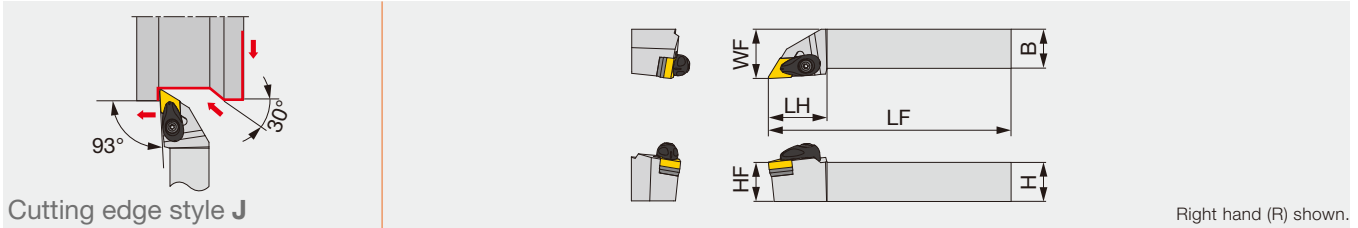
*Torque: Recommended torque (N·m) for clamping RE**: Standard corner radius

SPARE PARTS

Designation	Clamp	Clamp screw	Spring	Spring pin	Shim	Shim screw	Wrench1
AWLNR/L**06-A	ACP3S	ACS-5W	BP-7	SP-2.5	ASW322	CSTB-3.5	T-15F
AWLNR/L**08-A	ACP4S	ACS-5W	BP-7	SP-2.5	ASW422	CSTB-3.5	T-15F
AWLNR/L**0604-A	ACP3S-E	ACS-5W	BP-7	SP-2.5	ASW322	CSTB-3.5	T-15F

ADJNR/L

Double-clamp toolholders – 93° approach angle. For negative 55° rhombic insert



TURNINGA

Designation	H	B	LF	LH	HF	WF	RE**	Insert	Torque*
ADJNR/L2020K15-A	20	20	125	36	20	25	0.8	DN**1504...	3
ADJNR/L2020K1506-A	20	20	125	36	20	25	0.8	DN**1506...	3
ADJNR/L2525M15-A	25	25	150	36	25	32	0.8	DN**1504...	3
ADJNR/L2525M1506-A	25	25	150	36	25	32	0.8	DN**1506...	3
ADJNR/L3225P15-A	32	25	170	36	32	32	0.8	DN**1504...	3

*Torque: Recommended torque (N·m) for clamping RE**: Standard corner radius

ISO E^{93°}TURN

Designation	H	B	LF	LH	HF	WF	RE**	Insert	Torque*
ADJNR/L2020K1104-A	20	20	125	30	20	25	0.8	DN**1104...	3
ADJNR/L2525M1104-A	25	25	150	30	25	32	0.8	DN**1104...	3

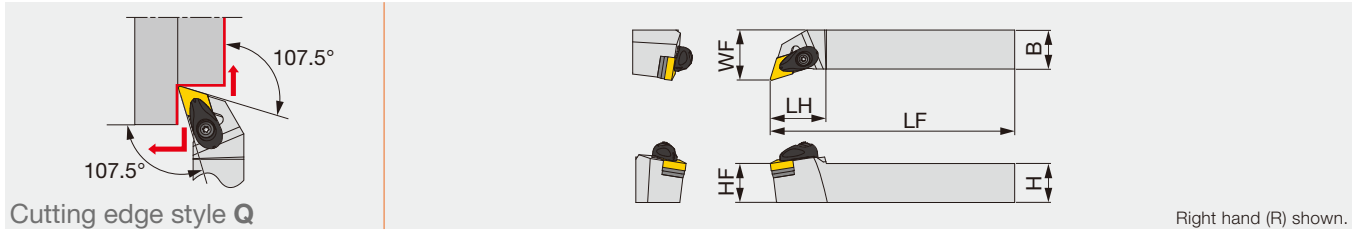
*Torque: Recommended torque (N·m) for clamping RE**: Standard corner radius

SPARE PARTS

Designation	Clamp	Clamp screw	Spring	Spring pin	Shim	Shim screw	Wrench
ADJNR/L**15-A	ACP4S	ACS-5W	BP-7	SP-2.5	ASD432	CSTB-3.5	T-15F
ADJNR/L**1506-A	ACP4S	ACS-5W	BP-7	SP-2.5	ASD432	CSTB-3.5	T-15F
ADJNR/L**1104-A	ACP3S-E	ACS-5W	BP-7	SP-2.5	ASD322	CSTB-3.5	T-15F

ADQNR/L

Double-clamp toolholders – 107.5° approach angle. For negative 55° rhombic insert



TURNING

Designation	H	B	LF	LH	HF	WF	RE**	Insert	Torque*
ADQNR/L2020K15-A	20	20	125	32	20	25	0.8	DN**1504...	3
ADQNR/L2020K1506-A	20	20	125	32	20	25	0.8	DN**1506...	3
ADQNR/L2525M15-A	25	25	150	36	25	32	0.8	DN**1504...	3
ADQNR/L2525M1506-A	25	25	150	36	25	32	0.8	DN**1506...	3

*Torque: Recommended torque (N·m) for clamping RE**: Standard corner radius

ISO ETURN

Designation	H	B	LF	LH	HF	WF	RE**	Insert	Torque*
ADQNR/L2020K1104-A	20	20	125	30	20	25	0.8	DN**1104...	3
ADQNR/L2525M1104-A	25	25	150	30	25	32	0.8	DN**1104...	3

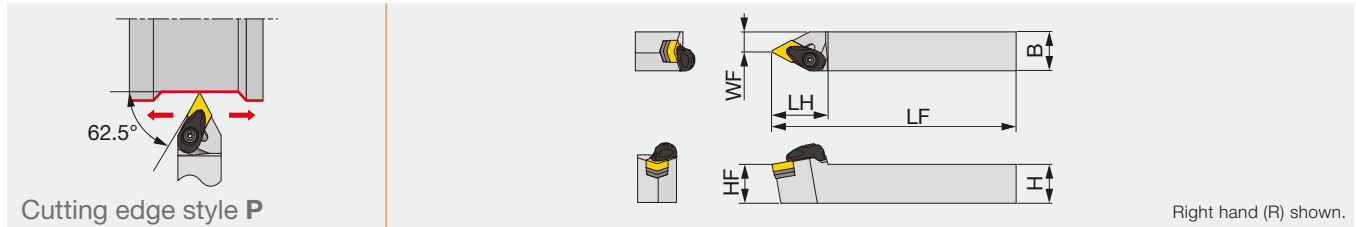
*Torque: Recommended torque (N·m) for clamping RE**: Standard corner radius

SPARE PARTS

Designation	Clamp	Clamp screw	Spring	Spring pin	Shim	Shim screw	Wrench
ADQNR/L**15-A	ACP4S	ACS-5W	BP-7	SP-2.5	ASD432	CSTB-3.5	T-15F
ADQNR/L**1506-A	ACP4S	ACS-5W	BP-7	SP-2.5	ASD432	CSTB-3.5	T-15F
ADQNR/L**1104-A	ACP3S-E	ACS-5W	BP-7	SP-2.5	ASD322	CSTB-3.5	T-15F

ADPNN

Double-clamp toolholder with 62.5° approach angle, for negative 55° rhombic inserts



Designation	H	B	LF	LH	HF	WF	RE**	Insert	Torque*
ADPNN2020K15-A	20	20	125	36	20	7.5	0.8	DN**1504...	3
ADPNN2525M15-A	25	25	150	36	25	12.5	0.8	DN**1504...	3

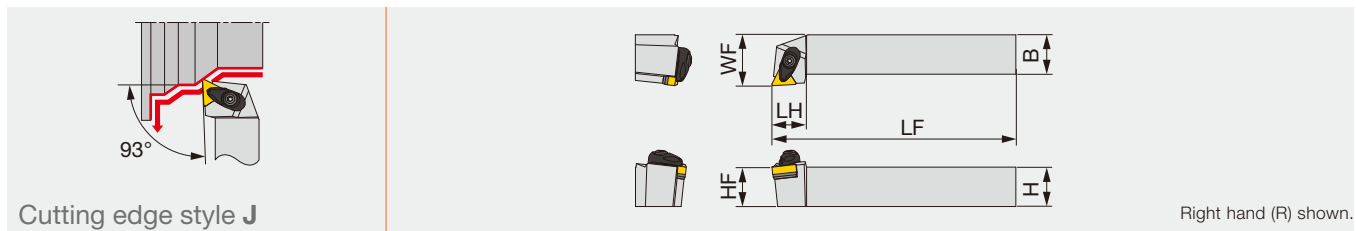
*Torque: Recommended torque (N·m) for clamping RE**: Standard corner radius

SPARE PARTS

Designation	Clamp	Clamp screw	Spring	Spring pin	Shim	Shim screw	Wrench
ADPNN**15-A	ACP4S	ACS-5W	BP-7	SP-2.5	ASD432	CSTB-3.5	T-15F

ATJNR/L

Double-clamp toolholder with 93° approach angle, for negative triangle inserts



Designation	H	B	LF	LH	HF	WF	RE**	Insert	Torque*
ATJNR/L2020K16-A	20	20	125	22	20	25	0.8	TN**1604...	3
ATJNR/L2525M16-A	25	25	150	22	25	32	0.8	TN**1604...	3

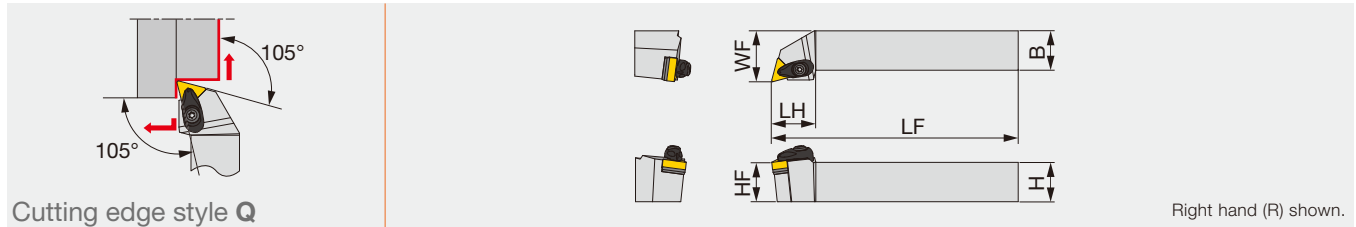
*Torque: Recommended torque (N·m) for clamping RE**: Standard corner radius

SPARE PARTS

Designation	Clamp	Clamp screw	Spring	Spring pin	Shim	Shim screw	Wrench
ATJNR/L**16-A	ACP3S	ACS-5W	BP-7	SP-2.5	AST322	CSTB-3.5	T-15F

ATQNR/L

Double-clamp toolholder with 105° approach angle, for negative triangle inserts



Designation	H	B	LF	LH	HF	WF	RE**	Insert	Torque*
ATQNR/L2020K16-A	20	20	125	28	20	25	0.8	TN**1604...	3
ATQNR/L2525M16-A	25	25	150	28	25	32	0.8	TN**1604...	3

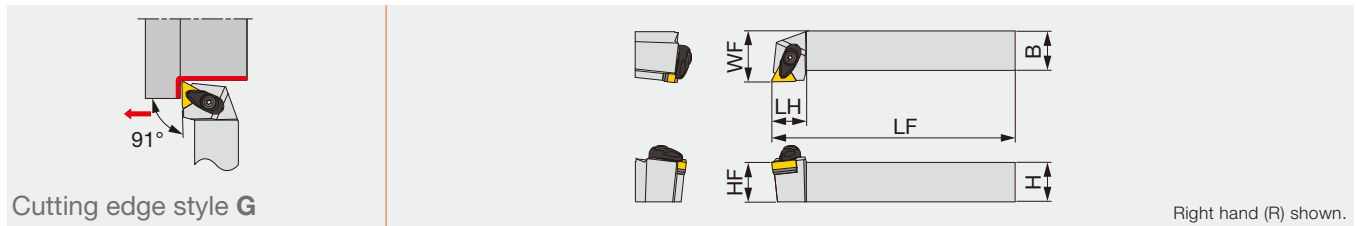
*Torque: Recommended torque (N·m) for clamping RE**: Standard corner radius

SPARE PARTS

Designation	Clamp	Clamp screw	Spring	Spring pin	Shim	Shim screw	Wrench
ATQNR/L**16-A	ACP3S	ACS-5W	BP-7	SP-2.5	AST322	CSTB-3.5	T-15F

ATGNR/L

Double-clamp toolholder with 91° approach angle, for negative triangle inserts



Designation	H	B	LF	LH	HF	WF	RE**	Insert	Torque*
ATGNR/L2020K16-A	20	20	125	22	20	25	0.8	TN**1604...	3
ATGNR/L2525M16-A	25	25	150	22	25	32	0.8	TN**1604...	3
ATGNR/L2525M22-A	25	25	150	26	25	32	0.8	TN**2204...	3

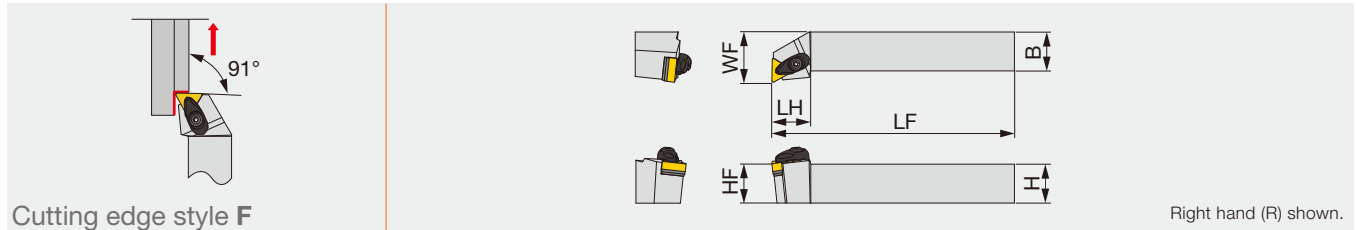
*Torque: Recommended torque (N·m) for clamping RE**: Standard corner radius

SPARE PARTS

Designation	Clamp	Clamp screw	Spring	Spring pin	Shim	Shim screw	Wrench
ATGNR/L**16-A	ACP3S	ACS-5W	BP-7	SP-2.5	AST322	CSTB-3.5	T-15F
ATGNR/L**22-A	ACP4S	ACS-5W	BP-7	SP-2.5	AST422	CSTB-3.5	T-15F

ATFNR/L

Double-clamp toolholder for facing with 91° approach angle, negative triangle inserts



Designation	H	B	LF	LH	HF	WF	RE**	Insert	Torque*
ATFNR/L2020K16-A	20	20	125	25	20	25	0.8	TN**1604...	3
ATFNR/L2525M16-A	25	25	150	25	25	32	0.8	TN**1604...	3
ATFNR/L2525M22-A	25	25	150	29	25	32	0.8	TN**2204...	3

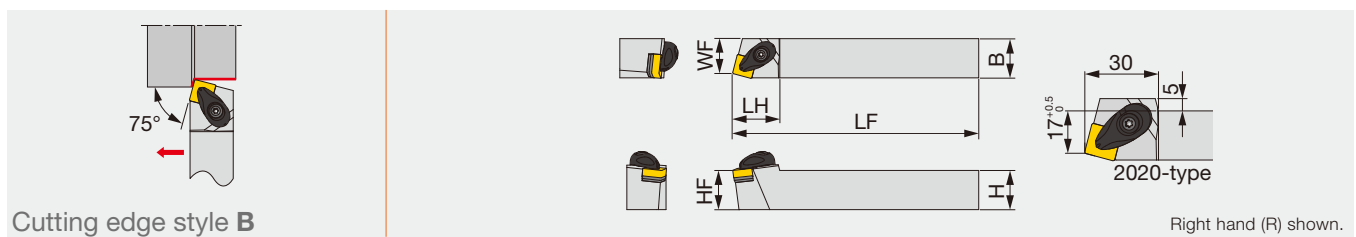
*Torque: Recommended torque (N·m) for clamping RE**: Standard corner radius

SPARE PARTS

Designation	Clamp	Clamp screw	Spring	Spring pin	Shim	Shim screw	Wrench
ATFNR/L**16-A	ACP3S	ACS-5W	BP-7	SP-2.5	AST322	CSTB-3.5	T-15F
ATFNR/L**22-A	ACP4S	ACS-5W	BP-7	SP-2.5	AST422	CSTB-3.5	T-15F

ASBNR/L

Double-clamp toolholder with 75° approach angle, for negative square inserts



Designation	H	B	LF	LH	HF	WF	RE**	Insert	Torque*
ASBNR/L2020K12-A	20	20	125	30	20	17	0.8	SN**1204...	3
ASBNR/L2525M12-A	25	25	150	30	25	22	0.8	SN**1204...	3
ASBNR/L2525M15-A	25	25	150	42.5	25	22	1.2	SN**1506...	6.4
ASBNR/L3232P15-A	32	32	170	42.5	32	27	1.2	SN**1506...	6.4
ASBNR/L3232P19-A	32	32	170	47.5	32	27	1.2	SN**1906...	6.4
ASBNR/L4040S19-A	40	40	250	47.5	40	35	1.2	SN**1906...	6.4

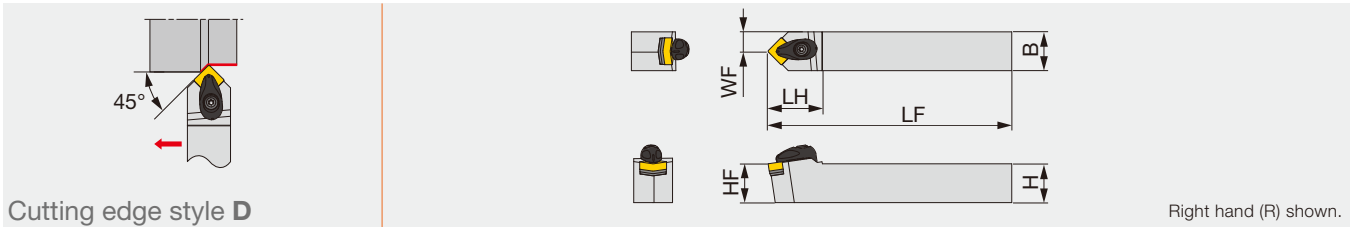
*Torque: Recommended torque (N·m) for clamping RE**: Standard corner radius

SPARE PARTS

Designation	Clamp	Clamp screw	Spring	Spring pin	Shim	Shim screw	Wrench1	Wrench2
ASBNR/L**12-A	ACP4S	ACS-5W	BP-7	SP-2.5	ASS422	CSTB-3.5	T-15F	-
ASBNR/L**15-A	ACP5S	ACS-6W	BP-8.8	SP-2.5	ASS533	CSTB-5	-	KEYV-T20
ASBNR/L**19-A	ACP6S	ACS-6W	BP-8.8	SP-2.5	ASS634	CSTB-5	-	KEYV-T20

ASDNN

Double-clamp toolholder with 45° approach angle, for negative square inserts



Designation	H	B	LF	LH	HF	WF	RE**	Insert	Torque*
ASDNN2020K12-A	20	20	125	35	20	10	0.8	SN**1204...	3
ASDNN2525M12-A	25	25	150	35	25	12.5	0.8	SN**1204...	3

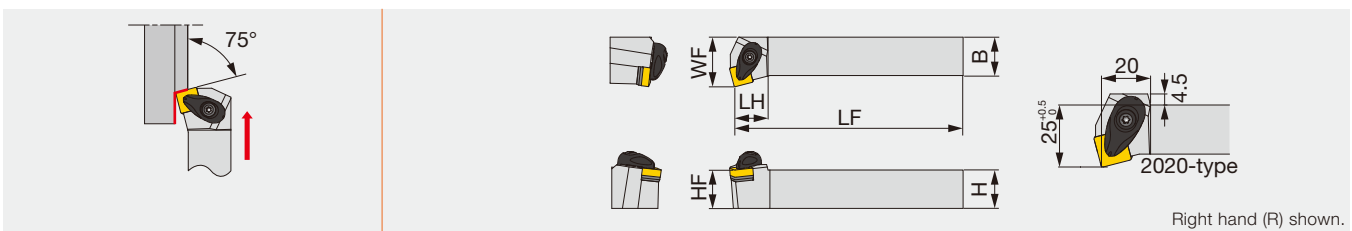
*Torque: Recommended torque (N·m) for clamping RE**: Standard corner radius

SPARE PARTS

Designation	Clamp	Clamp screw	Spring	Spring pin	Shim	Shim screw	Wrench
ASDNN**12-A	ACP4S	ACS-5W	BP-7	SP-2.5	ASS422	CSTB-3.5	T-15F

ASKNR/L

Double-clamp toolholder with 75° approach angle, for negative square inserts



Designation	H	B	LF	LH	HF	WF	RE**	Insert	Torque*
ASKNR/L2020K12-A	20	20	125	20	20	25	0.8	SN**1204...	3
ASKNR/L2525M12-A	25	25	150	22	25	32	0.8	SN**1204...	3

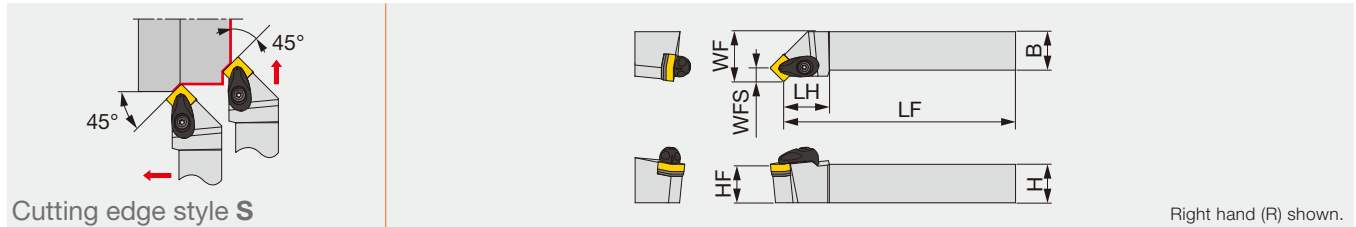
*Torque: Recommended torque (N·m) for clamping RE**: Standard corner radius

SPARE PARTS

Designation	Clamp	Clamp screw	Spring	Spring pin	Shim	Shim screw	Wrench
ASKNR/L**12-A	ACP4S	ACS-5W	BP-7	SP-2.5	ASS422	CSTB-3.5	T-15F

ASSNR/L

Double-clamp toolholder with 45° approach angle (S-style), for negative square inserts



Designation	H	B	LF	LH	HF	WF	WFS	RE**	Insert	Torque*
ASSNR/L2020K12-A	20	20	125	30	20	25	8.3	0.8	SN**1204...	3
ASSNR/L2525M12-A	25	25	150	30	25	32	8.3	0.8	SN**1204...	3
ASSNR/L2525M15-A	25	25	150	25	25	32	10.3	1.2	SN**1506...	6.4
ASSNR/L3232P15-A	32	32	170	25	32	40	10.3	1.2	SN**1506...	6.4
ASSNR/L3232P19-A	32	32	170	27.5	32	40	12.5	1.2	SN**1906...	6.4
ASSNR/L4040S19-A	40	40	250	27.5	40	50	12.5	1.2	SN**1906...	6.4

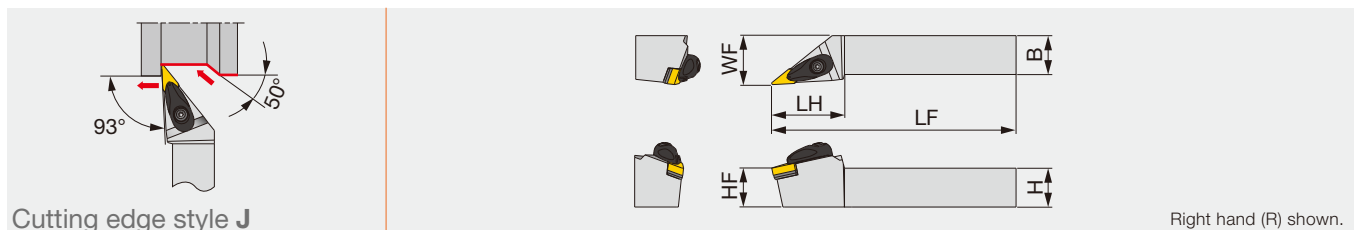
*Torque: Recommended torque (N·m) for clamping RE**: Standard corner radius

SPARE PARTS

Designation	Clamp	Clamp screw	Spring	Spring pin	Shim	Shim screw	Wrench1	Wrench2
ASSNR/L**12-A	ACP4S	ACS-5W	BP-7	SP-2.5	ASS422	CSTB-3.5	T-15F	-
ASSNR/L**15-A	ACP5S	ACS-6W	BP-8.8	SP-2.5	ASS533	CSTB-5	-	KEYV-T20
ASSNR/L**19-A	ACP6S	ACS-6W	BP-8.8	SP-2.5	ASS634	CSTB-5	-	KEYV-T20

AVJNR/L

Double-clamp toolholders – 93° approach angle. For negative 35° rhombic insert



Cutting edge style J

Designation	H	B	LF	LH	HF	WF	RE**	Insert	Torque*
AVJNR/L2020K16-A	20	20	125	43	20	25	0.8	V/YN**1604...	3
AVJNR/L2525M16-A	25	25	150	46	25	32	0.8	V/YN**1604...	3

*Torque: Recommended torque (N·m) for clamping RE**: Standard corner radius

ISO ETURN

Designation	H	B	LF	LH	HF	WF	RE**	Insert	Torque*
AVJNR/L2020K1204-A	20	20	125	37	20	25	0.8	VN**1204...	3
AVJNR/L2525M1204-A	25	25	150	37	25	32	0.8	VN**1204...	3

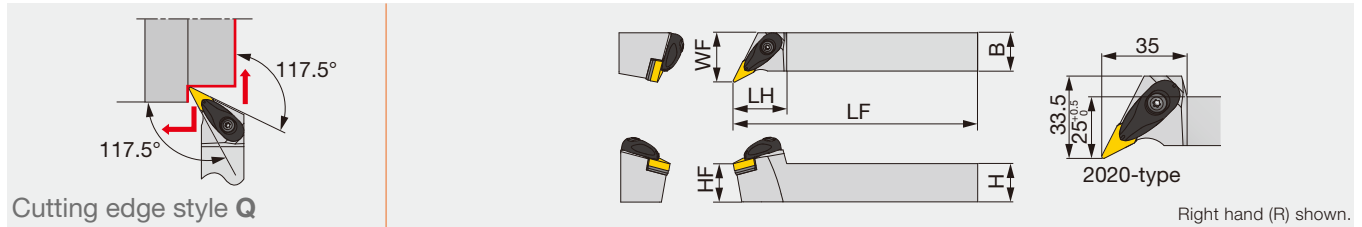
*Torque: Recommended torque (N·m) for clamping RE**: Standard corner radius

SPARE PARTS

Designation	Clamp	Clamp screw	Spring	Spring pin	Shim	Shim screw	Wrench
AVJNR/L**16-A	ACP3L	ACS-5W	BP-7	SP-2.5	ASV322	CSTB-3.5	T-15F
AVJNR/L**1204-A	ACP3L-E	ACS-5W	BP-7	SP-2.5	ASV222	CSTB-3.0	T-15F

AVQNR/L

Double-clamp toolholders – 117.5° approach angle. For negative 35° rhombic insert



TURNING

Designation	H	B	LF	LH	HF	WF	RE**	Insert	Torque*
AVQNR/L2020K16-A	20	20	125	35	20	25	0.8	V/YN**1604...	3
AVQNR/L2525M16-A	25	25	150	35	25	32	0.8	V/YN**1604...	3

*Torque: Recommended torque (N·m) for clamping RE**: Standard corner radius

ISO TURN

Designation	H	B	LF	LH	HF	WF	RE**	Insert	Torque*
AVQNR/L2020K1204-A	20	20	125	32	20	25	0.8	VN**1204...	3
AVQNR/L2525M1204-A	25	25	150	32	25	32	0.8	VN**1204...	3

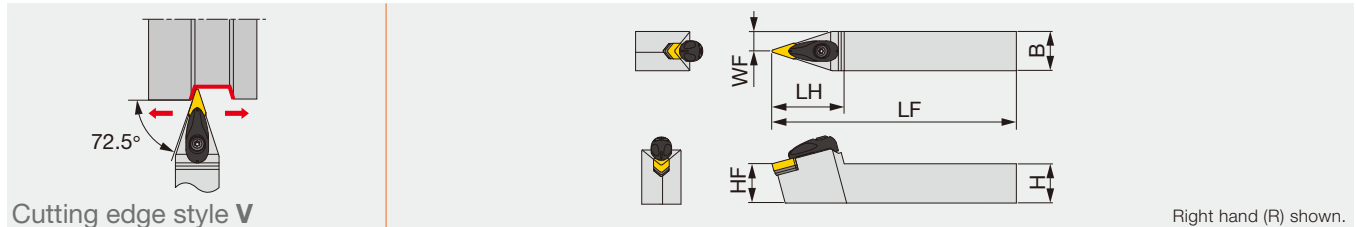
*Torque: Recommended torque (N·m) for clamping RE**: Standard corner radius

SPARE PARTS

Designation	Clamp	Clamp screw	Spring	Spring pin	Shim	Shim screw	Wrench
AVQNR/L...16-A	ACP3L	ACS-5W	BP-7	SP-2.5	ASV322	CSTB-3.5	T-15F
AVQNR/L**1204-A	ACP3L-E	ACS-5W	BP-7	SP-2.5	ASV222	CSTB-3.0	T-15F

AVVNN

Double-clamp toolholders – 72.5° approach angle. For negative 35° rhombic insert



TURNINGA

Designation	H	B	LF	LH	HF	WF	RE**	Insert	Torque*
AVVNN2020K16-A	20	20	125	46	20	10	0.8	V/YN**1604...	3
AVVNN2525M16-A	25	25	150	46	25	12.5	0.8	V/YN**1604...	3

*Torque: Recommended torque (N·m) for clamping RE**: Standard corner radius

ISO ETURN

Designation	H	B	LF	LH	HF	WF	RE**	Insert	Torque*
AVVNN2020K1204-A	20	20	125	38	20	10	0.8	VN**1204...	3
AVVNN2525K1204-A	25	25	150	38	25	13	0.8	VN**1204...	3

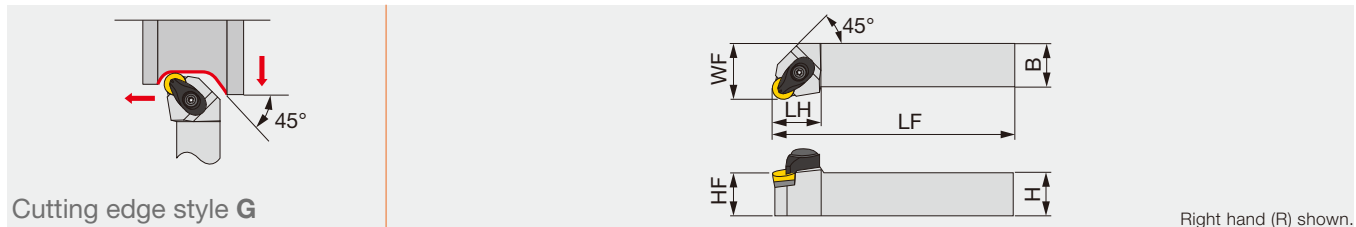
*Torque: Recommended torque (N·m) for clamping RE**: Standard corner radius

SPARE PARTS

Designation	Clamp	Clamp screw	Spring	Spring pin	Shim	Shim screw	Wrench
AVVNN**16-A	ACP3L	ACS-5W	BP-7	SP-2.5	ASV322	CSTB-3.5	T-15F
AVVNN**1204-A	ACP3L-E	ACS-5W	BP-7	SP-2.5	ASV222	CSTB-3.0	T-15F

ARGNR/L

Double-clamp toolholders – 117.5° approach angle. For negative 35° rhombic insert



Designation	H	B	LF	LH	HF	WF	RE**	Insert	Torque*
ARGNR/L2525M12-A	25	25	150	28	25	32	6.35	RN**120400	3

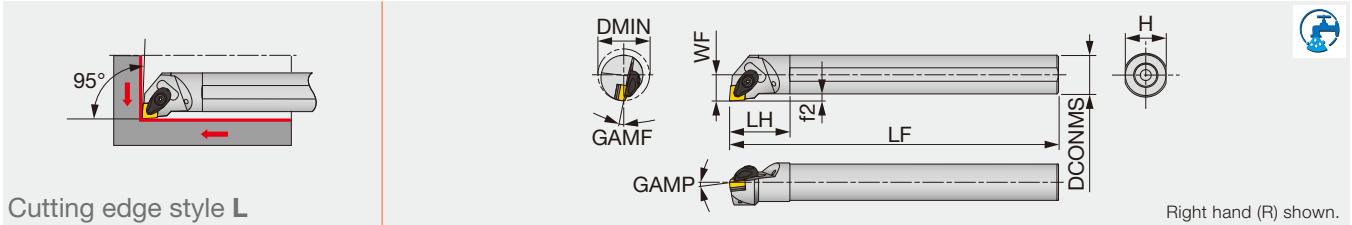
*Torque: Recommended torque (N·m) for clamping RE**: Standard corner radius

SPARE PARTS

Designation	Clamp	Clamp screw	Spring	Spring pin	Shim	Shim screw	Wrench
ARGNR/L...	ACP4S	ACS-5W	BP-7	SP-2.5	ASR420	CSTB-3.5	T-15F

A-ACLNR/L

Double-clamp boring bars. For negative 80° rhombic insert



Cutting edge style L

Right hand (R) shown.

TURNING

Designation	Material	DMIN	DCONMS	WF	LF	LH	H	f2	GAMP	GAMF	RE**	Insert	Torque*
A25R-ACLNR/L12-D320	Steel	32	25	17	200	45	23	4.5	-6°	-13°	0.8	CN**1204...	3
A32S-ACLNR/L12-D400	Steel	40	32	22	250	50	30	6	-6°	-10°	0.8	CN**1204...	3
A40T-ACLNR/L12-D500	Steel	50	40	27	300	55	37	7	-6°	-8°	0.8	CN**1204...	3
A50U-ACLNR12-D630	Steel	63	50	35	350	65	47	10	-6°	-7°	0.8	CN**1204...	3

*Torque: Recommended torque (N·m) for clamping RE**: Standard corner radius

ISO TURN

Designation	Material	DMIN	DCONMS	WF	LF	LH	H	f2	GAMP	GAMF	RE**	Insert	Torque*
A25R-ACLNR/L0904-D320	Steel	32	25	17	200	45	23	4.5	-6	-13	0.8	CN**0904...	3
A32S-ACLNR/L0904-D400	Steel	40	32	22	250	50	30	6	-6	-10	0.8	CN**0904...	3

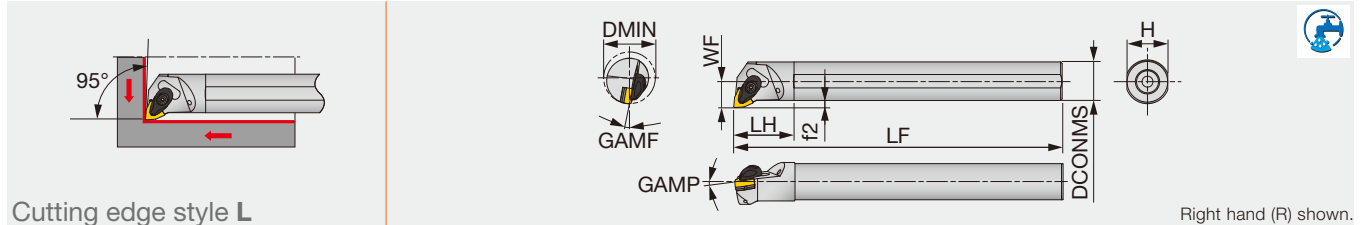
*Torque: Recommended torque (N·m) for clamping RE**: Standard corner radius

SPARE PARTS

Designation	Clamp	Clamp screw	Spring	Spring pin	Shim	Shim screw	Wrench
A**-ACLNR/L12-D...	ACP4S	ACS-5W	BP-7	SP-2.5	ASC422	CSTB-3.5	T-15F
A**-ACLNR/L0904...	ACP3S-E	ACS-5W	BP-7	SP-2.5	ASC322	CSTB-3.5	T-15F

A-AWLNR/L

Double-clamp boring bars. For negative 80° trigon insert



Cutting edge style L

Right hand (R) shown.



Designation	Material	DMIN	DCONMS	WF	LF	LH	H	f2	GAMP	GAMF	RE**	Insert	Torque*
A25R-AWLNR/L06-D320	Steel	32	25	17	200	45	23	4.5	-6°	-13°	0.8	WN**0604...	3
A32S-AWLNR/L06-D400	Steel	40	32	22	250	50	30	6	-6°	-10°	0.8	WN**0604...	3
A25R-AWLNR/L08-D320	Steel	32	25	17	200	45	23	4.5	-6°	-13°	0.8	WN**0804...	3
A32S-AWLNR/L08-D400	Steel	40	32	22	250	50	30	6	-6°	-10°	0.8	WN**0804...	3
A40T-AWLNR/L08-D500	Steel	50	40	27	300	55	37	7	-6°	-8°	0.8	WN**0804...	3
A50U-AWLNR/L08-D630	Steel	63	50	35	350	65	47	10	-6°	-7°	0.8	WN**0804...	3

*Torque: Recommended torque (N·m) for clamping RE**: Standard corner radius



Designation	Material	DMIN	DCONMS	WF	LF	LH	H	f2	GAMP	GAMF	RE**	Insert	Torque*
A25R-AWLNR/L0604-D320	Steel	32	25	17	200	45	23	4.5	-6	-13	0.8	WN**0604...	3
A32S-AWLNR/L0604-D400	Steel	40	32	22	250	50	30	6	-6	-10	0.8	WN**0604...	3

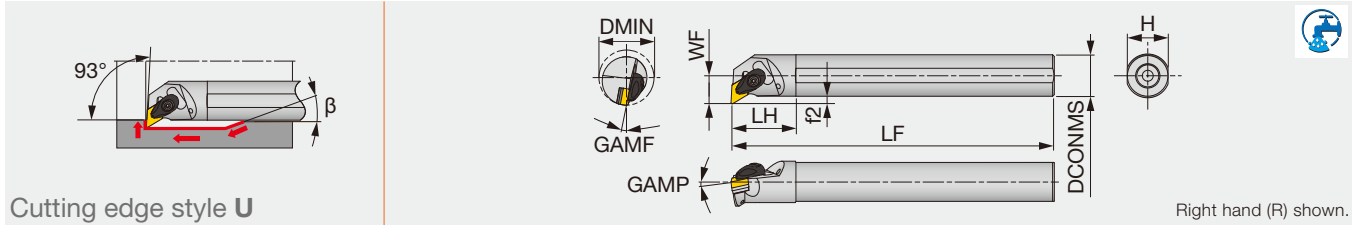
*Torque: Recommended torque (N·m) for clamping RE**: Standard corner radius

SPARE PARTS

Designation	Clamp	Clamp screw	Spring	Spring pin	Shim	Shim screw	Wrench
A**-AWLNR/L06-D...	ACP3S	ACS-5W	BP-7	SP-2.5	ASW322	CSTB-3.5	T-15F
A**-AWLNR/L08-D...	ACP4S	ACS-5W	BP-7	SP-2.5	ASW422	CSTB-3.5	T-15F
A**-AWLNR/L0604...	ACP3S-E	ACS-5W	BP-7	SP-2.5	ASW322	CSTB-3.5	T-15F

A-ADUNR/L

Double-clamp boring bars. For negative 55° rhombic insert



Cutting edge style U

Right hand (R) shown.

TURNING

Designation	Material	DMIN	DCONMS	WF	LF	LH	H	f2	GAMP	GAMF	β°	RE**	Insert	Torque*
A25R-ADUNR/L15-D320	Steel	32	25	17	200	45	23	4.5	-6°	-13°	30	0.8	DN**1504...	3
A32S-ADUNR/L15-D400	Steel	40	32	22	250	50	30	6	-6°	-11°	20	0.8	DN**1504...	3
A40T-ADUNR15-D500	Steel	50	40	27	300	55	37	7	-6°	-8°	15	0.8	DN**1504...	3
A50U-ADUNR15-D630	Steel	63	50	35	350	65	47	10	-6°	-7°	15	0.8	DN**1504...	3
A25R-ADUNR/L1506-D320	Steel	32	25	17	200	45	23	4.5	-6°	-13°	15	0.8	DN**1506...	3
A32S-ADUNR/L1506-D400	Steel	40	32	22	250	50	30	6	-6°	-11°	20	0.8	DN**1506...	3

*Torque: Recommended torque (N·m) for clamping RE**: Standard corner radius

ISO ETURN

Designation	Material	DMIN	DCONMS	WF	LF	LH	H	f2	GAMP	GAMF	β°	RE**	Insert	Torque*
A25R-ADUNR/L1104-D320	Steel	32	25	17	200	45	23	4.5	-6°	-13°	20	0.8	DN**1104...	3
A32S-ADUNR/L1104-D400	Steel	40	32	22	250	50	30	6	-6°	-11°	20	0.8	DN**1104...	3

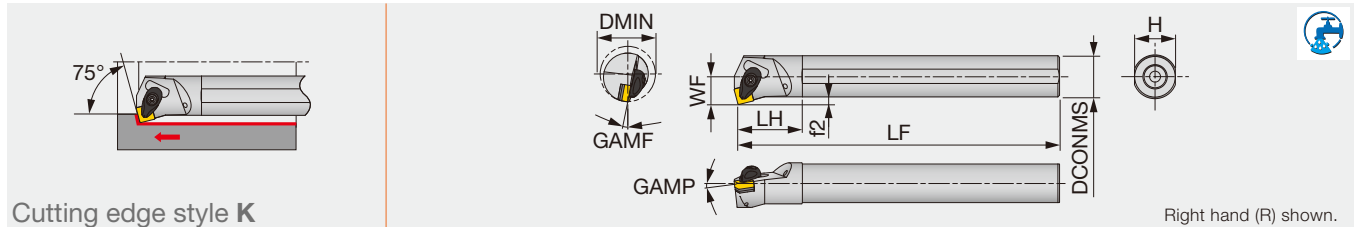
*Torque: Recommended torque (N·m) for clamping RE**: Standard corner radius

SPARE PARTS

Designation	Clamp	Clamp screw	Spring	Spring pin	Shim	Shim screw	Wrench
A**-ADUNR/L15-D...	ACP4S	ACS-5W	BP-7	SP-2.5	ASD432	CSTB-3.5	T-15F
A**-ADUNR/L1506-D...	ACP4S	ACS-5W	BP-7	SP-2.5	ASD423	CSTB-3.5	T-15F
A**-ADUNR/L1104...	ACP3S-E	ACS-5W	BP-7	SP-2.5	ASD322	CSTB-3.5	T-15F

A-ASKNR/L

Double-clamp boring bar, for negative square inserts



Designation	Material	DMIN	DCONMS	WF	LF	LH	H	f2	GAMP	GAMF	RE**	Insert	Torque*
A25R-ASKNR/L12-D320	Steel	32	25	17	200	45	23	4.5	-6°	-13°	0.8	SN**1204...	3
A32S-ASKNR/L12-D400	Steel	40	32	22	250	50	30	6	-6°	-10°	0.8	SN**1204...	3

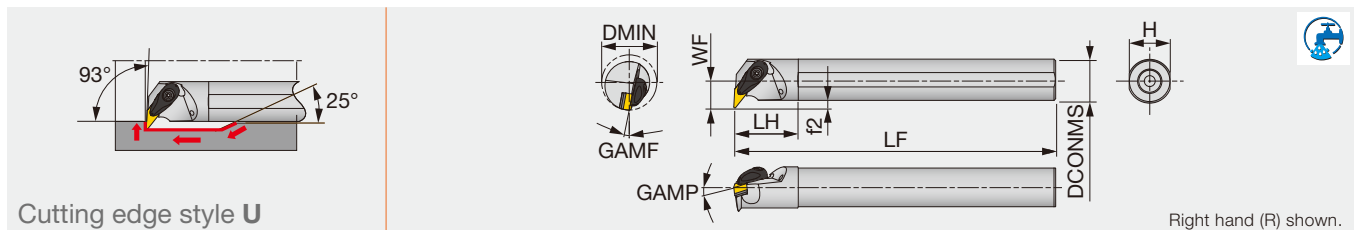
*Torque: Recommended torque (N·m) for clamping RE**: Standard corner radius

SPARE PARTS

Designation	Clamp	Clamp screw	Spring	Spring pin	Shim	Shim screw	Wrench
A**-ASKN*12-D...	ACP4S	ACS-5W	BP-7	SP-2.5	ASS422	CSTB-3.5	T-15F

A-AVUNR/L

Double-clamp boring bar, for negative 35° or 25° rhombic inserts



Designation	Material	DMIN	DCONMS	WF	LF	LH	H	f2	GAMP	GAMF	RE**	Insert	Torque*
A32S-AVUNR/L16-D400	Steel	40	32	22	250	50	30	6	-6°	-10°	0.8	V/YN**1604...	3
A40T-AVUNR/L16-D500	Steel	50	40	27	300	55	37	7	-6°	-8°	0.8	V/YN**1604...	3

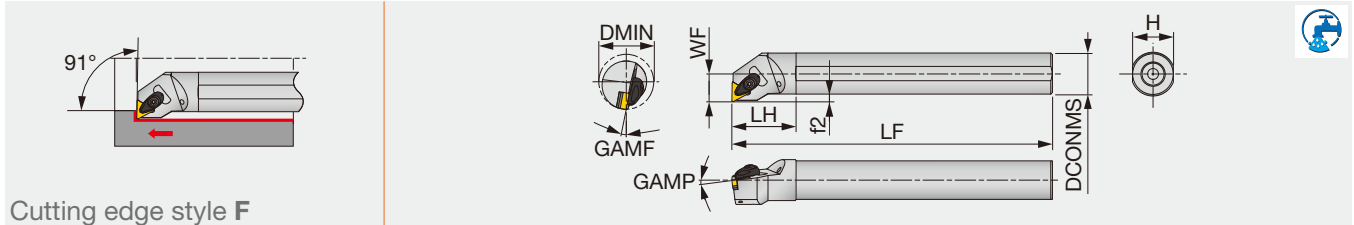
*Torque: Recommended torque (N·m) for clamping RE**: Standard corner radius

SPARE PARTS

Designation	Clamp	Clamp screw	Spring	Spring pin	Shim	Shim screw	Wrench
A**-AVUNR/L16-D...	ACP3L	ACS-5W	BP-7	SP-2.5	ASV322	CSTB-3.5	T-15F

A-ATFNR/L

Double-clamp boring bar, for negative triangle inserts



Cutting edge style F

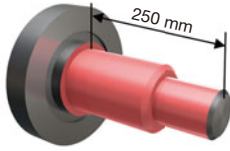

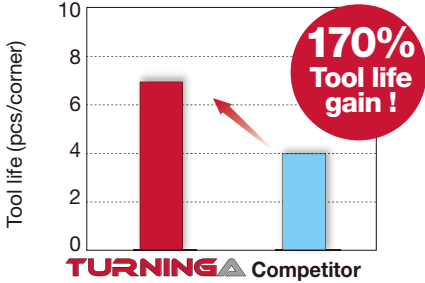
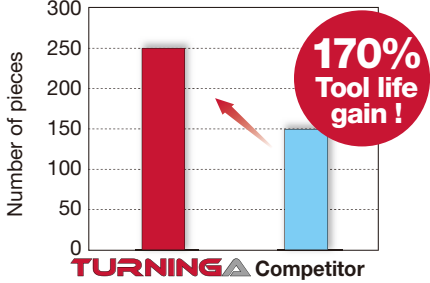
Designation	Material	DMIN	DCONMS	WF	LF	LH	H	f2	GAMP	GAMF	RE**	Insert	Torque*
A25R-ATFNR/L16-D320	Steel	32	25	17	200	45	23	4.5	-6°	-13°	0.8	TN**1604...	3
A32S-ATFNR/L16-D400	Steel	40	32	22	250	50	30	6	-6°	-10°	0.8	TN**1604...	3

*Torque: Recommended torque (N·m) for clamping RE**: Standard corner radius

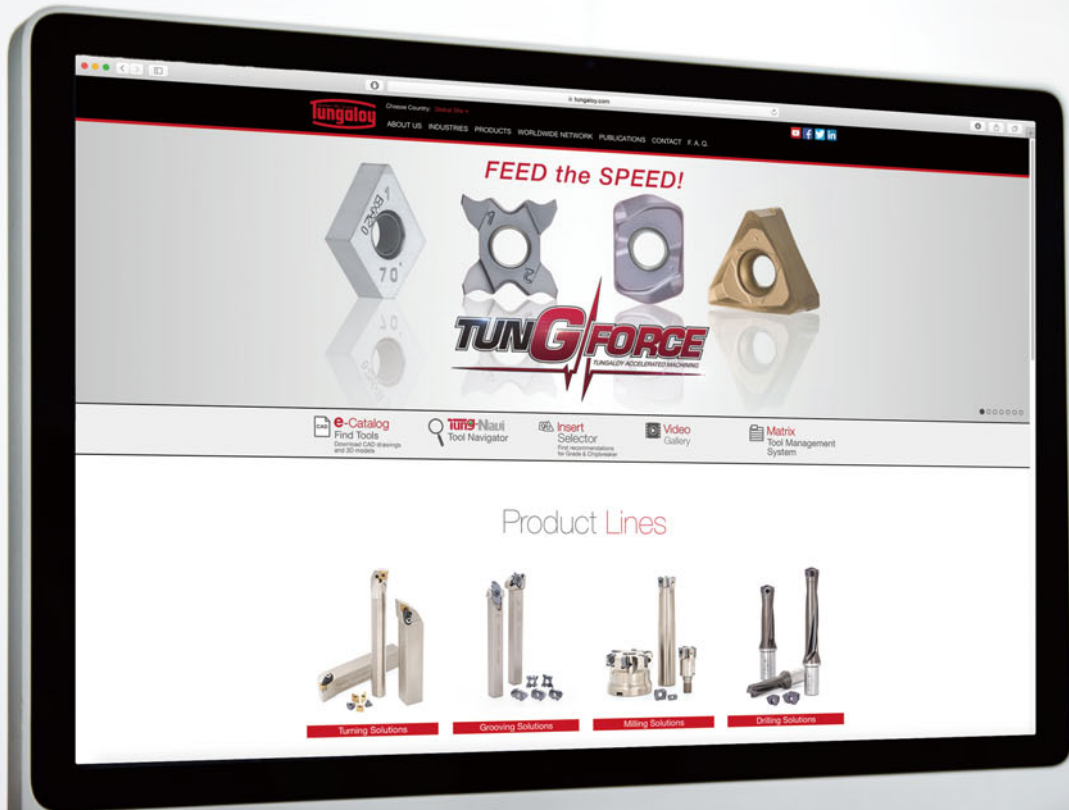
SPARE PARTS

Designation	Clamp	Clamp screw	Spring	Spring pin	Shim	Shim screw	Wrench
A**-ATFNR/L16-D...	ACP3S	ACS-5W	BP-7	SP-2.5	AST322	CSTB-3.5	T-15F

PRACTICAL EXAMPLES

Work piece type		Shaft parts	Hub (Automotive parts)
Toolholder		ACLNR2525M12-A	AWLNR2525M08-A
Insert		CNMG120408-TM	WNMG080412-TM
Grade		T9215	T9225
Workpiece material		SCM440 (42CrMo4)	SCM420(Alloy Steel)
			
Cutting conditions	Cutting speed : V_c (m/min)	250	220
	Feed : f (mm/rev)	0.3	0.3
	Depth of cut : a_p (mm)	3.5	1.0
	Machining	External profiling (Continuous)	Face & Profiling (Continuous & Interrupted)
	Coolant	Wet	Wet
Results		 <p>TURNINGA Competitor</p> <p>High clamping rigidity improves workpiece accuracy. Tool life can be improved by 170%.</p>	 <p>TURNINGA Competitor</p> <p>High clamping strength drastically decreases the potential for sudden fracture. Tool life can be improved by 170%.</p>

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