

TurnLine

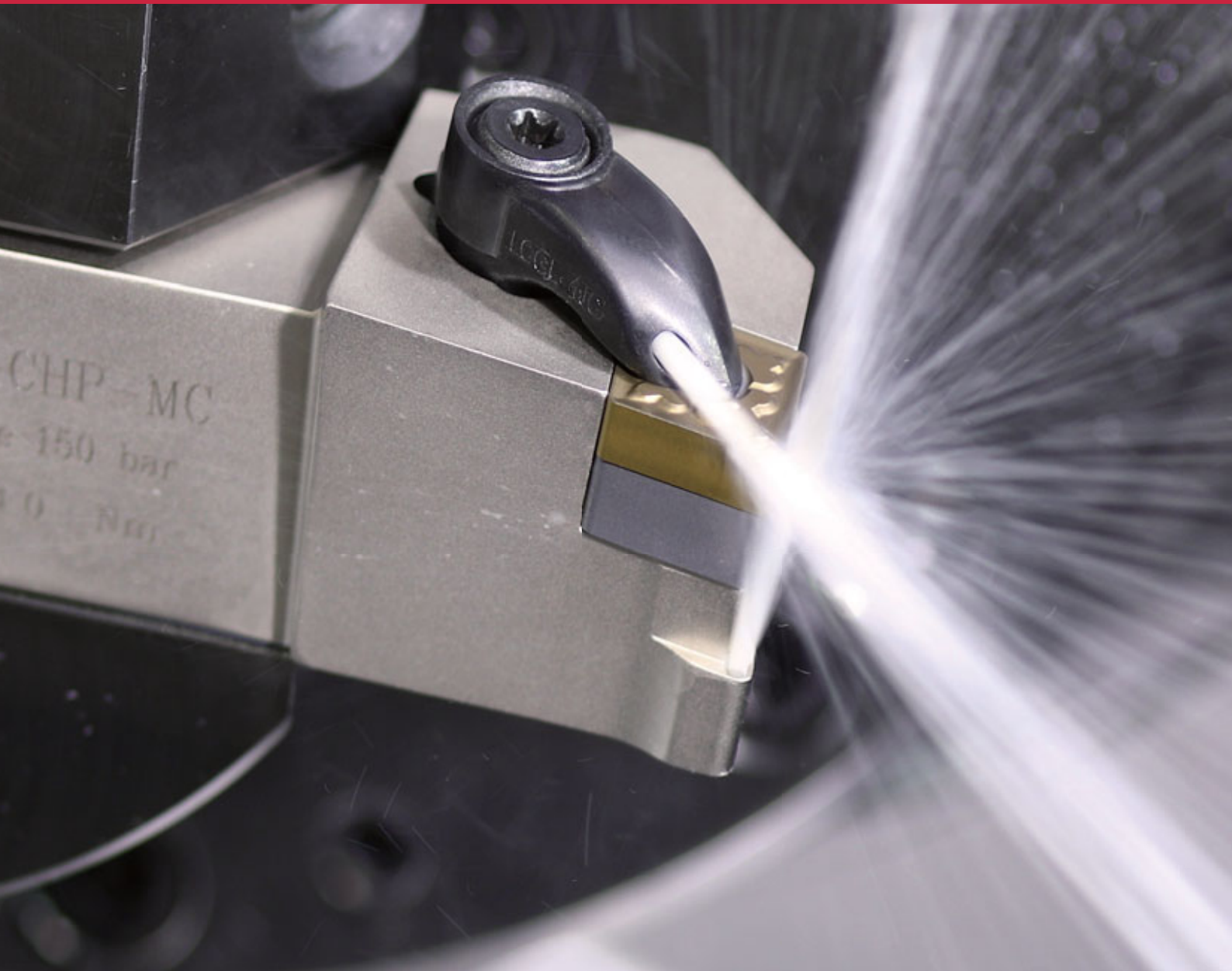
**TUNG T<sup>URN</sup> JET**

www.tungaloy.com

Tungaloy Report No. 432-G



## Double clamp turning & External threading toolholders with through-coolant capability



**INDUSTRY 4.0**  
*FEED the SPEED!*



C6ASHA25-HPMC  
6121257

**Sumitomo** SER2525X16-CHP-MC  
High pressure coolant  
9261239

ACCELERATED MACHINING



TurnLine

**TUNG T<sup>URN</sup> TJET**  
TUNGALOY

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


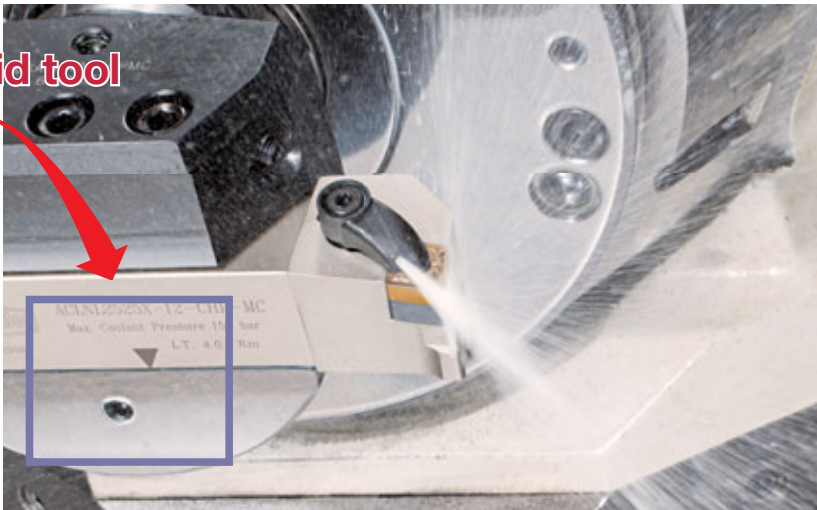








Wide line up enable to improve all applications

[www.tungaloy.com](http://www.tungaloy.com)

## Optimized two streams of coolant jets to maximize productivity

### Internal coolant toolholder series

	Tube connection	Direct connection
For general lathes	<p><b>New</b></p>  <p>Hybrid tool</p>	
		  <p>For VDI (DIN 69880) &amp; PSC adapter</p>
For small lathes		  <p>Machines for direct system : L20 &amp; D25</p>
Features	<ul style="list-style-type: none"> <li>- Mountable to varieties types of machines</li> <li>- Flexible tube connections</li> </ul>	<ul style="list-style-type: none"> <li>- No tubes needed</li> <li>- No chip tangling</li> <li>- Easy tool change-over</li> </ul>

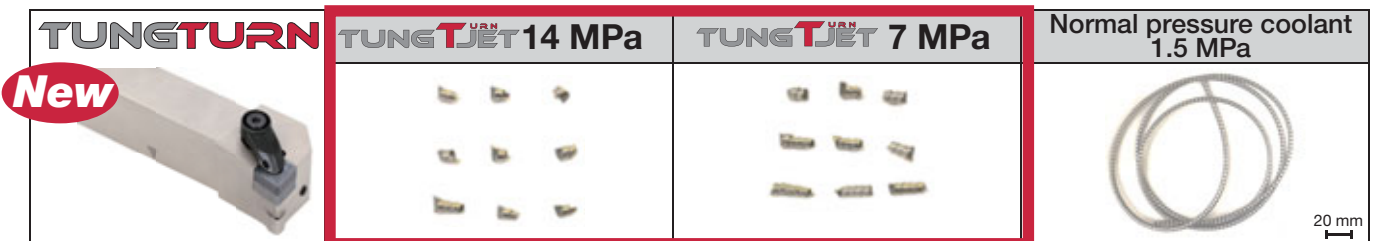
Double clamp turning tool holders



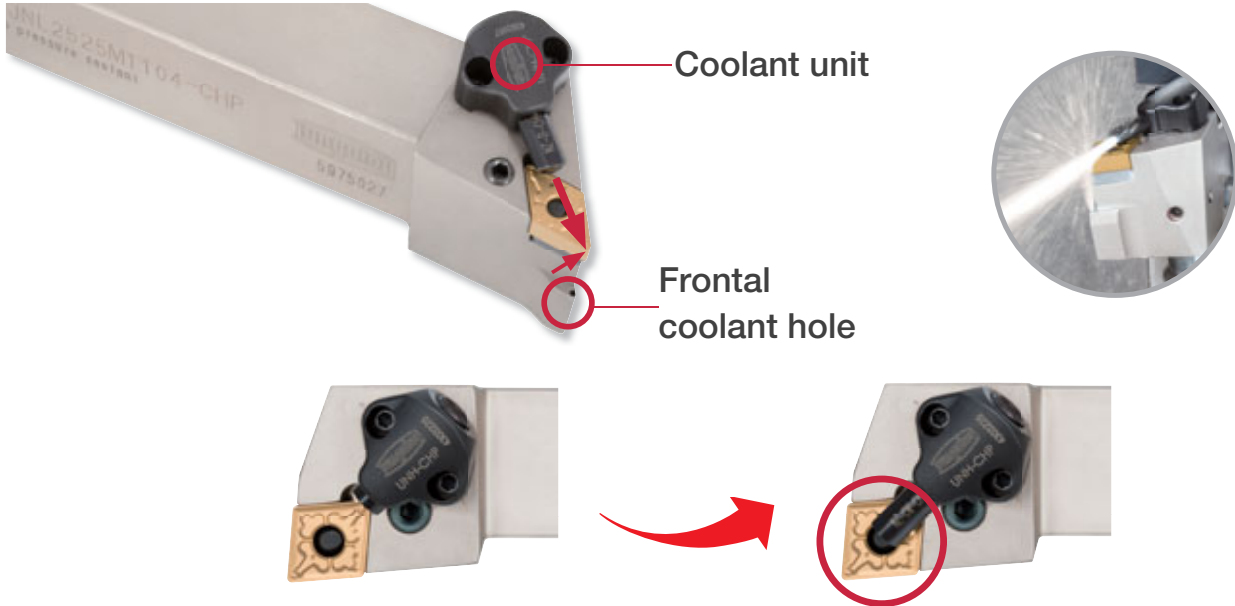
Improvement of chip control with internal coolant

**S** Heat-resistant alloys  
(Inconel 718)

Workpiece materials : INCONEL 718  
 Toolholder : **ACLNL2525X-12-CHP-MC**  
 Insert : CNMG120408-HRM AH8005  
 Cutting speed :  $V_c = 60$  m/min  
 Feed :  $f = 0.15$  mm/rev  
 Depth of cut :  $ap = 2.0$  mm



## Lever lock clamp (Nozzle style) turning tool holders

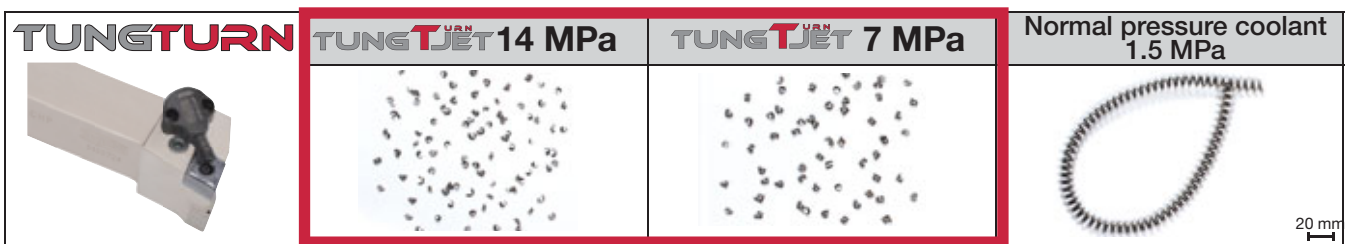


High pressure coolant disperses the cutting heat during machining, which prevents damage on cutting edges

## Improvement of chip control with high pressure coolant

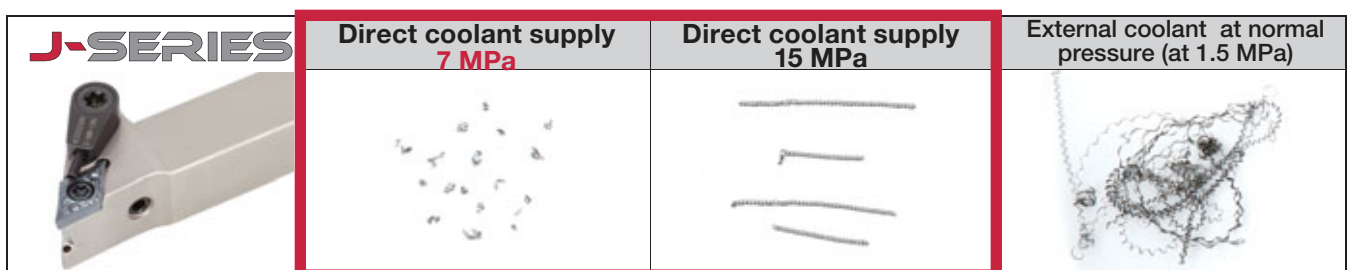
**S** Heat-resistant alloys (Inconel 718)

Toolholder : PCLNL2525M12-CHP  
 Insert : CNMG120408-HRM AH8005  
 Cutting speed :  $V_c = 60$  m/min  
 Feed :  $f = 0.2$  mm/rev  
 Depth of cut :  $a_p = 1$  mm



**M** Stainless steel: External turning (SUS304)

Material : SUS304  
 Holder : JSDJ2CR1212X11-CHP  
 Insert : DCGT11T302FN-JS SH725  
 Cutting speed :  $V_c = 80$  m/min  
 Feed rate :  $f = 0.03$  mm/rev  
 Depth of cut :  $a_p = 1.5$  mm  
 Coolant type : Oil



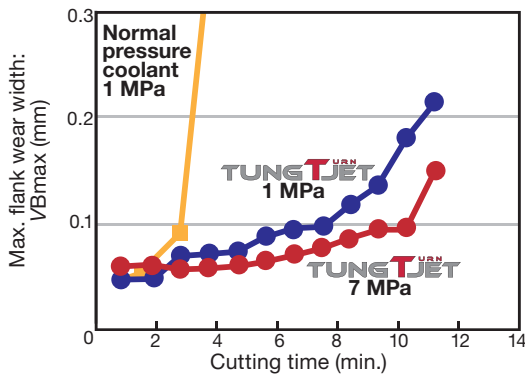
## Drastically improved tool life with internal coolant

### S Heat-resistant alloys (Inconel 718)

Workpiece materials : INCONEL 718  
 Toolholder : ACLNL2525X-12-CHP-MC  
 Insert : CNMG120408-HRM AH8005  
 Cutting speed :  $V_c = 60$  m/min  
 Feed :  $f = 0.15$  mm/rev  
 Depth of cut :  $a_p = 2.0$  mm

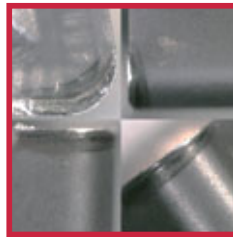


**TUNGTURN**

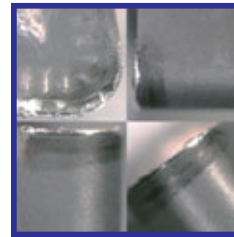


After machining for 4 min.

TUNGTURN (7 MPa)



TUNGTURN (1 MPa)



External coolant (1 MPa)

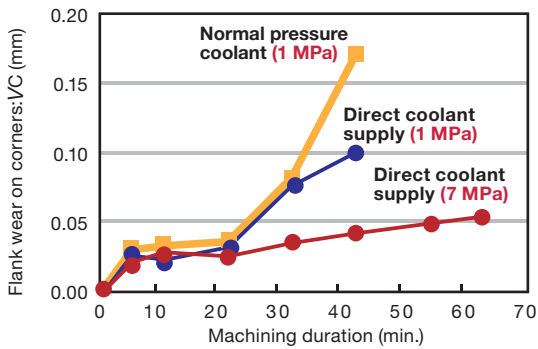


### M Stainless steel: External turning (SUS304)

Material : SUS304  
 Holder : JSDJ2CR1212X11-CHP  
 Insert : DCGT11T302FN-JS SH725  
 Cutting speed :  $V_c = 200$  m/min  
 Feed rate :  $f = 0.1$  mm/rev  
 Depth of cut :  $a_p = 0.5$  mm  
 Coolant type : Oil

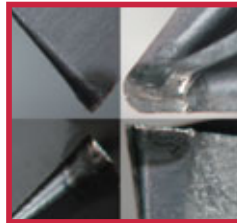


**J-SERIES**

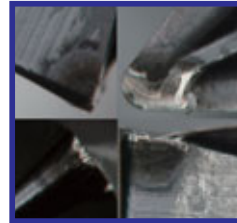


After machining for 40 min.

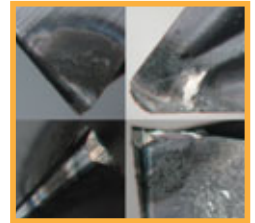
Direct coolant supply (7 MPa)



Direct coolant supply (1 MPa)











External coolant at normal pressure (1 MPa)





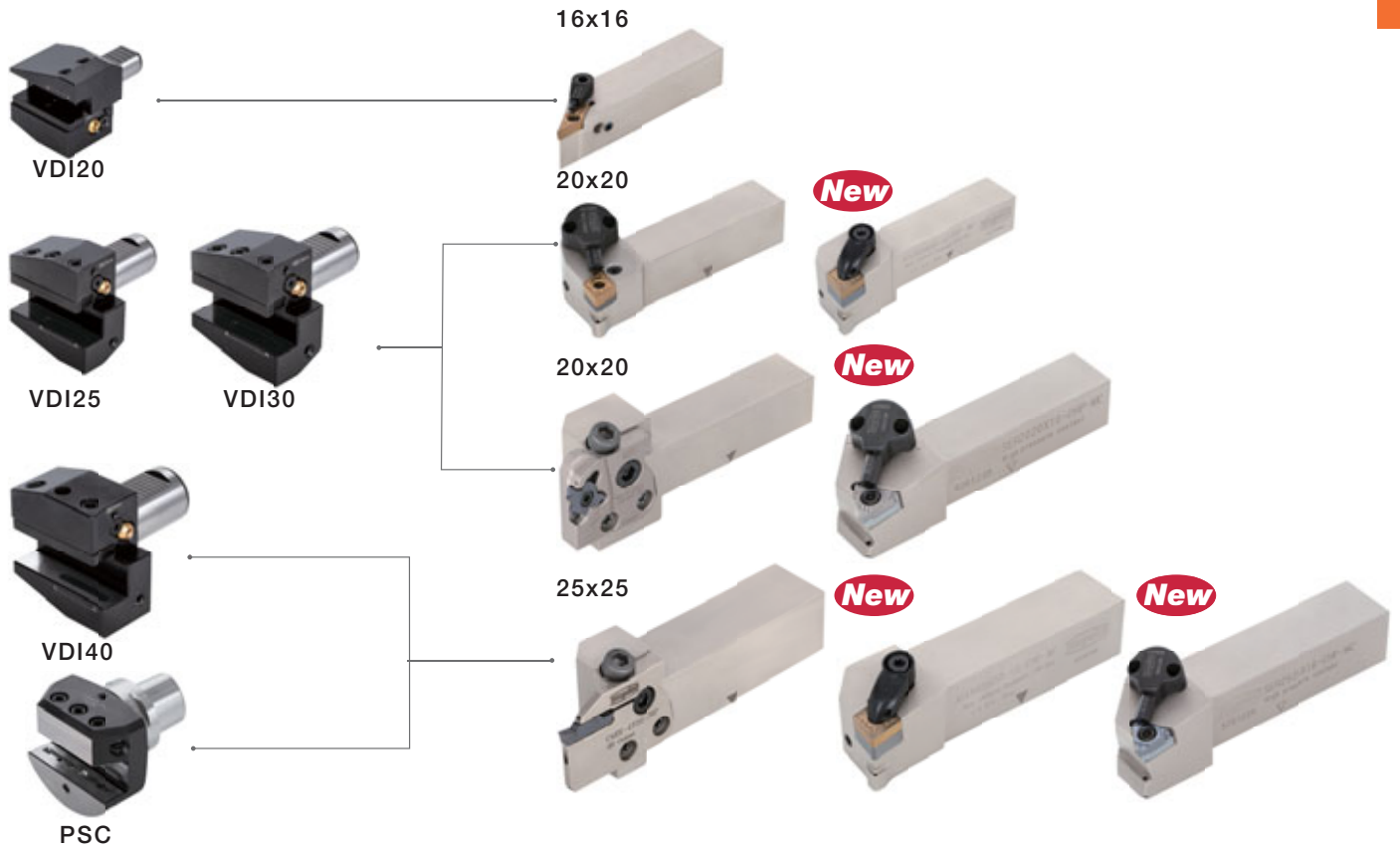
# TUNGTURN

TUNGALOY

Series	Direct connections		Tube connections		TUNGCAP
	For General lathe	For small lathe	For General lathe	For small lathe	For General machining
<b>New</b> <b>ISO ETURN</b> <b>TUNGTURN</b> 	Shank size : 16X16 20X20 25X25	-	Shank size : 20X20 25X25	-	PSC size : C4 C5 C6
	<b>P.10, 14, 17, P.22 - 23</b>				
	Applicable adapter: VDI 20, 25, 30, 40 PSC size : C6				
	<b>P.47 - 51</b>				
<b>J-SERIES</b>  <b>MINIFTURN</b> 	-	Shank size : 10X12 12X12 16X16	-	Shank size : 12X12 16X16	-
	<b>DIRECTTJET</b>	<b>P.24 - 29</b>	<b>P.25 - 29</b>		
<b>New</b> <b>TUNGMSYSTEM</b> 	Shank size : 20X20 25X25	-	Shank size : 20X20 25X25	-	PSC size : C3 C4 C5 C6
	<b>P.31</b>		<b>P.34</b>		
	Applicable adapter: VDI 20, 25, 30, 40 PSC size : C6		-		
	<b>P.47 - 51</b>		<b>P.32 - 33</b>		
<b>TETRAMCUT</b>  <b>TETRAFCUT</b>  <b>DUOJUST</b>  <b>TUNG CUT</b> 	-	Shank size : 10X12 12X12 16X16	Shank size : 20X20 25X25	Shank size : 12X12 16X16 20X20	-
	<b>DIRECTTJET</b>	<b>P.36 - 38, 40 - 41</b>	<b>P.36, 38 - 39</b>	<b>P.36 - 38, 40 - 41</b>	
<b>EASYM CUT</b> 	-	-	Shank size : 25X25	-	-
	<b>DIRECTTJET</b>	<b>P.43 - 45</b>			
<b>TUNGTHREAD</b> <b>New</b> 	Shank size : 20X20 25X25	Shank size : 12X12 16X16	Shank size : 20X20 25X25	Shank size : 12X12 16X16	-
	<b>P.46</b>	<b>P.46</b>	<b>P.46</b>	<b>P.46</b>	



## Adapters - square shank size



## Optimized coolant designs for different insert types increases machining stability

Coolant flow rates

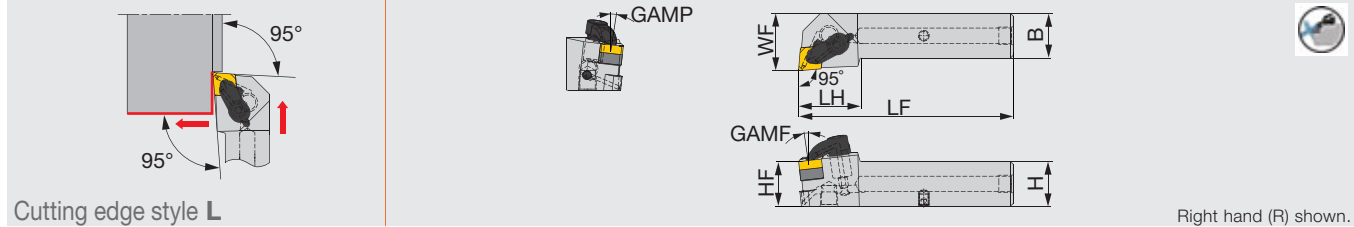
Insert type	Coolant hole	Coolant unit	Flow rate l/min.		
			7 MPa	10 MPa	14 MPa
	<b>New</b>	<b>LCGL-4JC SET</b> <b>LCGR-4JC SET</b>	12.5	14.8	17.5
		<b>CU-CW-CHP</b>	17	20	24
		<b>CU-D-CHP</b>	16	19	22
		<b>CU-V-CHP</b>	8	9.5	11
 Tools for small lathes		<b>S-CU-CHP</b>	4	4.8	5.7
Frontal coolant hole		-	1.8 - 2.6	2.1 - 3.4	2.5 - 3.6

**New**

## ACLNR/L-CHP-MC

Direct connection Tube connection

Double clamping tool holders-95° approach angle  
For negative 80° rhombic insert. High-pressure coolant capability with tube and direct connections



Designation	H	B	LF	LH	HF	WF	GAMP	GAMF	Insert	Torque*
ACLNR/L2020X-12-CHP-MC	20	20	105	35	20	25	6°	6°	CNMG1204	4
ACLNR/L2525X-12-CHP-MC	25	25	120	35	25	32	6°	6°	CNMG1204	4

\*Torque: Recommended torque (N·m) for clamping  
Applicable for 14 MPa pressure coolant

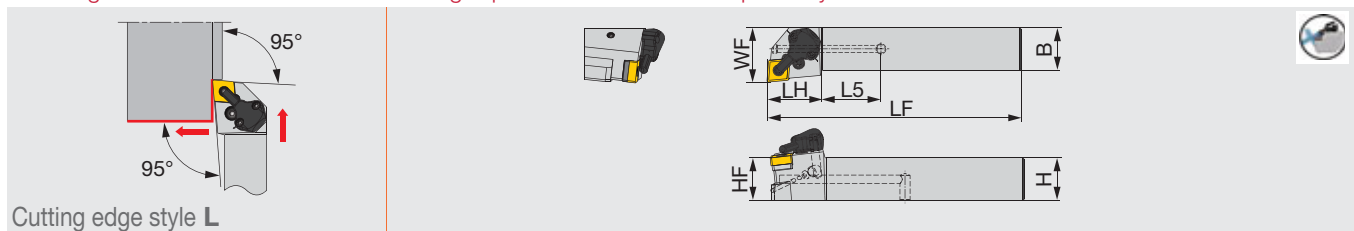
### SPARE PARTS

Designation	Clamp set	Shim	Shim screw	screw for tube connection	Coolant plug	O-ring	Wrench 1
ACLNL**X-12-CHP-MC	LCGL-4JCSET	RCT443	SR14-506	PLUGG1/8-6.5TL360	SRM5X5 DIN913TL360	OR4X3NBR70	KEYL-T20
ACLNR**X-12-CHP-MC	LCGR-4JCSET	RCT443	SR14-506	PLUGG1/8-6.5TL360	SRM5X5 DIN913TL360	OR4X3NBR70	KEYL-T20

## PCLNR/L2020X-CHP-MC

Direct connection

Lever lock toolholders – 95° approach angle.  
For negative 80° rhombic insert. High-pressure coolant capability with bottom direct connection



Designation	H	B	LF	LH	HF	L5	WF	Insert	Torque*
PCLNR/L2020X09-CHP-MC	20	20	97	27	20	29	25	CN**0904...	2
PCLNR/L2020X12-CHP-MC	20	20	97	27	25	29	25	CN**1204...	3

\*Torque: Recommended torque (N·m) for clamping

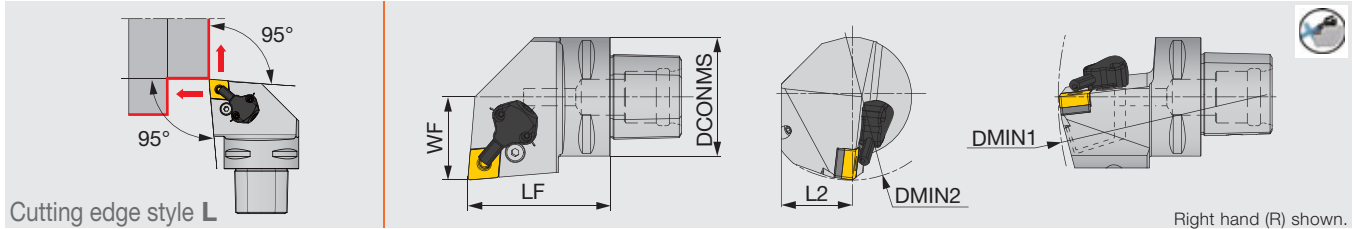
### SPARE PARTS

Designation	Shim	Spring	Lever	Spring	Spring pin	Wrench	Coolant unit	Wrench	Coolant plug	Wrench
PCLNR/L2020X09-CHP-MC	TCN323	SP3	LR3	SR117-2014	PN3-4	HW2.5	CU-CW-CHP	T-8/5	SRM5X5 DIN913TL360	-
PCLNR/L2020X12-CHP-MC	TCN443	SP4	LR4DH	SR117-2010	PN3-4L	HW2.5	CU-CW-CHP	T-8/5	SRM5X5 DIN913TL360	HW3.0

## C-PCLNR/L-CHP

**TUNGCAP** Direct connection

Lever lock toolholders with TungCap connection – 95° approach angle.  
For negative 80° rhombic insert. High-pressure coolant capability.



Right hand (R) shown.

Designation	DCONMS	LF	L2	WF	DMIN1	DMIN2	RE**	Insert	Torque*
C4PCLNR/L27050-0904-CHP	40	50	25	27	140	110	0.8	CN**0904...	2
C6PCLNR/L45065-0904-CHP	63	65	41	45	190	125	0.8	CN**0904...	2
C4PCLNR/L27050-12-CHP	40	50	25	27	140	110	0.8	CN**1204...	3
C5PCLNR/L35060-12-CHP	50	60	32	35	165	110	0.8	CN**1204...	3
C6PCLNR/L45065-12-CHP	63	65	41	45	190	125	0.8	CN**1204...	3

\*Torque: Recommended torque (N·m) for clamping

Applicable for 14 MPa pressure coolant

\*\*RE: Standard corner radius

### SPARE PARTS

Designation	Shim	Clamping screw	Wrench 1	Spring pin	Lever
C*PCLNR/L**0904-CHP	LSC317	LCS3	P-2.5	LSP3	LCL33
C*PCLNR/L**12-CHP	LSC42	LCS4	P-3	LSP4	LCL4

### SPARE PARTS

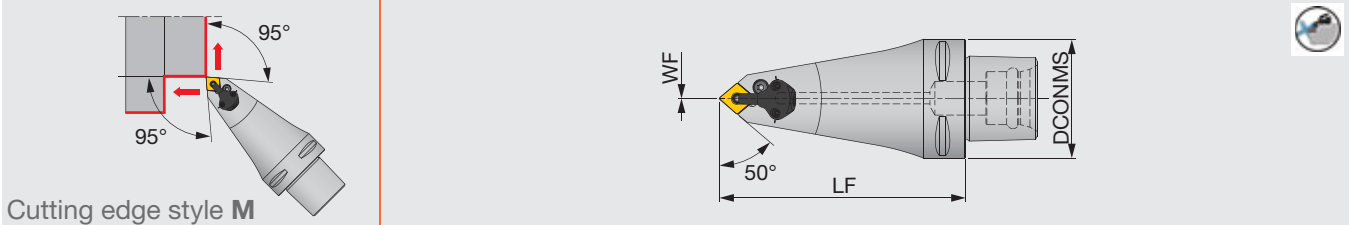
Designation	Coolant unit	Mounting screw	Wrench 2	O-ring
C*PCLNR/L**0904-CHP	CU-CW-CHP	SRM3	T-8F	OR6.4X0.9N
C*PCLNR/L**12-CHP	CU-CW-CHP	SRM3	T-8F	OR6.4X0.9N



## C-PCMNN-CHP

**TUNGCAP** Direct connection

Lever lock toolholder with TungCap connection.  
For negative 80° rhombic insert. High-pressure coolant capability.



Designation	DCONMS	LF	WF	RE**	Insert	Torque*
C6PCMNN00130-12-CHP	63	115	0	0.8	CN**1204...	3

\*Torque: Recommended torque (N-m) for clamping  
Applicable for 14 MPa pressure coolant  
\*\*RE: Standard corner radius

For external turning only.

### SPARE PARTS

Designation	Shim	Clamping screw	Wrench 1	Spring pin	Lever
C6PCMNN00130-12-CHP	LSC42	LCS4	P-3	LSP4	LCL4

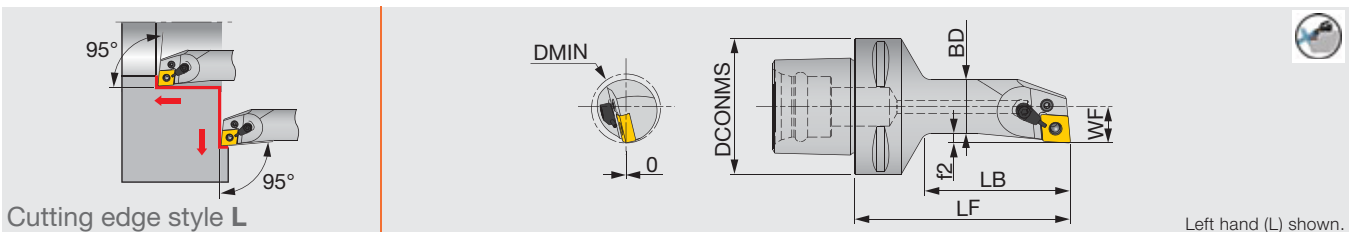
### SPARE PARTS

Designation	Coolant unit	Mounting screw	Wrench 2	O-ring
C6PCMNN00130-12-CHP	CU-CW-CHP	SRM3	T-8F	OR6.4X0.9N

## C-PCLNL-CHP

**TUNGCAP** Direct connection

Lever lock internal toolholder with TungCap connection – 95° approach angle.  
For negative 80° rhombic insert. High-pressure coolant capability.



Designation	DMIN	DCONMS	BD	LF	LB	WF	f2	RE**	Insert	Torque*
C6PCLNL17100-12-CHP	32	63	25	100	67.5	17	4.5	0.8	CN**1204...	3

\*Torque: Recommended torque (N-m) for clamping  
Applicable for 14 MPa pressure coolant  
\*\*RE: Standard corner radius

### SPARE PARTS

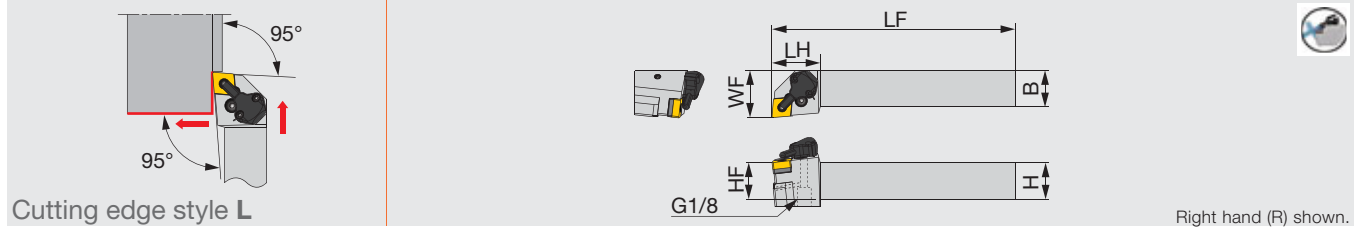
Designation	Clamping screw	Coolant unit	Wrench	Lever
C6PCLNL17100-12-CHP	LCS43	S-CU-CHP	P-2.5F	LCL43N

## PCLNR/L-CHP

Tube connection

Lever lock toolholders – 95° approach angle.

For negative 80° rhombic insert. High-pressure coolant capability.



Right hand (R) shown.

Designation	H	B	LF	LH	HF	WF	RE**	Insert	Torque*
PCLNR/L2020K0904-CHP	20	20	125	33	20	32	0.8	CN**0904...	2
PCLNR/L2525M0904-CHP	25	25	150	33	25	32	0.8	CN**0904...	2
PCLNR/L2020K12-CHP	20	20	125	33	20	32	0.8	CN**1204...	3
PCLNR/L2525M12-CHP	25	25	150	33	25	32	0.8	CN**1204...	3

\*Torque: Recommended torque (N·m) for clamping

\*\*RE: Standard corner radius

### SPARE PARTS

Designation	Shim	Clamping screw	Wrench 1	Spring pin	Lever
PCLNR/L**0904-CHP	LSC317	LCS3	P-2.5	LSP3	LCL33
PCLNR/L**12-CHP	LSC42	LCS4	P-3	LSP4	LCL4

### SPARE PARTS

Designation	Coolant unit	Mounting screw	Wrench 2	O-ring	Coolant screw	Wrench 3
PCLNR/L**0904-CHP	CU-CW-CHP	SRM3	T-8F	OR6.4X0.9N	SRM4X4TL360	P-2
PCLNR/L**12-CHP	CU-CW-CHP	SRM3	T-8F	OR6.4X0.9N	SRM4X4TL360	P-2

Hose connection to the tool holder refer to page 52

**New**

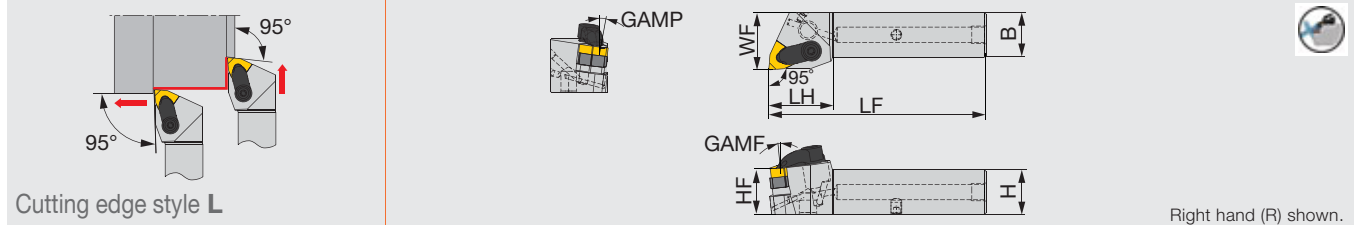
## AWLNR/L-CHP-MC

Direct connection

Tube connection

Double clamping tool holders-95° approach angle

For negative 80° trigon insert. High-pressure coolant capability with tube and direct connections



Designation	H	B	LF	LH	HF	WF	GAMP	GAMF	Insert	Torque*
AWLNR/L2020X-08-CHP-MC	20	20	106	36	20	25	6°	6°	WN**0804...	4
AWLNR/L2525X-08-CHP-MC	25	25	121	36	25	32	6°	6°	WN**0804...	4

\*Torque: Recommended torque (N-m) for clamping  
Applicable for 14 MPa pressure coolant

### SPARE PARTS

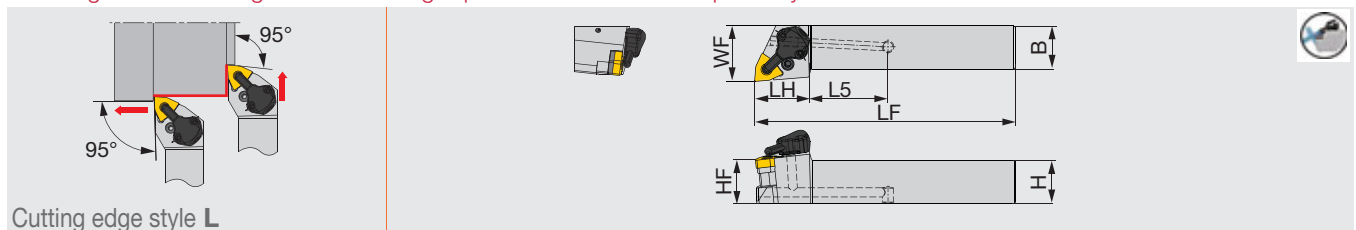
Designation	Clamp set	Shim	Shim screw	screw for tube connection	Coolant plug	O-ring	Wrench 1
AWLNR**X-08-CHP-MC	LCGL-4JCSET	RWT443	SR14-506	PLUGG1/8-6.5TL360	SRM5X5 DIN913TL360	OR4X3NBR70	KEYL-T20
AWLNR**X-08-CHP-MC	LCGR-4JCSET	RWT443	SR14-506	PLUGG1/8-6.5TL360	SRM5X5 DIN913TL360	OR4X3NBR70	KEYL-T20

## PWLNR/L2020X-CHP-MC

Direct connection

Lever lock toolholders – 95° approach angle.

For negative 80° trigon insert. High-pressure coolant capability with bottom direct connection



Designation	H	B	LF	LH	HF	L5	WF	Insert	Torque*
PWLNR/L2020X06-CHP-MC	20	20	97	27	20	29	25	WN**0604...	2
PWLNR/L2020X08-CHP-MC	20	20	97	27	20	29	25	WN**0804...	3

\*Torque: Recommended torque (N-m) for clamping  
Applicable for 30 MPa pressure coolant

### SPARE PARTS

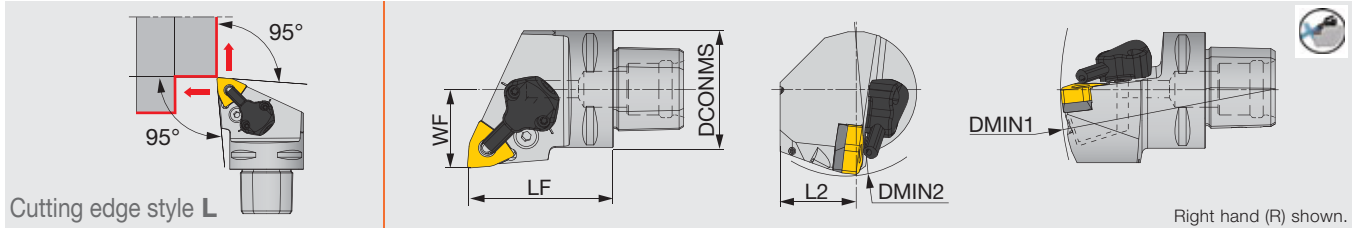
Designation	Shim	Spring	Lever	Spring	Spring pin	Wrench	Coolant unit	Wrench	Coolant plug	Wrench
PWLNR/L2020X06-CHP-MC	TWN3	SP3	LR3	SR117-2014	PN3-4	HW2.5	CU-CW-CHP	T-8/5	SRM5X5 DIN913TL360	-
PWLNR/L2020X08-CHP-MC	TWN443	SP4	LR4DH	SR117-2010	PN3-4L	HW2.5	CU-CW-CHP	T-8/5	SRM5X5 DIN913TL360	HW3.0



## C-PWLNLR/L-CHP

**TUNGCAP** Direct connection

Lever lock toolholders with TungCap connection – 95° approach angle.  
For negative 80° trigon insert. High-pressure coolant capability.



Cutting edge style L

Right hand (R) shown.

Designation	DCONMS	LF	L2	WF	DMIN1	DMIN2	RE**	Insert	Torque*
C4PWLNLR/L27050-0604-CHP	40	50	25	27	140	110	0.8	WN**0604...	2
C4PWLNLR/L27050-08-CHP	40	50	25	27	140	110	0.8	WN**0804...	3
C6PWLNLR/L45065-08-CHP	63	65	41	45	190	110	0.8	WN**0804...	3

\*Torque: Recommended torque (N-m) for clamping

Applicable for 14 MPa pressure coolant

\*\*RE: Standard corner radius

### SPARE PARTS

Designation	Shim	Clamping screw	Wrench 1	Spring pin	Lever
C*PWLNLR/L**0604-CHP	LSW312	LCS3	P-2.5	LSP3	LCL3
C*PWLNLR/L**-08-CHP	LSW42BL	LCS4	P-3	LSP4	LCL4

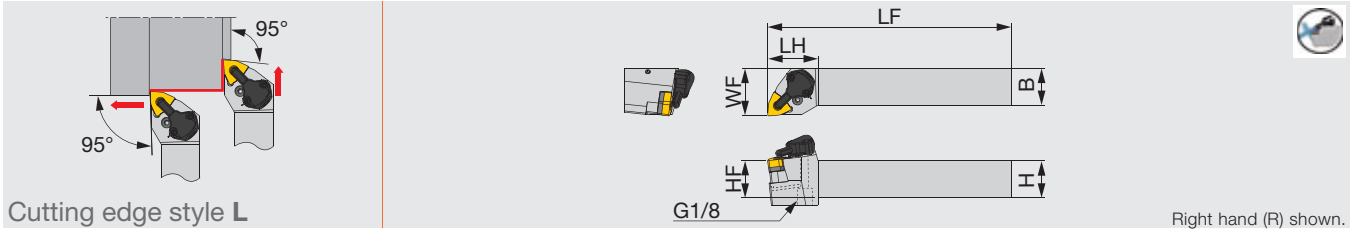
### SPARE PARTS

Designation	Coolant unit	Mounting screw	Wrench 2	O-ring
C*PWLNLR/L**0604-CHP	CU-CW-CHP	SRM3	T-8F	OR6.4X0.9N
C*PWLNLR/L**-08-CHP	CU-CW-CHP	SRM3	T-8F	OR6.4X0.9N

## PWLNR/L-CHP

Tube connection

Lever lock toolholders – 95° approach angle.  
For negative 80° trigon insert. High-pressure coolant capability.



Right hand (R) shown.

Designation	H	B	LF	LH	HF	WF	RE**	Insert	Torque*
PWLNR/L2020K0604-CHP	20	20	125	34	20	32	0.8	WN**0604...	2
PWLNR/L2525M0604-CHP	25	25	150	34	25	32	0.8	WN**0604...	2
PWLNR/L2020K08-CHP	20	20	125	34	20	32	0.8	WN**0804...	3
PWLNR/L2525M08-CHP	25	25	150	34	25	32	0.8	WN**0804...	3

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

### SPARE PARTS

Designation	Shim	Clamping screw	Wrench 1	Spring pin	Lever
PWLNR/L**0604-CHP	LSW312	LCS3	P-2.5	LSP3	LCL3
PWLNR/L**08-CHP	LSW42	LCS4	P-2.5	LSP4	LCL4

### SPARE PARTS

Designation	Coolant unit	Mounting screw	Wrench 2	O-ring	Coolant screw	Wrench 3
PWLNR/L**0604-CHP	CU-CW-CHP	SRM3	T-8F	OR6.4X0.9N	SRM4X4TL360	P-2
PWLNR/L**08-CHP	CU-CW-CHP	SRM3	T-8F	OR6.4X0.9N	SRM4X4TL360	P-2

Hose connection to the tool holder refer to page 52

**New**

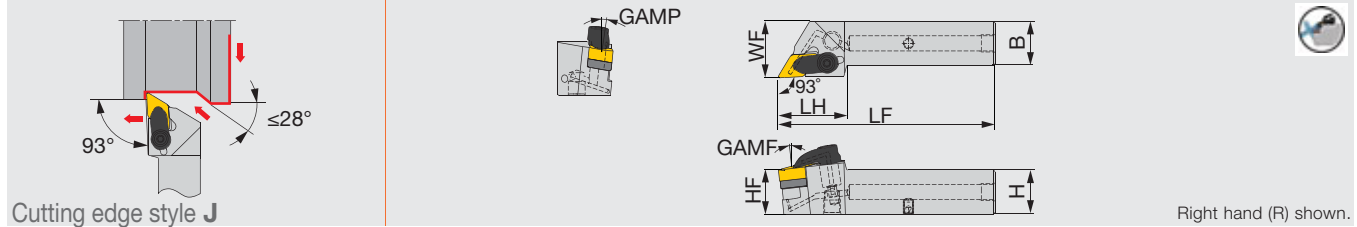
## ADJNR/L-CHP-MC

Direct connection

Tube connection

Double clamping tool holders-93° approach angle

For negative 55° rhombic insert. High-pressure coolant capability with tube and direct connections



Designation	H	B	LF	LH	HF	WF	GAMP	GAMF	Insert	Torque*
ADJNR/L2020X-15-CHP-MC	20	20	110	40	20	25	6°	6°	DN**1506...	4
ADJNR/L2525X-15-CHP-MC	25	25	125	40	25	32	6°	6°	DN**1506...	4

\*Torque: Recommended torque (N-m) for clamping  
 \*\*Used shim RDT443, in case using insert DN\*\*1504...  
 Applicable for 14 MPa pressure coolant

### SPARE PARTS

Designation	Clamp set	Shim	Shim screw	screw for tube connection	Coolant plug	O-ring	Wrench 1
ADJNL***X-15-CHP-MC	LCGL-4JCSET	RDT433	SR14-506	PLUGG1/8-6.5TL360	SRM5X5 DIN913TL360	OR4X3NBR70	KEYL-T20
ADJNR***X-15-CHP-MC	LCGR-4JCSET	RDT433	SR14-506	PLUGG1/8-6.5TL360	SRM5X5 DIN913TL360	OR4X3NBR70	KEYL-T20

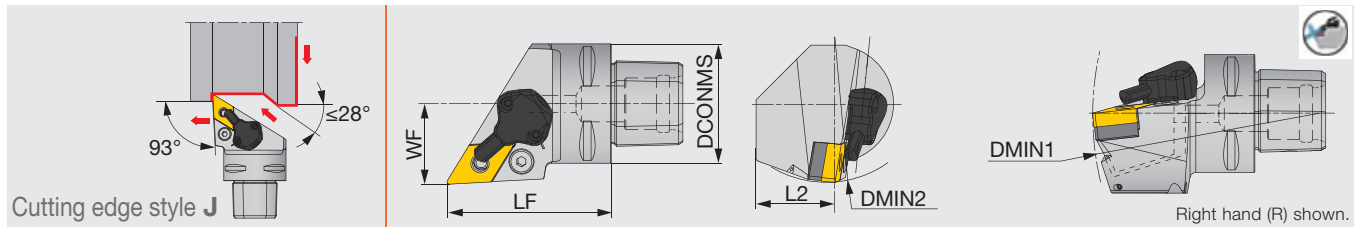
## C-PDJNR/L-CHP

**TUNG CAP**

Direct connection

Lever lock toolholders with TungCap connection – 93° approach angle.

For negative 55° rhombic insert. High-pressure coolant capability.



Designation	DCONMS	LF	L2	WF	DMIN1	DMIN2	RE**	Insert	Torque*
C4PDJNR/L27055-1104-CHP	40	50	27	140	140	110	0.8	DN**1104...	2
C6PDJNR/L45065-1104-CHP	63	65	45	190	190	110	0.8	DN**1104...	2
C4PDJNR/L27055-15-CHP	40	50	27	140	140	110	0.8	DN**1504(06)...	3
C5PDJNR/L35060-15-CHP	50	60	35	165	165	110	0.8	DN**1504(06)...	3
C6PDJNR/L45065-15-CHP	63	65	45	190	190	110	0.8	DN**1504(06)...	3

\*Torque: Recommended torque (N-m) for clamping  
 Applicable for 14 MPa pressure coolant  
 \*\*RE: Standard corner radius

### SPARE PARTS

Designation	Shim	Clamping screw	Wrench 1	Spring pin	Lever
C*PDJNR/L**1104-CHP	ELSD32	LCS3	P-2.5	LSP3	LCL33L
C*PDJNR/L**-15-CHP	LSD43A	LCS4	P-3	LSP4	LCL4

Option: LSD42A (Shim for DN\*\*1506...), NSP4S (Spring pin for DN\*\*1506...)

### SPARE PARTS

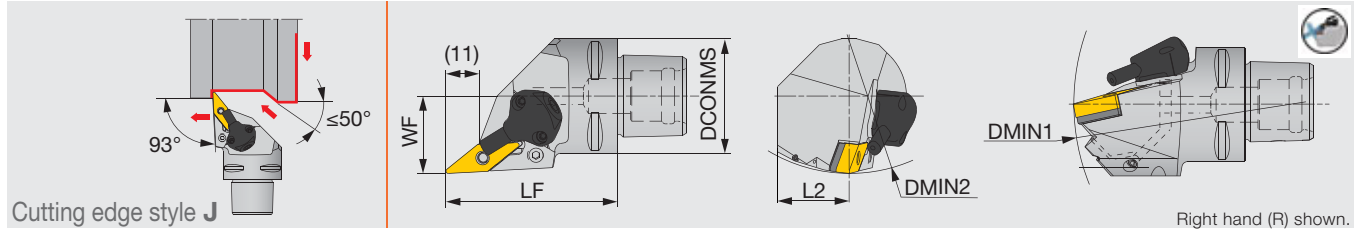
Designation	Coolant unit	Mounting screw	Wrench 2	O-ring
C*PDJNR/L**1104-CHP	CU-D-CHP	SRM3	T-8F	OR6.4X0.9N
C*PDJNR/L**-15-CHP	CU-D-CHP	SRM3	T-8F	OR6.4X0.9N



## C-PVJNR/L-CHP

**TUNGCAP** Direct connection

Lever lock toolholders with TungCap connection – 93° approach angle.  
For negative 35° or 25° rhombic insert. High-pressure coolant capability.



Designation	DCONMS	LF	L2	WF	DMIN1	DMIN2	RE**	Insert	Torque*
C4PVJNR/L27060-1204-CHP	40	60	20	27	140	90	0.8	VN**1204...	2
C6PVJNR/L45065-1204-CHP	63	65	31.5	45	190	81	0.8	VN**1204...	2
C4PVJNR/L27060-16-CHP	40	60	20	27	140	110	0.8	V/YN**1604...	2
C6PVJNR/L45065-16-CHP	63	65	31.5	45	190	81	0.8	V/YN**1604...	2

\*Torque: Recommended torque (N·m) for clamping  
Applicable for 14 MPa pressure coolant  
\*\*RE: Standard corner radius

### SPARE PARTS

Designation	Shim	Clamping screw	Wrench 1	Spring pin	Lever
C*PVJNR/L*-1204-CHP	LSV212	LCS3V	P-2.5	LSP3	LCL3V
C*PVJNR/L...16-CHP	LSV317	LCS3V	P-2.5	LSP3	LCL3V

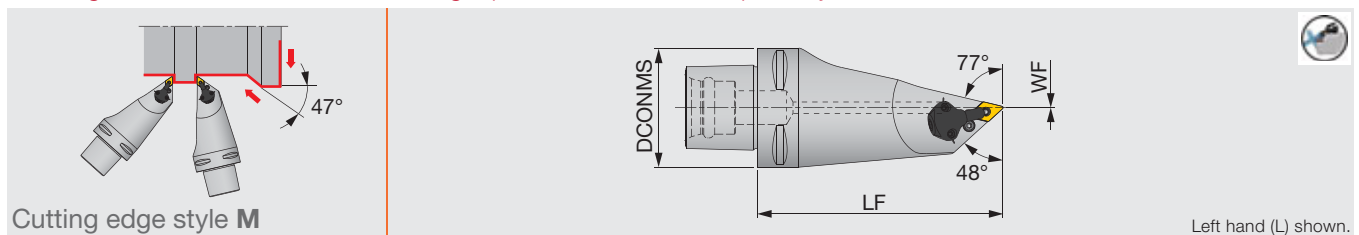
### SPARE PARTS

Designation	Coolant unit	Mounting screw	Wrench 2	O-ring
C*PVJNR/L*-1204-CHP	CU-V-CHP	SRM3	T-8F	OR6.4X0.9N
C*PVJNR/L...16-CHP	CU-V-CHP	SRM3	T-8F	OR6.4X0.9N

## C-PDMNL-CHP

**TUNGCAP** Direct connection

Lever lock toolholder with TungCap connection.  
For negative 55° rhombic insert. High-pressure coolant capability.



Designation	DCONMS	LF	WF	RE**	Insert	Torque*
C6PDMNL00130-1104-CHP	63	130	0	0.8	DN**1104...	2

\*Torque: Recommended torque (N·m) for clamping  
Applicable for 14 MPa pressure coolant  
\*\*RE: Standard corner radius

For external turning only.

### SPARE PARTS

Designation	Shim	Clamping screw	Wrench 1	Spring pin	Lever
C6PDMNL00130-1104-CHP	ELSD32	LCS3	P-2.5	LSP3	LCL33L

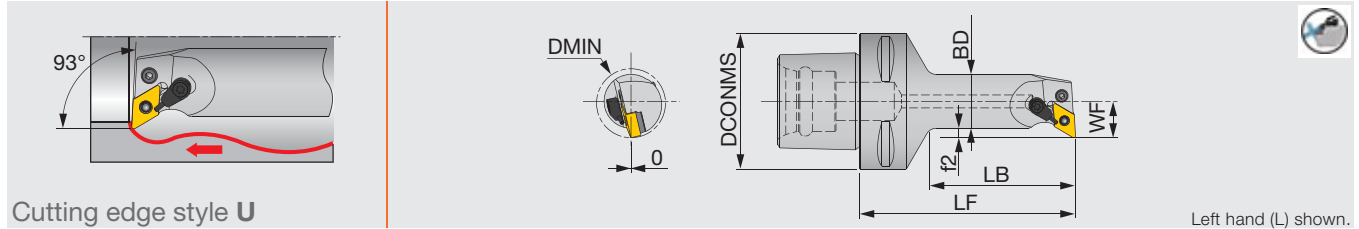
### SPARE PARTS

Designation	Coolant unit	Mounting screw	Wrench 2	O-ring
C6PDMNL00130-1104-CHP	CU-D-CHP	SRM3	T-8F	OR6.4X0.9N

## C-PDUNL-CHP

**TUNG CAP** Direct connection

Lever lock internal toolholder with TungCap connection – 93° approach angle.  
For negative 55° rhombic insert. High-pressure coolant capability.



Cutting edge style U

Left hand (L) shown.

Designation	DMIN	DCONMS	BD	LF	LB	WF	f2	RE**	Insert	Torque*
C6PDUNL17100-1104-CHP	32	63	25	100	67.5	17	4.5	0.8	DN**1104...	2

\*Torque: Recommended torque (N·m) for clamping  
Applicable for 14 MPa pressure coolant  
\*\*RE: Standard corner radius

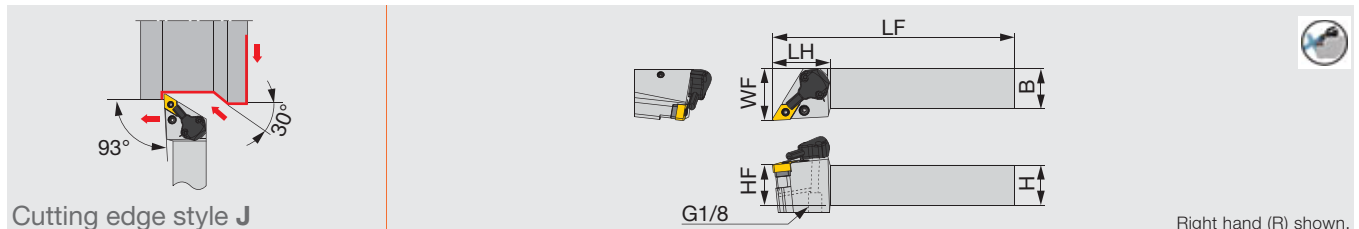
### SPARE PARTS

Designation	Shim	Clamping screw	Coolant unit	Wrench	Spring pin	Lever
C6PDUNL17100-1104-CHP	ELSD317BL	LCS43	S-CU-CHP	P-2.5	LSP3	LCL33L

## PDJNR/L-CHP

Tube connection

Lever lock toolholders – 93° approach angle.  
For negative 55° rhombic insert. High-pressure coolant capability.



Cutting edge style J

Right hand (R) shown.

Designation	H	B	LF	LH	HF	WF	RE**	Insert	Torque*
PDJNR/L2020K1104-CHP	20	20	125	36	20	32	0.8	DN**1104...	2
PDJNR/L2525M1104-CHP	25	25	150	36	25	32	0.8	DN**1104...	2
PDJNR/L2020K15-CHP	20	20	125	36	20	32	0.8	DN**1504...	3
PDJNR/L2525M15-CHP	25	25	150	36	25	32	0.8	DN**1504...	3

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

### SPARE PARTS

Designation	Shim	Clamping screw	Wrench 1	Spring pin	Lever
PDJNR/L**1104-CHP	ELSD32	LCS3	P-2.5	LSP3	LCL33L
PDJNR/L**15-CHP	LSD43A	LCS4	P-3	LSP4	LCL4

### SPARE PARTS

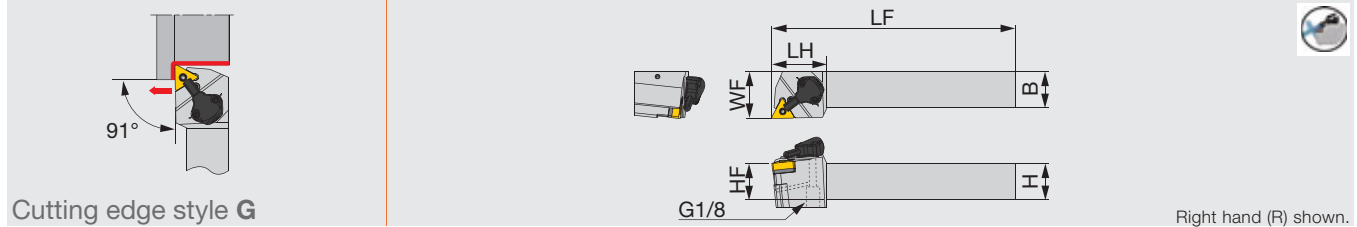
Designation	Coolant unit	Mounting screw	Wrench 2	O-ring	Coolant screw	Wrench 3
PDJNR/L**1104-CHP	CU-D-CHP	SRM3	T-8F	OR6.4X0.9N	SRM4X4TL360	P-2
PDJNR/L**15-CHP	CU-D-CHP	SRM3	T-8F	OR6.4X0.9N	SRM4X4TL360	P-2

Hose connection to the tool holder refer to page 52

## PTGNR/L-CHP

Tube connection

Lever lock toolholders – 91° approach angle.  
For negative triangle insert. High-pressure coolant capability.



Right hand (R) shown.

Designation	H	B	LF	LH	HF	WF	RE**	Insert	Torque*
PTGNR/L2020K1104-CHP	20	20	125	38	20	32	0.8	TN**1104...	2
PTGNR/L2525M1104-CHP	25	25	150	38	25	32	0.8	TN**1104...	2
PTGNR/L2020K16-CHP	20	20	125	38	20	32	0.8	TN**1604...	2
PTGNR/L2525M16-CHP	25	25	150	38	25	32	0.8	TN**1604...	2

\*Torque: Recommended torque (N·m) for clamping

\*\*RE: Standard corner radius

### SPARE PARTS

Designation	Shim	Clamping screw	Wrench 1	Spring pin	Lever
PTGNR/L**1104-CHP	-	LCS23A	P-2.5	LSP3	LCL23
PTGNR/L**16-CHP	LST317	LCS3	P-2.5	LSP3	LCL3

### SPARE PARTS

Designation	Coolant unit	Mounting screw	Wrench 2	O-ring	Coolant screw	Wrench 3
PTGNR/L**1104-CHP	CU-CW-CHP	SRM3	T-8F	OR6.4X0.9N	SRM4X4TL360	P-2
PTGNR/L**16-CHP	CU-CW-CHP	SRM3	T-8F	OR6.4X0.9N	SRM4X4TL360	P-2

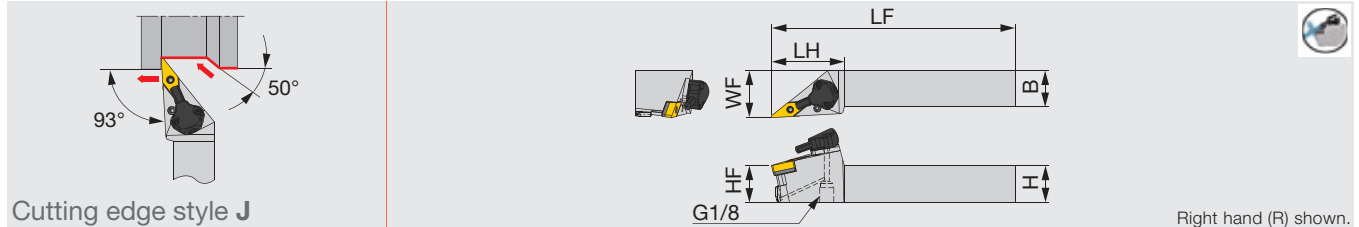
Hose connection to the tool holder refer to page 52



## PVJNR/L-CHP

Tube connection

Lever lock toolholders – 93° approach angle.  
For negative 35° or 25° rhombic insert. High-pressure coolant capability.



Designation	H	B	LF	LH	HF	WF	RE**	Insert	Torque*
PVJNR/L2020K1204-CHP	20	20	125	50	25	32	0.8	VN**1204...	2
PVJNR/L2525M1204-CHP	25	25	150	50	25	32	0.8	VN**1204...	2
PVJNR/L2020K16-CHP	20	20	125	50	20	32	0.8	V/YN**1604...	2
PVJNR/L2525M16-CHP	25	25	150	50	25	32	0.8	V/YN**1604...	2

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

### SPARE PARTS

Designation	Shim	Clamping screw	Wrench 1	Spring pin	Lever
PVJNR/L**1204-CHP	LSV212	LCS3V	P-2.5	LSP3	LCL3V
PVJNR/L**16-CHP	LSV317	LCS3V	P-2.5	LSP3	LCL3V

### SPARE PARTS

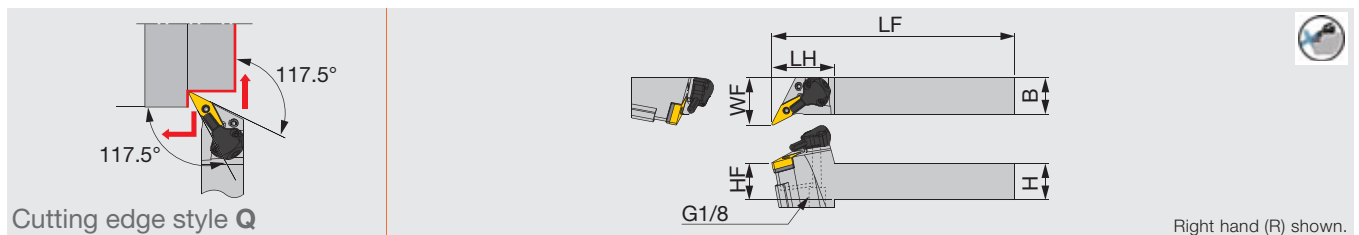
Designation	Coolant unit	Mounting screw	Wrench 2	O-ring	Coolant screw	Wrench 3
PVJNR/L**1204-CHP	CU-V-CHP	SRM3	T-8F	OR6.4X0.9N	SRM4X4TL360	P-2
PVJNR/L**16-CHP	CU-V-CHP	SRM3	T-8F	OR6.4X0.9N	SRM4X4TL360	P-2

Hose connection to the tool holder refer to page 52

## PVQNR/L-CHP

Tube connection

Lever lock toolholders – 117.5° approach angle.  
For negative 35° or 25° rhombic insert. High-pressure coolant capability.



Designation	H	B	LF	LH	HF	WF	RE**	Insert	Torque*
PVQNR/L2020K16-CHP	20	20	125	42.5	20	32	0.8	V/YN**1604...	2
PVQNR/L2525M16-CHP	25	25	150	42.5	25	32	0.8	V/YN**1604...	2

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

### SPARE PARTS

Designation	Shim	Clamping screw	Wrench 1	Spring pin	Lever
PVQNR/L**16-CHP	LSV317	LCS3V	P-2.5	LSP3	LCL3V

### SPARE PARTS

Designation	Coolant unit	Mounting screw	Wrench 2	O-ring	Coolant screw	Wrench 3
PVQNR/L**16-CHP	CU-V-CHP	SRM3	T-8F	OR6.4X0.9N	SRM4X4TL360	P-2

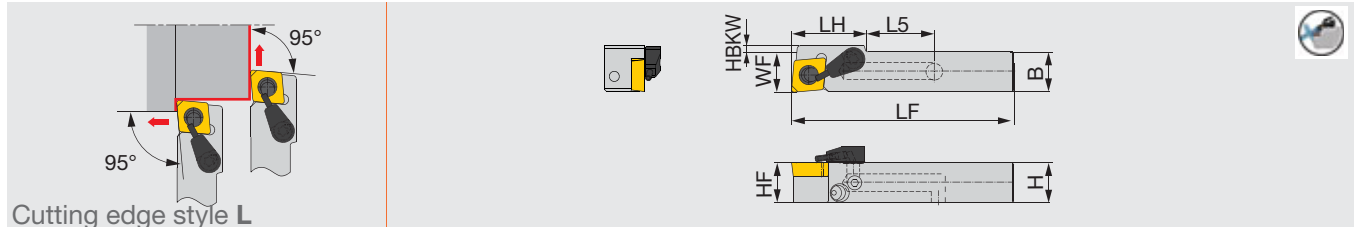
Hose connection to the tool holder refer to page 52

## PCLCR/L1616X09S-CHP-MC

Direct connection

Lever lock toolholders – 95° approach angle.

For positive 80° rhombic insert. High-pressure coolant capability with bottom direct connection



Designation	H	B	LF	LH	L5	HF	WF	HBKW	Insert
PCLCR/L1616X09S-CHP-MC	16	16	71	23	17	16	16.2	-	CC**09T3

Applicable for 14 MPa pressure coolant

### SPARE PARTS



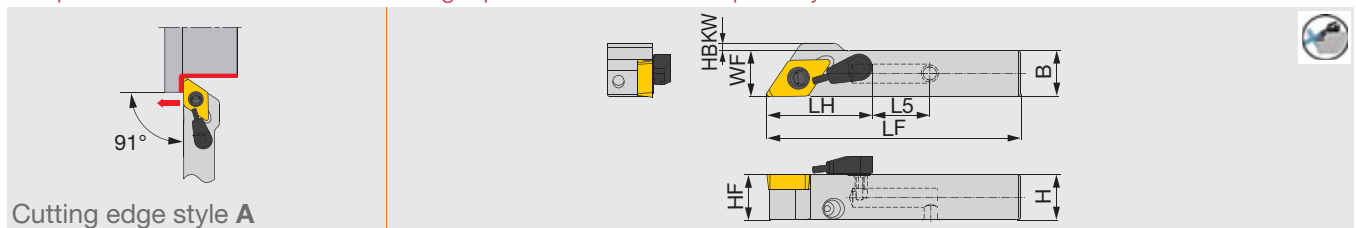
Designation	Lever	Pin	Clamping screw	Wrench	Coolant plug	Coolant unit
PCLCR/L1616X09S-CHP-MC	SLLV-3	SLPI-3	SR10400150	HW2.5/5	SR5/16UNFTL360	S-CU-CHP

## PDACR/L1616X11S-CHP-MC

Direct connection

Lever lock toolholders – 91° approach angle.

For positive 55° rhombic insert. High-pressure coolant capability with bottom direct connection



Designation	H	B	LF	LH	L5	HF	WF	HBKW	Insert
PDACR/L1616X11S-CHP-MC	16	16	76	28	17	16	16.2	-	DC**11T3

Applicable for 14 MPa pressure coolant

### SPARE PARTS



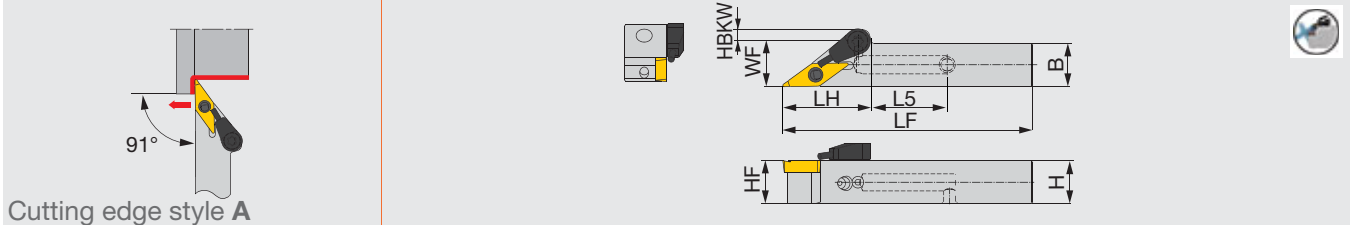
Designation	Lever	Pin	Clamping screw	Wrench	Coolant plug	Coolant unit
PDACR/L1616X11S-CHP-MC	SLLV-3	SLPI-3	SR10400150	HW2.5/5	SR5/16UNFTL360	S-CU-CHP

## PVACR/L1616X11S-CHP-MC

Direct connection

Lever lock toolholders – 93° approach angle.

For positive 35° or 25° rhombic insert. High-pressure coolant capability with bottom direct connection



Designation	H	B	LF	LH	L5	HF	WF	HBKW	Insert
PVACR/L1616X11S-CHP-MC	16	16	73	26	16	16	16.2	-	VC**1103

Applicable for 14 MPa pressure coolant

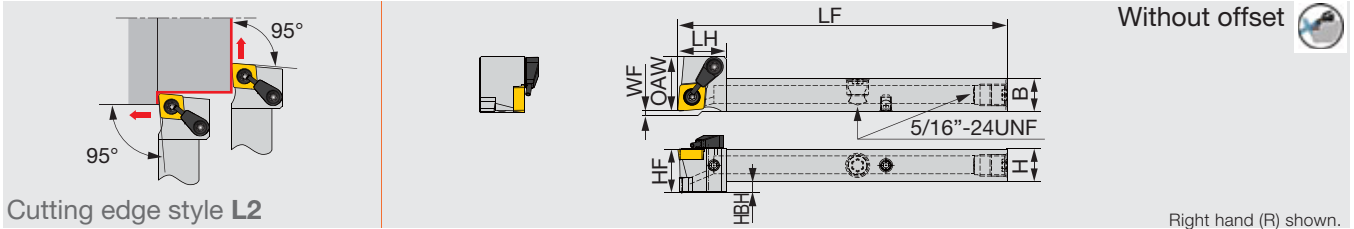
### SPARE PARTS

Designation	Lever	Pin	Clamping screw	Wrench	Coolant plug	Coolant unit
PVACR/L1616X11S-CHP-MC	SLLV-2	SL-PI-2	SR10400150	HW2.0/5	SR5/16UNFTL360	S-CU-CHP

## JSCL2CR-CHP

**DIRECTT<sup>UNE</sup>JET** Direct connection

Screw-on toolholder without offset, 95° approach angle for positive 80° rhombic inserts, high pressure coolant compatible



Designation	H	B	LF	LH	HF	HBH	WF	OAW	RE	Insert	Torque*
JSCL2CR1212X09-CHP***	12	12	120	18	12	4	0	20	0.2	CC**09T3	1.2
JSCL2CR1212X09B-CHP	12	12	120	18	12	1.5	0	20	0.2	CC**09T3	1.2
JSCL2CR1616X09-CHP	16	16	120	18	16	0	0	20	0.2	CC**09T3	1.2

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

Note: Right-hand toolholders (R) are used with right-hand inserts (R). Left-hand toolholders (L) are used with left-hand inserts (L).

\*\*\*: To be replaced with the new design

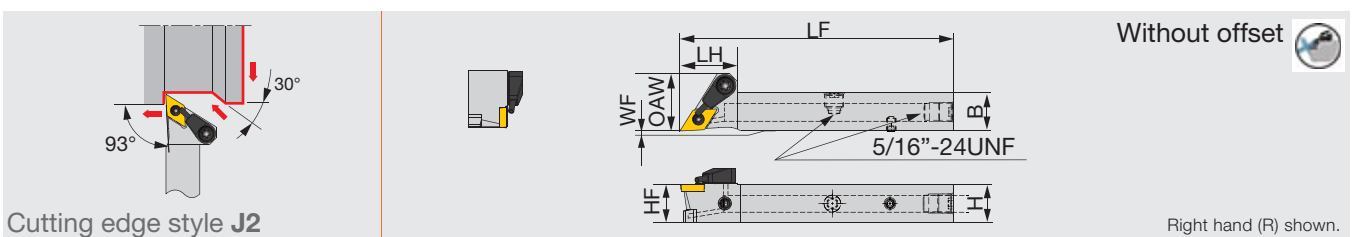
### SPARE PARTS

Designation	Clamping screw	Coolant unit	Wrench	Coolant plug	Wrench	DirectJet plug	Wrench
JSCL2CR**-CHP	CSTB-4SD	S-CU-CHP	T-8F	SR5/16UNFTL360	P-4	SSHM4-6-TB	P-2

## JSDJ2CR-CHP

**DIRECTT<sup>UNE</sup>JET** Direct connection

Screw-on toolholder without offset, 93° approach angle for positive 55° rhombic inserts, high pressure coolant compatible



Designation	H	B	LF	LH	HF	WF	OAW	RE	Insert	Torque*
JSDJ2CR1212X11-CHP	12	12	120	19	12	0	20.5	0.2	DC**11T3	1.2
JSDJ2CR1616X11-CHP	16	16	120	19	16	0	20.5	0.2	DC**11T3	1.2

\*Torque: Recommended torque (N-m) for clamping \*\*re: Standard corner radius

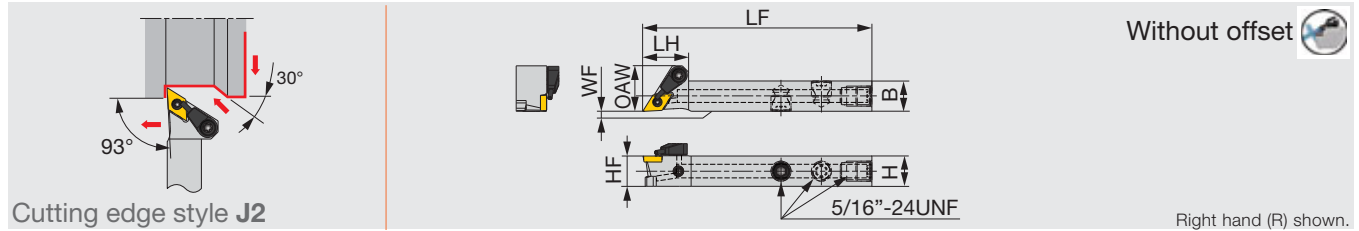
### SPARE PARTS

Designation	Clamping screw	Coolant unit	Wrench	Coolant plug	Wrench	DirectJet plug	Wrench
JSDJ2CR**11-CHP	CSTB-4SD	S-CU-CHP	T-8F	SR5/16UNFTL360	P-4	SSHM4-6-TB	P-2

## JSDJ2CR/L-CHP

Tube connection

Screw-on toolholders without offset – 93° approach angle. For positive 55° rhombic insert. High-pressure coolant capability.



Designation	H	B	LF	LH	HF	WF	OAW	RE**	Insert	Torque*
JSDJ2CR/L1212F07-CHP	12	12	85	18	12	0	18	0.2	DC**0702...	1.2
JSDJ2CR/L1212F11-CHP	12	12	85	19	12	0	20.5	0.2	DC**11T3...	1.2

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

### SPARE PARTS

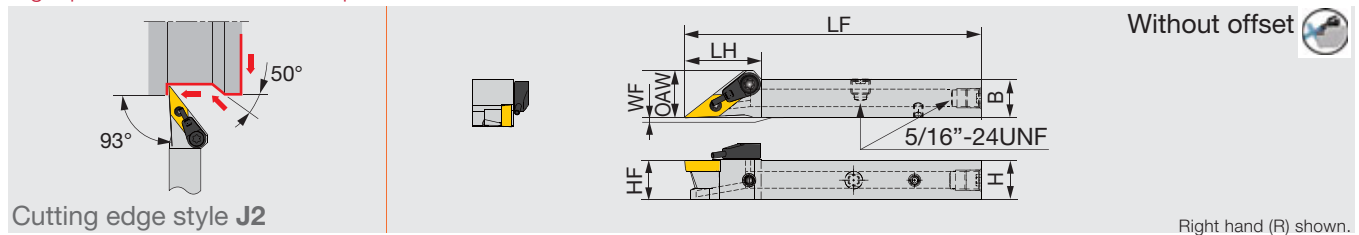
Designation	Clamping screw	Coolant unit	Wrench
JSDJ2CR/L1212F07-CHP	CSTB-2.5	S-CU-CHP	T-8F
JSDJ2CR/L1212F11-CHP	CSTB-4SD	S-CU-CHP	T-8F

Hose connection to the tool holder refer to page 52

## JSVJ2BR-CHP

**DIRECTJET** Direct connection

Screw-on toolholder without offset, 93° approach angle for positive 35° rhombic inserts, high pressure coolant compatible



Designation	H	B	LF	LH	HF	WF	OAW	RE	Insert	Torque*
JSVJ2BR1212X11-CHP	12	12	120	23.6	12	0	14.7	0.2	VB**1103	1.2
JSVJ2BR1616X11-CHP	16	16	120	23.6	16	0	16	0.2	VB**1103	1.2

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

### SPARE PARTS

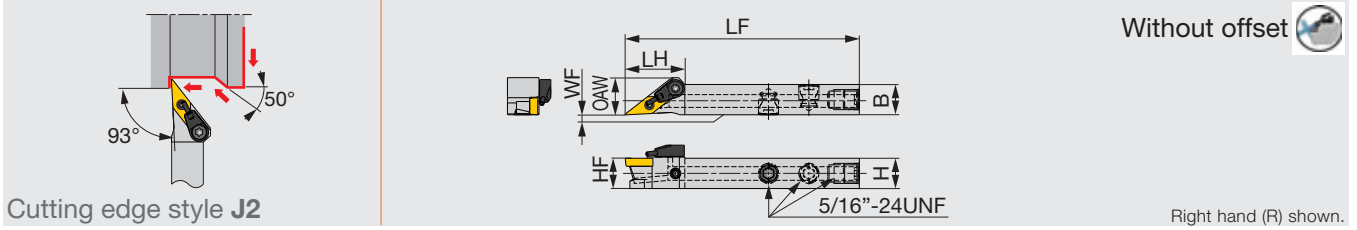
Designation	Clamping screw	Coolant unit	Wrench	Coolant plug	Wrench	DirectJet plug	Wrench
JSVJ2B**11-CHP	CSTB-2.5	S-CU-CHP	T-8F	SR5/16UNFTL360	P-4	SSHM4-6-TB	P-2



## JSVJ2BR/L-CHP

Tube connection

Screw-on toolholder without offset – 93° approach angle. For positive 35° rhombic insert.  
High-pressure coolant capability.



Designation	H	B	LF	LH	HF	WF	OAW	RE**	Insert	Torque*
JSVJ2BR/L1212F11-CHP	12	12	85	23.6	12	0	14.7	0.2	VB**1103...	1.2

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

### SPARE PARTS

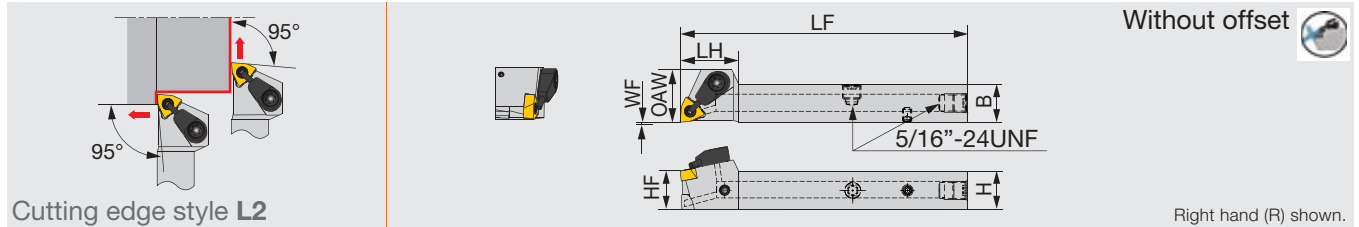
Designation	Clamping screw	Coolant unit	Wrench	Coolant plug	Wrench
JSVJ2B**11-CHP	CSTB-2.5	S-CU-CHP	T-8F	SR5/16UNFTL360	P-4

Hose connection to the tool holder refer to page 52

## JSWL2XR-CHP

**DIRECTJET** Direct connection

Screw-on toolholder without offset, 95° approach angle, for WXGU inserts, high pressure coolant compatible



Designation	H	B	LF	LH	HF	WF	OAW	RE**	Insert	Torque*
JSWL2XR1212X04-CHP	12	12	120	18.5	12	0	16.5	0.2	WXGU0403**L	0.9
JSWL2XR1616X04-CHP	16	16	120	18.5	16	0	16.5	0.2	WXGU0403**L	0.9

\*Torque: Recommended torque (N·m) for clamping \*\*RE: Standard corner radius  
 Note: Right-hand toolholders (R) are used with left-hand inserts (L).

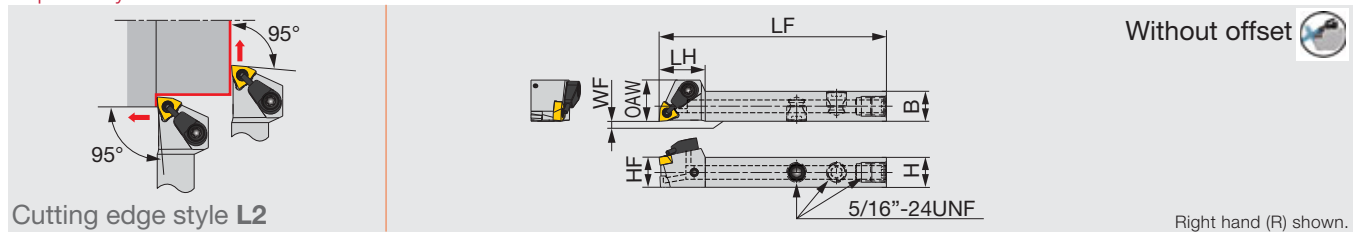
### SPARE PARTS

Designation	Clamping screw	Coolant unit	Wrench	Coolant plug	Wrench	DirectJet plug	Wrench
JSWL2XR**04-CHP	SR34-514	S-CU-CHP	T-7F	SR5/16UNFTL360	P-4	SSHM4-6-TB	P-2

## JSWL2XR/L-CHP

Tube connection

Screw-on toolholder without offset – 95° approach angle. For WXGU insert. High-pressure coolant capability.



Designation	H	B	LF	LH	HF	WF	OAW	RE**	Insert	Torque*
JSWL2XR/L1212F04-CHP	12	12	85	18	12	0	16.5	0.2	WXGU0403**L/R...	0.9

\*Torque: Recommended torque (N·m) for clamping  
 \*\*RE: Standard corner radius  
 Note: Right-hand toolholders (R) are used with left-hand inserts (L). Left-hand toolholders (L) are used with right-hand inserts (R).

### SPARE PARTS

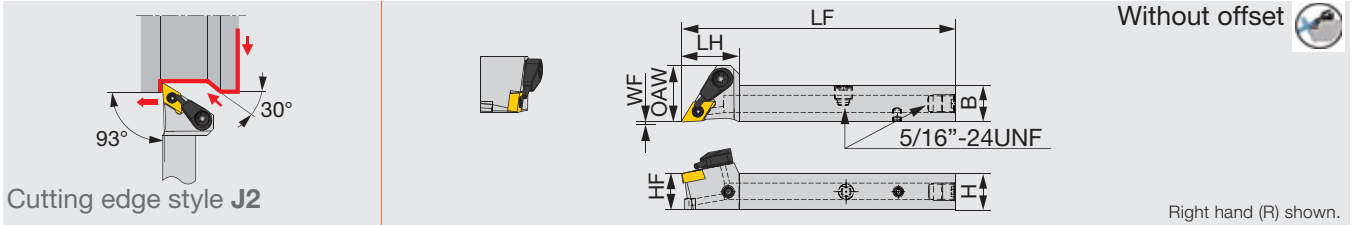
Designation	Clamping screw	Coolant unit	Wrench	Coolant plug	Wrench
JSWL2XR/L1212F04-CHP	SR34-514	S-CU-CHP	T-7F	SR5/16UNFTL360	P-4

Hose connection to the tool holder refer to page 52

## JSDJ2XR-CHP

**DIRECTJET** Direct connection

Screw-on toolholder without offset, 93° approach angle, for DXGU inserts, high pressure coolant compatible



Designation	H	B	LF	LH	HF	WF	OAW	RE**	Insert	Torque*
JSDJ2XR1212X07-CHP	12	12	120	19	12	0	18.5	0.2	DXGU0703**L	0.9
JSDJ2XR1616X07-CHP	16	16	120	19	16	0	18.5	0.2	DXGU0703**L	0.9

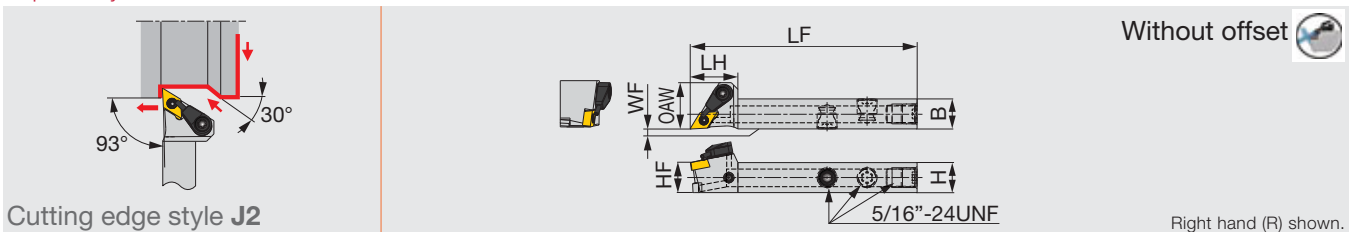
\*Torque: Recommended torque (N-m) for clamping \*\*RE: Standard corner radius  
Note: Right-hand toolholders (R) are used with left-hand inserts (L).

Designation	Clamping screw	Coolant unit	Wrench	Coolant plug	Wrench	DirectJet plug	Wrench
JSDJ2XR**07-CHP	SR34-514	S-CU-CHP	T-7F	SR5/16UNFTL360	P-4	SSHM4-6-TB	P-2

## JSDJ2XR/L-CHP

Tube connection

Screw-on toolholder without offset – 93° approach angle. For DXGU insert. High-pressure coolant capability.



Designation	H	B	LF	LH	HF	WF	OAW	RE **	Insert	Torque*
JSDJ2XR/L1212F07-CHP	12	12	85	19	12	0	18.5	0.2	DXGU0703**L/R...	0.9

\*Torque: Recommended torque (N-m) for clamping  
\*\*RE: Standard corner radius  
Note: Right-hand toolholders (R) are used with left-hand inserts (L). Left-hand toolholders (L) are used with right-hand inserts (R).

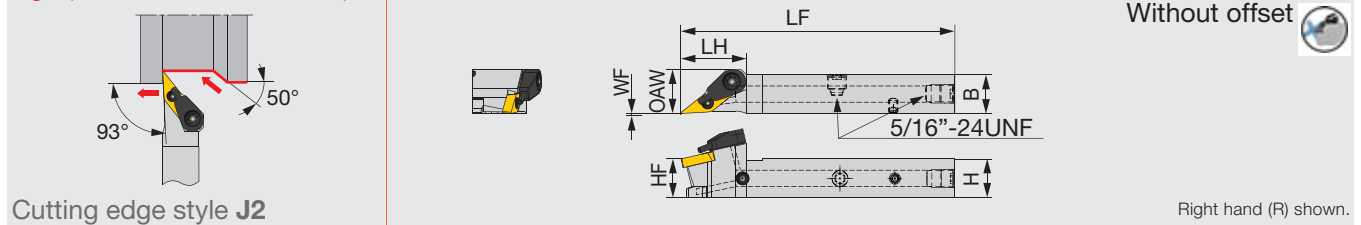
Designation	Clamping screw	Coolant unit	Wrench	Coolant plug	Wrench
JSDJ2XR/L1212F07-CHP	SR34-514	S-CU-CHP	T-7F	SR5/16UNFTL360	P-4

Hose connection to the tool holder refer to page 52

## JSVJ2XR-CHP

**DIRECTJET** Direct connection

Screw-on toolholder without offset, 93° approach angle, for VXGU inserts, high pressure coolant compatible



Designation	H	B	LF	LH	HF	WF	OAW	RE**	Insert	Torque*
JSVJ2XR1212X09-CHP	12	12	120	19.5	12	0	13.4	0.2	VXGU09T2**L	0.9
JSVJ2XR1616X09-CHP	16	16	120	19.5	16	0	16	0.2	VXGU09T2**L	0.9

\*Torque: Recommended torque (N-m) for clamping \*\*RE: Standard corner radius  
Note: Right-hand toolholders (R) are used with left-hand inserts (L).

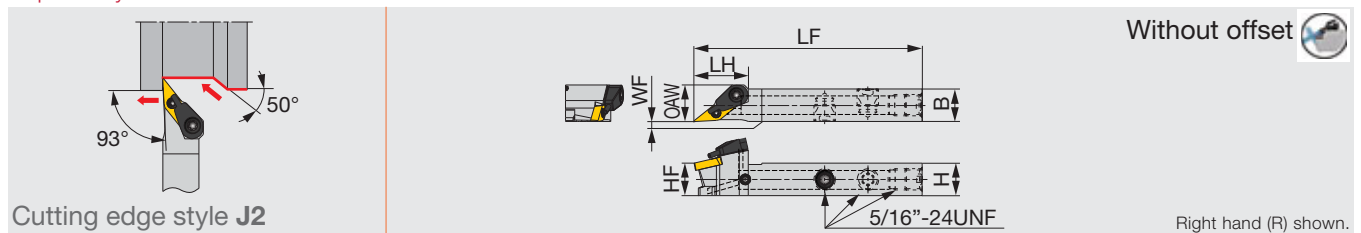
### SPARE PARTS

Designation	Clamping screw	Coolant unit	Wrench	Coolant plug	Wrench	DirectJet plug	Wrench
JSVJ2XR**F09-CHP	SR34-508	S-CU-CHP	T-7F	SR5/16UNFTL360	P-4	SSHM4-6-TB	P-2

## JSVJ2XR/L-CHP

Tube connection

Screw-on toolholder without offset – 93° approach angle. For VXGU insert. High-pressure coolant capability.



Designation	H	B	LF	LH	HF	WF	OAW	RE**	Insert	Torque*
JSVJ2XR/L1212F09-CHP	12	12	85	20	12	0	13.5	0.2	VXGU09T2**L/R...	0.9

\*Torque: Recommended torque (N-m) for clamping  
\*\*RE: Standard corner radius  
Note: Right-hand toolholders (R) are used with left-hand inserts (L). Left-hand toolholders (L) are used with right-hand inserts (R).

### SPARE PARTS

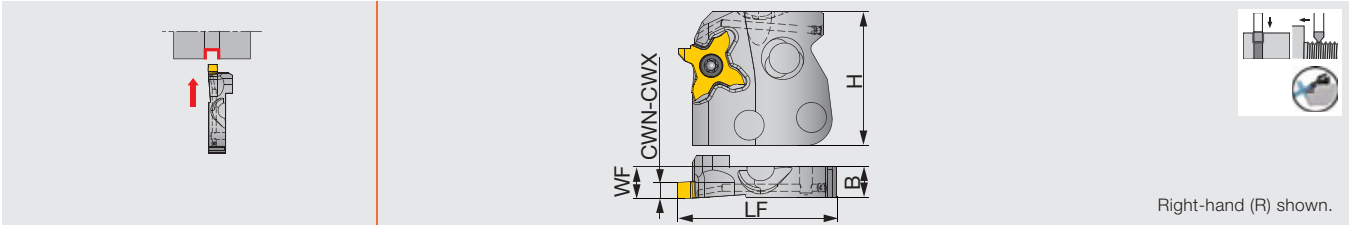
Designation	Clamping screw	Coolant unit	Wrench	Coolant plug	Wrench
JSVJ2XR**F09-CHP	SR34-508	S-CU-CHP	T-7F	SR5/16UNFTL360	P-4

Hose connection to the tool holder refer to page 52

## STCAR/L18-CHP

Modular blade with high pressure coolant channels

## TETRAMCUT



Right-hand (R) shown.

Designation	CWN	CWX	WF	H	LF	B	Insert	Torque*
STCAR/L18-CHP	0.33	3	7.5	33	38	7.2	TC*18...	1.2

- Use the right hand insert (TC\*18R...) with the right hand blade (STCAR...). Use the left hand insert (TC\*18L...) with the left hand blade (STCAL...).

\*Torque: Recommended torque (N-m) for clamping

### SPARE PARTS

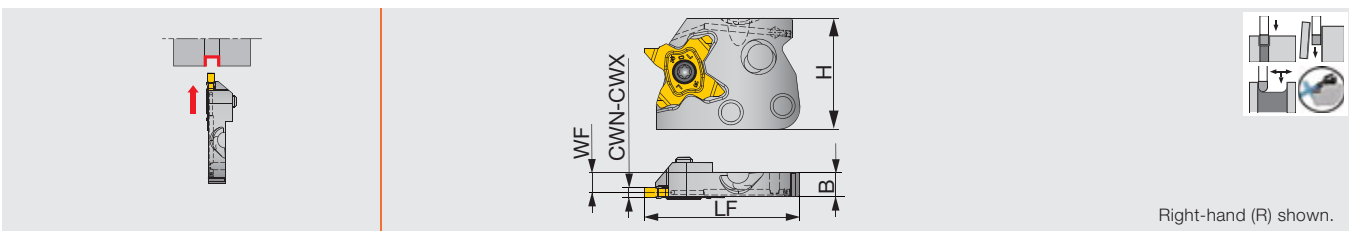


Designation	Clamping screw	Wrench
STCAL18-CHP	CSTC-4L100DR	T-1008/5
STCAR18-CHP	CSTC-4L100DL	T-1008/5

## STCAR/L27-CHP

Modular blade with high pressure coolant channels

## TETRAFCUT



Right-hand (R) shown.

Designation	CWN	CWX	WF	H	LF	B	Insert	Torque*
STCAR/L27-CHP	0.5	3.18	6	33	46	7.2	TC*27...	2.5

\*Torque: Recommended torque (N-m) for clamping

### SPARE PARTS

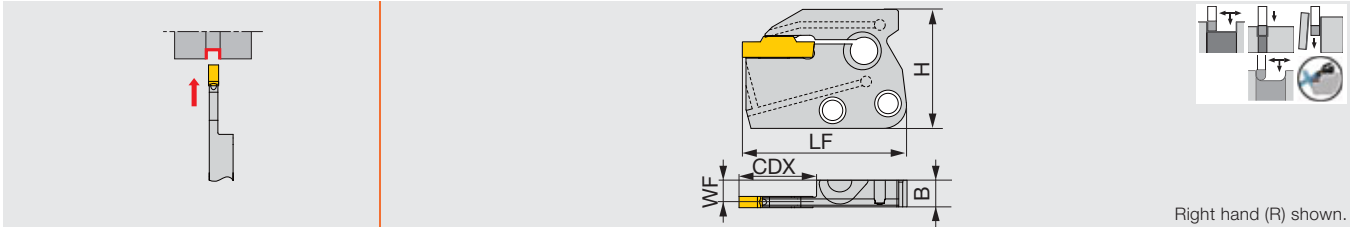


Designation	Screw	Wrench
STCAR27-CHP	SR16-212-01397L	T-2010/5
STCAL27-CHP	SR16-212-01397	T-2010/5



## CAER/L-CHP

Modular blade for parting & grooving, with channels for high pressure coolant



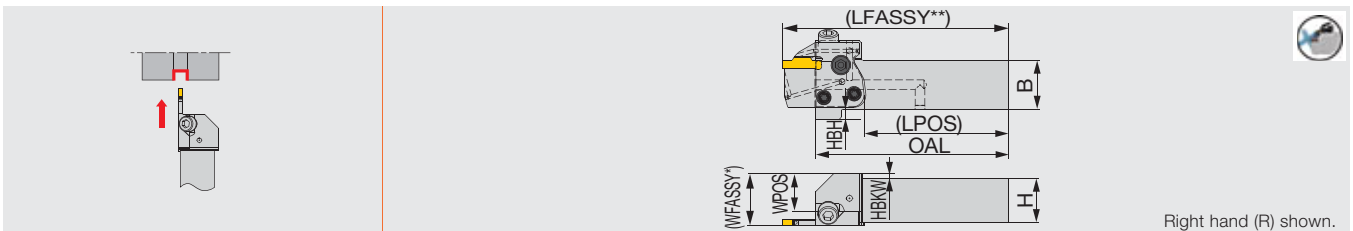
Designation	CW	Seat size	CDX	H	B	LF	WF <sup>(1)</sup>
CAER/L-2T16-CHP	2	2	16	33	7.2	41.5	7.3
CAER/L-2T20-CHP	2	2	20	33	7.2	45.5	7.3
CAER/L-3T16-CHP	3	3	16	33	7.2	41.5	7.4
CAER/L-3T20-CHP	3	3	20	33	7.2	45.5	7.5
CAER/L-4T16-CHP	4	4	16	33	7.2	41.5	7.7
CAER/L-4T20-CHP	4	4	20	33	7.2	45.5	7.7
CAER/L-5T20-CHP	5	5	20	33	7.2	46.3	7.8
CAER/L-6T20-CHP	6	6	20	33	7.2	46.3	7.8

- Always use 1 cutting edged insert when the working depth exceeds the total insert length minus 1.5 mm.

## CHSR/L-CHP-MC

Direct connection

TungModularSystem tool holder, with hose-free direct coolant supply



Designation	H	B	OAL	LPOS	WPOS	HBKW	HBH	Blade(Optional)	Torque*
CHSR/L2020-CHP-MC	20	20	98	73.5	14	6	10	CAER/L-CHP	5
CHSR/L2525-CHP-MC	25	25	98	73.5	19	-	5	CAER/L-CHP	5

\*WFASSY : shank (WPOS) + blade (WF)

\*\*LFASSY : shank (LPOS) + blade (LF)

\*Torque: Recommended torque (N·m) for clamping

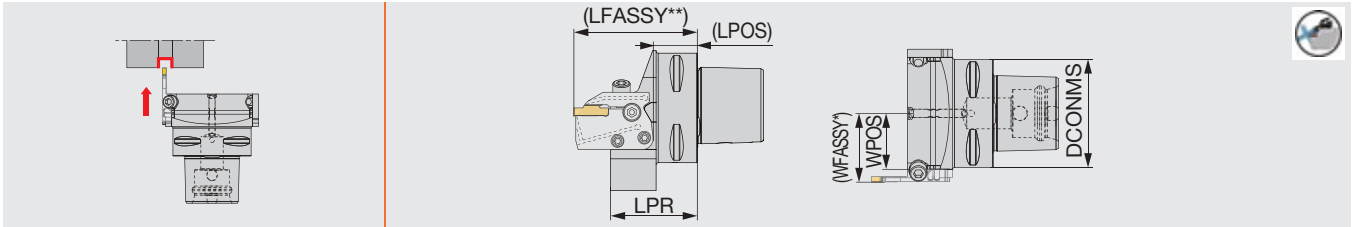
Applicable for 30 MPa pressure coolant

- See pages 35 for modular blade assembly instruction

## C\*CHSN-CHP

**TUNGCAP** Direct connection

PSC body for CAER/L-CHP, with channels for high pressure coolant



Designation	DCONMS	LPR	LPOS	WPOS	Blade(Optional)	Torque*
C3CHSN19045-CHP	32	45	17.5	18.5	CAER/L-CHP	5
C4CHSN21047-CHP	40	46.5	21.5	21	CAER/L-CHP	5
C5CHSN26047-CHP	50	47	22.5	26	CAER/L-CHP	5
C6CHSN33050-CHP	63	50	24.5	32.5	CAER/L-CHP	5

\*WFASSY : shank (WPOS) + blade (WF)

\*\*LFASSY : shank (LPOS) + blade (LF)

Applicable for 30 MPa pressure coolant

\*Torque: Recommended torque (N-m) for clamping

### SPARE PARTS

Designation	Clamping screw	Wrench	Clamping screw	Clamping screw	Wrench	O-ring
C*CHSN*-CHP	SRM5-04451	T-20/5	SRM6X12DIN6912	SRM6X20-XT	HW5.0	OR5X1N

• See pages 35 for modular blade assembly instruction

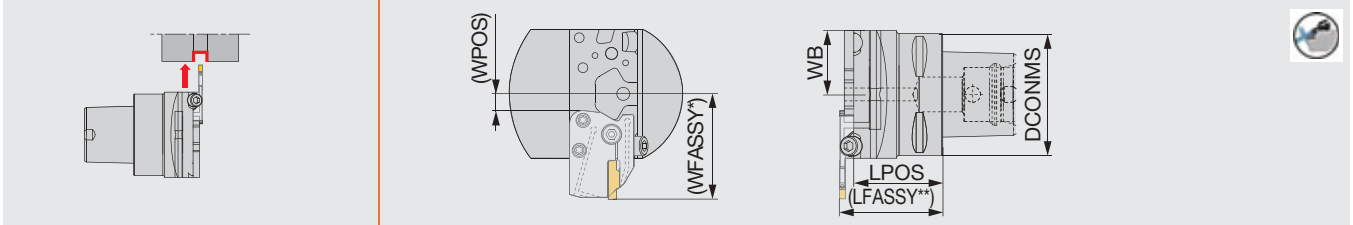
### Recommended torque

Clamping screw	Torque (N · m)
SRM5-04451	5
SRM6X12DIN6912	8.5
SRM6X20-XT	8.5

## C\*CHFVN-CHP

**TUNGCAP** Direct connection

PSC body for CAER/L-CHP, with channels for high pressure coolant



Designation	DCONMS	LPOS	WB	WPOS	Blade(Option)	Torque*
C3CHFVN26040-CHP	32	40	26	1.5	CAER/L-CHP	5
C4CHFVN26046-CHP	40	46	26	1.5	CAER/L-CHP	5
C5CHFVN26046-CHP	50	46	26	1.5	CAER/L-CHP	5
C6CHFVN33046-CHP	63	46	33	8.5	CAER/L-CHP	5

\*WFASSY : shank (WPOS) + blade (LF)

\*\*LFASSY : shank (LPOS) + blade (WF)

Applicable for 30 MPa pressure coolant

\*Torque: Recommended torque (N·m) for clamping

### SPARE PARTS

Designation	Clamping screw	Wrench	Clamping screw	Clamping screw	Wrench	O-ring
C*CHFVN...-CHP	SRM5-04451	T-20/5	SRM6X12DIN6912	SRM6X20-XT	HW5.0	OR5X1N

• See pages 35 for modular blade assembly instruction

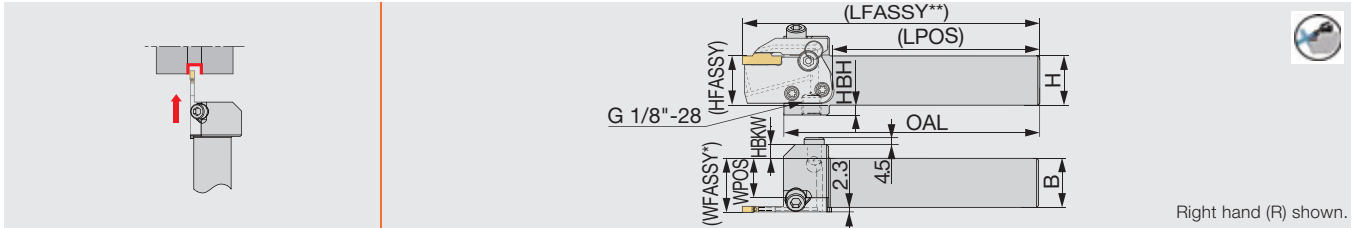
### Recommended torque

Clamping screw	Torque (N · m)
SRM5-04451	5
SRM6X12DIN6912	8.5
SRM6X20-XT	8.5

## CHSR/L-CHP

Tube connection

Shank for CAER/L-CHP, with channels for high pressure coolant



Right hand (R) shown.

Designation	H	B	OAL	LPOS	WPOS	HBKW	HBH	Blade(Optional)	Torque*
CHSR/L2020-CHP	20	20	130	105.5	15.1	12	10	CAER/L-CHP	5
CHSR/L2525-CHP	25	25	130	105.5	20.1	7	5	CAER/L-CHP	5

\*WFASSY : shank (WPOS) + blade (WF)

\*\*LFASSY : shank (LPOS) + blade (LF)

Applicable for 30 MPa pressure coolant

\*Torque: Recommended torque (N·m) for clamping

### SPARE PARTS

Designation	Screw	Wrench	Clamping screw	Clamping screw	Wrench	O-ring	Plug
CHSR/L*-CHP	SRM5-04451	T-20/5	SRM6X12DIN6912	SRM6X20-XT	HW5.0	OR5X1N	PLUGG1/8ISO1179

• See page 35 for instruction on installing and removing the blade and insert  
Hose connection to the tool holder refer to page 52

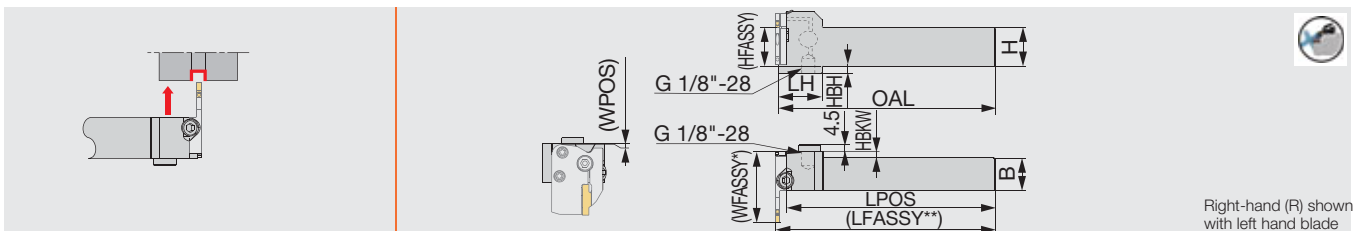
### Recommended torque

Clamping screw	Torque (N·m)
SRM5-04451	5
SRM6X12DIN6912	8.5
SRM6X20-XT	8.5

## CHFVR/L-CHP

Tube connection

Shank for CAER/L-CHP, with channels for high pressure coolant



Right-hand (R) shown  
with left hand blade

Designation	H	B	OAL	LH	LPOS	WPOS	HBKW	HBH	Blade(Optional)	Torque*
CHFVR/L2020-CHP	20	20	140	28	135.1	0.5	5	10	CAER/L-CHP	5
CHFVR/L2525-CHP	25	25	140	28	135.1	0.5	0	5	CAER/L-CHP	5

\*WFASSY : shank (WPOS) + blade (LF)

\*\*LFASSY : shank (LPOS) + blade (WF)

Right-hand (R) shown with left hand blade

Applicable for 30 MPa pressure coolant

\*Torque: Recommended torque (N·m) for clamping

### SPARE PARTS

Designation	Clamping screw	Wrench	Clamping screw	Clamping screw	Wrench	O-ring	Plug
CHFVR/L*-CHP	SRM5-04451	T-20/5	SRM6X12DIN6912	SRM6X20-XT	HW5.0	OR5X1N	PLUGG1/8ISO1179

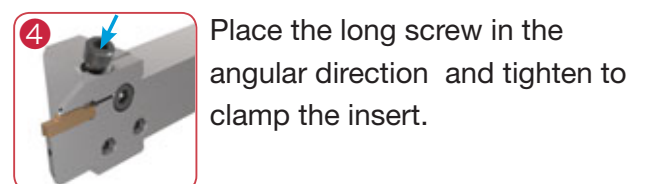
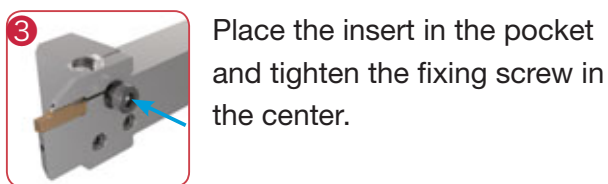
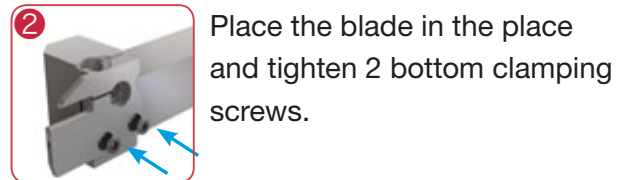
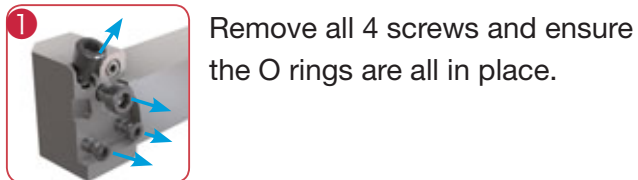
### Recommended torque

Clamping screw	Torque (N·m)
SRM5-04451	5
SRM6X12DIN6912	8.5
SRM6X20-XT	8.5

• See pages 35 for modular blade assembly instruction  
Hose connection to the tool holder refer to page 52

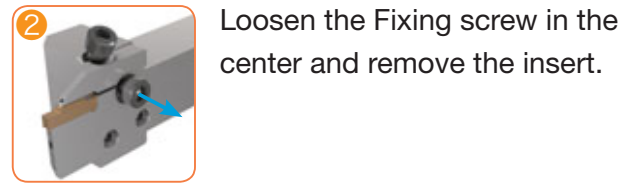
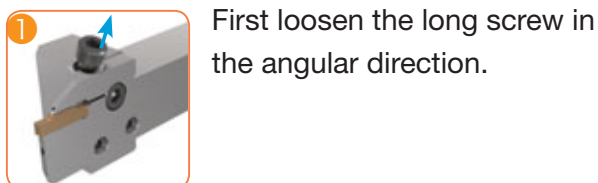
## How to install and remove the blade and insert

### Installing the insert

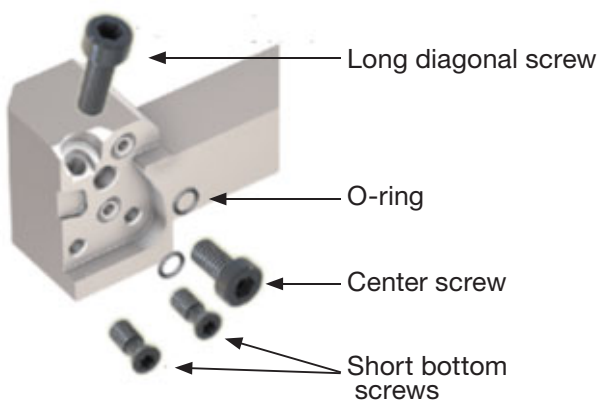


Please follow the installation order as shown above. When the screws are tightened in the 4 → 3 order, the insert clamping may be insufficient and unstable.

### Removing the insert



Loosing the long screw alone may not release the insert.

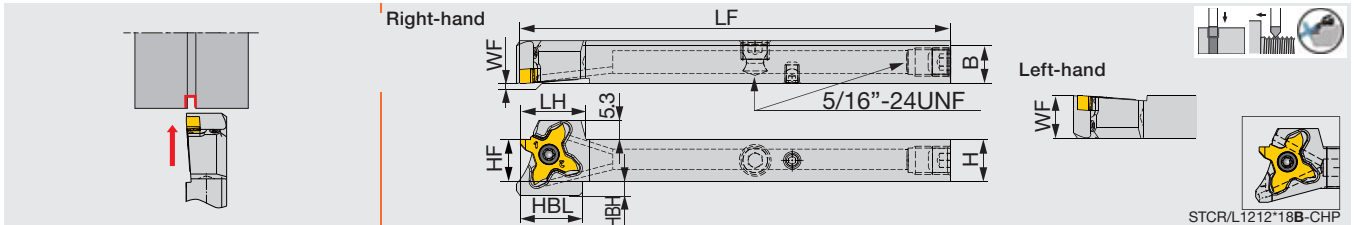




## STCR/L-18-CHP

**DIRECTJET** Direct connection

External grooving and threading toolholder, high pressure coolant compatible



Designation	CW	H	B	LF	LH	HBL	HF	WF	HBH	Insert	Torque*
STCR/L1212X18-CHP***	0.33 - 3	12	12	120	18.5	17.5	12	0/12	4	TC**18	1.2
STCR/L1212X18B-CHP	0.33 - 3	12	12	120	18.5	17.5	12	0/12	4	TC**18	1.2
STCR/L1616X18-CHP	0.33 - 3	16	16	120	18.5	-	16	0/16	0	TC**18	1.2

• The right hand insert (TC\*18R\*\*\*) is used for the right hand toolholders (STCR\*\*\*), and the left hand insert (TC\*18L\*\*\*) is used for the left hand toolholders (STCL\*\*\*).  
 \*Torque: Recommended torque (N·m) for clamping  
 \*\*\*: To be replaced with the new design

### SPARE PARTS

Designation	Clamping screw	Wrench	Coolant plug	Wrench	DirectJet plug	Wrench
STCL**18-CHP	CSTC-4L100DR	T-1008/5	SR5/16UNFTL360	P-4	SSHM4-6-TB	P-2
STCR**18-CHP	CSTC-4L100DL	T-1008/5	SR5/16UNFTL360	P-4	SSHM4-6-TB	P-2

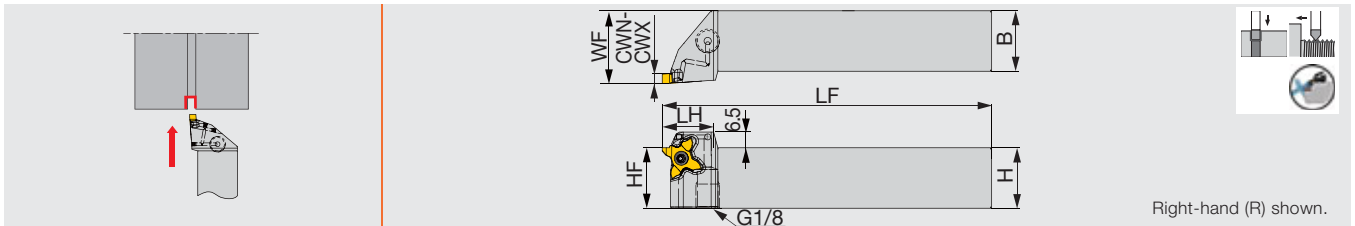
Groove width range : 0.33 ~ 3.0 mm

Threading pitch range : 0.8 ~ 3.0 mm

## STCR/L-18-CHP

Tube connection

Threading tool - for external threading with high pressure coolant capability



Designation	CWN	CWX	H	B	LF	LH	HBL	HF	WF	HBH	Insert	Torque*
STCR/L2020X18-CHP	0.33	3	20	20	120	23	-	20	25	-	TC*18...	1.2
STCR/L2525Z18-CHP	0.33	3	25	25	135	23	-	25	30	-	TC*18...	1.2

- Use the right hand insert (TC\*18R...) with the right hand toolholders (STCR...). Use the left hand insert (TC\*18L...) with the left hand holder (STCL...).

\*Torque: Recommended torque (N·m) for clamping

### SPARE PARTS

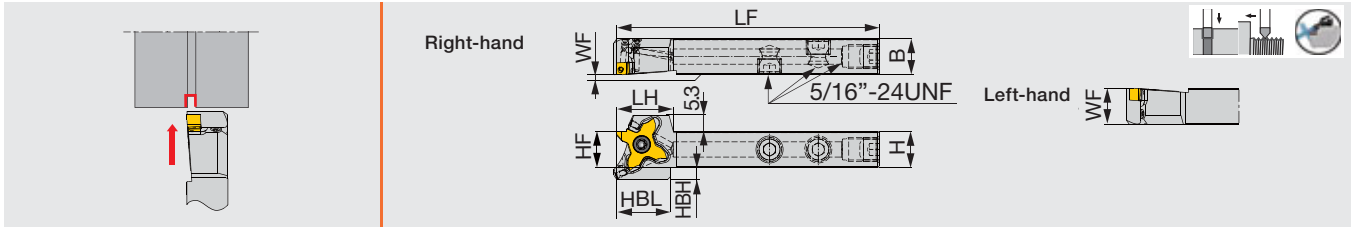
Designation	Clamping screw	Wrench
STCL**18-CHP	CSTC-4L100DR	T-1008/5
STCR**18-CHP	CSTC-4L100DL	T-1008/5

Hose connection to the tool holder refer to page 52

## STCR/L-18-CHP

Tube connection

External grooving and threading toolholder. High pressure coolant capability.



Designation	CW	H	B	LF	LH	HBL	HF	WF	HBH	Insert	Torque*
STCR/L1212F18-CHP***	0.33-3	12	12	85	18.5	17.5	12	0/12	4	TC**18	1.2
STCR/L1212F18B-CHP	0.33-3	12	12	85	18.5	17.5	12	0/12	4	TC**18	1.2

• The right hand insert (TC\*18R\*\*\*) is used for the right hand toolholders (STCR\*\*\*), and the left hand insert (TC\*18L\*\*\*) is used for the left hand toolholders (STCL\*\*\*).  
 (1) "0/12" for the WF dimension indicates WF = 0 for the right handed tool, WF = 12 for the left handed tool.

\*Torque: Recommended torque (N·m) for clamping

\*\*\*: To be replaced with the new design

### SPARE PARTS

Designation	Clamping screw	Wrench	Coolant plug	Wrench
STCL**18-CHP	CSTC-4L100DR	T-1008/5	SR5/16UNFTL360	P-4
STCR**18-CHP	CSTC-4L100DL	T-1008/5	SR5/16UNFTL360	P-4

Groove width range : 0.33 ~ 3.0 mm

Threading pitch range : 0.8 ~ 3.0 mm

Hose connection to the tool holder refer to page 52

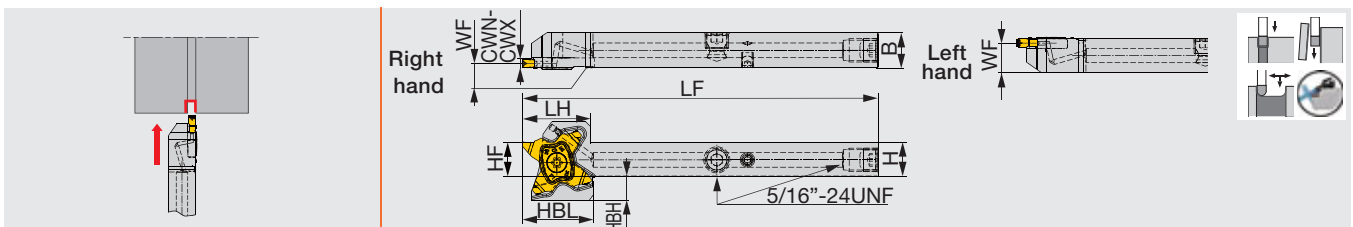
# TETRAFORCE

TUNGALOY

## STCR/L-27-CHP

DIRECTTJET Direct connection

Grooving and parting-off tool with DirectTung-Jet high pressure coolant capability



Designation	CWN	CWX	H	B	LF	LH	HF	WF(1)	HBH	HBL	insert	Torque*
STCR/L1212-27-CHP	0.5	3.18	12	12	120	23	12	1.5/10.5	8	24	TC*27...	2.5

- Make sure to avoid tool interferences when used on Swiss machines

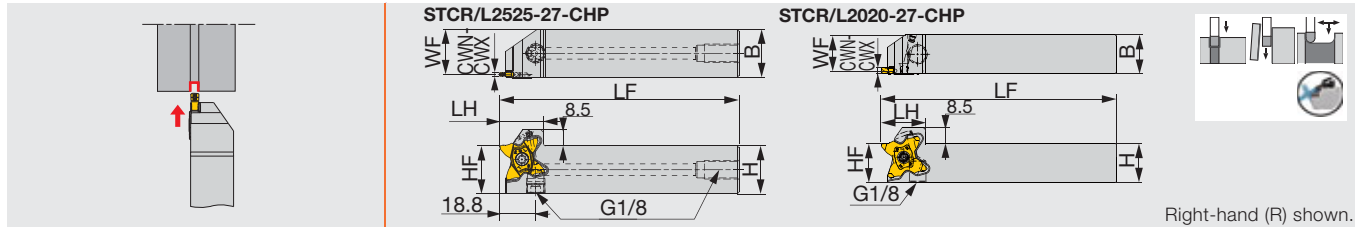
\*Torque: Recommended torque (N·m) for clamping

(1) The above WF value is valid when an insert width of CW=3 is mounted.

## STCR/L-CHP

Tube connection

Precision grooving tools with uniquely shaped insert with 4 cutting edges and channel for high pressure coolant supply



Designation	CWN	CWX	H	B	LF	LH	HF	WF	insert	Torque*
STCR/L2020-27-CHP	0.5	3.18	20	20	120	23	20	18.5	TC*27...	2.5
STCR/L2525-27-CHP	0.5	3.18	25	25	125	23	25	23.5	TC*27...	2.5

\*Torque: Recommended torque (N·m) for clamping

### SPARE PARTS



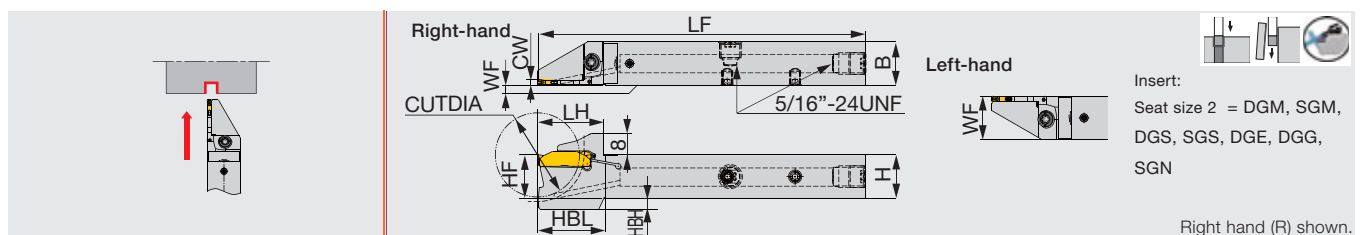
Designation	Screw	Wrench
STCR...-27-CHP	SR16-212-01397L	T-2010/5
STCL...-27-CHP	SR16-212-01397	T-2010/5

Hose connection to the tool holder refer to page 52

## JCTER/L-CHP

DIRECTJET Direct connection

External grooving and parting-off toolholder, high pressure coolant compatible



Designation	CW	Seat size	CUTDIA	H	B	LF	LH	HBL	HF	WF (1)	HBH	Torque*
JCTER/L1212X2T12-CHP	2	2	25	12	12	120	24.7	24.7	12	0/12	5	3.0
JCTER/L1616X2T12-CHP	2	2	25	16	16	120	24.7	24.5	16	0/16	1	3.0
JCTER/L1616X2T16-CHP	2	2	32	16	16	120	24.7	24.7	16	0/16	4	3.0
JCTER/L2020X2T16-CHP	2	2	32	20	20	120	24.7	-	20	0/20	0	3.0

(1) "WF" value is calculated with groove width "CW" shown in the table. • CUTDIA: Max. parting off dia.

\*Torque: Recommended torque (N·m) for clamping

### SPARE PARTS



Designation	Clamping screw	Wrench	Coolant plug	Wrench	DirectJet plug	Wrench
JCTER/L...	C SHB-4-A	T-15F	SR5/16UNFTL360	P-4	SSHM4-6-TB	P-2

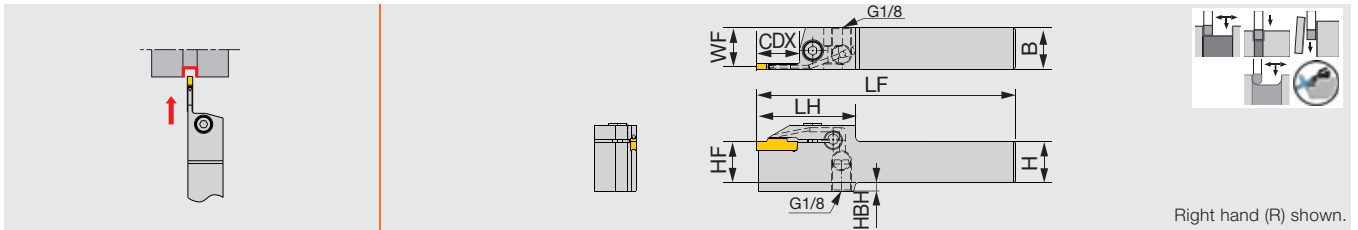
Parting-off width: 2.0 mm

See page 42 for the proper tool overhang and plug settings.

## CTER/L-CHP

Tube connection

Modular blade for parting & grooving, with channels for high pressure coolant



Designation	CW	Seat size	CDX	HF	B	H	LF	WF	HBH	LH	Torque*
CTER/L2020-2T17-CHP	2	2	17	20	20	20	125	19.1	4	45	5.5
CTER/L2525-2T17-CHP	2	2	17	25	25	25	150	24.1	-	45	5.5
CTER/L2020-3T20-CHP	3	3	20	20	20	20	125	18.8	4	48	5.5
CTER/L2525-3T20-CHP	3	3	20	25	25	25	150	23.8	-	48	5.5
CTER/L2525-3T25-CHP	3	3	25	25	25	25	150	23.8	-	51	5.5
CTER/L2525-4T25-CHP	4	4	25	25	25	25	150	23.5	-	55	8
CTER/L2525-5T20-CHP	5	5	20	25	25	25	150	23.08	-	49	8
CTER/L2525-6T20-CHP	6	6	20	25	25	25	150	22.58	7	52	12

• Always use 1 cutting edged insert when the working depth exceeds the total insert length minus 1.5 mm.

\*Torque: Recommended torque (N·m) for clamping

### SPARE PARTS



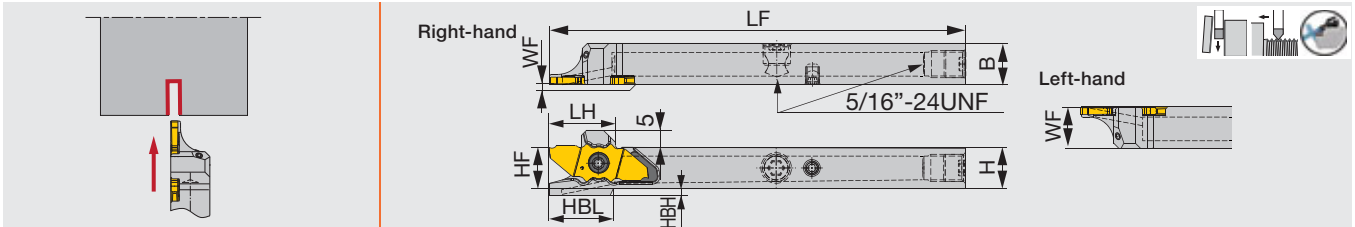
Designation	Clamping screw	Wrench
CTER/L2020-2T17-CHP	CM5x0.8x20-A	P-4
CTER/L2525-2T17-CHP	CM5x0.8x25-A	P-4
CTER/L2020-3T20-CHP	CM5x0.8x20-A	P-4
CTER/L2525-3T20-CHP	CM5x0.8x25-A	P-4
CTER/L2525-3T25-CHP	CM5x0.8x25-A	P-4
CTER/L2525-4T25-CHP	CM6x1x25-A	P-5
CTER/L2525-5T20-CHP	CM6x1x25-A	P-5
CTER/L2525-6T20-CHP	CM8x1.25x25-A	P-6

Hose connection to the tool holder refer to page 52

## JSXXR/L-CHP

**DIRECTJET** Direct connection

Parting and threading toolholder, high pressure coolant compatible



Designation	CW	H	B	WF	LF*	HF	HBH	LH	HBL	Insert	Torque*
JSXXR/L1212X09-CHP	1 - 2	12	12	0.2/11.8	≤ 120	12	2	≤ 19.4	18.8	JX*G06...,12...,16..., 20...	1.2
JSXXR/L1616X09-CHP***	1 - 2	16	16	0.2/15.8	≤ 120	16	2.5	≤ 19.4	18.7	JX*G06...,12...,16..., 20...	1.2
JSXXR/L1616X09B-CHP	1 - 2	16	16	0.2/15.8	≤ 120	16	0	≤ 19.4	18.7	JX*G06...,12...,16..., 20...	1.2

\*Torque: Recommended torque (N·m) for clamping

\*\*LF (Functional Length) LH (Head Length), and HBL (Head-bottom Offset Length) values shown above are true with JXPG16\*\*\* insert.

LF, LH, and HBL will all be 2 mm shorter than the above values with JX\*G12\*\* and JXPG20\*\*\* inserts, and 4 mm shorter for JXPG06\*\*\* insert.

\*\*\*To be replaced with the new design

Note: Use the right-hand insert (JX\*G\*\*R\*\*\*) for a right-hand holder (JSXXR\*\*\*); the left-hand insert (JX\*G\*\*L\*\*\*) for a left-hand holder (JSXXL\*\*\*).

### SPARE PARTS

Designation	Clamping screw	Wrench	Coolant plug	Wrench	DirectJet plug	Wrench
JSXXR...	CSTC-4L100DL	T-1008/5	SR5/16UNFTL360	P-4	SSHM4-6-TB	P-2
JSXXL...	CSTC-4L100DR	T-1008/5	SR5/16UNFTL360	P-4	SSHM4-6-TB	P-2

Parting-off widths : 1.0 mm and 1.5 mm (for a max parting diameter of  $\phi 6$  mm)  
: 1.5 mm and 2.0 mm (for max parting diameters of  $\phi 12$  mm,  $\phi 16$  mm,  $\phi 20$  mm)

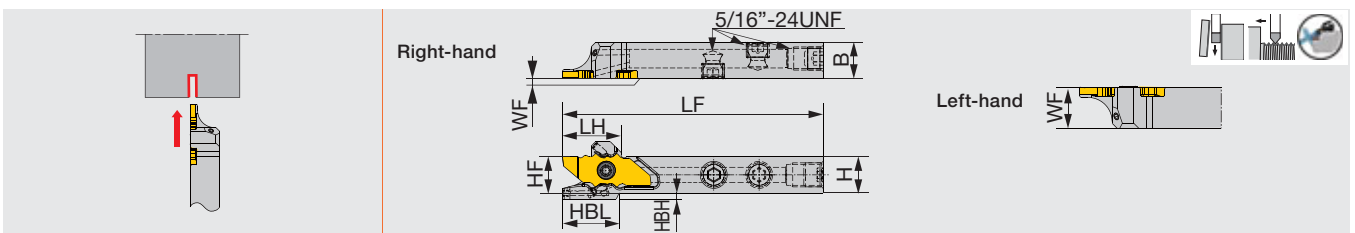
Threading pitch range : 0.2 - 1.5 mm

See page 42 for the proper tool overhang and plug settings.

## JSXXR/L-CHP

Tube connection

Parting-off and threading toolholder. High pressure coolant capability.



Designation	CW	H	B	WF (1)	LF*	HF	HBH	LH*	HBL	Insert	Torque*
JSXXR/L1212F09-CHP	1-2	12	12	0.2/11.8	≤ 85	12	2	≤ 19.4	18.65	JX*G06...,12...,16..., 20...	1.2

\*Torque: Recommended torque (N·m) for clamping

\*\*LF (Functional Length) LH (Head Length), and HBL (Head-bottom Offset Length) values shown above are true with JXPG16\*\*\* insert.

LF, LH, and HBL will all be 2 mm shorter than the above values with JX\*G12\*\* and JXPG20\*\*\* inserts, and 4 mm shorter for JXPG06\*\*\* insert.

Note: Use the right-hand insert (JX\*G\*\*R\*\*\*) for a right-hand holder (JSXXR\*\*\*); the left-hand insert (JX\*G\*\*L\*\*\*) for a left-hand holder (JSXXL\*\*\*).

### SPARE PARTS

Designation	Clamping screw	Wrench	Coolant plug	Wrench
JSXXR...	CSTC-4L100DL	T-1008/5	SR5/16UNFTL360	P-4
JSXXL...	CSTC-4L100DR	T-1008/5	SR5/16UNFTL360	P-4

Parting-off widths : 1.0 mm and 1.5 mm (for a max parting diameter of  $\phi 6$  mm)  
: 1.5 mm and 2.0 mm (for max parting diameters of  $\phi 12$  mm,  $\phi 16$  mm,  $\phi 20$  mm)

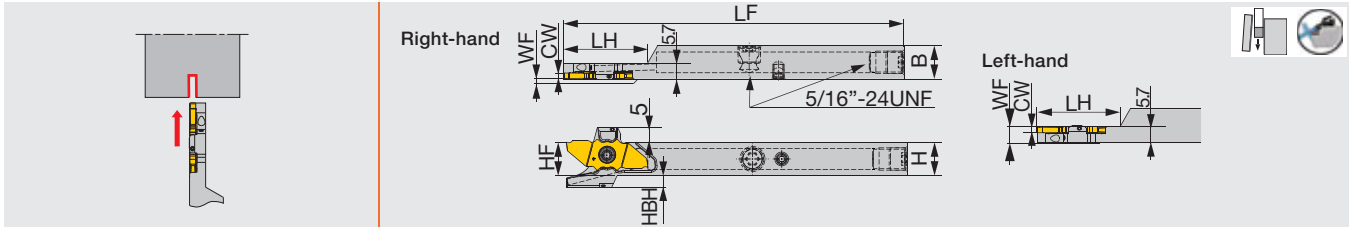
Threading pitch range : 0.2 - 1.5 mm

Hose connection to the tool holder refer to page 52

## JSXXR/L-S-CHP

**DIRECTJET** Direct connection

Parting-off tool holder, capable with sub spindle, high-pressure coolant compatible



Designation	CW	H	B	WF	LF*	HF	HBH	LH	Insert	Torque*
JSXXR/L1212X09-S-CHP***	1 - 2	12	12	0.2/5.5	≤ 120	12	4	30	JX*G06...,12...,16..., 20...	1.2
JSXXR/L1212X09B-S-CHP	1 - 2	12	12	0.2/5.5	≤ 120	12	2	30	JX*G06...,12...,16..., 20...	1.2
JSXXR/L1616X09-S-CHP***	1 - 2	16	16	0.2/5.5	≤ 120	16	1.5	30	JX*G06...,12...,16..., 20...	1.2
JSXXR/L1616X09B-S-CHP	1 - 2	16	16	0.2/5.5	≤ 120	16	0	30	JX*G06...,12...,16..., 20...	1.2

\*Torque: Recommended torque (N-m) for clamping

\*\*LF (Overall Tool Length) and LH (Head Length) values shown above are true with JXPG16\*\*\* insert.

Both LF and LH will be 2 mm shorter than the above value with JX\*G12\*\* and JXPG20\*\*\* inserts; 4 mm shorter with JXPG06\*\*\* insert.

\*\*\*To be replaced with the new design

Note: Use the right-hand insert (JX\*G\*\*R\*\*\*) for a right-hand holder (JSXXR\*\*\*); the left-hand insert (JX\*G\*\*L\*\*\*) for a left-hand holder (JSXXL\*\*\*).

### SPARE PARTS

Designation	Clamping screw	Wrench	Coolant plug	Wrench	DirectJet plug	Wrench
JSXXR**09-S-CHP	CSTC-4L055DL	T-1008/5	SR5/16UNFTL360	P-4	SSHM4-6-TB	P-2
JSXXL**09-S-CHP	CSTC-4L055DR	T-1008/5	SR5/16UNFTL360	P-4	SSHM4-6-TB	P-2

Parting-off widths : 1.0 mm and 1.5 mm (for a max parting diameter of ø6 mm)

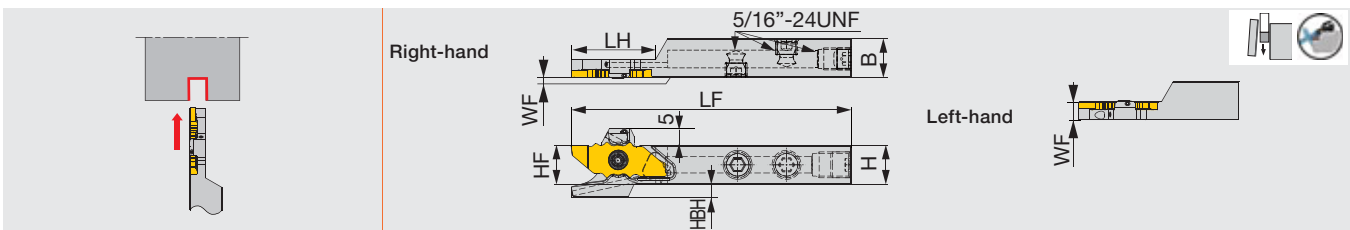
: 1.5 mm and 2.0 mm (for max parting diameters of ø12 mm, ø16 mm, ø20mm)

See page 42 for the proper tool overhang and plug settings.

## JSXXR/L-F-S-CHP

Tube connection

Parting-off toolholder for sub-spindle, with high pressure coolant capability.



Designation	CW	H	B	WF (1)	LF*	HF	HBH	LH*	Insert	Torque*
JSXXR/L1212F09-S-CHP***	1-2	12	12	0.2/5.5	≤ 85	12	4	26	JX*G06...,12...,16..., 20...	1.2
JSXXR/L1212F09B-S-CHP	1-2	12	12	0.2/5.5	≤ 85	12	2	26	JX*G06...,12...,16..., 20...	1.2

\*Torque: Recommended torque (N-m) for clamping

\*\*LF (Overall Tool Length) and LH (Head Length) values shown above are true with JXPG16\*\*\* insert.

Both LF and LH will be 2 mm shorter than the above value with JX\*G12\*\* and JXPG20\*\*\* inserts; 4 mm shorter with JXPG06\*\*\* insert.

\*\*\*To be replaced with the new design

Note: Use the right-hand insert (JX\*G\*\*R\*\*\*) for a right-hand holder (JSXXR\*\*\*); the left-hand insert (JX\*G\*\*L\*\*\*) for a left-hand holder (JSXXL\*\*\*).

### SPARE PARTS

Designation	Clamping screw	Wrench	Coolant plug	Wrench
JSXXR...	CSTC-4L100DL	T-1008/5	SR5/16UNFTL360	P-4
JSXXL...	CSTC-4L100DR	T-1008/5	SR5/16UNFTL360	P-4

Parting-off widths : 1.0 mm and 1.5 mm (for a max parting diameter of ø6 mm)

: 1.5 mm and 2.0 mm (for max parting diameters of ø12 mm, ø16 mm, ø20 mm)

Threading pitch range : 0.2 - 1.5 mm

Hose connection to the tool holder refer to page 52



## When using with the DirectTungJet system for small lathe

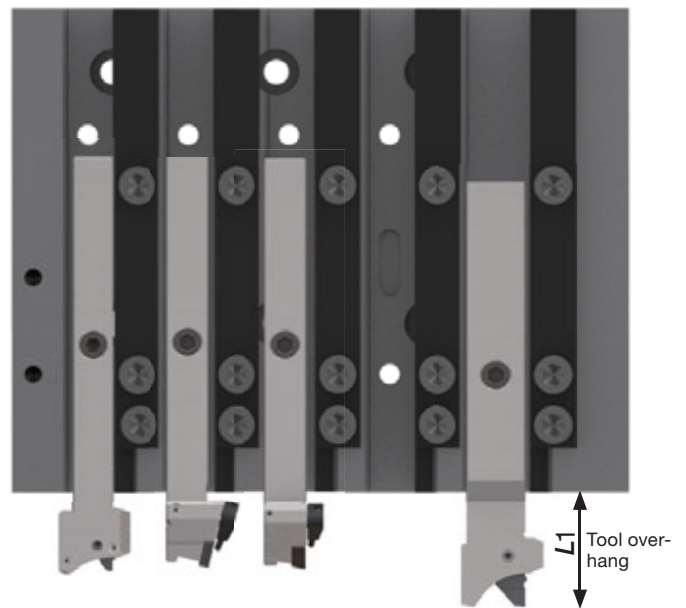
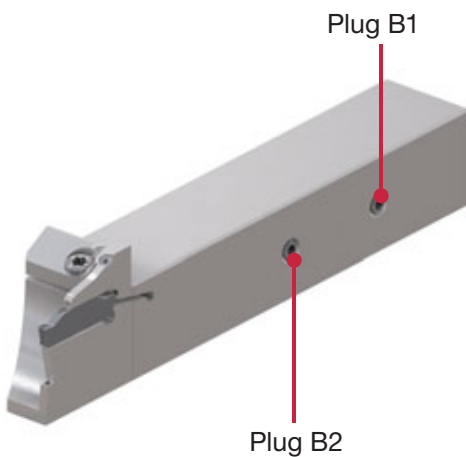
- Adjust the tool overhang length as specified in Table 1 below.
- Remove the plug as specified in Table 1 below when using with the directl coolant system.

**Table 1**

Machine model	Tool settings for a 20 x 20 mm square shank <sup>(1)</sup>		Tool settings for a 16 x 16 mm square shank <sup>(1)</sup>		Tool settings for a 12 x 12 mm square shank	
	Overhang L1 (mm)	Coolant plug to remove	Overhang L1 (mm)	Coolant plug to remove	Overhang L1 (mm)	Coolant plug to remove
CINCOM L20	-	-	30	B1	20 <sup>(2)</sup>	B1
CINCOM D25	25	B1	25	B1	-	-

(1): 20 x 20 mm and 16 x 16 mm square shanks of DuoJustCut and TungCut have both Plug B1 and Plug B2 on the shank body. Others have only Plug B1.

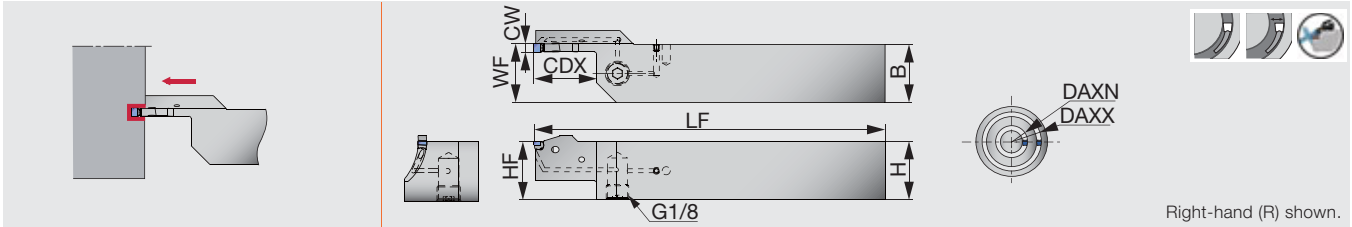
(2): The overhang length for the 12 x 12 mm TungCut shank should be 30 mm. (used in Tool Post #1 only)



## ETFR-CHP

Tube connection

Toolholders for face grooving & turning with channels for high-pressure coolant



Designation	CW	DAXN	DAXX	CDX	H	B	LF	HF	WF	Insert
ETFR2525-4T15-030035-CHP	4	30	35	15	25	25	150	25	25.5	E**4
ETFR2525-4T22-035045-CHP	4	35	45	22	25	25	150	25	25.5	E**4
ETFR2525-4T25-045055-CHP	4	45	55	25	25	25	150	25	25.5	E**4
ETFR2525-4T25-055075-CHP	4	55	75	25	25	25	150	25	25.5	E**4
ETFR2525-4T25-075120-CHP	4	75	120	25	25	25	150	25	25.5	E**4
ETFR2525-4T25-120200-CHP	4	120	200	25	25	25	150	25	25.5	E**4
ETFR2525-4T25-200500-CHP	4	200	500	25	25	25	150	25	25.5	E**4

## SPARE PARTS



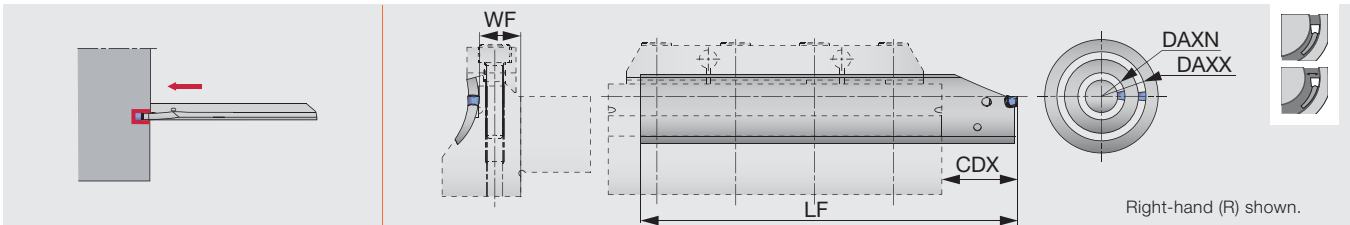
Designation	Wrench*
ETFR...-CHP	ECW-456EF

\*Optional parts

Hose connection to the tool holder refer to page 52

## EFPR/L

Adjustable blade for face grooving



Designation	CW	DAXN	DAXX	WF	LF	Min.CDX	Max.CDX	Insert
EFPR/L-4-030035	4	30.0	35.0	13.6	125.0	18	50	E**4
EFPR-4-035045	4	35.0	45.0	13.6	125.0	18	50	E**4
EFPR-4-045055	4	45.0	55.0	13.6	125.0	18	50	E**4
EFPR-4-055075	4	55.0	75.0	13.6	125.0	18	50	E**4
EFPR-4-075120	4	75.0	120.0	13.6	140.0	18	65	E**4
EFPR-4-120200	4	120.0	200.0	13.6	140.0	18	65	E**4
EFPR-4-200500	4	200.0	500.0	13.6	140.0	18	65	E**4
EFPR-5-035045	5	35.0	45.0	13.6	125.0	19	50	ETX5
EFPR-5-045055	5	45.0	55.0	13.6	125.0	19	50	ETX5
EFPR-5-055075	5	55.0	75.0	13.6	125.0	19	50	ETX5
EFPR-5-075120	5	75.0	120.0	13.6	140.0	19	65	ETX5
EFPR-5-120200	5	120.0	200.0	13.6	140.0	19	65	ETX5
EFPR-5-200500	5	200.0	500.0	13.6	140.0	19	65	ETX5
EFPR-6-045055	6	45.0	55.0	13.6	125.0	20	50	ETX6
EFPR-6-055075	6	55.0	75.0	13.6	125.0	20	50	ETX6
EFPR-6-075120	6	75.0	120.0	13.6	140.0	20	65	ETX6
EFPR-6-120200	6	120.0	200.0	13.6	140.0	20	65	ETX6
EFPR/L-6-200500	6	200.0	500.0	13.6	140.0	20	65	ETX6

### SPARE PARTS

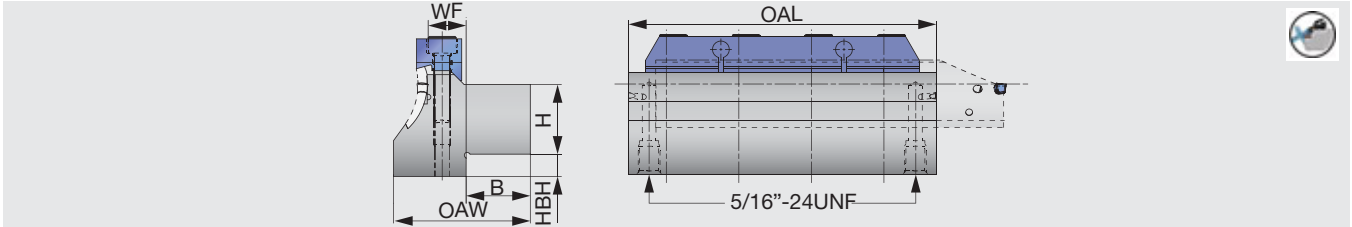


Designation	Wrench*
EFPR/L...	ECW-456I

\*Optional parts

## CTBU-CHP for EFPR/L

Tool block for EasyMulti-Cut face blade series with channels for high-pressure coolant



Designation	CW	DAXN	H	B	HBH	OAW	OAL	Blade
CTBU25-030-4-CHP	4	30.0	25.0	23.0	8	26.0	110.0	EFPR/L-4-030035
CTBU25-035-4/5-CHP	4, 5	35.0	25.0	23.0	8	26.0	110.0	EFPR/L-4/5-035045
CTBU25-045-4/5-CHP	4, 5	45.0	25.0	23.0	8	26.0	110.0	EFPR/L-4/5-045055
CTBU25-055-4/5-CHP	4, 5	55.0	25.0	23.0	8	24.0	110.0	EFPR/L-4/5-055075
CTBU25-075-4/5-CHP	4, 5	75.0	25.0	23.0	8	22.0	110.0	EFPR/L-4/5-075120
CTBU25-120-4/5-CHP	4, 5	120.0	25.0	23.0	8	21.0	110.0	EFPR/L-4/5-120200
CTBU25-200-4/5-CHP	4, 5	200.0	25.0	23.0	8	18.5	110.0	EFPR/L-4/5-200500
CTBU25-045-6-CHP	6	45.0	25.0	23.0	8	28.0	110.0	EFPR/L-6-045055
CTBU25-055-6-CHP	6	55.0	25.0	23.0	8	26.0	110.0	EFPR/L-6-055075
CTBU25-075-6-CHP	6	75.0	25.0	23.0	8	24.0	110.0	EFPR/L-6-075120
CTBU25-120-6-CHP	6	120.0	25.0	23.0	8	23.0	110.0	EFPR/L-6-120200
CTBU25-200-6-CHP	6	200.0	25.0	23.0	8	20.5	110.0	EFPR/L-6-200500

### SPARE PARTS



Designation	Clamping screw	Clamp	Wrench
CTBU...-CHP	CM6X30-S	CT-110	P-5

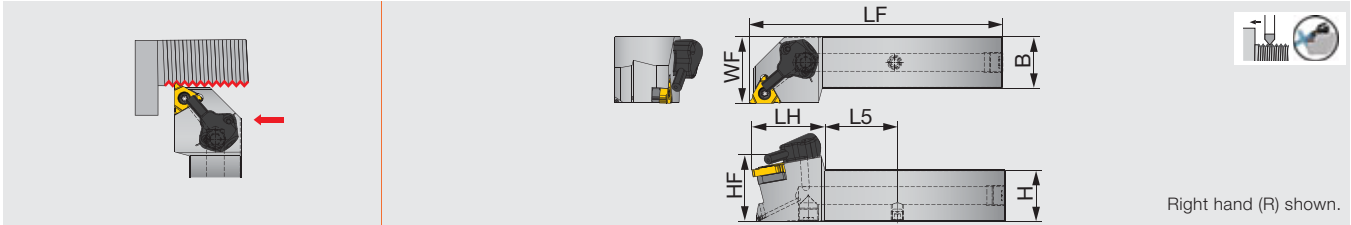
**New**

## SER-X-CHP-MC

Direct connection

Tube connection

Screw-on external threading toolholders-High-pressure coolant capability with tube and direct connection



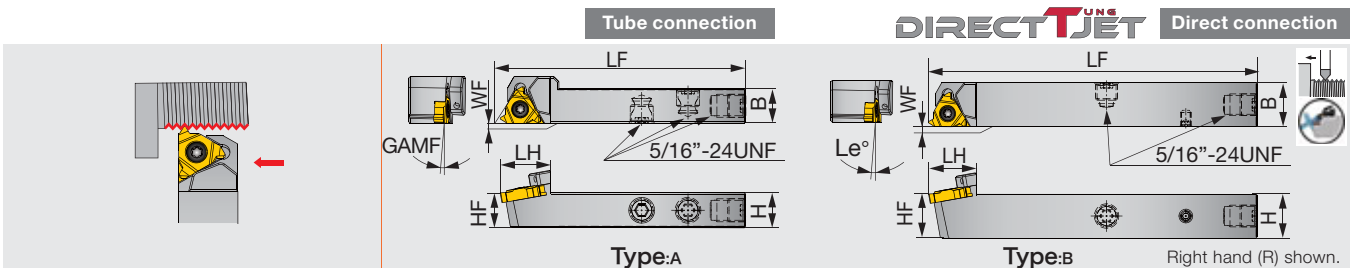
Designation	H	B	LF	LH	HF	WF	L5	Insert
SER2020X16-CHP-MC	20	20	107	36	20	32	27.9	16ER...
SER2525X16-CHP-MC	25	25	122	36	25	32	33.75	16ER...
SER2525X22-CHP-MC	25	25	122	36	25	32	33.75	16ER...

### SPARE PARTS

Designation	Clamping screw	Wrench	Shim screw	Shim	Coolant unit	Coolant plug	Wrench
SER**X16-CHP-MC	CSTB-3.5ST	T-15F	DTS5-3.5	A16-1DT	CU-V-CHP	PLUGG1/8-6.5TL360	P-3.5
SER**X22-CHP-MC	CSTB-4ST	T-15F	DTS6-4	GX22-1DT	CU-CW-CHP	PLUGG1/8-6.5TL360	P-4

## JSE2R16-CHP

Screw-on external threading toolholders-High-pressure coolant capability with tube and direct connection



Designation	H	B	LF	LH	HF	WF	GAMF	Type	Insert
JSE2R1212F16-CHP *	12	12	85	19	12	0	1°	A	16ER...
JSE2R1212X16-CHP	12	12	120	19	12	0	1°	B	16ER...
JSE2R1616X16-CHP	16	16	120	19	16	0	1°	B	16ER...





### SPARE PARTS

Designation	Clamping screw	Wrench	Coolant plug	Wrench
JSE2R**16-CHP	CSTB-3.5	T-15F	SR5/16UNFTL360	P-4

\* External coolant tube connection type

VDI adapters

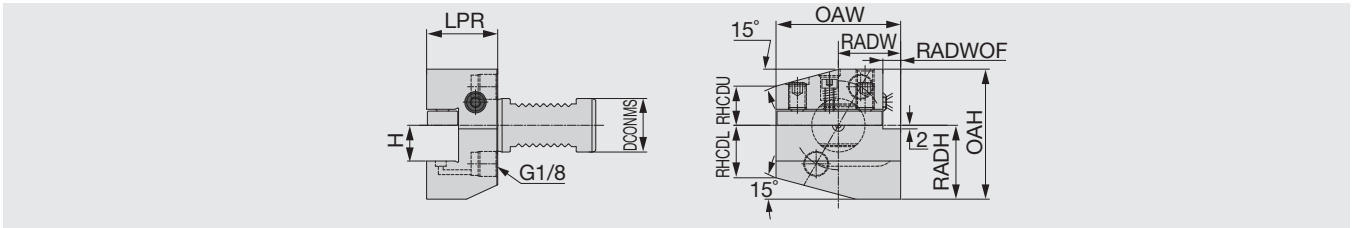
**VDI30 B1B4 A - 302040-JHPMC**

1	2	3						
<table border="1"> <tr><td>20</td></tr> <tr><td>25</td></tr> <tr><td>30</td></tr> <tr><td>40</td></tr> </table>	20	25	30	40	<p><b>2</b>  <b>B1B4</b>                      : Radial toolholder                      : for Left hand tool holder</p> 	<p><b>3</b>  <b>C1C4</b>                      : Axial toolholder                      : for Right hand tool holder</p> 	<p><b>3</b>  <b>A type</b>                      Clamping screw on top, parallel clamping</p> 	<p><b>3</b>  <b>AK type</b>                      Clamping screw on side, Wedge clamping</p> 
20								
25								
30								
40								
	<p><b>B2B3</b>                      : Radial toolholder                      : for Right hand tool holder</p>	<p><b>C2C3</b>                      : Axial toolholder                      : for Left hand tool holder</p>						

# VDI & PSC Adapter

## VDI\*\*B1B4A-JHPMC

VDI adapter for square shank tool holder, with hose-free direct coolant supply

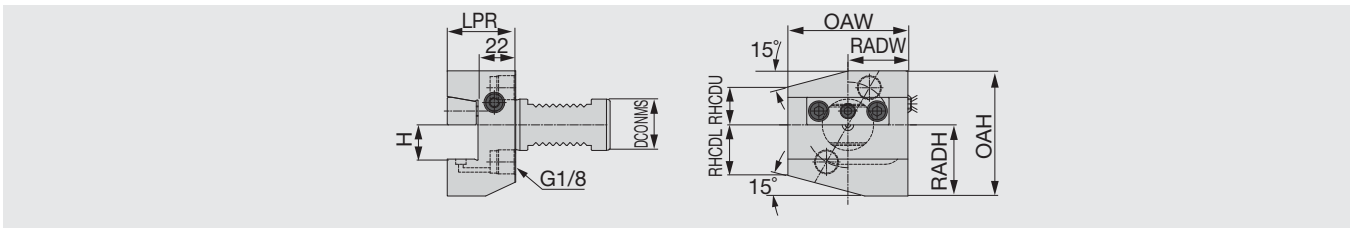


Designation	DCONMS	H	LPR	OAW	RADW	RADWOF	RHCDC	RHCDU	RADH	OAH
VDI20B1A-201640-JHPMC	20	16	40	55	30	7	19	19	30	55
VDI20B4A-201640-JHPMC	20	16	40	55	30	7	19	19	30	55
VDI25B1A-252040-JHPMC	25	20	40	70	35	10	29.5	22	38.5	70
VDI30B1B4A-302040-JHPMC	30	20	40	70	35	10	29.5	22	41.5	73
VDI40B1B4A-402544-JHPMC	40	25	44	85	42.5	12.5	35	30	48	86

Applicable for 8 MPa pressure coolant

## VDI\*\*B1B4AK-JHPMC

VDI adapter for square shank tool holder, with hose-free direct coolant supply

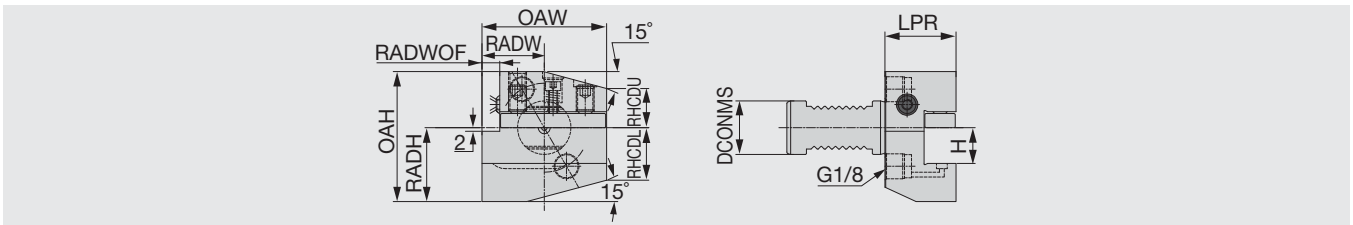


Designation	DCONMS	H	LPR	OAW	RADW	RHCDC	RHCDU	RADH	OAH
VDI30B1B4AK-302040-JHPMC	30	20	40	70	35	29.5	22	41.5	73
VDI40B1B4AK-402544-JHPMC	40	25	44	85	42.5	35	30	48	86

Applicable for 8 MPa pressure coolant

## VDI\*\*B2B3A-JHPMC

VDI adapter for square shank tool holder, with hose-free direct coolant supply

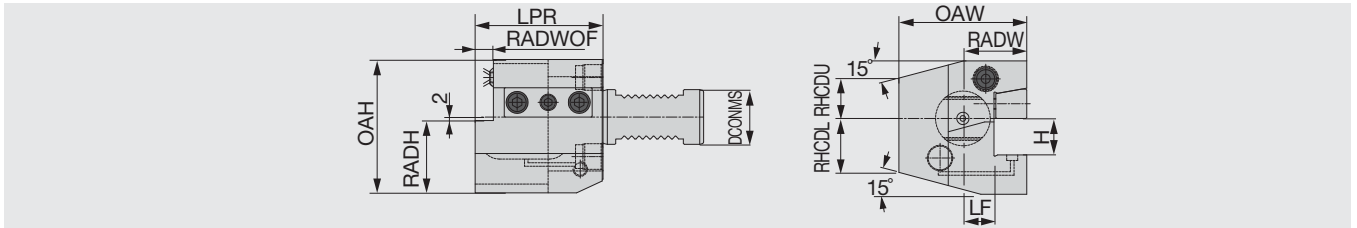


Designation	DCONMS	H	LPR	OAW	RADW	RADWOF	RHCDC	RHCDU	RADH	OAH
VDI20B2A-201640-JHPMC	20	16	40	55	30	7	19	19	30	55
VDI20B3A-201640-JHPMC	20	16	40	55	30	7	19	19	30	55
VDI25B2A-252040-JHPMC	25	20	40	70	35	10	29.5	22	38.5	70
VDI30B2B3A-302040-JHPMC	30	20	40	70	35	10	29.5	27	41.5	73
VDI40B2B3A-402544-JHPMC	40	25	44	85	42.5	12.5	35	30	48	86

Applicable for 8 MPa pressure coolant

## VDI\*\*C1C4A-JHPMC

VDI adapter for square shank tool holder, with hose-free direct coolant supply

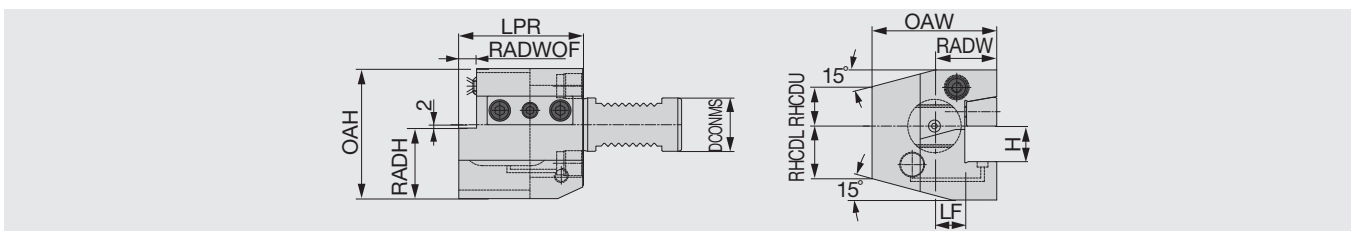


Designation	DCONMS	H	LPR	OAW	RADW	LF	RADWOF	RHCDCD	RHCDCU	RADH	OAH
VDI25C1C4A-252055-JHPMC	25	20	55	58	33	13	7	26	28	36	66
VDI30C1C4A-302070-JHPMC	30	20	70	70	35	17	10	26	22	38	70
VDI40C1C4A-402585-JHPMC	40	25	85	85	42.5	21	12.5	35	30	48	86

Applicable for 8 MPa pressure coolant

## VDI\*\*C1C4AK-JHPMC

VDI adapter for square shank tool holder, with hose-free direct coolant supply



Designation	DCONMS	H	LPR	OAW	RADW	LF	RADWOF	RHCDCD	RHCDCU	RADH	OAH
VDI30C1C4AK-302070-JHPMC	30	20	70	70	35	17	10	26	22	38	70
VDI40C1C4AK-402585-JHPMC	40	25	85	85	42.5	21	12.5	35	30	48	86

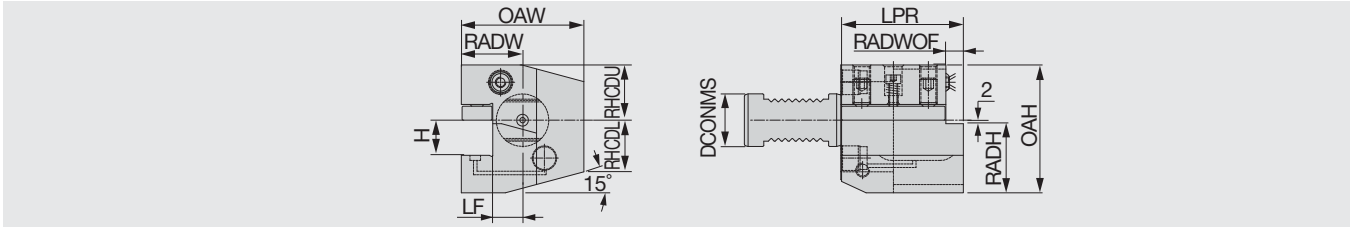
Applicable for 8 MPa pressure coolant



# VDI & PSC Adapter

## VDI\*\*C2C3A-JHPMC

VDI adapter for square shank tool holder, with hose-free direct coolant supply

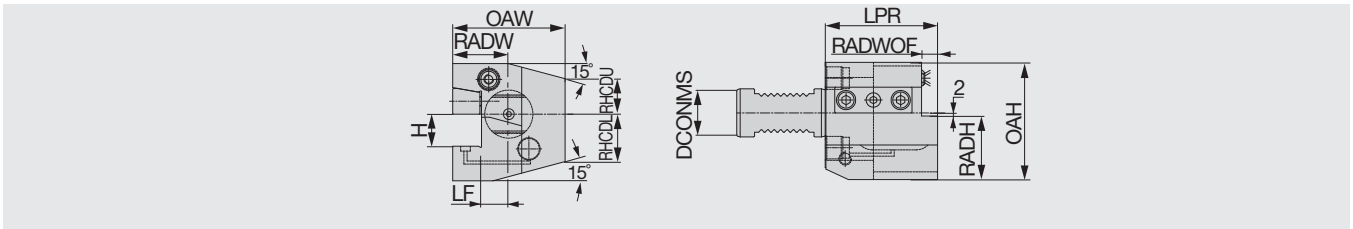


Designation	DCONMS	H	LPR	OAW	RADW	LF	RADWOF	RHC DL	RHC DU	RADH	OAH
VDI25C2C3A-252055-JHPMC	25	20	55	52	37	15	7	38	38	36	66
VDI30C2C3A-302070-JHPMC	30	20	70	76	41	17	10	26	26	38	70
VDI40C2C3A-402585-JHPMC	40	25	85	90	47.5	21	12.5	35	30	48	86

Applicable for 8 MPa pressure coolant

## VDI\*\*C2C3AK-JHPMC

VDI adapter for square shank tool holder, with hose-free direct coolant supply



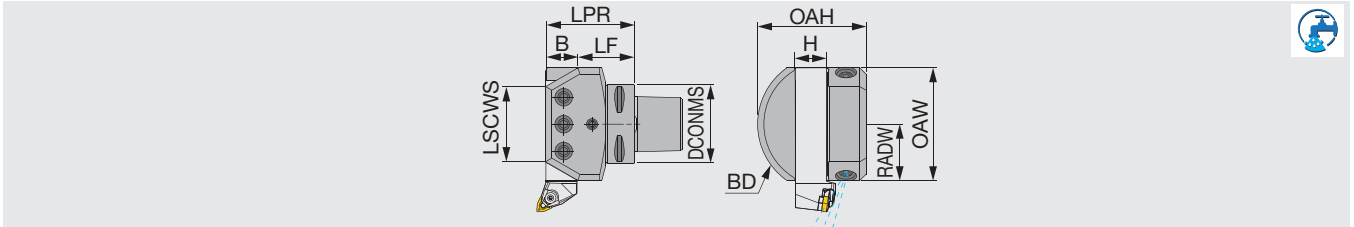
Designation	DCONMS	H	LPR	OAW	RADW	LF	RADWOF	RHC DL	RHC DU	RADH	OAH
VDI30C2C3AK-302070-JHPMC	30	20	70	76	41	17	10	26	22	38	70
VDI40C2C3AK-402585-JHPMC	40	25	85	90	47.5	21	12.5	35	30	48	86

Applicable for 8 MPa pressure coolant

## C\*ASHA-HPMC

**TUNGCAP**

PSC adapter for square shank tool holder, with hose-free direct coolant supply

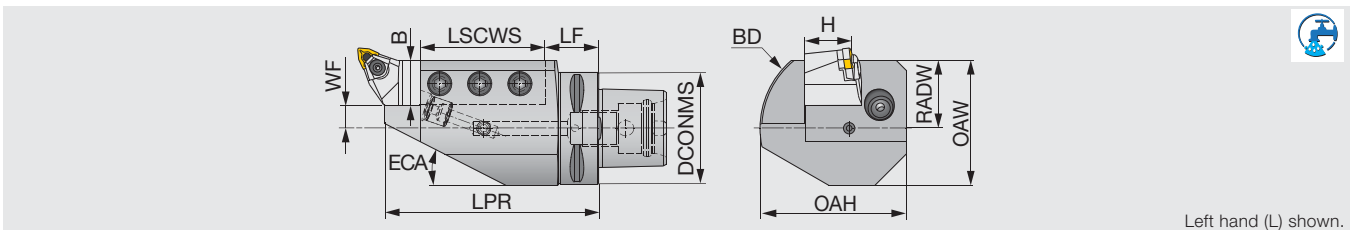


Designation	DCONMS	H	B	LPR	LSCWS	LF	RADW	OAW	OAH	BD
C6ASHA25-HPMC	63	25	25	71	61	46	45	90	86.6	110

## C\*ASHR/L-HPMC

**TUNGCAP**

PSC adapter for square shank tool holder, with hose-free direct coolant supply

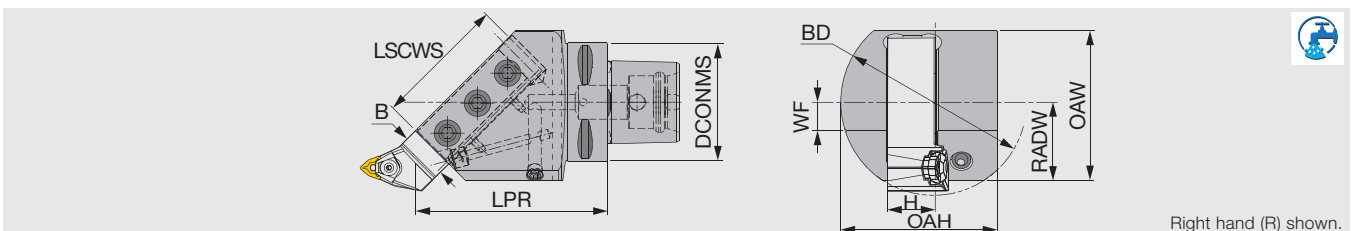


Designation	DCONMS	LPR	LSCWS	LF	WF	H	B	OAH	RADW	OAW	BD	ECA
C6ASHR251-J-HPMC	63	120	82	38	4.5	25	25	76.5	29.5	61	90	27
C6ASHL251-HPMC	63	120	70	30	13	25	25	82	38	70	100	27

## C\*ASHR/L-45-HPMC

**TUNGCAP**

PSC adapter for square shank tool holder, with hose-free direct coolant supply



Designation	DCONMS	H	B	LSCWS	LPR	OAH	RADW	OAW	WF	BD
C6ASHR/L25-45-HPMC	63	25	25	70	102	83	41.6	79.6	15	100

## CONNECTION OF TOOLHOLDER AND COOLANT HOSE

- Toolholder in the size of over 20 mm: Hose on the bottom of the head
- Toolholder in the size of less than 16 mm: Hose on the back, front, or back end side

### For general lathes (P-type)

Designation	PCLN... / PDJN... / PTGN... / PV*N... / PWLN...	ACLN... / AWLN... / ADJLN...
Shank size	Over 20 mm	Over 20 mm
Example of connection		
Washer	CHP-COPPER-SEAL1/8	CHP-COPPER-SEAL1/8
Connector	CHP-NIPPLE-G1/8-7/16UNF	CHP-NIPPLE-G1/8-7/16UNF
Hose	CHP-HOSE-G1/8-7/16-200BS <sup>(1)</sup>	CHP-HOSE-G1/8-7/16-200BS <sup>(1)</sup>
	CHP-HOSE-G1/8-7/16-250BS <sup>(1)</sup>	CHP-HOSE-G1/8-7/16-250BS <sup>(1)</sup>
	CHP-HOSE-5/16-7/16-200BS <sup>(2)</sup>	CHP-HOSE-5/16-7/16-200BS <sup>(2)</sup>

Thread size of hose for machine: <sup>(1)</sup>G1/8" -28 BSPP, <sup>(2)</sup>5/16" -24UNF

### For small lathes (J-type)

Designation	JSDJ2X... / JSWL2X... / JSVJ2X... / JSDJ2C... / JSVJ2B...		
Shank size	≤ 16 mm		
Connection	Back	Front	Back end
Example of connection			
Connector for toolholder	CHP-CONECTOR5/16-G1/8	-	-
Hose	CHP-HOSE-G1/8-7/16-200BS <sup>(3)</sup>	CHP-HOSE-5/16-7/16-200BS <sup>(3)</sup>	CHP-HOSE-5/16-7/16-200BS <sup>(3)</sup>
	CHP-HOSE-G1/8-7/16-250BS <sup>(3)</sup>	-	-
	CHP-HOSE-G1/8-G1/8-200BB <sup>(4)</sup>	-	-
	CHP-HOSE-G1/8-G1/8-250BB <sup>(4)</sup>	-	-
Connector for machine <sup>(5)</sup>	CHP-NIPPLE-G1/8-7/16UNF	CHP-NIPPLE-G1/8-7/16UNF	CHP-NIPPLE-G1/8-7/16UNF
Washer for machine <sup>(5)</sup>	CHP-COPPER-SEAL1/8	CHP-COPPER-SEAL1/8	CHP-COPPER-SEAL1/8

(3): The tube thread type on the machine side is 7/16" -20UNF, female thread. Therefore, use both Nipple (5) and Washer (5) to connect to the machine G1/8 female thread.

(4): The thread type on the machine side is G1/8" -28 BSPP, male thread.

## PARTS FOR COOLANT HOSE

### Connecting hose

Fig. 1

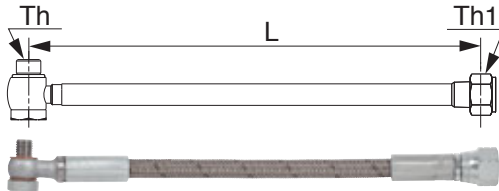
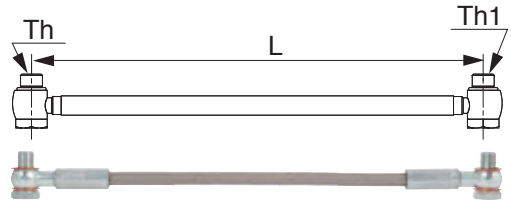
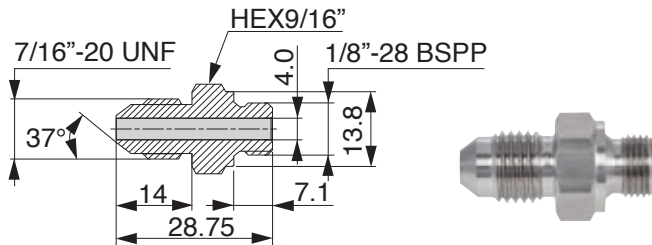


Fig. 2



Designation	Length	Threading size		Max. pressure (Mpa)	Fig.
	L	Th	Th1		
CHP-HOSE-G1/8-7/16-200BS	200	G1/8"-28 BSPP	7/16"-20 UNF	26	1
CHP-HOSE-G1/8-7/16-250BS	250	G1/8"-28 BSPP	7/16"-20 UNF	26	1
CHP-HOSE-5/16-7/16-200BS	200	5/16"-24UNF	7/16"-20 UNF	20	1
CHP-HOSE-5/16-G1/8-200BS	200	5/16"-24UNF	G1/8"-28 BSPP	20	1
CHP-HOSE-G1/8-G1/8-200BB	200	G1/8"-28 BSPP	G1/8"-28 BSPP	26	2
CHP-HOSE-G1/8-G1/8-250BB	250	G1/8"-28 BSPP	G1/8"-28 BSPP	26	2

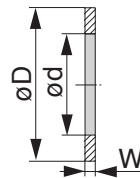
### Connector



**Designation**

CHP-NIPPLE-G1/8-7/16UNF

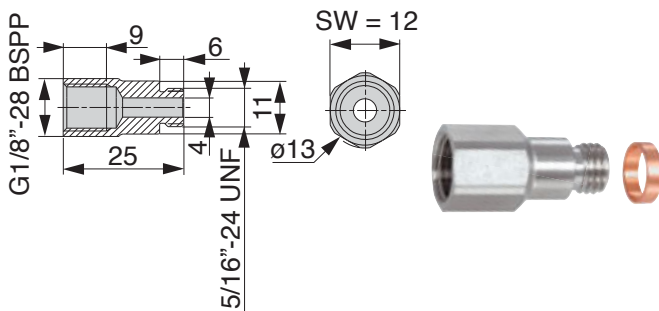
### Seal washer



**Designation**

Designation	øD	ød	W
CHP-COPPER-SEAL1/8	15	8	1
CHP-COPPER-SEAL5/16	11	8	1
CHP-COPPER-SEAL5/16-2.5	11	8	2.5

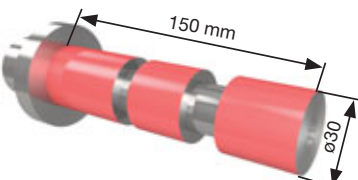
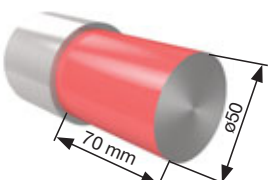
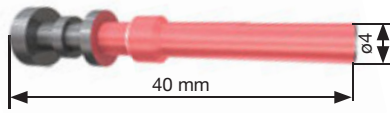

### Connector for small lathe with seal washer



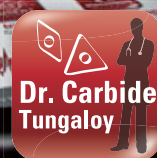
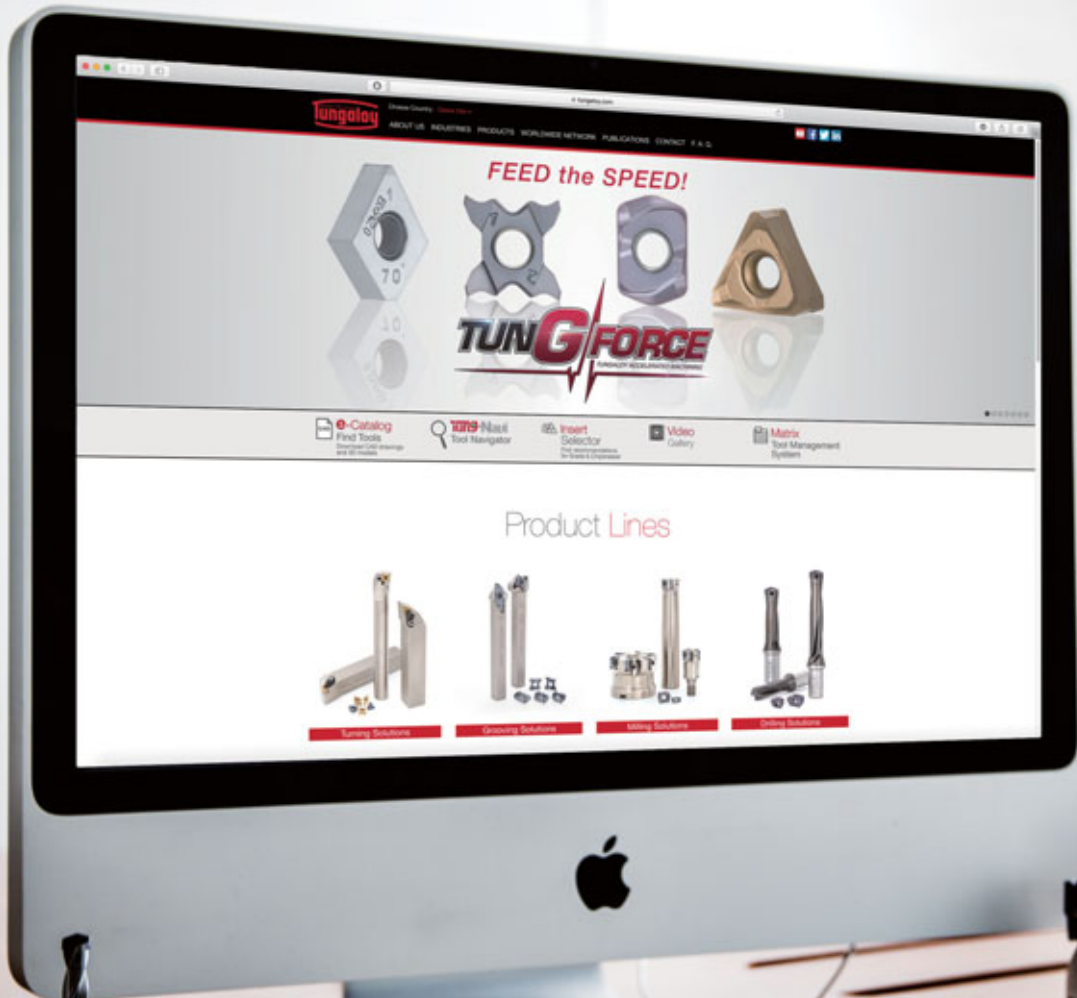
**Designation**

CHP-CONECTOR/5/16-G1/8

## PRACTICAL EXAMPLES

Workpiece type		Valve parts	Tube parts
Toolholder		PDJNR2525M15-CHP	PCLNR2525M12-CHP
Insert		DNMG150408-HRM	CNMG120408-HRM
Grade		AH8015	AH8015
Workpiece material		INCONEL 718	Ti-6AL-4V
Cutting conditions			
Cutting speed : Vc(m/min)		80	60
Feed : f (mm/rev)		0.3	0.2
Depth of cut : ap (mm)		2	2
Machining		External turning	External turning
Coolant		Wet	Wet
Results		 <p><b>Tool life 1.3 times longer</b></p> <p>Due to cooling effect of high pressure coolant, tool life is 1.3 times longer than machining with normal pressure coolant.</p>	 <p><b>Tool life 3 times longer</b></p> <p>Due to its high pressure coolant system, TungTurn-Jet provides excellent chip control and tool life is 3 times longer than machining with normal pressure coolant.</p>
Workpiece type		Shaft	Shaft stator
Toolholder		JSDJ2CR1616X11-CHP	STCR2525-27-CHP
Insert		DCGT11T302FN-JS	TCS27-200-020
Grade		SH725	AH725
Workpiece material		X5CrNi18-9	42CrMo4
Cutting conditions			
Cutting speed : Vc(m/min)		92	180
Feed : f (mm/rev)		1.5	0.12
Depth of cut : ap (mm)		300	2
Machining		External turning	External grooving
Coolant		Wet	Wet
Results		 <p><b>Tool life 1.5 times longer</b></p> <p>Due to its high pressure coolant system, TungTurn-Jet provides excellent chip control and tool life is 1.5 times longer than machining with normal pressure coolant.</p>	 <p><b>Tool life 3 times longer</b></p> <p>Due to cooling effect of high pressure coolant, tool life is 3 times longer than machining with normal pressure coolant.</p>

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