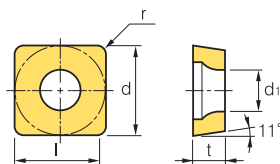


B Turning Insert (Positive)

SP

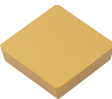
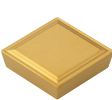


Square 90° Positive
Relief Angle: 11°



Dimensions (mm)			
Size	d	t	d ₁
06	6.35	2.38	2.8
07	7.94	2.38	-
09	9.525	3.18	3.4
12	12.7	4.76	-
15	15.875	4.76	-
19	19.05	4.76	-

Workpiece																			Machining types
	Steel	P	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	
Stainless steel	M	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●
Cast iron	K	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●
Non-ferrous metal	N	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●
Heat resistant alloy, Titanium alloy	S	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●
Hardened steel	H	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●

Inserts	Designation	Cermet			Coated		Coated												Uncoated		Cutting Condition						
		CN1500	CN2000	CN2500	CC1500	CC2500	NC3215	NC3120	NC3225	NC3030	NC5330	NC6310	NC6315	NC9115	NC9125	NC9135	PC5300	PC5400	PC8105	PC8110	PC8115	PC9030	H01	H05	fn (mm/rev)	ap (mm)	
Medium to finishing		SPGA 060204																								0.50~0.25	0.50~2.00
		090308T	●	●																						0.10~0.25	0.70~3.00
		090308T-Z		●																						0.10~0.25	0.70~3.00
		(Z = Special Nega land)																									
Medium to finishing		SPGN 070202																								0.03~0.10	0.50~2.00
		070208																								0.10~0.25	0.70~3.00
		090302																								0.03~0.10	0.50~3.00
		090304																								0.08~0.20	0.70~3.50
		090308																								0.10~0.25	0.70~3.50
		120302																								0.03~0.20	0.50~3.00
		120304																								0.08~0.20	1.00~5.00
		120308									●															0.10~0.25	1.00~5.00
		120312																								0.15~0.30	1.00~5.00
		120316																								0.18~0.33	1.00~5.00
		120402																								0.03~0.20	0.50~3.00
		120404																								0.08~0.20	1.00~5.00
		120408																								0.10~0.25	1.00~5.00
		120412																								0.15~0.30	1.00~5.00
		120416																								0.18~0.33	1.00~5.00
		120430																								0.20~0.60	2.00~5.00
		120440																								0.25~0.70	3.00~5.00
		150404																								0.08~0.20	1.50~7.00
		150408																								0.10~0.25	1.50~7.00
		150412																								0.15~0.30	1.50~7.00
		150416																								0.18~0.33	1.50~7.00
		150420																								0.20~0.45	1.50~7.00
		190404																								0.08~0.20	1.50~9.00
		190408																								0.10~0.25	1.50~9.00
		190412																								0.15~0.45	1.50~9.00
		190416																								0.18~0.60	1.50~9.00
		190424																								0.25~0.70	2.50~9.00
Finishing		SPGR 090304-F																								0.05~0.20	0.30~2.00
		120304-F																							0.10~0.25	0.50~2.00	

➤ Cutting edge geometry A52~A61

➤ Recommended chip breaker B04~B11

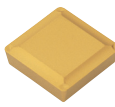
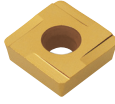
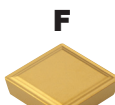
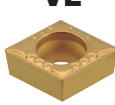
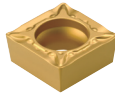
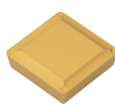
➤ Code system B26~B27

● : Stock item

Available tool holders			
Designation	Page	Designation	Page
CSDPN	B169	SSKPR/L	B208
CSKPR/L	B170		



Dimensions (mm)			
Size	d	t	d ₁
09	9.525	3.18	3.4~4.4
12	12.7	3.18	-
15	15.875	4.76	-
19	19.05	4.76	-
25	25.4	6.35	-

Inserts		Designation		Cermet			Coated		Coated																Uncoated		Cutting Condition	
				CN1500	CN2000	CN2500	CC1500	CC2500	NC3215	NC3120	NC3225	NC3030	NC5330	NC6310	NC6315	NC9115	NC9125	NC9135	PC5300	PC5400	PC8105	PC8110	PC8115	PC9030	H01	H05	fn (mm/rev)	ap (mm)
Medium cutting		SPGR	090308-M																							0.10~0.40	1.00~3.50	
			120308-M																							0.20~0.40	1.50~4.00	
Medium to finishing		SPGT	090304R																							0.08~0.23	0.30~3.00	
			090308R																							0.10~0.30	0.50~3.00	
			090304L		●																					0.08~0.23	0.30~3.00	
			090308L																							0.10~0.30	0.50~3.00	
Finishing		SPMR	090304-F																							0.05~0.20	0.30~2.00	
			120304-F							●	●															0.10~0.25	0.50~2.00	
Finishing		SPMT	09T304-VL																							0.04~0.18	0.20~1.40	
			09T308-VL																							0.08~0.22	0.20~1.40	
Finishing		SPMT	090304-VF																							0.05~0.20	0.30~1.50	
			090308-VF																							0.10~0.25	0.30~1.50	
Medium cutting		SPMR	090308-M							●	●															0.10~0.40	1.00~3.50	
			120308-M							●	●															0.10~0.40	1.50~4.00	
			120312-M								●															0.20~0.40	1.50~4.00	
Medium to finishing		SPUN	120304																							0.10~0.30	1.00~5.00	
			120308																							0.15~0.40	1.00~5.00	
			120308SN																							0.15~0.40	1.00~5.00	
			150412																							0.20~0.50	1.00~5.00	
			190412								●															0.20~0.50	1.50~7.00	
			190416																							0.25~0.60	2.00~7.00	
			250620																							0.30~0.80	3.00~10.0	

● : Stock item

Available tool holders			
Designation	Page	Designation	Page
CSDPN	B169	SSKPR/L	B208
CSKPR/L	B170		