GrooveLine

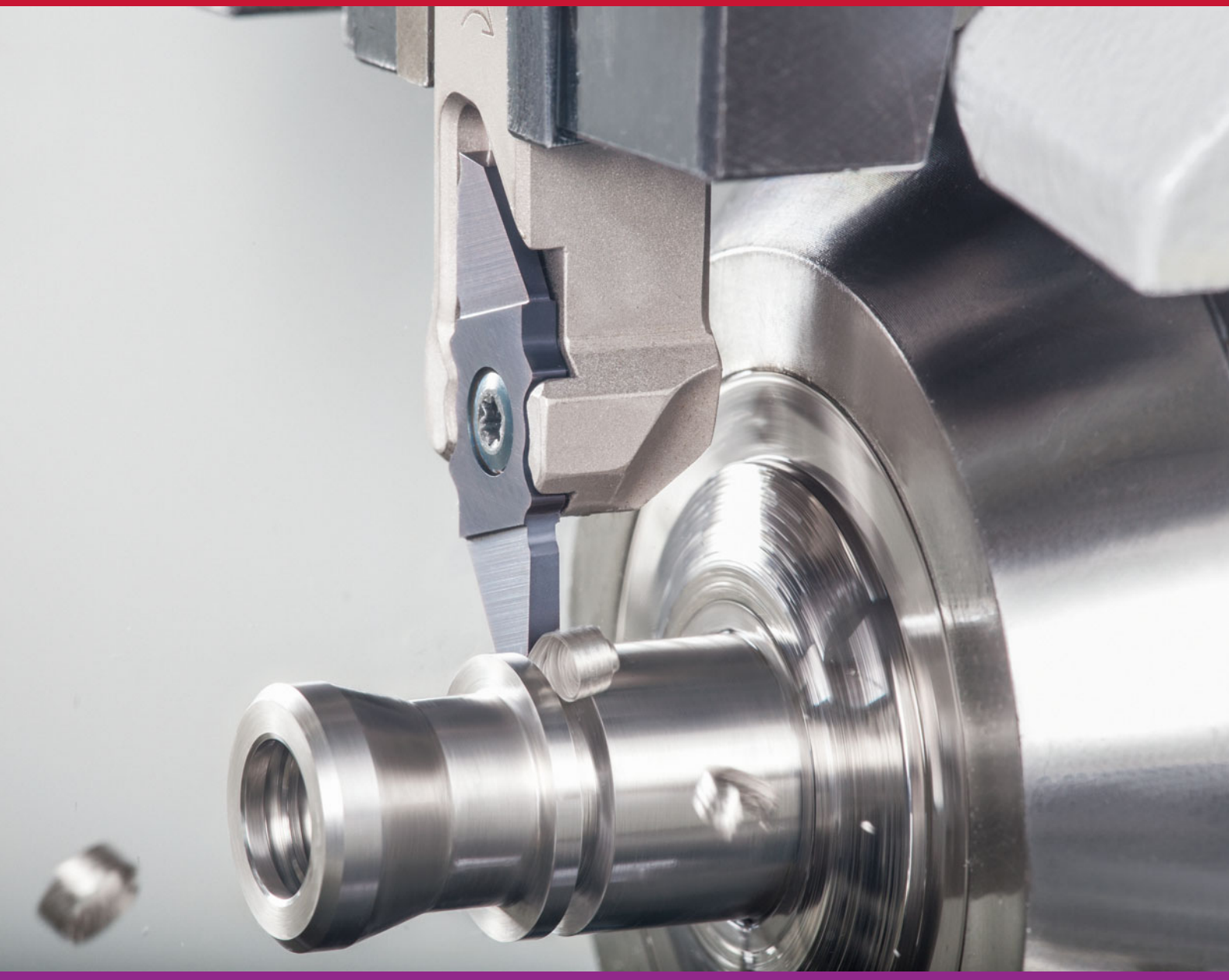
DUOJUST CUT

www.tungaloy.com

Tungaloy Report No. 504-G

Member IMC Group Tungaloy

Brand New 25mm square shank holders
for grooving & parting-off operations



INDUSTRY 4.0

FEED the SPEED!


ACCELERATED MACHINING

GrooveLine

DUOJCUT UST

TUNGALOY

TUNGROOVE FORCE

ACCELERATED MACHINING

New

Double-sided inserts, **perfect for parting-off small parts up to 20 mm diameter,** as well as general grooving.

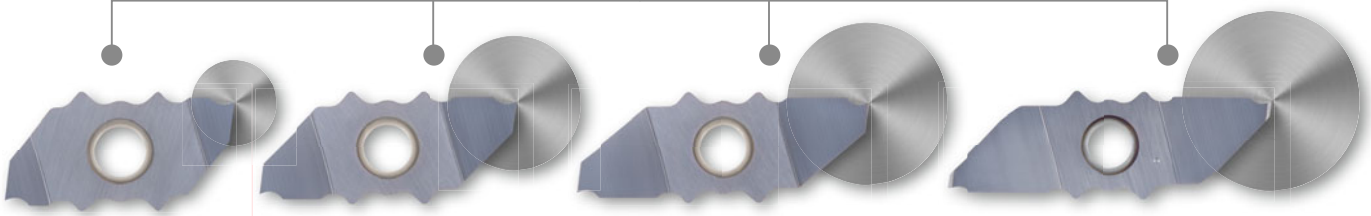
Innovative clamping system ensures stability in **parting-off operations**

4 types of inserts are available for various parting-off diameters and can be mounted **in the same pocket of the toolholder.**

- Optimized overhang length for **stable machining**

Regular-type toolholder

Toolholder for sub-spindle



JXPG06
Max. parting-off dia.
ø6 mm

JXPG12
Max. parting-off dia.
ø12 mm

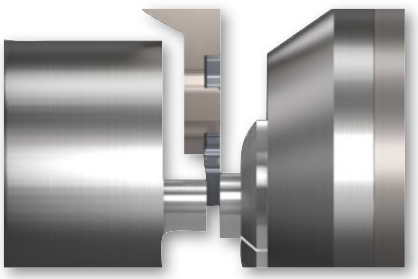
JXPG16
Max. parting-off dia.
ø16 mm

JXPG20
Max. parting-off dia.
ø20 mm

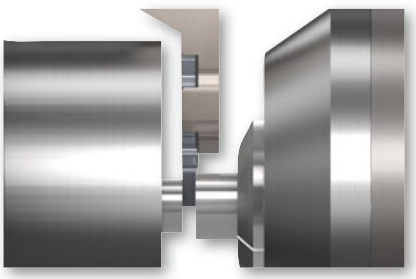
Toolholder for sub-spindle

- Perfect for parting-off a short workpiece in a narrow approach when a sub-spindle is used.

Right hand

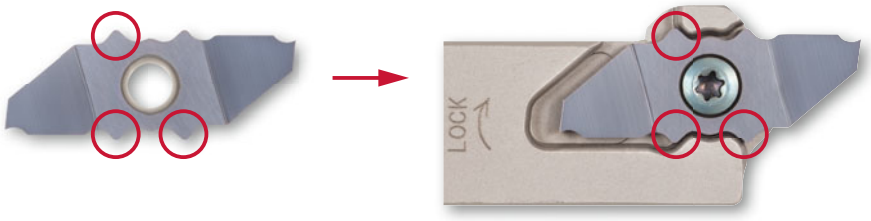


Left hand



Unique clamping system for highly rigid clamping

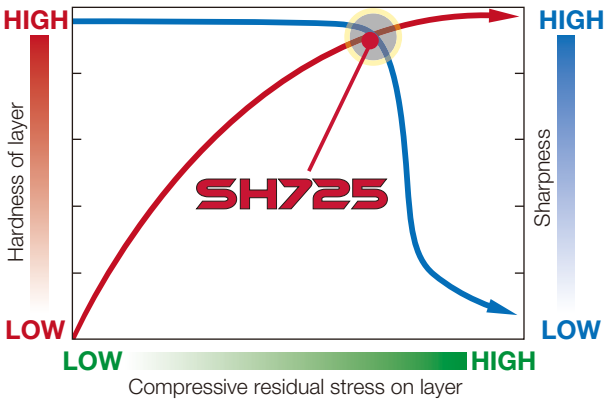
Insert is secured at 3 points



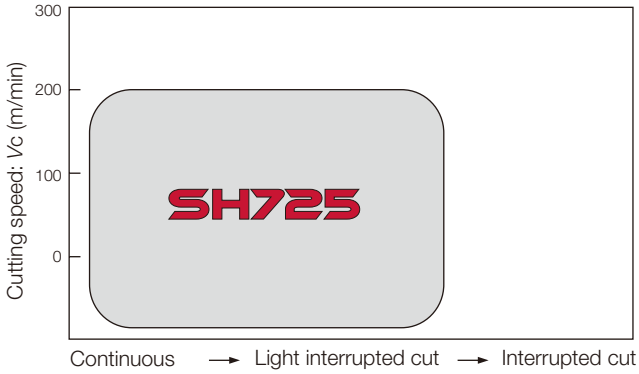
- **The unused cutting edge is always protected due to the innovative clamping system.**
- Even if the first cutting edge is chipped, the other unused cutting edge can be used because the insert is clamped in the center.

SH725, new PVD grade for small lathes

- **PVD grade designed for precision part machining**
- Good balance between hardness and sharpness
- High adhesion strength



Application Range



Delivers stable machining on small lathes

DUOJUST CUT
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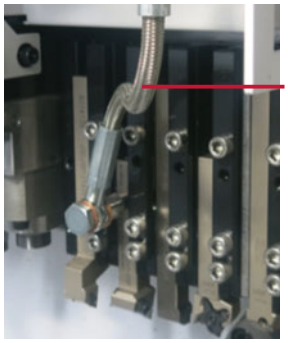
DIRECT TUNG JET system

Tube-less design streamlines tool setup
Through-coolant supply enables high productivity

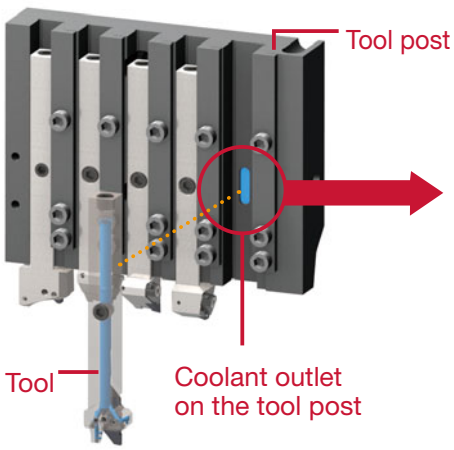
External coolant tube

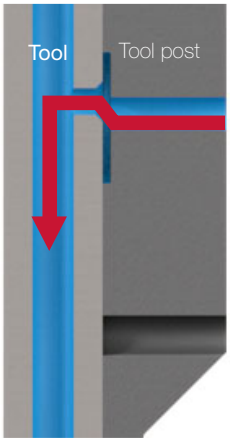


DirectTungJet system

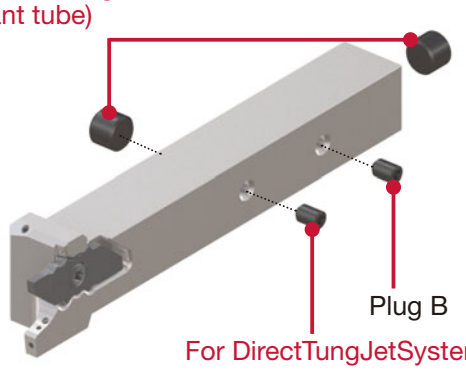
No need for coolant tube setup.
Eliminates chip entanglement on tubes and streamlines tool replacements.

Coolant is supplied from the tool post directly to the tools





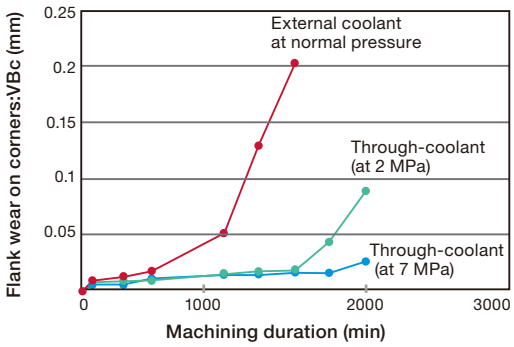
Plug A
(for connecting an external coolant tube)

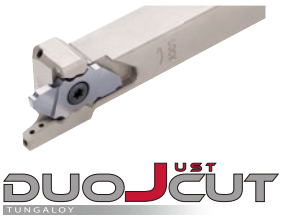


Use a non-coolant-through tool when coolant supply is not needed through the tool.

Tool Wear reduction with TungTurn-Jet

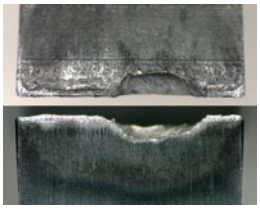
M Stainless steel: Parting-off (SUS304)



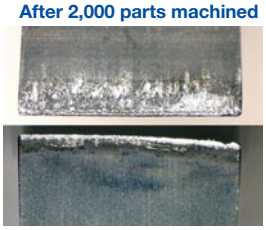


Material : SUS304
Holder : JSXXL1212X09-CHP
Insert : JXPG16L20F SH725
Cutting speed : Vc = 100 m/min^{-1}
Feed rate : f = 0.03 mm/rev
Coolant type : Oil

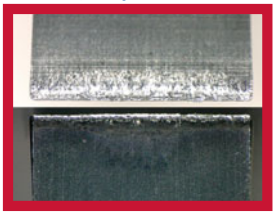
External coolant at normal pressure
After 1,500 parts machined



Through-coolant (at 2 MPa)
After 2,000 parts machined

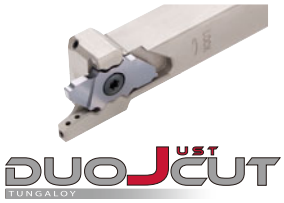


Through-coolant (at 7 MPa)
After 2,000 parts machined



Improvement of chip evacuation with TungTurn-Jet

M Stainless steel: Parting-off (SUS304)

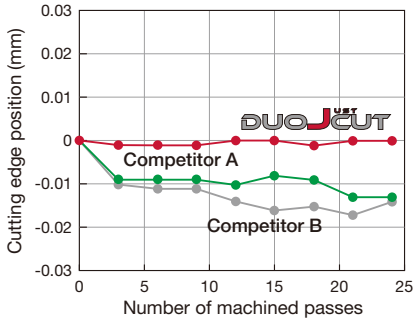


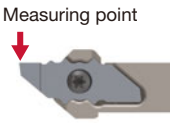
Material : SUS304
Holder : JSXXL1212X09-CHP
Insert : JXPG16L20F SH725
Rotation : Vc = 100 m/min
Feed rate : f = 0.03 mm/rev
Cooant type : Oil

TUNGTJET Through-coolant supply (at 7 MPa)	TUNGTJET Through-coolant supply (at 1.5 MPa)	External coolant at normal pressure
		

CUTTING PERFORMANCE

Cutting edge positions during machining



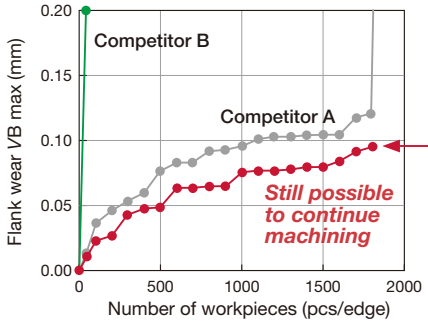


Process: Measure 1 → machining → Measure 2
Displacement of cutting edge position = Difference between Measure 1 & 2

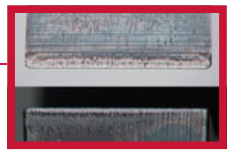
Toolholder	: JSXXL1212F09-S
Insert	: JXPG16L20F / SH725
Workpiece material	: S45C / C45, 170HB
Cutting speed	: *Vc* = 100 m/min
Feed	: *f* = 0.06 mm/rev
Groove width	: CW = 2.0 mm
Machining	: Parting-off (ø16)
Coolant	: Wet
Machine	: Swiss lathe

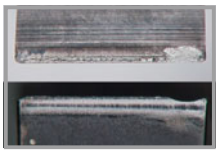
DuoJust-Cut's 3–point clamping system is highly rigid, delivering stable machining with small displacement of the cutting edge position.

Tool life of regular-type toolholder: Carbon steel



DUOJUST CUT
SH725
1,800 pcs





Competitor A
1,800 pcs

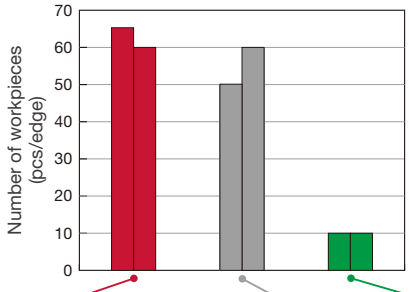
Competitor B
10 pcs

P

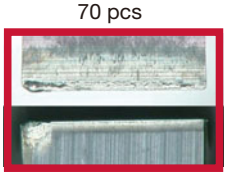
Toolholder	: JSXXL1212X09
Insert	: JXPG16L20F / SH725
Workpiece material	: S45C / C45, 210HB
Cutting speed	: *Vc* = 150 m/min
Feed	: *f* = 0.06 mm/rev (≤ ø2: 0.01 mm/rev)
Groove width	: CW = 2 mm
Machining	: Parting-off (ø16)
Coolant	: Wet
Machine	: Swiss lathe

DuoJust-Cut extends tool life and reduces flank wear during steel machining due to improved clamping rigidity and wear resistance.

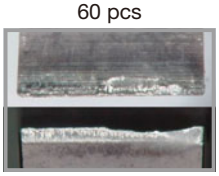
Tool life of regular-type toolholder: Stainless steel



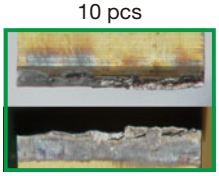
DUOJUST CUT
SH725
70 pcs



Competitor A
60 pcs



Competitor B
10 pcs



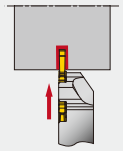
M

Toolholder	: JSXXL1212X09
Insert	: JXPG16L20F / SH725
Workpiece material	: SUS303 / X10CrNiS18-9, 230HB
Cutting speed	: *Vc* = 120 m/min
Feed	: *f* = 0.04 mm/rev (≤ ø2: 0.01 mm/rev)
Groove width	: CW = 2.0 mm
Machining	: Parting-off (ø16)
Coolant	: Wet
Machine	: Swiss lathe

Tool life of DuoJust-Cut in stainless steel machining is longer than the competitors.

JSXXR/L

Parting-off and grooving tools



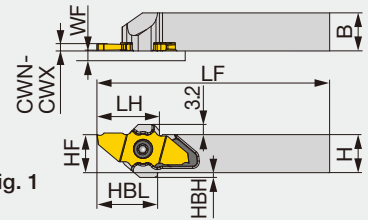


Fig. 1

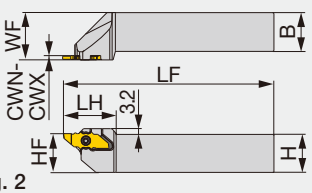


Fig. 2

Right-hand (R) shown.

Designation	CWN	CWX	H	B	LF*	LH**	HF	WF	HBL**	HBH	Insert	Torque*	Fig.
JSXXR/L1010X09	1	2	10	10	120	19.65	10	0.2	19	3	JX*G06...,12...,16...,20...	1.2	1
JSXXR/L1212F09	1	2	12	12	85	19.65	12	0.2	19	1.5	JX*G06...,12...,16...,20...	1.2	1
JSXXR/L1212X09	1	2	12	12	120	19.65	12	0.2	19	1.5	JX*G06...,12...,16...,20...	1.2	1
JSXXR/L1616X09	1	2	16	16	120	19.65	16	0.2	-	-	JX*G06...,12...,16...,20...	1.2	1
JSXXR/L2020H09	1	2	20	20	100	22.5	20	0.2	-	-	JX*G06...,12...,16...,20...	1.2	1
New JSXXR/L2525Z09	1	2	25	25	135	34	25	30	-	-	JX*G06...,12...,16...,20...	1.2	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...).

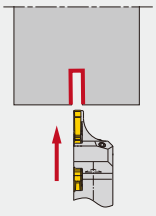
SPARE PARTS

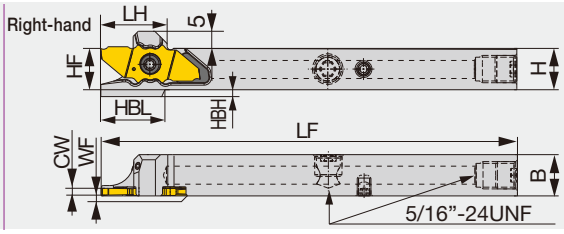

Designation	Clamping screw	Wrench
JSXXR...	CSTC-4L100DL	T-1008/5
JSXXL...	CSTC-4L100DR	T-1008/5

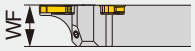
JSXXR/L-X-CHP

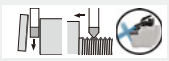
DIRECT TJET

Parting-off tool for swiss lathes for DirectTungJet system









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	-	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



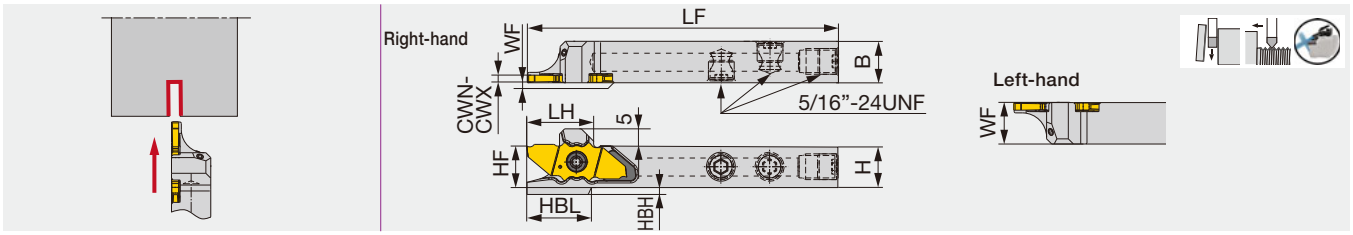



Designation	Clamping screw	Wrench	Coolant plug	Wrench	DirectTungJet plug	Wrench
JSXXR...	CSTC-4L100DL	T-1008/5	SR5/16UNFTL360	P-4	SSHM4-6-TB	P-2
JSXXL...	CSTC-4L100DR	T-1008/5	SR5/16UNFTL360	P-4	SSHM4-6-TB	P-2

Parting-off widths : 1.0 mm and 1.5 mm (for a max parting diameter of ø6 mm)
: 1.5 mm and 2.0 mm (for max parting diameters of ø12 mm, ø16 mm and ø20 mm)
Threading pitch range : 0.2 - 1.5 mm

JSXXR/L-F-CHP

Parting-off tool for swiss lathes



Designation	CWN	CWX	H	B	LF**	LH**	HF	WF	HBL**	HBH	Insert	Torque*
JSXXR/L1212F09-CHP	1	2	12	12	85	≤ 19.4	12	0.2/11.8	-	2	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

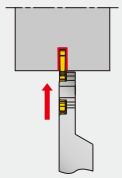
Designation	Clamping screw	Wrench	Coolant plug	Wrench
JSXXR...	CSTC-4L100DL	T-1008/5	SR5/16UNFTL360	P-4
JSXXL...	CSTC-4L100DR	T-1008/5	SR5/16UNFTL360	P-4

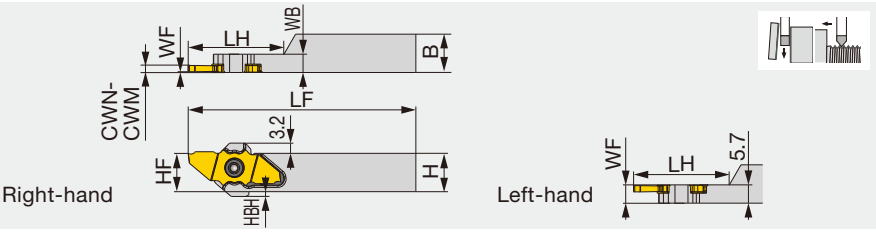
Parting-off widths : 1.0 mm and 1.5 mm (for a max parting diameter of ø6 mm)
: 1.5 mm and 2.0 mm (for max parting diameters of ø12 mm, ø16 mm and ø20 mm)

Threading pitch range : 0.2 ~ 1.5 mm

JSXXR/L-S

Parting-off tool for sub spindle in swiss lathes





Designation	CWN	CWM	H	B	LF*	LH*	HF	WF	HBH	Insert	Torque*
JSXXR/L1010X09-S	1	2	10	10	120	26	10	0.2/5.5	3	JXPG06...,12...,16...	1.2
JSXXR/L1212F09-S	1	2	12	12	85	26	12	0.2/5.5	1.5	JXPG06...,12...,16...	1.2
JSXXR/L1212X09-S	1	2	12	12	120	30	12	0.2/5.5	1.5	JXPG06...,12...,16...	1.2
JSXXR/L1616X09-S	1	2	16	16	120	30	16	0.2/5.5	-	JX*G06...,12...,16...,20...	1.2

*Torque: Recommended torque (N·m) for clamping
**LF (Functional Length) and LH (Head Length) values shown above are true with JXPG16... insert. LF and LH will be 2 mm shorter than the above values with JX*G12... insert, and 4 mm shorter for JXPG06... insert. LF, LH, and HBL will all be 2 mm shorter with JXPG20... insert.
***JXPG20... insert will not fit.
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...).

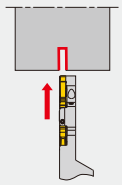
SPARE PARTS

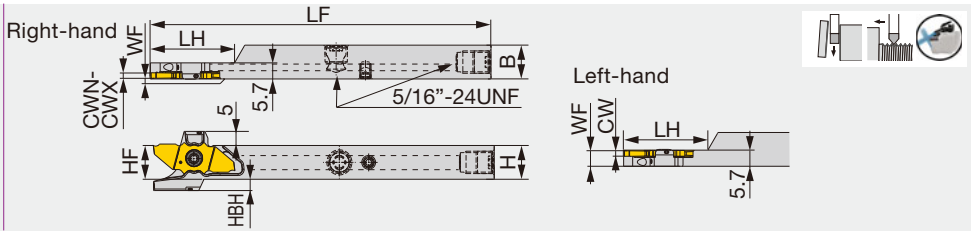
Designation	Clamping screw	Wrench
JSXXR***-S	CSTC-4L055DL	T-1008/5
JSXXL***-S	CSTC-4L055DR	T-1008/5

JSXXR/L-X-S-CHP

DIRECT TUNG JET

Parting-off tool for sub spindle in swiss lathes and DirectTungJet system





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

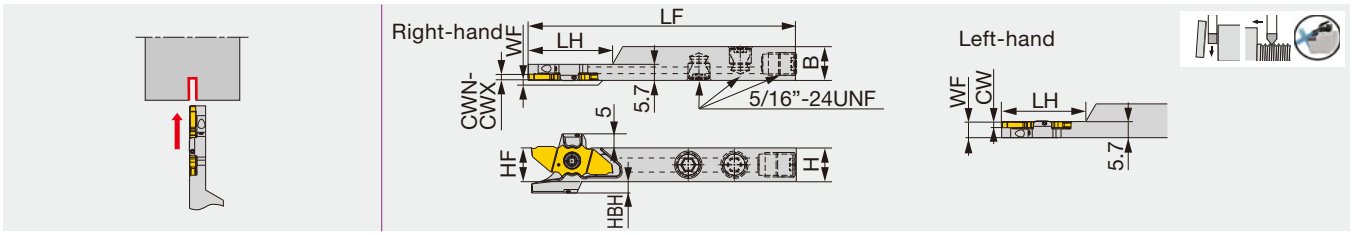
SPARE PARTS

Designation	Clamping screw	Wrench	Coolant plug	Wrench	DirectTungJet plug	Wrench
JSXXR***-S-CHP	CSTC-4L055DL	T-1008/5	SR5/16UNFTL360	P-4	SSHM4-6-TB	P-2
JSXXL***-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 and ø20 mm)

JSXXR/L-F-S-CHP

Parting-off tool for sub spindle in swiss lathes



Designation	CWN	CWX	H	B	LF**	LH**	HF	WF	HBH	Insert	Torque*
JSXXR/L1212F09-S-CHP***	1	2	12	12	85	26	12	0.2/5.5	4	JX*G06...,12...,16..., 20...	1.2
JSXXR/L1212F09B-S-CHP	1	2	12	12	85	30	12	0.2/5.5	2	JX*G06...,12...,16..., 20...	1.2

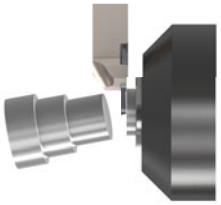
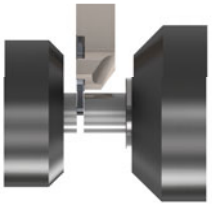
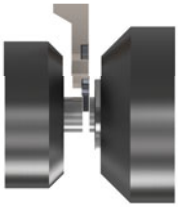
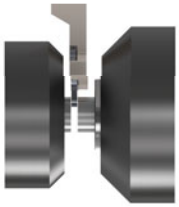
*Torque: Recommended torque (N·m) for clamping
**LF (Overall Tool Length) and LH (Head Length) values shown above are true with JXPG16... insert. Both LF and LH will be 2 mm shorter than the above value with JX*G12... and JXPG20... inserts; 4 mm shorter with JXPG06... insert.
***To be replaced with the 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

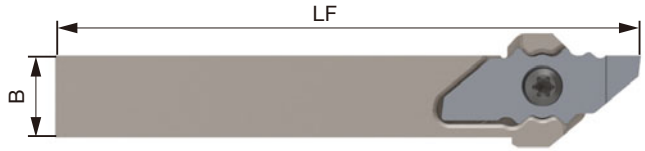
Designation	Clamping screw	Wrench	Coolant plug	Wrench
JSXXR***-S-CHP	CSTC-4L055DL	T-1008/5	SR5/16UNFTL360	P-4
JSXXL***-S-CHP	CSTC-4L055DR	T-1008/5	SR5/16UNFTL360	P-4

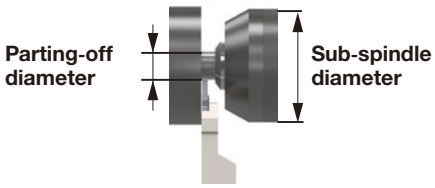
Parting-off widths : 1.0 mm and 1.5 mm (for a max parting diameter of ø6 mm)
: 1.5 mm and 2.0 mm (for max parting diameters of ø12 mm, ø16 mm and ø20 mm)

HOW TO SELECT TOOLS

	Large-diameter machining of workpiece with rigidity		Small-diameter machining of workpiece with short overhang	
	Main-spindle tooling	Sub-spindle tooling	Sub-spindle tooling	
			Workpiece with long overhang at the side of sub-spindle for the process after parting-off	Short workpiece with low rigidity
Application	 Main spindle	 Sub-spindle Main spindle	 Sub-spindle Main spindle	 Sub-spindle Main spindle
	Position of parting-off is at the side of the main spindle	Position of parting-off is at the side of the sub-spindle	Position of parting-off is at the side of the main spindle	Position of parting-off is at the side of the sub-spindle
Toolholder	R-hand (JSXXR type)	L-hand (JSXXL type)	R-hand (JSXXR-S type)	L-hand (JSXXL-S type)
Insert	Right-hand insert with lead angle to remove center core (JXPG**R***-15 type)	Left-hand insert (JXPG**L*** type)	Right-hand insert (JXPG**R*** type)	Left-hand insert (JXPG**L*** type)

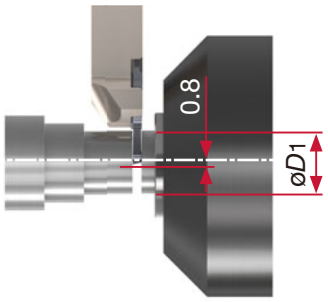
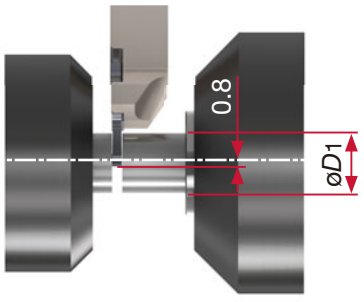
HOW TO SELECT TOOLHOLDERS FOR SUB-SPINDLE





Sub-spindle dia.	Parting-off dia.	B	LF	Insert	Toolholder
ø40	~ ø6	10	116	JXPG06*	JSXXR/L1010X09-S
ø40	~ ø6	12	81	JXPG06*	JSXXR/L1212F09-S
ø40	~ ø12	10	118	JXPG12*	JSXXR/L1010X09-S
ø40	~ ø12	12	83	JXPG12*	JSXXR/L1212F09-S
ø40	~ ø16	10	120	JXPG16*	JSXXR/L1010X09-S
ø40	~ ø16	12	85	JXPG16*	JSXXR/L1212F09-S
ø40	~ ø20	12	87	JXPG20*	JSXXR/L1212F09B-S-CHP
ø50	~ ø6	12	116	JXPG06*	JSXXR/L1212X09-S
ø50	~ ø6	16	116	JXPG06*	JSXXR/L1616X09-S
ø50	~ ø12	12	118	JXPG12*	JSXXR/L1212X09-S
ø50	~ ø12	16	118	JXPG12*	JSXXR/L1616X09-S
ø50	~ ø16	12	85	JXPG16*	JSXXR/L1212F09-S
ø50	~ ø16	12	120	JXPG16*	JSXXR/L1212X09-S
ø50	~ ø16	16	120	JXPG16*	JSXXR/L1616X09-S
ø50	~ ø20	12	87	JXPG20*	JSXXR/L1212F09B-S-CHP
ø50	~ ø20	12	122	JXPG20*	JSXXR/L1212X09B-S-CHP
ø50	~ ø20	16	122	JXPG20*	JSXXR/L1616X09-S

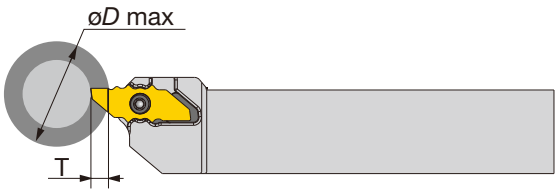
MAX. PARTING-OFF DIA. & DEPTH

Main-spindle tooling	Sub-spindle tooling
 Main spindle	 Sub-spindle Main spindle

There will be no tool-workpiece interference when parting off the workpiece with the cutting edge position apart from the workpiece center by 8 mm or more.

Maximum grooving depths (T) in relation to workpiece diameters (ø*D* max) without interference

Maximum grooving depth (T) is limited relative to workpiece diameter (ø*D* max) to avoid interference between workpiece and insert.

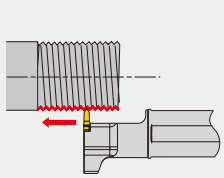


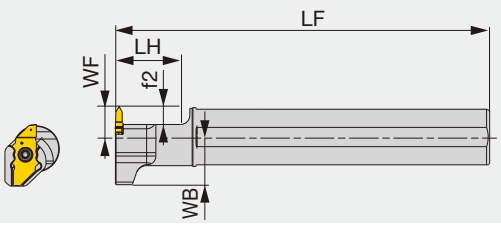
Grooving depths (T) and workpiece diameters (ø*D* max) for each insert

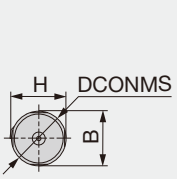
Designation	T≤1.0	T≤2.0	T≤2.5	T≤3.0	T≤3.5	T≤4.0	T≤5.0	T≤5.5	T≤6.0	T≤6.5	T≤7.0	T≤7.5	T≤8.0	T≤8.5	T≤9.0	T≤9.5	T≤10.0	T≤10.5
JXPG06...	∞	∞	200	60	30	-	-	-	-	-	-	-	-	-	-	-	-	-
JXPG12...	∞	∞	∞	∞	∞	∞	∞	100	60	35	-	-	-	-	-	-	-	-
JXPG16...	∞	∞	∞	∞	∞	∞	∞	∞	∞	∞	200	90	50	25	-	-	-	-
JXPG20...	∞	∞	∞	∞	∞	∞	∞	∞	∞	∞	∞	∞	∞	∞	200	80	50	25

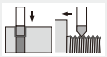
JS-SXXL09

Round shanks, for threading









Designation	DCONMS	H	B	LF	LH	WB	WF	f2	Insert	Torque*
JS19G-SXXL09	19.05	18	18	90	21	15.43	10	6	JX*G06,12*R	1.2
JS19X-SXXL09	19.05	18	18	120	21	15.43	10	6	JX*G06,12*R	1.2
JS20G-SXXL09	20	19	19	90	21	15.4	10	6	JX*G06,12*R	1.2
JS20X-SXXL09	20	19	19	120	21	15.4	10	6	JX*G06,12*R	1.2
JS22X-SXXL09	22	21	21	120	21	15.4	10	6	JX*G06,12*R	1.2
JS25H-SXXL09	25	24	24	100	21	15.4	10	6	JX*G06,12*R	1.2
JS254X-SXXL09	25.4	24	24	120	21	15.4	10	6	JX*G06,12*R	1.2

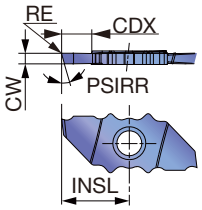
* Torque: Recommended torque (N·m) for clamping
Threading insert (JXTG12FR) and parting-off inserts (JXPG06R ,12R) fit this holder.

SPARE PARTS

Designation	Clamping screw	Wrench
JS***-SXXL09	CSTC-4L055L	T-1008/5

INSERT

JXPG**R/L-F (Sharp edge)



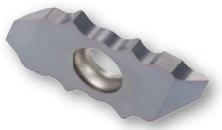
Right-hand (R) shown.

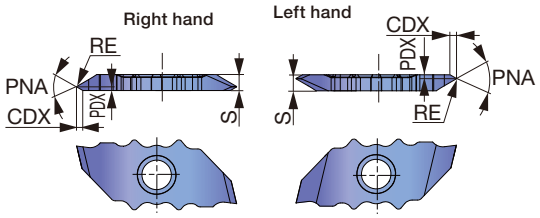
Designation	CW±0.025	RE	SH725		Dimensions (mm)			
			R	L	CUTDIA	CDX*	INSL	PSIRR/L
JXPG06R/L10F	1	0.05	●	●	6	3.5	10.5	0°
JXPG06R/L15F	1.5	0.05	●	●	6	3.5	10.5	0°
JXPG06R/L10F-15	1	0.05	●	●	6	3.5	10.5	15°
JXPG06R/L15F-15	1.5	0.05	●	●	6	3.5	10.5	15°
JXPG12R/L15F	1.5	0.05	●	●	12	6.5	12.5	0°
JXPG12R/L20F	2	0.05	●	●	12	6.5	12.5	0°
JXPG12R/L15F-15	1.5	0.05	●	●	12	6.5	12.5	15°
JXPG12R/L20F-15	2	0.05	●	●	12	6.5	12.5	15°
JXPG16R/L15F	1.5	0.05	●	●	16	8.5	14.5	0°
JXPG16R/L20F	2	0.05	●	●	16	8.5	14.5	0°
JXPG16R/L15F-15	1.5	0.05	●	●	16	8.5	14.5	15°
JXPG16R/L20F-15	2	0.05	●	●	16	8.5	14.5	15°
JXPG20R/L15F	1.5	0.05	●	●	20	10.5	16.5	0°
JXPG20R/L20F	2	0.05	●	●	20	10.5	16.5	0°
JXPG20R/L15F-15	1.5	0.05	●	●	20	10.5	16.5	15°
JXPG20R/L20F-15	2	0.05	●	●	20	10.5	16.5	15°

*Max grooving depth (CDX) varies depending on workpiece diameters.
(Refer to the table on p.14 for details)

● : Line-up
CUTDIA: Max. parting-off dia.
Packing quantity = 5 pcs.

JXTG12FR/L-60 (For Threading / Sharp edge)

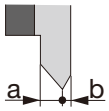
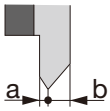
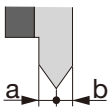
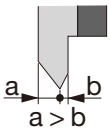
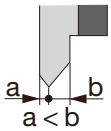
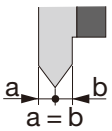




Designation	Grade SH725 R	Grade SH725 L	Dimensions (mm) Pitches	PDX	CDX	RE	S	PNA
JXTG12FR/L-60A-000	●	●	0.2 - 0.4	0.25	0.4	0.05 max flat	2.5	60°
JXTG12FR/L-60B-000	●	●	0.2 - 0.4	2.25	0.4	0.05 max flat	2.5	60°
JXTG12FR/L-60A-005	●	●	0.4 - 1	0.6	0.99	0.05	2.5	60°
JXTG12FR/L-60B-005	●	●	0.4 - 1	1.9	0.99	0.05	2.5	60°
JXTG12FR/L-60N-010	●	●	1 - 1.5	1.25	2.07	0.1	2.5	60°

● : Line-up
Packing quantity = 5 pcs.

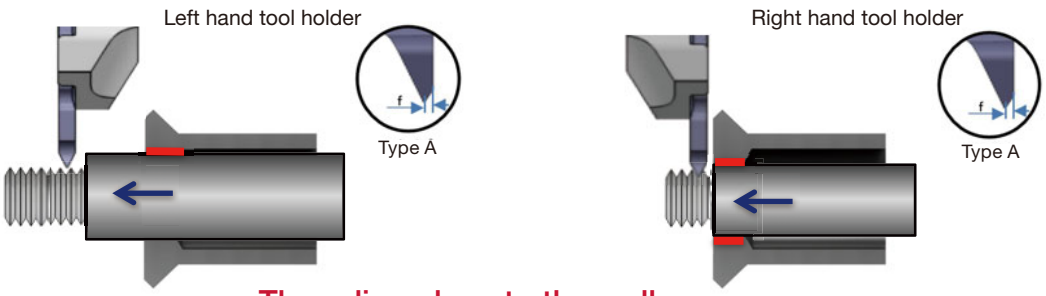
EDGE ORIENTATION AND DESCRIPTION OF THREADING INSERTS

	Type A	Type B	Type N
Right hand	 a > b	 a < b	 a = b
Left hand	 a > b	 a < b	 a = b

JXTG 12 F R - 60 A - 005

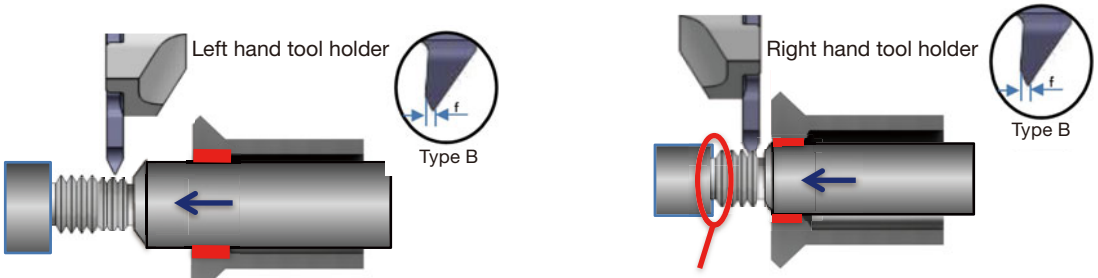
- JXTG: Insert shape
- 12: Insert size
- F: sharp edge
- R: Direction
- 60: Thread angle
- A: Edge orientation
- 005: Corner radius

WHEN TO USE TYPE A AND TYPE B INSERT



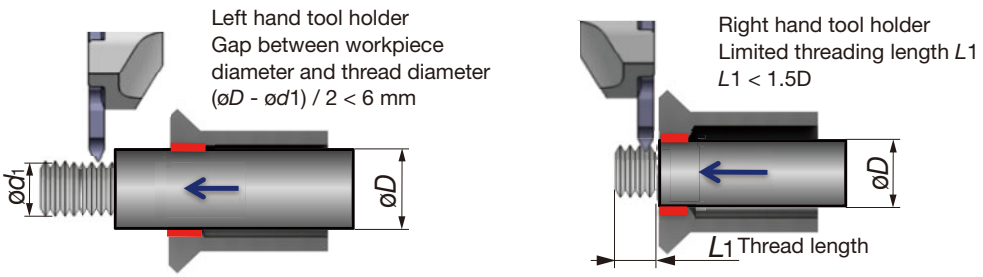
Threading close to the wall

Threading operation following back-turning

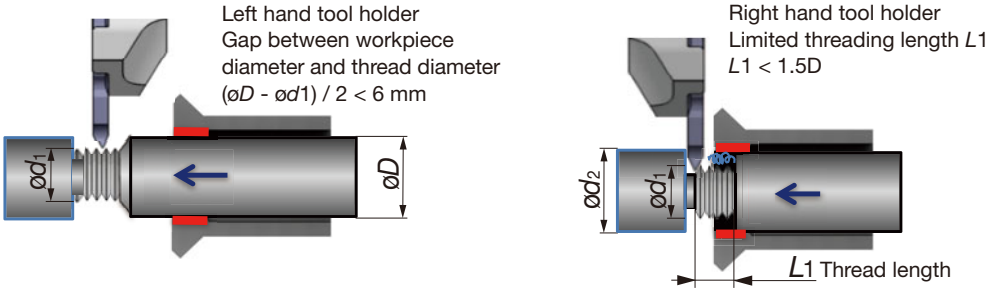


Undercutting needed in previous process

THREADING WORKPIECE IN MAIN SPINDLE



Threading operation following back-turning



STANDARD CUTTING CONDITIONS

ISO	Workpiece materials	Grades	Cutting speed *Vc* (m/min)	Feed *f* (mm/rev)
P	Low carbon steels (C15, C20, etc.)	SH725	50 - 200	0.01 - 0.05
	Carbon steels, Alloy steels (C55, 42CrMoS4, etc.)	SH725	50 - 200	0.01 - 0.05
	Free cutting steels (SUH22, SUH23, etc)	SH725	50 - 200	0.01 - 0.05
M	Stainless steels (X5CrNi18-9, X5CrNiMo17-12-2, etc)	SH725	50 - 200	0.01 - 0.05
N	Aluminium alloys (A5056, A6061, etc)	SH725	150 - 200	0.01 - 0.05
	Copper alloy (C2600, C280C, etc)	SH725	100 - 200	0.01 - 0.05
S	Titanium alloys (Ti-6Al-4V, etc.)	SH725	30 - 80	0.01 - 0.05
	Superalloys (Inconel718, etc.)	SH725	30 - 80	0.01 - 0.05

PARTS FOR INTERNAL COOLANT SUPPLY HOLDERS

Connecting hose

Fig. 1

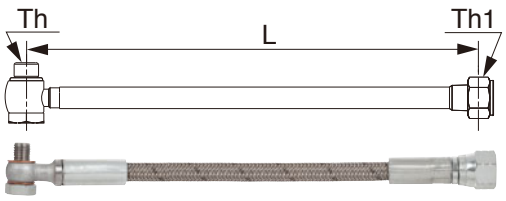
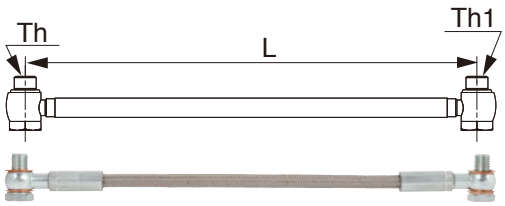
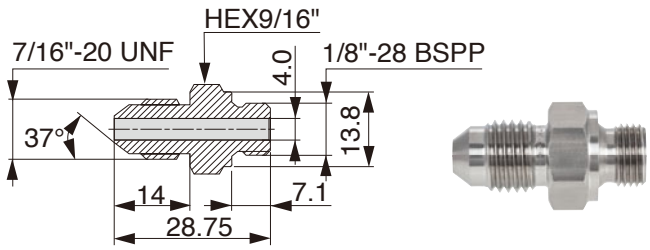


Fig. 2



Designation	Length	Threading size		Max. pressure	Fig.
	L	Th	Th1	(Mpa)	
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

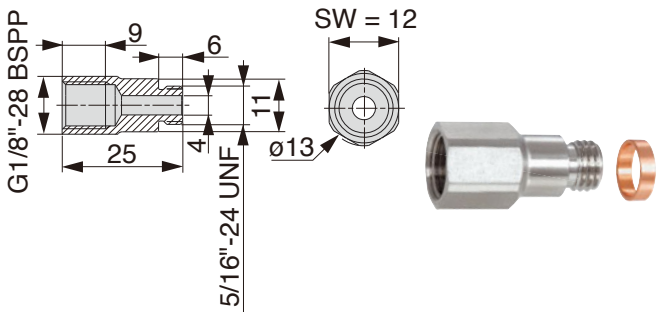


Designation
CHP-NIPPLE-G1/8-7/16UNF

Seal washer

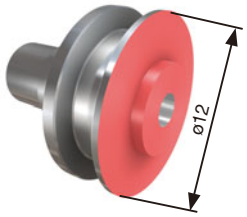
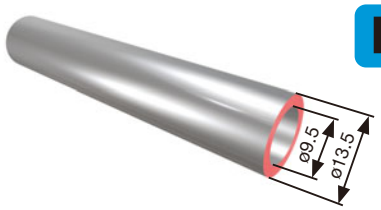
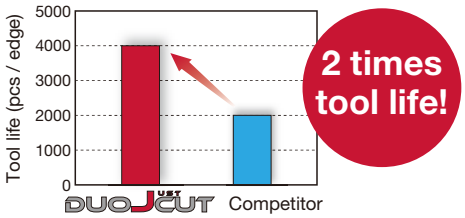
Designation	øD	ød	W
CHP-COPPER-SEAL1/8	15	8	1
CHP-COPPER-SEAL5/16	11	8	1
CHP-COPPER-SEAL5/16-2.5	11	8	2.5

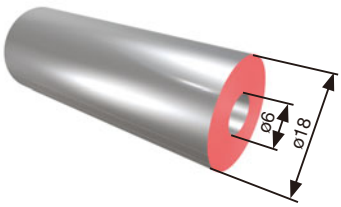
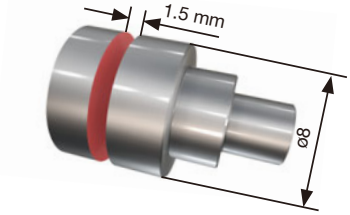
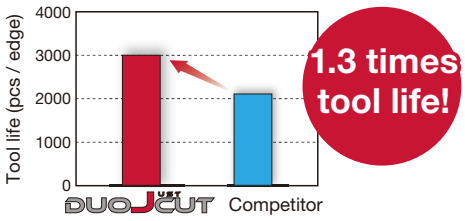
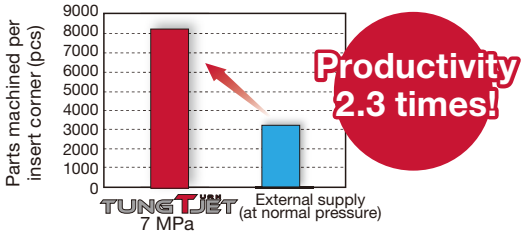
Connector for small lathe with seal washer



Designation
CHP-CONECTOR/5/16-G1/8

PRACTICAL EXAMPLES

Workpiece type		Hydraulic component	Torque limiter
Toolholder		JSXXL1212X09-S	JSXXL1212X09-S
Insert		JXPG16L20F	JXPG12L15F
Grade		SH725	SH725
Workpiece material		SUS304 / X5CrNi18-9	Low carbon alloy
		 M	 P
Cutting conditions	Cutting speed: *Vc* (m/min)	75	120
	Feed : *f* (mm/rev)	0.02	0.03
	Groove width : CW (mm)	2.0	1.5
	Machining	Parting-off	Parting-off
	Coolant	Wet	Wet
Results		 DuoJust-Cut doubles tool life and provides excellent surface finish due to highly rigid insert clamping.	 Chip control of DuoJust-Cut is better than the competitor's even in parting-off of thin workpiece. Also, the DuoJust-Cut insert with sharp cutting edge provides stable machining without chattering.

Workpiece type		Injection parts	Injection parts
Toolholder		JSXXL1212X09-S	JSXXR1212X09-CHP
Insert		JXPG12L20F	JXPG16R15F
Grade		SH725	SH725
Workpiece material		SUS304L	SUS304 / X5CrNi18-9
		 M	 M
Cutting conditions	Cutting speed: *Vc* (m/min)	100	120
	Feed : *f* (mm/rev)	0.05	0.08
	Groove width : CW (mm)	2	2.5
	Machining	Parting-off	Parting-off
	Coolant	Wet	Wet
Results		 DuoJust-Cut extends tool life to 130% and reduces burrs due to the sharp cutting edge.	 TungTurn-Jet's high pressure, through-coolant supply system has improved the tool life to 230% over external coolant supply method, while reducing tool wear during stainless steel parting operation.

MEMO

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