

內徑車刀桿 系列

Internal Turning Toolholders Series

泛用鋼材 $\leq 50\text{HRC}$

不銹鋼

鋁合金 / 銅合金

鑄鐵

For general steel ($\leq 50\text{HRC}$), stainless steel, cast iron and aluminum/copper alloy machining.



產品選擇表 Product Selection Table

內徑車刀桿 Internal Turning Toolholders



MCKN

主偏角 Entering Angle
75°

最小車徑
P.483 $\phi 25\sim70$



MCLN

主偏角 Entering Angle
95°

最小車徑
P.483 $\phi 25\sim70$



SCLC

主偏角 Entering Angle
95°

最小車徑
P.484 $\phi 9\sim50$



SDUC

主偏角 Entering Angle
93°

最小車徑
P.485 $\phi 13\sim50$



MSKN

主偏角 Entering Angle
75°

最小車徑
P.486 $\phi 30\sim70$



MTQN

主偏角 Entering Angle
105°

最小車徑
P.486 $\phi 25\sim40$



DTUN

主偏角 Entering Angle
93°


最小車徑
P.487 $\phi 28\sim40$



STUP

主偏角 Entering Angle
93°

最小車徑
P.488 $\phi 9\sim30$



STUC

主偏角 Entering Angle
93°

最小車徑
P.490 $\phi 12\sim38$



MVUN

主偏角 Entering Angle
93°

最小車徑
P.491 $\phi 32\sim60$



SVQB

主偏角 Entering Angle
117.5°

最小車徑
P.491 $\phi 16\sim50$



SVUB

主偏角 Entering Angle
93°

最小車徑
P.492 $\phi 22\sim50$



SVQC

主偏角 Entering Angle
117.5°

最小車徑
P.493 $\phi 16\sim50$



SVUC

主偏角 Entering Angle
93°

最小車徑
P.494 $\phi 16\sim50$



MWLN

主偏角 Entering Angle
95°

最小車徑
P.495 $\phi 25\sim70$

內徑車刀桿 ISO 編碼規範

ISO Designation For Internal Turning Tools

S	20	R	—	M	C	L	N	R	—	12	
11	7	8		1	2	3	4	5		9	10

11

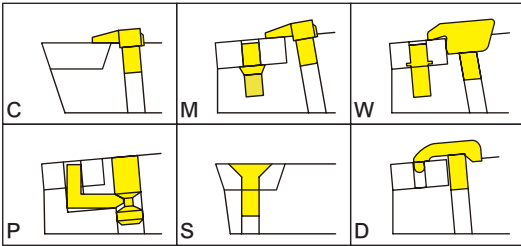
刀桿設計 Shank Design

代號 Code	設 計 Design
S	鋼材柄。 Steel Shank.
A	鋼材柄 + 中心出水孔。 Steel Shank + Coolant Hole.
B	抗震鋼材柄。 Steel Shank + Device Anti-Vibration.
C	鎢鋼柄。 Cemented Carbide Shank With Steel Head.
D	抗震鋼材柄 + 中心出水孔。 Steel Shank + Device Anti-Vibration + Coolant Hole.
E	鎢鋼柄 + 中心出水孔。 Cemented Carbide Shank With Steel Head + Coolant Hole.
F	抗震鎢鋼柄。 Cemented Carbide Shank With Steel Head + Device Anti-Vibration.
G	抗震鎢鋼柄 + 中心出水孔。 Cemented Carbide Shank With Steel Head + Device Anti-Vibration + Coolant Hole.
H	重金屬。 Heavy Metal Shank.
J	重金屬 + 中心出水孔。 Heavy Metal Shank + Coolant Hole.

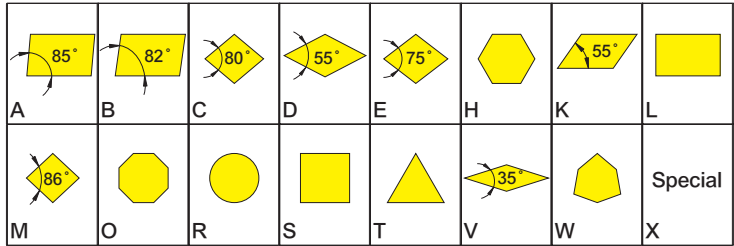
內徑車刀桿 ISO 編碼規範

ISO Designation For Internal Turning Tools

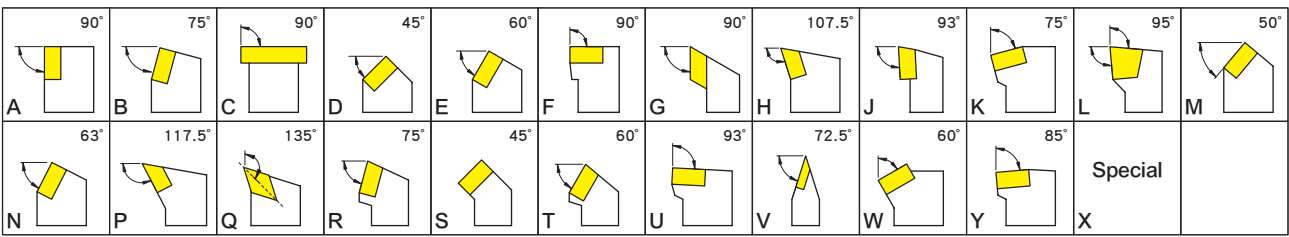
1 刀片夾持方式 Type Of Locking



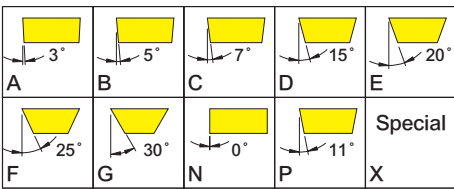
2 刀片形狀 Insert Shape



3 主偏角 Entering Angle



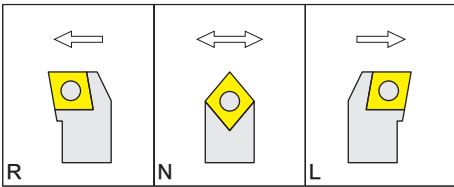
4 刀片離隙角 Clearance Angle



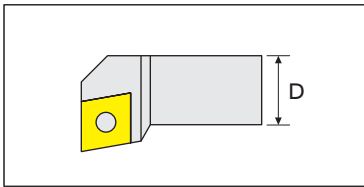
8 刀桿全長 Shank Length

代號 Code	尺寸 (mm)
A	32
B	40
C	50
D	60
E	70
F	80
G	90
H	100
J	110
K	125
L	140
M	150
N	160
P	170
Q	180
R	200
S	250
T	300
U	350
V	400
W	450
Y	500
X	Special

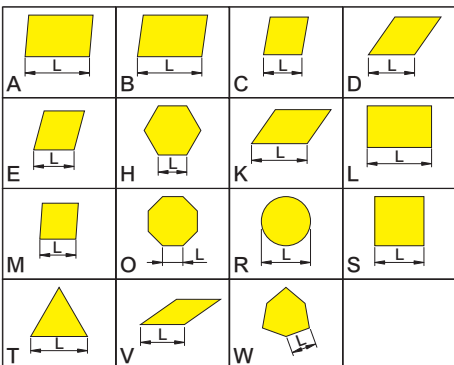
5 切削方向 Cutting Direction



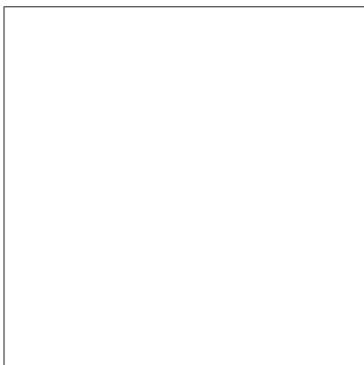
7 刀桿寬度 Shank Width



9 刀片邊長 Insert Length

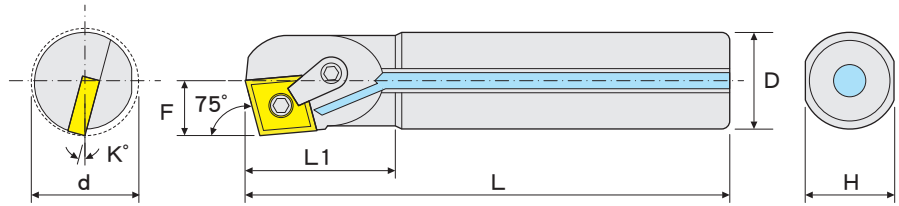
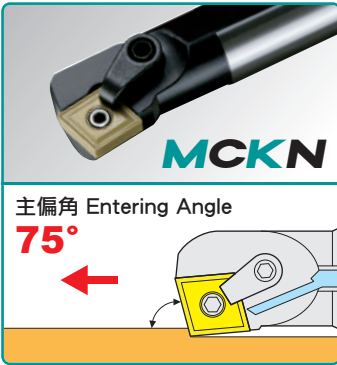


10 特殊記號 Optional Code



內徑車刀桿

INTERNAL TURNING TOOLHOLDERS

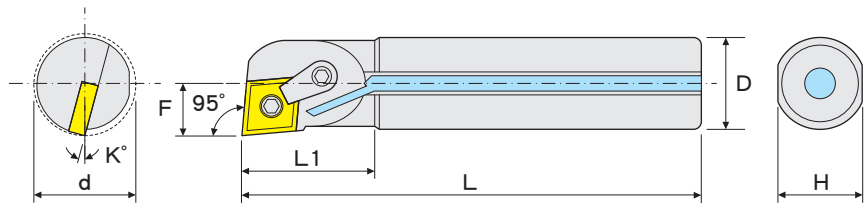


d = 最小車徑 d = Min. Bore Dia. / 右車刀桿圖示 Right-Hand Shown

鋼材柄訂購編號 Order No. (Steel Shank)		尺寸 Dimension (mm)						最小車徑 d	搭配刀片 Insert	配件 Spare Parts
無出水孔 Non-coolant	出水孔 Coolant	F	L1	H	L	D	K			
S20R-MCKN ^R / _L -12	A20R-MCKN ^R / _L -12	13.0	40	18	200	20	15°	25	CN..1204..	①
S25R-MCKN ^R / _L -12	A25R-MCKN ^R / _L -12	15.5	40	23	200	25	13°	30		
S32S-MCKN ^R / _L -12	A32S-MCKN ^R / _L -12	19.5	48	30	250	32	13°	40		②
S40T-MCKN ^R / _L -12	A40T-MCKN ^R / _L -12	25.5	55	37	300	40	12°	50		
S50U-MCKN ^R / _L -12	A50U-MCKNR-12	30.5	60	47	350	50	10°	60		
S60V-MCKN ^R / _L -12	—	35.5	60	57	400	60	9°	70		

配件 Spare Parts	Shim	Pin	Wrench	Clamp	Screw	Wrench
①	—	MLP44-A	PL25	MC620	MS620TX	ETL15
②	CMS432	MLP46-A	PL25	MC620	MS625TX	ETL15

→ 搭配刀片 Insert P.449 → 切削條件表 Cutting Condition P.612



d = 最小車徑 d = Min. Bore Dia. / 右車刀桿圖示 Right-Hand Shown

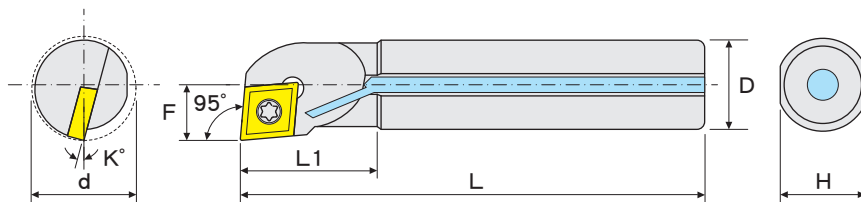
鋼材柄訂購編號 Order No. (Steel Shank)		尺寸 Dimension (mm)						最小車徑 d	搭配刀片 Insert	配件 Spare Parts
無出水孔 Non-coolant	出水孔 Coolant	F	L1	H	L	D	K			
S20R-MCLN ^R / _L -12	A20R-MCLN ^R / _L -12	13.0	40	18	200	20	15°	25	CN..1204..	①
S25R-MCLN ^R / _L -12	A25R-MCLN ^R / _L -12	15.5	40	23	200	25	13°	30		
S32S-MCLN ^R / _L -12	A32S-MCLN ^R / _L -12	19.5	48	30	250	32	13°	40		②
S40T-MCLN ^R / _L -12	A40T-MCLN ^R / _L -12	25.5	55	37	300	40	12°	50		
S50U-MCLN ^R / _L -12	—	30.5	60	47	350	50	10°	60		
S60V-MCLN ^R / _L -12	A60V-MCLN ^R / _L -12	35.5	60	57	400	60	9°	70		

配件 Spare Parts	Shim	Pin	Wrench	Clamp	Screw	Wrench
①	—	MLP44-A	PL25	MC620	MS620TX	ETL15
②	CMS432	MLP46-A	PL25	MC620	MS625TX	ETL15

→ 搭配刀片 Insert P.449 → 切削條件表 Cutting Condition P.612

內徑車刀桿

INTERNAL TURNING TOOLHOLDERS



d = 最小車徑 d = Min. Bore Dia. / 右車刀桿圖示 Right-Hand Shown

鋼材柄訂購編號 Order No. (Steel Shank)		尺寸 Dimension (mm)						最小車徑 d	搭配刀片 Insert	配件 Spare Parts
無出水孔 Non-coolant	出水孔 Coolant	F	L1	H	L	D	K			
S08K-SCLC ^{R/L} -06	A08K-SCLC ^{R/L} -06	5.0	20	7	125	8	15°	10	CC..0602..	①
S08K-SCLC ^{R/L} -06-D09	A08K-SCLC ^{R/L} -06-D09	4.5	20	7	125	8	15°	9		
S10K-SCLC ^{R/L} -06	A10K-SCLC ^{R/L} -06	6.0	22	9	125	10	13°	12		
S10K-SCLC ^{R/L} -06-D11	A10K-SCLC ^{R/L} -06-D11	5.5	22	9	125	10	13°	11		
S12M-SCLC ^{R/L} -06	A12M-SCLC ^{R/L} -06	8.0	26	11	150	12	10°	16		
S12M-SCLC ^{R/L} -06-D13	A12M-SCLC ^{R/L} -06-D13	6.5	26	11	150	12	10°	13		
S14Q-SCLC ^{R/L} -06	A14Q-SCLC ^{R/L} -06	8.0	26	13	180	14	10°	16		
S16Q-SCLC ^{R/L} -06	A16Q-SCLC ^{R/L} -06	10.0	32	15	180	16	7°	20		
S12M-SCLC ^{R/L} -09	A12M-SCLC ^{R/L} -09	8.0	26	11	150	12	10°	16	CC..09T3..	②
S14Q-SCLC ^{R/L} -09	A14Q-SCLC ^{R/L} -09	8.0	26	13	180	14	10°	16		
S15Q-SCLC ^{R/L} -09	A15Q-SCLC ^{R/L} -09	8.5	32	14	180	15	10°	17		
S16Q-SCLC ^{R/L} -09	A16Q-SCLC ^{R/L} -09	10.0	32	15	180	16	7°	20		
S16Q-SCLC ^{R/L} -09-D18	A16Q-SCLC ^{R/L} -09-D18	9.0	32	15	180	16	7°	18		
S18Q-SCLC ^{R/L} -09	A18Q-SCLC ^{R/L} -09	10.0	32	17	180	18	7°	20		
S20R-SCLC ^{R/L} -09	A20R-SCLC ^{R/L} -09	13.0	40	18	200	20	5°	25		
S22R-SCLC ^{R/L} -09	—	13.0	40	20	200	22	5°	25	③	
S25R-SCLC ^{R/L} -09	A25R-SCLC ^{R/L} -09	15.0	40	23	200	25	5°	30	④	
S32S-SCLC ^{R/L} -09	A32S-SCLC ^{R/L} -09	19.5	48	30	250	32	5°	38	CC..1204..	⑤
S32S-SCLC ^{R/L} -12	A32S-SCLC ^{R/L} -12	20.0	48	30	250	32	5°	38		
S40T-SCLC ^{R/L} -12	A40T-SCLC ^{R/L} -12	26.0	55	37	300	40	3°	50		
S40V-SCLC ^{R/L} -12	A40V-SCLC ^{R/L} -12	26.0	55	37	400	40	3°	50		

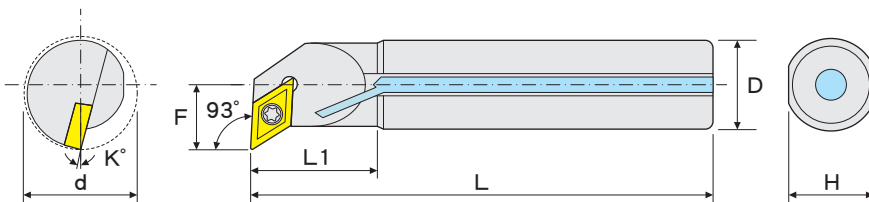
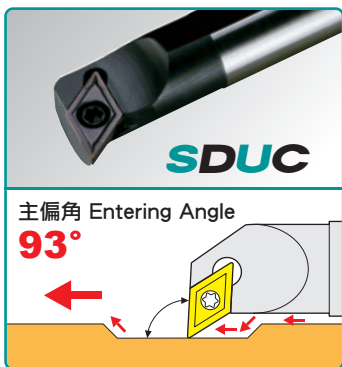
配件 Spare Parts	Screw	Wrench
①	MS2506A	ETF09
②	MS4008A	ETF15
③	MS4009A	ETF15
④	MS4011A	ETF15
⑤	MS5011A	ETF20

→ 搭配刀片 Insert P.440, 441

→ 切削條件表 Cutting Condition P.611

內徑車刀桿

INTERNAL TURNING TOOLHOLDERS



d = 最小車徑 d = Min. Bore Dia. / 右車刀桿圖示 Right-Hand Shown

鋼柄訂購編號 Order No. (Steel Shank)		尺寸 Dimension (mm)						最小車徑 d	搭配刀片 Insert	配件 Spare Parts
無出水孔 Non-coolant	出水孔 Coolant	F	L1	H	L	D	K			
S10K-SDUC ^R / _L -07	A10K-SDUC ^R / _L -07	7.0	25	9	125	10	13°	13	DC..0702..	①
S12M-SDUC ^R / _L -07	A12M-SDUC ^R / _L -07	8.5	30	11	150	12	10°	16		
S16Q-SDUC ^R / _L -07	A16Q-SDUC ^R / _L -07	11.0	30	15	180	16	7°	20		
S20R-SDUC ^R / _L -07	A20R-SDUC ^R / _L -07	12.5	40	18	200	20	7°	25		
S16Q-SDUC ^R / _L -11	A16Q-SDUC ^R / _L -11	11.0	30	15	180	16	7°	20	DC..11T3..	②
S20R-SDUC ^R / _L -11	A20R-SDUC ^R / _L -11	13.0	40	18	200	20	7°	25		
S25R-SDUC ^R / _L -11	A25R-SDUC ^R / _L -11	16.0	45	23	200	25	5°	32		
S25S-SDUC ^R / _L -11	—	16.0	45	23	250	25	5°	32		
S32S-SDUC ^R / _L -11	A32S-SDUC ^R / _L -11	20.0	48	30	250	32	5°	40		
S40T-SDUC ^R / _L -11	A40T-SDUC ^R / _L -11	26.0	55	37	300	40	3°	50		

鎢鋼柄訂購編號 Order No. (Carbide Shank)		尺寸 Dimension (mm)						最小車徑 d	搭配刀片 Insert	配件 Spare Parts
無出水孔 Non-coolant	出水孔 Coolant	F	L1	H	L	D	K			
C10K-SDUC ^R / _L -07	E10K-SDUC ^R / _L -07	7.0	25	9.2	125	10	13°	13	DC..0702..	①
C10M-SDUCR-07	E10M-SDUCR-07	7.0	25	9.2	150	10	13°	13		
C12M-SDUC ^R / _L -07	E12M-SDUC ^R / _L -07	8.5	30	11.2	150	12	10°	16		
C12Q-SDUCR-07	E12Q-SDUCR-07	8.5	30	11.2	180	12	10°	16		
C16R-SDUCR-07	E16R-SDUCR-07	11.0	30	15.2	200	16	7°	20	DC..11T3..	②
C16R-SDUC ^R / _L -11	E16R-SDUC ^R / _L -11	11.0	30	15.2	200	16	7°	20		
C20R-SDUC ^R / _L -11	E20R-SDUC ^R / _L -11	13.0	40	19.2	200	20	7°	25		
C25S-SDUCR-11	E25S-SDUCR-11	16.0	45	24.2	250	25	5°	32		

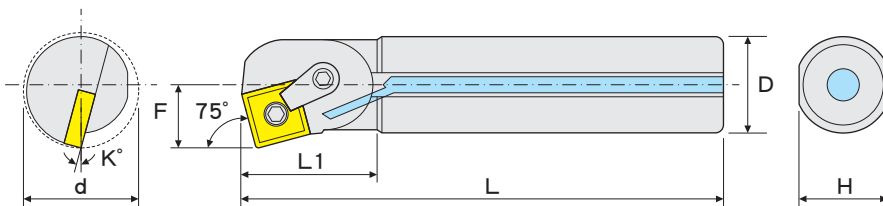
配件 Spare Parts	Screw	Wrench
①	MS2506B	ETF09
②	MS4009A	ETF15

→ 搭配刀片 Insert P.442, 443

→ 切削條件表 Cutting Condition P.611

內徑車刀桿

INTERNAL TURNING TOOLHOLDERS

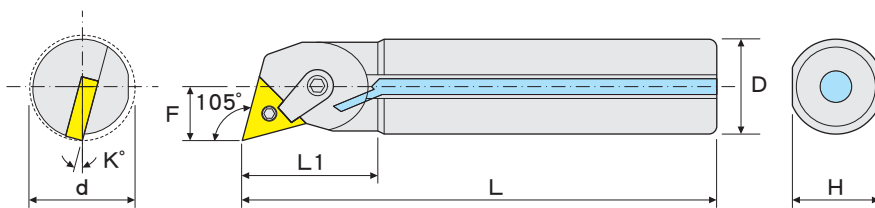


d = 最小車徑 d = Min. Bore Dia. / 右車刀桿圖示 Right-Hand Shown

鋼材柄訂購編號 Order No. (Steel Shank)		尺寸 Dimension (mm)						最小車徑 d	搭配刀片 Insert	配件 Spare Parts
無出水孔 Non-coolant	出水孔 Coolant	F	L1	H	L	D	K			
S25R-MSKN ^R / _L -12	A25R-MSKN ^R / _L -12	15.0	40	23	200	25	13°	30	SN..1204..	①
S32S-MSKN ^R / _L -12	A32S-MSKN ^R / _L -12	19.5	48	30	250	32	13°	40		②
S40T-MSKN ^R / _L -12	—	25.5	55	37	300	40	12°	50		
S50U-MSKN ^R / _L -12	—	30.5	60	47	350	50	10°	60		
S60V-MSKN ^R / _L -12	—	36.0	60	57	400	60	9°	70		

配件 Spare Parts	Shim	Pin	Wrench	Clamp	Screw	Wrench
①	—	MLP44-A	PL25	MC620	MS620TX	ETL15
②	SMS432	MLP46-A	PL25	MC620	MS625TX	ETL15

→ 搭配刀片 Insert P.450 → 切削條件表 Cutting Condition P.612



d = 最小車徑 d = Min. Bore Dia. / 右車刀桿圖示 Right-Hand Shown

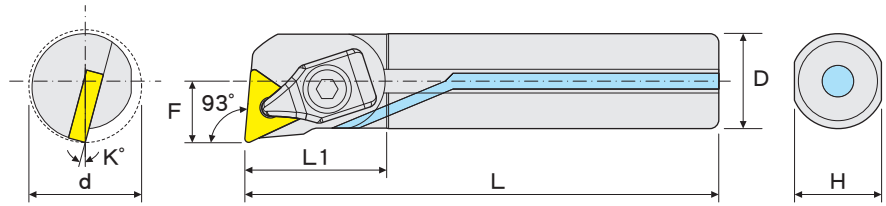
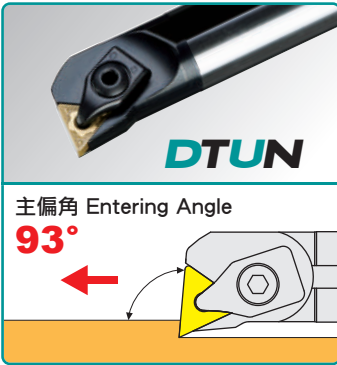
鋼材柄訂購編號 Order No. (Steel Shank)		尺寸 Dimension (mm)						最小車徑 d	搭配刀片 Insert	配件 Spare Parts
無出水孔 Non-coolant	出水孔 Coolant	F	L1	H	L	D	K			
S20R-MTQN ^R / _L -16	A20R-MTQN ^R / _L -16	13	40	18	200	20	15°	25	TN..1604..	①
S25R-MTQN ^R / _L -16	A25R-MTQN ^R / _L -16	15	40	23	200	25	13°	30		②
S32S-MTQN ^R / _L -16	A32S-MTQN ^R / _L -16	20	48	30	250	32	13°	40		

配件 Spare Parts	Shim	Pin	Wrench	Clamp	Screw	Wrench
①	—	MLP33L-A	PL20	MC515	MS520TX	ETL10
②	TWS322	MLP34L-A	PL20	MC620	MS625TX	ETL15

→ 搭配刀片 Insert P.451, 452 → 切削條件表 Cutting Condition P.612

內徑車刀桿

INTERNAL TURNING TOOLHOLDERS



d = 最小車徑 d = Min. Bore Dia. / 右車刀桿圖示 Right-Hand Shown

鋼材柄訂購編號 Order No. (Steel Shank)		尺寸 Dimension (mm)						最小車徑 d	搭配刀片 Insert	配件 Spare Parts
無出水孔 Non-coolant	出水孔 Coolant	F	L1	H	L	D	K			
S20R-DTUN ^{R/L} -16	A20R-DTUN ^{R/L} -16	14.0	40	18	200	20	15°	28	TN..1604..	①
S25R-DTUN ^{R/L} -16	A25R-DTUN ^{R/L} -16	15.5	40	23	200	25	13°	30		②
S25S-DTUN ^{R/L} -16	—	15.5	40	23	250	25	13°	30		
S32S-DTUN ^{R/L} -16	A32S-DTUN ^{R/L} -16	19.5	48	30	250	32	13°	40		

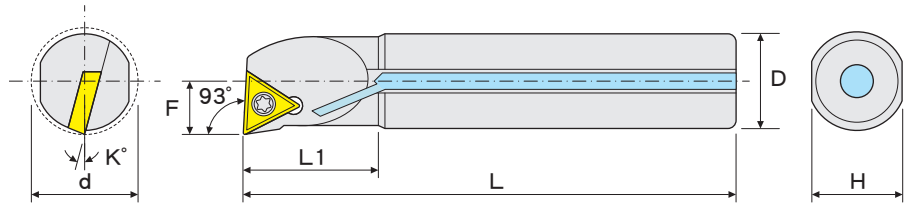
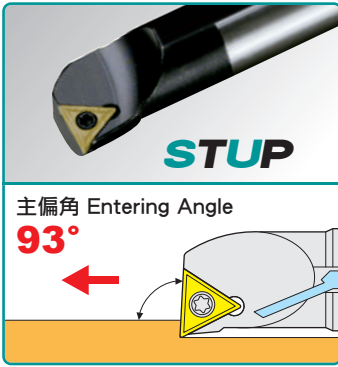
配件 Spare Parts	Shim	Screw	Wrench	Clamp	Wrench
①	—	—	—	MCD324	ETL20
②	TWS322	MS4008H	PL25	MCD324B	PL40

→ 搭配刀片 Insert P.451, 452

→ 切削條件表 Cutting Condition P.612

內徑車刀桿

INTERNAL TURNING TOOLHOLDERS



d = 最小車徑 d = Min. Bore Dia. / 右車刀桿圖示 Right-Hand Shown

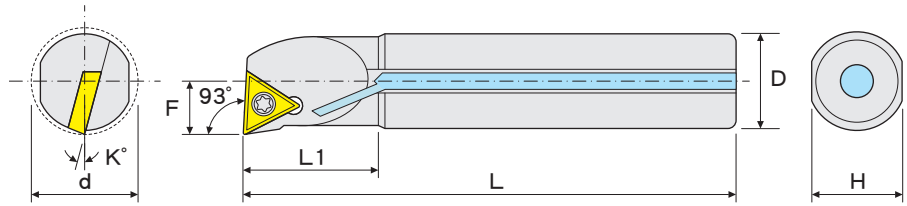
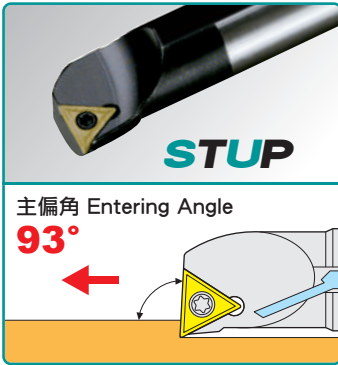
鋼材柄訂購編號 Order No. (Steel Shank)		尺寸 Dimension (mm)						最小車徑 d	搭配刀片 Insert	配件 Spare Parts	
無出水孔 Non-coolant	出水孔 Coolant	F	L1	H	L	D	K				
S08K-STUP ^{R/L} -08	A08K-STUP ^{R/L} -08	5.5	20	7	125	8	10°	10	TP..0802..	①	
S08K-STUP ^{R/L} -08-D09	A08K-STUP ^{R/L} -08-D09	4.5	20	7	125	8	10°	9			
S10K-STUP ^{R/L} -08	A10K-STUP ^{R/L} -08	6.0	22	9	125	10	8°	12		②	
S10K-STUP ^{R/L} -08-D11	A10K-STUP ^{R/L} -08-D11	5.5	22	9	125	10	8°	11			
S12M-STUP ^{R/L} -08		8.0	26	11	150	12	8°	16		TP..1103..	③
S16Q-STUP ^{R/L} -08-D18		9.0	32	15	180	16	7°	18			
S10K-STUP ^{R/L} -11	A10K-STUP ^{R/L} -11	6.0	22	9	125	10	8°	12			
S12M-STUP ^{R/L} -11	A12M-STUP ^{R/L} -11	8.0	26	11	150	12	8°	16			
S12M-STUP ^{R/L} -11-D13	A12M-STUP ^{R/L} -11-D13	6.5	26	11	150	12	8°	13			
S14Q-STUP ^{R/L} -11	A14Q-STUP ^{R/L} -11	8.0	26	13	180	14	7°	16			
S15Q-STUP ^{R/L} -11	A15Q-STUP ^{R/L} -11	8.5	32	14	180	15	7°	17			
S16Q-STUP ^{R/L} -11	A16Q-STUP ^{R/L} -11	10.0	32	15	180	16	7°	20			
S16Q-STUP ^{R/L} -11-D18	A16Q-STUP ^{R/L} -11-D18	9.0	32	15	180	16	7°	18			
S18Q-STUP ^{R/L} -11	A18Q-STUP ^{R/L} -11	10.0	32	17	180	18	7°	20			
S20R-STUP ^{R/L} -11	A20R-STUP ^{R/L} -11	13.0	40	18	200	20	7°	25			
S22R-STUPR-11		13.0	40	20	200	22	5°	25			
S23R-STUPR-11		13.0	40	21	200	23	5°	26			
S25R-STUP ^{R/L} -11	A25R-STUP ^{R/L} -11	15.0	40	23	200	25	0°	30			

配件 Spare Parts	Screw	Wrench
①	MS2205A	ETF07
②	MS2206A	ETF07
③	MS3008A	ETF09

→ 搭配刀片 Insert P.452 → 切削條件表 Cutting Condition P.611

內徑車刀桿

INTERNAL TURNING TOOLHOLDERS



d = 最小車徑 d = Min. Bore Dia. / 右車刀桿圖示 Right-Hand Shown

鎢鋼柄訂購編號 Order No. (Carbide Shank)		尺寸 Dimension (mm)						最小車徑 d	搭配刀片 Insert	配件 Spare Parts
無出水孔 Non-coolant	出水孔 Coolant	F	L1	H	L	D	K			
C08K-STUP ^R / _L -08	E08K-STUPR-08	5.5	20	7.2	125	8	10°	10	TP..0802..	①
C08K-STUPR-08-D09	E08K-STUPR-08-D09	4.5	20	7.2	125	8	10°	9		
C10K-STUPR-08	E10K-STUPR-08	6.0	22	9.2	125	10	8°	12		②
C10K-STUPR-08-D11		5.5	22	9.2	125	10	8°	11		
C12M-STUPR-08		8.0	26	11.2	150	12	8°	16	TP..1103..	③
C10K-STUP ^R / _L -11	E10K-STUP ^R / _L -11	6.0	22	9.2	125	10	8°	12		
C10M-STUPR-11	E10M-STUPR-11	6.0	22	9.2	150	10	8°	12		
C12M-STUP ^R / _L -11	E12M-STUPR-11	8.0	26	11.2	150	12	8°	16		
C12M-STUPR-11-D13	E12M-STUPR-11-D13	6.5	26	11.2	150	12	8°	13		
C12Q-STUPR-11	E12Q-STUPR-11	8.0	26	11.2	180	12	8°	16		
C12Q-STUPR-11-D13	E12Q-STUPR-11-D13	6.5	26	11.2	180	12	8°	13		
C14R-STUPR-11	E14R-STUPR-11	8.0	26	13.2	200	14	7°	16		
C16R-STUP ^R / _L -11	E16R-STUPR-11	10.0	32	15.2	200	16	7°	20		
C16R-STUPR-11-D18	E16R-STUPR-11-D18	9.0	32	15.2	200	16	7°	18		
C20R-STUPR-11	E20R-STUPR-11	13.0	40	19.2	200	20	7°	25		
C25S-STUPR-11		15.0	40	24.2	250	25	0°	30		

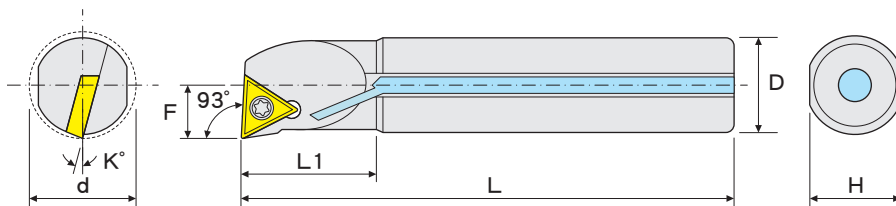
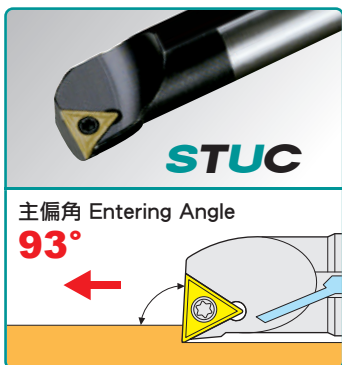
配件 Spare Parts	Screw	Wrench
①	MS2205A	ETF07
②	MS2206A	ETF07
③	MS3008A	ETF09

→ 搭配刀片 Insert P.452

→ 切削條件表 Cutting Condition P.611

內徑車刀桿

INTERNAL TURNING TOOLHOLDERS



d = 最小車徑 d = Min. Bore Dia. / 右車刀桿圖示 Right-Hand Shown

鋼材柄訂購編號 Order No. (Steel Shank)		尺寸 Dimension (mm)							最小車徑 d	搭配刀片 Insert	配件 Spare Parts
無出水孔 Non-coolant	出水孔 Coolant	F	L1	H	L	D	K				
S10K-STUC ^{R/L} -11	A10K-STUC ^{R/L} -11	6.0	22	9	125	10	13°	12	TC..1102..	①	
S12M-STUC ^{R/L} -11	A12M-STUC ^{R/L} -11	8.0	26	11	150	12	10°	16			
S12M-STUC ^{R/L} -11-D13	A12M-STUC ^{R/L} -11-D13	6.5	26	11	150	12	10°	13			
S16Q-STUC ^{R/L} -11	A16Q-STUC ^{R/L} -11	10.0	32	15	180	16	7°	20			
S16Q-STUC ^{R/L} -11-D18	A16Q-STUC ^{R/L} -11-D18	9.0	32	15	180	16	7°	18			
S20R-STUC ^{R/L} -16	A20R-STUC ^{R/L} -16	13.0	40	18	200	20	7°	25	TC..16T3..	②	
S25R-STUC ^{R/L} -16	A25R-STUC ^{R/L} -16	15.0	40	23	200	25	5°	30			
S32S-STUC ^{R/L} -16	A32S-STUC ^{R/L} -16	20.0	48	30	250	32	5°	38			
S32T-STUC ^{R/L} -16	A32T-STUC ^{R/L} -16	20.0	48	30	300	32	5°	38			

鎢鋼柄訂購編號 Order No. (Carbide Shank)		尺寸 Dimension (mm)							最小車徑 d	搭配刀片 Insert	配件 Spare Parts
無出水孔 Non-coolant	出水孔 Coolant	F	L1	H	L	D	K				
C10K-STUCR-11	E10K-STUCR-11	6.0	22	9.2	125	10	13°	12	TC..1102..	②	
C10M-STUCR-11	E10M-STUCR-11	6.0	22	9.2	150	10	13°	12			
C12M-STUC ^{R/L} -11	E12M-STUCR-11	8.0	26	11.2	150	12	10°	16			
C12M-STUCR-11-D13		6.5	26	11.2	150	12	10°	13			
C12Q-STUC ^{R/L} -11	E12Q-STUCR-11	8.0	26	11.2	180	12	10°	16			
C12Q-STUCR-11-D13		6.5	26	11.2	180	12	10°	13			
C16R-STUCR-11	E16R-STUCR-11	10.0	32	15.2	200	16	7°	20			
C16R-STUCR-11-D18		9.0	32	15.2	200	16	7°	18			

配件 Spare Parts	Screw	Wrench
①	MS2506A	ETF09
②	MS4011A	ETF15

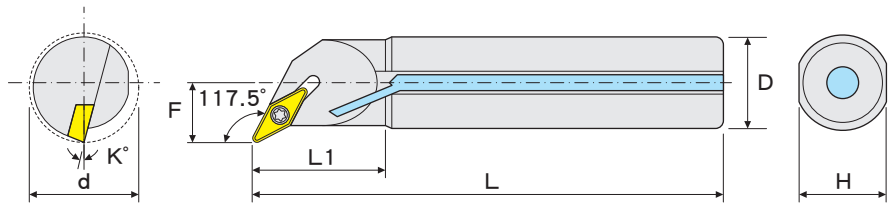
→ 搭配刀片 Insert P.445 → 切削條件表 Cutting Condition P.611

TURNING Internal Turning Toolholders

內徑車刀桿

內徑車刀桿

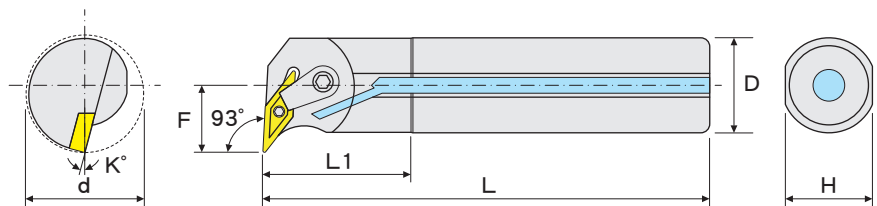
INTERNAL TURNING TOOLHOLDERS



d = 最小車徑 d = Min. Bore Dia. / 右車刀桿圖示 Right-Hand Shown

鋼材柄訂購編號 Order No. (Steel Shank)		尺寸 Dimension (mm)						最小車徑 d	搭配刀片 Insert	配件 Spare Parts
無出水孔 Non-coolant	出水孔 Coolant	F	L1	H	L	D	K			
S12M-SVQB ^R / _L -11	A12M-SVQB ^R / _L -11	9.0	28	11	150	12	10°	16	VB..1103..	①
S16Q-SVQB ^R / _L -11	A16Q-SVQB ^R / _L -11	11.0	35	15	180	16	7°	20		
S20R-SVQB ^R / _L -11	A20R-SVQB ^R / _L -11	13.0	40	18	200	20	7°	25		
S20R-SVQB ^R / _L -16	A20R-SVQB ^R / _L -16	13.5	40	18	200	20	5°	27	VB..1604..	②
S25R-SVQB ^R / _L -16	A25R-SVQB ^R / _L -16	16.0	45	23	200	25	5°	32		
S25S-SVQB ^R / _L -16	A25S-SVQB ^R / _L -16	16.0	45	23	250	25	5°	32		
S32S-SVQB ^R / _L -16	A32S-SVQB ^R / _L -16	20.0	48	30	250	32	5°	40		
S32V-SVQB ^R / _L -16	—	20.0	48	30	400	32	5°	40		
S40T-SVQB ^R / _L -16	—	25.5	60	37	300	40	5°	50		
S40V-SVQB ^R / _L -16	—	25.5	60	37	400	40	5°	50		

配件 Spare Parts	Shim	Screw	Wrench	Screw	Wrench
①	—	—	—	MS2506A	ETF09
②	—	—	—	MS3509B	ETF15
③	VSS322	MDS05035S	PL35	MS3512B	ETF15



→ 搭配刀片 Insert P.446

→ 切削條件表 Cutting Condition P.611

d = 最小車徑 d = Min. Bore Dia. / 右車刀桿圖示 Right-Hand Shown

鋼材柄訂購編號 Order No. (Steel Shank)		尺寸 Dimension (mm)						最小車徑 d	搭配刀片 Insert	配件 Spare Parts
無出水孔 Non-coolant	出水孔 Coolant	F	L1	H	L	D	K			
S25R-MVUN ^R / _L -16	A25R-MVUN ^R / _L -16	18	45	23	200	25	13°	32	VN..1604..	①
S32S-MVUN ^R / _L -16	A32S-MVUN ^R / _L -16	21	50	30	250	32	13°	40		
S40T-MVUN ^R / _L -16	A40T-MVUN ^R / _L -16	26	55	37	300	40	10°	50		
S50U-MVUN ^R / _L -16	A50U-MVUN ^R / _L -16	32	60	47	350	50	9°	60		

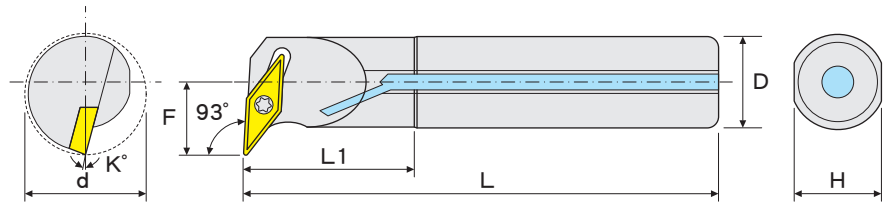
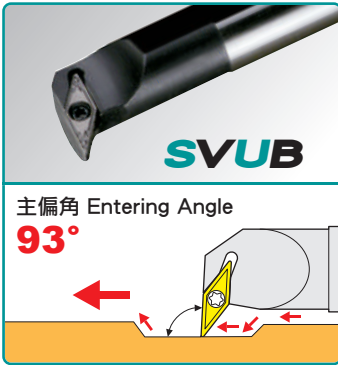
配件 Spare Parts	Shim	Pin	Wrench	Clamp	Screw	Wrench
①	—	MLP33L-A	PL20	MC515	MS520TX	ETL10
②	VMS322	MLP34L-A	PL20	MC620	MS625TX	ETL15

→ 搭配刀片 Insert P.453

→ 切削條件表 Cutting Condition P.612

內徑車刀桿

INTERNAL TURNING TOOLHOLDERS



d = 最小車徑 d = Min. Bore Dia. / 右車刀桿圖示 Right-Hand Shown

鋼材柄訂購編號 Order No. (Steel Shank)		尺寸 Dimension (mm)						最小車徑 d	搭配刀片 Insert	配件 Spare Parts
無出水孔 Non-coolant	出水孔 Coolant	F	L1	H	L	D	K			
S16Q-SVUB ^{R/L} -11	A16Q-SVUB ^{R/L} -11	13	30	15	180	16	7°	22	VB..1103..	①
S20R-SVUB ^{R/L} -11	A20R-SVUB ^{R/L} -11	15	40	18	200	20	7°	27		
S25R-SVUB ^{R/L} -16	A25R-SVUB ^{R/L} -16	18	45	23	200	25	5°	32	VB..1604..	②
S25S-SVUB ^{R/L} -16	A25S-SVUB ^{R/L} -16	18	45	23	250	25	5°	32		
S32S-SVUB ^{R/L} -16	A32S-SVUB ^{R/L} -16	22	50	30	250	32	5°	40		
S40T-SVUB ^{R/L} -16	A40T-SVUB ^{R/L} -16	27	55	37	300	40	5°	50		③
S40U-SVUB ^{R/L} -16	—	27	55	37	350	40	5°	50		
S40V-SVUB ^{R/L} -16	—	27	55	37	400	40	5°	50		

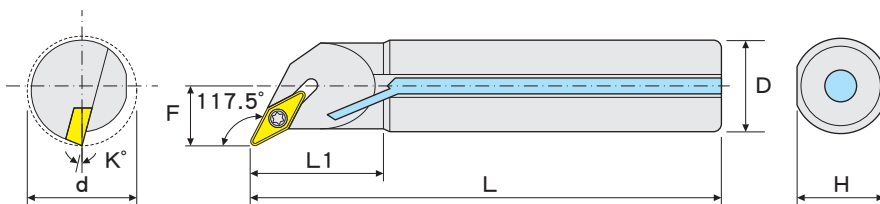
配件 Spare Parts	Shim	Screw	Wrench	Screw	Wrench
①	—	—	—	MS2506A	ETF09
②	—	—	—	MS3509B	ETF15
③	VSS322	MDS05035S	PL35	MS3512B	ETF15
④	—	—	—	MS2005A	ETF06

→ 搭配刀片 P.446
Insert

→ 切削條件表 P.611
Cutting Condition

內徑車刀桿

INTERNAL TURNING TOOLHOLDERS



d = 最小車徑 d = Min. Bore Dia. / 右車刀桿圖示 Right-Hand Shown

鋼材柄訂購編號 Order No. (Steel Shank)		尺寸 Dimension (mm)						最小車徑 d	搭配刀片 Insert	配件 Spare Parts
無出水孔 Non-coolant	出水孔 Coolant	F	L1	H	L	D	K			
S12M-SVQC ^{R/L} -11	A12M-SVQC ^{R/L} -11	9.0	28	11	150	12	10°	16	VC..1103..	①
S16Q-SVQC ^{R/L} -11	A16Q-SVQC ^{R/L} -11	11.0	35	15	180	16	7°	20		
S20R-SVQC ^{R/L} -11	A20R-SVQC ^{R/L} -11	13.0	40	18	200	20	7°	25		
S20R-SVQC ^{R/L} -16	A20R-SVQC ^{R/L} -16	13.5	40	18	200	20	5°	27	VC..1604..	②
S25R-SVQC ^{R/L} -16	A25R-SVQC ^{R/L} -16	16.0	45	23	200	25	5°	32		
S25S-SVQC ^{R/L} -16	A25S-SVQC ^{R/L} -16	16.0	45	23	250	25	5°	32		
S32S-SVQC ^{R/L} -16	A32S-SVQC ^{R/L} -16	20.0	48	30	250	32	5°	40		
S40T-SVQC ^{R/L} -16	—	25.5	60	37	300	40	5°	50		
S40V-SVQC ^{R/L} -16	—	25.5	60	37	400	40	5°	50		

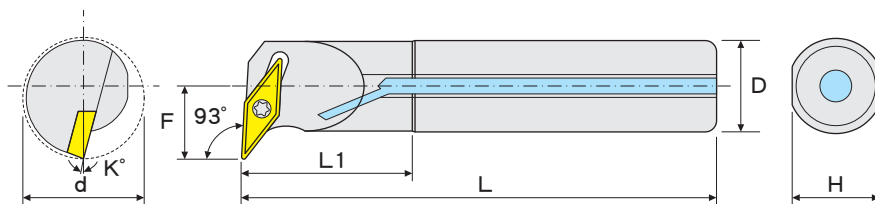
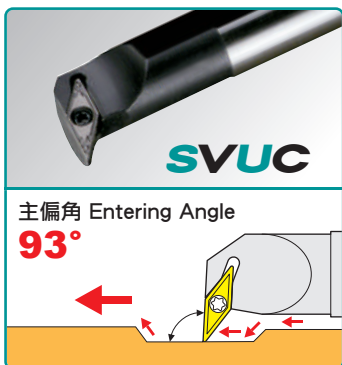
配件 Spare Parts	Shim	Screw	Wrench	Screw	Wrench
①	—	—	—	MS2506A	ETF09
②	—	—	—	MS3509B	ETF15
③	VSS322	MDS05035S	PL35	MS3512B	ETF15

→ 搭配刀片 Insert P.447, 448

→ 切削條件表 Cutting Condition P.611

內徑車刀桿

INTERNAL TURNING TOOLHOLDERS



d = 最小車徑 d = Min. Bore Dia. / 右車刀桿圖示 Right-Hand Shown

鋼材柄訂購編號 Order No. (Steel Shank)		尺寸 Dimension (mm)						最小車徑 d	搭配刀片 Insert	配件 Spare Parts
無出水孔 Non-coolant	出水孔 Coolant	F	L1	H	L	D	K			
S12M-SVUC ^R / _L -08	A12M-SVUC ^R / _L -08	9.5	26	11	150	12	10°	16	VC..0802..	④
S16Q-SVUC ^R / _L -11	A16Q-SVUC ^R / _L -11	13.0	30	15	180	16	7°	22	VC..1103..	①
S20R-SVUC ^R / _L -11	A20R-SVUC ^R / _L -11	15.0	40	18	200	20	7°	27		②
S25R-SVUC ^R / _L -16	A25R-SVUC ^R / _L -16	18.0	45	23	200	25	5°	32	VC..1604..	③
S25S-SVUC ^R / _L -16	A25S-SVUC ^R / _L -16	18.0	45	23	250	25	5°	32		
S32S-SVUC ^R / _L -16	A32S-SVUC ^R / _L -16	22.0	50	30	250	32	5°	40		
S40T-SVUC ^R / _L -16	A40T-SVUC ^R / _L -16	27.0	55	37	300	40	5°	50		
S40U-SVUC ^R / _L -16	A40U-SVUC ^R / _L -16	27.0	55	37	350	40	5°	50		
S40V-SVUC ^R / _L -16	A40V-SVUC ^R / _L -16	27.0	55	37	400	40	5°	50		

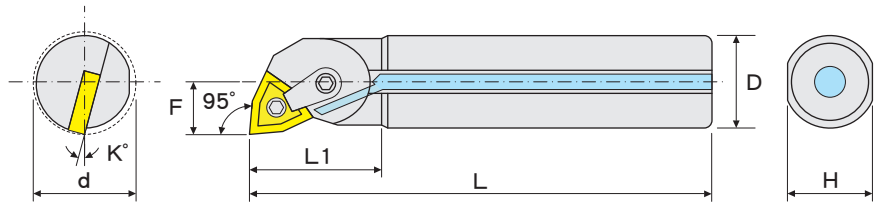
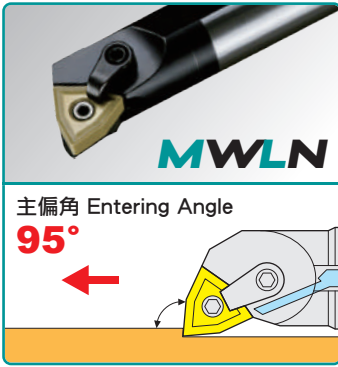
配件 Spare Parts	Shim	Screw	Wrench	Screw	Wrench
①	—	—	—	MS2506A	ETF09
②	—	—	—	MS3509B	ETF15
③	VSS322	MDS05035S	PL35	MS3512B	ETF15
④	—	—	—	MS2005A	ETF06

→ 搭配刀片 Insert P.447, 448

→ 切削條件表 Cutting Condition P.611

內徑車刀桿

INTERNAL TURNING TOOLHOLDERS



d = 最小車徑 d = Min. Bore Dia. / 右車刀桿圖示 Right-Hand Shown

鋼材柄訂購編號 Order No. (Steel Shank)		尺寸 Dimension (mm)						最小車徑 d	搭配刀片 Insert	配件 Spare Parts
無出水孔 Non-coolant	出水孔 Coolant	F	L1	H	L	D	K			
S20R-MWLN ^R / _L -08	A20R-MWLN ^R / _L -08	13.0	40	18	200	20	15°	25	WN..0804..	①
S25R-MWLN ^R / _L -08	A25R-MWLN ^R / _L -08	15.0	40	23	200	25	13°	30		②
S32S-MWLN ^R / _L -08	A32S-MWLN ^R / _L -08	20.0	48	30	250	32	13°	40		③
S40T-MWLN ^R / _L -08	A40T-MWLN ^R / _L -08	25.5	55	37	300	40	10°	50		
S50U-MWLN ^R / _L -08	—	30.5	60	47	350	50	9°	60		
S50V-MWLN ^R / _L -08	A50V-MWLN ^R / _L -08	30.5	60	47	400	50	9°	60		
S60V-MWLN ^R / _L -08	—	35.5	60	57	400	60	8°	70		

配件 Spare Parts	Shim	Pin	Wrench	Clamp	Screw	Wrench
①	—	MLP44-A	PL25	MC515	MS520TX	ETL10
②	WMS432	MLP46-A	PL25	MC515	MS520TX	ETL10
③	WMS432	MLP46-A	PL25	MC620	MS625TX	ETL15

→ 搭配刀片 Insert [P.454](#)

→ 切削條件表 Cutting Condition [P.612](#)



MEMO

TURNING

Internal Turning Toolholders

內徑車刀桿