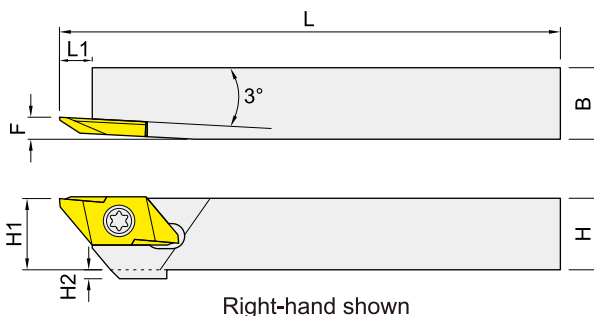


**Back Turning - BTAH** 後掃車削

**Tool Holder Specifications** 刀桿規格



Order No.	Item Specification	Dimensions (mm)						Insert	Screw	Wrench
		H(H1)	B	L	L1	F	H2			
IBTAHR1010K	BTAHR-1010K-50	10	10	125	5.5	3.5	2	BTAT	IMS4009A	ITK15
IBTAHL1010K	BTAHL-1010K-50	10	10	125	5.5	3.5	2			
IBTAHR1212K	BTAHR-1212K-50	12	12	125	5.5	3.5	-			
IBTAHL1212K	BTAHL-1212K-50	12	12	125	5.5	3.5	-			
IBTAHR1616K	BTAHR-1616K-50	16	16	125	5.5	3.5	-			
IBTAHL1616K	BTAHL-1616K-50	16	16	125	5.5	3.5	-			

**Recommended Cutting Conditions** 建議切削數據

Working Material	Vc (m/min)	fr (mm/rev)
Carbon Steel / Alloy Steel	30 ~ 180	0.01 ~ 0.15
Stainless Steel	50 ~ 120	0.02 ~ 0.10
Cast Iron	30 ~ 180	0.01 ~ 0.15
Aluminum Alloy	70 ~ 230	0.03 ~ 0.15

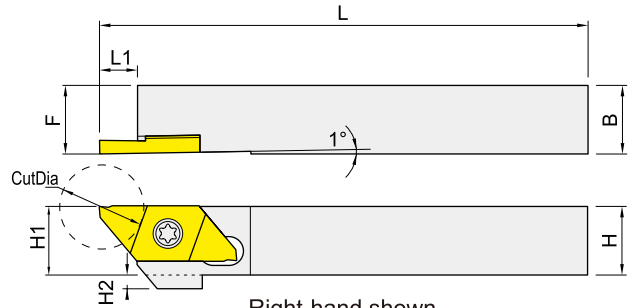
**Insert Specifications** 刀片規格

Inserts	Designation	Grade No.				Dimensions (mm)				Drawing
		CP6025				K	R	L	W	
<p>Back turning 後掃加工</p> <p>Right hand shown</p> <p>Left hand</p>	BTAT552800R-B	✓				55°	0	2.8	0.5	<p>Right hand insert shown</p>
	BTAT552801R-B	✓				55°	0.1	2.8	0.5	
	BTAT603500R-B	✓				60°	0	3.5	0.5	
	BTAT603501R-B	✓				60°	0.1	3.5	0.5	
	BTAT552800L-B	✓				55°	0	2.8	0.5	
	BTAT552801L-B	✓				55°	0.1	2.8	0.5	
	BTAT603500L-B	✓				60°	0	3.5	0.5	
	BTAT603501L-B	✓				60°	0.1	3.5	0.5	

Grooving or Parting - CTAH

切槽或切斷

Tool Holder Specifications 刀桿規格



Order No.	Item Specification	Dimensions (mm)						Insert	CutDia (mm)	Screw	Wrench
		H(H1)	B	L	L1	F	H2				
ICTAHR1010K	CTAHR-1010K-120	10	10	125	5.5	10	2	CTAT	12	IMS4009A	ITK15
ICTAHR1212K	CTAHR-1212K-120	12	12	125	5.5	12	-			IMS4011A	
ICTAHR1616K	CTAHR-1616K-120	16	16	125	5.5	16	-				
ICTAHL1616K	CTAHL-1616K-120	16	16	125	5.5	16	-				
ICTAHR2020K	CTAHR-2020K-120	20	20	125	5.5	20	-				
ICTAHL2020K	CTAHL-2020K-120	20	20	125	5.5	20	-				

Recommended Cutting Conditions 建議切削數據

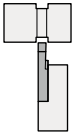
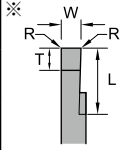
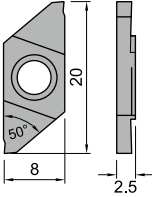
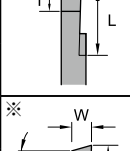
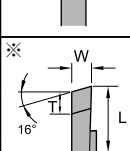
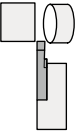
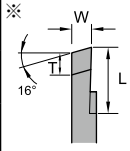
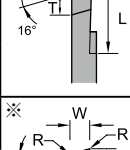
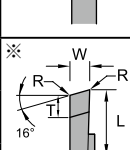
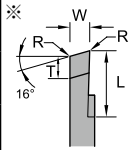
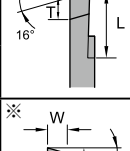
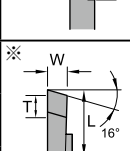
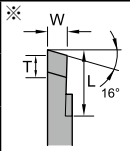
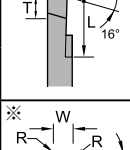
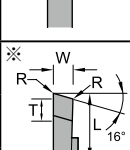
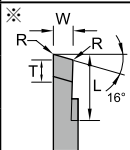
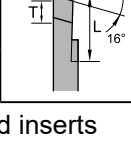
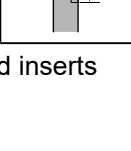
Working Material	Vc (m/min)	fr (mm/rev)
Carbon Steel / Alloy Steel	30 ~ 180	0.01 ~ 0.09
Stainless Steel	50 ~ 120	0.02 ~ 0.05
Cast Iron	30 ~ 180	0.01 ~ 0.09
Aluminum Alloy	70 ~ 230	0.03 ~ 0.11

Turning

Grooving or Parting - CTAH

切槽或切斷

Insert Specifications 刀片規格

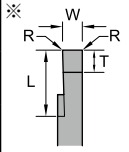
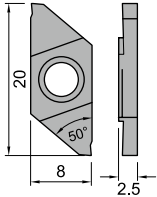
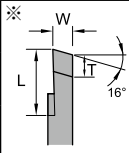
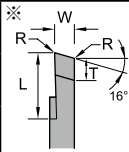
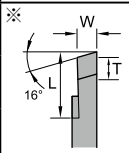
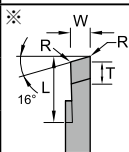
Inserts	Designation	Grade No.					Dimensions (mm)				Drawing
		CP6025					W	R	L	T	
 Grooving 切槽加工	 CTAT101205RN	✓					1.0	0.05	6.7	1.5	 Right hand insert shown
	 CTAT151205RN	✓					1.5	0.05	6.7	1.5	
	 CTAT201205RN	✓					2.0	0.05	6.7	1.5	
 Parting off 切斷加工	 CTAT101200RR	✓					1.0	-	6.7	1.5	
	 CTAT151200RR	✓					1.5	-	6.7	1.5	
	 CTAT201200RR	✓					2.0	-	6.7	1.5	
Right hand shown	 CTAT101205RR	✓					1.0	0.05	6.7	1.5	
	 CTAT151205RR	✓					1.5	0.05	6.7	1.5	
	 CTAT201205RR	✓					2.0	0.05	6.7	1.5	
	 CTAT101200RL	✓					1.0	-	6.7	1.5	
	 CTAT151200RL	✓					1.5	-	6.7	1.5	
	 CTAT201200RL	✓					2.0	-	6.7	1.5	
Right hand shown	 CTAT101205RL	✓					1.0	0.05	6.7	1.5	
	 CTAT151205RL	✓					1.5	0.05	6.7	1.5	
	 CTAT201205RL	✓					2.0	0.05	6.7	1.5	

※ Right hand inserts

Grooving or Parting - CTAH

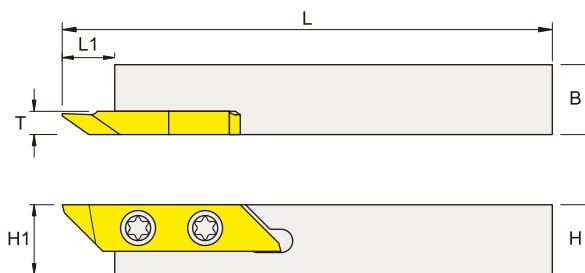
切槽或切斷

Insert Specifications 刀片規格

Inserts	Designation	Grade No.					Dimensions (mm)				Drawing
		CP6025					W	R	L	T	
 <p>※</p>	CTAT101205LN	✓					1.0	0.05	6.7	1.5	 <p>Left hand insert shown</p>
	CTAT151205LN	✓					1.5	0.05	6.7	1.5	
	CTAT201205LN	✓					2.0	0.05	6.7	1.5	
 <p>※</p>	CTAT101200LL	✓					-	6.7	1.5		
	CTAT151200LL	✓					1.5	-	6.7	1.5	
	CTAT201200LL	✓					2.0	-	6.7	1.5	
 <p>※</p>	CTAT101205LL	✓					1.0	0.05	6.7	1.5	
	CTAT151205LL	✓					1.5	0.05	6.7	1.5	
	CTAT201205LL	✓					2.0	0.05	6.7	1.5	
 <p>※</p>	CTAT101200LR	✓					-	6.7	1.5		
	CTAT151200LR	✓					1.5	-	6.7	1.5	
	CTAT201200LR	✓					2.0	-	6.7	1.5	
 <p>※</p>	CTAT101205LR	✓					1.0	0.05	6.7	1.5	
	CTAT151205LR	✓					1.5	0.05	6.7	1.5	
	CTAT201205LR	✓					2.0	0.05	6.7	1.5	

※Left hand inserts

## Tool Holder Specifications 刀桿規格



Right-hand shown

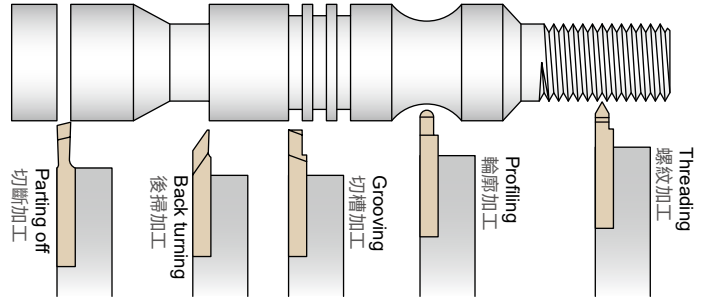
Order No.	Item Specification	Dimensions (mm)					Insert	Screw	Wrench
		H(H1)	B	L	L1	T			
ISAKGR1010K	SAKGR-1010K-374	10	10	125	9	4	SAK...	IMS3509A	ITK15
ISAKGL1010K	SAKGL-1010K-374	10	10	125	9	4			
ISAKGR1212K	SAKGR-1212K-374	12	12	125	9	4			
ISAKGL1212K	SAKGL-1212K-374	12	12	125	9	4			
ISAKGR1212M	SAKGR-1212M-374	12	12	150	9	4			
ISAKGL1212M	SAKGL-1212M-374	12	12	150	9	4			
ISAKGR1616M	SAKGR-1616M-374	16	16	150	9	4			
ISAKGL1616M	SAKGL-1616M-374	16	16	150	9	4			
ISAKGR2020K	SAKGR-2020K-374	20	20	125	9	4			
ISAKGL2020K	SAKGL-2020K-374	20	20	125	9	4			
ISAKGR2525M	SAKGR-2525M-374	25	25	150	9	4			
ISAKGL2525M	SAKGL-2525M-374	25	25	150	9	4			

## Recommended Cutting Conditions 建議切削數據

For Back turning, Parting off and Grooving

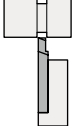
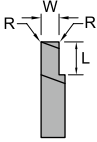
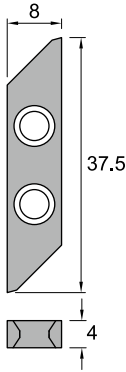
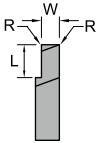
Working Material	Vc (m/min)	fr (mm/rev)
Carbon Steel / Alloy Steel	50 ~ 200	0.02 ~ 0.10
Stainless Steel	50 ~ 200	0.02 ~ 0.10
Cast Iron	50 ~ 200	0.02 ~ 0.10
Aluminum Alloy	200 ~ 300	0.05 ~ 0.15
High Temperature Alloy	80 ~ 120	0.03 ~ 0.07
Hardened Steel	80 ~ 120	0.03 ~ 0.07

Insert Specifications 刀片規格



Inserts	Designation	Grade No.				Dimensions (mm)					Drawing		
		CP6025				W	R	L	K	T			
<p>Back turning 後掃加工</p>	Right hand	SAKBR20005	✓				2.0	-	5.0	35°	0.5	<p>Right hand insert shown</p>	
	SAKBR20015	✓				2.0	0.1	5.0	35°	0.5			
	SAKBR20025	✓				2.0	0.2	5.0	35°	0.5			
	SAKBR30015	✓				3.0	0.1	5.0	35°	0.75			
	SAKBR30025	✓				3.0	0.2	5.0	35°	0.75			
	Left hand	SAKBL20005	✓					2.0	-	5.0	35°		0.5
	SAKBL20015	✓				2.0	0.1	5.0	35°	0.5			
	SAKBL20025	✓				2.0	0.2	5.0	35°	0.5			
	SAKBL30015	✓				3.0	0.1	5.0	35°	0.75			
	SAKBL30025	✓				3.0	0.2	5.0	35°	0.75			

Insert Specifications 刀片規格

Inserts	Designation	Grade No.					Dimensions (mm)					Drawing	
		CP6025					W	R	L	K	T		
 <p>Grooving 切槽加工</p>	 <p>Right hand</p>	SAKGR10013	✓					1.0	0.1	3.0	-	-	 <p>Right hand insert shown</p>
		SAKGR15013	✓					1.5	0.1	3.0	-	-	
		SAKGR15025	✓					1.5	0.2	5.0	-	-	
		SAKGR15027	✓					1.5	0.2	7.0	-	-	
		SAKGR20015	✓					2.0	0.1	5.0	-	-	
		SAKGR20025	✓					2.0	0.2	5.0	-	-	
		SAKGR20027	✓					2.0	0.2	7.0	-	-	
		SAKGR20029	✓					2.0	0.2	9.0	-	-	
		SAKGR25015	✓					2.5	0.1	5.0	-	-	
		SAKGR25025	✓					2.5	0.2	5.0	-	-	
		SAKGR25029	✓					2.5	0.2	9.0	-	-	
		SAKGR30015	✓					3.0	0.1	5.0	-	-	
		SAKGR30019	✓					3.0	0.1	9.0	-	-	
		SAKGR30025	✓					3.0	0.2	5.0	-	-	
	SAKGR30027	✓					3.0	0.2	7.0	-	-		
	SAKGR30029	✓					3.0	0.2	9.0	-	-		
	 <p>Left hand</p>	SAKGL10013	✓					1.0	0.1	3.0	-	-	
		SAKGL15013	✓					1.5	0.1	3.0	-	-	
		SAKGL15025	✓					1.5	0.2	5.0	-	-	
		SAKGL15027	✓					1.5	0.2	7.0	-	-	
		SAKGL20015	✓					2.0	0.1	5.0	-	-	
		SAKGL20025	✓					2.0	0.2	5.0	-	-	
		SAKGL20027	✓					2.0	0.2	7.0	-	-	
		SAKGL20029	✓					2.0	0.2	9.0	-	-	
		SAKGL25015	✓					2.5	0.1	5.0	-	-	
		SAKGL25025	✓					2.5	0.2	5.0	-	-	
		SAKGL25029	✓					2.5	0.2	9.0	-	-	
		SAKGL30015	✓					3.0	0.1	5.0	-	-	
SAKGL30019		✓					3.0	0.1	9.0	-	-		
SAKGL30025		✓					3.0	0.2	5.0	-	-		
SAKGL30027	✓					3.0	0.2	7.0	-	-			
SAKGL30029	✓					3.0	0.2	9.0	-	-			

Insert Specifications 刀片規格

Inserts	Designation	Grade No.					Dimensions (mm)					Drawing	
		CP6025					W	R	L	K	Pitch		
<p>Parting off 切斷加工</p>	<p>Right hand</p>	SAKCR15018	✓					1.5	0.1	8.5	15°	-	<p>Right hand insert shown</p>
		SAKCR20019	✓					2.0	0.1	9.0	15°	-	
		SAKCR25019	✓					2.5	0.1	9.0	15°	-	
	SAKCR30019	✓					3.0	0.1	9.0	15°	-		
	<p>Left hand</p>	SAKCL15018	✓					1.5	0.1	8.5	15°	-	
		SAKCL20019	✓					2.0	0.1	9.0	15°	-	
		SAKCL25019	✓					2.5	0.1	9.0	15°	-	
SAKCL30019		✓					3.0	0.1	9.0	15°	-		
<p>Profiling 輪廓加工</p>	<p>Right hand</p>	SAKPR10053	✓					1.0	0.5	3.0	-	-	
		SAKPR15075	✓					1.5	0.75	5.0	-	-	
		SAKPR20105	✓					2.0	1.0	5.0	-	-	
		SAKPR25125	✓					2.5	1.25	5.0	-	-	
		SAKPR30158	✓					3.0	1.5	8.0	-	-	
	<p>Left hand</p>	SAKPL10053	✓					1.0	0.5	3.0	-	-	
		SAKPL15075	✓					1.5	0.75	5.0	-	-	
		SAKPL20105	✓					2.0	1.0	5.0	-	-	
		SAKPL25125	✓					2.5	1.25	5.0	-	-	
		SAKPL30158	✓					3.0	1.5	8.0	-	-	
<p>Threading 螺紋加工</p>	<p>Right hand</p>	SAKTR20655	✓					2.0	0.05	6.0	55°	0.5~2	
		SAKTR30655	✓					3.0	0.1	6.0	55°	1~3	
		SAKTR20660	✓					2.0	0.05	6.0	60°	0.5~2	
		SAKTR30660	✓					3.0	0.1	6.0	60°	1~3	
	<p>Left hand</p>	SAKTL20655	✓					2.0	0.05	6.0	55°	0.5~2	
		SAKTL30655	✓					3.0	0.1	6.0	55°	1~3	
		SAKTL20660	✓					2.0	0.05	6.0	60°	0.5~2	
		SAKTL30660	✓					3.0	0.1	6.0	60°	1~3	