

For deep hole grooving/parting off


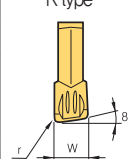
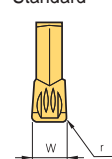
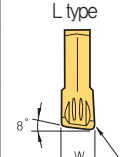
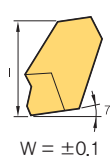
Saw Man

Features of parting insert

- Possible to machine a wide range of workpieces such as steel, cast iron, stainless steel, etc.
- Extended tool life due to low resistance rake angle
- Minimized burr due to minimal Nose R
- Various lead angle available
- Narrow chip curl due to dots on rake surface of insert

Workpiece	Cutting Speed (vc = m/min)									Feed (fn = mm/rev)					
	CVD				PVD				Uncoateds	Cutting width (mm)					
	NC3120	NC3030	NCM325	NC5330	PC230	PC8110	PC5300	PC6510	ST30A	2	3	4	5	6	
SM□□C	80~180			80~180	80~180						0.02~0.15	0.03~0.20	0.08~0.30	0.10~0.4	0.12~0.50
SCM	70~150	70~150	70~150	70~150	70~150						0.02~0.15	0.03~0.20	0.08~0.30	0.10~0.4	0.12~0.50
GC/GCD				50~100				50~100	50~100		0.05~0.12	0.10~0.25	0.10~0.30	0.10~0.35	0.10~0.40
STS			50~120	50~120		50~120	60~140				0.02~0.10	0.03~0.15	0.08~0.25	0.10~0.35	0.12~0.40
Non-ferrous metal (Al, Copper)									200~450		0.05~0.10	0.05~0.20	0.05~0.25	0.05~0.30	0.05~0.35

Insert

Application	Picture	Designation	Coated										Uncoated	Dimensions (mm)			Configuration	
			NC3120	NC3225	NC3030	NCM325	NC5330	PC3035	PC8105	PC8110	PC5300	PC9030	ST30A	W	l	r		
Parting tools		SP 160													1.6	7.8	0.16	   
		180													1.8	9.3	0.16	
		200		●	●	●	●			●	●	●			2.2	9.3	0.2	
		200R			●							●			2.2	9.3	0.2	
		200L										●			2.2	9.3	0.2	
		300		●	●	●	●	●		●	●	●	●		3.1	11.3	0.2	
		300R			●	●	●			●					3.1	11.3	0.2	
		300L				●									3.1	11.3	0.2	
		400		●	●	●	●	●		●	●	●			4.1	11.3	0.25	
		400R				●				●					4.1	11.3	0.25	
		400L				●									4.1	11.3	0.25	
		500				●	●	●		●	●				5.1	11.4	0.3	
		500R													5.1	11.4	0.3	
		500L													5.1	11.4	0.3	
		600				●		●			●				6.4	11.4	0.35	
		600R													6.4	11.4	0.35	
		600L													6.4	11.4	0.35	
800													8.0	14.06	0.4			
900													9.6	14.06	0.45			

● : Stock item



SPB/SPB-S (Blades)



SP

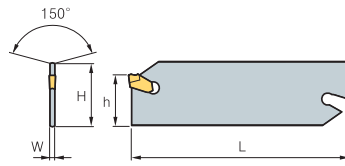


Fig. 1

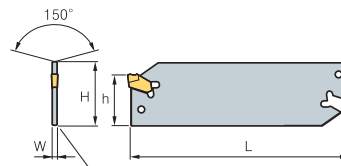
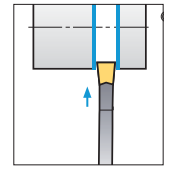





Fig. 2



(mm)

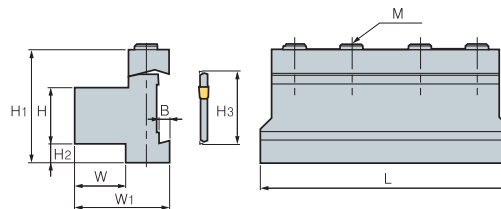
Designation	H	W	L	h	Inserts	Wrench		Fig.	
									
SPB	226	26	1.6	110	21	SP200, 200R/L	SW50L	-	1
	232	32	1.6	150	25	SP200, 200R/L			
	326	26	2.4	110	21	SP300, 300R/L			
	332	32	2.4	150	25	SP300, 300R/L			
	426	26	3.2	110	21	SP400, 400R/L			
	432	32	3.2	150	25	SP400, 400R/L			
	526	26	4.0	110	21	SP500, 500R/L			
	532	32	4.0	150	25	SP500, 500R/L			
	626	26	5.2	110	21	SP600, 600R/L			
	632	32	5.2	150	25	SP600, 600R/L			
SPB-S	226-S	26	1.6	110	21	SP200, 200R/L	-	SW15S (Separately ordered)	2
	232-S	32	1.6	150	25	SP200, 200R/L			
	326-S	26	2.4	110	21	SP300, 300R/L			
	332-S	32	2.4	150	25	SP300, 300R/L			
	426-S	26	3.2	110	21	SP400, 400R/L			
	432-S	32	3.2	150	25	SP400, 400R/L			
	526-S	26	4.0	110	21	SP500, 500R/L			
	532-S	32	4.0	150	25	SP500, 500R/L			
	626-S	26	5.2	110	21	SP600, 600R/L			
	632-S	32	5.2	150	25	SP600, 600R/L			
	832-S	32	6.8	150	25	SP800			
	932-S	32	8	150	25	SP900			
	8526-S	52.6	6.8	150	45	SP800			
	9526-S	52.6	8	150	45	SP900			

 Applicable inserts C59


SMBB (Block)




SPB□□□(-S)
KGTB□□□32



(mm)

Designation	H	W	H3	L	H1	H2	W1	B	M	Blades	Wrench
											
SMBB	1626	16	12	26	86	43	13	30	5.3	3-M6	HW50L
	2026	20	19	26	86	43	9	38	5.3	3-M6	
	2032	20	19	32	100	50	13	38	5.3	4-M6	
	2526	25	23	26	86	43	4	42	5.3	4-M6	
	2532	25	23	32	110	50	8	42	5.3	4-M6	
	3232	32	30	32	110	54	5	48	5.3	4-M6	
	40526	40	41	52.6	130	81.73	22	66	8	4-M8	

 Applicable inserts C59



SPH/SPH-S (Holder)



SP

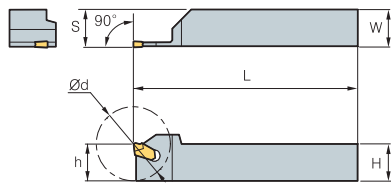


Fig. 1

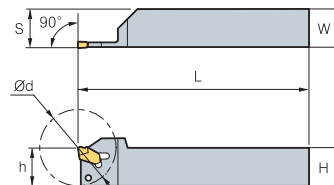
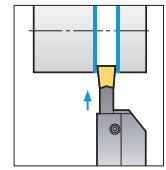





Fig. 2



• R type insert
(mm)

Designation	H = (h)	W	L	Ød	S	Inserts	Wrench		Fig.	
										
SPH	316R/L	16	16	100	32	16.3	SP300, 300R/L	SW50L	-	1
	320R/L	20	20	120	40	20.3	SP300, 300R/L			
	325R/L	25	25	150	50	25.3				
	420R/L	20	20	120	50	20.4	SP400, 400R/L			
	425R/L	25	25	150	60	25.4	SP500, 500R/L			
	520R/L	20	20	120	60	20.5	SP300, 300R/L			
	525R/L	25	25	150	70	25.5	SP500, 500R/L			
SPH	316R/L-S	16	16	100	32	16.3	SP300, 300R/L	-	SW15S (Separately ordered)	2
	320R/L-S	20	20	120	40	20.3	SP300, 300R/L			
	325R/L-S	25	25	150	50	25.3	SP300, 300R/L			
	420R/L-S	20	20	120	50	20.4	SP400, 400R/L			
	425R/L-S	25	25	150	60	25.4	SP400, 400R/L			
	520R/L-S	20	20	120	60	20.5	SP500, 500R/L			
	525R/L-S	25	25	150	70	25.5	SP500, 500R/L			

 Applicable inserts **C59**