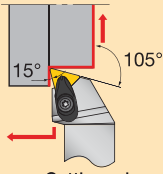
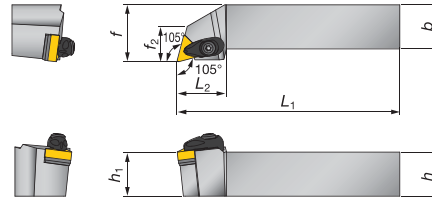


### External Profiling



Cutting edge style **Q**



Right hand (R) shown.

Toolholders Cat. No.	Stock		Dimensions (mm)						Std. Corner $r_{\epsilon}$	Applicable inserts	Page	
	R	L	$h$	$b$	$L_1$	$L_2$	$h_1$	$f$				$f_2$
ATQNR/L2020K16-A	●	●	20	20	125	28	20	25	18	0.8	TN□□1604□□	2-70 ~ 3-8 ~ T-CBN 3-21 ~ T-DIA
ATQNR/L2525M16-A	●	●	25	25	150	28	25	32	20			

\*Recommend clamping torque: 3.0 N·m

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TAC External Toolholders

### Basic Selection Chipbreakers TN□□1604□□-□□

Operation	Precision finishing	Finishing	Finishing to medium cutting	Medium cutting
	Grade	<b>NS730</b>	<b>GT730</b>	<b>T9115</b>
Page	2-70	2-71	2-74	2-77
Chipbreaker	<b>TF</b> 	<b>TSF</b> 	<b>TM</b> 	<b>TH</b> 
$V_c$ (m/min)	200 (150-250)	200 (150-300)	200 (150-300)	220 (150-300)
$a_p$ (mm)	0.3 (0.05-0.5)	1.0 (0.3-1.5)	3.0 (1.0-5.0)	4.0 (3.0-6.0)
$f$ (mm/rev)	0.1 (0.03-0.15)	0.15 (0.08-0.3)	0.3 (0.2-0.5)	0.3 (0.2-0.5)
$r_{\epsilon}$ (mm)	0.4	0.4	0.8	1.2

Operation	Finishing	Finishing to medium cutting	Medium cutting
	Grade	<b>T6020</b>	<b>T6030</b>
Page	2-71	2-74	2-77
Chipbreaker	<b>SS</b> 	<b>SM</b> 	<b>TH</b> 
$V_c$ (m/min)	150 (100-200)	120 (70-150)	120 (70-150)
$a_p$ (mm)	1.0 (0.5-3.0)	2.0 (0.5-4.0)	3.0 (3.0-6.0)
$f$ (mm/rev)	0.1 (0.03-0.15)	0.3 (0.2-0.4)	0.3 (0.2-0.3)
$r_{\epsilon}$ (mm)	0.4	0.8	1.6

Operation	Precision finishing	Finishing	Finishing to medium cutting	Medium cutting
	Grade	<b>BX930</b>	<b>T5115</b>	<b>T5115</b>
Page	3-8	2-72	2-75	2-77
Chipbreaker	<b>T-CBN</b> 	<b>CF</b> 	<b>CM</b> 	<b>CH</b> 
$V_c$ (m/min)	700 (300-1200)	270 (140-400)	270 (150-400)	270 (140-400)
$a_p$ (mm)	0.3 (0.05-0.5)	1.0 (0.5-2.0)	2.0 (1.0-5.0)	4.0 (2.0-6.0)
$f$ (mm/rev)	0.1 (0.05-0.2)	0.15 (0.05-0.2)	0.3 (0.15-0.4)	0.4 (0.2-0.6)
$r_{\epsilon}$ (mm)	0.4	0.4	0.8	1.2

Operation	Precision finishing	Finishing	Finishing to medium cutting
	Grade	<b>DX120</b>	<b>GH110</b>
Page	3-21	2-70	2-77
Chipbreaker	<b>T-DIA With chipbreaker</b> 	<b>O1</b> 	<b>P</b> 
$V_c$ (m/min)	1500 (500-2500)	600 (100-1000)	600 (100-1000)
$a_p$ (mm)	0.5 (0.05-1.0)	0.5 (0.05-1.0)	2.0 (0.5-4.0)
$f$ (mm/rev)	0.1 (0.05-0.2)	0.1 (0.03-0.15)	3.0 (0.2-0.5)
$r_{\epsilon}$ (mm)	0.4	0.4	0.8

Operation	Precision finishing	Finishing	Finishing to medium cutting	Medium cutting
	Grade	<b>BX470</b>	<b>KS20</b>	<b>AH905</b>
Page	3-8	2-71	2-75	2-76
Chipbreaker	<b>T-CBN</b> 	<b>SS</b> 	<b>HMM</b> 	<b>SA</b> 
$V_c$ (m/min)	200 (100-280)	50 (30-70)	50 (20-100)	50 (20-80)
$a_p$ (mm)	0.3 (0.1-0.5)	1.0 (0.5-3.0)	1.5 (0.5-3.0)	2.0 (1.0-4.0)
$f$ (mm/rev)	0.1 (0.05-0.2)	0.1 (0.03-0.15)	0.2 (0.1-0.3)	0.3 (0.2-0.5)
$r_{\epsilon}$ (mm)	0.4	0.4	0.8	0.8

Operation	Precision finishing	Finishing
	Grade	<b>BXM10</b>
Page	3-8	3-8
Chipbreaker	<b>T-CBN</b> 	<b>T-CBN</b> 
$V_c$ (m/min)	200 (150-350)	150 (70-220)
$a_p$ (mm)	0.1 (0.05-0.30)	0.2 (0.05-0.30)
$f$ (mm/rev)	0.1 (0.03-0.18)	0.1 (0.05-0.25)
$r_{\epsilon}$ (mm)	0.4	0.4

For other machining types, see "Selection System"



● : Stocked items.