

MITSUBISHI

MITSUBISHI CARBIDE

TOOLS NEWS

B088G

For Swiss type lathes (Opposite Tool Post)

For front turning

DIMPLE SLEEVE HOLDER



**CNC Lathes
Effective in outer diameter
copying on the second spindle
(back spindle).**

For Swiss type lathes (Opposite Tool Post)

For front turning

DIMPLE SLEEVE HOLDER

Features

Shank Diameter

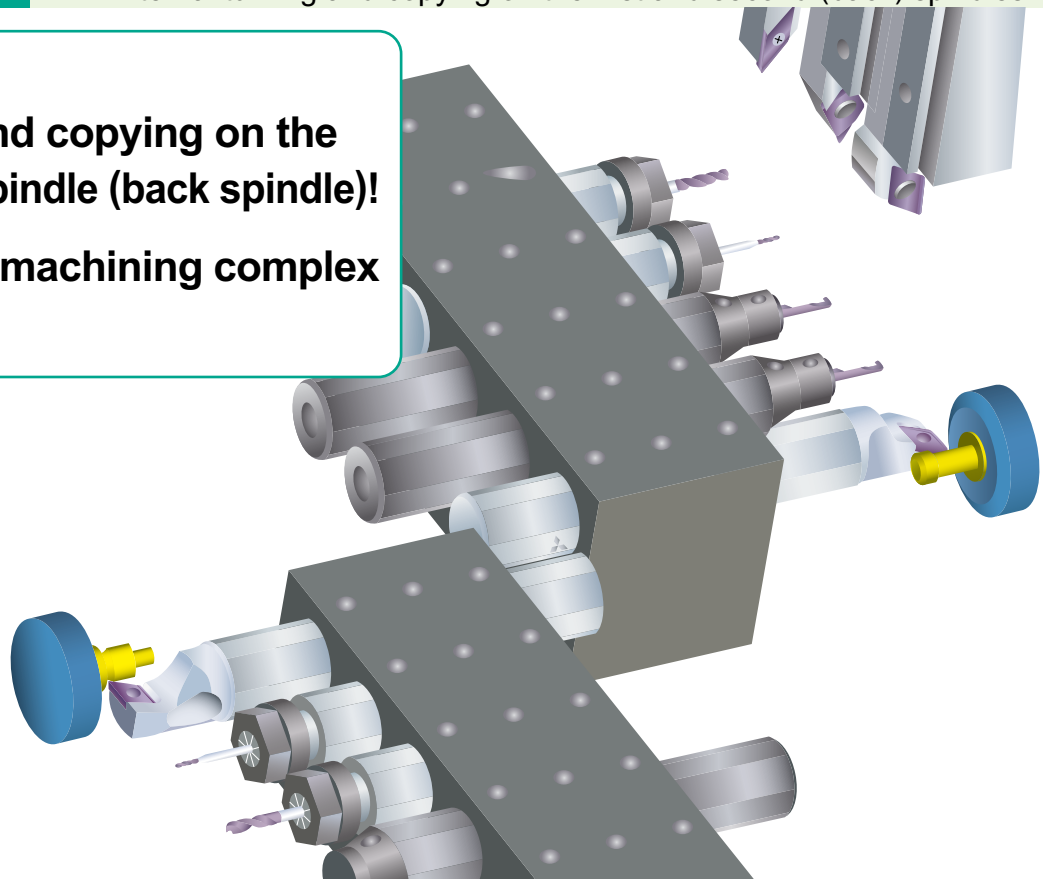
ø15.875, ø19.05, ø20, ø22, ø25.4

Applications

External turning and copying on the first and second (back) spindles

USAGE !

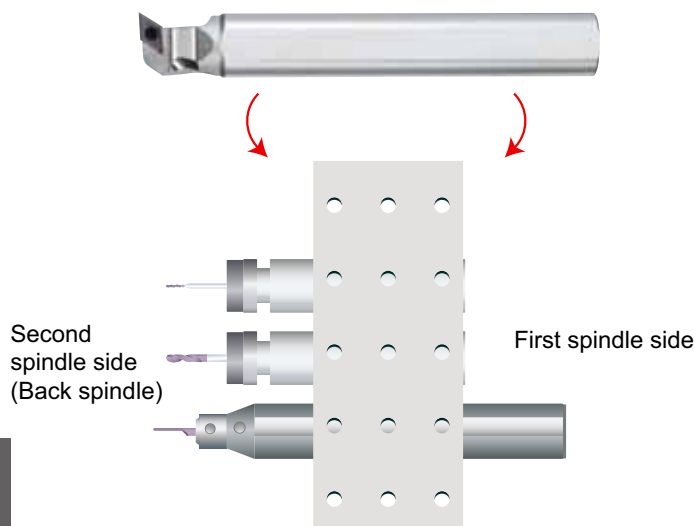
1. Facing and copying on the second spindle (back spindle)!
2. Tools for machining complex parts!



Easy Installation

Can be installed from both the front and back sides of tool posts due to the head diameter being smaller than the shank diameter.

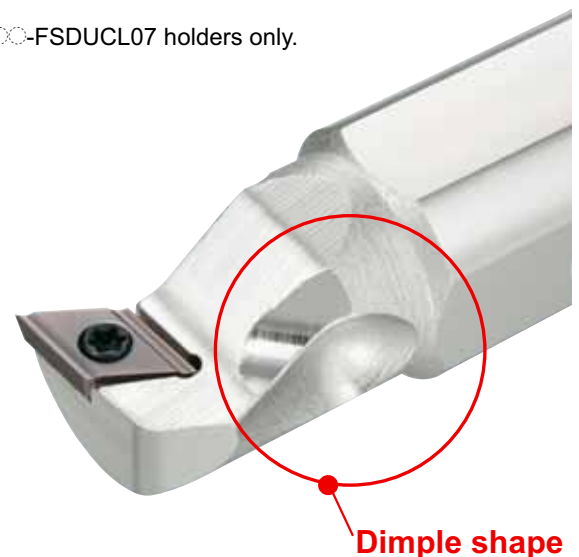
*SH○○○-FSDUCL07 holders only.





Excellent Vibration Resistance

Use of a dimple head shape for reliable cutting even with long overhangs.

*SH○○○-FSDUCL07 holders only.



Holders

Order Number		Stock	Insert Number	Dimensions (mm)							 Clamp Screw	 Wrench
				D4	L1	L2	H1	F1	S1	F2		
SH16H-FSDUCL07	●	0702	DCET DCGT DCGW DCMT DCMW	15.875	100	20	14	7.75	4.2	0.75	TS254	TKY08R
19K-FSDUCL07	●			19.05	125	20	17	9.25	4.2	0.75	TS254	TKY08R
20K-FSDUCL07	●			20	125	20	18	9.75	4.2	0.75	TS254	TKY08R
22K-FSDUCL07	●			22	125	20	20	10.75	4.2	0.75	TS254	TKY08R
25M-FSDUCL07	●			25.4	150	20	23	12.25	4.2	0.75	TS254	TKY08R
SH16H-FSDUCL11	●	11T3	DCET DCGT DCGW DCMT DCMW NP-DCGW NP-DCMT NP-DCMW	15.875	100	20	15	7.75	6.4	0.75	TS43	TKY15R
19K-FSDUCL11	●			19.05	125	20	17	9.25	6.4	0.75	TS43	TKY15R
20K-FSDUCL11	●			20	125	20	18	9.75	6.4	0.75	TS43	TKY15R
22K-FSDUCL11	●			22	125	20	20	10.75	6.4	0.75	TS43	TKY15R
25M-FSDUCL11	●			25.4	150	20	23	12.25	6.4	0.75	TS43	TKY15R

(Note 1) Handed type insert for use on right hand tool holders only.

(Note 2) Insert photo, the letters show the chip breaker style and the figures show the insert dimensions.


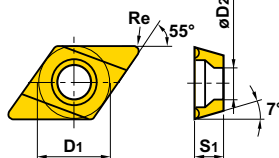

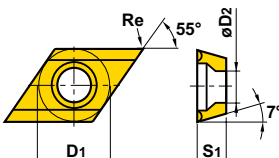

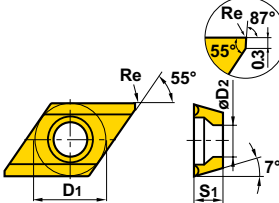

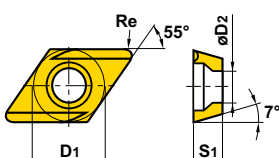

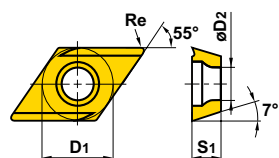
● : Inventory maintained.

Recommended Cutting Conditions


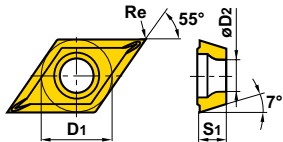

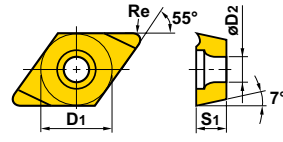

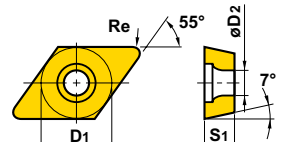

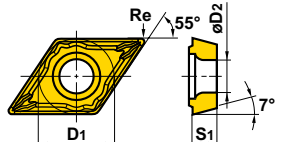

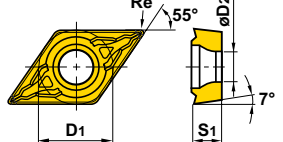

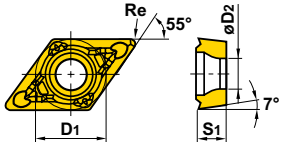

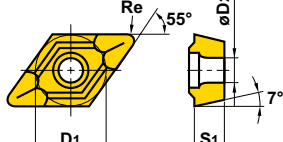
	Work Material	Grade	Cutting Speed (m/min)	Feed (mm/rev)
P	Carbon Steel · Alloy Steel	VP15TF	100 (50–150)	0.08 (0.01–0.15)
	Free Cutting Steel	VP15TF	110 (30–180)	0.08 (0.01–0.15)
		NX2525	150 (50–250)	0.08 (0.01–0.15)
M	Stainless Steel	VP15TF	80 (50–120)	0.06 (0.02–0.1)
N	Non-Ferrous Metal	HTi10	150 (70–230)	0.09 (0.03–0.15)

For front turning **DIMPLE SLEEVE HOLDER**

INSERTS


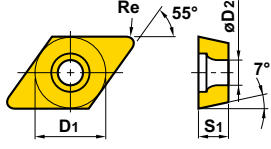

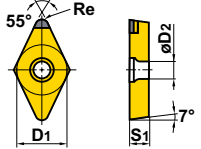

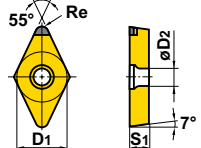

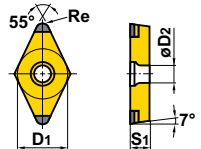

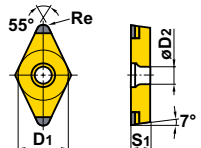

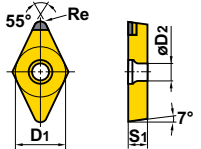
Shape	Order Number	Class	Material								Dimensions (mm)				Geometry						
			Coated	Cermet	Coated Cermet	Carbide	CBN	PCD	D1	S1	Re	D2									
			UE6020	US7020	US735	VP10RT	VP15TF	NX2525	AP25N	VP25N	VP45N	HT10	RT9010	MB8025	MB825	MD220					
R-SR Breaker  Medium Cutting	DCET0702V3R-SR	E				●	●					●					6.35	2.38	0.03	2.8	
	070201R-SR	E				●	●					●					6.35	2.38	0.1	2.8	
	070202R-SR	E				●	●					●					6.35	2.38	0.2	2.8	
	070204R-SR	E				●	●					●					6.35	2.38	0.4	2.8	
	11T3V3R-SR	E				●	●					●					9.525	3.97	0.03	4.4	
	11T301R-SR	E				●	●					●					9.525	3.97	0.1	4.4	
	11T302R-SR	E				●	●					●					9.525	3.97	0.2	4.4	
11T304R-SR	E				●	●					●					9.525	3.97	0.4	4.4		
R-SN Breaker  Medium Cutting	DCET070200R-SN	E				●	●					●					6.35	2.38	0	2.8	
	0702V3R-SN	E				●	●					●					6.35	2.38	0.03	2.8	
	070201R-SN	E				●	●					●					6.35	2.38	0.1	2.8	
	070202R-SN	E				●	●					●					6.35	2.38	0.2	2.8	
	070204R-SN	E				●	●					●					6.35	2.38	0.4	2.8	
	11T300R-SN	E				●	●					●					9.525	3.97	0	4.4	
	11T3V3R-SN	E				●	●					●					9.525	3.97	0.03	4.4	
11T301R-SN	E				●	●					●					9.525	3.97	0.1	4.4		
11T302R-SN	E				●	●					●					9.525	3.97	0.2	4.4		
11T304R-SN	E				●	●					●					9.525	3.97	0.4	4.4		
RW-SN Breaker  Medium Cutting (Wiper)	DCET0702V3RW-SN	E				●											6.35	2.38	0.03	2.8	
	11T3V3RW-SN	E				●											9.525	3.97	0.03	4.4	
R-SN Breaker  Medium Cutting	DCGT0702V3R-SN	G				●											6.35	2.38	0.03	2.8	
	070201R-SN	G				●											6.35	2.38	0.1	2.8	
	070202R-SN	G				●											6.35	2.38	0.2	2.8	
	11T3V3R-SN	G				●											9.525	3.97	0.03	4.4	
	11T301R-SN	G				●											9.525	3.97	0.1	4.4	
	11T302R-SN	G				●											9.525	3.97	0.2	4.4	
11T304R-SN	G				●											9.525	3.97	0.4	4.4		
R-SS Breaker  Light Cutting	DCGT0702V3R-SS	G				●											6.35	2.38	0.03	2.8	
	070201R-SS	G				●											6.35	2.38	0.1	2.8	
	070202R-SS	G				●											6.35	2.38	0.2	2.8	
	11T3V3R-SS	G				●											9.525	3.97	0.03	4.4	
	11T301R-SS	G				●											9.525	3.97	0.1	4.4	
11T302R-SS	G				●											9.525	3.97	0.2	4.4		

*With a RW-SW breaker (wiper insert), the wiper effect does not work when copying, corner radius machining and facing.

Shape	Order Number	Class	Coated		Cermet	Coated Cermet	Carbide	CBN	PCD	Dimensions (mm)				Geometry							
			UE6020	US7020						US735	VP10RT	VP15TF	NX2525		AP25N	VP25N	VP45N	HT10	RT9010	MB8025	MB825
AM Breaker 	DCGT070202-AM	G			●												6.35	2.38	0.2	2.8	
	070204-AM	G			●												6.35	2.38	0.4	2.8	
	11T302-AM	G			●												9.525	3.97	0.2	4.4	
	11T304-AM	G			●												9.525	3.97	0.4	4.4	
Medium Cutting																					
R-F Breaker 	DCGT070202R-F	G			●●	□	●										6.35	2.38	0.2	2.8	
	070204R-F	G			●●	□	●										6.35	2.38	0.4	2.8	
	11T302R-F	G			●●	□	●										9.525	3.97	0.2	4.4	
	11T304R-F	G			●●	□	●										9.525	3.97	0.4	4.4	
Finish Cutting																					
Flat top 	DCGW070200	G			●												6.35	2.38	0	2.8	
	0702V5	G			●												6.35	2.38	0.05	2.8	
	11T300	G			●												9.525	3.97	0	4.4	
	11T3V5	G			●												9.525	3.97	0.05	4.4	
Medium Cutting																					
FV Breaker 	DCMT070202-FV	M	●		●	●											6.35	2.38	0.2	2.8	
	070204-FV	M	●		●	●											6.35	2.38	0.4	2.8	
	11T304-FV	M	●		●	●											9.525	3.97	0.4	4.4	
	11T308-FV	M	●		●	●											9.525	3.97	0.8	4.4	
Finish Cutting																					
SV Breaker 	DCMT070202-SV	M	●●●	●●	●	●											6.35	2.38	0.2	2.8	
	070204-SV	M	●●●	●●	●	●											6.35	2.38	0.4	2.8	
	070208-SV	M	●●●	●●	●	●											6.35	2.38	0.8	2.8	
	11T302-SV	M	●●●	●●	●	●											9.525	3.97	0.2	4.4	
	11T304-SV	M	●●●	●●	●	●											9.525	3.97	0.4	4.4	
	11T308-SV	M	●●●	●●	●	●											9.525	3.97	0.8	4.4	
Light Cutting																					
MV Breaker 	DCMT070202-MV	M	●●●	●●	●	●											6.35	2.38	0.2	2.8	
	070204-MV	M	●●●	●●	●	●											6.35	2.38	0.4	2.8	
	070208-MV	M	●●●	●●	●	●											6.35	2.38	0.8	2.8	
	11T302-MV	M	●●●	●●	●	●											9.525	3.97	0.2	4.4	
	11T304-MV	M	●●●	●●	●	●											9.525	3.97	0.4	4.4	
	11T308-MV	M	●●●	●●	●	●											9.525	3.97	0.8	4.4	
Medium Cutting																					
Standard Breaker 	DCMT070202	M	●	●	●	●											6.35	2.38	0.2	2.8	
	070204	M	●	●	●	●											6.35	2.38	0.4	2.8	
	070208	M		□	●	●											6.35	2.38	0.8	2.8	
	11T302	M	●	●	●	●											9.525	3.97	0.2	4.4	
	11T304	M	●	●	●	●											9.525	3.97	0.4	4.4	
	11T308	M	●	●	●	●											9.525	3.97	0.8	4.4	
Medium Cutting																					


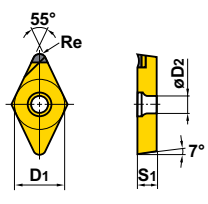

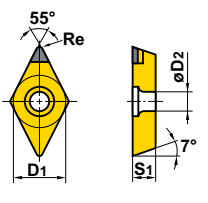
For front turning **DIMPLE SLEEVE HOLDER**

INSERTS

Shape	Order Number	Class	Material										Dimensions (mm)				Geometry				
			Coated	Cermet	Coated Cermet	Carbide	CBN	PCD	D1	S1	Re	D2									
			UE6020	US7020	US735	VP10RT	VP15TF	NX2525	AP25N	VP25N	VP45N	HT10	RT9010	MB8025	MB825	MD220					
	DCMW070202	M															6.35	2.38	0.2	2.8	
	070204	M										●					6.35	2.38	0.4	2.8	
	11T304	M										●					9.525	3.97	0.4	4.4	
	11T308	M										●					9.525	3.97	0.8	4.4	
	NP-DCMW070204G	M												●			6.35	2.38	0.4	2.8	 <p>*Last letter of insert number G: For General Poupose</p>
	11T304G	M												●			9.525	3.97	0.4	4.4	
	NP-DCGW070202G	G												●			6.35	2.38	0.2	2.8	 <p>*Last letter of insert number G: For General Poupose</p>
	070204G	G												●			6.35	2.38	0.4	2.8	
	070208G	G												●			6.35	2.38	0.8	2.8	
	11T302G	G												●●			9.525	3.97	0.2	4.4	
	11T304G	G												●●			9.525	3.97	0.4	4.4	
	NP-DCGW11T304G2	G												●			9.525	3.97	0.4	4.4	 <p>*Last letter of insert number G: For General Poupose</p>
	11T308G2	G												●			9.525	3.97	0.8	4.4	
	TNP-DCGW11T304G2	G												●			9.525	3.97	0.4	4.4	 <p>*Last letter of insert number G: For General Poupose</p>
	11T308G2	G												●			9.525	3.97	0.8	4.4	
	NP-DCGW11T308GWJR	G												●			9.525	3.97	0.8	4.4	

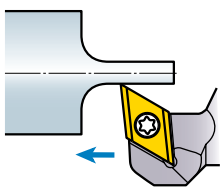
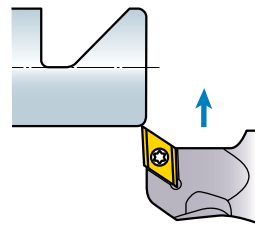
*1 With a CBN wiper insert, wiper effect does not work in copying, corner radius machining and facing.

*2 The order number is for a 10-insert pack. Please specify order number, grade and quantity.

Shape	Order Number	Class	Coated		Cermet	Coated Cermet	Carbide	CBN	PCD	Dimensions (mm)				Geometry			
			UE6020	US7020	US735	VP10RT	VP15TF	NX2525	AP25N	VP25N	VP45N	HT10	RT9010		MB8025	MB825	MD220
NEW PETIT CUT (PCD) 	NP-DCMT070202R-F	M							●	6.35	2.38	0.2	2.8				
	070204R-F	M							●	6.35	2.38	0.4	2.8				
	11T302R-F	M								●	9.525	3.97	0.2		4.4		
	11T304R-F	M								●	9.525	3.97	0.4		4.4		
Finish Cutting																	
(CBN, PCD) 	DCMW070202	M							□ ●	6.35	2.38	0.2	2.8				
	070204	M							□ ●	6.35	2.38	0.4	2.8				
	11T302	M							□ ●	9.525	3.97	0.2	4.4				
	11T304	M							● ●	9.525	3.97	0.4	4.4				
Finish Cutting																	

For front turning ***DIMPLE SLEEVE HOLDER***

Application Example

Tool	SH19K-FSDUCL11	SH20K-FSDUCL07	
Insert	DCGT11T302R-SN	DCET070202R-SN	
Grade	VP15TF	VP15TF	
Workpiece	JIS SCM415 	JIS SUS303 	
Cutting Conditions	Cutting Speed (m/min)	34	63
	Feed (mm/rev)	0.05	0.02
	Depth of Cut (mm)	0.6	0.3
Coolant	Oil	Oil	
Result	Excellent machining with no vibration when compared to a competitors existing product.	Tool life doubled compared to competitors.	

For Your Safety

●Don't touch inserts and chips without gloves. ●Please machine within the recommended application range, and exchange expired tools with new ones in advance of breakage. ●Please use safety cover and wear safety glasses. ●When using compounded cutting oils, please take fire preventions. ●When attaching inserts or spare parts, please use the attached wrench or spanner.

MITSUBISHI MATERIALS CORPORATION



The Scope of the Registration:
Design, Development and
Production of General
Carbide Tools and Carbide
Blanks



The Scope of the Registration:
Design, Development and
Production of Cutting Tools,
Wear-resistant Tools, Rock
Drilling Tools, Cemented
Carbide Blanks and Coated
Products



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(Tools specifications subject to change without notice.)