

Steel  
shank type  
Expansion

Chatter resistant boring bars

***SCREW CLAMP  
DIMPLE BAR***

**Highly rigid and light-weight heads prevent vibration and achieve good surface finish.**

- Heavy metal shank and steel shank having coolant hole.
- Excellent chipbreakers for challenging boring applications
- Expansion of *MIRACLE*® coated *VP15TF* insert series

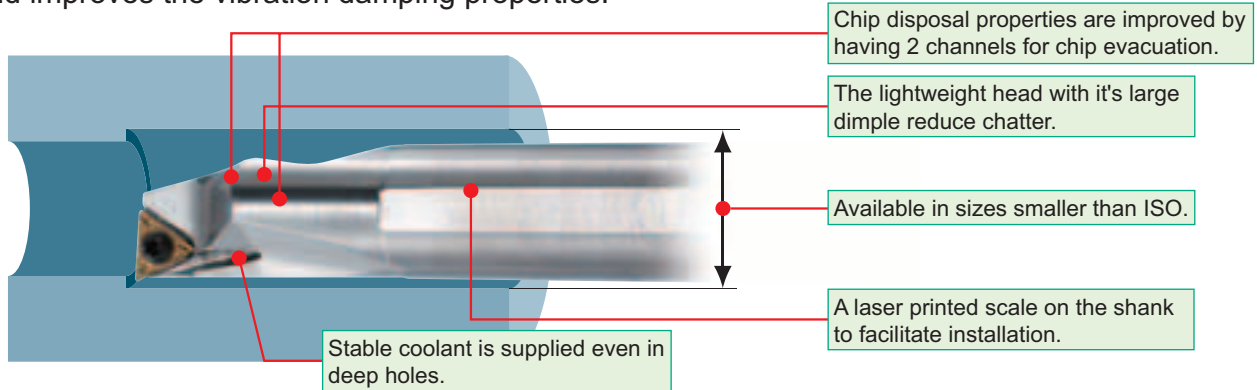


# Chatter resistant boring bars

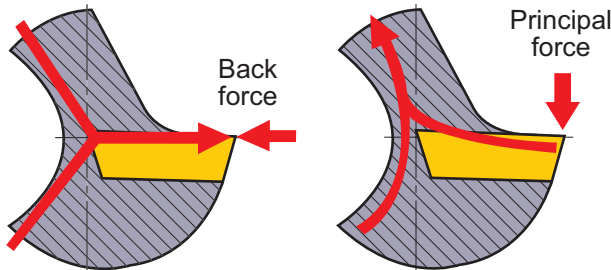
## SCREW CLAMP DIMPLE BAR

### Features

Using computer simulation a highly rigid & lightweight head configuration has been designed that reduces chattering and improves the vibration damping properties.



#### Deflection resistance

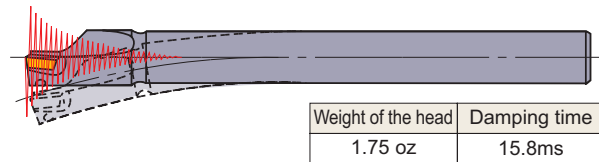


The Dimple bar design effectively balances the principal and back forces, and reduces deflection by up to 17%.

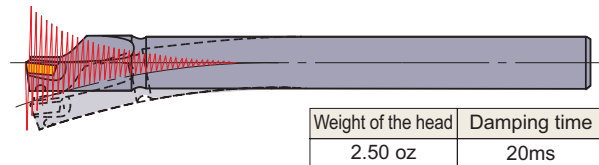
Boring bars	Deflection
Dimple bar	.0011inch
Conventional bar	.0013inch

#### Vibration resistance

##### Screw clamp Dimple bar



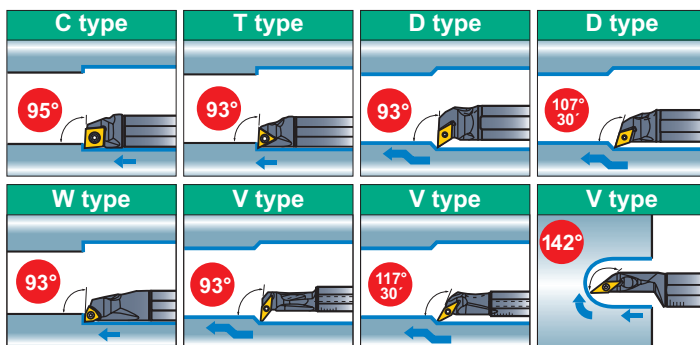
##### Conventional bar



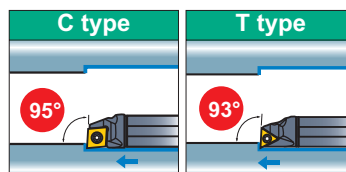
By reducing the weight of the head, the damping properties are increased.

#### Standard insert geometries offered in a wide variety of grades.

##### Heavy metal shank type



##### Steel shank type

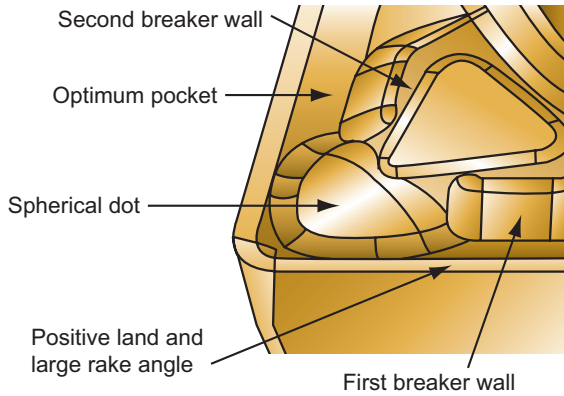


## Features of *MV·SV* breaker

Newly developed, new-concept molded breakers for the Heavy Metal and Steel Shank Screw Dimple Bars. Stable chip control and sharp cutting can be applied to wide cutting areas.

### ● *MV* beaker for medium cutting

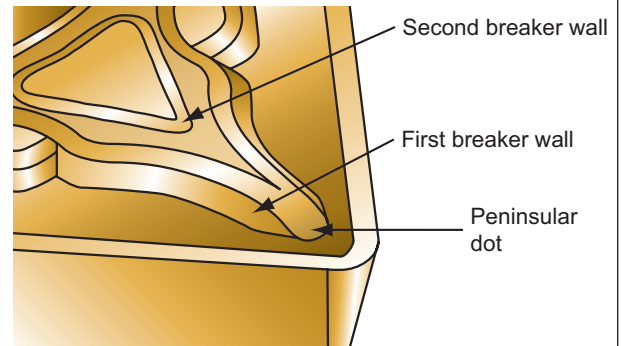
A combination of spherical dots and two-stage breaker walls achieves stable chip control for depths of cut of .031-.079 inch.



The large rake angle enables sharp cutting and longer tool life.

### ● *SV* beaker for light cutting

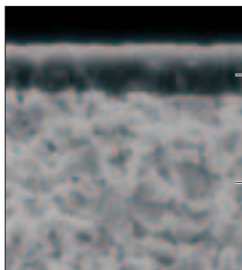
A combination of "peninsular" dots and two-stage breaker walls makes sure of chip control even for depths of cut of .039 inch or below.



The large rake angle enables sharp cutting and excellent surface finish.

## Features of the Grades

### ● MIRACLE coating grade *VP15TF*



"MIRACLE" coating  
(Al,Ti)N

Cemented carbide  
substrate  
TF15

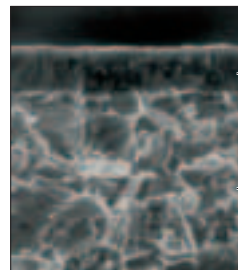
#### (Al, Ti)N "MIRACLE" coating

Heat resistance and adhesion strength have substantially increased, compared to conventional coatings. Tool life has become much longer.

#### TF15 micro-grain cemented carbide substrate

Micro-grain cemented carbide with good balance of wear and fracture resistance. TF15 prevents fracturing and achieves stable machining.

### ● MIRACLE coating grade *VP45N*



"MIRACLE" coating  
(Al,Ti)N

Highly tough  
cermet substrate  
NX4545

#### (Al, Ti)N "MIRACLE" coating

Heat resistance and adhesion strength have substantially increased, compared to conventional coatings. Tool life has become much longer.

#### Highly tough cermet substrate NX4545

Toughness has increased compared with existing cermet. Stable boring.

### ● CVD coating grade *UE6020*



Ti compound lamination  
Micro grain Al<sub>2</sub>O<sub>3</sub>

Fibrous TiCN  
Cemented carbide  
substrate with tough  
surface layer

#### "Even Coating" Technology

A very smooth and stable structure of a special titanium compound lamination has high resistance to adhesive fracture and peeling.

#### Triple-layer structure

Coating layers, including a surface, are triple-layer structure. An outer layer is a smooth layer of aluminum oxide (Al<sub>2</sub>O<sub>3</sub>). Al<sub>2</sub>O<sub>3</sub> has high-heat resistance and provides high performance in high-speed machining. An inner layer is fibrous crystalline titanium, which has good balance of wear and fracture resistance.

#### Special cemented carbide substrate

The substrate has a hard core and a very tough surface layer.

### ● CVD coating grade *US7020*



TiN  
Micro grain Al<sub>2</sub>O<sub>3</sub>

Fibrous TiCN

Cemented carbide  
substrate with tough  
surface layer

#### Thin layer coating of fibrous TiCN + Micrograin Al<sub>2</sub>O<sub>3</sub>

This thin layer coating with high adhesion strength is less liable to peeling than other grades for cutting steels.

#### Cemented carbide substrate with tough surface layer





Cemented carbide substrate, which has a hard core and a tougher surface layer than existing grades, has reduced chipping of the cutting edge and plastic deformation in high-speed cutting of stainless steels.

#### Small honing design

Small honing design enables sharper cutting than other grades for cutting steels, preventing welding of a workpiece to the cutting edge.

# SCREW CLAMP DIMPLE BAR

## Cutting Performance

I/d	Cutting speed	DIMPLE BAR	Competitor boring bar (using a cermet grade)
Hole depth =5 Shank dia.	262 SFM	Excellent surface finish 	Poor surface finish 
Hole depth =4 Shank dia.	524 SFM	Excellent surface finish 	Surface shows chatter marks 

**Heavy metal shank**

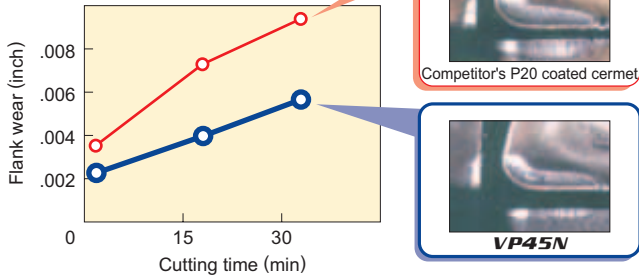
Cutting conditions  
Workpiece : ANSI 4140 (185HB)  
Depth of cut : .020 inch  
Feed : .004 IPR  
Wet cutting

DIMPLE BAR  
Holder : M-FSCLPR-103-C  
Insert : CPMH321MV  
Grade : AP25N

## Cutting Performance of VP15TF · VP45N · UE6020 · US7020

### VP45N

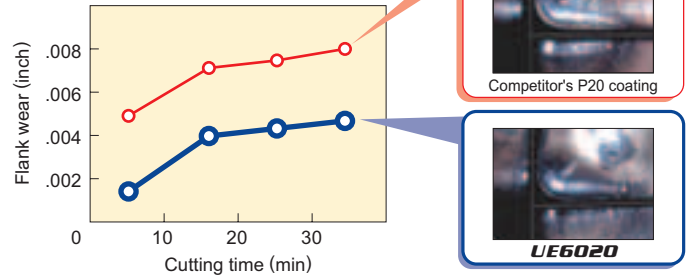
VP45N provides superior wear resistance in cutting of mild steels.



Holder : M-FSCLPR-103-C Workpiece : ANSI 4140  
Insert : CPMH321MV Boring  
Cutting speed : 524 SFM Overhang : 2.52 inch (l/d=4)  
Feed : .004 IPR Wet cutting  
Depth of cut : .039 inch

### UE6020

UE6020 provides superior wear resistance in cutting of general steels.




Holder : M-FSCLPR-123-C Workpiece : ANSI 4140  
Insert : CPMH321MV Boring  
Cutting speed : 590 SFM Overhang : 1.89 inch (l/d=3)  
Feed : .006 IPR Wet cutting  
Depth of cut : .039 inch

### VP15TF

VP15TF exhibits excellent fracture resistance.

Feed (IPR)	.003	.004	.008	.012
<b>VP15TF</b>	○	○	○	○
Competitor's P20 coating	○	○	○	○
Competitor's P20 coated cermet	○	○	○	○

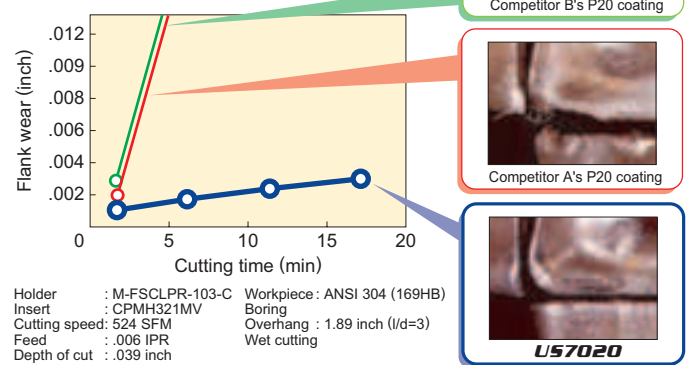
○ Good × Fracture



Holder : M-FSCLCR-103-C Workpiece : ANSI 4140  
Insert : CPMH321MV Interrupted facing  
Cutting speed : 394 SFM Overhang : 1.89 inch (l/d=3)  
Feed : Var IPR Wet cutting  
Depth of cut : .039 inch

### US7020

US7020 provides superior wear resistance in cutting of stainless steels.

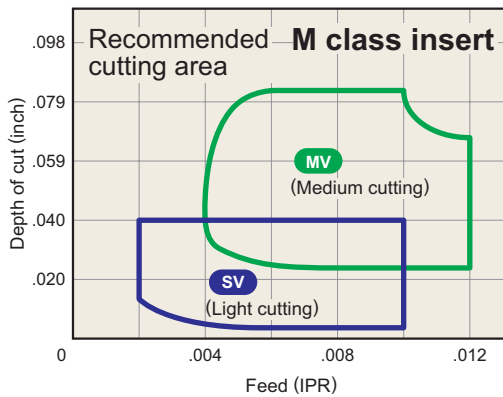


Holder : M-FSCLPR-103-C Workpiece : ANSI 304 (169HB)  
Insert : CPMH321MV Boring  
Cutting speed : 524 SFM Overhang : 1.89 inch (l/d=3)  
Feed : .006 IPR Wet cutting  
Depth of cut : .039 inch

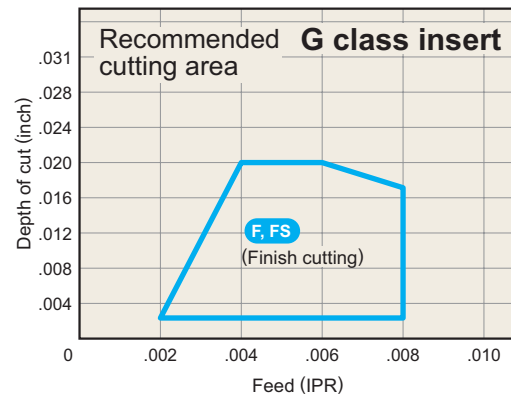
### Recommended Use of the Holder

Insert Type	Page	Holder	Lead Angle	Shank Material	Economical	Cutting Edge Strength	Copying	Curved Faces Deep Faces
80°Rhombic	5	M-FSCLC/P...C	95°	Heavy metal		◎		
	5	S-FSCLP...C	95°	Steel		◎		
Triangular	7	M-FSTUP...C	93°	Heavy metal	◎			
	7	S-FSTUP...C	93°	Steel	◎			
55°Rhombic	9	M-FSDUC...C	93°	Heavy metal			◎	
	11	M-FSDQC...C	107°30'	Heavy metal			◎	
Trigon	13	M-FSWUB/P...C	93°	Heavy metal	◎	◎		
35°Rhombic	15	M-FSVUB/C...C	93°	Heavy metal			◎	
		M-FSVPB/C...C	117°30'	Heavy metal			◎	
	16	M-FSVJB/C...C	142°	Heavy metal				◎

### Recommended Use of the Breakers



Cutting conditions  
 Insert : CPMH321MV, SV Workpiece : ANSI 5020  
 Cutting speed : 492 SFM Wet cutting



Cutting conditions  
 Insert : CCGH21.51LF Workpiece : ANSI 4140  
 Cutting speed : 492 SFM Wet cutting

### Recommended Cutting Conditions

Workpiece Material	Cutting Mode	Breaker	Recom- mendation	Grade	Cutting Speed (SFM)	L/D≤3 (Steel shank), L/D≤3 (Heavy metal shank)		L/D=4-5 (Steel shank), L/D=4-6 (Heavy metal shank)	
						Feed (IPR)	D.O.C. (inch)	Feed (IPR)	D.O.C. (inch)
P Mild steel <180HB	Finishing	F/FS	①	NX2525	555 (390-720)	.004 (.002-.006)	-.020	.004 (.002-.006)	-.020
				②	VP45N	460 (295-620)	.008 (.004-.010)	-.040	.006 (.002-.008)
	Light	SV	②	VP15TF	590 (425-755)	.008 (.004-.010)	-.040	.006 (.002-.008)	-.040
				①	VP45N	425 (260-590)	.010 (.006-.014)	-.080	.008 (.006-.010)
	Medium	MV	②	VP15TF	525 (360-690)	.010 (.006-.014)	-.080	.008 (.006-.010)	-.060
				①	VP15TF	460 (295-620)	.004 (.002-.006)	-.020	.004 (.002-.006)
Carbon steel Alloy steel 180-280HB	Finishing	F/FS	②	NX2525	425 (260-590)	.004 (.002-.006)	-.020	.004 (.002-.006)	-.020
				①	VP15TF	425 (260-590)	.008 (.004-.010)	-.040	.006 (.002-.008)
	Light	SV	②	UE6020	460 (295-620)	.008 (.004-.010)	-.040	.006 (.002-.008)	-.040
				①	VP15TF	390 (230-555)	.010 (.006-.014)	-.080	.008 (.006-.010)
	Medium	MV	②	UE6020	425 (260-590)	.010 (.006-.014)	-.080	.008 (.006-.010)	-.060
				①	VP15TF	490 (360-620)	.004 (.002-.006)	-.020	.004 (.002-.006)
M Stainless steel 180-280HB	Finishing	F/FS	①	VP15TF	490 (360-620)	.004 (.002-.006)	-.020	.004 (.002-.006)	-.020
				②	US7020	490 (360-620)	.008 (.004-.010)	-.040	.006 (.002-.008)
	Light	SV	②	VP15TF	425 (295-555)	.008 (.004-.010)	-.040	.006 (.002-.008)	-.040
				①	US7020	460 (330-590)	.008 (.006-.010)	-.080	.008 (.006-.010)
Medium	MV	②	VP15TF	390 (260-525)	.008 (.006-.010)	-.080	.008 (.006-.010)	-.040	
			①	HTI10	425 (295-525)	.006 (.004-.008)	-.020	.006 (.004-.008)	-.020
K Cast iron Tensile strength <350MPa	Finishing	F/FS	①	HTI10	425 (295-525)	.006 (.004-.008)	-.020	.006 (.004-.008)	-.020
				②	US7020	295 (195-390)	.008 (.006-.010)	-.080	.008 (.006-.010)
H Heat treated steel 35-65HRC	Finishing	No breaker	①	MB825	330 (260-655)	.004 (.002-.006)	-.006	.004 (.002-.006)	-.004
N Aluminium Alloy	Finishing	F/FS	①	HTI10	985(655-1310)	.004 (.002-.006)	-.020	.004 (.002-.006)	-.020
				No breaker	①	MD220	655 (490-820)	.004 (.002-.006)	-.080

\* If the SCREW CLAMP DIMPLE BAR vibrates, reduce cutting speed to 70% of the above.

## SCREW CLAMP DIMPLE BAR

### HOLDERS

Order Number		Stock		Insert Number	Dimensions (inch)						Min. Cutting Diameter (inch) D1	Standard Corner Radius (inch) Re	Finish		Light	
		R	L		D4	L1	L2	F1	H1	RR°			Insert Screw	Wrench		
<b>M-FSCLC/P</b>																
<b>M-FSCLCR/L-052-C</b>		●	●	CCMH CCGH NP-CCMB NP-CCMH	21.5	.313	5.000	.703	.196	.281	12	.390	.016	TS253	TKY08F	
<b>M-FSCLPR/L-062.5-C</b>		●	●	CPMH NP-CPMB NP-CPMH	2.51.5	.375	6.000	.844	.227	.336	5	.450	.016	TS3D	TKY10F	
<b>-082.5-C</b>		●	●		2.51.5	.500	8.000	1.125	.290	.461	4	.580	.016	TS3D	TKY10F	
<b>-103-C</b>		●	●		32	.625	10.000	1.406	.352	.586	3.5	.700	.016	TS4D	TKY15F	

(Note) When using inserts with right and left hand chip breakers, please use left hand inserts for right hand holders and right hand inserts for left hand holders.

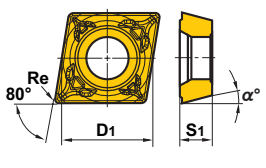
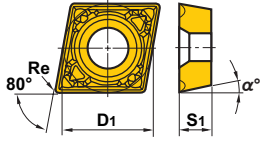
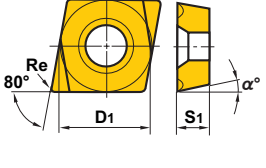
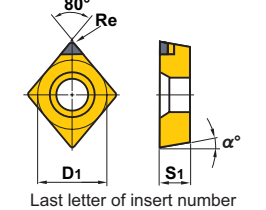
Order Number		Stock		Insert Number	Dimensions (inch)						Min. Cutting Diameter (inch) D1	Standard Corner Radius (inch) Re	Finish		Light	
		R	L		D4	L1	L2	F1	H1	RR°			Insert Screw	Wrench		
<b>S-FSCLP</b>																
<b>S-FSCLPR/L-062.5-C</b>		○	○	CPMH NP-CPMB NP-CPMH	2.51.5	.375	6.000	.844	.227	.336	5	.450	.016	TS3D	TKY10F	
<b>-082.5-C</b>		○	○		2.51.5	.500	8.000	1.125	.290	.461	4	.580	.016	TS3D	TKY10F	
<b>-103-C</b>		○	○		32	.625	10.000	1.406	.352	.586	3.5	.700	.016	TS4D	TKY15F	
<b>-123-C</b>		○	○		32	.750	10.000	1.688	.414	.711	2	.825	.016	TS4D	TKY15F	
<b>-163-C</b>		○	○		32	1.000	12.000	2.250	.598	.937	0	1.200	.016	TS4D	TKY15F	

(Note) When using inserts with right and left hand chip breakers, please use left hand inserts for right hand holders and right hand inserts for left hand holders.

(Note) Insert photo, letters show chip breaker style, figures show inscribed circle.

● : Inventory maintained. ○ : Inventory maintained. (Available Winter 2006) ★ : Inventory maintained in Japan.  
□ : Non stock, produced to order only.

INSERTS

Application	Order Number	Stock Grade										Dimensions (inch)				Geometry
		Coated			MIRACLE Coated		Cermet	Coated Cermet	Carbide	CBN	PCD	D1	S1	Re	$\alpha^\circ$	
		UE6020	US7020	US735	VP15TF	VP45N	NX2525	AP25N	HT110	MB825	MD220					
Light Cutting	CCMH21.50.5SV	●	★	●	★	★	★					.250	.094	.008	7	<b>CCMH...SV</b> <b>CPMH...SV</b> 
	21.51SV	●	★	●	★	★	★					.250	.094	.016	7	
	CPMH2.51.50.5SV	●	★	●	★	●	★					.313	.094	.008	11	
	2.51.51SV	●	★	●	★	●	★					.313	.094	.016	11	
	320.5SV	●	★	●	★	●	★					.375	.125	.008	11	
	321SV	●	★	●	★	●	★					.375	.125	.016	11	
	322SV	●	★	●	★	●	★					.375	.125	.031	11	
Medium Cutting	CCMH21.50.5MV	●	●	●	★	●	★	●				.250	.094	.008	7	<b>CCMH...MV</b> <b>CPMH...MV</b> 
	21.51MV	●	●	●	●	●	★	●				.250	.094	.016	7	
	CPMH2.51.51MV	●	●	●	●	●	★	●				.313	.094	.016	11	
	2.51.52MV	●	●	●	●	●	★	●				.313	.094	.031	11	
	321MV	●	●	●	●	●	★	●				.375	.125	.016	11	
	322MV	●	●	●	●	●	★	●				.375	.125	.031	11	
Finish Cutting	CCGH21.50.5RF				●		★	□	●			.250	.094	.008	7	<b>CCGH...R/LF</b> <b>CPMH...R/LF</b>  <p>Left hand is shown.</p>
	21.50.5LF				●		★	★	●			.250	.094	.008	7	
	21.51RF				●		★	□	●			.250	.094	.016	7	
	21.51LF				●		★	★	●			.250	.094	.016	7	
	CPMH2.51.51RF				●		★	□	●			.313	.094	.016	11	
	2.51.51LF				●		★	★	●			.313	.094	.016	11	
	321RF				●		★	□	●			.375	.125	.016	11	
	321LF				●		★	★	●			.375	.125	.016	11	
Finish Cutting	NP-CCMB21.51G										●	.250	.094	.016	7	<b>NP-CCMB...G</b> <b>NP-CPMB...G</b>  <p>Last letter of insert number G : For General Purpose</p>
	NP-CPMB2.51.51G										●	.313	.094	.016	11	
	321G										●	.375	.125	.016	11	
	NP-CCMH21.50.5										●	.250	.094	.008	7	
	21.51										●	.250	.094	.016	7	
	NP-CPMH2.51.50.5										●	.313	.094	.008	11	
2.51.51										●	.313	.094	.016	11		
320.5										●	.375	.125	.008	11		
321										●	.375	.125	.016	11		

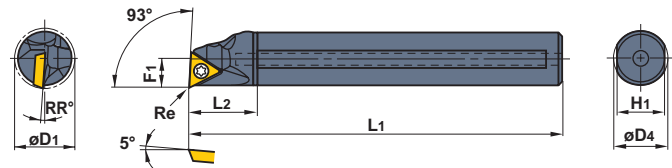
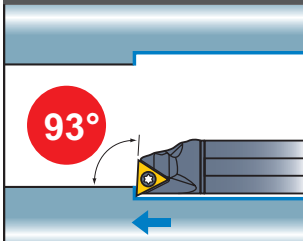
# SCREW CLAMP DIMPLE BAR

## HOLDERS

### M-FSTUP

Heavy metal shank with coolant hole

TP<sup>o</sup> inserts



Right hand tool holder shown.

Finish	Light	Medium
R/L-FS (1.5,1.8,2)	SV (1.5,1.8,2)	MV (1.5,1.8,2)
PCD		CBN
R/L-F (1.5,1.8,2)	(1.5,1.8,2)	

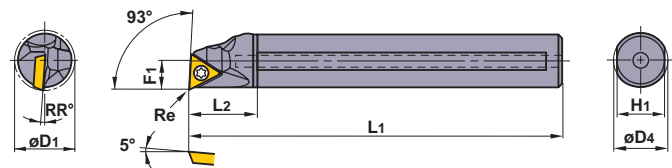
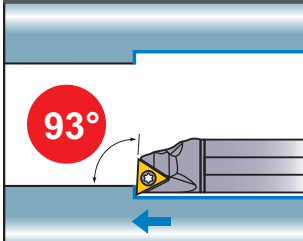
Order Number	Stock		Insert Number	Dimensions (inch)						Min. Cutting Diameter (inch) D1	Standard Corner Radius (inch) Re	Insert Screw	Wrench	
	R	L		D4	L1	L2	F1	H1	RR°					
M-FSTUPR/L-051.5-C	●	●	TPMH TPGH NP-TPMB NP-TPMH	1.51.5	.313	5.000	.703	.196	.281	10	.390	.016	TS2D	TKY06F
-061.8-C	●	●		1.81.5	.375	6.000	.844	.227	.336	8	.450	.016	TS25D	TKY08F
-081.8-C	●	●		1.81.5	.500	8.000	1.125	.290	.461	7	.580	.016	TS25D	TKY08F
-102-C	●	●		22	.625	10.000	1.406	.352	.586	4	.700	.016	TS31D	TKY10F

(Note) When using inserts with right and left hand chip breakers, please use left hand inserts for right hand holders and right hand inserts for left hand holders.

### S-FSTUP

Steel shank with coolant hole

TP<sup>o</sup> inserts



Right hand tool holder shown.

Finish	Light	Medium
R/L-FS (1.8,2)	SV (1.8,2)	MV (1.8,2)
PCD		CBN
R/L-F (1.8,2)	(1.8,2)	

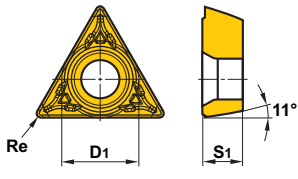
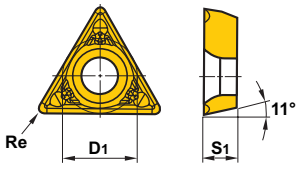
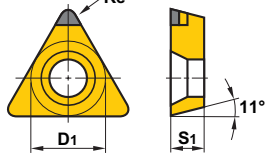
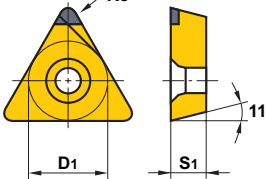
Order Number	Stock		Insert Number	Dimensions (inch)						Min. Cutting Diameter (inch) D1	Standard Corner Radius (inch) Re	Insert Screw	Wrench	
	R	L		D4	L1	L2	F1	H1	RR°					
S-FSTUPR/L-061.8-C	○	○	TPMH TPGH NP-TPMB NP-TPMH	1.81.5	.375	6.000	.844	.227	.336	8	.450	.016	TS25D	TKY08F
-081.8-C	○	○		1.81.5	.500	8.000	1.125	.290	.461	7	.580	.016	TS25D	TKY08F
-102-C	○	○		22	.625	10.000	1.406	.352	.586	4	.700	.016	TS31D	TKY10F
-122-C	○	○		22	.750	10.000	1.688	.414	.711	0	.825	.016	TS31D	TKY10F
-162-C	○	○		22	1.000	12.000	2.250	.638	.937	0	1.280	.016	TS31D	TKY10F

(Note) When using inserts with right and left hand chip breakers, please use left hand inserts for right hand holders and right hand inserts for left hand holders.

(Note) Insert photo, letters show chip breaker style, figures show inscribed circle.

● : Inventory maintained. ○ : Inventory maintained. (Available Winter 2006) ★ : Inventory maintained in Japan.  
□ : Non stock, produced to order only.

INSERTS

Application	Order Number	Stock Grade										Dimensions (inch)			Geometry	
		Coated			MIRACLE Coated		Cermet	Coated Cermet	Carbide	CBN	PCD	D1	S1	Re		
		UE6020	US7020	US735	VP15TF	VP45N	NX2525	AP25N	HT10	MB825	MD220					
Light Cutting	TPMH1.51.50.5SV	●	★	●		●	★					.188	.094	.008	<p>TPMH...SV</p> 	
	1.51.51SV	●	★	●		●	★					.188	.094	.016		
	1.81.50.5SV	●	★	●		●	★					.219	.094	.008		
	1.81.51SV	●	★	●		●	★					.219	.094	.016		
	220.5SV	●	★	●		●	★					.250	.125	.008		
	221SV	●	★	●		●	★					.250	.125	.016		
	222SV	●	★	●		●	★					.250	.125	.031		
	320.5SV	●	★	●		★	★					.375	.125	.008		
	321SV	●	★	●		★	★					.375	.125	.016		
	322SV	●	★	●		●	★					.375	.125	.031		
Medium Cutting	TPMH1.51.50.5MV	●	●	●	●	●	★	●				.188	.094	.008	<p>TPMH...MV</p> 	
	1.51.51MV	●	●	●	●	●	★	●				.188	.094	.016		
	1.81.50.5MV	●	●	●	●	●	★	●				.219	.094	.008		
	1.81.51MV	●	●	●	●	●	★	★				.219	.094	.016		
	220.5MV	●	★	●	★	★	★	●				.250	.125	.008		
	221MV	●	●	●	●	●	★	●				.250	.125	.016		
	222MV	●	●	●	●	●	★	●				.250	.125	.031		
	321MV	●	●	●	●	●	★	●				.375	.125	.016		
	322MV	●	●	●	●	★	★	●				.375	.125	.031		
	Finish Cutting	TPGH1.51.50.5RFS				●		★	□	●			.188	.094		.008
1.51.50.5LFS					●		★	★	●			.188	.094	.008		
1.51.51RFS					●		★	□	●			.188	.094	.016		
1.51.51LFS					●		★	★	●			.188	.094	.016		
1.81.50.5RFS					●		★	□	●			.219	.094	.008		
1.81.50.5LFS					●		★	★	●			.219	.094	.008		
1.81.51RFS					●		★	□	●			.219	.094	.016		
1.81.51LFS					●		★	★	●			.219	.094	.016		
220.5RFS					●		★	□	●			.250	.125	.008		
220.5LFS					●		★	★	●			.250	.125	.008		
221RFS					●		★	□	●			.250	.125	.016		
221LFS					●		★	★	●			.250	.125	.016		
321RFS					●		★	□	●			.375	.125	.016		
321LFS					●		★	★	●			.375	.125	.016		
322RFS					●		★	□	●			.375	.125	.031		
322LFS					●		★	★	●			.375	.125	.031		
		NP-TPMB1.51.51G											.188	.094	.016	<p>NP-TPMB...G</p>  <p>Last letter of insert number G : For General Purpose</p>
		1.81.51G											.219	.094	.016	
		221G											.250	.125	.016	
		321G											.375	.125	.016	
	NP-TPMH1.51.50.5RF										●	.188	.094	.008	<p>NP-TPMH...R/LF</p>  <p>Left hand is shown.</p>	
	1.51.50.5LF										●	.188	.094	.008		
	1.51.51RF										●	.188	.094	.016		
	1.51.51LF										●	.188	.094	.016		
	1.81.50.5RF										●	.219	.094	.008		
	1.81.50.5LF										●	.219	.094	.008		
	1.81.51RF										●	.219	.094	.016		
	1.81.51LF										●	.219	.094	.016		
	220.5RF										●	.250	.125	.008		
	220.5LF										●	.250	.125	.008		
	221RF										●	.250	.125	.016		
	221LF										●	.250	.125	.016		

# SCREW CLAMP DIMPLE BAR

## HOLDERS

<b>M-FSDUC</b>		Heavy metal shank With coolant hole		DC $\odot$ inserts		Finish									
						R/LF	Light	Medium							
						 (2,3)	 (2,3)	 (2,3)							
						PCD			CBN						
						R/LF			 (2,3)	 (2,3)					
Order Number	Stock		Insert Number	Dimensions (inch)							Min. Cutting Diameter (inch) D1	Standard Corner Radius (inch) Re	 Insert Screw	 Wrench	
	R	L		D4	H1	L1	L2	F1	F2	RR°					
M-FSDUCR/L-062-C	●	●	DCMT DCGT NP-DCMT NP-DCGW	21.5 $\odot$	.375	.336	6.000	.675	.317	.130	7.5	.525	.016	TS25	TKY08F
-082-C	●	●		21.5 $\odot$	.500	.461	8.000	.833	.380	.130	6	.667	.016	TS25	TKY08F
-102-C	●	●		21.5 $\odot$	.625	.586	10.000	.781	.442	.130	5	.781	.016	TS25	TKY08F
-123-C	●	●		32.5 $\odot$	.750	.711	10.000	.844	.615	.240	5	1.200	.031	TS43	TKY15F

(Note) When using inserts with right and left hand chip breakers, please use left hand inserts for right hand holders and right hand inserts for left hand holders.

<b>M-FSDQC</b>		Heavy metal shank With coolant hole		DC $\odot$ inserts		Finish									
						R/LF	Light	Medium							
						 (2,3)	 (2,3)	 (2,3)							
						PCD			CBN						
						R/LF			 (2,3)	 (2,3)					
Order Number	Stock		Insert Number	Dimensions (inch)							Min. Cutting Diameter (inch) D1	Standard Corner Radius (inch) Re	 Insert Screw	 Wrench	
	R	L		D4	H1	L1	L2	F1	F2	RR°					
M-FSDQCR/L-062-C	●	●	DCMT DCGT NP-DCMT NP-DCGW	21.5 $\odot$	.375	.336	6.000	.769	.290	.102	8	.488	.016	TS25	TKY08F
-082-C	●	●		21.5 $\odot$	.500	.461	8.000	.938	.352	.102	6	.667	.016	TS25	TKY08F
-102-C	●	●		21.5 $\odot$	.625	.586	10.000	.879	.415	.102	5	.781	.016	TS25	TKY08F
-123-C	●	●		32.5 $\odot$	.750	.711	10.000	.975	.521	.146	7	.938	.031	TS43	TKY15F

(Note) When using inserts with right and left hand chip breakers, please use left hand inserts for right hand holders and right hand inserts for left hand holders.

(Note) Insert photo, letters show chip breaker style, figures show inscribed circle.

INSERTS

Application	Order Number	Stock Grade										Dimensions (inch)			Geometry	
		Coated			MIRACLE Coated		Cermet	Coated Cermet	Carbide	CBN		PCD	D1	S1		Re
		UE6020	US7020	US735	VP15TF	VP45N	NX2525	AP25N	HT10	MB825	MB8025	MD220				
Finish Cutting	DCMT21.50.5FV	●					★	●					.250	.094	.008	DCMT...FV 
	21.51FV	●					★	●					.250	.094	.016	
	32.51FV	●					★	●					.375	.156	.016	
	32.52FV	●					★	●					.375	.156	.031	
Light Cutting	DCMT21.50.5SV	●	★	●	★	●	★					.250	.094	.008	DCMT...SV 	
	21.51SV	●	★	●	●	●	★					.250	.094	.016		
	21.52SV	●	★	●	●	●	★					.250	.094	.031		
	32.50.5SV	●	★	●	●	●	★					.375	.156	.008		
	32.51SV	●	★	●	●	●	★					.375	.156	.016		
	32.52SV	●	★	●	●	★	★					.375	.156	.031		
Medium Cutting	DCMT21.50.5MV	●	★	●	●	●	★	●				.250	.094	.008	DCMT...MV 	
	21.51MV	●	●	●	●	★	★	●				.250	.094	.016		
	21.52MV	●	●	●	●	★	★	●				.250	.094	.031		
	32.50.5MV	●	●	●	●	●	★	●				.375	.156	.008		
	32.51MV	●	●	●	●	●	★	●				.375	.156	.016		
	32.52MV	●	●	●	●	★	★	●				.375	.156	.031		
Finish Cutting	DCGT21.50.5RF				●		★	□	●			.250	.094	.008	DCGT...R/LF 	
	21.50.5LF				●		★	●	●			.250	.094	.008		
	21.51RF				●		★	□	●			.250	.094	.016		
	21.51LF				●		★	●	●			.250	.094	.016		
	32.50.5RF				●		★	□	●			.375	.156	.008		
	32.50.5LF				●		★	●	●			.375	.156	.008		
	32.51RF				●		★	□	●			.375	.156	.016		
	32.51LF				●		★	●	●			.375	.156	.016		
	NP-DCGW21.50.5G										●		.250	.094	.008	NP-DCGW...G/F/T 
	21.51G									●		.250	.094	.016		
	21.52G									●		.250	.094	.031		
	32.50.5G									●		.375	.156	.008		
	32.51G									●	●	.375	.156	.016		
	32.51F										□	.375	.156	.016		
32.51T										□	.375	.156	.016			
32.52G									●	●	.375	.156	.031			
32.52F										□	.375	.156	.031			
32.52T										□	.375	.156	.031			
NP-DCGW32.51-G2										●		.375	.156	.016	NP-DCGW...-G2 	
32.52-G2										●		.375	.156	.031		
Finish Cutting	NP-DCMT21.50.5RF										●	.250	.094	.008	NP-DCMT...R/LF 	
	21.50.5LF										●	.250	.094	.008		
	21.51RF										●	.250	.094	.016		
	21.51LF										●	.250	.094	.016		
	32.50.5RF										●	.375	.156	.008		
	32.50.5LF										●	.375	.156	.008		
	32.51RF										●	.375	.156	.016		
	32.51LF										●	.375	.156	.016		

## SCREW CLAMP DIMPLE BAR

### HOLDERS

#### M-FSWUB/P

Heavy metal shank  
With coolant hole

WB $\circ$ , WP $\circ$  inserts

Finish

R/LF

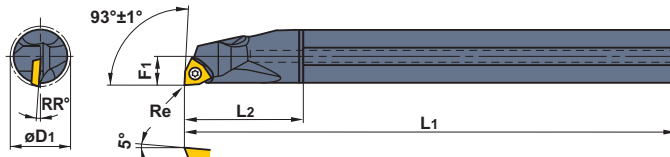
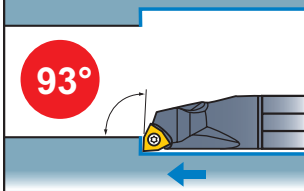


Medium

MV



(1.5,2,3)



The  $\phi$ .313 and  $\phi$ .375 shanks are 0°.

Right hand tool holder shown.

Order Number	Stock		Insert Number	Dimensions (inch)						Min. Cutting Diameter (inch) D1	Standard Corner Radius (inch) Re	Insert Screw	Wrench	
	R	L		D4	H1	L1	L2	F1	RR°					
M-FSWUBR/L-051.5-C	●	●	WBMT WBGT	1.51.5 $\circ$	.313	.281	5.000	.703	.196	14	.391	.008	TS2	TKY06F
-061.5-C	●	●		1.51.5 $\circ$	.375	.336	6.000	.844	.227	11	.450	.008	TS2	TKY06F
M-FSWUPR/L-082-C	●	●	WPMT	21.5 $\circ$	.500	.461	8.000	1.125	.289	4	.583	.016	TS253	TKY08F
-102-C	●	●		21.5 $\circ$	.625	.586	10.000	1.406	.352	1	.703	.016	TS253	TKY08F
-123-C	●	●		32 $\circ$	.750	.711	10.000	1.688	.414	2	.825	.031	TS4	TKY15F

(Note) When using inserts with right and left hand chip breakers, please use left hand inserts for right hand holders and right hand inserts for left hand holders.

### INSERTS

Application	Order Number	Stock Grade							Dimensions (inch)				Geometry	
		Coated			MIRACLE Coated	Cermet	Coated Cermet	Carbide	D1	S1	Re	$\alpha^\circ$		
		UE6020	US7020	US735	VP15TF	VP45N	NX2525	AP25N						HT10
Medium Cutting	WBMT1.51.50.5RMV	●	●	●	★	★	★	□	.188	.094	.008	5	WBMT...R/LMV WPMT...MV 	
	1.51.50.5LMV	●	●	●	★	★	★	□	.188	.094	.008	5		
	1.51.51RMV	●	●	●	★	★	★	□	.188	.094	.016	5		
	1.51.51LMV	●	●	●	★	★	★	□	.188	.094	.016	5		
	WPMT21.50.5MV	●	●	●	★	★	★	□	.250	.094	.008	11		
	21.51MV	●	●	●	★	★	★	□	.250	.094	.016	11		
	321MV	●	●	●	●	★	★	□	.375	.125	.016	11		
322MV	●	●	●	●	★	★	□	.375	.125	.031	11			
Finish Cutting	WBGT1.51.5V3LF				●		★		.188	.094	.001	5	WBGT...R/LF 	
	1.51.50.2LF				●		★		.188	.094	.004	5		
	1.51.50.5RF				●		★	□	●	.188	.094	.008		5
	1.51.50.5LF				●		★	□	●	.188	.094	.008		5
	1.51.51RF				●		★	□	●	.188	.094	.016		5
	1.51.51LF				●		★	□	●	.188	.094	.016		5

Left hand is shown.

(Note) Insert photo, letters show chip breaker style, figures show inscribed circle.

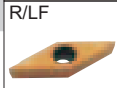
HOLDERS

**M-FSVUB/C**

Heavy metal shank  
With coolant hole

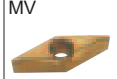
VC $\circ\circ$ , VB $\circ\circ$  inserts

Finish

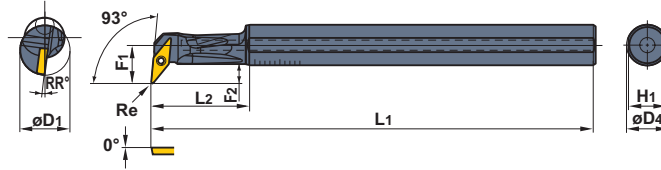
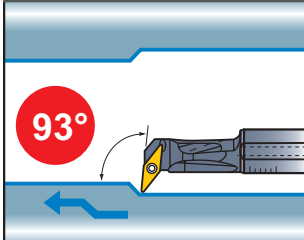


(1.5,2)

Medium



(1.5,2,3)



Right hand tool holder shown.

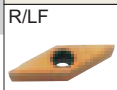
Order Number	Stock		Insert Number	Dimensions (inch)							Min. Cutting Diameter (inch) D1	Standard Corner Radius (inch) Re	Insert Screw	Wrench	
	R	L		D4	H1	L1	L2	F1	F2	RR°					
M-FSVUCR/L-081.5-C	●	●	VCGT VCMT	1.51.5 $\circ$	.500	.461	8.000	1.042	.447	.197	8	.667	.016	TS202	TKY06F
M-FSVUBR/L-102-C	●	●	VBGT VBMT	22 $\circ$	.625	.586	10.000	1.269	.608	.295	8	.781	.016	TS255	TKY08F
-122-C	●	●	NP-VBGW	22 $\circ$	.750	.711	10.000	1.519	.670	.295	7	.938	.016	TS255	TKY08F

**M-FSVPB/C**

Heavy metal shank  
With coolant hole

VC $\circ\circ$ , VB $\circ\circ$  inserts

Finish

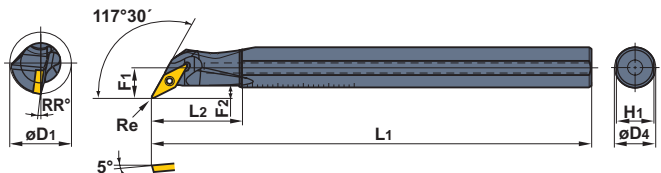
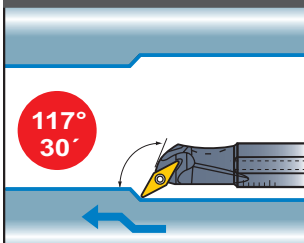


(1.51.5,2)

Medium



(1.51.5,2)



Right hand tool holder shown.

Order Number	Stock		Insert Number	Dimensions (inch)							Min. Cutting Diameter (inch) D1	Standard Corner Radius (inch) Re	Insert Screw	Wrench	
	R	L		D4	H1	L1	L2	F1	F2	RR°					
M-FSVPCR/L-061.5-C	●	●	VCGT VCMT	1.51.5 $\circ$	.375	.336	6.000	.938	.306	.118	8	.600	.016	TS202	TKY06F
M-FSVPBR/L-082-C	●	●	VBGT VBMT	22 $\circ$	.500	.461	8.000	1.167	.467	.157	8	.833	.016	TS255	TKY08F
-102-C	●	●	NP-VBGW	22 $\circ$	.625	.586	10.000	1.367	.490	.177	5	.977	.016	TS255	TKY08F
-122-C	●	●	NP-VBGW	22 $\circ$	.750	.711	10.000	1.500	.572	.177	5	1.125	.016	TS255	TKY08F

(Note) When using inserts with right and left hand chip breakers, please use left hand inserts for right hand holders and right hand inserts for left hand holders.

## SCREW CLAMP DIMPLE BAR

### HOLDERS

## M-FSVJB/C

Heavy metal shank  
With coolant hole

VC $\circ\circ$ , VB $\circ\circ$  inserts

Finish

R/LF



(1.51.5,2)

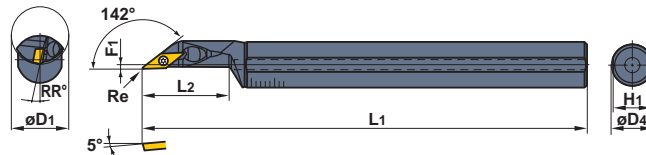
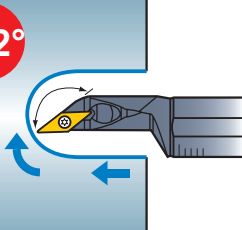
Medium

MV



(1.51.5,2)

142°



Right hand tool holder shown.

Order Number	Stock		Insert Number	Dimensions (inch)						Min. Cutting Diameter (inch) D1	Standard Corner Radius (inch) Re	Insert Screw	Wrench	
	R	L		D4	H1	L1	L2	F1	RR°					
M-FSVJCR/L-081.5-C	●	●	VCGT	1.51.5 $\circ$	.500	.461	8.000	1.083	.093	5	.667	.016	TS202	TKY06F
-101.5-C	●	●	VCMT	1.51.5 $\circ$	.625	.586	10.000	1.406	.076	5	.781	.016	TS202	TKY06F
M-FSVJBR/L-122-C	●	●	VBGT	22 $\circ$	.750	.711	10.000	1.406	.060	5	.938	.016	TS255	TKY08F

(Note) When using inserts with right and left hand chip breakers, please use left hand inserts for right hand holders and right hand inserts for left hand holders.

### INSERTS

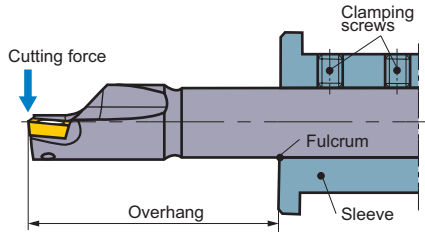
Application	Order Number	Stock Grade								Dimensions (inch)				Geometry	
		Coated		MIRACLE Coated		Cermet	Coated Cermet	Carbide	CBN	D1	S1	Re	$\alpha^\circ$		
		UE6020	US7020	US735	VP15TF	VP45N	NX2525	AP25N	HT10	MB8025					
Finish - Medium Cutting	VCMT1.51.50.5MV	●	●	●	●	★	★	●			.188	.094	.008	7	VCMT...MV VBMT...MV 
	1.51.51MV	●	●	●	●	★	★	●			.188	.094	.016	7	
	VBMT221MV	★	●	●	●	★	★	●			.250	.125	.016	5	
	222MV	●	●	●	●	★	★	●			.250	.125	.031	5	
	331MV	●	●	●	●	★	★	●			.375	.188	.016	5	
	332MV	●	●	●	●	★	★	●			.375	.188	.031	5	
Finish Cutting	VCGT1.51.50.5RF				●		★	●	●		.188	.094	.008	7	VCGT...R/LF VBGT...R/LF  Left hand is shown.
	1.51.50.5LF				●		★	●	●		.188	.094	.008	7	
	1.51.51RF				●		★	●	●		.188	.094	.016	7	
	1.51.51LF				●		★	●	●		.188	.094	.016	7	
	VBGT220.5RF				●		★	★	●		.250	.125	.008	5	
	220.5LF				●		★	★	●		.250	.125	.008	5	
	221RF				●		★	★	●		.250	.125	.016	5	
	221LF				●		★	★	●		.250	.125	.016	5	
	NP-VBGW331G									●		.375	.188	.016	
332G									●		.375	.188	.031	5	
														NP-VBGW...G 	

(Note) Insert photo, letters show chip breaker style, figures show inscribed circle.

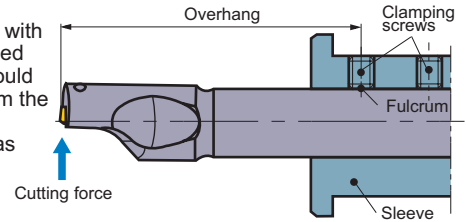
**Operational Guidance**

**● Installation of DIMPLE BAR**

(1) If the clamp is not rigid then chattering and vibrations will occur. Use at least 2 clamping screws to ensure that the clamping force is sufficient.



(2) When machining with the holder reversed the overhang should be measured from the tip to the first clamping screw as shown.



**● CCG/MT, CPG/MT, CPMX, TPG/MX, TPG/MV inserts**

	Order Number	Insert Screw	Remark
By changing the Insert screw, it is possible to use the inserts listed on the left hand side.	CCG/MT21.51	Can be used as it is.	If the screw is too long then please grind away the unnecessary material.
	CPG/MT2.51.5	Change to TS3.	
	CPG/MT32	Change to TS4.	
	CPMX2.51.5	Can be used as it is.	
	CPMX32	Can be used as it is.	
	TPGD/P63	Change to CS200T.	
	TPGD/P73	Change to CS250T.	
	TPGA/M22	Change to CS300890T.	
	TPG/MV1.81.5	Change to TS25.	
TPG/MV22	Change to TS3.		

**Machining of the FSVJB/C type**

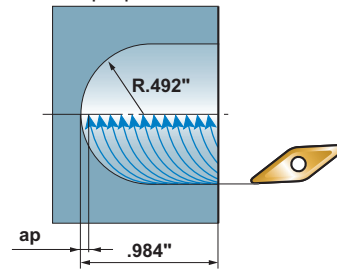
**● Use a pre-drilled hole for increased productivity.**

When machining a prepared hole, the amount of reads is greatly reduced.

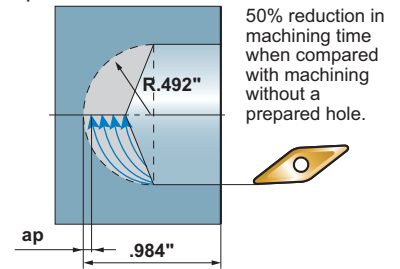
<Cutting conditions>

- Workpiece : ANSI 1055
- Tool : M-FSVJBR-122-C
- Insert : VBMT221MV
- Cutting speed : 393 SFM
- Feed : .002 IPR
- Depth of cut : .011 inch
- Coolant : W.S.O

Machining a workpiece without prepared hole.



Machining a workpiece with prepared hole.



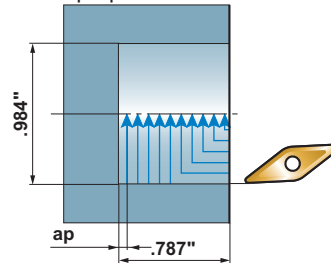
**● Deep faces**

When machining a prepared hole, the amount of reads is greatly reduced.

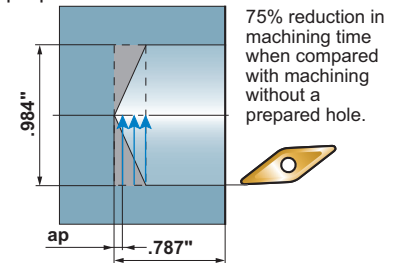
<Cutting conditions>

- Workpiece : ANSI 1055
- Tool : M-FSVJBR-122-C
- Insert : VBMT221MV
- Cutting speed : 393 SFM
- Feed : .002 IPR
- Depth of cut : .011 inch
- Coolant : W.S.O

Machining a workpiece without prepared hole.

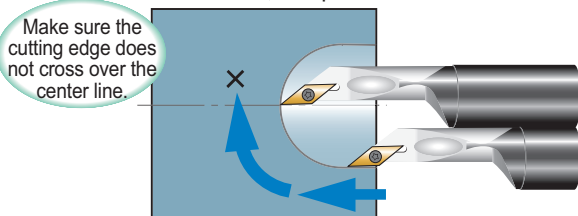


Machining a workpiece with prepared hole.



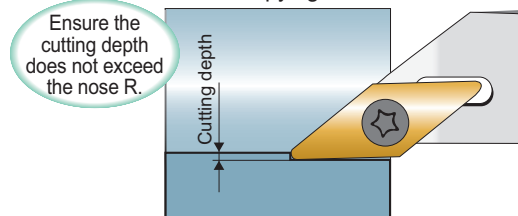
**■ Caution when using the FSVJB/C type**

<Curved faces, Deep faces>



Crossing over the center line leads to chipping.

<Copying>

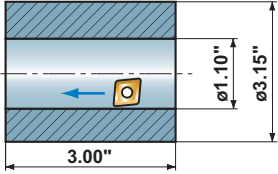
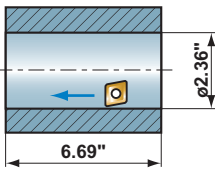
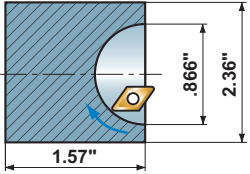


Cutting depths large than nose R lead to burrs developing.

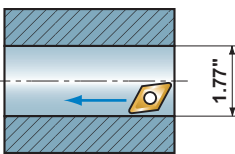
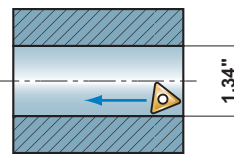
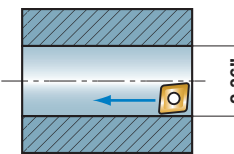
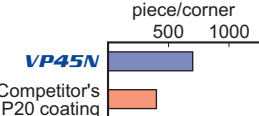
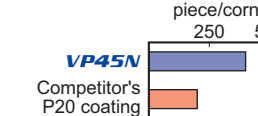
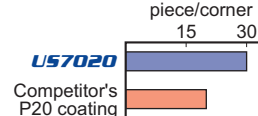
# SCREW CLAMP DIMPLE BAR

## Application Examples

### ● Chatter resistance

Tool	M-FSCLPR-103-C	M-FSCLPR-123-C	M-FSVJCR-101.5-C
Insert (Grade)	CPMH322MV (AP25N)	CPMH321LF (VP15TF)	VCMT1.51.51MV (AP25N)
Overhang	3.15 inch (l/d=5)	6.89 inch (l/d=8.75)	2.52 inch (l/d=4)
Machine	NC machine	NC machine	NC machine
Workpiece	ANSI 1045 (200HB) 	Steel (200HB) 	ANSI 4140 (220HB) 
	Cutting Speed (SFM)	260	200
Feed (IPR)	.008	.007	.002
Depth of Cut (inch)	.020	.020	.011
Coolant	WSO	WSO	WSO
Result	Even with an overhang 1.7 times that of a conventional bar, the surface finish is still of a high standard.	Possible to machine even when the overhang is large with demanding cutting conditions.	Compared with a competitor's bar no vibrations occurred, surface finish was of a high standard. Additionally excellent chip disposal was also achieved.

### ● Wear resistance / Chipping resistance

Tool	M-FSDUCR-102-C	M-FSTUPR-122-C	M-FSCLPR-123-C
Insert (Grade)	DCMT21.51SV (VP45N)	TPMH221SV (VP45N)	CPMH321MV (US7020)
Overhang	2.83 inch (l/d=4.5)	5.51 inch (l/d=7)	3.15 inch (l/d=4)
Machine	NC machine	NC machine	NC machine
Workpiece	ANSI 1045 	Steel 	ANSI 304 
	Cutting Speed (SFM)	600	750
Feed (IPR)	.004	.010	.004
Depth of Cut (inch)	.014	.004	.020
Coolant	WSO	WSO	WSO
Result	 Compared to a competitor's conventional grade, tool life has become about 1.8 times longer.	 Chips control has become better than and tool life has become about twice as long as a competitor's conventional grade.	 Compared to a competitor's conventional grade, tool life has become about more than 1.5 times longer.

**For your safety**

● Do not touch sharp parts or chips without wearing gloves. ● Use tools under recommended cutting conditions, and exchange tools before excessive wear occurs. ● Chips become extremely hot, scattered over and may be stretched. Ensure safety guards and goggles are used. ● In case of using non-water soluble oil, make sure to have a fire prevention countermeasure. ● Use the provided wrench, and ensure the inserts and spare parts are damped securely.

**MITSUBISHI MATERIALS CORPORATION**



**MITSUBISHI MATERIALS U.S.A. CORPORATION**

17401 Eastman Street, Irvine, California 92614, U.S.A.  
TEL. 949-862-5100 FAX. 949-862-5180

Customer Service: (800)523-0800 Technical Support: (800)486-2341

Chicago Branch Office: 2401 Hassell Road, Northwest Tech Centre, Suite 1540, Hoffman Estates, Illinois 60169, U.S.A.  
TEL. 847-285-6900 FAX. 847-285-3405

Detroit Branch Office: 39303 Country Club Drive, Suite A-1, Farmington Hills, Michigan 48331, U.S.A.  
TEL. 248-489-1000 FAX. 248-489-3008

Toront Branch Office: 6535 Millcreek Drive, Unit 63 & 64, Mississauga, Ontario, Canada L5N 2M2  
TEL. 905-814-0240 FAX. 905-814-0245

**MMC METAL DE MEXICO S.A. DE C.V.**

Av. La Cañada No.16, Parque Industrial Bernardo Quintana, El Marques, Queretaro, CP 76246 Mexico  
TEL. 011-52-442-221-6136/011-52-442-221-6137/011-52-442-221-6150 FAX. 011-52-442-221-6134

**Mitsubishi Carbides Home page : <http://www.mitsubishicarbide.com>**

(Tools specifications subject to change without notice.)