



Highly rigid clamping system

TURNINGA

Tungaloy Report No. 365-G

Out of the box. Onto the turret in seconds.





Ready-to-Use Short Type-A Holders



TURNING



Now offers short shank holders readily suited
for the latest CNC turret designs

New

Zero modification needed — out of the box, onto the turret Type-A short-shank holders drastically reduce labor hours and operational overhead

■ The Power of ZERO

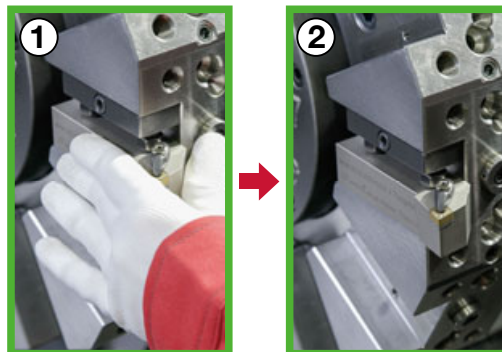
- ✓ **ZERO modification costs:** Eliminates expenses for labor and specialized cutting consumables.
- ✓ **ZERO modification process:** Turret-ready—install directly into the turret tool post right from the box.
- ✓ **ZERO material waste:** Eco-friendly design eliminates off-cuts and maximizes material efficiency.

New short shank toolholders are available for the Type-A toolholder series for regular size inserts and ISO-EcoTurn inserts.

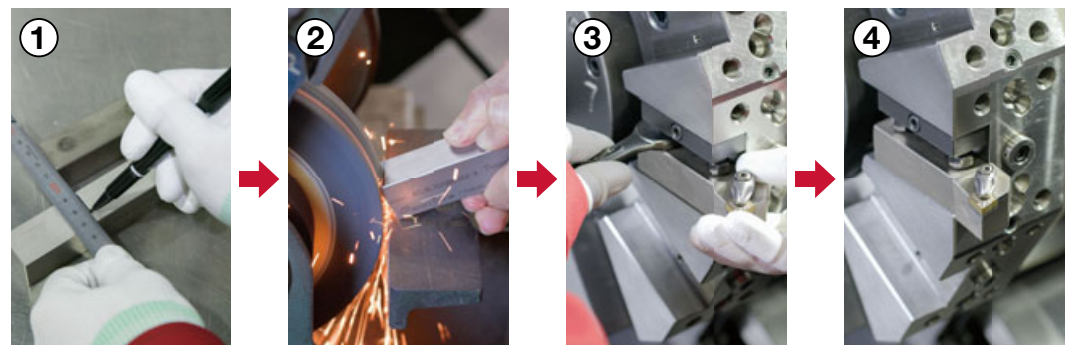


■ Comparison of work processes

New



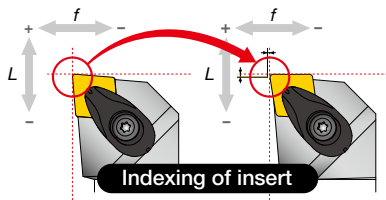
Increase work efficiency !



This solution is designed for small machine turrets. For standard-size turrets, use regular-length turning toolholders for maximum stability and reliability.

Higher indexing accuracy

Achieves superior cutting edge repeatability.

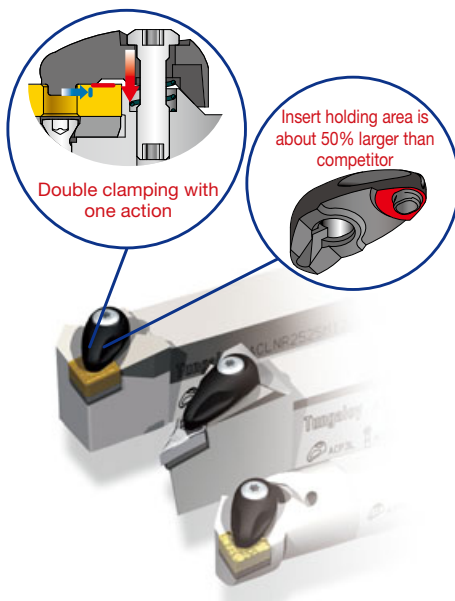


Indexing accuracy

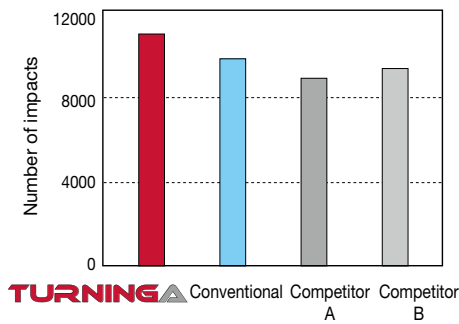
	f direction (μm)	L direction (μm)
TURNING	0.8	1.4
Conventional	1.1	2.2
Competitor A	2.8	7.7
Competitor B	3.8	1.5
Competitor C	1	2.2

Unique clamp improves rigidity

- Larger holding area enhances clamping force drastically.
- Higher rigidity provides excellent stability and reduces vibration.



Comparison of impact resistance



P Toolholder : ACLNR2525M12-A
 Insert : CNMG120408-TM T9115
 Workpiece material : S45C / C45
 Cutting speed : $V_c = 200$ m/min
 Feed : $f = 0.3$ mm/rev
 Depth of cut : $a_p = 1 - 2$ mm
 Application : Interrupted

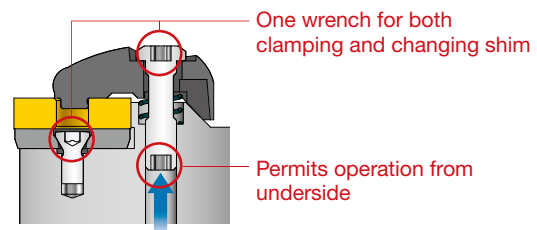
Easy handling and maintenance

Only one wrench required

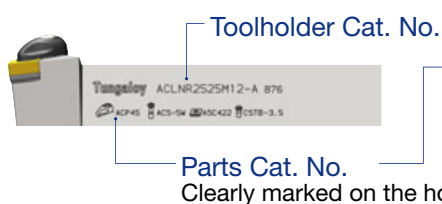
Only one wrench is required for the clamping screw and the shim screw. Easy maintenance.

Marking

Parts Cat. No. are marked on the holder.



External-use toolholder



Internal-use toolholders

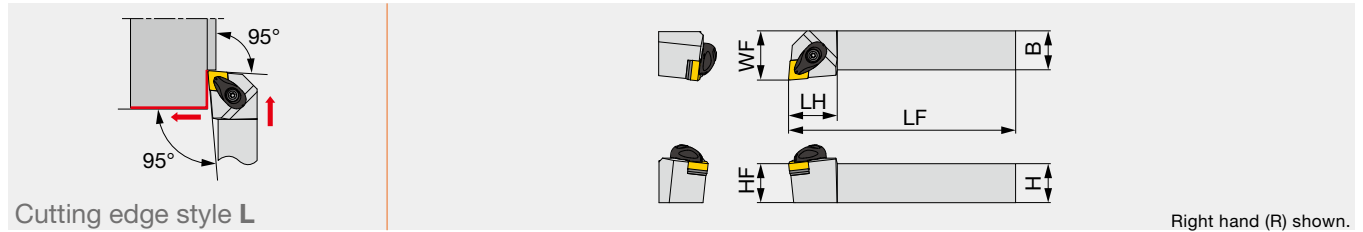


Toolholder Cat. No.
 (Min. bore diameter is included in Cat. No.)

The last three digits indicate min. bore diameter.
 (Example : -D320 indicates 32 mm)

ACLNR/L

Double-clamp toolholder with 95° approach angle, for negative 80°/70° rhombic inserts



	Designation	H	B	LF	LH	HF	WF	**RE	Insert	*Torque
New	ACLNR/L2020H0904-A	20	20	100	25	20	25	0.8	CN**/GNMG0904...	3
	ACLNR/L2020K0904-A	20	20	125	25	20	25	0.8	CN**/GNMG0904...	3
New	ACLNR/L2525H0904-A	25	25	100	25	25	32	0.8	CN**/GNMG0904...	3
	ACLNR/L2525M0904-A	25	25	150	25	25	32	0.8	CN**/GNMG0904...	3
New	ACLNR/L2020H12-A	20	20	100	26	20	25	0.8	CN**/GNGA1204...	3
	ACLNR/L2020K12-A	20	20	125	26	20	25	0.8	CN**/GNGA1204...	3
New	ACLNR/L2525H12-A	25	25	100	26	25	32	0.8	CN**/GNGA1204...	3
	ACLNR/L2525K12-A	25	25	125	30	25	32	0.8	CN**/GNGA1204...	3
	ACLNR/L2525M12-A	25	25	150	30	25	32	0.8	CN**/GNGA1204...	3
	ACLNR/L3225P12-A	32	25	170	30	32	32	0.8	CN**/GNGA1204...	3
	ACLNR/L2525M16-A	25	25	150	31	25	32	1.2	CN**1606...	6.4
	ACLNR/L3225P16-A	32	25	170	31	32	32	1.2	CN**1606...	6.4
	ACLNR/L3232P16-A	32	32	170	31	32	40	1.2	CN**1606...	6.4
	ACLNR/L3232P19-A	32	32	170	40	32	40	1.2	CN**1906...	6.4
	ACLNR/L4040S19-A	40	40	250	40	40	50	1.2	CN**1906...	6.4

*Torque: Recommended clamping torque (N·m)

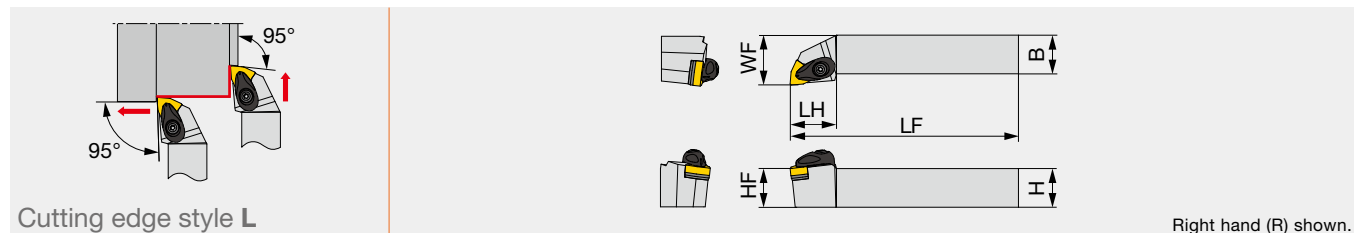
**RE: Standard corner radius

SPARE PARTS

Designation	Clamp	Clamp screw	Spring	Spring pin	Shim	Shim screw	Wrench1	Wrench2
ACLNR/L**0904-A	ACP3S-E	ACS-5W	BP-7	SP-2.5	ASC322	CSTB-3.5	T-15F	-
ACLNR/L**12-A	ACP4S	ACS-5W	BP-7	SP-2.5	ASC422	CSTB-3.5	T-15F	-
ACLNR/L**16-A	ACP5S	ACS-6W	BP-8.8	SP-2.5	ASC533	CSTB-5	-	KEYV-T20
ACLNR/L**19-A	ACP6S	ACS-6W	BP-8.8	SP-2.5	ASC634	CSTB-5	-	KEYV-T20

AWLNR/L

Double-clamp toolholder with 95° approach angle, for negative 80° trigon inserts



	Designation	H	B	LF	LH	HF	WF	**RE	Insert	*Torque
New	AWLNR/L2020H0604-A	20	20	100	27	20	25	0.8	WN**0604...	3
	AWLNR/L2020K0604-A	20	20	125	27	20	25	0.8	WN**0604...	3
New	AWLNR/L2525H0604-A	25	25	100	27	25	32	0.8	WN**0604...	3
	AWLNR/L2525M0604-A	25	25	150	27	25	32	0.8	WN**0604...	3
New	AWLNR/L2020H08-A	20	20	100	30	20	25	0.8	WN**0804...	3
	AWLNR/L2020K08-A	20	20	125	30	20	25	0.8	WN**0804...	3
New	AWLNR/L2525H08-A	25	25	100	30	25	32	0.8	WN**0804...	3
	AWLNR/L2525K08-A	25	25	125	30	25	32	0.8	WN**0804...	3
	AWLNR/L2525M08-A	25	25	150	30	25	32	0.8	WN**0804...	3
	AWLNR/L3225P08-A	32	25	170	30	32	32	0.8	WN**0804...	3

*Torque: Recommended clamping torque (N·m)

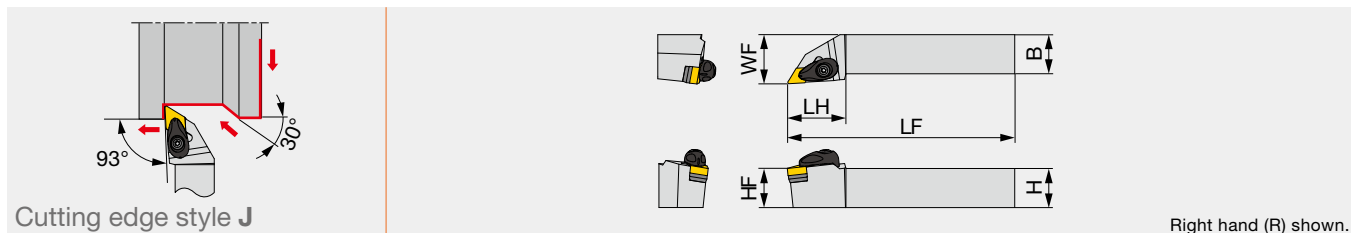
**RE: Standard corner radius

SPARE PARTS

Designation	 Clamp	 Clamp screw	 Spring	 Spring pin	 Shim	 Shim screw	 Wrench
AWLNR/L**0604-A	ACP3S-E	ACS-5W	BP-7	SP-2.5	ASW322	CSTB-3.5	T-15F
AWLNR/L**08-A	ACP4S	ACS-5W	BP-7	SP-2.5	ASW422	CSTB-3.5	T-15F

ADJNR/L

Double-clamp toolholder with 93° approach angle, for negative 55°/45° rhombic inserts



	Designation	H	B	LF	LH	HF	WF	**RE	Insert	*Torque
New	ADJNR/L2020H1104-A	20	20	100	30	20	25	0.8	DN**/FNMG1104...	3
	ADJNR/L2020K1104-A	20	20	125	30	20	25	0.8	DN**/FNMG1104...	3
New	ADJNR/L2525H1104-A	25	25	100	30	25	32	0.8	DN**/FNMG1104...	3
	ADJNR/L2525M1104-A	25	25	150	30	25	32	0.8	DN**/FNMG1104...	3
New	ADJNR/L2020H15-A	20	20	100	36	20	25	0.8	DN**/FNGA1504...	3
	ADJNR/L2020K15-A	20	20	125	36	20	25	0.8	DN**/FNGA1504...	3
New	ADJNR/L2525H15-A	25	25	100	36	25	32	0.8	DN**/FNGA1504...	3
	ADJNR/L2525M15-A	25	25	150	36	25	32	0.8	DN**/FNGA1504...	3
	ADJNR/L3225P15-A	32	25	170	36	32	32	0.8	DN**/FNGA1504...	3
New	ADJNR/L2020H1506-A	20	20	100	36	20	25	0.8	DN**/FNGA1506...	3
	ADJNR/L2020K1506-A	20	20	125	36	20	25	0.8	DN**/FNGA1506...	3
New	ADJNR/L2525H1506-A	25	25	100	36	25	32	0.8	DN**/FNGA1506...	3
	ADJNR/L2525M1506-A	25	25	150	36	25	32	0.8	DN**/FNGA1506...	3

*Torque: Recommended clamping torque (N·m)

**RE: Standard corner radius

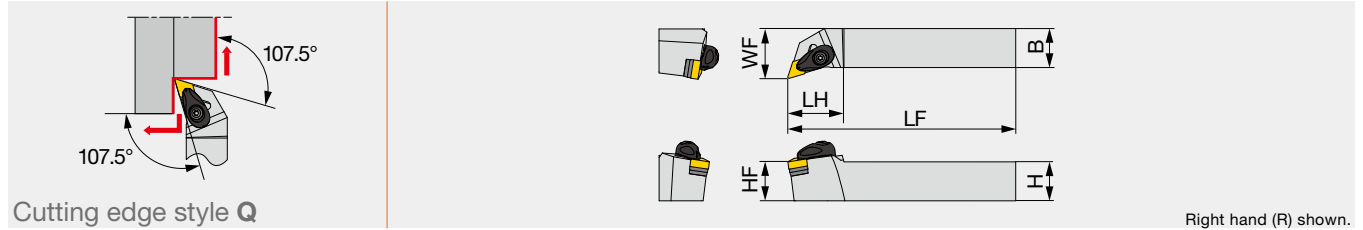
SPARE PARTS



Designation	Clamp	Clamp screw	Shim	Shim screw	Spring	Spring pin	Wrench
ADJNR/L**1104-A	ACP3S-E	ACS-5W	ASD322	CSTB-3.5	BP-7	SP-2.5	T-15F
ADJNR/L**15-A	ACP4S	ACS-5W	ASD432	CSTB-3.5	BP-7	SP-2.5	T-15F
ADJNR/L**1506-A	ACP4S	ACS-5W	ASD423	CSTB-3.5	BP-7	SP-2.5	T-15F

ADQNR/L

Double-clamp toolholder with 107.5° approach angle, for negative 55°/45° rhombic inserts



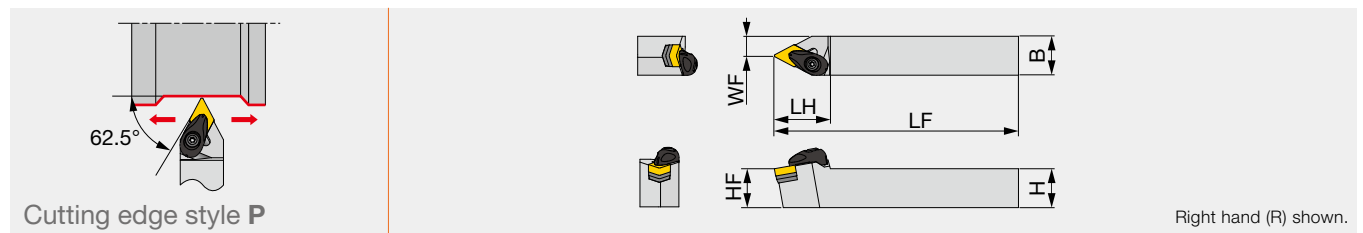
Designation	H	B	LF	LH	HF	WF	**RE	Insert	*Torque
ADQNR/L2020K1104-A	20	20	125	30	20	25	0.8	DN**/FNMG1104...	3
ADQNR/L2525M1104-A	25	25	150	30	25	32	0.8	DN**/FNMG1104...	3
ADQNR/L2020K15-A	20	20	125	32	20	25	0.8	DN**/FNGA1504...	3
ADQNR/L2525M15-A	25	25	150	36	25	32	0.8	DN**/FNGA1504...	3
ADQNR/L2020K1506-A	20	20	125	32	20	25	0.8	DN**/FNGA1506...	3
ADQNR/L2525M1506-A	25	25	150	36	25	32	0.8	DN**/FNGA1506...	3

*Torque: Recommended clamping torque (N·m)

**RE : Standard corner radius

ADPNN

Double-clamp toolholder with 62.5° approach angle, for negative 55°/45° rhombic inserts



Designation	H	B	LF	LH	HF	WF	**RE	Insert	*Torque
ADPNN2020K15-A	20	20	125	36	20	7.5	0.8	DN**/FNGA1504...	3
ADPNN2525M15-A	25	25	150	36	25	12.5	0.8	DN**/FNGA1504...	3

*Torque: Recommended clamping torque (N·m)

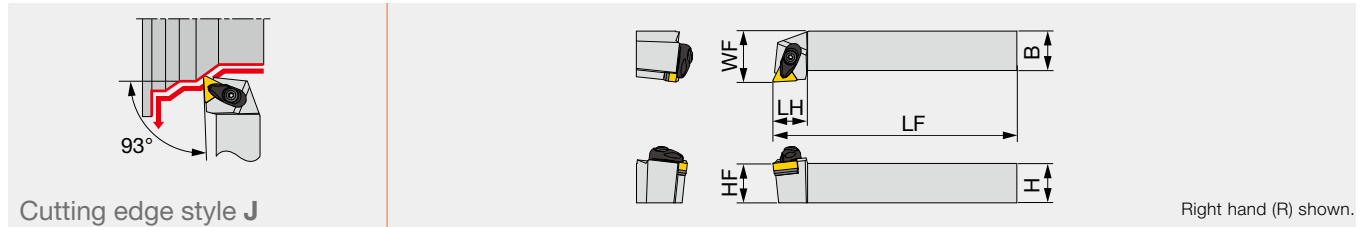
**RE: Standard corner radius

SPARE PARTS

Designation	 Clamp	 Clamp screw	 Spring	 Spring pin	 Shim	 Shim screw	 Wrench
ADQNR/L**1104-A	ACP3S-E	ACS-5W	BP-7	SP-2.5	ASD322	CSTB-3.5	T-15F
ADQNR/L**15-A, ADPNN**15-A	ACP4S	ACS-5W	BP-7	SP-2.5	ASD432	CSTB-3.5	T-15F
ADQNR/L**1506-A	ACP4S	ACS-5W	BP-7	SP-2.5	ASD423	CSTB-3.5	T-15F

ATJNR/L

Double-clamp toolholder with 93° approach angle, for negative 60° triangular inserts



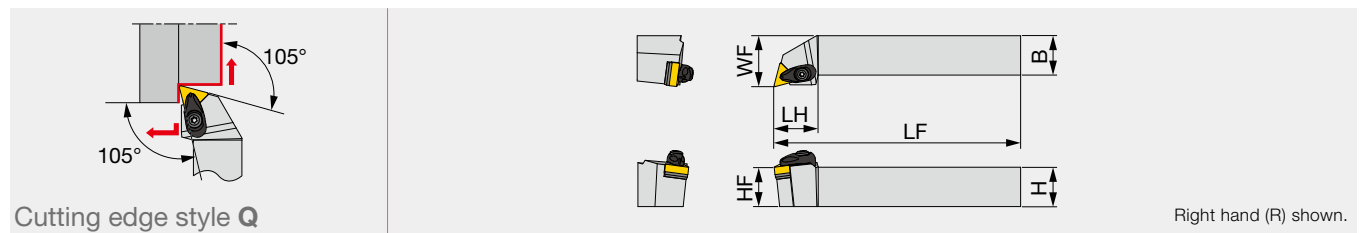
Designation	H	B	LF	LH	HF	WF	**RE	Insert	*Torque
ATJNR/L2020K16-A	20	20	125	22	20	25	0.8	TN**1604...	3
ATJNR/L2525M16-A	25	25	150	22	25	32	0.8	TN**1604...	3

*Torque: Recommended clamping torque (N·m)

**RE: Standard corner radius

ATQNR/L

Double-clamp toolholder with 105° approach angle, for negative 60° triangular inserts



	Designation	H	B	LF	LH	HF	WF	**RE	Insert	*Torque
New	ATQNR/L2020H16-A	20	20	100	28	20	25	0.8	TN**1604...	3
	ATQNR/L2020K16-A	20	20	125	28	20	25	0.8	TN**1604...	3
New	ATQNR/L2525H16-A	25	25	100	28	25	32	0.8	TN**1604...	3
	ATQNR/L2525M16-A	25	25	150	28	25	32	0.8	TN**1604...	3

*Torque: Recommended clamping torque (N·m)

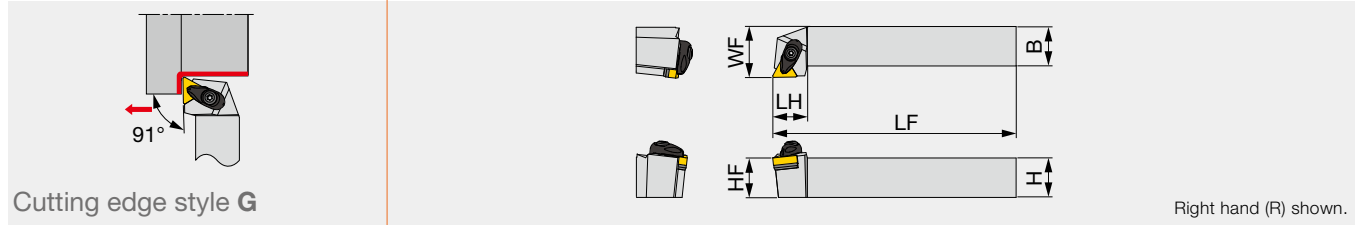
**RE: Standard corner radius

SPARE PARTS

							
Designation	Clamp	Clamp screw	Spring	Spring pin	Shim	Shim screw	Wrench
ATJNR/L**16-A, ATQNR/L**16-A	ACP3S	ACS-5W	BP-7	SP-2.5	AST322	CSTB-3.5	T-15F

ATGNR/L

Double-clamp toolholder with 91° approach angle, for negative triangle inserts



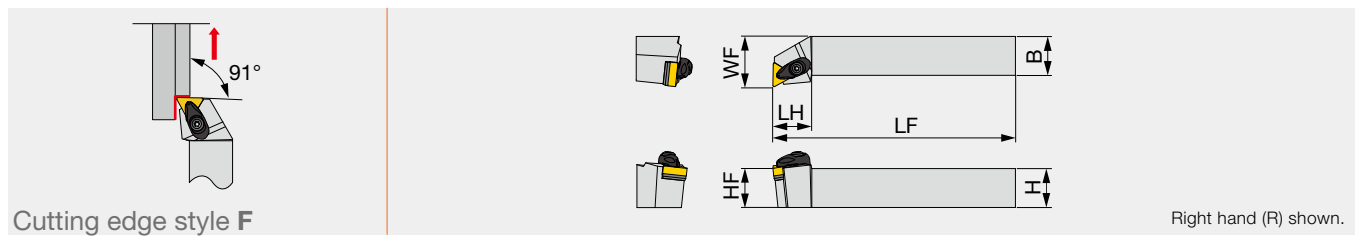
Designation	H	B	LF	LH	HF	WF	**RE	Insert	*Torque
ATGNR/L2020K16-A	20	20	125	22	20	25	0.8	TN**1604...	3
ATGNR/L2525M16-A	25	25	150	22	25	32	0.8	TN**1604...	3
ATGNR/L2525M22-A	25	25	150	26	25	32	0.8	TN**2204...	3

*Torque: Recommended clamping torque (N·m)

**RE: Standard corner radius

ATFNR/L

Double-clamp toolholder for facing with 91° approach angle, negative triangle inserts



Designation	H	B	LF	LH	HF	WF	**RE	Insert	*Torque
ATFNR/L2020K16-A	20	20	125	25	20	25	0.8	TN**1604...	3
ATFNR/L2525M16-A	25	25	150	25	25	32	0.8	TN**1604...	3
ATFNR/L2525M22-A	25	25	150	29	25	32	0.8	TN**2204...	3

*Torque: Recommended clamping torque (N·m)

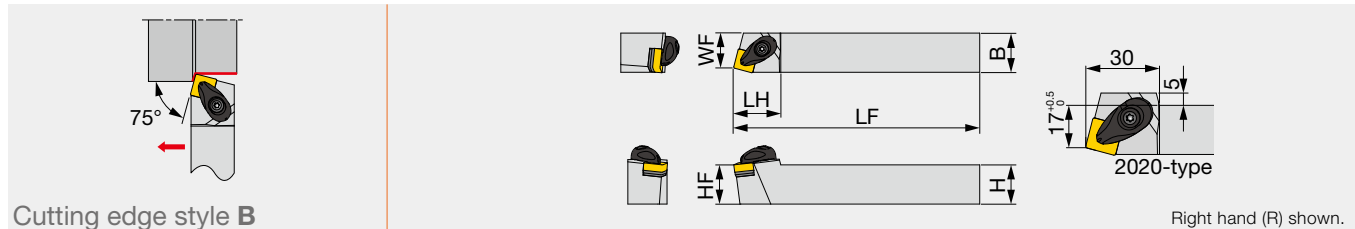
**RE: Standard corner radius

SPARE PARTS

Designation							
ATGNR/L**16-A, ATFNR/L**16-A	ACP3S	ACS-5W	BP-7	SP-2.5	AST322	CSTB-3.5	T-15F
ATGNR/L**22-A, ATFNR/L**22-A	ACP4S	ACS-5W	BP-7	SP-2.5	AST422	CSTB-3.5	T-15F

ASBNR/L

Double-clamp toolholder with 75° approach angle, for negative square inserts



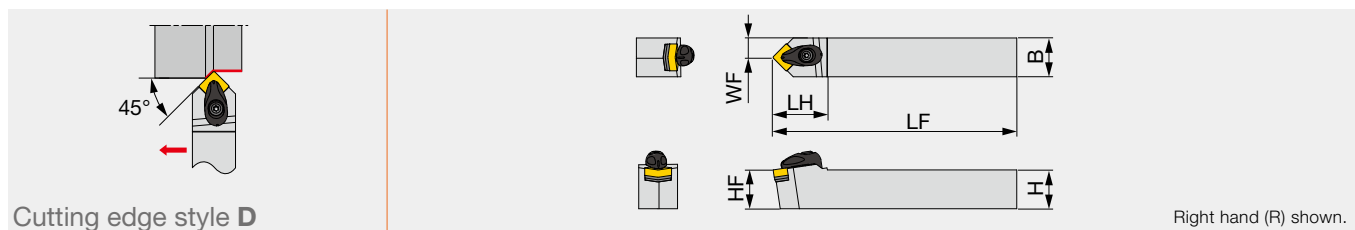
Designation	H	B	LF	LH	HF	WF	**RE	Insert	*Torque
ASBNR/L2020K12-A	20	20	125	30	20	17	0.8	SN**1204...	3
ASBNR/L2525M12-A	25	25	150	30	25	22	0.8	SN**1204...	3
ASBNR/L2525M15-A	25	25	150	42.5	25	22	1.2	SN**1506...	6.4
ASBNR/L3232P15-A	32	32	170	42.5	32	27	1.2	SN**1506...	6.4
ASBNR/L3232P19-A	32	32	170	47.5	32	27	1.2	SN**1906...	6.4
ASBNR/L4040S19-A	40	40	250	47.5	40	35	1.2	SN**1906...	6.4

*Torque: Recommended clamping torque (N·m)

**RE: Standard corner radius

ASDNN

Double-clamp toolholder with 45° approach angle, for negative square inserts



Designation	H	B	LF	LH	HF	WF	**RE	Insert	*Torque
ASDNN2020K12-A	20	20	125	35	20	10	0.8	SN**1204...	3
ASDNN2525M12-A	25	25	150	35	25	12.5	0.8	SN**1204...	3

*Torque: Recommended clamping torque (N·m)

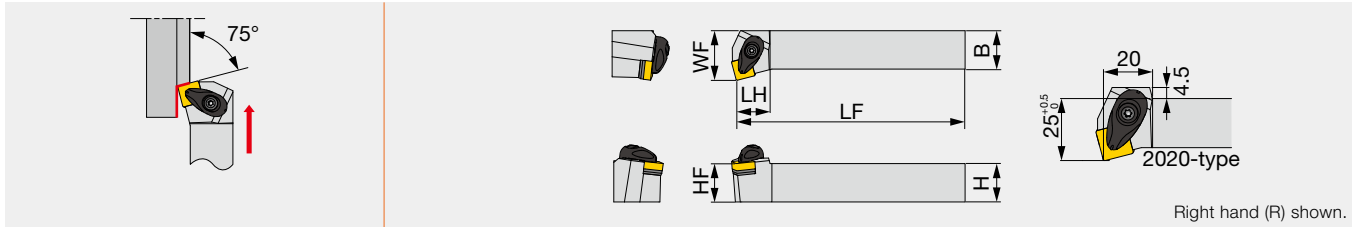
**RE: Standard corner radius

SPARE PARTS

Designation	Clamp	Clamp screw	Spring	Spring pin	Shim	Shim screw	Wrench1	Wrench2
ASBNR/L**12-A, ASDNN**12-A	ACP4S	ACS-5W	BP-7	SP-2.5	ASS422	CSTB-3.5	T-15F	-
ASBNR/L**15-A	ACP5S	ACS-6W	BP-8.8	SP-2.5	ASS533	CSTB-5	-	KEYV-T20
ASBNR/L**19-A	ACP6S	ACS-6W	BP-8.8	SP-2.5	ASS634	CSTB-5	-	KEYV-T20

ASKNR/L

Double-clamp toolholder with 75° approach angle, for negative square inserts



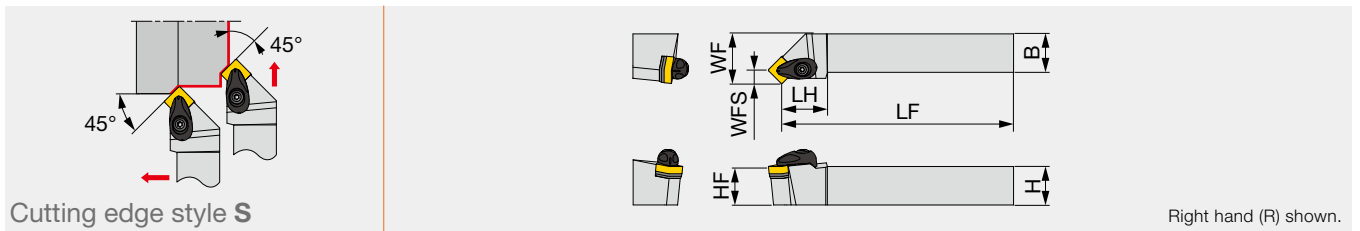
Designation	H	B	LF	LH	HF	WF	**RE	Insert	*Torque
ASKNR/L2020K12-A	20	20	125	20	20	25	0.8	SN**1204...	3
ASKNR/L2525M12-A	25	25	150	22	25	32	0.8	SN**1204...	3

*Torque: Recommended clamping torque (N·m)

**RE: Standard corner radius

ASSNR/L

Double-clamp toolholder with 45° approach angle (S-style), for negative square inserts



Designation	H	B	LF	LH	HF	WF	WFS	**RE	Insert	*Torque
ASSNR/L2020K12-A	20	20	125	30	20	25	8.3	0.8	SN**1204...	3
ASSNR/L2525M12-A	25	25	150	30	25	32	8.3	0.8	SN**1204...	3
ASSNR/L2525M15-A	25	25	150	25	25	32	10.3	1.2	SN**1506...	6.4
ASSNR/L3232P15-A	32	32	170	25	32	40	10.3	1.2	SN**1506...	6.4
ASSNR/L3232P19-A	32	32	170	27.5	32	40	12.5	1.2	SN**1906...	6.4
ASSNR/L4040S19-A	40	40	250	27.5	40	50	12.5	1.2	SN**1906...	6.4

*Torque: Recommended clamping torque (N·m)

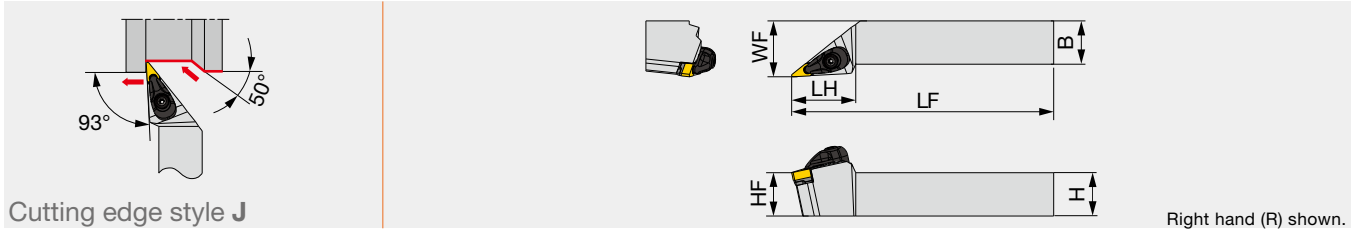
**RE: Standard corner radius

SPARE PARTS

Designation	Clamp	Clamp screw	Spring	Spring pin	Shim	Shim screw	Wrench1	Wrench2
ASKNR/L**12-A, ASSNR/L**12-A	ACP4S	ACS-5W	BP-7	SP-2.5	ASS422	CSTB-3.5	T-15F	-
ASSNR/L**15-A	ACP5S	ACS-6W	BP-8.8	SP-2.5	ASS533	CSTB-5	-	KEYV-T20
ASSNR/L**19-A	ACP6S	ACS-6W	BP-8.8	SP-2.5	ASS634	CSTB-5	-	KEYV-T20

AVJNR/L

Double-clamp toolholder with 93° approach angle, for negative 35°/25° rhombic inserts



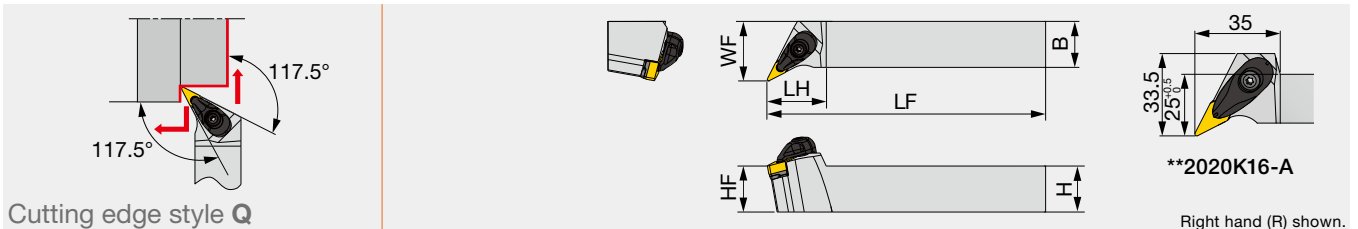
	Designation	H	B	LF	LH	HF	WF	**RE	Insert	*Torque
New	AVJNR/L2020H1204-A	20	20	100	37	20	25	0.8	VN**1204...	3
	AVJNR/L2020K1204-A	20	20	125	37	20	25	0.8	VN**1204...	3
New	AVJNR/L2525H1204-A	25	25	100	37	25	32	0.8	VN**1204...	3
	AVJNR/L2525M1204-A	25	25	150	37	25	32	0.8	VN**1204...	3
New	AVJNR/L2020J16-A	20	20	110	43	20	25	0.8	VN**/YN**1604...	3
	AVJNR/L2020K16-A	20	20	125	43	20	25	0.8	VN**/YN**1604...	3
New	AVJNR/L2525J16-A	25	25	110	46	25	32	0.8	VN**/YN**1604...	3
	AVJNR/L2525M16-A	25	25	150	46	25	32	0.8	VN**/YN**1604...	3

*Torque: Recommended clamping torque (N·m)

**RE: Standard corner radius

AVQNR/L

Double-clamp toolholder with 117.5° approach angle, for negative 35°/25° rhombic inserts



	Designation	H	B	LF	LH	HF	WF	**RE	Insert	*Torque
	AVQNR/L2020K1204-A	20	20	125	32	20	25	0.8	VN**1204...	3
	AVQNR/L2525M1204-A	25	25	150	32	25	32	0.8	VN**1204...	3
	AVQNR/L2020K16-A	20	20	125	35	20	25	0.8	VN**/YN**1604...	3
	AVQNR/L2525M16-A	25	25	150	35	25	32	0.8	VN**/YN**1604...	3

*Torque: Recommended clamping torque (N·m)

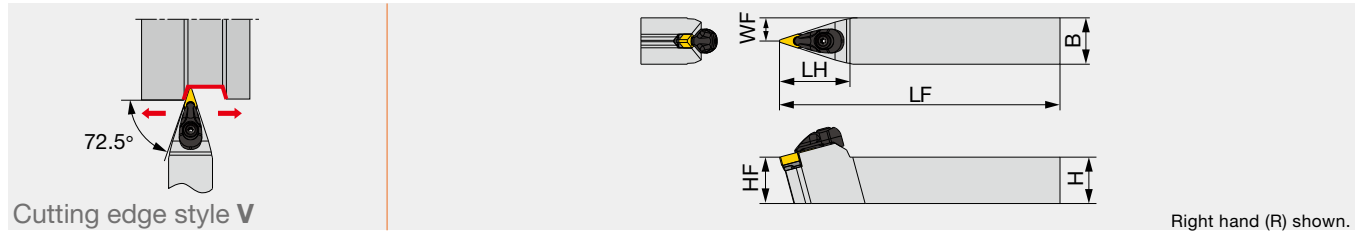
**RE: Standard corner radius

SPARE PARTS

Designation	Clamp	Clamp screw	Spring	Spring pin	Shim	Shim screw	Wrench 1	Wrench 2
AVJNR/L**1204-A	ACP3L-E	ACS-5W	BP-7	SP-2.5	ASV222	CSTB-3.0	T-9F	T-15F
AVQNR/L**1204-A								
AVJNR/L**16-A	ACP3L	ACS-5W	BP-7	SP-2.5	ASV322	CSTB-3.5	T-9F	T-15F
AVQNR/L**16-A								

AVVNN

Double-clamp toolholder with 72.5° approach angle, for negative 35°/25° rhombic inserts



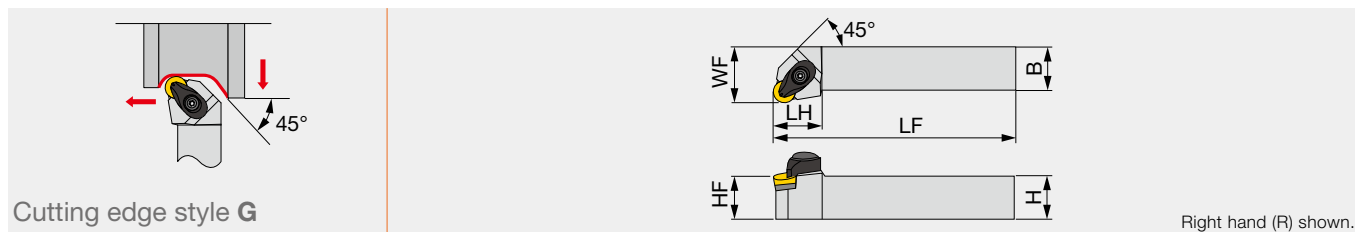
Designation	H	B	LF	LH	HF	WF	**RE	Insert	*Torque
AVVNN2020K1204-A	20	20	125	38	20	10	0.8	VN**1204...	3
AVVNN2525M1204-A	25	25	150	38	25	12.5	0.8	VN**1204...	3
AVVNN2020K16-A	20	20	125	46	20	10	0.8	VN**/YN**1604...	3
AVVNN2525M16-A	25	25	150	46	25	12.5	0.8	VN**/YN**1604...	3

*Torque: Recommended clamping torque (N-m)

**RE: Standard corner radius

ARGNR/L

Double-clamp toolholder with 91° approach angle, for negative round inserts



Designation	H	B	LF	LH	HF	WF	**RE	Insert	*Torque
ARGNR/L2525M12-A	25	25	150	28	25	32	6.35	RN**120400	3

*Torque: Recommended clamping torque (N-m)

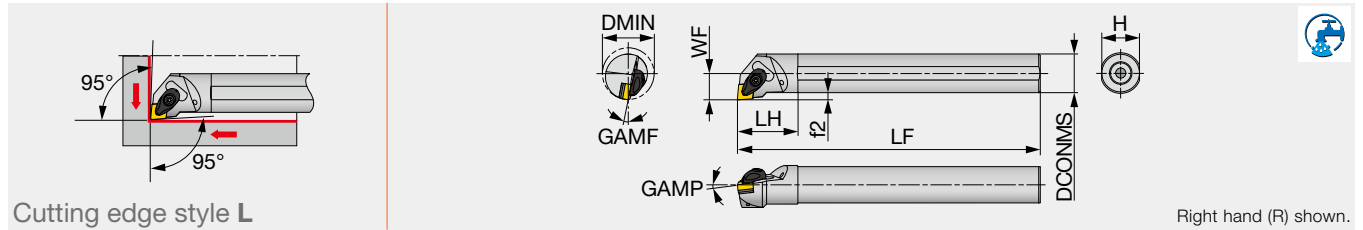
**RE: Standard corner radius

SPARE PARTS

Designation	Clamp	Clamp screw	Spring	Spring pin	Shim 1	Shim 2	Shim screw	Wrench 1	Wrench 2
AVVNN**1204-A	ACP3L-E	ACS-5W	BP-7	SP-2.5	ASV222	-	CSTB-3.0	T-9F	T-15F
AVVNN**16-A	ACP3L	ACS-5W	BP-7	SP-2.5	ASV322	-	CSTB-3.5	T-9F	T-15F
ARGNR/L...	ACP4S	ACS-5W	BP-7	SP-2.5	-	ASR420	CSTB-3.5	-	T-15F

A-ACLNLR/L

Double-clamp boring bar, for negative 80°/70° rhombic inserts



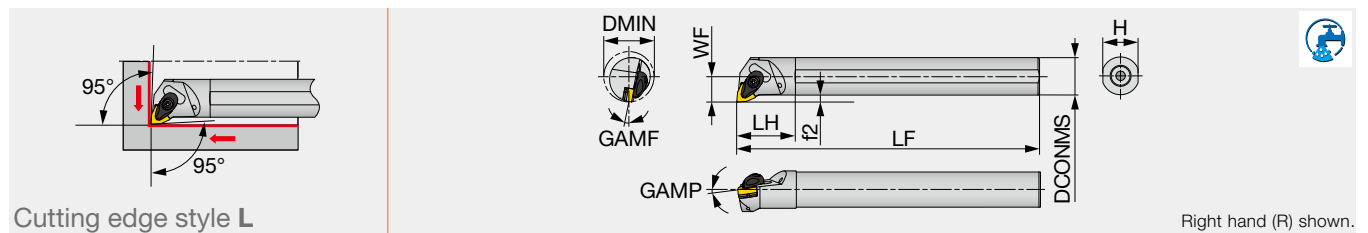
Designation	Material	DMIN	DCONMS	WF	LF	LH	H	f2	GAMP	GAMF	**RE	Insert	*Torque
A25R-ACLNLR/L0904-D320	Steel	32	25	17	200	45	23	4.5	-6°	-13°	0.8	CN**/GNMG0904...	3
A32S-ACLNLR/L0904-D400	Steel	40	32	22	250	50	30	6	-6°	-10°	0.8	CN**/GNMG0904...	3
A25R-ACLNLR/L12-D320	Steel	32	25	17	200	45	23	4.5	-6°	-13°	0.8	CN**/GNGA1204...	3
A32S-ACLNLR/L12-D400	Steel	40	32	22	250	50	30	6	-6°	-10°	0.8	CN**/GNGA1204...	3
A40T-ACLNLR/L12-D500	Steel	50	40	27	300	55	37	7	-6°	-8°	0.8	CN**/GNGA1204...	3
A50U-ACLNLR12-D630	Steel	63	50	35	350	65	47	10	-6°	-7°	0.8	CN**/GNGA1204...	3

*Torque: Recommended clamping torque (N-m)

**RE: Standard corner radius

A-AWLNR/L

Double-clamp boring bar, for negative 80° trigon inserts



Designation	Material	DMIN	DCONMS	WF	LF	LH	H	f2	GAMP	GAMF	**RE	Insert	*Torque
A25R-AWLNR/L0604-D320	Steel	32	25	17	200	45	23	4.5	-6°	-13°	0.8	WN**0604...	3
A32S-AWLNR/L0604-D400	Steel	40	32	22	250	50	30	6	-6°	-10°	0.8	WN**0604...	3
A25R-AWLNR/L06-D320	Steel	32	25	17	200	45	23	4.5	-6°	-13°	0.8	WN**0604...	3
A32S-AWLNR/L06-D400	Steel	40	32	22	250	50	30	6	-6°	-10°	0.8	WN**0604...	3
A25R-AWLNR/L08-D320	Steel	32	25	17	200	45	23	4.5	-6°	-13°	0.8	WN**0804...	3
A32S-AWLNR/L08-D400	Steel	40	32	22	250	50	30	6	-6°	-10°	0.8	WN**0804...	3
A40T-AWLNR/L08-D500	Steel	50	40	27	300	55	37	7	-6°	-8°	0.8	WN**0804...	3
A50U-AWLNR/L08-D630	Steel	63	50	35	350	65	47	10	-6°	-7°	0.8	WN**0804...	3

*Torque: Recommended clamping torque (N-m)

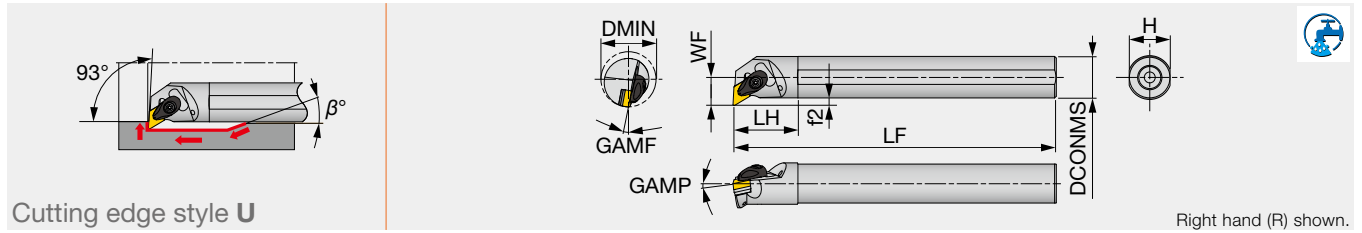
**RE: Standard corner radius

SPARE PARTS

Designation	Clamp	Clamp screw	Spring	Spring pin	Shim 1	Shim 2	Shim screw	Wrench
A**-ACLNLR/L0904-D...	ACP3S-E	ACS-5W	BP-7	SP-2.5	ASC322	-	CSTB-3.5	T-15F
A**-ACLNLR/L12-D...	ACP4S	ACS-5W	BP-7	SP-2.5	ASC422	-	CSTB-3.5	T-15F
A**-AWLNR/L0604-D...	ACP3S-E	ACS-5W	BP-7	SP-2.5	-	ASW322	CSTB-3.5	T-15F
A**-AWLNR/L06-D...	ACP3S	ACS-5W	BP-7	SP-2.5	-	ASW322	CSTB-3.5	T-15F
A**-AWLNR/L08-D...	ACP4S	ACS-5W	BP-7	SP-2.5	-	ASW422	CSTB-3.5	T-15F

A-ADUNR/L

Double-clamp boring bar, for negative 55°/45° rhombic inserts



Designation	Material	DMIN	DCONMS	WF	LF	LH	H	f2	GAMP	GAMF	β°	**RE	Insert	*Torque
A25R-ADUNR/L1104-D320	Steel	32	25	17	200	45	23	4.5	-6°	-13°	20	0.8	DN**/FNMG1104...	3
A32S-ADUNR/L1104-D400	Steel	40	32	22	250	50	30	6	-6°	-11°	20	0.8	DN**/FNMG1104...	3
A25R-ADUNR/L15-D320	Steel	32	25	17	200	45	23	4.5	-6°	-13°	30	0.8	DN**/FNGA1504...	3
A32S-ADUNR/L15-D400	Steel	40	32	22	250	50	30	6	-6°	-11°	20	0.8	DN**/FNGA1504...	3
A40T-ADUNR15-D500	Steel	50	40	27	300	55	37	7	-6°	-8°	15	0.8	DN**/FNGA1504...	3
A50U-ADUNR15-D630	Steel	63	50	35	350	65	47	10	-6°	-7°	15	0.8	DN**/FNGA1504...	3
A25R-ADUNR/L1506-D320	Steel	32	25	17	200	45	23	4.5	-6°	-13°	15	0.8	DN**/FNGA1506...	3
A32S-ADUNR/L1506-D400	Steel	40	32	22	250	50	30	6	-6°	-11°	20	0.8	DN**/FNGA1506...	3

*Torque: Recommended clamping torque (N-m)

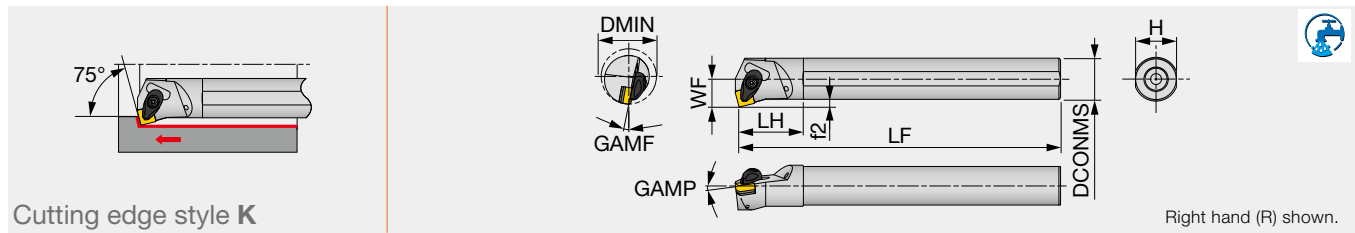
**RE : Standard corner radius

SPARE PARTS

Designation	Clamp	Clamp screw	Spring	Spring pin	Shim	Shim screw	Wrench
A**-ADUNR/L1104-D...	ACP3S-E	ACS-5W	BP-7	SP-2.5	ASD322	CSTB-3.5	T-15F
A**-ADUNR/L15-D...	ACP4S	ACS-5W	BP-7	SP-2.5	ASD432	CSTB-3.5	T-15F
A**-ADUNR/L1506-D...	ACP4S	ACS-5W	BP-7	SP-2.5	ASD423	CSTB-3.5	T-15F

A-ASKNR/L

Double-clamp boring bar, for negative square inserts



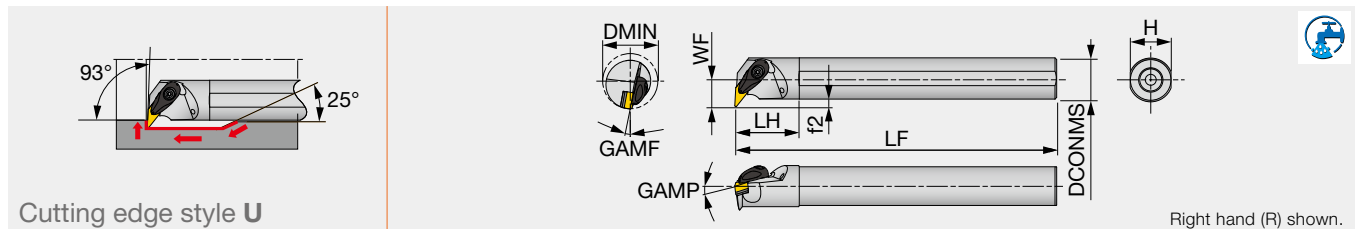
Designation	Material	DMIN	DCONMS	WF	LF	LH	H	f2	GAMP	GAMF	**RE	Insert	*Torque
A25R-ASKNR/L12-D320	Steel	32	25	17	200	45	23	4.5	-6°	-13°	0.8	SN**1204...	3
A32S-ASKNR/L12-D400	Steel	40	32	22	250	50	30	6	-6°	-10°	0.8	SN**1204...	3

*Torque: Recommended clamping torque (N-m)

**RE : Standard corner radius

A-AVUNR/L

Double-clamp boring bar, for negative 35°/25° rhombic inserts



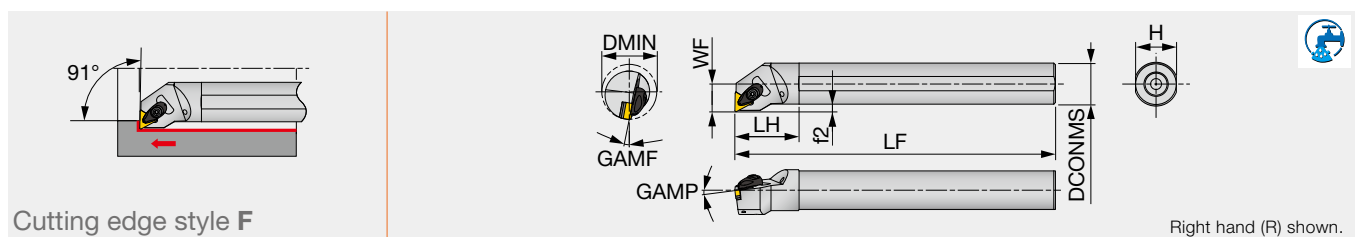
Designation	Material	DMIN	DCONMS	WF	LF	LH	H	f2	GAMP	GAMF	**RE	Insert	*Torque
A32S-AVUNR/L16-D400	Steel	40	32	22	250	50	30	6	-6°	-10°	0.8	VN**/YN**1604...	3
A40T-AVUNR/L16-D500	Steel	50	40	27	300	55	37	7	-6°	-8°	0.8	VN**/YN**1604...	3

*Torque: Recommended clamping torque (N-m)

**RE : Standard corner radius

A-ATFNR/L

Double-clamp boring bar, for negative 60° triangular inserts



Designation	Material	DMIN	DCONMS	WF	LF	LH	H	f2	GAMP	GAMF	**RE	Insert	*Torque
A25R-ATFNR/L16-D320	Steel	32	25	17	200	45	23	4.5	-6°	-13°	0.8	TN**1604...	3
A32S-ATFNR/L16-D400	Steel	40	32	22	250	50	30	6	-6°	-10°	0.8	TN**1604...	3

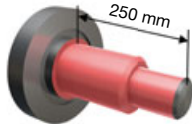
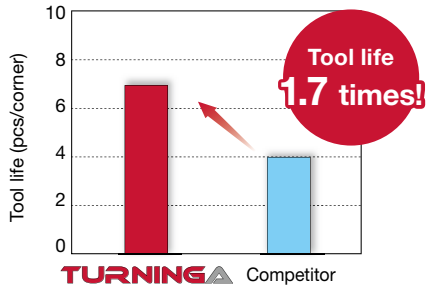
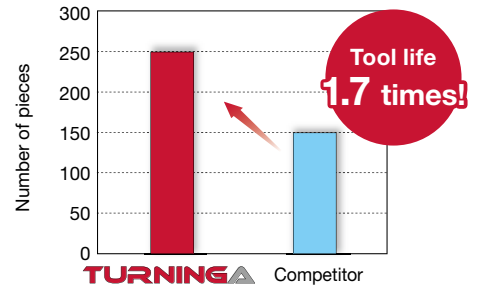
*Torque: Recommended clamping torque (N-m)

**RE : Standard corner radius

SPARE PARTS

Designation	Clamp	Clamp screw	Spring	Spring pin	Shim 1	Shim 2	Shim 3	Shim screw	Wrench
A**-ASKN*12-D...	ACP4S	ACS-5W	BP-7	SP-2.5	ASS422	-	-	CSTB-3.5	T-15F
A**-AVUNR/L16-D...	ACP3L	ACS-5W	BP-7	SP-2.5	-	ASV322	-	CSTB-3.5	T-15F
A**-ATFNR/L16-D...	ACP3S	ACS-5W	BP-7	SP-2.5	-	-	AST322	CSTB-3.5	T-15F

PRACTICAL EXAMPLES

Workpiece type		Shaft parts	Hub (Automotive parts)
Toolholder		ACLNR2525M12-A	AWLNR2525M08-A
Insert		CNMG120408-TM	WNMG080412-TM
Grade		T9215	T9225
Workpiece material		SCM440 (42CrMo4)	SCM420 (Alloy Steel)
		 P	 P
Cutting conditions	Cutting speed : V_c (m/min)	250	220
	Feed : f (mm/rev)	0.3	0.3
	Depth of cut : a_p (mm)	3.5	1
	Machining	External profiling (Continuous)	Face & Profiling (Continuous & Interrupted)
	Coolant	Wet	Wet
Results		 TURNING Competitor High clamping rigidity improves workpiece accuracy. Tool life can be improved by 170%.	 TURNING Competitor High clamping strength drastically decreases the potential for sudden fracture. Tool life can be improved by 170%.

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