

PCLN (External / Facing)

Side Rake Angle: -6°
Angle of Inclination: -6°

● **Applicable Inserts**

Toolholder	Insert	
PCLN%...12-3B	CN□G	33..
PCLN%...16-3D		
PCLN%...12-4B	CN□A CN□G CN□M	43..
PCLN%...16-4D		
PCLN%...-09		
PCLN%...-12	CN□A CN□G CN□M	43..
PCLN%...-16		

● Right-hand shown

Toolholder Dimensions

Part Number	Stock		Unit	Dimensions							Standard Corner-R(rε)	Spare Parts					
	R	L		H1=h	B	L1	L2	F1	F2	Lever		Lock Screw	Shim	Shim Pin	Punch	Wrench	
PCLN% 12-3B	●		Inch	0.75	0.75	4.50	0.87	1.00	0.61	1/32	LL-1N	LS-1N	LC-32N	LSP-1	PC-1	FH-2.5	
PCLN% 12-4B	●			0.75	0.75	4.50	1.06	1.00	0.80	1/32	LL-2N	LS-2N	LC-42N	LSP-2	PC-2	LW-3	
PCLN% 16-4D	●			1.00	1.00	6.00	1.06	1.25	0.78								
PCLN% 1616H-09	○	○	mm	16	16	100	22	20	14	0.8	LL-1N	LS-1N	LC-32N	LSP-1	PC-1	FH-2.5	
PCLN% 2020K-09	○	○		20	20	125	22	25	15								
PCLN% 2525M-09	○	○		25	25	150	22	32	18								
PCLN% 1616H-12	○	○	mm	16	16	100	27	20	17	0.8	LL-2N	LS-2N	LC-42N *LC-42N-20	LSP-2	PC-2	LW-3	
PCLN% 2020H-12*	○			20	20	100	27	25	20								
PCLN% 2020K-12	○	○		20	20	125	27	25	20								
PCLN% 2525M-12	○	○		25	25	150	27	32	20								
PCLN% 3225P-12	○	○		32	25	170	27	32	20								
PCLN% 2525M-16	○	○		25	25	150	32	32	25								
PCLN% 3232P-16	○	○	32	32	170	32	40	27	0.8	LL-5N	LS-4N	LC-53N	LSP-3	-	LW-3		

* Mark indicates short shank type.

● When using inserts whose corner-R(ε) is greater than 1/16", please purchase a shim with * mark and use it in order to prevent workpiece and shim from interfering with each other.

Applicable Inserts

Application	Finishing	Finishing-Medium	Finishing	Finishing-Medium	Finishing-Medium	Finishing-Medium	Medium-Roughing	Medium-Roughing
Ref. Page	● B14	● B14	● B14	● B14	● B14	● B15	● B15	● B15
Insert	WP (Wiper)	WQ (Wiper)	PP	PQ	CQ	CJ	GS	PG
Size	43..	43..	43..	43..	43.., 54..	43.., 54..	33.., 43..	43..
Application	Medium-Roughing	Medium-Roughing	Medium-Roughing / High Feed Rate	Roughing	Roughing	Single Sided / Roughing / High Feed Rate	Finishing	Medium
Ref. Page	● B15	● B15	● B16	● B16	● B16	● B17	● B21	● B21
Insert	PS	HS	PT	Standard	PH	PX	%-S	%
Size	43.., 54..	43.., 54.., 64..	43.., 54..	43.., 54.., 64..	43.., 54.., 64..	43.., 54.., 64..	33..	33.., 43..
Application	Soft Steel / Small D.O.C.	Soft Steel / Finishing	Soft Steel / Medium	Soft Steel / Roughing	Stainless Steel / Finishing	Stainless Steel / Medium-Roughing	Stainless Steel / Medium-Roughing	Cast Iron
Ref. Page	● B17	● B17	● B17	● B17	● B19	● B19	● B19	● B19
Insert	XF	XP	XQ	XS	MQ	MS	MU	C
Size	43..	43..	43..	43..	43..	43..	43.., 54.., 64..	43.., 54..
Application	Cast Iron	Cast Iron	Cast Iron	Cast Iron	Non-ferrous Metals	Non-ferrous Metals	Non-ferrous Metals	Hard Materials
Ref. Page	● B19	● B20	● B20	● B90	● B20	● B20	● C23	● C6, C7
Insert	ZS	GC	Without Chipbreaker	Ceramic	AH	A3	PCD	CBN
Size	43..	43..	43..	43..	43..	43..	43..	43..