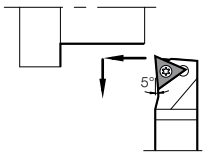
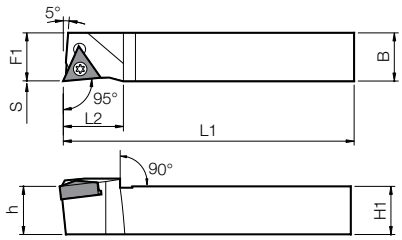
для заказа - kyocera@kyocera-tools.ru

STLN (Without Offset • External / Up Facing)





Side Rake Angle : - 6°
Inclination Angle : - 7°

• Right-hand Shown

Toolholder Dimensions

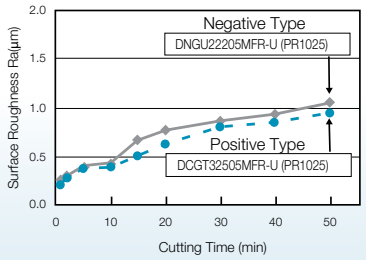
Part Number		Stock	Unit	Dimensions H1=h	B	L1	L2	F1	S	Standard Corner-R(rε)	Spare Parts Clamp Screw	Spare Parts Wrench	Applicable Inserts
STLNR	6-1.8FF	●	inch	0.375	0.375	6.00	0.590	0.375	0	0.008	SB-2570TR	LTW-8SS	TNGU182..
	8-1.8DF	●		0.500	0.500	6.00	0.590	0.500	0				
	10-1.8CF	●		0.625	0.625	5.00	0.590	0.625	0				
STLNR	1010K-09FF	●	mm	10	10	120	15	10	0	0.2	SB-2570TR	LTW-8SS	TNGU182..
	1212F-09FF	●		12	12	85	15	12	0				
	1212K-09FF	●		12	12	120	15	12	0				
	1616K-09FF	●		16	16	120	15	16	0				

Applicable Inserts

Application	Finishing	Low Feed
Ref. Page	B51	B51
Insert / Toolholder	FR-F 	(E/F)R-U 
STLNR...1.8... STLNR...-09FF	TNGU182..	TNGU182..

Double-sided design allows both edges to be used. Compared to the positive type, the double-sided design offers less cost per insert and more stability.

Surface roughness comparison (Sharp edge)



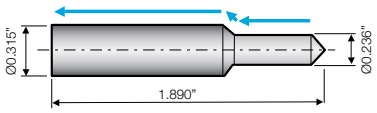
<Cutting Conditions>
Workpiece Material : 1045 Steel Vc = 325 sfm, D.O.C. = 0.059", f = 0.0012 ipr, Wet

(Internal Evaluation)

Case Studies

303 Stainless Steel

• Spool
<0.236" Dia. portion>
• Vc = 225 sfm
• D.O.C. = 0.049"
• f = 0.001 ipr
• Wet
<0.315" Dia. portion>
• Vc = 425 sfm
• D.O.C. = 0.001"
• f = 0.001 ipr
• Wet



Required Surface 0.8μmRa

DNGU22205MF-SK (PR1025)	60,000 pcs/Insert (4 edges)
Competitor D (DCGT)	20,000 pcs/Insert (2 edges)

Competitor D (DCGT) machined 10,000 pcs/edge. PR1025 machined 15,000 pcs/edge resulting in 3 times longer tool life per insert.

(User Evaluation)

Recommended Cutting Conditions

Workpiece Material	Grades PR1005	PR1025	PR1225	PR1425
Free-Cutting Steel	◕ Vc=325sfm (200~500)	-	-	-
Carbon Steel / Alloy Steel	◔ Vc=325sfm (200~500)	◔ Vc=325sfm (200~500)	◔ Vc=325sfm (200~500)	◕ Vc=400sfm (200~650)
Stainless Steel	-	◔ Vc=325sfm (200~500)	◕ Vc=250sfm (175~500)	○ Vc=325sfm (250~500)

◕ : Continuous to Light interruption / 1st Recommendation
◔ : Continuous to Light interruption / 2nd Recommendation
● : Continuous / 1st Recommendation
○ : Continuous / 2nd Recommendation

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● : U.S. Stock Standard
○ : World Express (Shipping: 7-10 Business Days)