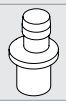
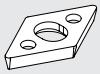
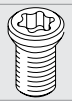
для заказа - kyocera@kyocera-tools.ru

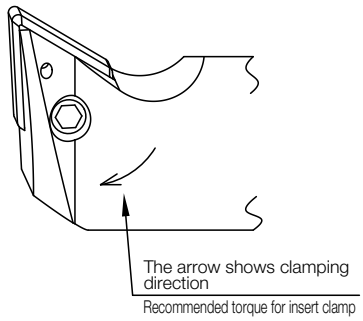
Spare Parts (Common)

Toolholder Part Number	Spare Parts									
	Lever	Lock Screw	Shim	Shim Pin	Punch	Wrench	Lock Pin	Shim	Shim Screw	Wrench (for Shim Screw)
										
S25R - PD□N□15-32	-	-	-	-	-	LW-3	PP-4	PD-42	SB-2050TR	FT-6
S32S - PD□N□15-44	LL-3N	LS-2N	LD-42	LSP-2	PC-2	LW-3	-	-	-	-
S40T - PD□N□15-54			*LD-42-20							

· Shim When using inserts whose corner-R(rε) = 1.60mm or larger for S25R-PD□N□15-32, use shim modified by additional processing to prevent interference between workpiece and shim.
When using inserts whose corner-R(rε) = 1.60mm or larger for S32S-PD□N□15-44 and S40T-PD□N□15-54, purchase and use shim with * mark separately to prevent interference between workpiece and shim.

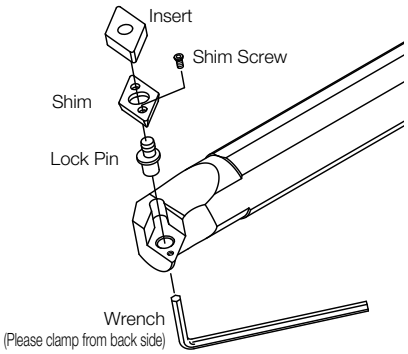
How to Change S25R-PD□N□15-32 Inserts

· Please replace S25R-PD□N□15-32 insert from the back side

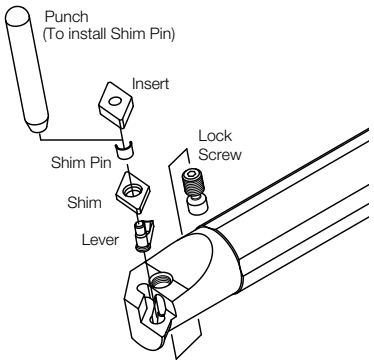


How to Assemble Spare Parts

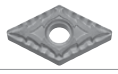
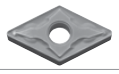
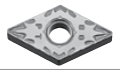
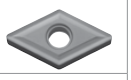
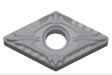
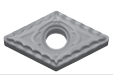
· S25R-PD□N□15-32 (Pin Lock)



· S32S-PD□N□15-44 (Lever Lock)
· S40T-PD□N□15-54 (Lever Lock)



Applicable Inserts

Application	Finishing	Finishing-Medium	Finishing-Medium	Finishing-Medium	Medium-Roughing	Medium-Roughing	Medium-Roughing	Medium-Roughing / High Feed Rate	Roughing
Ref. Page	B22	B22	B22	B23	B23	B23	B24	B24	B24
Insert / Toolholder	**PP**	**PQ**	**CQ**	**CJ**	**GS**	**PG**	**PS**	**PT**	**Standard**
									
...-PD□N□15-...	DNMG43..	DNMG43..	DNMG43..	DNMG43..	DNMG43..	DNMG43..	DNMG43..	DNMG43..	DNMG43..
Application	Roughing	Single Sided / Roughing / High Feed Rate	Medium	Low Carbon Steel / Finishing	Low Carbon Steel / Medium	Low Carbon Steel / Roughing	Stainless Steel / Finishing	Stainless Steel / Medium-Roughing	Stainless Steel / Medium-Roughing
Ref. Page	B24	B25	B27	B25	B25	B25	B26	B26	B26
Insert / Toolholder	**PH**	**PX**	**□**	**XP**	**XQ**	**XS**	**MQ**	**MS**	**MU**
									
...-PD□N□15-...	DNMG43..	DNMM43..	DNGG43..	DNMG43..	DNMG43..	DNMG43..	DNMG43..	DNMG43..	DNMG43..
Application	Stainless Steel / Medium-Roughing	Cast Iron	Cast Iron	Cast Iron	Cast Iron	Non-ferrous Metals	Non-ferrous Metals	Non-ferrous Metals	Hardened Materials
Ref. Page	B26	B26	B27	B27	B91	B27	B27	C23	C8, C9
Insert / Toolholder	**TK**	**C**	**ZS**	**GC**	**Ceramic**	**AH**	**□-A3**	**PCD**	**CBN**
									
...-PD□N□15-...	DNMG43..	DNMG43..	DNMG43..	DNMG43..	DNGA43..	DN_G43..	DNGG43..	DNMM43..	DNGA43..

Recommended Cutting Conditions → **F103~F104**

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