

● Toolholder Dimensions

Description			Std.	No. of Insert	No. of Flute	Dimension (mm)					Rake Angle (°)		Drawing	Spare Parts			
						øD	ød	L	ℓ	S	S1	A.R.		R.R.	Clamp Screw	Wrench	Anti-seize Compound
																	
Cylindrical Long Shank	MEY	16-S16-190	●	4	2	16	16	190	61	19	4.5	+11°	-11°	Fig.4	SB-2040TRG	DTM-6	MP-1
		17-S16-190	●			17			31								
		20-S20-200	●			20	200	63	22	6	+13°				-9°		
		21-S20-200	●					21								35	
		25-S25-220	●			25	220	80	28	7.5		-11°					
		26-S25-220	●					26					40				
		32-S32-230	●			32	230	90	36	9.5	-9°						
		33-S32-230	●					33					50				
		40-S32-240	●	7		40	240	55	42	7.5		-11°	Fig.5	SB-3070TRG	DT-10		
		50-S42-250	●			50								42	250	70	

• S1 shows the edge length of the complete 2-flute part.

● Applicable Inserts (Quantity of Inserts)

Description		Applicable Inserts M18			
		Side Edge Insert		Center Edge Insert	
					
MEY	16-S16(-...)	JOMT08T208ER-D		GOMT08T208ER-D	1 pc
	17-S16(-...)	JOMT100308ER-D		GOMT100308ER-D	
	20-S20(-...)	JOMT100308ER-D		GOMT100308ER-D	
	21-S20(-...)	JOMT13T308ER-D		GOMT13T308ER-D	
	25-S25(-...)	JOMT13T308ER-D		GOMT13T308ER-D	
	26-S25(-...)	JOMT160408ER-D		GOMT160408ER-D	
	32-S32(-...)	JOMT160408ER-D		GOMT160408ER-D	
	33-S32(-...)	JOMT13T308ER-D		GOMT13T308ER-D	
	40-S32(-...)	JOMT13T308ER-D		GOMT13T308ER-D	1 pc
	50-S42(-...)	JOMT160408ER-D		GOMT160408ER-D	

◆ Recommended Cutting Conditions

Workpiece Material	fz (mm/t)		Recommended Insert Grade (Cutting Speed Vc : m/min)												
			Cermet			PVD Coated Carbide						Carbide			
	Drilling	Shouldering Slotting	TN60	TN100M	TC60	PR630	PR730	PR830				PR660	PR905	PW30	KW10
Stainless Steel	0.08~0.12	0.05~0.15						★ 100~180							
Carbon Steel	0.08~0.15	0.05~0.25						★ 120~200							
Alloy Steel	0.08~0.15	0.05~0.25						★ 100~180							
Mold Steel	0.08~0.12	0.05~0.15						★ 80~150							
Cast Iron	0.05~0.20	0.05~0.25											★ 100~200		

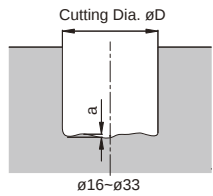
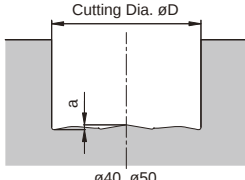
★ : 1st Recommendation

● Caution of drilling

- 1) Drilling conditions should be calculated as one flute line.
- 2) Use compressed air during drilling.
- 3) Carbon Steel other than low carbon steel can be drilled to a depth of 0.5D without step feeding. For soft steel or sticky material such as stainless steel, step feed drilling (0.5-1.0mm) is recommended.
- 4) For stainless steel drilling, coolant is recommended.
- 5) Please refer right list for maximum hole depth.

Cutting Dia. (øD)	max. hole depth (mm)
ø16	13
ø17	13
ø20	17
ø21	17
ø25	22
ø26	22
ø32	29
ø33	29
ø40	36
ø50	40

● Shape of the bottom of the drilled hole

Cutting Dia.	a (mm)	Shape of the bottom
ø16, ø17	0.5	
ø20, ø21	0.64	
ø25, ø26	0.85	
ø32, ø33	1.12	
ø40	1.54	
ø50	1.65	

● : Std. Item ○ : Check Availability R : Std. Item (R-hand Only) L : Std. Item (L-hand Only)