

TurnLine

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ISO E^{CO}TURN

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Tungaloy Report No. 426S1-US

AHB
TOOLING & MACHINERY

**COMPLETE
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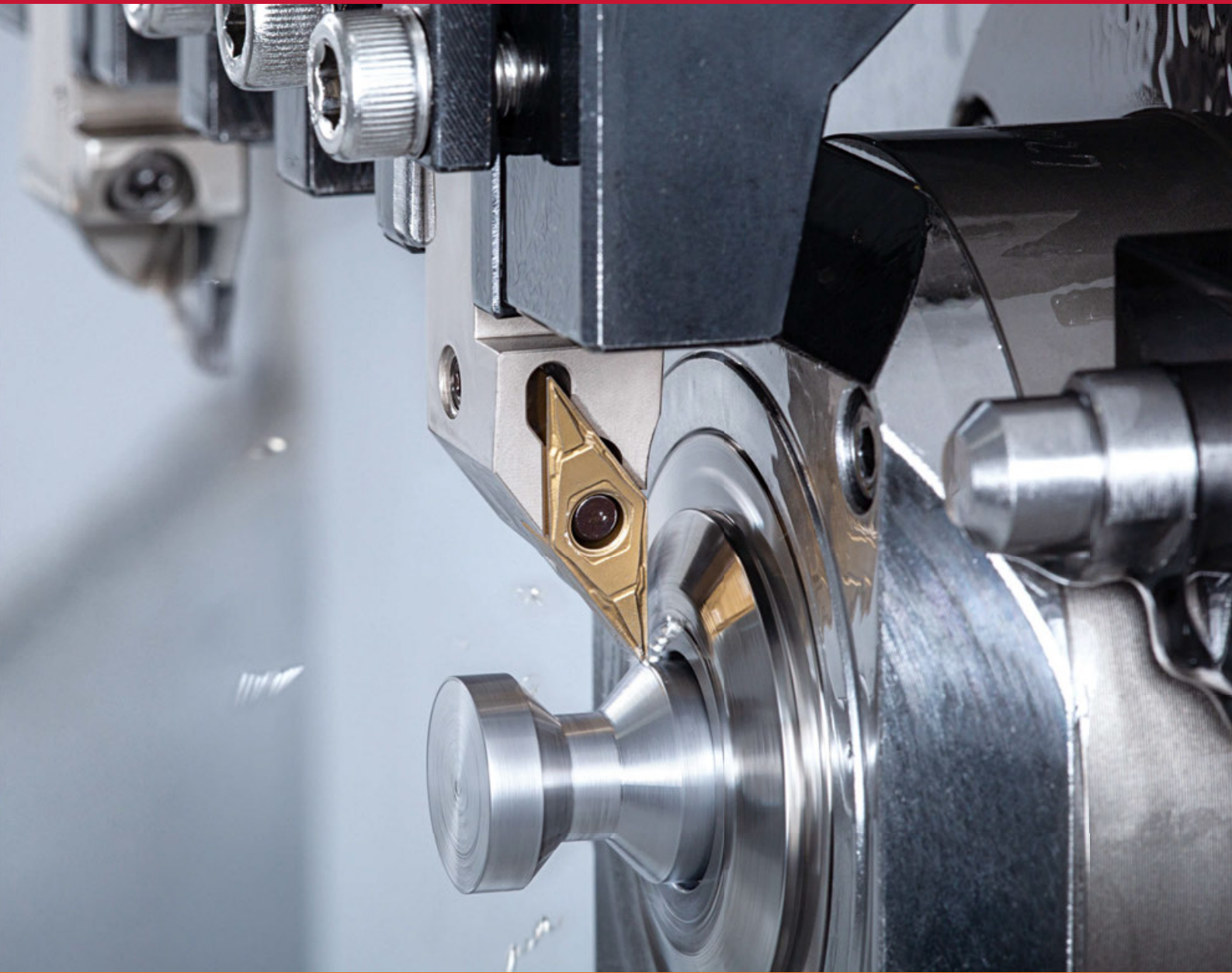
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Newest turning toolholders with
easy insert clamping system



INDUSTRY 4.0
FEED the SPEED!



Enables easy and quick insert exchange

New tool holders for VNMG2.33**E (VNMG1204**E) insert



New

- **Machine type**
For Swiss machines
- **Features**
 - Lever lock clamping (to be clamped from the back)
 - Without offset
 - Square shanks in sizes: 0.500" X 0.500" (12X12) and 0.625" X 0.625" (16X16)
 - Insert: VNMG2.33**E (VNMG1204**E)

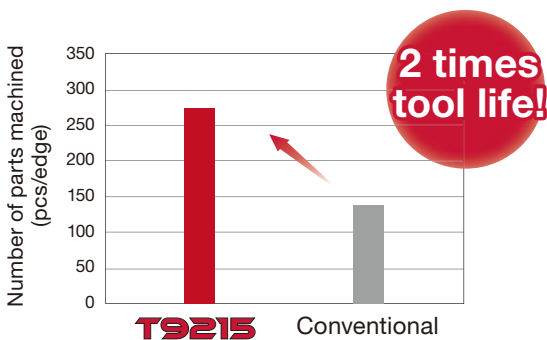
- **Machine type**
For general CNC lathes
- **Features**
 - Standard lever lock clamping
 - With offset
 - Square shanks in sizes: **New** 0.625" X 0.625" (16X16), 0.750" X 0.750" (20X20), and 1.000" X 1.000" (25X25)
 - Insert: VNMG2.33**E (VNMG1204**E)



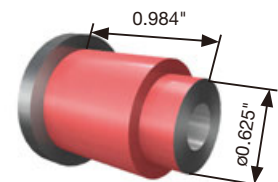
Latest grades offer excellent cutting performance in a wide variety of applications

VNMG2.33**E (VNMG1204**E) line up			
Material	Grade		Chipbreaker
P K	T9215	CVD coating	TF / TSF / TM
P	T9225	CVD coating	TF / TSF
P	AT9530 / GT9530 / NS9530	Coated and uncoated cermets	TSF
M	AH630 / AH645	PVD coating	SS / SM
M	T6120 / T6130	CVD coating	SS / SM

Cutting performance

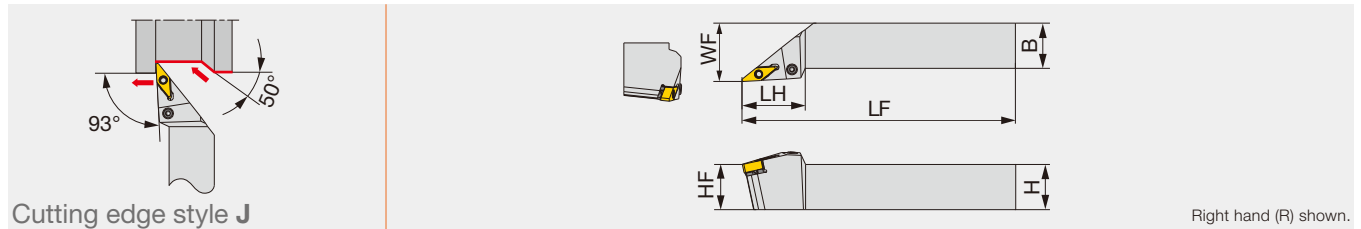


- P** Insert : VNMG 2.331E TSF T9215
- Workpiece material : 1045
- Cutting speed : $V_c = 492$ sfm
- Feed : $f = 0.004$ ipr
- Depth of cut : $a_p = 0.020$ "
- Coolant : Wet



PVJNR/L-Eco

Lever-lock toolholder with 93° approach angle, for negative 35° rhombic inserts



Right hand (R) shown.

	Inch	H	B	LF	LH	HF	WF	RE**	Insert	Torque
New	PVJNR/L102.33	0.625	0.625	4.000	1.380	0.625	0.875	0.031	VNMG2.33...	1.48
	Metric	H	B	LF	LH	HF	WF	RE**	Insert	Torque*
New	PVJNR/L1616H1204	16	16	100	35	16	20	0.8	VN**1204...	2
	PVJNR/L2020K1204	20	20	125	35	20	25	0.8	VN**1204...	2
	PVJNR/L2525M1204	25	25	150	35	25	32	0.8	VN**1204...	2

Torque: Recommended clamping torque: lbs-ft (*N·m)

**RE: The holder measurements are true with this insert radius

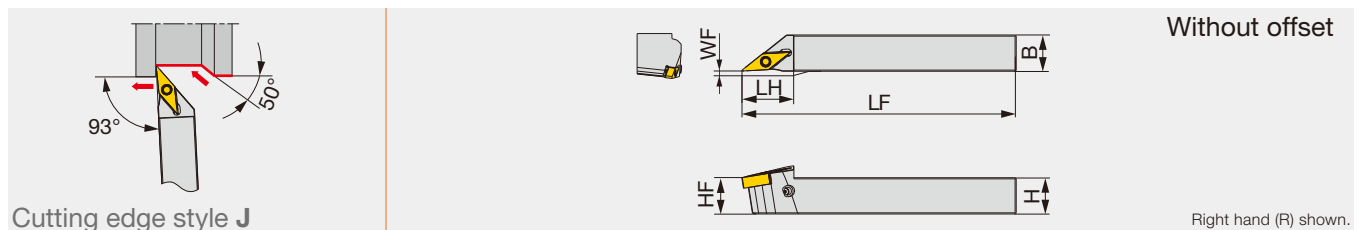
SPARE PARTS

Designation	Shim	Clamping screw	Wrench	Spring pin	Lever
PVJNR/L102.33 PVJNR/L**1204	LSV212	LCS3V	P-2.5	LSP3	LCL3V

New

JPVJ2NR/L-Eco

Back-clamp toolholder with 93° approach angle, for negative 35° rhombic inserts



Without offset

Right hand (R) shown.

	Inch	H	B	LF	LH	HF	WF	RE**	Insert	Torque
	JPVJ2NR082.33	0.500	0.500	4.75	0.900	0.500	0	0.0078	VNMG2.33...	0.66
	JPVJ2NR102.33	0.625	0.625	4.75	0.900	0.625	0	0.0078	VNMG2.33...	0.66
	Metric	H	B	LF	LH	HF	WF	RE**	Insert	Torque*
	JPVJ2NR/L1212X1204	12	12	120	23	12	0	0.2	VN**1204...	0.9
	JPVJ2NR/L1616X1204	16	16	120	23	16	0	0.2	VN**1204...	0.9

Torque: Recommended clamping torque: lbs-ft (*N·m)

**RE: The holder measurements are true with this insert radius

SPARE PARTS

Designation	Lever	Pin	Clamping screw	Wrench
JPVJ2NR/L***.33 JPVJ2NR/L**1204	SLLV-4	SL-PI-2	SR10400611	HW2.0/5RED

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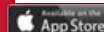
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