

# MINITURN™

TURNING PRODUCTS

# AHB

TOOLING & MACHINERY

COMPLETE METALWORKING SOLUTIONS  
(800) 991-4225 [www.ahbinc.com](http://www.ahbinc.com)  
ISO Certified [customerservice@ahbinc.com](mailto:customerservice@ahbinc.com)



### Series

- TMB

### Holder Styles

- Back Turning, Square Shank
- Right hand only
- With or without CoolBurst™

### Square Shank Size

- .500"
- .625"
- 12mm
- 16mm

### Insert Options

- Series BTVC...
- Wiper geometry

### Corner Radii

- .000" (0.0mm)
- .004" (0.1mm)
- .008" (0.2mm)

## Series TMB Back Turning Holders and Inserts for Swiss Automatic Machines

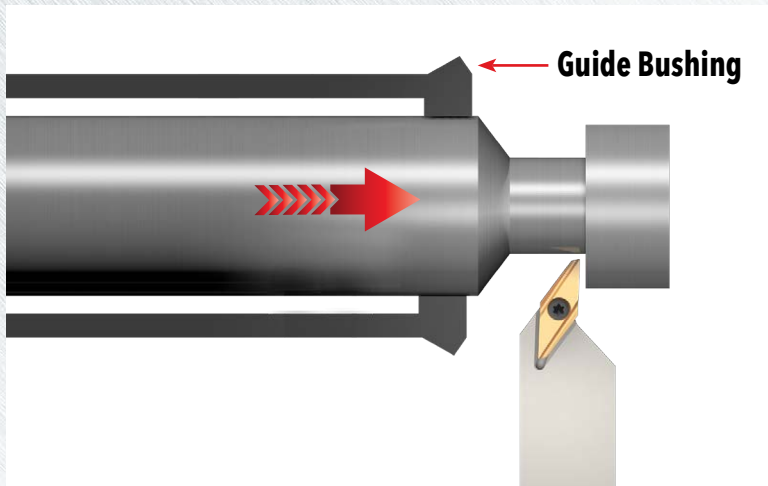
New MINI-TURN TMB back turning holders and inserts make it possible to plunge and turn features that exist behind larger diameters on the work piece. The holder/insert positioning is located away from the guide bushing and allows finish machining to be performed without retracting the work piece from the guide bushing. A specialized insert edge geometry enables high precision, and wiper geometry provides excellent surface roughness.


Standard TMB holders are right-handed and available in inch and metric shanks. All holders use BTVC inserts that feature a 35-degree included angle, wiper geometry, a sharp cutting edge and a maximum reach of .283" (7.2mm) per side.

Back turning tools are a popular option for small size component machining in industries ranging from automotive and medical to semiconductor manufacturing.



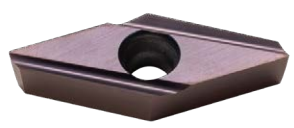
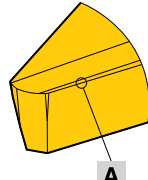

**MINITURN™ TMB BACK TURNING HOLDER**



- Back turning design for general purpose machining
- Can produce a square shoulder on back side of the workpiece
- Finish machining can be performed without retracting the workpiece from the guide bushing
- Holders offered with or without thru-coolant **COOLBURST™** technology 

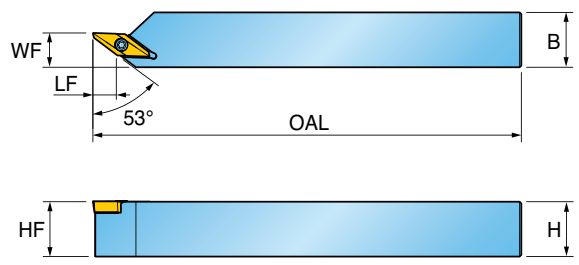
**MINITURN™ BTVC BACK TURNING INSERTS**

- Sharp cutting edge and optimized chip groove shape provides excellent chip control
- Optimal grooving performance with .283" (7.2mm) depth of cut capability
- Wiper edge produces excellent surface finish

Chip breaker	Edge geometry	
 <p data-bbox="381 1648 414 1680">R-F</p>	 <p data-bbox="844 1627 876 1659">A</p>	 <p data-bbox="1347 1543 1380 1585">A</p>



**MINITURN™ TMB-SVXCR SCREW TYPE BACK TURNING HOLDER (BTVC22\_)**



**INCH**

Approach angle	Part Number	Dimension (inch)						Insert
		H Shank Height	HF Functional Height	B Shank Width	OAL Overall Length	WF Functional Width	LF Functional Length	
	TMB-SVXCR 08-2C-SH	.500	.500	.500	5.0	.394	.283	BTVC22... (1103...)
	TMB-SVXCR 10-2C-SH	.625	.625	.625	5.0	.394	.283	

**METRIC**

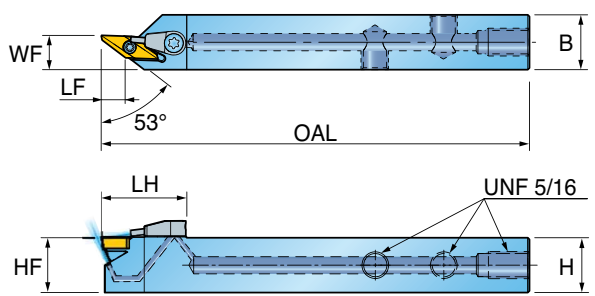
Approach angle	Part Number	Dimension (mm)						Insert
		H Shank Height	HF Functional Height	B Shank Width	OAL Overall Length	WF Functional Width	LF Functional Length	
	TMB-SVXCR 1212 K11	12	12	12	125	10	7.2	BTVC22... (1103...)
	TMB-SVXCR 1616 K11	16	16	16	125	10	7.2	

**Spare Parts**

Part Number	Screw	Wrench	
TMB-SVXCR	S0 250651	T7	



**MINITURN™ TMB-SVXCR-TB** SCREW TYPE BACK TURNING HOLDER W/HIGH-PRESSURE COOLANT (BTVC22\_)



**INCH**

Approach angle	Part Number	Dimension (inch)						Insert
		H Shank Height	HF Functional Height	B Shank Width	OAL Overall Length	WF Functional Width	LF Functional Length	
	TMB-SVXCR-TB 08-2C-SH	.500	.500	.500	5.0	.394	.283	BTVC22... (1103...)
	TMB-SVXCR-TB 10-2C-SH	.625	.625	.625	5.0	.394	.283	

**METRIC**

Approach angle	Part Number	Dimension (mm)						Insert
		H Shank Height	HF Functional Height	B Shank Width	OAL Overall Length	WF Functional Width	LF Functional Length	
	TMB-SVXCR-TB 1212 K11	12	12	12	125	10	7.2	BTVC22... (1103...)
	TMB-SVXCR-TB 1616 K11	16	16	16	125	10	7.2	

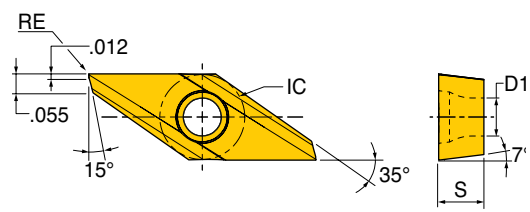
**Spare Parts**

Part Number	Screw	Oil Supply Unit	Plug	Wrench	
TMB-SVXCR-TB	SO 250651	S-CU-TB	PLG 5/16 UNF	T7	L-W 5/32



## MINITURN™ BTVC INSERTS

### Positive 7° clearance 35° rhombic inserts



Size	Dimension (inch)		
	IC Inscribed Circle	S Thickness	RE Corner Radius
22X	.250	.125	.000
220	.250	.125	.004
220.5	.250	.125	.008

Insert	Part Number	ap (inch)	Feed (ipr)	PVD coated
				TT4430
	BTVC22X0R-F (BTVC110300R-F)	.0012-.138	.0004-.0047	●
	BTVC220MR-F (BTVC110301MR-F)	.0020-.138	.0004-.0060	●
	BTVC220.5MR-F (BTVC110302MR-F)	.0040-.138	.0004-.0060	●

●: Standard items



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