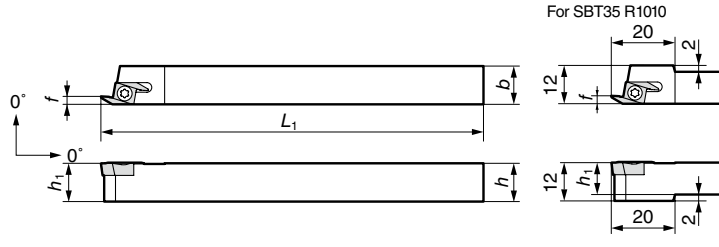
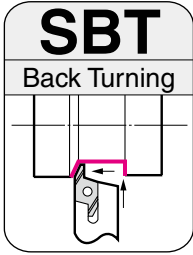


SBT/PBT Type

Back Turning



For SBT35 R1010

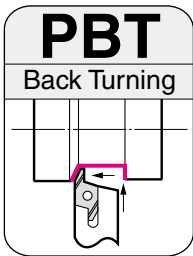
Parts

Screw	(For Torx Holes) Wrench
BFTX0307N	TRX10
Recommended Tightening Torque (N·m)	2.0

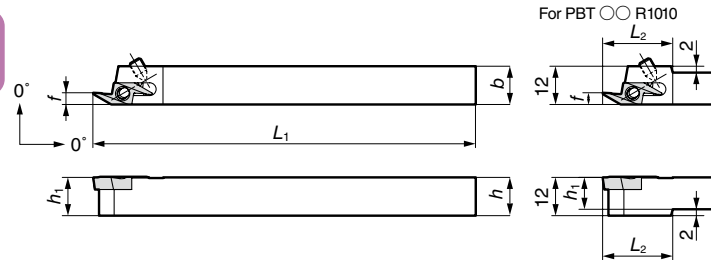
Holder

Above figures show right hand tools.

Cat. No.	Stock	Dimensions (mm)					Applicable Insert
		h	b	L ₁	f	h ₁	
SBT35 R1010	●	10	10	120	2.5	10	BTR35 ○○
SBT35 R1212	●	12	12	120	9.5	12	
SBT35 R1616	●	16	16	120	13.5	16	
SBT35 R2020	●	20	20	125	17.5	20	



Side lever locking holders



For PBT ○○ R1010

Parts

Lever Pin	Clamp Bolt	Pin	(For Hexagonal Holes) Wrench
LCL09	BTT0407 BTT0411	LP07	TH020

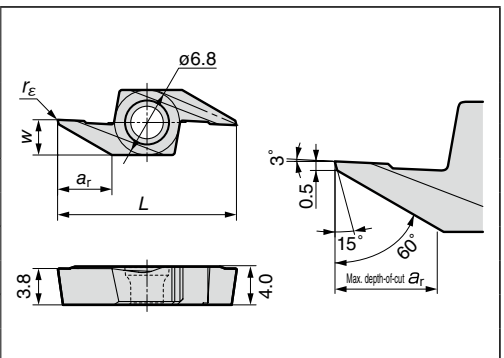
Holder

Above figures show right hand tools.

Cat. No.	Stock	Dimensions (mm)							Applicable Insert	Lever Pin	Clamp Bolt	Pin	Wrench
		h	b	L ₁	f	h ₁	L ₂						
PBT35 R1010	●	10	10	120	2.5	10	20	BTR35 ○○	LCL09	BTT0407 BTT0411	LP07	TH020	
PBT35 R1212	●	12	12	120	2.5	12	—						
PBT35 R1616	●	16	16	120	2.5	16	—						
PBT35 R2020	●	20	20	120	2.5	20	—						
PBT55 R1010	●	10	10	120	3.7	10	22	BTR55 ○○	LCL09	BTT0407 BTT0411	LP07	TH020	
PBT55 R1212	●	12	12	120	3.7	12	—						
PBT55 R1616	●	16	16	120	3.7	16	—						
PBT55 R2020	●	20	20	120	3.7	20	—						
PBT80 R1010	●	10	10	120	5.2	10	25	BTR80 ○○	LCL09	BTT0407 BTT0411	LP07	TH020	
PBT80 R1212	●	12	12	120	5.2	12	—						
PBT80 R1616	●	16	16	120	5.2	16	—						
PBT80 R2020	●	20	20	120	5.2	20	—						

Insert (Coated Carbide/ Cermet)

Cat. No.	Stock				Dimensions (mm)				Applicable Holder
	Coated Carbide		Cermet		L	a _r	w	r _ε	
	AC530U	ACZ150	T11500A	T1200A					
BT R3505	●	●	●	▲	15	3.5	2.5	0.05	SBT35R ○○○○
BT R3515	●	●	●	▲	15	3.5	2.5	0.15	PBT35R ○○○○
BT R5505	●	●	—	—	19	5.5	3.7	0.05	PBT55R ○○○○
BT R5515	●	●	—	—	19	5.5	3.7	0.15	PBT55R ○○○○
BT R8005	●	●	—	—	24	8.0	5.2	0.05	PBT80R ○○○○
BT R8015	●	●	—	—	24	8.0	5.2	0.15	PBT80R ○○○○



Recommended Cutting Conditions

Work material	P Carbon Steel		P Free-cutting Steel		M Stainless Steel	
	Plunging	Traverse	Plunging	Traverse	Plunging	Traverse
Cutting Speed v _c (m/min)	50 to 150		50 to 150		50 to 150	
Feed Rate f (mm/rev)	0.02 to 0.05	0.02 to 0.10	0.02 to 0.10	0.02 to 0.15	0.02 to 0.04	0.02 to 0.06
Coolant	Oil based					

Shank Tolerance of SBT Type/PBT Type

The shank height (h) has a plus tolerance (0.1-0.3) in order to avoid interference with the tool post.

