

Double Clamp Series

SINGLE ACTION TYPE -
SIMPLE AND HIGHLY
RIGID CLAMPING

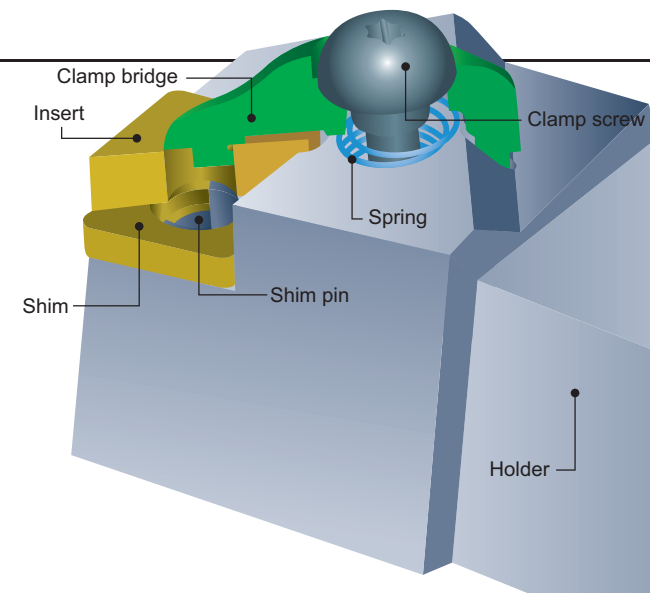


Single Action Type DOUBLE CLAMP SERIES

■Features

Single action type double clamp system

- Newly developed highly rigid clamping system.
- Easy and secure insert retention.
- World class cutting edge indexing accuracy.



New optimised clamp bridge

The clamp bridge features a new geometry that is optimized promoting chip flow while maintaining tool rigidity. This has been achieved by using CAE design analysis technology to avoid chip packing problems. This new bridge type is also compatible with both right and left hand tool holders.



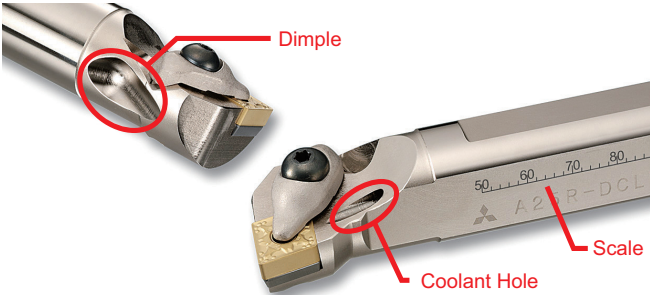
Special surface treatment

The body and clamp bridge has been treated with a special surface coating for higher corrosion and abrasion resistance.



Higher vibration resistance and chip discharge properties

The dimple boring bar features excellent vibration resistance properties and through coolant holes for better chip discharge. In addition, a scale for easy overhang length setting is etched on the body.



Double-ended torx hole clamp screw

Equally sized torx holes are provided on both ends of the clamp screw, making it easy to attach and remove the insert even when an inverted holder is used, thus ensuring rapid insert indexing and secure clamping.

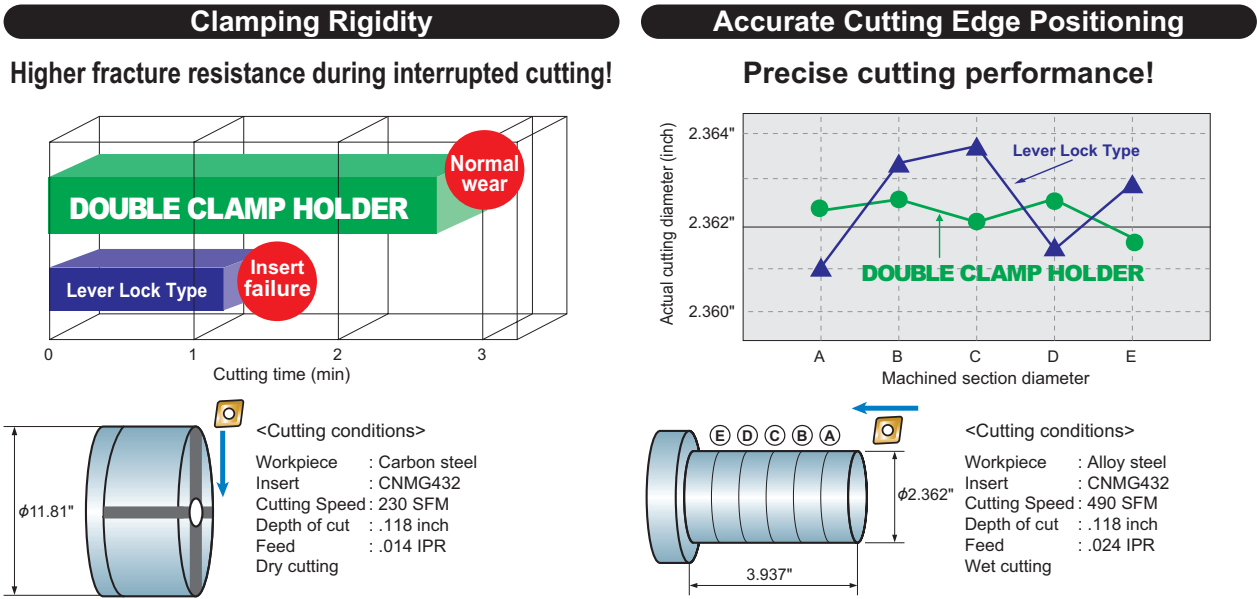


A wide selection of tool holders

Mitsubishi's Double Clamp series. **23** types, **161** items

Shape		Tool holder geometry					
External turning		Type					
		No. of items	12	4	12	1	2
		Type					
		No. of items	4	2	4	4	8
		Type					
		No. of items	2	6	4	2	10
Boring		Type					
		No. of items	14	10	10	16	4
		Type					
		No. of items	14	10	10	16	4
		Type					
		No. of items	14	10	10	16	4

■Cutting Performance



DOUBLE CLAMP HOLDER

DCLN			External turning Facing							CNC inserts		Finish		Light		Medium		Medium	
										Right hand tool holder shown.		FH (4) Medium (4) Standard (4)		SA (4) Medium to Semi-Heavy (4) GH (4)		MV (4) Stainless (3,4) MS (4)		MH (4) CBN (4)	
Order Number	Stock	Insert Number		Dimensions (inch)															
				H1	B	L1	L2	H2	F1	Shim	Shim Pin	Clamp Bridge	Spring	Clamp Screw	Wrench	Punch			
DCLNR/L-123	●●	●● CNMA CNMG CNMM CNGG NP-CNMA NP-CNGA	32	.750	.750	4.500	1.000	.750	1.000	LLSCN33 (LLSCN32)*	LLP23	DCK2211	DCS2	DC0520T	TKY15F	LLH3			
-124	●●		43	.750	.750	4.500	1.250	.750	1.000	LLSCN42	LLP14	DCK2613	DCS1	DC0621T	TKY20F	LLH4			
-163	●●		32	1.000	1.000	6.000	1.000	1.000	1.250	LLSCN33 (LLSCN32)*	LLP23	DCK2211	DCS2	DC0520T	TKY15F	LLH3			
-164	●●		43	1.000	1.000	6.000	1.250	1.000	1.250	LLSCN42	LLP14	DCK2613	DCS1	DC0621T	TKY20F	LLH4			
-204	●●		43	1.250	1.250	6.000	1.250	1.250	1.500	LLSCN42	LLP14	DCK2613	DCS1	DC0621T	TKY20F	LLH4			
-244	●●		43	1.500	1.500	6.000	1.250	1.500	2.000	LLSCN42	LLP14	DCK2613	DCS1	DC0621T	TKY20F	LLH4			

*Please use shim no.LLSCN32 with .187inch thick insert. When using .187inch thick inserts, the shim should be ordered separately.

DDJN			External turning Copying								DNC Inserts		Finish		Light		Medium		Medium	
											Right hand tool holder shown.		 (4)		 (4)		 (4)		 (4)	
											Medium to Semi-Heavy GH		Stainless MS		G Class MJ		CBN		 (4)	
													(4)		(3,4)		(4)		(4)	
Order Number	Stock	Insert Number	Dimensions (inch)																	
			H1	B	L1	L2	H2	F1	Shim	Shim Pin	Clamp Bridge	Spring	Clamp Screw	Wrench	Punch					
DDJNR/L-123	●●	●● DNMA DNMG DNMM DNGA DNGG DNMG DNMX NP-DNMA NP-DNGA	33	.750	.750	4.500	1.188	.750	1.000	LLSDN32	LLP23	DCK2211	DCS2	DC0520T	TKY15F	LLH3				
-124	●●		43	.750	.750	4.500	1.375	.750	1.000	LLSDN43 (LLSDN42)*	LLP24 (LLP14)*	DCK2613	DCS1	DC0621T	TKY20F	LLH4				
-163	●●		33	1.000	1.000	6.000	1.188	1.000	1.250	LLSDN32	LLP23	DCK2211	DCS2	DC0520T	TKY15F	LLH3				
-164	●●		43	1.000	1.000	6.000	1.375	1.000	1.250	LLSDN43 (LLSDN42)*	LLP24 (LLP14)*	DCK2613	DCS1	DC0621T	TKY20F	LLH4				
-204	●●		43	1.250	1.250	6.000	1.375	1.250	1.500	LLSDN43 (LLSDN42)*	LLP24 (LLP14)*	DCK2613	DCS1	DC0621T	TKY20F	LLH4				
-244	●●		43	1.500	1.500	6.000	1.500	1.500	2.000	LLSDN43 (LLSDN42)*	LLP24 (LLP14)*	DCK2613	DCS1	DC0621T	TKY20F	LLH4				

*Please use shim no.LLSDN42 and shim pin LLP14 with .25inch thick insert. When using .25inch thick inserts, the shim and shim pin should be ordered separately.

DDPN		External turning Copying		DNO Inserts		Finish		Light		Medium		Medium					
						FH		SA		MV		MH					
						(4)		(4)		(4)		(4)					
						Medium to Semi-Heavy		Stainless		G Class		CBN					
						GH		MS		MJ							
						(4)		(4)		(4)		(4)					
Order Number	Stock	Insert Number		Dimensions (inch)													
				H1	B	L1	L2	H2	F1	Shim	Shim Pin						
DDPNN-164	●	DNMA DNMG DNMM DNGA DNGG DNMG DNMX NP-DNMA NP-DNGA	43	1.000	1.000	6.000	1.500	1.000	.500	LLSDN43 (LLSDN42)*	LLP24 (LLP14)*	DCK2613	DCS1	DC0621T	TKY20F	LLH4	

*Please use shim no.LLSDN42 and shim pin LLP14 with .25inch thick insert. When using .25inch thick inserts, the shim and shim pin should be ordered separately.

Recommended Cutting Conditions				
Work Material	Cutting Mode	Breaker	Grade	Cutting Speed (SFM)
P	Finish	FS	AP25N	935—1455
	Light	SA	UE6110	935—1590
Carbon Steel Alloy Steel (180HB—280HB)	Finish	FH	AP25N	705—1115
	Light	SA	UE6110	685—1160
	Medium	MV	UE6110	620—1065

Work Material	Cutting Mode	Breaker	Grade	Cutting Speed (SFM)
M	Finish	FS	AP25N	375—785
Stainless Steel (≤200HB)	Light	SA	US735	310—605
	Medium	MS	US735	275—540
K	Light	MA	UC5115	520—965
Cast Iron (≤350MPa)	Medium	Standard	UC5115	520—965
	Semi-Heavy	Flat Top	UC5115	505—915

(Note) Insert photo, letters show chip breaker style, figures show inscribed circle.

● : USA Stock

DOUBLE CLAMP HOLDER

DDQN			External turning Copying		DN $\circ$ inserts		Finish		Light		Medium		Medium				
					FH		SA	MV	MH								
					(4)		(4)	(4)	(4)								
					Medium to Semi-Heavy		Stainless	G Class	CBN								
					GH		MS	MJ									
					(4)		(4)	(4)	(4)								
Order Number	Stock		Insert Number	Dimensions (inch)													
	R	L		H1	B	L1	L2	H2	F1	Shim	Shim Pin	Clamp Bridge	Spring	Clamp Screw	Wrench	Punch	
DDQNR/L-164	●	●	DNMA DNMG DNMM DNMA DNMG DNMM NP-DNMA NP-DNMA	43 $\circ$	1.000	1.000	6.000	1.375	1.000	1.250	LLSDN43 (LLSDN42)*	LLP24 (LLP14)*	DCK2613	DCS1	DC0621T	TKY20F	LLH4

*Please use shim no.LLSDN42 and shim pin LLP14 with .25inch thick insert. When using .25inch thick inserts, the shim and shim pin should be ordered separately.

DRGN		NEW		External turning							RN ⁰⁰ inserts										Medium				
																					Standard				
											Right hand tool holder shown.										Medium				
																					Flat top				
																					(4)				
Order Number		Stock		Insert Number		Dimensions (inch)																			

Recommended Cutting Conditions				
Work Material	Cutting Mode	Breaker	Grade	Cutting Speed (SFM)
P Mild Steel (≤180HB)	Finish	FS	AP25N	935—1455
	Light	SA	UE6110	935—1590
	Medium	MS	UE6110	850—1440
Carbon Steel Alloy Steel (180HB—280HB)	Finish	FH	AP25N	705—1115
	Light	SA	UE6110	685—1160
	Medium	MV	UE6110	620—1065

Work Material	Cutting Mode	Breaker	Grade	Cutting Speed (SFM)
M Stainless Steel (≤200HB)	Finish	FS	AP25N	375—785
	Light	SA	US735	310—605
	Medium	MS	US735	275—540
K Cast Iron (≤350MPa)	Light	MA	UC5115	520—965
	Medium	Standard	UC5115	520—965
	Semi-Heavy	Flat Top	UC5115	505—915

(Note) Insert photo, letters show chip breaker style, figures show inscribed circle.

DSRN			External turning								SN ⁰⁰ inserts		Finish		Light		Medium		Medium	
											FH		SA	MV	MH					
											 (4)		 (4)	 (4)	 (4)					
											Medium to Semi-Heavy		Stainless	CBN						
											GH		MS							
											 (4)		 (4)	 (4)						
Order Number	Stock		Insert Number	Dimensions (inch)																
	R	L		H1	B	L1	L2	H2	F1	Shim	Shim Pin	Clamp Bridge	Spring	Clamp Screw	Wrench	Punch				
DSRNR/L-124	●	●	SNMA SNMG SNMM SNGA SNGG NP-SNMA NP-SNMA	43	.750	.750	4.500	1.250	.750	.878	LLSSN42	LLP14	DCK2613	DCS1	DC0621T	TKY20F	LLH4			
-164	●	●		43	1.000	1.000	6.000	1.250	1.000	1.128	LLSSN42	LLP14	DCK2613	DCS1	DC0621T	TKY20F	LLH4			

DSSN			External turning Chamfering								SN ^o inserts		Finish		Light		Medium		Medium	
											FH		SA	MV	MH					
											 (4)		 (4)	 (4)	 (4)					
											Medium to Semi-Heavy GH  (4)		Stainless MS  (4)	CBN  (4)						
Order Number	Stock		Insert Number	Dimensions (inch)																
	R	L		H1	B	L1	L2	H2	F1	Shim	Shim Pin	Clamp Bridge	Spring	Clamp Screw	Wrench	Punch				
DSSNR/L-124	●	●	SNMA SNMG SNMM SNGA SNGG SNMA NP-SNMA NP-SNGA	43 ^o	.750	.750	4.500	1.250	.750	.659	LLSSN42	LLP14	DCK2613	DCS1	DC0621T	TKY20F	LLH4			
-164	●	●		43 ^o	1.000	1.000	6.000	1.250	1.000	.909	LLSSN42	LLP14	DCK2613	DCS1	DC0621T	TKY20F	LLH4			

DSKN		NEW		Facing		SN inserts					Finish		Light		Medium		Medium	
									FH		SA		MV		MH			
									(4)		(4)		(4)		(4)			
									Medium to Semi-Heavy		Stainless		CBN					
									GH		MS							
									(4)		(4)		(4)					
Order Number	Stock		Insert Number	Dimensions (inch)														
	R	L		H1	B	L1	L2	H2	F1	Shim	Shim Pin	Clamp Bridge	Spring	Clamp Screw	Wrench	Punch		
DSKNR/L-124	●	●	SNMA SNMG SNMM SNMA SNMG SNMM NP-SNMA NP-SNMA	43	.750	.750	4.500	1.000	.750	1.000	LLSSN42	LLP14	DCK2613	DCS1	DC0621T	TKY20F	LLH4	
-164	●	●		43	1.000	1.000	6.000	1.000	1.000	1.250	LLSSN42	LLP14	DCK2613	DCS1	DC0621T	TKY20F	LLH4	

DOUBLE CLAMP HOLDER

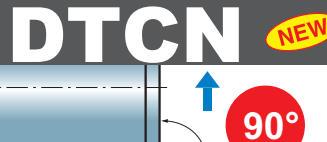
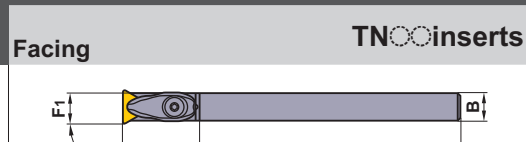
DSDN			External turning Chamfering		SN $\circ$ inserts					Finish		Light	Medium	Medium		
										FH (4) Medium to Semi-Heavy GH (4)	SA (4) Stainless MS (4)	MV (4) CBN (4)	MH (4)			
Order Number	Stock	Insert Number	H1	B						L1	L2	H2	F1	Shim	Shim Pin	Clamp Bridge
DSDNN-124	●	SNMA SNMG SNMM SNGA SNGG NP-SNMA NP-SNGA	43 $\circ$	.750	.750	4.500	1.375	.750	.375	LLSSN42	LLP14	DCK2613	DCS1	DC0621T	TKY20F	LLH4
-164	●		43 $\circ$	1.000	1.000	6.000	1.375	1.000	.500	LLSSN42	LLP14	DCK2613	DCS1	DC0621T	TKY20F	LLH4

DTFN			Facing		TN $\circ$ inserts					Finish		Light	Medium	Medium			
										 (3,4) Medium to Semi-Heavy (3,4)	 (3,4) Stainless (3,4)	 (3,4) CBN (3,4)	 (3,4)				
Order Number	Stock	Insert Number	Dimensions (inch)														
			H1	B	L1	L2	H2	F1	Shim	Shim Pin	Clamp Bridge	Spring	Clamp Screw	Wrench	Punch		
DTFNR/L-123	●	●	TNMA	33 $\circ$	.750	.750	4.500	1.000	.750	1.000	LLSTN32 (LLSTN33)*	LLP23	DCK2211	DCS2	DC0520T	TKY15F	LLH3
-163	●	●	TNMG	33 $\circ$	1.000	1.000	6.000	1.000	1.000	1.250	LLSTN32 (LLSTN33)*	LLP23	DCK2211	DCS2	DC0520T	TKY15F	LLH3
NEW -164	●	●	TNMM	43 $\circ$	1.000	1.000	6.000	1.219	1.000	1.250	LLSTN42	LLP14	DCK2613	DCS1	DC0621T	TKY20F	LLH4
NEW -204	●	●	TNGA	43 $\circ$	1.250	1.250	6.000	1.219	1.250	1.500	LLSTN42	LLP14	DCK2613	DCS1	DC0621T	TKY20F	LLH4
			TNGG														
			NP-TNMA														
			NP-TNGA														

*Please use shim no.LLSTN33 with .125inch thick insert. When using .125inch thick inserts, the shim should be ordered separately.

DTGN				External turning							TN $\circ$ inserts		Finish		Light		Medium		Medium	
											FH (3,4) Medium to Semi-Heavy GH (3,4)		SA (3,4) Stainless MS (3,4)		MV (3,4) CBN (3,4)		MH (3,4)			
Order Number	Stock		Insert Number	Dimensions (inch)																
	R	L		H1	B	L1	L2	H2	F1	Shim	Shim Pin	Clamp Bridge	Spring	Clamp Screw	Wrench	Punch				
DTGNR/L-123	●	●	TNMA TNMG TNMM TNGA TNGG NP-TNMA NP-TNGA	33 $\circ$	.750	.750	4.500	1.000	.750	1.000	LLSTN32 (LLSTN33)*	LLP23	DCK2211	DCS2	DC0520T	TKY15F	LLH3			
-163	●	●		33 $\circ$	1.000	1.000	6.000	1.000	1.000	1.250	LLSTN32 (LLSTN33)*	LLP23	DCK2211	DCS2	DC0520T	TKY15F	LLH3			
NEW -164	●	●		43 $\circ$	1.000	1.000	6.000	1.250	1.000	1.250	LLSTN42	LLP14	DCK2613	DCS1	DC0621T	TKY20F	LLH4			
NEW -204	●	●		43 $\circ$	1.250	1.250	6.000	1.250	1.250	1.500	LLSTN42	LLP14	DCK2613	DCS1	DC0621T	TKY20F	LLH4			
NEW -244	●	●		43 $\circ$	1.500	1.500	6.000	1.250	1.500	2.000	LLSTN42	LLP14	DCK2613	DCS1	DC0621T	TKY20F	LLH4			

*Please use shim no.LLSTN33 with .125inch thick insert. When using .125inch thick inserts, the shim should be ordered separately.

DTCN		NEW		Facing		TN $\circ$ inserts				Finish		Light		Medium		Medium	
								FH  (3)		SA  (3)		MV  (3)		MH  (3)			
								Medium to Semi-Heavy GH  (3)		Stainless MS  (3)		CBN  (3)					
Order Number	Stock	Insert Number		Dimensions (inch)													
				H1	B	L1	L2	H2	F1	Shim	Shim Pin	Clamp Bridge	Spring	Clamp Screw	Wrench	Punch	
DTCNN-433	●	TNMA	TNMG	33 $\circ$	.750	.500	4.500	1.375	.750	.539	LLSTN32 (LLSTN33)*	LLP23	DCK3113	DCS2	DC0520T	TKY15F	LLH3
-443	●	TNMA	TNMG	33 $\circ$	1.000	.500	6.000	1.375	1.000	.539	LLSTN32 (LLSTN33)*	LLP23	DCK3113	DCS2	DC0520T	TKY15F	LLH3

*Please use shim no.LLSTN33 with .125inch thick insert. When using .125inch thick inserts, the shim should be ordered separately.

Recommended Cutting Conditions					
Work Material		Cutting Mode	Breaker	Grade	Cutting Speed (SFM)
P	Mild Steel (≤180HB)	Finish	FS	AP25N	935—1455
		Light	SA	UE6110	935—1590
		Medium	MS	UE6110	850—1440
	Carbon Steel Alloy Steel (180HB—280HB)	Finish	FH	AP25N	705—1115
		Light	SA	UE6110	685—1160
		Medium	MV	UE6110	620—1065

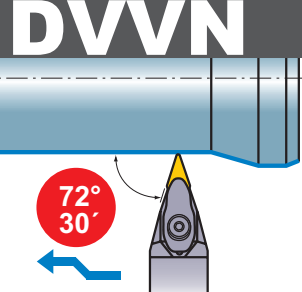
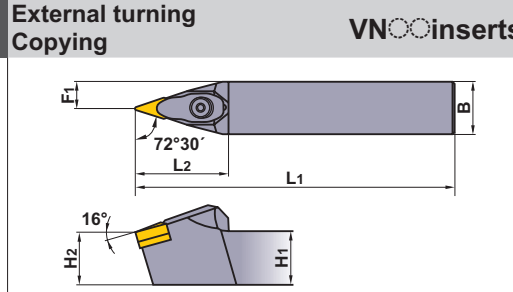
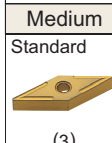
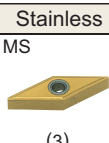
Work Material	Cutting Mode	Breaker	Grade	Cutting Speed (SFM)
M	Finish	FS	AP25N	375—785
	Light	SA	US735	310—605
	Medium	MS	US735	275—540
K	Light	MA	UC5115	520—965
	Medium	Standard	UC5115	520—965
	Semi-Heavy	Flat Top	UC5115	505—915

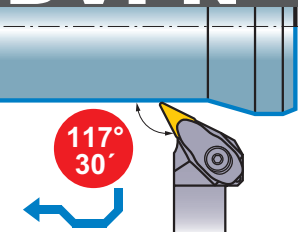
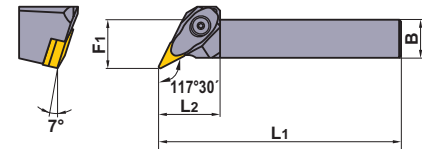
(Note) Insert photo, letters show chip breaker style, figures show inscribed circle.

● : USA Stock

DOUBLE CLAMP HOLDER

DVJN			External turning Copying								VN ⁰⁰ inserts		Finish		Light		Medium		Medium	
											FH		SH		MV		MH			
											(3)		(3)		(3)		(3)			
											Medium Standard		Stainless MS		G Class MJ		CBN			
											(3)		(3)		(3)		(3)			
Order Number	Stock		Insert Number	Dimensions (inch)																
	R	L		H1	B	L1	L2	H2	F1	Shim	Shim Pin	Clamp Bridge	Spring	Clamp Screw	Wrench	Punch				
DVJNR/L-123	●	●	VNGA VNMG VNGM	33 ⁰⁰	.750	.750	4.500	1.625	.750	1.000	DCSVN32	LLP13	DCK3113	DCS2	DC0520T	TKY15F	LLH3			
-163	●	●	VNGG VNMM	33 ⁰⁰	1.000	1.000	6.000	1.625	1.000	1.250	DCSVN32	LLP13	DCK3113	DCS2	DC0520T	TKY15F	LLH3			
-203	●	●	NP-VNMA NP-VNGA	33 ⁰⁰	1.250	1.250	6.000	1.625	1.250	1.500	DCSVN32	LLP13	DCK3113	DCS2	DC0520T	TKY15F	LLH3			

DVVN			External turning Copying							VN ⁰⁰ inserts		Finish		Light		Medium		Medium	
										 (3)		 (3)		 (3)		 (3)			
										Medium Standard		Stainless MS		G Class MJ		CBN			
										 (3)		 (3)		 (3)		 (3)			
Order Number	Stock	Insert Number	Dimensions (inch)																
			H1	B	L1	L2	H2	F1	Shim	Shim Pin	Clamp Bridge	Spring	Clamp Screw	Wrench	Punch				
DVVNN-123	●	VNGA VNMG VNGM VNGG VNMM NP-VNMA NP-VNGA	33 ⁰⁰	.750	.750	4.500	1.750	.750	.375	DCSVN32	LLP13	DCK3113	DCS2	DC0520T	TKY15F	LLH3			
-163	●	NP-VNMA NP-VNGA	33 ⁰⁰	1.000	1.000	6.000	1.750	1.000	.500	DCSVN32	LLP13	DCK3113	DCS2	DC0520T	TKY15F	LLH3			

DVPN			Facing Copying		VN ⁰⁰ inserts					Finish		Light		Medium		Medium	
										Right hand tool holder shown.		 (3)	 (3)	 (3)	 (3)		
										Medium Standard		Stainless MS		G Class MJ		CBN	
										 (3)		 (3)		 (3)		 (3)	
Order Number	Stock		Insert Number	Dimensions (inch)													
	R	L		H1	B	L1	L2	H2	F1	Shim	Shim Pin	Clamp Bridge	Spring	Clamp Screw	Wrench	Punch	
DVPNR/L-123	●	●	VNGA VNMG VNGM VNGG VNMM NP-VNMA NP-VNGA	33 ⁰⁰	.750	.750	4.500	1.250	.750	1.000	DCSVN32	LLP13	DCK3113	DCS2	DC0520T	TKY15F	LLH3
-163	●	●		33 ⁰⁰	1.000	1.000	6.000	1.250	1.000	1.250	DCSVN32	LLP13	DCK3113	DCS2	DC0520T	TKY15F	LLH3

DWLN				External turning Facing		WN ⁰⁰ inserts				Finish		Light		Medium		Medium	
										 (4)		 (4)		 (3,4)		 (4)	
										Medium Standard		Medium to Semi-Heavy GH		Stainless MS		CBN	
										 (4)		 (4)		 (3,4)		 (4)	
										Right hand tool holder shown.							
Order Number	Stock		Insert Number	Dimensions (inch)													
	R	L		H1	B	L1	L2	H2	F1	Shim	Shim Pin	Clamp Bridge	Spring	Clamp Screw	Wrench	Punch	
DWLNRL-123	●	●	WNMA WNMG NP-WNMA NP-WNGA	33 ⁰⁰	.750	.750	4.500	1.000	.750	1.000	LLSWN32 (LLSWN33)*	LLP23	DCK2211	DCS2	DC0520T	TKY15F	LLH3
-124	●	●		43 ⁰⁰	.750	.750	4.500	1.250	.750	1.000	LLSWN42	LLP14	DCK2613	DCS1	DC0621T	TKY20F	LLH4
-163	●	●		33 ⁰⁰	1.000	1.000	6.000	1.000	1.000	1.250	LLSWN32 (LLSWN33)*	LLP23	DCK2211	DCS2	DC0520T	TKY15F	LLH3
-164	●	●		43 ⁰⁰	1.000	1.000	6.000	1.250	1.000	1.250	LLSWN42	LLP14	DCK2613	DCS1	DC0621T	TKY20F	LLH4
-204	●	●		43 ⁰⁰	1.250	1.250	6.000	1.250	1.250	1.500	LLSWN42	LLP14	DCK2613	DCS1	DC0621T	TKY20F	LLH4

*Please use shim no.LLSWN33 with .125inch thick insert. When using .125inch thick inserts, the shim should be ordered separately.

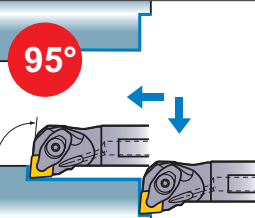
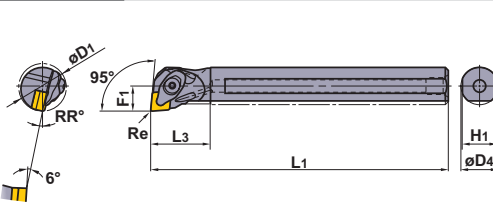
Recommended Cutting Conditions					
	Work Material	Cutting Mode	Breaker	Grade	Cutting Speed (SFM)
P	Mild Steel (≤180HB)	Finish	FS	AP25N	935—1455
		Light	SA	UE6110	935—1590
		Medium	MS	UE6110	850—1440
	Carbon Steel Alloy Steel (180HB—280HB)	Finish	FH	AP25N	705—1115
		Light	SA	UE6110	685—1160
		Medium	MV	UE6110	620—1065

Work Material	Cutting Mode	Breaker	Grade	Cutting Speed (SFM)
M	Finish	FS	AP25N	375—785
	Light	SA	US735	310—605
	Medium	MS	US735	275—540
K	Light	MA	UC5115	520—965
	Medium	Standard	UC5115	520—965
	Semi-Heavy	Flat Top	UC5115	505—915

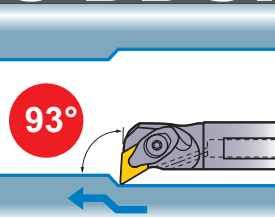
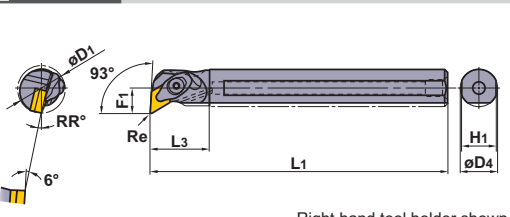
(Note) Insert photo, letters show chip breaker style, figures show inscribed circle.

● : USA Stock

DOUBLE CLAMP DIMPLE BAR

S-DCLN			Steel shank with coolant hole										C _N inserts		Finish		Light		Light		Medium	
															FH		SA		SH		MV	
																						
															(4)		(4)		(3,4)		(4)	
															Medium		Medium		Stainless		CBN	
																						
															(4)		(3,4)		(3,4)		(4)	
													Right hand tool holder shown.									
Order Number		Stock	Insert Number		Dimensions (inch)							Min. Cutting Diameter (inch) D1	Standard Corner Radius (inch) Re									
		R	L			D4	L1	L3	F1	H1	RR°											
S-DCLNR/L-123-C		●	●	CNMA	32	.750	10.000	1.219	.500	.711	12	1.000	.031	LLSCP32	LLP13	DCK2211	DCS2	DC0520T	TKY15F	LLH3		
NEW -163-C		●	●	CNMG	32	1.000	12.000	1.625	.641	.922	11	1.281	.031	LLSCP32	LLP13	DCK2211	DCS2	DC0520T	TKY15F	LLH3		
-164-C		●	●	CNMA	43	1.000	12.000	1.625	.641	.922	11	1.281	.031	LLSCP42	LLP14	DCK2613	DCS1	DC0621T	TKY20F	LLH4		
-204-C		●	●		CNMG	43	1.250	14.000	2.000	.766	1.171	13	1.532	.031	LLSCN42	LLP14	DCK2613	DCS1	DC0621T	TKY20F	LLH4	
NEW -244-C		●	●	CNMG	43	1.250	14.000	2.000	.766	1.171	13	1.532	.031	LLSCN42	LLP14	DCK2613	DCS1	DC0621T	TKY20F	LLH4		
NEW -284-C		●	●	CNMG	43	1.500	14.000	2.000	.891	1.382	12	1.782	.031	LLSCN42	LLP14	DCK2613	DCS1	DC0621T	TKY20F	LLH4		
NEW -284-C		●	●	CNMG	43	1.500	14.000	2.000	.891	1.382	12	1.782	.031	LLSCN42	LLP14	DCK2613	DCS1	DC0621T	TKY20F	LLH4		
NEW -284-C		●	●	NP-CNMA	43	1.750	14.000	2.500	1.016	1.632	10	2.032	.031	LLSCN42	LLP14	DCK2613	DCS1	DC0621T	TKY20F	LLH4		
NEW -324-C		●	●	NP-CNMA	43	2.000	14.000	2.500	1.281	1.882	10	2.562	.031	LLSCN42	LLP14	DCK2613	DCS1	DC0621T	TKY20F	LLH4		

S-DSKN			Steel shank with coolant hole										SN $\circ$ inserts		Finish		Light		Medium		Medium	
													(4)		(4)		(4)		(4)			
													Medium		Stainless		G Class		CBN			
													Standard		MS		R/L					
													(4)		(4)		(4)		(4)			
Order Number			Stock		Insert Number		Dimensions (inch)						Min. Cutting Diameter (inch) $D1$	Standard Corner Radius (inch) Re								
		R	L			$D4$	$L1$	$L3$	$F1$	$H1$	RR°											
S-DSKNR/L-164-C		●	●	SNMA	43 $\circ$	1.000	12.000	1.625	.641	.922	13	1.282	.031	LLSSP42	LLP14	DCK2613	DCS1	DC0621T	TKY20F	LLH4		
-204-C		●	●	SNMG	43 $\circ$	1.250	14.000	2.000	.766	1.171	13	1.532	.031	LLSSN42	LLP14	DCK2613	DCS1	DC0621T	TKY20F	LLH4		
-244-C		●	●	SNMM	43 $\circ$	1.500	14.000	2.000	.891	1.382	11	1.782	.031	LLSSN42	LLP14	DCK2613	DCS1	DC0621T	TKY20F	LLH4		
-284-C		●	●	SNGA	43 $\circ$	1.500	14.000	2.000	.891	1.382	11	1.782	.031	LLSSN42	LLP14	DCK2613	DCS1	DC0621T	TKY20F	LLH4		
-284-C		●	●	SNGG	43 $\circ$	1.750	14.000	2.500	1.016	1.632	10	2.032	.031	LLSSN42	LLP14	DCK2613	DCS1	DC0621T	TKY20F	LLH4		
-284-C		●	●	NP-SNMA	43 $\circ$	1.750	14.000	2.500	1.016	1.632	10	2.032	.031	LLSSN42	LLP14	DCK2613	DCS1	DC0621T	TKY20F	LLH4		
-324-C		●	●	NP-SNGA	43 $\circ$	2.000	14.000	2.500	1.281	1.882	9	2.562	.031	LLSSN42	LLP14	DCK2613	DCS1	DC0621T	TKY20F	LLH4		

S-DDUN			Steel shank with coolant hole							DNinserts			Finish		Finish		Light		Medium											
													FH		FJ		SA		MV											
																														
													(4)		(4)		(4)		(4)											
													Medium		Medium		Stainless		CBN											
													MH		Standard		MS													
																														
													(4)		(3,4)		(3,4)		(4)											
Order Number			Stock		Insert Number		Dimensions (inch)						Min. Cutting Diameter (inch) D1		Standard Corner Radius (inch) Re															
S-DDUNR/L-164-C			●	●	DNMA	43	1.000	12.000	1.625	.657	.922	13	1.314	.031	LLSDP42	LLP14	DCK2613	DCS1	DC0621T	TKY20F	LLH4									
-204-C			●	●	DNMG	43	1.250	14.000	2.000	1.000	1.171	11	2.000	.031	LLSDN43	LLP14	DCK2613	DCS1	DC0621T	TKY20F	LLH4									
NEW -244-C			●	●	DNGA	43	1.500	14.000	2.000	1.125	1.382	10	2.250	.031	LLSDN43	LLP24	DCK2613	DCS1	DC0621T	TKY20F	LLH4									
NEW -284-C			●	●	DNGG	43	1.750	14.000	2.500	1.250	1.632	9	2.500	.031	LLSDN43	LLP24	DCK2613	DCS1	DC0621T	TKY20F	LLH4									
NEW -324-C			●	●	NP-DNMA	43	2.000	14.000	2.500	1.375	1.882	8	2.750	.031	LLSDN43	LLP24	DCK2613	DCS1	DC0621T	TKY20F	LLH4									

S-DTFN			Steel shank with coolant hole								TN $\circ$ inserts		Finish		Light		Medium		Medium	
													FH		SA		MV		MH	
													(3)		(3,4)		(3,4)		(3,4)	
													Medium		Stainless		G Class		CBN	
													Standard		MS		R/L			
			Right hand tool holder shown.										(3,4)		(3,4)		(3,4)		(3,4)	
Order Number	Stock		Insert Number	Dimensions (inch)							Min. Cutting Diameter (inch) D1	Standard Corner Radius (inch) Re								
	R	L		D4	L1	L3	F1	H1	RR°											
S-DTFNR/L-123-C	●	●	TNMA TNMG TNMM TNMA TNGG NP-TNMA NP-TNGA	33 $\circ$	.750	10.000	1.250	.500	.711	13	1.000	.031	—	—	DCK2211	DCS2	DC0520T	TKY15F	—	
-163-C	●	●		33 $\circ$	1.000	12.000	1.625	.641	.922	13	1.282	.031	LLSTP32	LLP13	DCK2211	DCS2	DC0520T	TKY15F	LLH3	
-203-C	●	●		33 $\circ$	1.250	14.000	2.000	.766	1.171	13	1.532	.031	LLSTN32	LLP13	DCK2211	DCS2	DC0520T	TKY15F	LLH3	
-243-C	●	●		33 $\circ$	1.500	14.000	2.000	.891	1.382	12	1.782	.031	LLSTN32	LLP13	DCK2211	DCS2	DC0520T	TKY15F	LLH3	
-244-C	●	●		43 $\circ$	1.500	14.000	2.000	.891	1.382	12	1.782	.031	LLSTN42	LLP14	DCK2613	DCS1	DC0621T	TKY20F	LLH4	
-283-C	●	●		33 $\circ$	1.750	14.000	2.500	1.016	1.632	11	2.032	.031	LLSTN32	LLP13	DCK2211	DCS2	DC0520T	TKY15F	LLH3	
-284-C	●	●		43 $\circ$	1.750	14.000	2.500	1.016	1.632	11	2.032	.031	LLSTN42	LLP14	DCK2613	DCS1	DC0621T	TKY20F	LLH4	
-324-C	●	●		43 $\circ$	2.000	14.000	2.500	1.125	1.882	10	2.250	.031	LLSTN42	LLP14	DCK2613	DCS1	DC0621T	TKY20F	LLH4	

DOUBLE CLAMP DIMPLE BAR

S-DVUN				Steel shank with coolant hole VN $\circ$ inserts										Finish		Finish		Light		Medium	
														FH		FJ		SH		MV	
														(3)		(3)		(3)		(3)	
														Medium		Stainless		CBN			
														MH		MS					
				Right hand tool holder shown.										(3)		(3)		(3)			
Order Number	Stock		Insert Number	Dimensions (inch)							Min. Cutting Diameter (inch)	Standard Corner Radius (inch)									
	R	L		D4	L1	L3	F1	H1	RR°	D1										Re	Shim
S-DVUNR/L-203-C	●	●	VNMA VNMG VNGA VNGM	33 $\circ$	1.250	14.000	2.000	1.000	1.171	10	2.000	.031	DCSVN32	LLP13	DCK3113	DCS2	DC0520T	TKY15F	LLH3		
NEW -243-C	●	●	NP-VNMA NP-VNGA	33 $\circ$	1.500	14.000	2.500	1.125	1.382	9	2.250	.031	DCSVN32	LLP13	DCK3113	DCS2	DC0520T	TKY15F	LLH3		

S-DWLN			Steel shank with coolant hole										WN $\circ$ inserts			Finish		Light		Medium	
													FH		SA		MV				
													(4)		(4)		(3,4)				
													Stainless		CBN						
													MS								
			Right hand tool holder shown.										(3,4)		(4)						
Order Number	Stock		Insert Number	Dimensions (inch)							Min. Cutting Diameter (inch)	Standard Corner Radius (inch)									
	R	L		D4	L1	L3	F1	H1	RR°	D1										Re	Shim
S-DWLNR/L-123-C	●	●	WNMG	33 $\circ$	.750	10.000	1.250	.500	.711	12	1.000	.031	—	—	DCK2211	DCS2	DC0520T	TKY15F	—		
NEW -163-C	●	●		33 $\circ$	1.000	12.000	1.750	.641	.922	13	1.282	.031	LLSWP32	LLP13	DCK2211	DCS2	DC0520T	TKY15F	LLH3		
-164-C	●	●	WNMA WNMG	43 $\circ$	1.000	12.000	2.000	.641	.922	13	1.282	.031	LLSWP42	LLP14	DCK2613	DCS1	DC0621T	TKY20F	LLH4		
-204-C	●	●		43 $\circ$	1.250	14.000	2.000	.766	1.171	13	1.532	.031	LLSWN42	LLP14	DCK2613	DCS1	DC0621T	TKY20F	LLH4		
NEW -244-C	●	●	NP-WNMA	43 $\circ$	1.500	14.000	2.500	.891	1.382	12	1.782	.031	LLSWN42	LLP14	DCK2613	DCS1	DC0621T	TKY20F	LLH4		
NEW -284-C	●	●	NP-WNGA	43 $\circ$	1.750	14.000	2.500	1.125	1.632	11	2.250	.031	LLSWN42	LLP14	DCK2613	DCS1	DC0621T	TKY20F	LLH4		
NEW -324-C	●	●		43 $\circ$	2.000	14.000	2.500	1.281	1.882	10	2.562	.031	LLSWN42	LLP14	DCK2613	DCS1	DC0621T	TKY20F	LLH4		

Recommended Cutting Conditions								
Work Material	Hardness	Cutting Mode	l/d ≤ 3			3 < l/d ≤ 4		
			Cutting Speed (SFM)	Feed (IPR)	Depth of Cut (inch)	Cutting Speed (SFM)	Feed (IPR)	Depth of Cut (inch)
P Carbon Steel, Alloy Steel	180—280HB	Medium Cutting	360 (260—460)	.010 (.004—.016)	—.197	360 (260—460)	.008 (.004—.012)	—.157
M Stainless Steel	≤200HB	Medium Cutting	260 (195—330)	.008 (.004—.012)	—.157	230 (165—330)	.006 (.004—.015)	—.118
K Cast Iron	Tensile Strength ≤350MPa	Medium Cutting	260 (195—330)	.010 (.004—.016)	—.197	260 (195—330)	.008 (.004—.012)	—.157

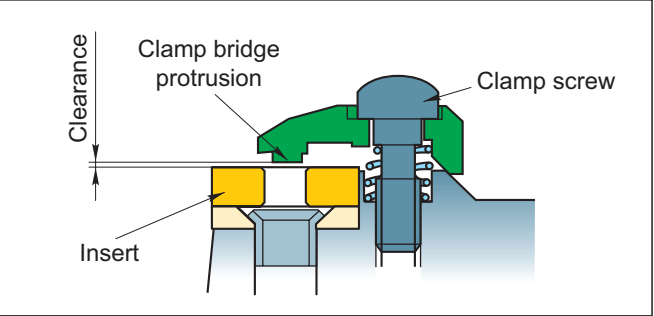
(Note 1) Insert photo, letters show chip breaker style, figures show inscribed circle.
(Note 2) When using inserts with right and left hand chip breakers, please use left hand inserts for right hand holders and right hand inserts for left hand holders.

● : USA Stock

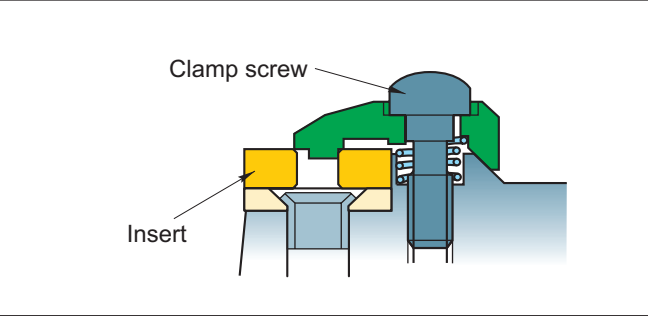
Operational Guidance

- When indexing or replacing an insert, check to be sure there is clearance between the protruding section of the clamp and the insert, as shown in the figure below. → Guide: Turn the clamp screw 2-3 rotations from the fully clamped state to ensure clearance.
- When clamping the insert, be sure to use the wrench provided. Over tightening may cause damage to the clamp bridge and the torx holes of the clamp screw. (The appropriate tightening torque is 44 in.·lbs. for a TKY20F wrench size; 31 in.·lbs. for a TKY15F type.)

Unclamped state



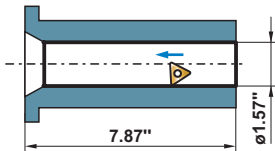
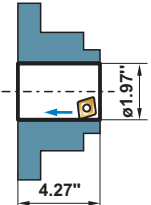
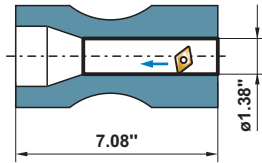
Clamped state



- If chips interfere or wrap around the clamp screw, the selected insert breaker may not be suitable. In this case, a review of the insert breaker is recommended as this may affect the surface finish accuracy of the workpiece.

DOUBLE CLAMP SERIES

Tool		DCLNL-164	DWLN-124	DVJNR-163
Insert		CNMG432MA	WNMG432SA	VNMG332MV
Grade		UE6010	UE6010	UE6020
Workpiece		Carbon steel 	Carbon steel 	Alloy steel
Cutting Conditions	Cutting Speed (SFM)	460 — 490	490 — 730	575
	Feed (IPR)	.010	.006 — .016	.016
	Depth of Cut (inch)	.040 — .138	.040 — .079	.040
	Coolant	Water soluble	Water soluble	Water soluble
Result		Abnormal damage to the insert is unlikely to occur during machining because mis-clamping can easily be avoided compared to when using conventional products.	Dimensional control becomes easier due to a higher cutting edge positioning accuracy.	Higher clamping rigidity of the insert and a 20% increase in the number of components machined.

Tool		S-DTFNR-163-C	S-DCLNR-164-C	S-DDUNR-164-C
Insert		TNMG331MS	CNMG432MS	DNMG432MA
Grade		US7020	VP15TF	UE6020
Workpiece		Carbon steel 	Stainless steel 	Alloy steel 
Cutting Conditions	Cutting Speed (SFM)	490	425	490
	Feed (IPR)	.016	.008	.010
	Depth of Cut (inch)	.039	.079	.059
	Coolant	Water soluble	Water soluble	Water soluble
Result		Excellent machining with no vibration even when using a long overhang of $l/d = 5.5$.	Double tool life achieved with no vibration when compared to conventional products.	Prolonged tool life with no vibration even when using an overhang 2 times longer than normal.

[illegible]



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Customer Service: 800.523.0800
Technical Service: 800.486.2341

Chicago Office (Engineering)

300 N. Martingale Road, Suite 500
Schaumburg, IL 60173
Main: 847.252.6300
Fax: 847.519.1732

MMC Metal de Mexico, S.A. DE C.V.

Av. La Cañada No.16,
Parque Industrial Bernardo
Quintana, El Marques,
Queretaro C.P. 76246 MEXICO
Main: +52.442.221.61.36
Fax: +52.442.221.61.34

North Carolina-MTEC (Marketing & Technical Center)

105 Corporate Center Drive, Suite A
Mooresville, NC 28117
Main: 980.312.3100
Fax: 704.746.9292

Toronto Office (Canada Branch)

600 Matheson Blvd. Unit 5 (Office)
Mississauga, ON L5R 4C1
Main: 905.814.0240
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Novi, MI 48375
Main: 248.308.2620
Fax: 248.308.2627

FOR YOUR SAFETY

- Don't handle inserts and chips without gloves.
- Please machine within the recommended application range and exchange expired tools with new ones in advance of breakage.
- Please use safety covers and wear safety glasses.
- When using compounded cutting oils, please take fire precautions.
- When attaching inserts or spare parts, please use only the correct wrench or driver.
- When using rotating tools, please make a trial run to check run-out, vibration and abnormal sounds etc.

www.mmc-carbide.com/us

Tools specifications subject to change without notice.

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