

# HOW TO READ THE STANDARD OF HSK-T TOOLS

## ● How this section page is organised

① Organised by application. (Refer to the index on the next page.)

### PRODUCT TYPE

indicates the first four letters of the order number, as well as cutting applications.

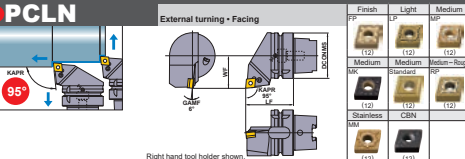
### TITLE OF PRODUCT SERIES

### PRODUCT SECTION

### HSK-T TOOLS

## FOR MULTI-TASK MACHINES

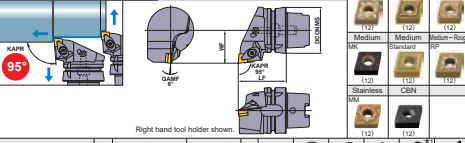
### PCLN



Order Number	Stock	Insert Number	Dimensions (mm)			WT (kg)	Shim	Shim Pin	Clamp Lever	Clamp Screw	Wrench	
			DCOMNS	LF	WF							
H63TH-PCLNR/L-DX12	●	CNCA CNOG CNI-M	1204	63	65	45	1.3	LLSCN42	LLP14	LLCL14	LLCS108	HKY30R

\*1 Clamp Torque (N·m) : LLC3108-3  
\*2 WT : Tool Weight  
Note 1) Dimensions shown for insert corner RE 0.8.

### DCLN



Order Number	Stock	Insert Number	Dimensions (mm)			WT (kg)	Shim	Shim Pin	Clamp Bridge	Spring	Clamp Screw	Wrench	
			DCOMNS	LF	WF								
H63TH-DCLNR/L-DX12	●	CNCA CNOG CNI-M	1204	63	65	45	1.3	LLSCN42	LLP14	DCK2613	DCS1	DC0621T	TKY20F

\*1 Clamp Torque (N·m) : DC0621T=5.0  
\*2 WT : Tool Weight  
Note 1) Dimensions shown for insert corner RE 0.8.

● : Inventory maintained in Japan.

PCLN type inserts > A674-A680  
DCLN type inserts > A674-A680  
CBN & PCD inserts > B622-B625, B655  
SCREWING CONDITION > A616-A618

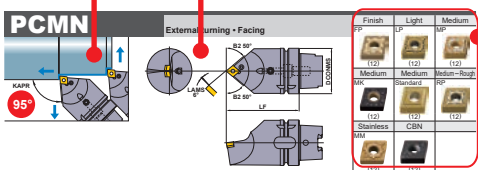
**LEGEND FOR STOCK STATUS MARK**  
is shown on the left hand page of each double-page spread.

**REFERENCE PAGE FOR APPLICABLE INSERTS**  
indicates reference pages for details of inserts that are applicable to the title product.

**PRODUCT STANDARDS**  
Indicates order numbers, stock status (per right/left hand), applicable inserts, dimensions, and spare parts.

**FIGURE SHOWING THE TOOLING APPLICATION**  
uses illustrations and arrows to depict available machining applications along with cutting edge lead angles.

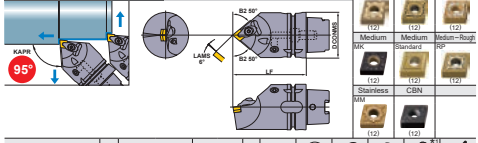
**GEOMETRY CHIP BREAKER BY CUTTING APPLICATION**



Order Number	Stock	Insert Number	Dimensions (mm)			WT (kg)	Shim	Shim Pin	Clamp Lever	Clamp Screw	Plug	Wrench
			DCOMNS	LF	WF							
H63TH-PCMNN-H12	●	CNCA CNOG CNI-M	1204	63	100	1.7	LLSCN42	LLP14	LLCL14	LLCS108	HGM-P118	HKY30R
H63TH-PCMNN-L12	●	CNCA CNOG CNI-M	1204	63	140	2.7	LLSCN42	LLP14	LLCL14	LLCS108	HGM-P118	HKY30R

\*1 Clamp Torque (N·m) : LLC3108-3  
\*2 WT : Tool Weight  
Note 1) Dimensions shown for insert corner RE 0.8.

### DCMN



Order Number	Stock	Insert Number	Dimensions (mm)			WT (kg)	Shim	Shim Pin	Clamp Bridge	Spring	Clamp Screw	Wrench
			DCOMNS	LF	WF							
H63TH-DCMNN-H12	●	CNCA CNOG CNI-M	1204	63	100	1.7	LLSCN42	LLP14	DCK2613	DCS1	DC0621T	TKY20F
H63TH-DCMNN-L12	●	CNCA CNOG CNI-M	1204	63	140	2.7	LLSCN42	LLP14	DCK2613	DCS1	DC0621T	TKY20F

\*1 Clamp Torque (N·m) : DC0621T=5.0  
\*2 WT : Tool Weight  
Note 1) Dimensions shown for insert corner RE 0.8.

PCMN type inserts > A674-A680  
DCMN type inserts > A674-A680  
CBN & PCD inserts > B622-B625, B655

SCREWING CONDITION > A616-A618  
RECOMMENDED CUTTING CONDITIONS > A610-A615  
SPARE PARTS > P601  
TECHNICAL DATA > 0691

**PAGE REFERENCE**  
- SPARE PARTS  
- TECHNICAL DATA  
indicates reference pages, including the above, on the right hand page of each double-page spread.

● To Order : Please specify  
① order number and hand of tool (right/left).

# HSK-T TOOLS

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CLASSIFICATION OF HSK-T TOOLS .....	H004
<b>HSK-T TOOL STANDARDS</b>	
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<b>EXTERNAL TURNING • FACING • BORING</b>	
CN <sup>○</sup> ○ <sup>○</sup> INSERTS TOOL HOLDERS .....	H008
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DN <sup>○</sup> ○ <sup>○</sup> INSERTS TOOL HOLDERS .....	H009
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RC <sup>○</sup> ○ <sup>○</sup> INSERTS TOOL HOLDERS .....	H012
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MT INSERTS TOOL HOLDERS.....	H017
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<b>BORING BAR SLEEVES.....</b>	

EXTERNAL TURNING TOOL HOLDERS.....	H019
BORING BAR HOLDERS.....	H021
BORING BAR SLEEVES.....	H022

\*Arranged by Alphabetical order

H022	H100TH-B <sup>○</sup> ○ <sup>○</sup> ○ <sup>○</sup>
H020	H100TH-EN3232R/L-130
H019	H100TH-EV3232R/L-180
H008	H63TH-A <sup>○</sup> ○ <sup>○</sup> ○ <sup>○</sup> DCLNR/L12
H021	H63TH-B <sup>○</sup> ○ <sup>○</sup> ○ <sup>○</sup>
H008	H63TH-DCLNL-L12-3
H006	H63TH-DCLNR/L-DX12
H007	H63TH-DCMNN-H/L12
H011	H63TH-DDJNL-L15-3
H009	H63TH-DDJNR/L-DX15
H010	H63TH-DDNNN-H/L15
H020	H63TH-EN2525R/L-115
H021	H63TH-EV2020R/L-105-3
H019	H63TH-EV2525R/L-112

H014	H63TH-MGHR/L-DX43 <sup>○</sup> ○ <sup>○</sup>
H016	H63TH-MMTENR-H/L16
H016	H63TH-MMTER-DX16
H017	H63TH-MTHR/L-DX43
H006	H63TH-PCLNR/L-DX12
H007	H63TH-PCMNN-H/L12
H009	H63TH-PDJNR/L-DX15
H010	H63TH-PDNNN-H/L15
H012	H63TH-PRDCN-H/L12
H012	H63TH-PRGCR/L-DX12
H013	H63TH-SVPBR/L-DX16
H013	H63TH-SVVBH-H/L16
H022	SL32 <sup>○</sup> ○ <sup>○</sup> -90



Tooling system  
for turning on  
multi-task machines

# HSK TOOLS

## HSK-T System

HSK-T is a new HSK system designed for turning on multi-task machines that are compatible with HSK-A type (ISO standard: ISO12164-1:2001). The HSK system was developed by a consortium of 17 Japanese manufacturers and registered in ISO standard (ISO12164-3:2008) under the name HSK-T type in 2008 and JIS standard (JIS B6064-3) in 2013.

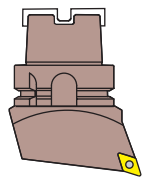


## High accuracy cutting edge positioning

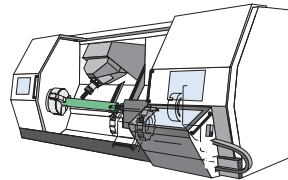
The HSK-T type has a closer tolerance between the spindle key and tool holder keyway than the HSK-A type. This results in higher cutting edge positional accuracies. For milling, the conventional HSK-A type tools can be still used.

## Compatible with both multi-task machines and machining centres

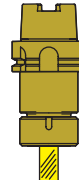
HSK-T TOOLS



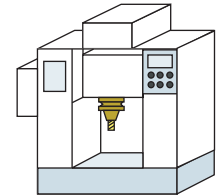
HSK-T  
Turning tool holder



HSK-T spindle  
Multi-task machines



HSK-A  
Rotating tool holder



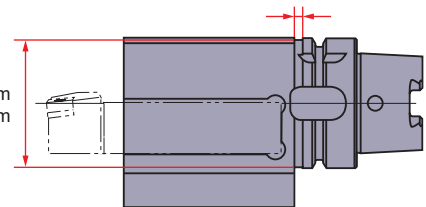
HSK-A spindle  
Machining centre

### \*Note

Short neck length from the flange with thick body of the HSK-T turning tool as shown in the figure at the left. Because there are machines which cannot be mounted depending on the ATC specifications of the multi-task machine (HSK-A type), please check beforehand. Also be careful of interference of the magazine with adjacent tools.

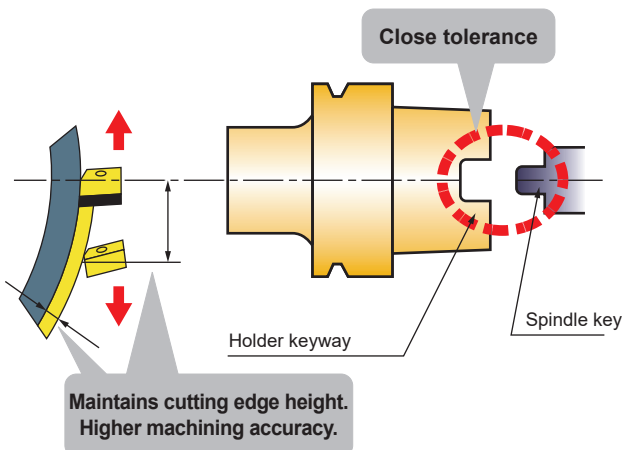
Neck length  
HSK-T63 Min.4mm  
HSK-T100 Min.5mm

Neck thickness  
HSK-T63 Max.62mm  
HSK-T100 Max.99mm



HSK-T turning tool standard (Example)

## Improved keyway tolerance



### Tolerance comparison (Example)

(mm)

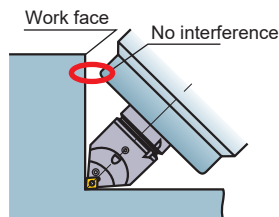
	12.2	12.3	12.4	12.5	12.6
<b>HSK A63</b>		12.25	12.35	12.58	
		0.10 Key tolerance			
		0.15 Minimum clearance			
			0.08		
			12.25		
			Keyway tolerance		
			0.33 Maximum clearance		
<b>HSK T63</b>		12.385	12.41	12.46	
		0.025			
		0.015 Minimum clearance			
			0.035		
			12.425		
			Keyway tolerance		
			0.075 Maximum clearance		

# High accuracy and rigidity HSK-T type tooling system developed for use on multi-task machines.

## Straight type tools suitable for use on multi-task machines

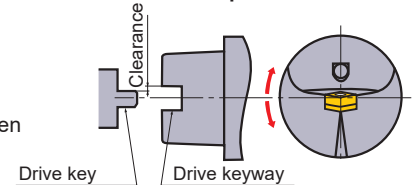
Avoid workpiece interference with improved tool accessibility.

By tilting the machines B spindle (main axis of the tool) at 45 deg, interference between the spindle, holder, workpiece and chuck can be avoided.



Improve centreline height by positioning the cutting edge at the centre of the spindle.

Increased stability and accuracy can be achieved because the cutting edge centreline height is not affected by the gap between the spindle and the key.



## New one-action type double clamp series

The double clamp mechanism offers high rigidity, accuracy and reliability that ensures secure insert clamping. Therefore making it suitable turning of difficult to machine materials such as stainless and heat resistant alloys.



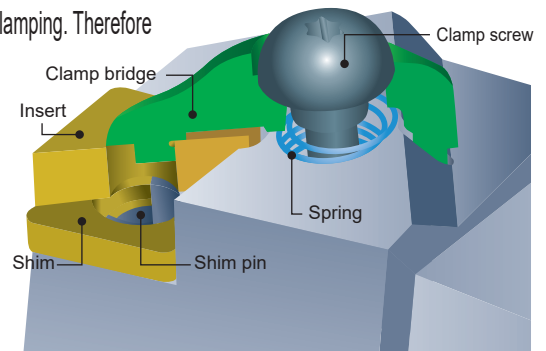
Handed type for turning and facing



Straight type for turning and facing



For turning, facing and boring



H

HSK-T TOOLS

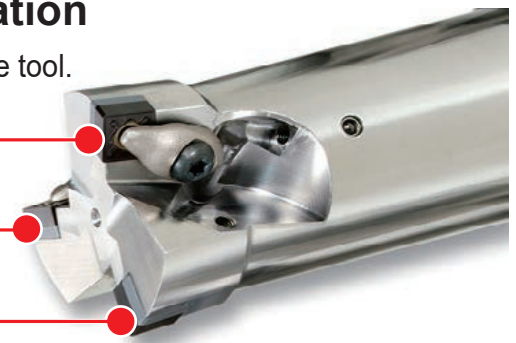
## 3 on 1 tool for process and tool consolidation

3 turning inserts of the same geometry can be installed on a single tool.

The same type of inserts can be installed for quick change with spare tools.

Different types of inserts can be installed for different applications (roughing, semi finishing and finishing)

Inserts in different grade types can be installed to cover various kinds of workpieces.



## New HSK-T100 size for large workpieces

Larger tool holder sizes for high efficiency machining.

Square shank holder type



Boring bar / Drill type

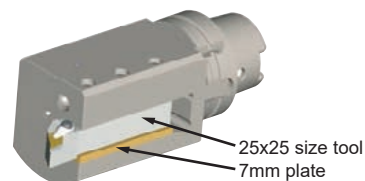


Sleeve




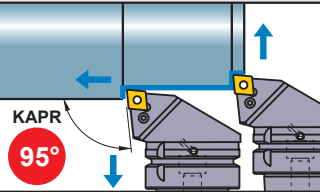

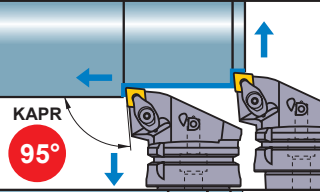

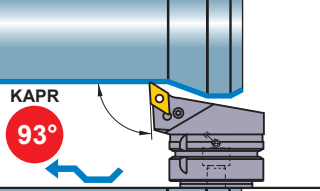

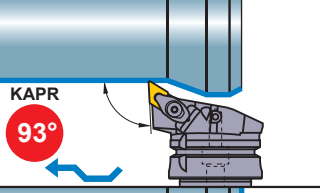

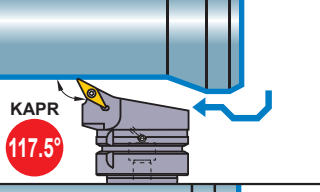

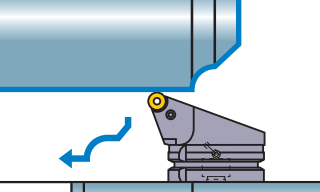

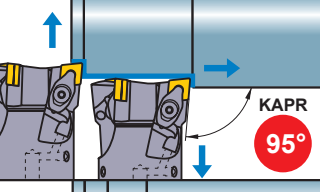

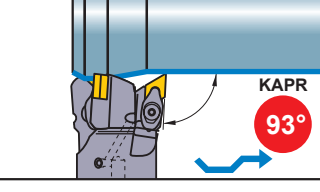
**A single tool can be used with different sized tool holders.**


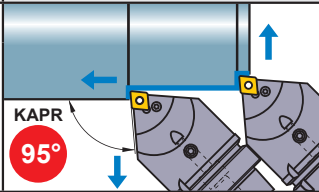

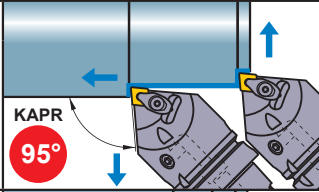

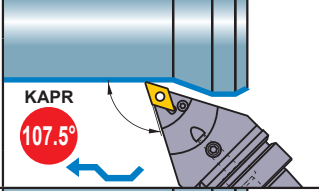

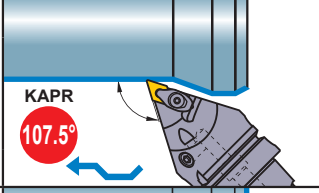

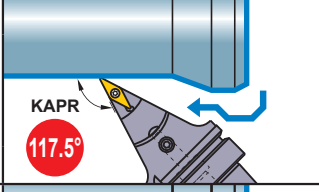

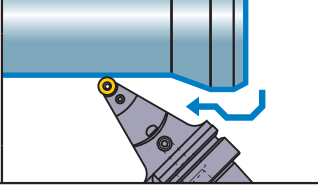
- Available for use with JIS B4126 (ISO 5610) 32x32 and 32x25 tools.
- Possible to fit a 25x25 tool by using a 7mm plate.
- \*Please prepare a plate on your own.




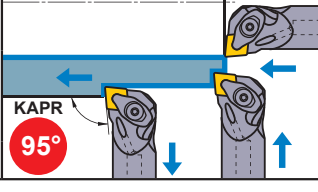
# CLASSIFICATION OF HSK-T TOOLS

## EXTERNAL TURNING • FACING • COPYING


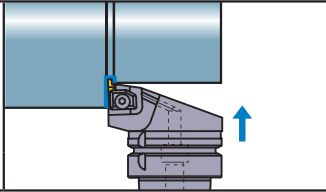

Order Number	Cutting Mode
H63TH-PCLNR/L-DX12  → H006	 KAPR 95°
H63TH-DCLNR/L-DX12  → H006	 KAPR 95°
H63TH-PDJNR/L-DX15  → H009	 KAPR 93°
H63TH-DDJNR/L-DX15  → H009	 KAPR 93°
H63TH-SVPBR/L-DX16  → H013	 KAPR 117.5°
H63TH-PRGCR/L-DX12  → H012	 KAPR 95°
H63TH-DCLNL-L12-3  → H008	 KAPR 95°
H63TH-DDJNL-L15-3  → H011	 KAPR 93°

Order Number	Cutting Mode
H63TH-PCMNN-H/L12  → H007	 KAPR 95°
H63TH-DCMNN-H/L12  → H007	 KAPR 95°
H63TH-PDNNN-H/L15  → H010	 KAPR 107.5°
H63TH-DDNNN-H/L15  → H010	 KAPR 107.5°
H63TH-SVVBH-H/L16  → H013	 KAPR 117.5°
H63TH-PRDCN-H/L12  → H012	 KAPR 95°


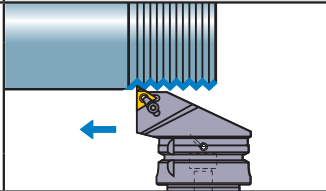


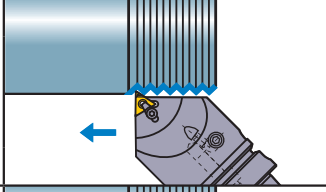


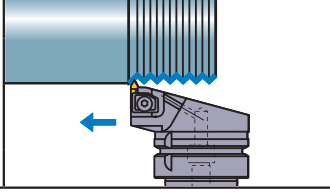

## EXTERNAL TURNING • FACING • BORING

Order Number	Cutting Mode
H63TH-A25KDCLNR/L12 H63TH-A32LDCLNR/L12  → H008	 KAPR 95°











## GROOVING

Order Number	Cutting Mode
<b>H63TH-MGHR/L-DX43</b>    H014	







## THREADING

Order Number	Cutting Mode
<b>H63TH-MMTER-DX16</b>    H016	
<b>H63TH-MMTENR-H/L16</b>    H016	
<b>H63TH-MTHR/L-DX43</b>    H017	

## EXTERNAL TURNING TOOL HOLDERS

Order Number	Holder
<b>H63TH-EV2525R/L-112</b>   H019	
<b>H100TH-EV3232R/L-180</b>   H019	
<b>H63TH-EN2525R/L-115</b>  *1  H020	
<b>H100TH-EN3232R/L-130</b>  *1  H020	
<b>H63TH-EV2020R/L-105-3</b>   H021	

## BORING BAR HOLDERS

Order Number	Holder
<b>H63TH-B</b>   H021	
<b>H100TH-B</b>   H022	
<b>SL32-90</b> (Sleeve)  *2  H022	

Note 1) The HSK63A shank type has a built-in coolant pipe for installation.

\*1 Mitsubishi Materials is licensed for production and distribution of these tools from MORI SEIKI CO., LTD under Patent No.3720202.

\*2 The SL32-90 sleeve is only for use with H100TH-B32-135.

H

HSK-T TOOLS

# FOR MULTI-TASK MACHINES

## PCLN

External turning • Facing

Right hand tool holder shown.

Finish	Light	Medium
FP (12)	LP (12)	MP (12)
Medium MK (12)	Medium Standard (12)	Medium-Rough RP (12)
Stainless MM (12)	CBN (12)	

Order Number	Stock		Insert Number	Dimensions (mm)			*2 WT (kg)				*1		
	R	L		DCONMS	LF	WF		Shim	Shim Pin	Clamp Lever	Clamp Screw	Wrench	
<b>H63TH-PCLNR/L-DX12</b>	●	●	CN○A CN○G CN○M	1204	63	65	45	1.3	LLSCN42	LLP14	LLCL14	LLCS108	HKY30R

\*1 Clamp Torque (N • m) : LLCS108=3.3

\*2 WT : Tool Weight

Note 1) Dimensions shown for insert corner RE 0.8.

HSK-T TOOLS

## DCLN

External turning • Facing **DOUBLE CLAMP type**

Right hand tool holder shown.

Finish	Light	Medium
FP (12)	LP (12)	MP (12)
Medium MK (12)	Medium Standard (12)	Medium-Rough RP (12)
Stainless MM (12)	CBN (12)	

Order Number	Stock		Insert Number	Dimensions (mm)			*2 WT (kg)					*1		
	R	L		DCONMS	LF	WF		Shim	Shim Pin	Clamp Bridge	Spring	Clamp Screw	Wrench	
<b>H63TH-DCLNR/L-DX12</b>	●	●	CN○A CN○G CN○M	1204	63	65	45	1.3	LLSCN42	LLP14	DCK2613	DCS1	DC0621T	TKY20F

\*1 Clamp Torque (N • m) : DC0621T=5.0

\*2 WT : Tool Weight









Note 1) Dimensions shown for insert corner RE 0.8.







● : Inventory maintained in Japan.

PCLN type inserts	> A074-A080
DCLN type inserts	> A074-A080
CBN & PCD inserts	> B022-B025, B055
RECOMMENDED CUTTING CONDITIONS	> A010-A015

# PCMN

## External turning • Facing

Finish	Light	Medium
FP  (12)	LP  (12)	MP  (12)
Medium MK  (12)	Medium Standard  (12)	Medium – Rough RP  (12)
Stainless MM  (12)	CBN  (12)	

Order Number	Stock	Insert Number	Dimensions (mm)		*2 WT (kg)						
			DCONMS	LF		Shim	Shim Pin	Clamp Lever	Clamp Screw	Plug	Wrench
H63TH-PCMNN-H12	●	CN $\odot$ A CN $\odot$ G CN $\odot$ M	63	100	1.7	LLSCN42	LLP14	LLCL14	LLCS108	HGM-PT1/8	HKY30R
H63TH-PCMNN-L12	●		63	140	2.7	LLSCN42	LLP14	LLCL14	LLCS108	HGM-PT1/8	HKY30R









\*1 Clamp Torque (N • m) : LLCS108=3.3







\*2 WT : Tool Weight

Note 1) Dimensions shown for insert corner RE 0.8.

# DCMNN

## External turning • DOUBLE CLAMP type Facing

Finish	Light	Medium
FP  (12)	LP  (12)	MP  (12)
Medium MK  (12)	Medium Standard  (12)	Medium – Rough RP  (12)
Stainless MM  (12)	CBN  (12)	

Order Number	Stock	Insert Number	Dimensions (mm)		*2 WT (kg)						
			DCONMS	LF		Shim	Shim Pin	Clamp Bridge	Spring	Clamp Screw	Wrench
H63TH-DCMNN-H12	●	CN $\odot$ A CN $\odot$ G CN $\odot$ M	63	100	1.7	LLSCN42	LLP14	DCK2613	DCS1	DC0621T	TKY20F
H63TH-DCMNN-L12	●		63	140	2.7	LLSCN42	LLP14	DCK2613	DCS1	DC0621T	TKY20F

\*1 Clamp Torque (N • m) : DC0621T=5.0

\*2 WT : Tool Weight

Note 1) Dimensions shown for insert corner RE 0.8.

H

HSK-T TOOLS

PCMN type inserts > A074 – A080  
 DCMNN type inserts > A074 – A080  
 CBN & PCD inserts > B022 – B025, B055

RECOMMENDED CUTTING CONDITIONS > A010 – A015  
 SPARE PARTS > P001  
 TECHNICAL DATA > Q001

H007



# FOR MULTI-TASK MACHINES

**DCLN** External turning • Facing **DOUBLE CLAMP type**

Finish	Light	Medium
FP (12)	LP (12)	MP (12)
Medium MK (12)	Medium Standard (12)	Medium-Rough RP (12)
Stainless MM (12)	CBN (12)	

Left hand tool holder only.

Order Number	Stock		Insert Number	Dimensions (mm)			*2 WT (kg)	Shim	Shim Pin	Clamp Bridge	Spring	Clamp Screw *1	Wrench	
	L			DCONMS	LF	WF								
<b>H63TH-DCLNL-L12-3</b>	●		CN○A CN○G CN○M	1204○○	63	140	30	2.2	LLSCN42	LLP14	DCK2613	DCS1	DC0621T	TKY20F

\*1 Clamp Torque (N • m) : DC0621T=5.0

\*2 WT : Tool Weight

Note 1) Dimensions shown for insert corner RE 0.8.

HSK-T TOOLS

**DCLN** External turning • Facing • Boring **DOUBLE CLAMP type**

Finish	Light	Medium
FP (12)	LP (12)	MP (12)
Medium MK (12)	Medium Standard (12)	Medium-Rough RP (12)
Stainless MM (12)	CBN (12)	

Right hand tool holder shown.

Order Number	Stock		Insert Number	Dimensions (mm)					DMIN (mm)	*2 WT (kg)	Shim	Shim Pin	Clamp Bridge	Spring	Clamp Screw *1	Wrench	
	R	L		DCONMS	LF	LU	WF	GAMF									
<b>H63TH-A25KDCLNR/L12</b>	●	●	CN○A CN○G CN○M	1204○○	63	125	82	17	11°	32	1.1	LLSCP42	LLP14	DCK2613	DCS1	DC0621T	TKY20F
<b>H63TH-A32LDCLNR/L12</b>	●	●	CN○A CN○G CN○M	1204○○	63	140	100	22	13°	40	1.4	LLSCN42	LLP14	DCK2613	DCS1	DC0621T	TKY20F

\*1 Clamp Torque (N • m) : DC0621T=5.0

\*2 WT : Tool Weight

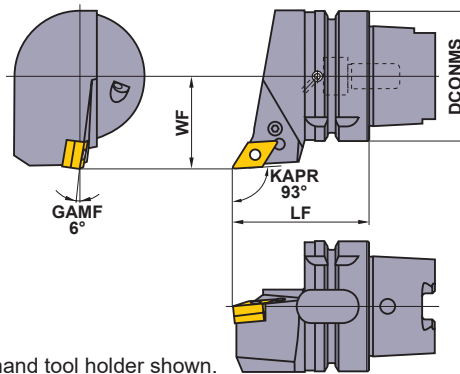
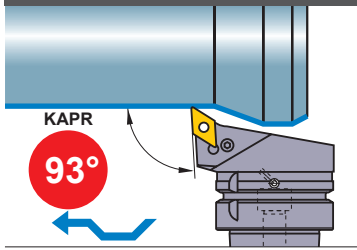
Note 1) Dimensions shown for insert corner RE 0.8.

● : Inventory maintained in Japan.









DCLN type inserts	> A074—A080
CBN & PCD inserts	> B022—B025, B055
RECOMMENDED CUTTING CONDITIONS	> A010—A015

# PDJN

## External turning • Copying



Right hand tool holder shown.

Finish	Light	Medium
FP  (15)	LP  (15)	MP  (15)
Medium MK  (15)	Medium-Rough RP  (15)	Stainless MM  (15)
G Class R/L  (15)	CBN  (15)	

Order Number	Stock		Insert Number	Dimensions (mm)			*3 WT (kg)	*2					
	R	L		DCONMS	LF	WF		Shim	Shim Pin	Clamp Lever	Clamp Screw	Wrench	
<b>H63TH-PDJNR/L-DX15</b>	●	●	DNOA DNOG DNO M DNMX	1504	63	65	45	1.2	LLSDN43 (LLSDN42)	LLP14	LLCL24	LLCS108	HKY30R

\*1 Clamp Torque (N • m) : LLCS108=3.3

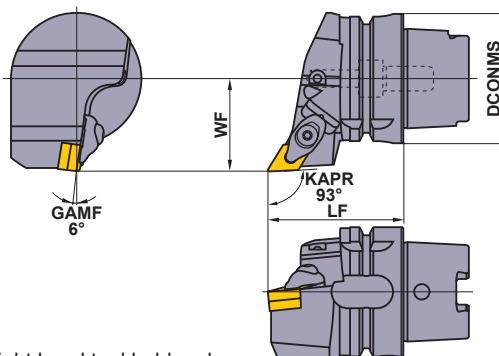
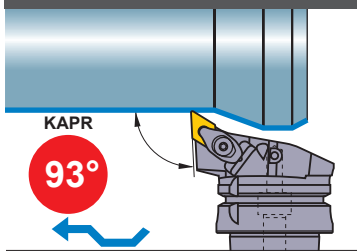
\*2 Please use shim no. LLSDN42 with 6.35mm thick inserts. When using 6.35mm thick inserts, the shim should be ordered separately.

\*3 WT : Tool Weight









Note 1) Dimensions shown for insert corner RE 0.8.

# DDJN

## External turning • DOUBLE CLAMP type



Right hand tool holder shown.

Finish	Light	Medium
FP  (15)	LP  (15)	MP  (15)
Medium MK  (15)	Medium-Rough RP  (15)	Stainless MM  (15)
G Class R/L  (15)	CBN  (15)	

Order Number	Stock		Insert Number	Dimensions (mm)			*3 WT (kg)	*2						
	R	L		DCONMS	LF	WF		Shim	Shim Pin	Clamp Bridge	Spring	Clamp Screw	Wrench	
<b>H63TH-DDJNR/L-DX15</b>	●	●	DNOA DNOG DNO M DNMX	1504	63	65	45	1.2	LLSDN43 (LLSDN42)	LLP24	DCK2613	DCS1	DC0621T	TKY20F

\*1 Clamp Torque (N • m) : DC0621T=5.0

\*2 Please use shim no. LLSDN42 with 6.35mm thick inserts. When using 6.35mm thick inserts, the shim should be ordered separately.

\*3 WT : Tool Weight

Note 1) Dimensions shown for insert corner RE 0.8.

H

HSK-T TOOLS

PDJN type inserts	> A081—A087
DDJN type inserts	> A081—A087
CBN & PCD inserts	> B026—B030, B055

RECOMMENDED CUTTING CONDITIONS	> A010—A015
SPARE PARTS	> P001
TECHNICAL DATA	> Q001

H009

# FOR MULTI-TASK MACHINES

## PDNN

External turning • Copying

Finish	Light	Medium
FP (15)	LP (15)	MP (15)
Medium MK (15)	Medium-Rough RP (15)	Stainless MM (15)
G Class R/L (15)	CBN (15)	

Order Number	Stock	Insert Number	Dimensions (mm)		*3 WT (kg)	*2						
			DCONMS	LF		Shim	Shim Pin	Clamp Lever	Clamp Screw	Plug	Wrench	
H63TH-PDNNN-H15	●	DN $\odot$ A DN $\odot$ G DN $\odot$ M	1504	63	100	1.6	LLSDN43 (LLSDN42)	LLP14	LLCL24	LLCS108	HGM-PT1/8	HKY30R
H63TH-PDNNN-L15	●			63	140	2.5	LLSDN43 (LLSDN42)	LLP14	LLCL24	LLCS108	HGM-PT1/8	HKY30R

\*1 Clamp Torque (N • m) : LLCS108=3.3

\*2 Please use shim no. LLSDN42 with 6.35mm thick inserts. When using 6.35mm thick inserts, the shim should be ordered separately.

\*3 WT : Tool Weight

Note 1) Dimensions shown for insert corner RE 0.8.

## DDNN

External turning • Copying **DOUBLE CLAMP type**

Finish	Light	Medium
FP (15)	LP (15)	MP (15)
Medium MK (15)	Medium-Rough RP (15)	Stainless MM (15)
G Class R/L (15)	CBN (15)	

Order Number	Stock	Insert Number	Dimensions (mm)		*3 WT (kg)	*2						
			DCONMS	LF		Shim	Shim Pin	Clamp Bridge	Spring	Clamp Screw	Wrench	
H63TH-DDNNN-H15	●	DN $\odot$ A DN $\odot$ G DN $\odot$ M	1504	63	100	1.6	LLSDN43 (LLSDN42)	LLP24	DCK2613	DCS1	DC0621T	TKY20F
H63TH-DDNNN-L15	●			63	140	2.5	LLSDN43 (LLSDN42)	LLP24	DCK2613	DCS1	DC0621T	TKY20F

\*1 Clamp Torque (N • m) : DC0621T=5.0

\*2 Please use shim no. LLSDN42 with 6.35mm thick inserts. When using 6.35mm thick inserts, the shim should be ordered separately.

\*3 WT : Tool Weight

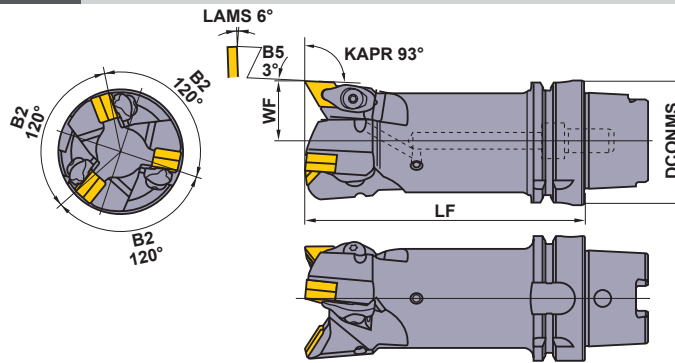
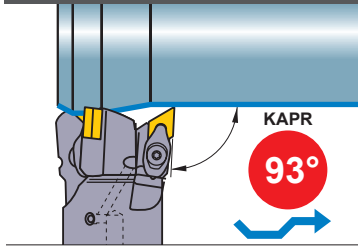
Note 1) Dimensions shown for insert corner RE 0.8.

● : Inventory maintained in Japan.







PDNN type inserts	> A081 – A087
DDNN type inserts	> A081 – A087
CBN & PCD inserts	> B026 – B030, B055
RECOMMENDED CUTTING CONDITIONS	> A010 – A015







# DDJN

## External turning • Facing **DOUBLE CLAMP type**



Left hand tool holder only.

Finish	Light
FP  (15)	LP  (15)
Medium	Medium
MP  (15)	MK  (15)
Medium-Rough	Stainless
RP  (15)	MM  (15)

Order Number	Stock	Insert Number	Dimensions (mm)			*3 WT (kg)	*2														
			DCONMS	LF	WF																
<b>H63TH-DDJNL-L15-3</b>	●	<table border="1"> <tr> <td>DN</td> <td>A</td> </tr> <tr> <td>DN</td> <td>G</td> </tr> <tr> <td>DN</td> <td>M</td> </tr> <tr> <td>DN</td> <td>MX</td> </tr> </table>	DN	A	DN	G	DN	M	DN	MX	1504	63	140	30	2.2	LLSDN43 (LLSDN42)	LLP24	DCK2613	DCS1	DC0621T	TKY20F
DN	A																				
DN	G																				
DN	M																				
DN	MX																				

\*1 Clamp Torque (N • m) : DC0621T=5.0

\*2 Please use shim no. LLSDN42 with 6.35mm thick inserts. When using 6.35mm thick inserts, the shim should be ordered separately.

\*3 WT : Tool Weight

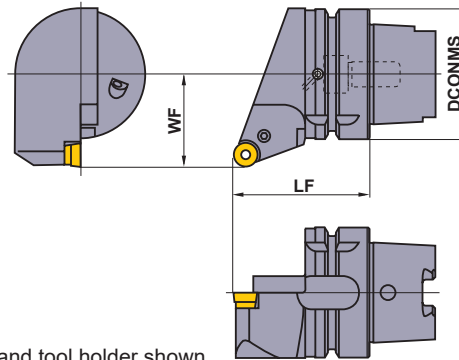
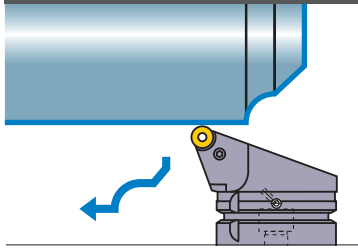
Note 1) Dimensions shown for insert corner RE 0.8.

# FOR MULTI-TASK MACHINES

## PRGC

External turning • Facing • Copying

Medium



Right hand tool holder shown.

Order Number	Stock		Insert Number	Dimensions (mm)			*2 WT (kg)	*1				
	R	L		DCONMS	LF	WF		Shim	Shim Pin	Clamp Lever	Clamp Screw	Wrench
<b>H63TH-PRGCR/L-DX12</b>	●	●	RCMX 1204M0	63	65	45	1.2	LLSRN123	LLP13	LLCL112	LLCS106	HKY25R

\*1 Clamp Torque (N • m) : LLCS106=2.2

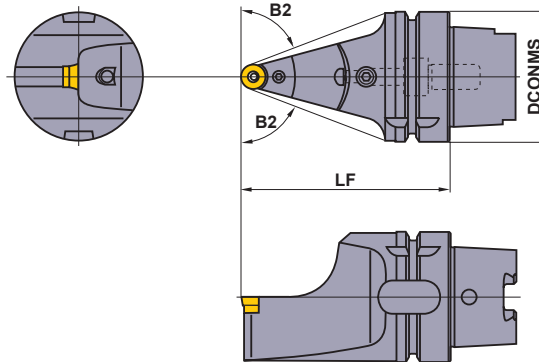
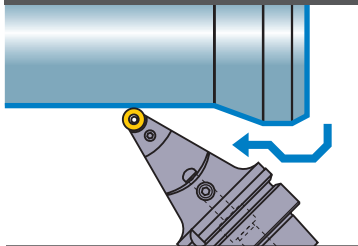
\*2 WT : Tool Weight

HSK-T TOOLS

## PRDC

External turning • Facing • Copying

Medium



Order Number	Stock		Insert Number	Dimensions (mm)			*2 WT (kg)	*1					
	R	L		DCONMS	LF	B2		Shim	Shim Pin	Clamp Lever	Clamp Screw	Plug	Wrench
<b>H63TH-PRDCN-H12</b>	●	●	RCMX 1204M0	63	100	69°	1.4	LLSRN123	LLP13	LLCL112	LLCS106	HGM-PT1/8	HKY25R
<b>H63TH-PRDCN-L12</b>	●	●		63	140	75°	2.3	LLSRN123	LLP13	LLCL112	LLCS106	HGM-PT1/8	HKY25R

\*1 Clamp Torque (N • m) : LLCS106=2.2

\*2 WT : Tool Weight

## RECOMMENDED CUTTING CONDITIONS

	Workpiece Material	Hardness	Cutting Mode	Breaker	Grade	Cutting Speed (m/min)
P	Mild Steel	≤180HB	Medium Cutting	Standard	UE6110	245—440
	Carbon Steel • Alloy Steel	180HB—350HB	Medium Cutting	Standard	UE6110	200—300
M	Stainless Steel	≤200HB	Medium Cutting	Standard	US735	70—130

● : Inventory maintained in Japan.

PRGC type inserts > A131

PRDC type inserts > A131

# SVPB

## Facing • Copying

Finish	Light
R/L-F  (16)	SV  (16)
Medium	Medium
MV  (16)	MP  (16)
CBN  (16)	

Right hand tool holder shown.

Order Number	Stock		Insert Number	Dimensions (mm)				*2 WT (kg)			*1		
	R	L		DCONMS	LF	WF	WF2		Shim	Shim Pin	Clamp Screw	Wrench	
<b>H63TH-SVPBR/L-DX16</b>	●	●	VB <sup>○</sup> T VB <sup>○</sup> W	1604 <sup>○</sup>	63	65	45	3.8	1.1	SPSVN32	BCP141	TS35D	TKY15F

\*1 Clamp Torque (N • m) : TS35D=3.5

\*2 WT : Tool Weight

Note 1) Dimensions shown for insert corner RE 0.8.

# SVVB

## Facing • Copying

Finish	Light
R/L-F  (16)	SV  (16)
Medium	Medium
MV  (16)	MP  (16)
CBN  (16)	

Order Number	Stock		Insert Number	Dimensions (mm)			*2 WT (kg)			*1			
	R	L		DCONMS	LF	B2		Shim	Shim Pin	Clamp Screw	Plug	Wrench	
<b>H63TH-SVVBH-H16</b>	●	●	VB <sup>○</sup> T VB <sup>○</sup> W	1604 <sup>○</sup>	63	100	66.5°	1.3	SPSVN32	BCP141	TS35D	HGM-PT1/8	TKY15F
<b>H63TH-SVVBH-L16</b>	●	●	VB <sup>○</sup> T VB <sup>○</sup> W	1604 <sup>○</sup>	63	140	72.5°	2.2	SPSVN32	BCP141	TS35D	HGM-PT1/8	TKY15F

\*1 Clamp Torque (N • m) : TS35D=3.5

\*2 WT : Tool Weight

Note 1) Dimensions shown for insert corner RE 0.8.

## RECOMMENDED CUTTING CONDITIONS

Workpiece Material	Hardness	Cutting Mode	Breaker	Grade	Cutting Speed (m/min)	
<b>P</b>	Mild Steel	≤180HB	Finish Cutting	<b>F</b>	<b>AP25N</b>	250 (150–300)
		Medium Cutting	<b>MP</b>	<b>UE6020</b>	250 (180–330)	
	Carbon Steel Alloy Steel	180HB–350HB	Finish Cutting	<b>F</b>	<b>AP25N</b>	210 (150–260)
			Medium Cutting	<b>MP</b>	<b>UE6020</b>	210 (160–260)
<b>M</b>	Stainless Steel	≤200HB	Medium Cutting	<b>MM</b>	<b>MP7035</b>	100 (70–120)
<b>K</b>	Gray Cast Iron	Tensile Strength≤350MPa	Medium Cutting	<b>MK</b>	<b>UE6020</b>	220 (160–290)

SVPB type inserts > A142–A144

SVVB type inserts > A142–A144

CBN inserts > B049

SPARE PARTS > P001

TECHNICAL DATA > Q001

H

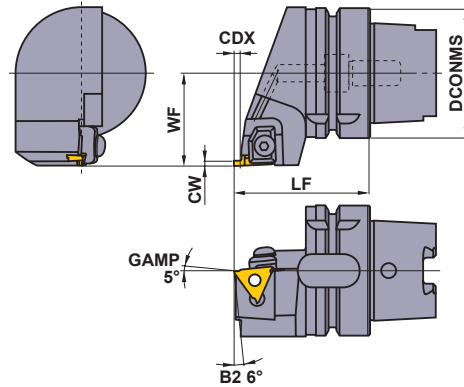
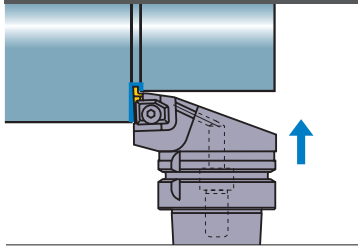
HSK-T TOOLS

H013

# FOR MULTI-TASK MACHINES

**MG**

Grooving



Right hand tool holder shown.

Order Number	Stock		Insert Number	Dimensions (mm)					*2 WT (kg)	 Clamp Bridge	 Clamp Screw	 Spring	 Wrench
	R	L		DCONMS	CW	CDX	LF	WF					
<b>H63TH-MGHR/L-DX4315</b>	●	●	MGTR/L 43125   43470	63	1.25	1.2			1.2	MTK1R/L	HBH06020	MES3	HKY40R
<b>H63TH-MGHR/L-DX4323</b>	●	●			1.45	1.5							
<b>H63TH-MGHR/L-DX4332</b>	●	●			1.5 ≤ CW ≤ 2.3	3	65	45					
<b>H63TH-MGHR/L-DX4333</b>	●	●			2.3 < CW ≤ 3.3	4.5							
					3.3 < CW ≤ 4.7	4.5							

\*1 Clamp Torque (N · m) : HBH06020=7.0

\*2 WT : Tool Weight

H

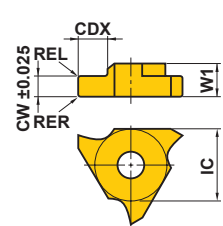
HSK-T TOOLS

## RECOMMENDED CUTTING CONDITIONS

Workpiece Material	Hardness	Grade	Cutting Speed (m/min)	Feed (mm/rev)
<b>P</b> Carbon Steel Alloy Steel	180–350HB	<b>VP20MF</b>	120 (100–140)	0.10 (0.03–0.18)
		<b>NX2525</b>	130 (100–160)	0.12 (0.03–0.2)
<b>M</b> Stainless Steel	≤200HB	<b>VP20MF</b>	120 (100–140)	0.10 (0.03–0.18)
<b>K</b> Gray Cast Iron	Tensile Strength ≤ 350MPa	<b>VP20MF</b>	120 (100–140)	0.10 (0.03–0.18)

● : Inventory maintained in Japan.  
(Contains 10 pieces per case.)

## INSERTS FOR MG TYPE

Order Number	Stock						Dimensions (mm)						Geometry
	Coated		Cermet		Carbide		CW	CDX	IC	W1	RER/L	LE	
	VP20MF		NX2525		UT120T								
	R	L	R	L	R	L							
MGTR/L43125	●	●	●	●	●	●	1.25	1.2	12.7	4.76	0.2	2.7	 <p>MGTR/L...</p>
MGTR/L43145	●	●		●	●	●	1.45	1.5	12.7	4.76	0.2	—	
MGTR/L43150	●	●	●	●	●	●	1.5	3	12.7	4.76	0.2	2.7	
MGTR/L43175	●	●	●	●	●	●	1.75	3	12.7	4.76	0.2	—	
MGTR/L43200	●	●	●	●	●	●	2	3	12.7	4.76	0.2	2.7	
MGTR/L43230	●	●	●	●	●	●	2.3	3	12.7	4.76	0.2	—	
MGTR/L43250	●	●	●	●	●	●	2.5	4.5	12.7	4.76	0.3	2.7	
MGTR/L43260	●	●	●		●	●	2.6	4.5	12.7	4.76	0.3	—	
MGTR/L43270	●	●			●	●	2.7	4.5	12.7	4.76	0.3	—	
MGTR/L43280		●		●	●	●	2.8	4.5	12.7	4.76	0.3	—	
MGTR/L43300	●	●	●	●	●	●	3	4.5	12.7	4.76	0.3	2.7	
MGTR/L43320	●				●	●	3.2	4.5	12.7	4.76	0.3	—	
MGTR/L43330		●		●	●	●	3.3	4.5	12.7	4.76	0.3	—	
MGTR/L43350	●	●	●	●	●	●	3.5	4.5	12.7	4.76	0.3	2.7	
MGTR/L43400	●	●	●		●	●	4	4.5	12.7	4.76	0.3	2.7	
MGTR/L43420	●	●	●		●	●	4.2	4.5	12.7	4.76	0.4	—	
MGTR/L43430	●	●	●		●	●	4.3	4.5	12.7	4.76	0.4	—	
MGTR/L43450	●	●	●	●	●	●	4.5	4.5	12.7	4.76	0.4	—	
MGTR/L43470	●	●	●	●	●	●	4.7	4.5	12.7	4.76	0.4	—	

Right hand insert shown.

H

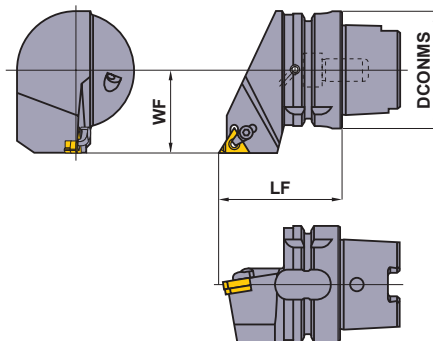
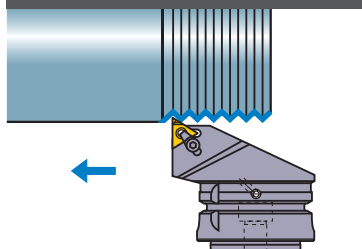
HSK-T TOOLS



# FOR MULTI-TASK MACHINES

## MMTE

### Threading



Right hand tool holder only.

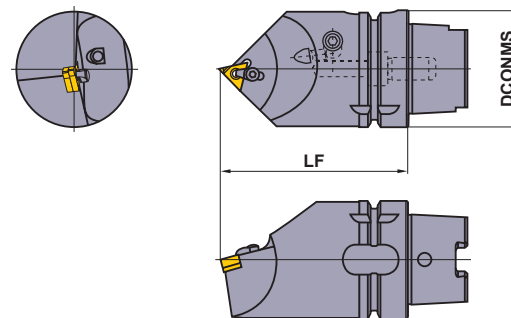
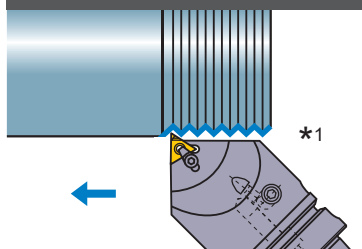
Order Number	Stock	Insert Number	Dimensions (mm)			*2 WT (kg)	*1					
			DCONMS	LF	WF		Clamp Bridge	Clamp Screw	Stop Ring	Shim	Shim Screw	Wrench
H63TH-MMTER-DX16	●	MMT16ER ○○○○	63	65	45	1.2	SETK51	SETS51	CR4	CTE32TP15	HFC03008	TKY15F HKY20R

\*1 Clamp Torque (N · m) : SETS51=3.5, HFC03008=1.5

\*2 WT : Tool Weight

## MMTEN

### Threading



Tool holder for right hand insert only.

Order Number	Stock	Insert Number	Dimensions (mm)			*3 WT (kg)	*2					
			DCONMS	LF			Clamp Bridge	Clamp Screw	Stop Ring	Shim	Shim Screw	Plug
H63TH-MMTENR-H16	●	MMT16ER ○○○○	63	100	1.7	SETK51	SETS51	CR4	CTE32TP15	HFC03008	HGM-PT1/8	TKY15F HKY20R
H63TH-MMTENR-L16	●		63	140	2.7	SETK51	SETS51	CR4	CTE32TP15	HFC03008	HGM-PT1/8	TKY15F HKY20R

\*1 For use with B axis tilted at 45 degrees.

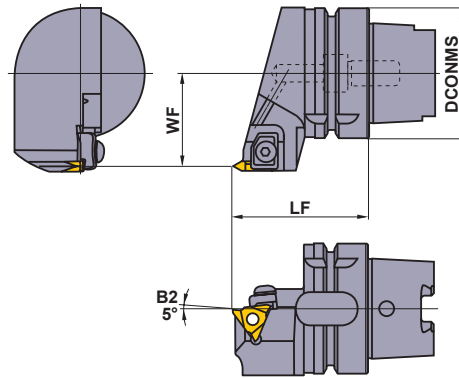
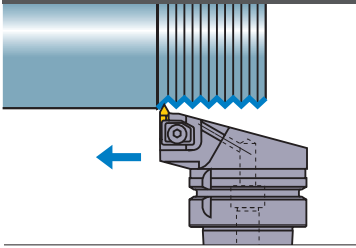
\*2 Clamp Torque (N · m) : SETS51=3.5, HFC03008=1.5

\*3 WT : Tool Weight

## RECOMMENDED CUTTING CONDITIONS

Workpiece Material	Hardness	Grade	Cutting Speed (m/min)
P Mild Steel	≤180HB	VP10MF	150 (70–230)
		VP15TF	100 (60–140)
	180–350HB	VP10MF	140 (80–200)
		VP15TF	100 (60–140)
M Stainless Steel	≤200HB	VP10MF	130 (80–180)
		VP15TF	80 (40–120)
K Gray Cast Iron	Tensile Strength≤350MPa	VP10MF	140 (80–200)
		VP15TF	90 (60–120)

● : Inventory maintained in Japan.

**MT****Threading**

Right hand tool holder shown.

Order Number	Stock		Insert Number	Dimensions (mm)			*2 WT (kg)		*1			
	R	L		DCONMS	LF	WF		Clamp Bridge	Clamp Screw	Spring	Wrench	
<b>H63TH-MTHR/L-DX43</b>	●	●	MTTR/L	43	63	65	45	1.2	MTK1R/L	HBH06020	MES3	HKY40R

\*1 Clamp Torque (N • m) : HBH06020=7.0

\*2 WT : Tool Weight

**H**

HSK-T TOOLS

**RECOMMENDED CUTTING CONDITIONS**

	Workpiece Material	Hardness	Grade	Cutting Speed (m/min)
<b>P</b>	Mild Steel	≤180HB	<b>UP20M</b>	140 (100–180)
			<b>NX2525</b>	200 (150–250)
			<b>UTi20T</b>	120 (100–150)
	Carbon Steel Alloy Steel	180HB–350HB	<b>UP20M</b>	120 (100–150)
			<b>NX2525</b>	170 (150–200)
			<b>UTi20T</b>	100 (70–120)
<b>M</b>	Stainless Steel	≤200HB	<b>UP20M</b>	120 (80–150)
			<b>UTi20T</b>	100 (70–130)
<b>K</b>	Gray Cast Iron	Tensile Strength≤350MPa	<b>UP20M</b>	80 (60–100)
			<b>UTi20T</b>	80 (60–100)
			<b>HTi10</b>	100 (70–130)

APPLICABLE INSERT	> H018
SPARE PARTS	> P001
TECHNICAL DATA	> Q001

**H017**

# FOR MULTI-TASK MACHINES

## INSERTS FOR MT TYPE

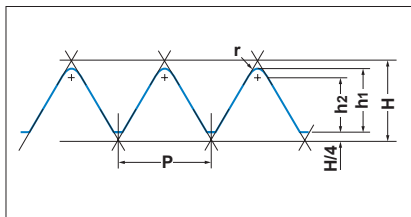
Type	Order Number	Class	Coated		Cermet		Carbide		ISO Pitch mm (thread/inch)	Dimensions (mm)			Geometry
			UP20M	NX2525	UT120T	HT110	IC	W1		RE			
General • 60°	MTTR436000	G	●	●	●	●			-0.8	12.7	4.76	0	<b>MTTR/L(60°) (G Class)</b>  Right hand insert shown.
	MTTR436001	G	●	●	●	●			1.0-1.75	12.7	4.76	0.1	
	MTTL436001	G	●		●	●			1.0-1.75	12.7	4.76	0.1	
	MTTR436002	G	●	●	●	●			2.0-2.5	12.7	4.76	0.2	
	MTTL436002	G	●	●	●	●			2.0-2.5	12.7	4.76	0.2	
	MTTR436003	G	●	●	●	●			3.0-3.5	12.7	4.76	0.3	
	MTTL436003	G	●	●	●	●			3.0-3.5	12.7	4.76	0.3	
	MTTR436004	G	●	●	●	●			4.0-4.5	12.7	4.76	0.4	
General • 55°	MTTR435501	G		●	●				(28-10)	12.7	4.76	0.1	<b>MTTR(55°) (G Class)</b>  Right hand insert shown.
	MTTR435502	G		●	●				(16-8)	12.7	4.76	0.2	
	MTTR435503	G		●	●				(11-8)	12.7	4.76	0.3	

H

HSK-T TOOLS

### STANDARD DEPTH OF CUT

- The chart on the right shows the cutting depths when machining external ISO metric screw threads.
- When you use cermet grades or cut stainless steel, please increase the number of passes by 2-3 times.



### METRIC THREAD

Unit : mm

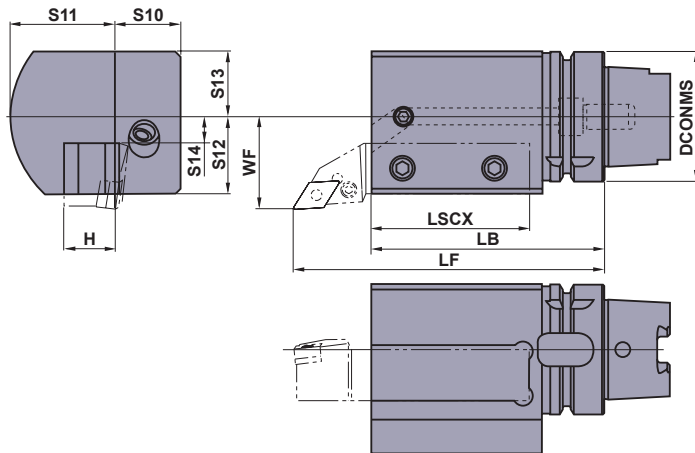
P (Pitch)	0.75	1.00	1.25	1.50	1.75	2.00	2.50	3.00	3.50	4.00	4.50	
h1	0.46	0.61	0.77	0.92	1.07	1.23	1.53	1.84	2.15	2.45	2.76	
h2	0.35	0.47	0.59	0.70	0.82	0.94	1.17	1.41	1.65	1.87	2.11	
r (Corner Radius)	0.11	0.14	0.18	0.22	0.25	0.29	0.36	0.43	0.50	0.58	0.65	
Number of Passes	1	0.18	0.20	0.20	0.25	0.25	0.25	0.30	0.30	0.35	0.35	0.40
	2	0.13	0.15	0.18	0.20	0.20	0.25	0.25	0.25	0.30	0.30	0.35
	3	0.10	0.10	0.12	0.15	0.20	0.20	0.20	0.25	0.25	0.25	0.30
	4	0.05	0.10	0.12	0.15	0.15	0.15	0.20	0.20	0.20	0.25	0.25
	5		0.06	0.10	0.10	0.12	0.15	0.15	0.20	0.20	0.25	0.25
	6			0.05	0.07	0.10	0.10	0.10	0.15	0.20	0.20	0.20
	7					0.05	0.08	0.10	0.15	0.15	0.20	0.20
	8						0.05	0.10	0.10	0.15	0.15	0.15
	9							0.08	0.10	0.10	0.15	0.15
	10							0.05	0.09	0.10	0.10	0.15
	11								0.05	0.10	0.10	0.10
	12									0.05	0.10	0.10
	13										0.05	0.10
	14											0.06

Note 1) The first pass causes a high load on the cutting edge.  
In order to avoid damage, keep the depth of cut to 0.4-0.5mm maximum.

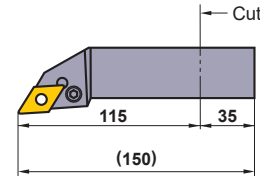
● : Inventory maintained in Japan.  
(Contains 10 pieces per case.)

# EXTERNAL TURNING TOOL HOLDERS

External turning • Facing



■ This holder is for 25×25 size tools.  
Please shorten the tool as shown below before use.



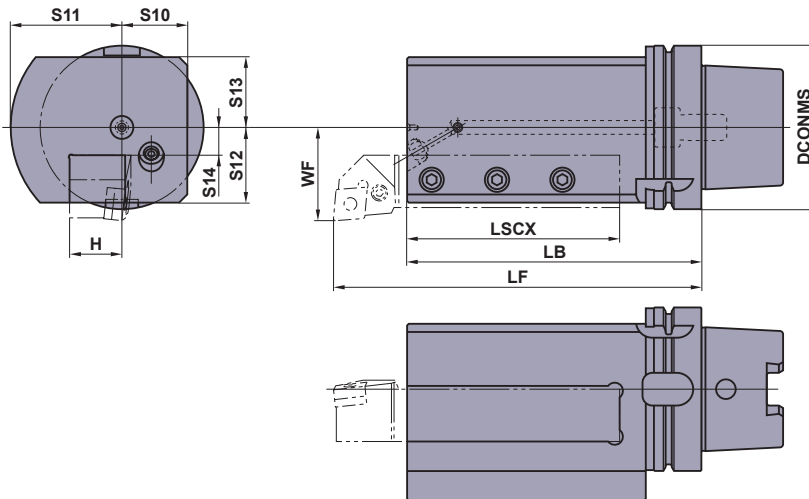
Right hand tool holder shown.

Order Number	Stock		Dimensions (mm)											* WT (kg)
	R	L	DCONMS	LF	LB	LSCX	H	S10	S11	WF	S14	S12	S13	
<b>H63TH-EV2525R/L-112</b>	●	●	63	150	112	77	25	32	53	45	13	38	32	3.9

\* WT : Tool Weight

# EXTERNAL TURNING TOOL HOLDERS

External turning • Facing



■ This holder is for 32×32 and 32×25 size tools.

Right hand tool holder shown.

Order Number	Stock		Dimensions (mm)											* WT (kg)
	R	L	DCONMS	LF	LB	LSCX	H	S10	S11	WF	S14	S12	S13	
<b>H100TH-EV3232R/L-180</b>	●	●	100	220	180	130	32	40	68	57	17	46	43	11.7

\* WT : Tool Weight

Note 1) Possible to fit a 25 x 25 tool by using a 7mm plate.

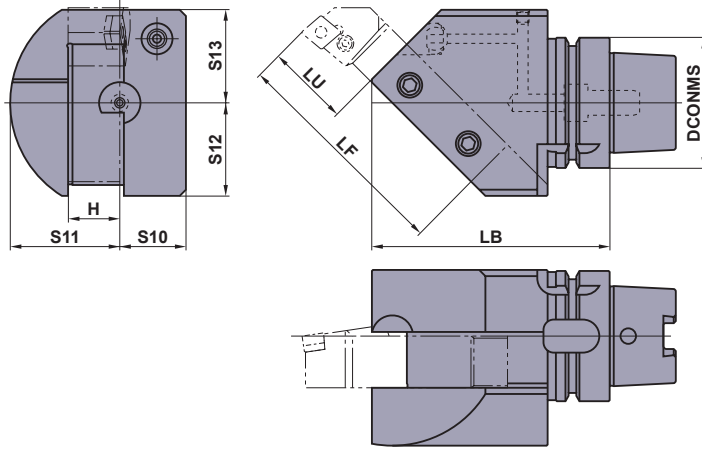
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HSK-T TOOLS

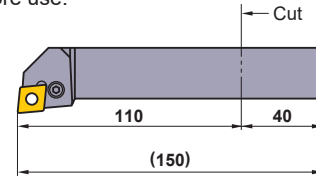
# FOR MULTI-TASK MACHINES

## EXTERNAL TURNING TOOL HOLDERS

External turning • Facing



■ This holder is for 25×25 size tools.  
Please shorten the tool as shown below before use.



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Right hand tool holder shown.

Order Number	Stock		Dimensions (mm)									* WT (kg)
	R	L	DCONMS	LB	LU	LF	H	S10	S11	S12	S13	
H63TH-EN2525R/L-115	●	●	63	115	40	110	25	32	53	45	45	3.7

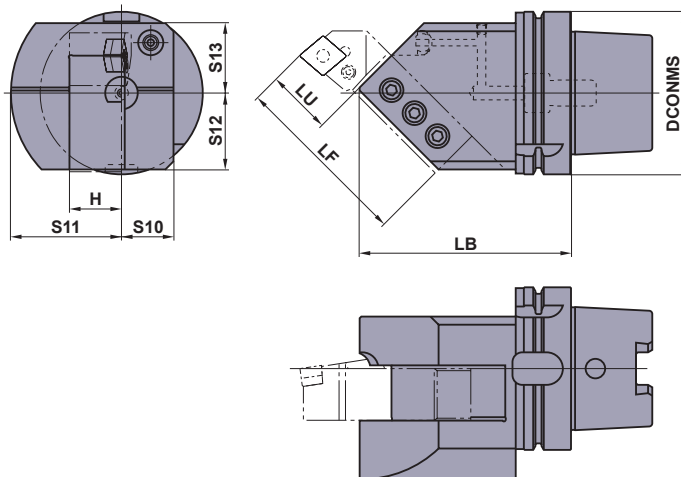
\* WT : Tool Weight

H

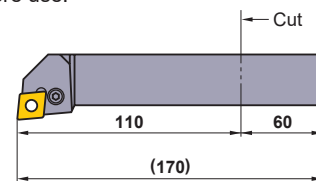
HSK-T TOOLS

## EXTERNAL TURNING TOOL HOLDERS

External turning • Facing



■ This holder is for 32×32 and 32×25 size tools.  
Please shorten the tool as shown below before use.



Mitsubishi Materials is licensed for production and distribution of these tools from MORI SEIKI CO., LTD under Patent No.3720202.

Right hand tool holder shown.

Order Number	Stock		Dimensions (mm)									* WT (kg)
	R	L	DCONMS	LB	LU	LF	H	S10	S11	S12	S13	
H100TH-EN3232R/L-130	●	●	100	130	40	110	32	32	68	47	43	6.6

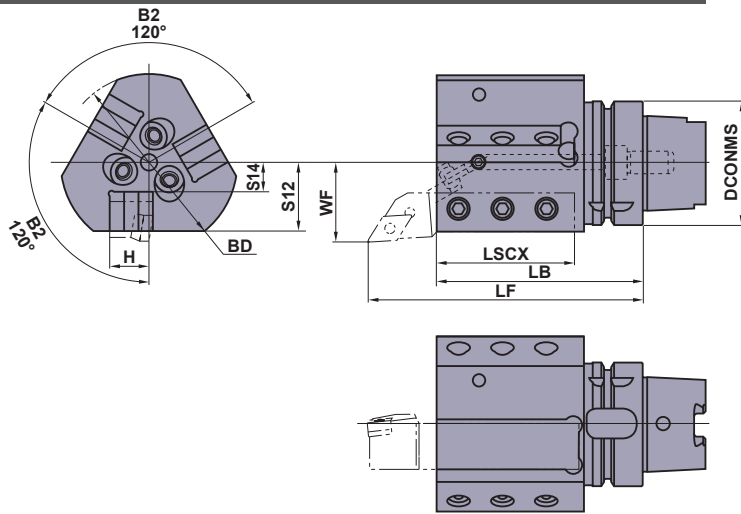
\* WT : Tool Weight

Note 1) Possible to fit a 25 x 25 tool by using a 7mm plate.

● : Inventory maintained in Japan.

# EXTERNAL TURNING TOOL HOLDERS

External turning • Facing



■ This holder is for 20×20 size tools.  
Please shorten the tool as shown below before use.

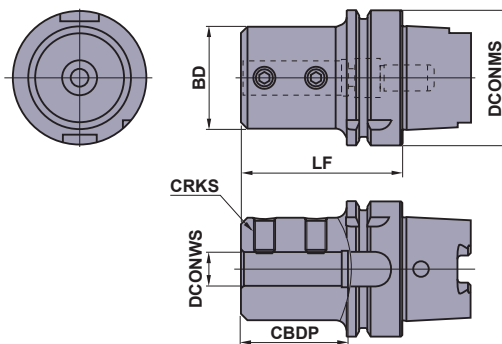
Right hand tool holder shown.

Order Number	Stock		Dimensions (mm)								* WT (kg)	
	R	L	DCONMS	LF	LB	LSCX	H	BD	WF	S14		S12
H63TH-EV2020R/L-105-3	●	●	63	140	105	70	20	90	40	15	35	2.9

\* WT : Tool Weight

# BORING BAR HOLDERS

Boring



Order Number	Stock	Dimensions (mm)						* WT (kg)
		DCONMS	BD	DCONWS	LF	CBDP	CRKS	
H63TH-B08-65	●	63	28	8	65	40	M8	0.9
H63TH-B10-70	●	63	35	10	70	45	M8	1.0
H63TH-B12-70	●	63	42	12	70	45	M8	1.1
H63TH-B16-75	●	63	48	16	75	50	M10	1.3
H63TH-B20-75	●	63	52	20	75	50	M10	1.4
H63TH-B25-83	●	63	62	25	83	58	M12	1.7
H63TH-B32-87	●	63	62	32	87	62	M12	1.7
H63TH-B40-97	●	63	65	40	97	72	M16	1.8

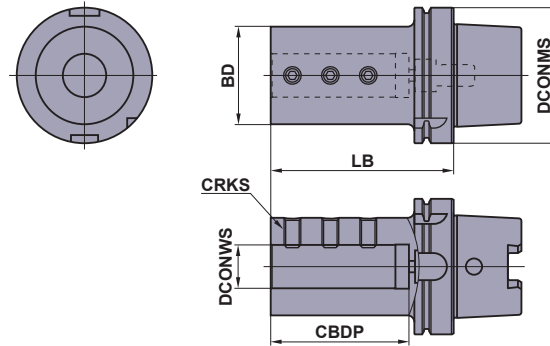
\* WT : Tool Weight

Note 1) Please shorten a boring bar to the required shank length. This holder is for boring bars and indexable type drills.

# FOR MULTI-TASK MACHINES

## BORING BAR HOLDERS

Boring



Order Number	Stock	Dimensions (mm)						* WT (kg)
		DCONMS	BD	DCONWS	LB	CBDP	CRKS	
H100TH-B25-120	●	100	62	25	120	88	M12	3.9
H100TH-B32-135	●	100	72	32	135	102	M12	4.8
H100TH-B40-150	●	100	82	40	150	117	M16	5.9
H100TH-B50-180	●	100	92	50	180	147	M16	7.7

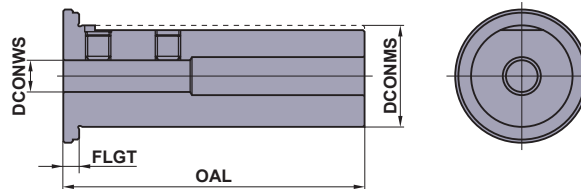
\* WT : Tool Weight

Note 1) Please shorten a boring bar to the required shank length. This holder is for boring bars and indexable type drills.

H

HSK-T TOOLS

## BORING BAR SLEEVES FOR H100TH-B32-135



Order Number	Stock	Dimensions (mm)				* WT (kg)
		DCONWS	DCONMS	OAL	FLGT	
SL3208-90	●	8	32	95	5	0.6
SL3210-90	●	10	32	95	5	0.5
SL3212-90	●	12	32	95	5	0.5
SL3216-90	●	16	32	95	5	0.5
SL3220-90	●	20	32	95	5	0.4

\* WT : Tool Weight

Note 1) These sleeves are only compatible with H100TH-B32-135 holder.

● : Inventory maintained in Japan.

SPARE PARTS > P046  
TECHNICAL DATA > Q001