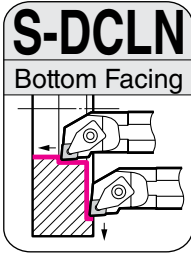
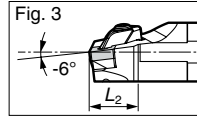
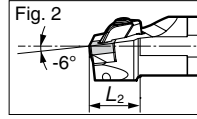
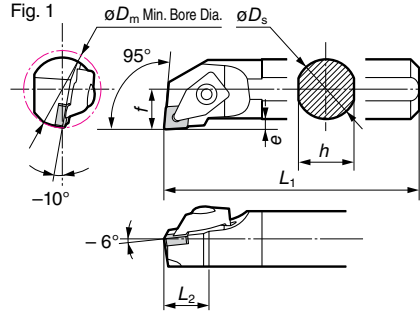


SEC-Boring Bars S-DCLN/D-DCLN Type

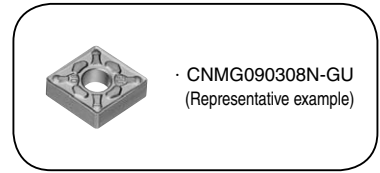
General Boring



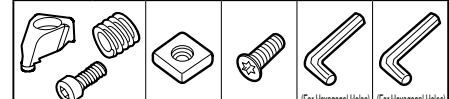
Steel



Insert



Spare Parts

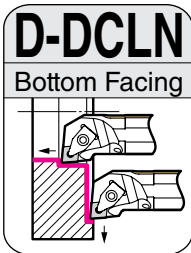


Holder

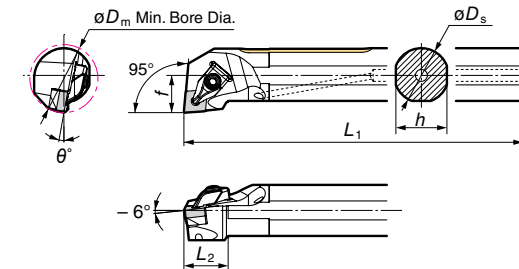
Direction of applicable inserts differs according to work material (*Refer to note at bottom of page E45) Above figures show right hand tools.

Shank	Cat. No.	Conventional Cat. No.	Stock		Dimensions (mm)							Fig.	Applicable Insert Cat. No.	Featured page	Clamp Set	Recommended Tightening Torque (N·m)	Shim	Shim Screw	Wrench for Upper Surface	Wrench for Lower Surface
			R	L	ϕD_m	ϕD_s	h	L_1	f	L_2	e									
Steel	S25R-DCLN R/L0903-32	—	●	●	32	25	23	200	17.0	18	4.5	1	CN □□0903□□	B20	SCP-1	5.0	—	—	LH040	LH025
	S25T-DCLN R/L0903-32	S25T-DCLN R/L09	●	●	32	25	23	300	17.0	18	4.5	1	CN □□0903□□	B20	SCP-1	5.0	—	—	LH040	LH025
	S32S-DCLN R/L1204-40	—	●	●	40	32	30	250	22.0	26	7.0	2	CN □□1204□□	From B21	SCP-2	5.0	CNS1204B	BFTX0409N	LH040	LH025
	S40T-DCLN R/L1204-50	—	●	●	50	40	37	300	27.0	26	8.5	2	CN □□1204□□	From B21	SCP-2	5.0	CNS1204B	BFTX0409N	LH040	LH025
	S50U-DCLN R/L1204-63	—	●	●	63	50	47	350	31.5	36	8.0	3	CN □□1204□□	From B21	SCP-2	5.0	CNS1204B	BFTX0409N	LH040	LH025

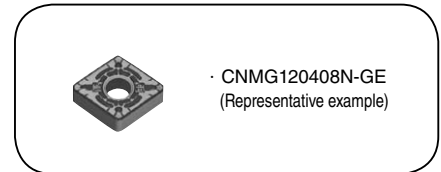
Clamp Set Parts E77



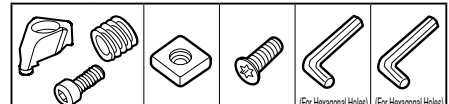
Anti-vibration with oil hole



Insert



Spare Parts



Holder

Right handed toolholders are applicable with left handed or neutral inserts. Left handed toolholders are applicable with right handed or neutral inserts. Above figures show right hand tools.

Shank	Cat. No.	Stock		Dimensions (mm)							Fig.	Applicable Insert Cat. No.	Featured page	Clamp Set	Recommended Tightening Torque (N·m)	Shim	Shim Screw	Wrench for Upper Surface	Wrench for Lower Surface
		R	L	ϕD_m	ϕD_s	h	L_1	f	L_2	θ									
Anti-vibration with oil hole	D25T-DCLN R/L1204-32	●	●	32	25	23	300	17	26	-12	1	CN □□1204□□	From B21	SCP-2	5.0	CNS1203B	BFTX0307N	LH040	LH025
	D32T-DCLN R/L1204-40	●	●	40	32	30	300	22	26	-10	1	CN □□1204□□	From B21	SCP-2	5.0	CNS1204B	BFTX0409N	LH040	LH025
	D40U-DCLN R/L1204-50	●	●	50	40	37	350	27	26	-10	1	CN □□1204□□	From B21	SCP-2	5.0	CNS1204B	BFTX0409N	LH040	LH025

Clamp Set Parts E77

* Applicable Inserts for DCLN and PCLN Types

When machining internal diameters: Right handed toolholders are applicable with left handed or neutral inserts. Left handed toolholders are applicable with right handed or neutral inserts.
When face grooving: Right handed toolholders are applicable with right handed or neutral inserts. Left handed toolholders are applicable with left handed or neutral inserts.

E Boring Bars