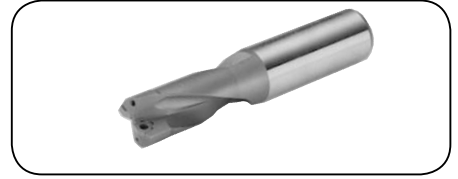
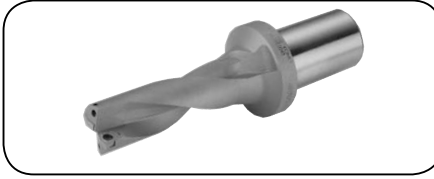
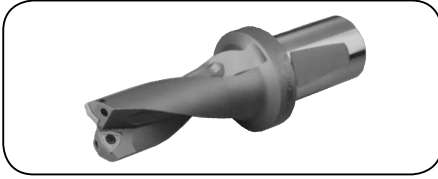


Inserts and Parts for Discontinued Series

Full Cut Drill BKS Type

*Production of this cutter body is on a made-to-order basis only.



Full Cut Drill Inserts only sold in Japan.

■ Inserts (JPW95 Type) Standard, Slim

P Steel **M** Stainless Steel **K** Cast Iron **N** Non-Ferrous Metal **S** Exotic Alloy **H** Hardened Steel

- A (Copper, Exotic Metal)		- B (General Purpose)		- BS (General Purpose - Strong Edge)				
Grade		Coated Carbide		Carbide				
Application	High Speed/Light							
	General Purpose							
	Roughing							
Cat. No.		AC225	AC2000	G10E	Dimensions (mm)			
					Inscribed Circle	Thickness	Nose Radius	
JPW 950504A		▲	▲		5.5	2.3	0.4	
950704A		▲	▲		7.0	3.0		
JPW 950504B		▲	▲	▲	5.5	2.3	0.4	
950704B		▲	▲	▲	7.0	3.0		
JPW 950504BS		▲			5.5	2.3	0.4	
950704BS		▲			7.0	3.0		

■ Inserts (JPW84 Type) Standard

P Steel **M** Stainless Steel **K** Cast Iron **N** Non-Ferrous Metal **S** Exotic Alloy **H** Hardened Steel

- C (General Purpose)		- CS (General Purpose - Strong Edge)						
Grade		Coated Carbide		Carbide				
Application	High Speed/Light							
	General Purpose							
	Roughing							
Cat. No.		AC225	AC2000	G10E	Dimensions (mm)			
					Inscribed Circle	Thickness	Nose Radius	
JPW 840804C		▲	▲	▲	8.0	3.8	0.4	
841004C		▲	▲	▲	10.0	3.8		
841204C		▲	▲	▲	12.0	4.8		
841508C			▲		15.0	5.3		
JPW 840804CS		▲			8.0	3.8	0.4	
841004CS		▲			10.0	3.8		
841204CS		▲			12.0	4.8		
841508CS		▲			15.0	5.3		

■ Spare Parts (Standard)

Insert Seat (External)	Insert Seat (Internal)	Pin	BFT Clamp Screw	BFF Spanner	Recommended Tightening Torque (N·m)	Applicable Holder	
						2D	3D
—	—	—	BFT2045T06	TRX06	0.5	ST20-BKS140-28L to 195-39L	ST20-BKS140-42L to 195-59L
—	—	—	BFT2506T08	TRX08	1.1	ST25-BKS200-40L to 245-49L	ST25-BKS200-60L to 245-74L
—	—	—	BFF2506T08	TRX08	1.1	ST32-BKS250-50L to 290-58L	ST32-BKS250-75L to 290-87L
—	—	—	BFF3505T10	TRX10	2.0	ST40-BKS300-60L to 360-72L	ST40-BKS300-90L to 360-108L
TS3744A	TS3744B	TSP3744	BFF3505T10	TRX10	2.0	ST40-BKS370-74L to 440-88L	ST40-BKS370-111L to 440-132L
TS4554A	TS4554B	TSP4568	BFF4510T15	TRX15	3.4	ST40-BKS450-90L to 540-108L	ST40-BKS450-135L to 540-162L
TS5568A	TS5568B	TSP4568	BFF4510T15	TRX15	3.4	ST40-BKS550-110L to 680-136L	ST40-BKS550-165L to 680-204L

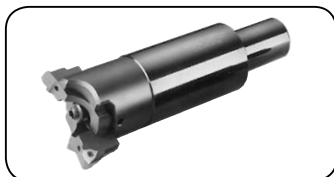
(Note) Pin sold with insert seat as a set.

■ Spare Parts (Slim)

Clamp Screw	Spanner	Recommended Tightening Torque (N·m)	Applicable Holder	
			2D	3D
BFT2045T06	TRX06	0.5	ST20-BKS140-28L to 195-39L	ST20-BKS140-42L to 195-59L
BFT2506T08	TRX08	1.1	ST25-BKS200-40L to 245-74L	ST25-BKS200-60L to 245-74L

Counter Drill VPS Type

*Production of this cutter body is on a made-to-order basis only.



■ Inserts

Inserts are same as those for the Full Cut Drill.

■ Spare Parts (Counter-weight)

Applicable Toolholder Cat. No.	Differential Screw	Radial Adjustment Screw	L Key (DS)	L Key (Radial)	Clamp Screw	Spanner	Recommended Tightening Torque (N·m)
	ST32-VPS051-135	DS41	M4X10L	LH040	LH020	BFT2506T08	
ST40-VPS061-165	DS53	M5X16L	LH050	LH025	BFF2506T08	TRX08	1.1
ST40-VPS075-180	DS68	M5X16L	LH060	LH025	BFF3505T10	TRX10	2.0
ST40-VPS092-180	DS68	M5X16L	LH060	LH025	BFF3505T10	TRX10	2.0
ST50-VPS109-225	DS68	M5X20L	LH060	LH025	BFF3505T10	TRX10	2.0
ST50-VPS129-225	DS68	M5X20L	LH060	LH025	BFF3505T10	TRX10	2.0

▲mark : To be replaced by new item (Please confirm stock availability)

Drilling
Solid
Special
Indexable
Reamer
Brazed
Others