

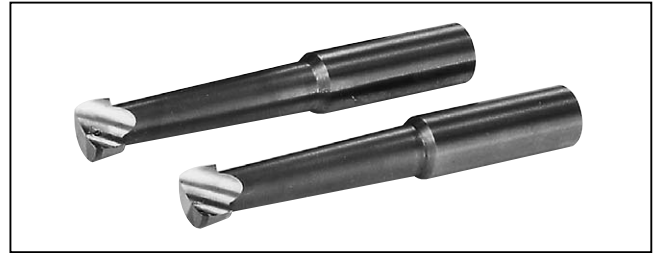
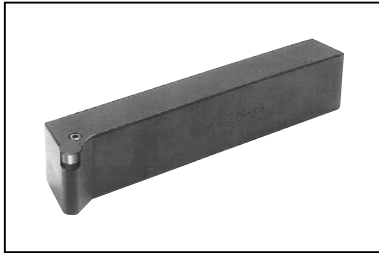
SUMIBORON
Tool Holders with **PR Type** Small Round Inserts

SUMIBORON
JIG Boring Tools **SJB Type**

● **Lever Lock clamping system**

- Easy to use, the lack of protruding clamp mechanism allow for smooth chip flow.

- **Versatile round insert can be applied to various operations.**



■ **Holder**

PRGC Type
External Copying

Cat. No.	Stock		Dimensions (mm)						Applicable Insert	
	R	L	∅d	h	b	L ₁	f	h ₁		L ₂
PRGC R/L3225P9	●	●	9	32	25	170	32	32	18	RCGA 0906M0

PRDC Type
External General Turning

Cat. No.	Stock		Dimensions (mm)						Applicable Insert	
	R	L	∅d	h	b	L ₁	f	h ₁		L ₂
PRDC N 3225P9	●	●	9	32	25	170	12.5	32	25	RCGA 0906M0

PRGN Type
External General Turning

Cat. No.	Stock		Dimensions (mm)						Applicable Insert	
	R	L	∅d	h	b	L ₁	f	h ₁		L ₂
PRGN R/L3225P9	●	●	9	32	25	170	32	32	10	RNGA 0906M0

Inserts are not included.

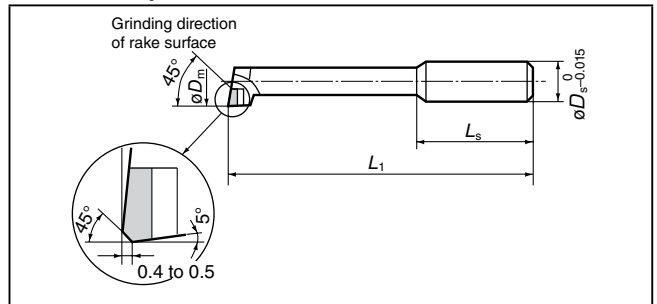
■ **Insert**

Cat. No.	Stock					Fig
	BN2000	BN250	BNX20	BN350	BN7000	
RCGA 0906M0	●	▲				1
RNGA 0906M0	●	▲	●			2

■ **Parts**

Shim	Lever Pin	Bolt	Shim Pin	Wrench	Applicable Insert
LSR817	LCL3S	LCS3	LSP3	LH025	
LSR917					PRGN R/L3225P9

■ **Tool Body**



Cat. No.	Stock	Dimensions (mm)			
	BN250	∅D _s	∅D _m	L ₁	L _s
SJB 0804	●	8	4	45	32
0805	●	8	5	45	32
0806	●	8	6	50	30
0808	●	8	8	60	30
SJB 1006	●	10	6	50	30
1008	●	10	8	60	30
1010	●	10	10	70	30
1012	●	10	12	70	30
1015	●	10	15	70	30

■ **Recommended Cutting Conditions**

Spindle Speed <i>n</i>	above 800min ⁻¹	Low speeds may cause chattering and chipping on the cutting edge.
Depth of cut <i>a_p</i>	0.03 to 0.3 mm/radius	Excessive depth of cut may cause larger tool deformation resulting in deterioration of bore accuracy.
Feed Rate <i>f</i>	0.03 to 0.1mm/rev	—