

SIGE



Internal screw clamp toolholder provides excellent chip evacuation

New insert grades PR20 series provide longer tool life
ø8mm minimum cutting diameter with a 2 edge design
Toolholders for automatic lathes available



NEW PR20 series
For Steel and Stainless steel



**KEEPS YOU
AHEAD**



Internal Grooving

SIGE

Internal screw clamp toolholder provides excellent chip evacuation
Superior chip control with molded chipbreaker

1

New grades PR20 series for general purpose
MEGACOAT NANO EX coating technology provides long tool life

New grades for Grooving and Cut-off

PR20 series

NEW



PR2025 is 1st recommendation for steel and stainless steel

Excellent wear resistance and fracture resistance provides long tool life

Achieve long tool life and high stability with the combination of

High content aluminum nano coating layer

-New coating for grooving launched-

Challenges

Since most of the grooving is continuous machining, the wear progress of the insert is rapid

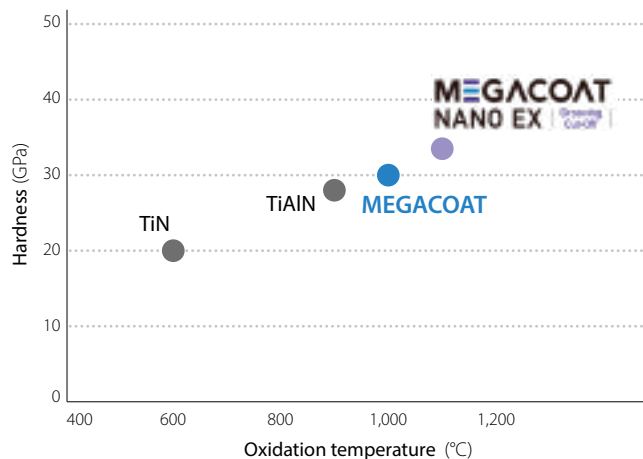
Tool life is shortened due to deterioration of surface finish, machining accuracy, burr, etc

SOLUTION

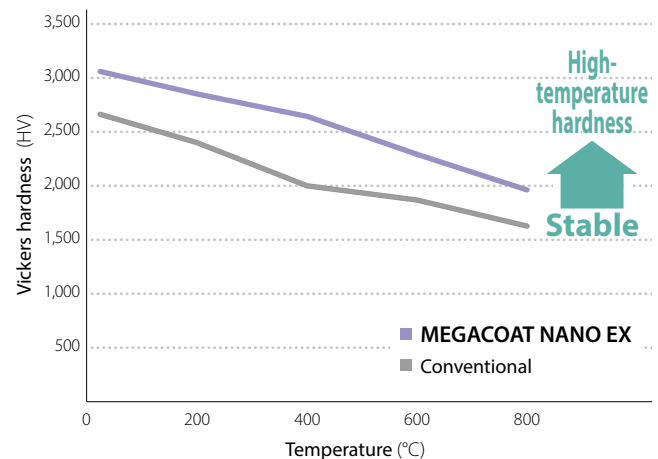
MEGACOAT NANO EX is a special nano coating layer with a high aluminum content developed by Kyocera's unique technology

Solve the machining challenges with excellent wear resistance, high-temperature hardness and plastic deformation resistance

Coating characteristics (Internal evaluation)



Comparison of vickers hardness transition with temperature (Internal evaluation)



Insert cross-section



Special nano coating layer

Long tool life

Excellent wear and fracture resistance

Multi-layering of high content aluminum nano layers added with high melting point material having different concentration. Suppresses hexagonal crystal precipitation and achieves excellent oxidation resistance

Stable machining

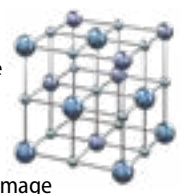
High coating toughness

Crystal grain refinement
Optimized internal stress suppresses crack growth

Unique Technology (Patent applied)

Proprietary coating process improve high content aluminum coating nano layers performance

Maintains a cubic crystal structure to maximize the properties of aluminum (Al)



CG image

2

Internal screw clamp toolholder provides excellent chip evacuation

Large chip pocket on screw clamp toolholder enables excellent chip evacuation

Screw clamp



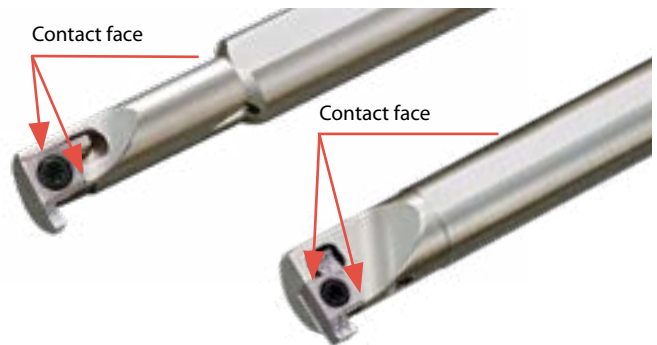
Conventional clamp



3

Reduces chattering with firm insert clamping system

Clamp the insert firmly from the two contact faces

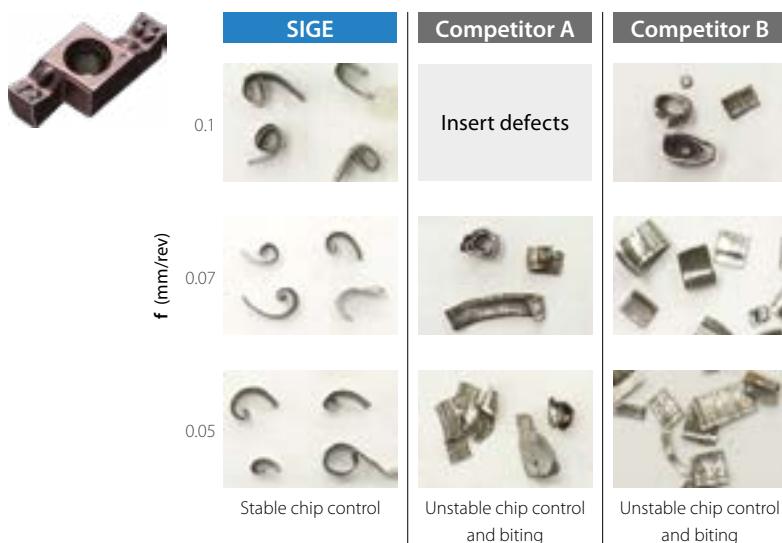


4

Superior chip control with a 2 edge design

Excellent chip evacuation with molded chipbreaker

Chip evacuation comparison (Internal evaluation)



Cutting conditions : $V_c = 100$ m/min, $a_p = 2.0$ mm, Minimum bore dia. $\phi 16$, Wet Workpiece : SCM415
SIGER1612C-EH, GER300-020CM

$\phi 8$ mm minimum cutting diameter

Chip evacuation comparison (Internal evaluation)



Cutting conditions : $V_c = 50$ m/min, $a_p = 1.25$ mm, $f = 0.02$ mm/rev, Minimum bore dia. $\phi 8$, Wet Workpiece : SCM415
SIGER0808A-EH, GER200-010A

5

Variety of toolholders for automatic lathe available

Shank diameter compatible with automatic lathes

Tool overhang length can be shortened by mounting sleeve still near the shank tip

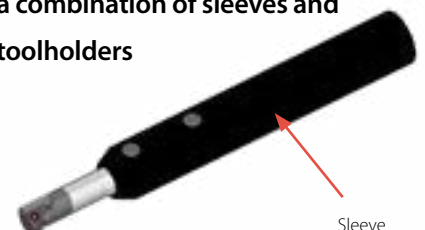
The toolholder is tightly restrained by the sleeve, which suppresses chatter when using automatic lathe

Can be restrained by the sleeve



Applicable sleeve

Overhang length is adjustable with a combination of sleeves and toolholders



NEW

• CDX shows available grooving depth. ● : Availability R : R-hand only available
• Inserts are sold in 10 piece boxes.

Ground chipbreaker : $GE^{R/L...A(R)}$, $GE^{R/L...B(R)}$

*Use PR2025, PR1225, KW10 for turning with edge width 1mm. (GE^R_J 100-005A/100-005B)

Applicable inserts (Molded chipbreaker)

NEW		Classification of usage		P	Carbon steel / Alloy steel											
		M	Stainless steel													
		K	Cast iron													
		N	Non-ferrous metals													
		S	Titanium alloy													
Shape Right-hand shown			Description	Dimensions (mm)							MEGACOAT NANO EX	MEGACOAT	Cermet	Carbide	Applicable toolholders	
				CW	CDX	RE	W1	INSL	S	D1	PR2025	PR1225	TN6020	GW15		KW10
2-edge/Molded chipbreaker 	 GER150-010CM~250-020CM GER250-020CM~350-020CM	GER	150-010CM	1.50	2.5	0.1	5.8	11.48	4.05	2.8	R	R			SIGER...C-EH SIGER...C-WH SIGER...C-WH-90	
			200-010CM	2.00								R	R			
			250-020CM	2.50							0.2	R	R			
			300-020CM	3.00								R	R			
			350-020CM	3.50								R	R			
	 GER150-010DM~200-010DM GER150-010EM~200-010EM GER230-020DM~250-020DM GER250-020EM~400-020EM GER300-020DM~400-020DM GER450-020EM~500-020EM	GER	150-010DM	1.50	3.0	0.1	6.8	16.44	5.05	3.4	R	R			SIGER2020D-EH	
			200-010DM	2.00	3.2						R	R				
			230-020DM	2.30							R	R				
			250-020DM	2.50							R	R				
			300-020DM	3.00	0.2						R	R				
			350-020DM	3.50		R	R									
			400-020DM	4.00		4.5	R	R								
		GER	150-010EM	1.50	3.0	0.1	9.54	21.66	5.55	4.4	R	R			SIGER...E-EH	
			200-010EM	2.00	3.2						R	R				
			250-020EM	2.50	4.5						R	R				
			300-020EM	3.00							R	R				
			350-020EM	3.50							R	R				
			400-020EM	4.00	5.5	R	R									
			450-020EM	4.50		R	R									
			500-020EM	5.00		6.5	R	R								

• CDX shows available grooving depth.
• Inserts are sold in 10 piece boxes.

● : Available R : R-hand only available

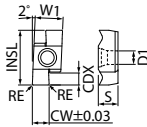
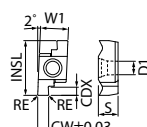
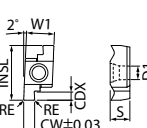
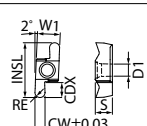
Recommended cutting conditions ★ 1st recommendation ☆ 2nd recommendation

Molded chipbreaker : GER...CM, GER...DM, GER...EM

Workpiece	Recommended insert grades (Vc : m/min)		(1) f for grooving (mm/rev)						Remarks
	MEGACOAT NANO EX 	MEGACOAT	(2) f for turning (mm/rev)						
			(3) ap for turning (mm)						
	PR2025	PR1225	GER 150 ~ 200 - 010CM	GER 250 ~ 350 - 020CM					
GER 150 ~ 200 - 010DM				GER 230 ~ 250 - 020DM	GER 300 ~ 400 - 020DM				
GER 150 ~ 200 - 010EM					GER 250 ~ 300 - 020EM	GER 350 ~ 400 - 020EM	GER 450 ~ 500 - 020EM		
Carbon steel (SxxC etc.)	 60 ~ 160	 60 ~ 160	(1) 0.03 ~ 0.1	(1) 0.03 ~ 0.12	(1) 0.04 ~ 0.12	(1) 0.05 ~ 0.12	(1) 0.05 ~ 0.12	(1) 0.05 ~ 0.12	Wet
			(2) 0.03 ~ 0.1	(2) 0.03 ~ 0.1	(2) 0.04 ~ 0.1	(2) 0.05 ~ 0.1	(2) 0.05 ~ 0.1	(2) 0.05 ~ 0.1	
			(3) Max. 1.0	(3) Max. 1.5	(3) Max. 1.5	(3) Max. 1.5	(3) Max. 1.5	(3) Max. 1.5	
Alloy steel (SCM etc.)	 60 ~ 140	 60 ~ 140	(1) 0.03 ~ 0.1	(1) 0.03 ~ 0.1	(1) 0.04 ~ 0.12	(1) 0.05 ~ 0.12	(1) 0.05 ~ 0.12	(1) 0.05 ~ 0.12	
			(2) 0.03 ~ 0.1	(2) 0.03 ~ 0.1	(2) 0.04 ~ 0.1	(2) 0.05 ~ 0.1	(2) 0.05 ~ 0.1	(2) 0.05 ~ 0.1	
			(3) Max. 1.0	(3) Max. 1.5	(3) Max. 1.5	(3) Max. 1.5	(3) Max. 1.5	(3) Max. 1.5	
Stainless steel (SUS304 etc.)	 60 ~ 110	 60 ~ 110	(1) 0.03 ~ 0.08	(1) 0.03 ~ 0.08	(1) 0.04 ~ 0.08	(1) 0.05 ~ 0.1	(1) 0.05 ~ 0.1	(1) 0.05 ~ 0.1	
			(2) 0.03 ~ 0.1	(2) 0.03 ~ 0.1	(2) 0.04 ~ 0.1	(2) 0.05 ~ 0.1	(2) 0.05 ~ 0.1	(2) 0.05 ~ 0.1	
			(3) Max. 1.0	(3) Max. 1.5	(3) Max. 1.5	(3) Max. 1.5	(3) Max. 1.5	(3) Max. 1.5	

Applicable inserts (Ground chipbreaker)

NEW

Shape Right-hand shown			Classification of usage ● : Light Interruption / 1st Choice ☺ : Light Interruption / 2nd Choice ● : Continuous/1st Choice ○ : Continuous/2nd Choice		P	Carbon steel / Alloy steel						●	☺	○			
					M	Stainless steel						●	☺				
					K	Cast iron									☺		
					N	Non-ferrous metals									●		
					S	Titanium alloy									●		
			Description		Dimensions (mm)							MEGACOAT NANO EX	MEGACOAT	Cermet	Carbide		Applicable toolholders
					CW	CDX	RE	W1	INSL	S	D1	PR2025	PR1225	TN6020	GW15	KW10	
2-edge			GE R/L	100-005C	1.00	2.5	0.05	5.8	11.48	4.05	3.1	●	●	●	●		SIGE R/L...C-EH SIGE R/L...C-WH SIGE R/L...C-WH-90
				120-005C	1.20							●	●	R	R		
				125-005C	1.25							●	●	R	●		
				140-005C	1.40							R	R	R	R		
				145-010C	1.45							●	●		R		
				150-010C	1.50							●	●	R	●		
				170-010C	1.70							R	R		R		
				185-010C	1.85							R	R		R		
				195-010C	1.95							R	R		R		
				200-010C	2.00							●	●	R	●		
				250-020C	2.50							●	●	●	●		
				300-020C	3.00							●	●	●	R		
				350-020C	3.50							●	●		R		
2-edge			GE R/L	100-005D	1.00	2.5	0.05	6.8	16.44	5.05	3.6	●	●	R	●		SIGE R/L2020D-EH
				140-005D	1.40							●	●	R	R		
				145-010D	1.45							●	●	R	R		
				150-010D	1.50							●	●	●	●		
				170-010D	1.70							●	●	R	R		
				185-010D	1.85							R	R		R		
				195-010D	1.95							R	R		R		
				200-010D	2.00							●	●	●	R		
				225-010D	2.25							●	●		R		
				230-020D	2.30							●	●	R	R		
				250-020D	2.50							●	●	●	R		
				280-020D	2.80							R	R		R		
				300-020D	3.00							●	●	●	●		
				330-020D	3.30							R	R		R		
				350-020D	3.50							R	R		R		
				400-020D	4.00							●	●	R	R		
			GE R/L	100-005E	1.00	2.5	0.05	9.54	21.66	5.55	4.6	●	●	R	R		SIGE R/L...E-EH
				150-010E	1.50							●	●	R	●		
				170-010E	1.70							●	●	R	R		
				185-010E	1.85							●	●	R	R		
				195-010E	1.95							●	●		R		
				200-010E	2.00							●	●	R	●		
				225-010E	2.25							R	R	R	R		
				230-020E	2.30							R	R	●	R		
				250-020E	2.50							●	●	●	●		
				275-020E	2.75							R	R		R		
				280-020E	2.80							●	●	R	R		
				300-020E	3.00							●	●	●	●		
				330-020E	3.30							●	●	R	R		
				350-020E	3.50							●	●	●	R		
				400-020E	4.00							●	●	R	●		
				430-020E	4.30							R	R	R	R		
				450-020E	4.50							R	R	R	R		
				460-020E	4.60							R	R		R		
				500-020E	5.00							●	●	R	R		
2-edge/Full-R			GER	200-100CR	2.00	2.5	1.0	5.8	11.48	4.05	3.1	R	R		R	SIGER...C-EH SIGER...C-WH(-...)	
				250-125CR	2.50		1.25					R	R		R		
				300-150CR	3.00		1.5					R	R		R		
			GER	200-100DR	2.00	3.2	1.0	6.8	16.44	5.05	3.6	R	R		R	SIGER2020D-EH	
				300-150DR	3.00	4.5	1.5					R	R		R		

• CDX shows available grooving depth.
• Inserts are sold in 10 piece boxes.

● : Available R : R-hand only available

Recommended cutting conditions ★ 1st recommendation ☆ 2nd recommendation

Ground chipbreaker : GE R/L...C(R), GE R/L...D(R), GE R/L...E

Workpiece	Recommended insert grades (Vc : m/min)				(1) f for grooving (mm/rev)							Remarks
	 MEGACOAT NANO EX	MEGACOAT	Cermet	Carbide	(2) f for turning (mm/rev)							
					(3) ap for turning (mm)							
	PR2025	PR1225	TN6020	GW15	GE ^R /L 100 ~ 200 - 010C 200 - 100CR	GE ^R /L 250 ~ 350 - 020C 250 ~ 300 - 150CR						
GE ^R /L 100 ~ 145 - 010D					GE ^R /L 150 ~ 195 - 010D	GE ^R /L 200 ~ 280 - 020D 200 - 100DR		GE ^R /L 300 ~ 400 - 020D 300 - 150DR				
GE ^R /L 100 - 010E					GE ^R /L 150 ~ 195 - 010E	GE ^R /L 200 ~ 225 - 010E 230 - 020E	GE ^R /L 250 ~ 330 - 020E		GE ^R /L 350 ~ 430 - 020E	GE ^R /L 450 ~ 500 - 020E		
Carbon steel (SxxC etc.)	 60 ~ 140	 60 ~ 140	 120 ~ 180	-	(1) 0.03 ~ 0.08	(1) 0.03 ~ 0.08	(1) 0.04 ~ 0.09	(1) 0.04 ~ 0.09	(1) 0.05 ~ 0.12	(1) 0.05 ~ 0.12	(1) 0.05 ~ 0.12	
					(2) 0.03 ~ 0.08	(2) 0.03 ~ 0.08	(2) 0.04 ~ 0.09	(2) 0.04 ~ 0.09	(2) 0.05 ~ 0.1	(2) 0.05 ~ 0.1	(2) 0.05 ~ 0.1	
					(3) Max. 0.3	(3) Max. 0.3	(3) Max. 0.3	(3) Max. 0.3	(3) Max. 0.5	(3) Max. 0.5	(3) Max. 0.5	
Alloy steel (SCM etc.)	 60 ~ 120	 60 ~ 120	 100 ~ 160	-	(1) 0.03 ~ 0.07	(1) 0.03 ~ 0.07	(1) 0.04 ~ 0.08	(1) 0.04 ~ 0.08	(1) 0.05 ~ 0.1	(1) 0.05 ~ 0.1	(1) 0.05 ~ 0.1	
					(2) 0.03 ~ 0.1	(2) 0.03 ~ 0.1	(2) 0.04 ~ 0.08	(2) 0.04 ~ 0.08	(2) 0.05 ~ 0.1	(2) 0.05 ~ 0.1	(2) 0.05 ~ 0.1	
					(3) Max. 0.3	(3) Max. 0.3	(3) Max. 0.3	(3) Max. 0.3	(3) Max. 0.5	(3) Max. 0.5	(3) Max. 0.5	
Stainless steel (SUS304 etc.)	 60 ~ 110	 60 ~ 110	 70 ~ 130	-	(1) 0.03 ~ 0.07	(1) 0.03 ~ 0.07	(1) 0.04 ~ 0.08	(1) 0.04 ~ 0.08	(1) 0.05 ~ 0.1	(1) 0.05 ~ 0.1	(1) 0.05 ~ 0.1	
					(2) 0.03 ~ 0.1	(2) 0.03 ~ 0.1	(2) 0.04 ~ 0.08	(2) 0.04 ~ 0.08	(2) 0.05 ~ 0.1	(2) 0.05 ~ 0.1	(2) 0.05 ~ 0.1	
					(3) Max. 0.3	(3) Max. 0.3	(3) Max. 0.3	(3) Max. 0.3	(3) Max. 0.5	(3) Max. 0.5	(3) Max. 0.5	
Cast iron (FC, FCD etc.)	-	-	-	 60 ~ 100	(1) 0.03 ~ 0.08	(1) 0.03 ~ 0.08	(1) 0.04 ~ 0.09	(1) 0.04 ~ 0.09	(1) 0.05 ~ 0.12	(1) 0.05 ~ 0.12	(1) 0.05 ~ 0.12	
					(2) 0.03 ~ 0.08	(2) 0.03 ~ 0.08	(2) 0.04 ~ 0.09	(2) 0.04 ~ 0.09	(2) 0.05 ~ 0.1	(2) 0.05 ~ 0.1	(2) 0.05 ~ 0.1	
					(3) Max. 0.3	(3) Max. 0.3	(3) Max. 0.3	(3) Max. 0.3	(3) Max. 0.5	(3) Max. 0.5	(3) Max. 0.5	
Aluminum	-	-	-	 150 ~ 300	(1) 0.05 ~ 0.12	(1) 0.05 ~ 0.12	(1) 0.05 ~ 0.15	(1) 0.05 ~ 0.15	(1) 0.08 ~ 0.15	(1) 0.08 ~ 0.15	(1) 0.08 ~ 0.15	
					(2) 0.05 ~ 0.12	(2) 0.05 ~ 0.12	(2) 0.05 ~ 0.15	(2) 0.05 ~ 0.15	(2) 0.08 ~ 0.15	(2) 0.08 ~ 0.15	(2) 0.08 ~ 0.15	
					(3) Max. 0.5	(3) Max. 0.5	(3) Max. 0.5	(3) Max. 0.5	(3) Max. 0.8	(3) Max. 0.8	(3) Max. 0.8	
Brass	-	-	-	 100 ~ 250	(1) 0.05 ~ 0.12	(1) 0.05 ~ 0.12	(1) 0.05 ~ 0.15	(1) 0.05 ~ 0.15	(1) 0.08 ~ 0.15	(1) 0.08 ~ 0.15	(1) 0.08 ~ 0.15	
					(2) 0.05 ~ 0.12	(2) 0.05 ~ 0.12	(2) 0.05 ~ 0.15	(2) 0.05 ~ 0.15	(2) 0.08 ~ 0.15	(2) 0.08 ~ 0.15	(2) 0.08 ~ 0.15	
					(3) Max. 0.5	(3) Max. 0.5	(3) Max. 0.5	(3) Max. 0.5	(3) Max. 0.8	(3) Max. 0.8	(3) Max. 0.8	

*Use PR2025, PR1225, KW10 for turning with edge width 1mm. (GE R/L100-005A/100-005B)

Lineup

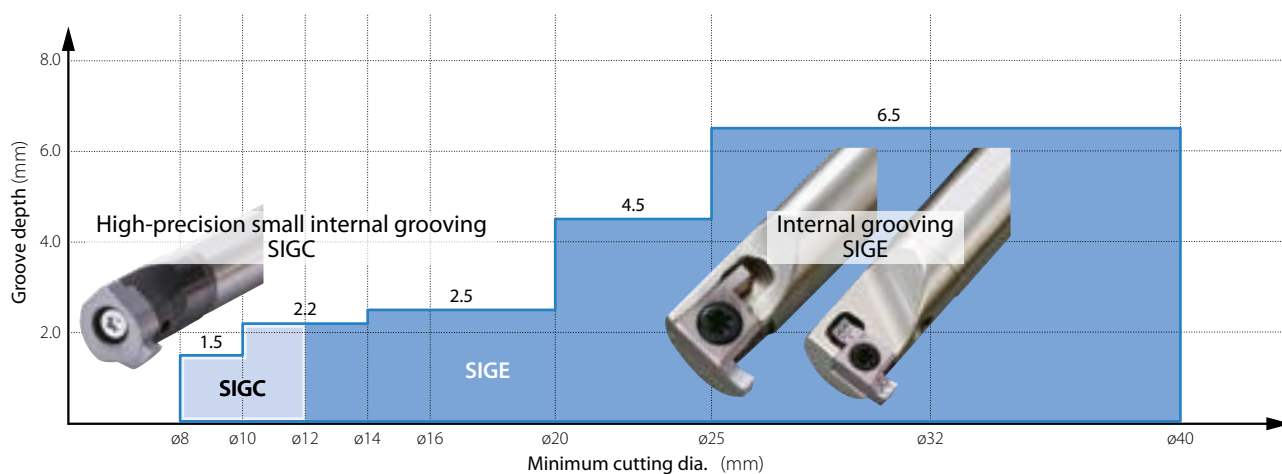
Insert	Shape																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																						
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	Description	GE ^R /...A GER...AR	GE ^R /...B	GER...BR	GER...CM	GER...DM	GER...EM			GE ^R /...C	GER...CR	GE ^R /...D				GER...DR	GE ^R /...E																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																						
	Groove width	1.0 1 2.0	1.0 1 3.0	1.0 1 2.0	1.5 1 3.5	1.5	2.0 1 2.5	3.0 1 4.0	1.5	2.0	2.5 1 3.0	3.5 1 4.0	4.5 1 5.0	1.0 1 3.5	2.0 1 3.0	1.0 1 1.45	1.5 1 1.95	2.0 1 2.8	3.0 1 4.0	2.0	3.0	1.0	1.5 1 1.95	2.0 1 2.3	2.5 1 3.3	3.5 1 4.3	4.5 1 5.0																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																												
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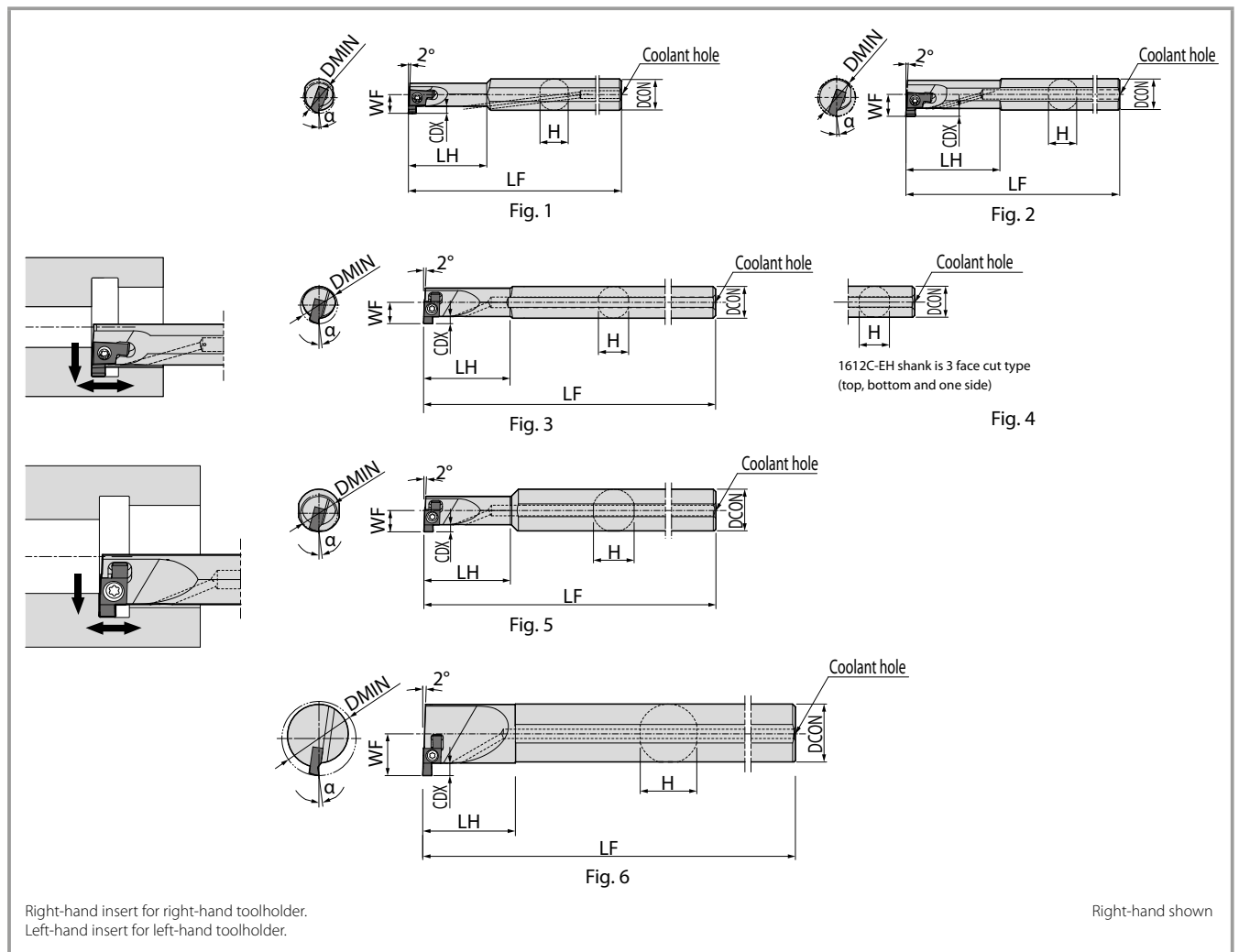
Applicable insert & rake angle (α) after Installement of insert

Description		Ground chipbreaker		α	Molded chipbreaker		α
SIGE [®] / _L	0808A-EH	GE [®] / _L 100-005A GER100-050AR	~ GE [®] / _L 200-010A ~ GER200-100AR	5°	-	-	-
	1010B-EH	GE [®] / _L 100-005B GER100-050BR	~ GE [®] / _L 300-020B ~ GER200-100BR	5°	-	-	-
	1210B-EH						
	1412C-EH						
	1612C-EH	GE [®] / _L 100-005C GER200-100CR	~ GE [®] / _L 350-020C ~ GER300-150CR	8°	GER150-010CM	~ GER350-020CM	10°
	1616C-EH						
	2020D-EH	GE [®] / _L 100-005D GER200-100DR	~ GE [®] / _L 400-020D ~ GER300-150DR	9°	GER150-010DM	~ GER400-020DM	10°
	2525E-EH						
	3232E-EH	GE [®] / _L 100-005E	~ GE [®] / _L 500-020E	10°	GER150-010EM	~ GER500-020EM	10°
	4032E-EH						
SIGE [®] / _L	0808A-WH	GE [®] / _L 100-005A GER100-050AR	~ GE [®] / _L 200-010A ~ GER200-100AR	5°	-	-	-
	1010B-WH						
	1210B-WH	GE [®] / _L 100-005B GER100-050BR	~ GE [®] / _L 300-020B ~ GER200-100BR	5°	-	-	-
	1008B-WH-90						
	1210B-WH-90						
	1412C-WH						
	1612C-WH	GE [®] / _L 100-005C GER200-100CR	~ GE [®] / _L 350-020C ~ GER300-150CR	8°	GER150-010CM	~ GER350-020CM	10°
	1412C-WH-90						

α indicates the rake angle at the center of the edge width after installing insert

Applicable range of internal grooving tool (SIGE and SIGC)





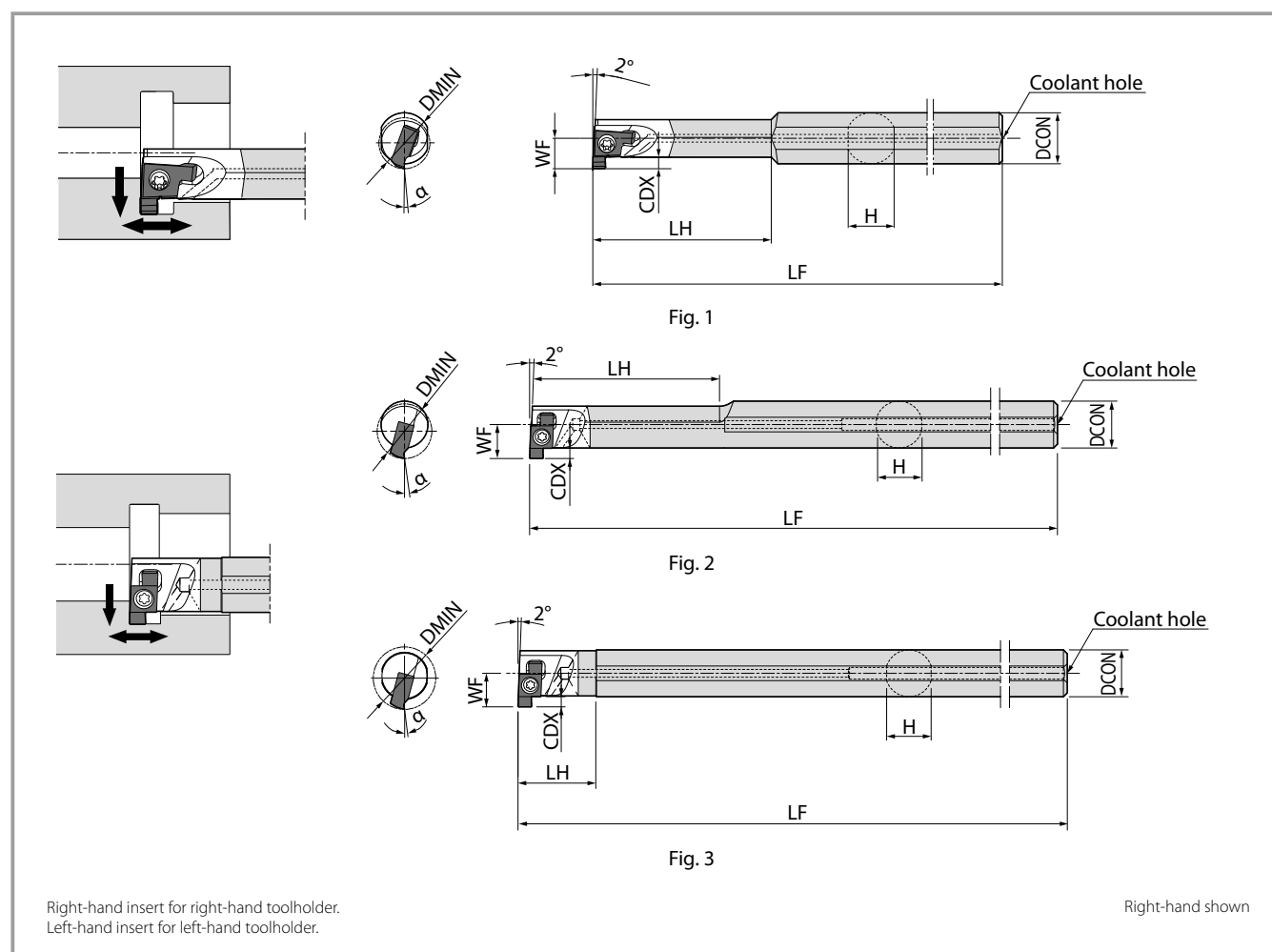
Toolholder dimentions

Description		Availability		Minimum cutting dia. (mm)	Dimensions (mm)						Coolant hole	Shape	Spare parts				Applicable insert	
		R	L		DMIN	DCON	H	LF	LH	WF			CDX	Clamp screw	Wrench			
																		
SIGE®/L	0808A-EH	●	●	8	8	7.2	100	20	4.8	1.5	Yes	Fig. 1	SB-2045TRN	-	-	FT-6	GER/L...A/AR	
SIGE®/L	1010B-EH	●	●	10	10	9	125	25	6.2	2.2	Yes	Fig. 1	SB-2255TR	-	DT-7	-	GER/L...B GER/...BR	
	1210B-EH	●	●	12				30	7			Fig. 2						
SIGE®/L	1412C-EH	●	●	14	12	11.4	150	33	8	2.5	Yes	Fig. 3	SB-2570TR	-	-	FT-8	GER/L...C GER...CM GER...CR	
	1612C-EH	●	●	16				20	8.5			Fig. 4						
	1616C-EH	●	●					16	15			160						36
SIGE®/L	2020D-EH	●	●	20	20	19	180	40	12.1	4.5	Yes	Fig. 5	SB-3080TR	-	-	FT-10	GER/L...D/DM/DR	
SIGE®/L	2525E-EH	●	●	25	25	24	200	45	15.6	6.5	Yes	Fig. 5	SB-4085TR	FT-15	-	-	GER/L...E GER...EM	
	3232E-EH	●	●	32	32	30.4	220	55	19			Fig. 5						
	4032E-EH	●	●	40			250	45	23			Fig. 6						

CDX shows the distance from the toolholder to the cutting edge. Available groove depth: "CDX" of insert

● : Available

SIGE Carbide anti-vibratoin bar (With coolant hole)



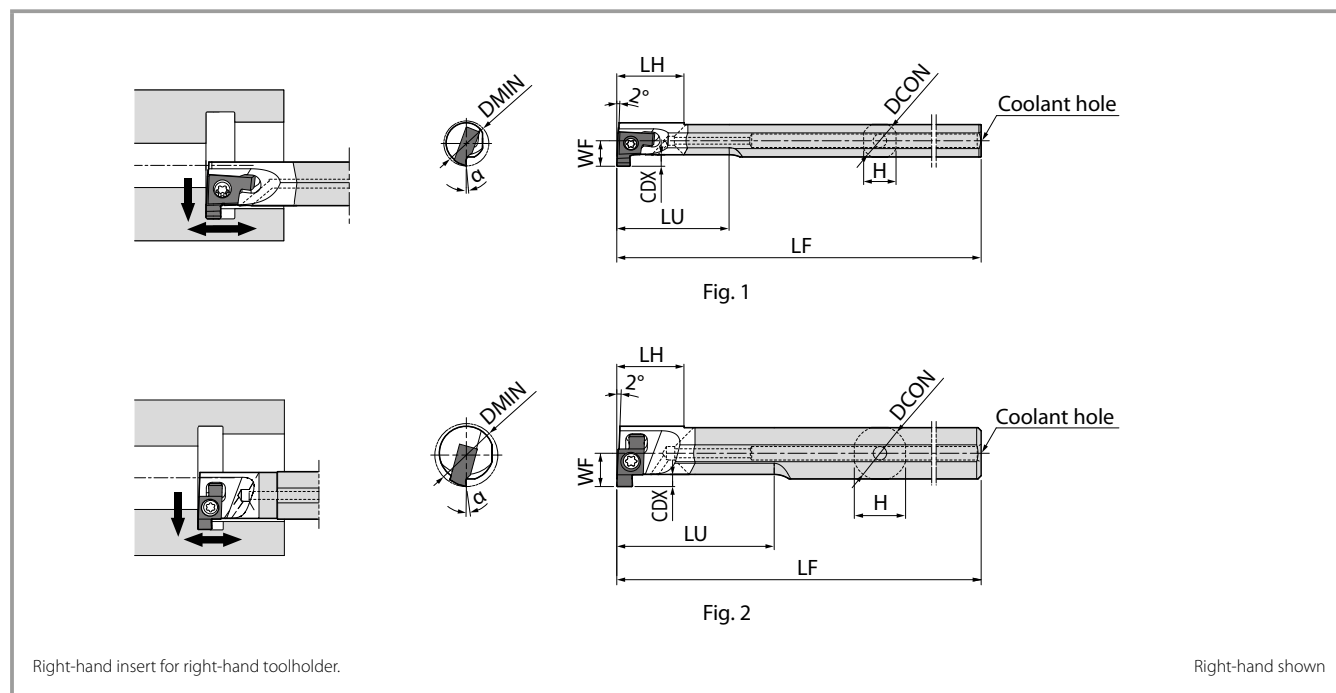
Toolholder dimentions

Description		Availability		Minimum cutting dia. (mm)	Dimensions (mm)						Coolant hole	Shape	Spare parts			Applicable insert	
		R	L		DMIN	DCON	H	LF	LH	WF			CDX	Clamp screw	Wrench		
																	
SIGE [®] / _L	0808A-WH	●	●	8	8	7.2	125	28	4.8	1.5	Yes	Fig. 1	SB-2045TRN	-	FT-6	GER/L...A/AR	
SIGE [®] / _L	1010B-WH	●	●	10	10	9	125	35	6.2	2.2	Yes	Fig. 1	SB-2255TR	DT-7	-	GER/L...B GER/-...BR	
	1210B-WH	●	●	12			140	45	7								
SIGE [®] / _L	1412C-WH	●	●	14	12	11.4	150	50	8.7	2.5	Yes	Fig. 2	SB-2570TR	-	FT-8	GER/L...C GER/-...CM GER/-...CR	
	1612C-WH	●	●	16			180	20	8.5			Fig. 3					

CDX shows the distance from the toolholder to the cutting edge. Available groove depth: "CDX" of insert

●: Available

SIGE Carbide anti-vibratooin bar (With coolant hole • for automatic Lathe)



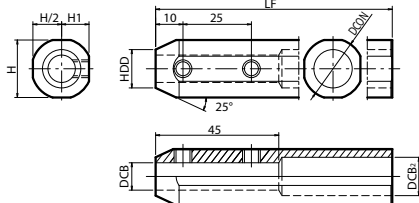
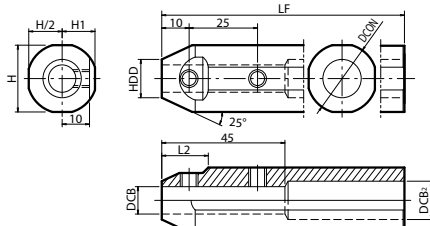
Toolholder dimention See next page for applicable sleeves

Description		Availability	Minimum cutting dia. (mm)	Dimensions (mm)							Coolant hole	Shape	Spare parts		Applicable insert
													Clamp screw	Wrench	
															
SIGER	1008B-WH-90	●	10	8	7.2	90	15	25	5.6	2.2	Yes	Fig. 1	SB-225STR	FT-7	GER...B GER...BR
	1210B-WH-90	●	12	10	9.4			30	6.6						
SIGER	1412C-WH-90	●	14	12	11.4	90	15	35	7.4	2.5	Yes	Fig. 2	SB-2570TR	FT-8	GER/L...C/CM/CR

CDX shows the distance from the toolholder to the cutting edge. Available groove depth: "CDX" of insert
 LH shows mininum overhang length (Distance from the cutting edge to the rear flat cut end position).

● : Available

Applicable sleeve (For automatic lathe)

																	
Toolholder intallation side											Toolholder intallation side						
Fig. 1											Fig. 2						
Description		Availability	Dimensions (mm)								Shape	Spare parts		Applicable machine manufacturer (Random order)			
			DCB	DCON	HDD	DCB2	H	H1	LF	L2		Screw	Wrench				
																	
SHA	0820-120	●	8	20	14	12	19	9.25	120	-	Fig. 1	HS6X4P	LW-3	EGURO TSUGAMI CITIZEN MACHINERY			
	1020-120	●	10														
SHA	0825.0-135	●	8	25	14	14	24	11.5	135	17	Fig. 2						
	1025.0-135	●	10														
	1225.0-135	●	12														
SHA	0819-120	●	8	19.05	14	12	18	8.75	120	-	Fig. 1	HS6X4P LW-3 CITIZEN MACHINERY					
	1019-120	●	10														
SHA	0820-120	●	8	20	14	12	19	9.25	120	-	Fig. 1						
	1020-120	●	10														
SHA	0825.4-120	●	8	25.4	14	14	24.4	12	120	17	Fig. 2						
	1025.4-120	●	10														
	1225.4-120	●	12														
SHA	0822-125	●	8	22	14	14	21	10	125	-	Fig. 1	HS6X4P LW-3 STAR MICRONICS NOMURA DS					
	1022-125	●	10														
	1222-125	●	12														
SHA	0823-120	●	8	23	14	14	22	10.5	120	16	Fig. 2	HS6X4P LW-3 NOMURA DS					
	1023-120	●	10														
	1223-120	●	12														

Length of DCB ... 45mm (all SHA types) ● : Available
Select the sleeve DCB to match the DCON dimension of the toolholder.