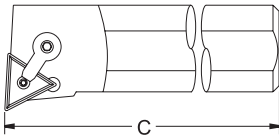


# INTERNAL MACHINING TOOL DESIGNATIONS

**C** - Carbide  
**E** - Carbide w/coolant through  
**A** - Steel w/coolant through  
**M** - Heavy metal  
**S** - Steel

**Bar Type**

<b>F</b> - 3.0	<b>Q</b> - 7.0
<b>G</b> - 3.5	<b>R</b> - 8.0
<b>H</b> - 4.0	<b>S</b> - 10.0
<b>J</b> - 4.5	<b>T</b> - 12.0
<b>K</b> - 5.0	<b>U</b> - 14.0
<b>L</b> - 5.5	<b>V</b> - 16.0
<b>M</b> - 6.0	<b>W</b> - 18.0
<b>N</b> - 6.5	<b>Y</b> - 20.0
<b>P</b> - 6.75	<b>X</b> - Special

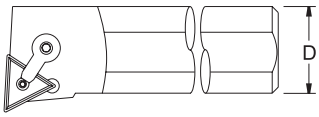


**Bar Length**



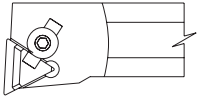
**Bar Diameter**

**Round Shanks:**  
(D) shown in 1/16 inch increments

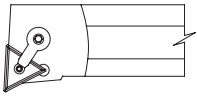


**Holding Method**

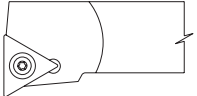
**C** - Clamp Lock



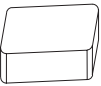
**M** - Multiple Lock




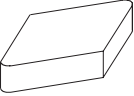
**S** - Screw Lock

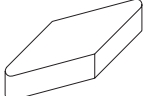


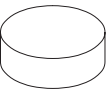
# INTERNAL MACHINING TOOL DESIGNATIONS


**C - 80° Diamond** 

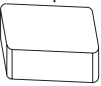
**T - Triangle** 

**D - 55° Diamond** 


**V - 35° Diamond** 

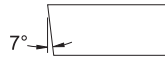
**R - Round** 


**W - 80° Trigon** 

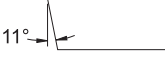
**S - Square** 

**Insert Shape**

**B - 5° Positive** 

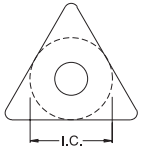
**C - 7° Positive** 

**N - 0° Negative** 

**P - 11° Positive** 

**Insert Clearance Angle**

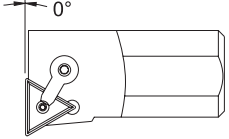
**Insert I.C.:**  
(I.C.) shown in 1/8 inch increments

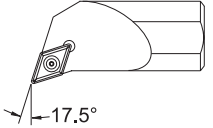


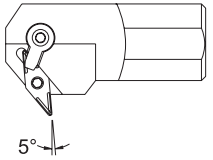
**Insert Size I.C.**

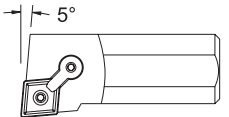
**T U N R - 3**

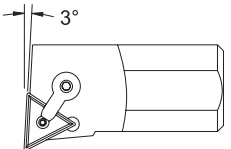
**Bar Style**

**F - Offset Shank**  
0° End Cutting Edge Angle 

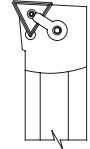
**Q - Offset Shank**  
17.5° End Cutting Edge Angle 

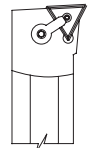
**X - Offset Shank**  
5° Back Cutting Edge Angle 

**L - Offset Shank**  
5° End or Side Cut Edge Angle 

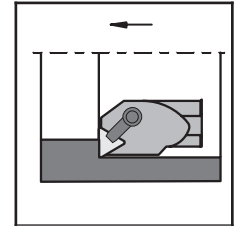
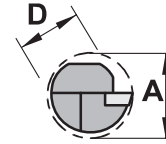
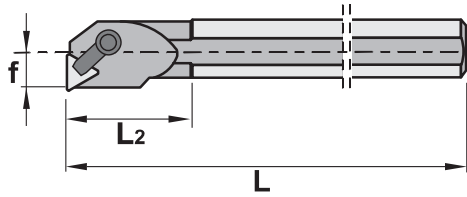
**U - Offset Shank**  
3° End Cutting Edge Angle 

**Hand of Tool**

**R - Right Hand** 

**L - Left Hand** 

# INTERNAL CLAMP LOCK TOOLS



Lead Angle: 0°  
Entering Angle: 90°

DESIGNATION	DIMENSIONS					INSERT (see pages 43-44)	SPARE PARTS			
	Min. Bore A	D	L	L <sub>2</sub>	f		Clamp	Clamp Screw	Shim	Pin
S16T-CTFPR/L-3	1.220	1.000	12.0	2.50	.640	TP_-32_	CL-7	XNS-34	---	---
S20U-CTFPR/L-3	1.600	1.250	14.0	3.00	.765		CL-6	XNS-36	C-3116	C-4002
S24U-CTFPR/L-3	1.840	1.500	14.0	3.00	.890					
S28U-CTFPR/L-3	2.100	1.750	14.0	4.00	1.015					
S24U-CTFPR/L-4	2.120	1.500	14.0	3.00	.890	TP_-43_	CL-20	XNS-48	C-3122	C-4012
S28U-CTFPR/L-4	2.380	1.750	14.0	3.00	1.015					
S32V-CTFPR/L-4	2.620	2.000	16.0	4.00	1.281					
S40V-CTFPR/L-4	3.120	2.500	16.0	4.00	1.531					