

New

Turning Holder

Stable clamping with Double clamp system

Double Clamp Holder

Features

- Simple and powerful clamping system operated by only clamp screw.
- Powerful two ways clamping system (upper and internal) is suitable for machining in very tough cutting conditions.
- When assembled with holder, it can be set precisely due to the special rear of clamp.
- Stable structure design and high quality clamp ensure durability at frequent insert change.
- Compact and optimized design for avoiding chip interference and powerful clamping.

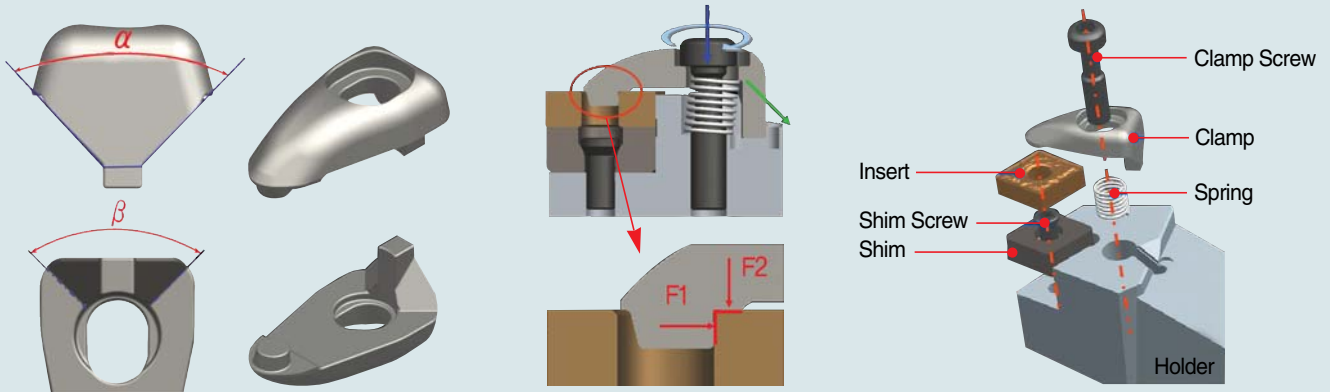




Double Clamp Holder New

Features | Effect

Features



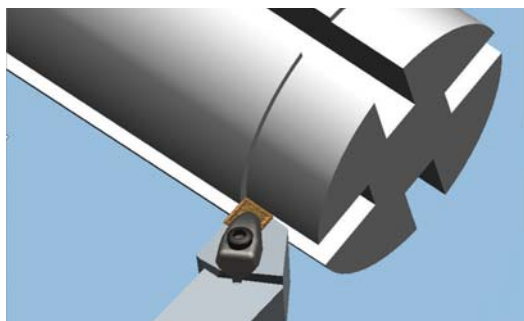
Effect

Stable clamping



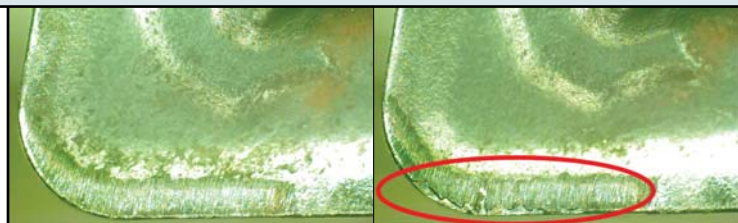
※ Powerful two ways clamping system pushes insert to both bottom and sides tightly.

Improving cutting performance



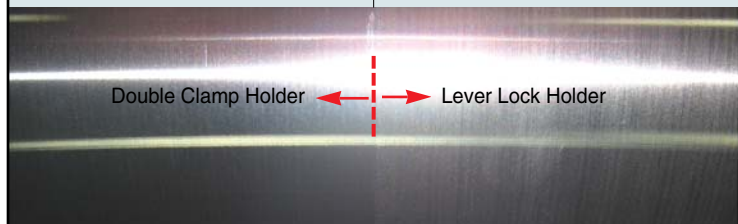
● Cutting condition

- Insert : CNMG432-VM
- Workpiece : 4140(4 grooves)
- Cutting speed : 660sfm
- Depth of cut : 0.08inch
- Feed : 0.006ipr



Double Clamp Holder
35min Cutting

Lever Lock Holder
35min Cutting



Double Clamp Holder ← → Lever Lock Holder

Rmax	Rz	Ra	Rmax	Rz	Ra
4.4s	4.1z	0.6a	5.5s	5.1z	0.7a

※ Ensures stable tool life at interrupted cutting condition due to powerful clamping.

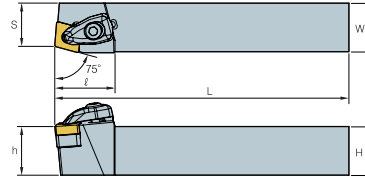
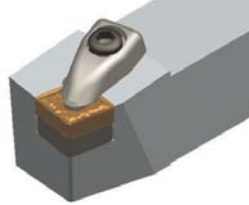
※ Reducing micro vibration shows better surface finish than conventional tools.



Double Clamp Holder New

DCBNR/L | DCLNR/L

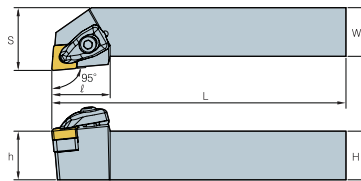
DCBNR/L



Designation	Stock		Dimensions(inch)						Insert
	R	L	H	W	L	S	h	ℓ	
DCBNR/L 12-4B	○	○	0.75	0.75	4.5	0.600	0.75	1.063	CN □□43□□
16-4D	○	○	1.00	1.00	6.0	0.790	1.00	1.063	
85-4D	○	○	1.25	1.00	6.0	0.790	1.25	1.063	
24-8E	○	○	1.50	1.50	7.0	1.186	1.50	1.968	CN □□86□□
24-8E-5	○	○	1.50	1.50	7.0	1.186	1.50	1.968	CN □□85□□

• Only shim can be replaced : 24-8E and 24-8E-5

DCLNR/L



Designation	Stock		Dimensions(inch)						Insert
	R	L	H	W	L	S	h	ℓ	
DCLNR/L 12-4B	○	○	0.75	0.75	4.5	1.00	0.75	1.181	CN □□43□□
16-4D	○	○	1.00	1.00	6.0	1.25	1.00	1.181	
85-4D	○	○	1.25	1.00	6.0	1.25	1.25	1.181	
20-4D	○	○	1.25	1.25	6.0	1.50	1.25	1.181	
24-8E	○	○	1.50	1.50	7.0	2.00	1.50	1.968	CN □□86□□
32-8F	○	○	2.00	2.00	8.0	2.50	2.00	1.968	
24-8E-5	○	○	1.50	1.50	7.0	2.00	1.50	1.968	CN □□85□□
32-8F-5	○	○	2.00	2.00	8.0	2.50	2.00	1.968	

• Only shim can be replaced : 24-8E and 8E-5 / 32-8F and 8F-5

DCBNR/L Parts

Insert	Clamp	Clamp screw	Shim	Shim screw	Spring	Wrench
CNOO43O	CVH4	CHX0518	SC44V	FTKA0410	SPR0714	HW30L
CNOO85O	CVH8	CHX0835	SC84V	FTKA0612	SPR1018	HW50L, TW25L
CNOO86O	CVH8	CHX0835	SC83V	FTKA0612	SPR1018	HW50L, TW25L

DCLNR/L Parts

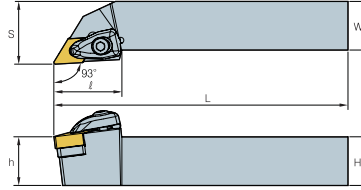
Insert	Clamp	Clamp screw	Shim	Shim screw	Spring	Wrench
CNOO43O	CVH4	CHX0518	SC44V	FTKA0410	SPR0714	HW30L
CNOO85O	CVH8	CHX0835	SC84V	FTKA0612	SPR1018	HW50L, TW25L
CNOO86O	CVH8	CHX0835	SC83V	FTKA0612	SPR1018	HW50L, TW25L



Double Clamp Holder New

DDJNR/L | DSBNR/L

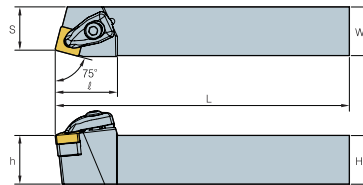
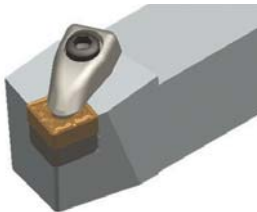
DDJNR/L



Designation	Stock		Dimensions(inch)						Insert
	R	L	H	W	L	S	h	ℓ	
DDJNR/L 12-4B	○	○	0.75	0.75	4.5	1.00	0.75	1.378	DN□□44□
16-4D	○	○	1.00	1.00	6.0	1.25	1.00	1.378	
85-4D	○	○	1.25	1.00	6.0	1.25	1.25	1.378	
20-4D	○	○	1.25	1.25	6.0	1.50	1.25	1.378	
12-4B-3	○	○	0.75	0.75	4.5	1.00	0.75	1.378	DN□□43□
16-4D-3	○	○	1.00	1.00	6.0	1.25	1.00	1.378	
20-4D-3	○	○	1.25	1.25	6.0	1.50	1.25	1.378	

• Only shim can be replaced : 12-4B and 12-4B-3 / 16-4D and 4D-3 / 20-4D and 4D-3

DSBNR/L



Designation	Stock		Dimensions(inch)						Insert
	R	L	H	W	L	S	h	ℓ	
DSBNR/L 12-4B	○	○	0.75	0.75	4.5	0.600	0.75	1.260	SN□□43□
16-4D	○	○	1.00	1.00	6.0	0.790	1.00	1.260	
85-4D	○	○	1.25	1.00	6.0	0.790	1.25	1.260	
20-4D	○	○	1.25	1.25	6.0	0.990	1.25	1.260	
24-8E	○	○	1.50	1.50	7.0	1.186	1.50	2.008	SN□□85□
32-8F	○	○	2.00	2.00	8.0	1.382	2.00	2.008	
24-8E-6	○	○	1.50	1.50	7.0	1.186	1.50	2.008	SN□□86□
32-8F-6	○	○	2.00	2.00	8.0	1.382	2.00	2.008	

• Only shim can be replaced : 24-8E and 8E-6 / 32-8F and 8F-6

■ DDJNR/L Parts

Insert	Clamp	Clamp screw	Shim	Shim screw	Spring	Wrench
DNOO430	CVH4	CHX0518	SD44V	FTKA0410	SPR0714	HW30L
DNOO440	CVH4	CHX0518	SD43V	FTKA0410	SPR0714	HW30L

■ DSBNR/L Parts

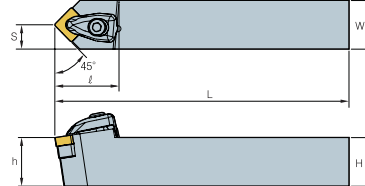
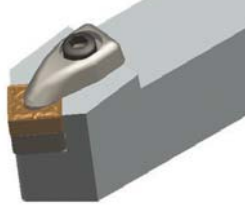
Insert	Clamp	Clamp screw	Shim	Shim screw	Spring	Wrench
SNOO430	CVH4	CHX0518	SS44V	FTKA0410	SPR0714	HW30L
SNOO850	CVH8	CHX0835	SS84V	FTKA0612	SPR1018	HW50L, TW25L
SNOO860	CVH8	CHX0835	SS83V	FTKA0612	SPR1018	HW50L, TW25L



Double Clamp Holder New

DSDNN | DSKNR/L

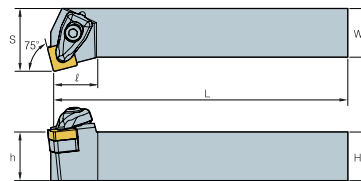
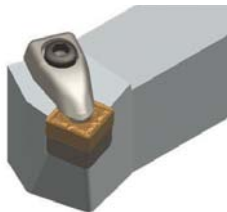
DSDNN



Designation	Stock	Dimensions(inch)						Insert
		H	W	L	S	h	ℓ	
DSDNN 12-4B	○	0.75	0.75	4.5	0.375	0.75	1.299	SN □□43 □
16-4D	○	1.00	1.00	6.0	0.500	1.00	1.299	
85-4D	○	1.25	1.00	6.0	0.500	1.00	1.299	
20-4D	○	1.25	1.25	6.0	0.625	1.25	1.299	
24-8E	○	1.50	1.50	7.0	0.750	1.50	2.087	SN □□85 □
32-8F	○	2.00	2.00	8.0	1.000	2.00	2.087	
24-8E-6	○	1.50	1.50	7.0	0.750	1.50	2.087	SN □□86 □
32-8F-6	○	2.00	2.00	8.0	1.000	2.00	2.087	

• Only shim can be replaced : 24-8E and 8E-6 / 32-8F and 8F-6

DSKNR/L



Designation	Stock		Dimensions(inch)						Insert
	R	L	H	W	L	S	h	ℓ	
DSKNR/L 12-4B	○	○	0.75	0.75	4.5	1.00	0.75	0.906	SN □□43 □
16-4D	○	○	1.00	1.00	6.0	1.25	1.00	0.906	
20-4D	○	○	1.25	1.25	6.0	1.50	1.25	0.906	
24-8E	○	○	1.50	1.50	7.0	2.00	1.50	1.772	SN □□85 □
24-8E-6	○	○	1.50	1.50	7.0	2.00	1.50	1.772	SN □□86 □

• Only shim can be replaced : 24-8E and 2408E-5

■ DSDNN Parts

Insert	Clamp	Clamp screw	Shim	Shim screw	Spring	Wrench
SN00430	CVH4	CHX0518	SS44V	FTKA0410	SPR0714	HW30L
SN00850	CVH8	CHX0835	SS84V	FTKA0612	SPR1018	HW50L, TW25L
SN00860	CVH8	CHX0835	SS83V	FTKA0612	SPR1018	HW50L, TW25L

■ DSKNR/L Parts

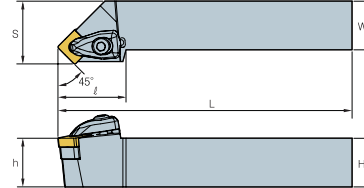
Insert	Clamp	Clamp screw	Shim	Shim screw	Spring	Wrench
SN00430	CVH4	CHX0518	SS44V	FTKA0410	SPR0714	HW30L
SN00850	CVH8	CHX0835	SS84V	FTKA0612	SPR1018	HW50L, TW25L
SN00860	CVH8	CHX0835	SS83V	FTKA0612	SPR1018	HW50L, TW25L



Double Clamp Holder New

DSSNR/L | DWLNR/L

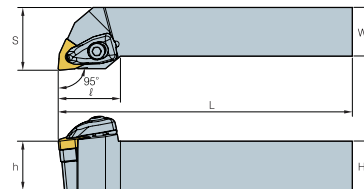
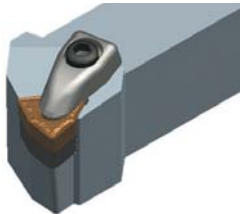
DSSNR/L



Designation	Stock		Dimensions(inch)						Insert
	R	L	H	W	L	S	h	ℓ	
DSSNR/L 12-4B	○	○	0.75	0.75	4.5	1.00	0.75	1.378	SN □ □ 43 □
16-4D	○	○	1.00	1.00	6.0	1.25	1.00	1.378	
85-4D	○	○	1.25	1.00	6.0	1.25	1.25	1.378	
20-4D	○	○	1.25	1.25	6.0	1.50	1.25	1.378	
24-8E	○	○	1.50	1.50	7.0	2.00	1.50	2.087	SN □ □ 85 □
24-8E-6	○	○	1.50	1.50	7.0	2.00	1.50	2.087	SN □ □ 86 □

• Only shim can be replaced : 24-8E and 8E-6

DWLNR/L



Designation	Stock		Dimensions(inch)						Insert
	R	L	H	W	L	S	h	ℓ	
DWLNR/L 12-4B	○	○	0.75	0.75	4.5	1.00	0.75	1.26	WN □ □ 43 □
16-4D	○	○	1.00	1.00	6.0	1.25	1.00	1.26	

DSSNR/L Parts

Insert	Clamp	Clamp screw	Shim	Shim screw	Spring	Wrench
SNOO430	CVH4	CHX0518	SS44V	FTKA0410	SPR0714	HW30L
SNOO850	CVH8	CHX0835	SS84V	FTKA0612	SPR1018	HW50L, TW25L
SNOO860	CVH8	CHX0835	SS83V	FTKA0612	SPR1018	HW50L, TW25L

DWLNR/L Parts

Insert	Clamp	Clamp screw	Shim	Shim screw	Spring	Wrench
WNOO430	CVH4	CHX0518	SS44V	FTKA0410	SPR0714	HW30L



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