

LIVETOOLS®

MACHINE TOOL PEOPLE

DAMPING TURNING TOOLS

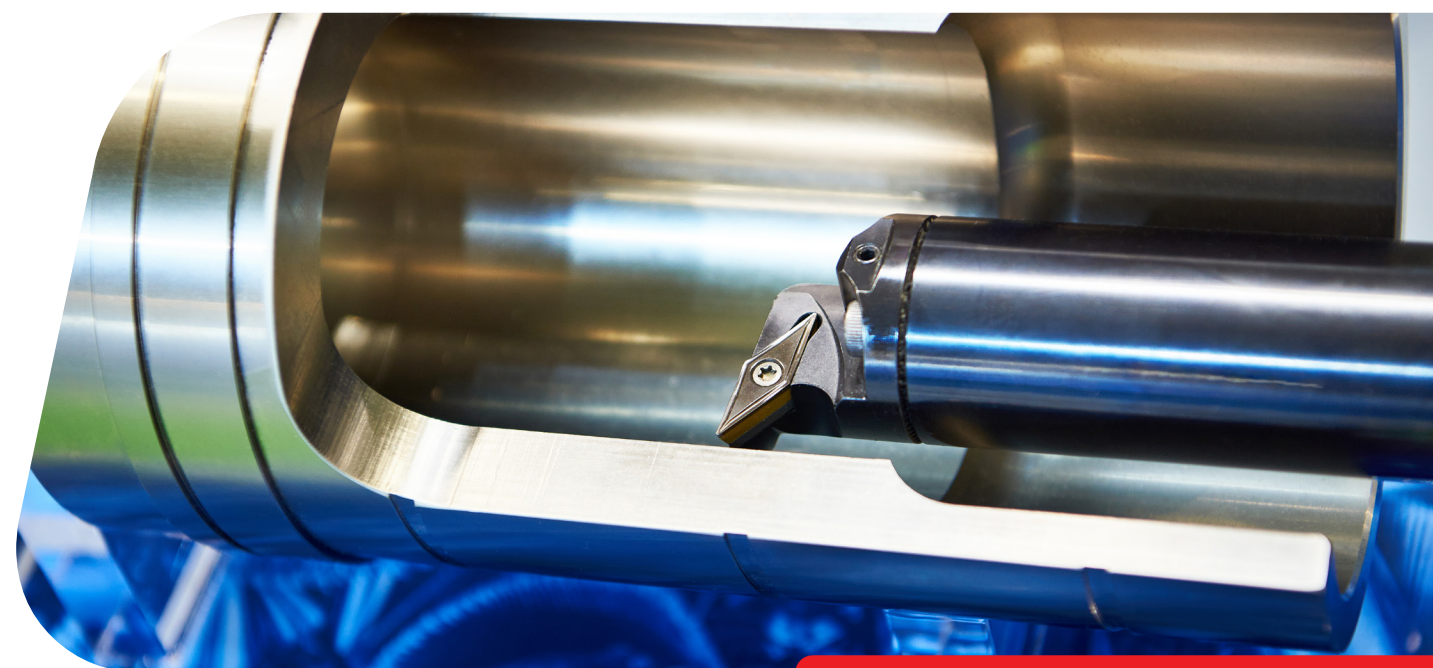
**PRODUCT
CATALOGUE**



**STEADY
BORE**

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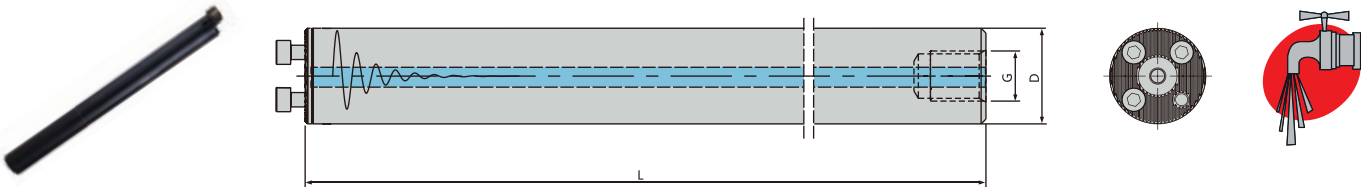




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DAMPING TURNING TOOL HOLDER



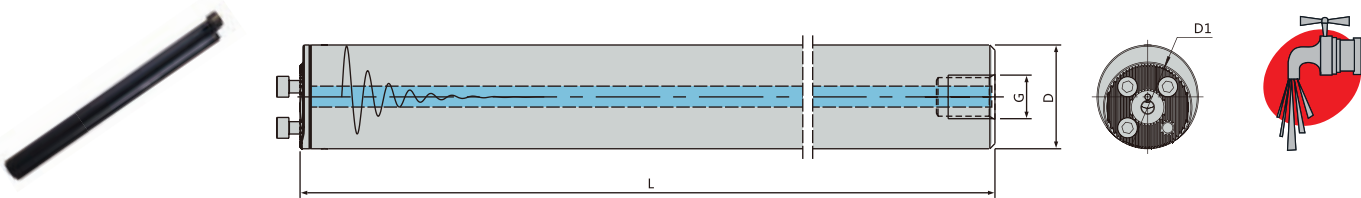
DESIGNATION	D	L	G	L/D	KG	CARTRIDGE	STOCK
VT16 C16X156V	16	156	G1/8"	7	0.2	VT16..	●
VT16 C16X204VE	16	204	-	10	0.5	VT16..	●
VT20 C20X200V	20	200	G1/4"	7	0.4	VT20..	●
VT20 C20X260VE	20	260	-	10	0.8	VT20..	●
VT25 C25X255V	25	255	G1/4"	7	1.0	VT25..	●
VT25 C25X330V	25	330	G1/4"	10	1.3	VT25..	●
VT25 C25X380VE	25	380	G1/8"	12	2.0	VT25..	○
VT25 C25X430VE	25	430	G1/8"	14	2.6	VT25..	○
VT32 C32X320V	32	320	G3/8"	7	2.1	VT32..	●
VT32 C32X416V	32	416	G3/8"	10	2.8	VT32..	●
VT32 C32X480VE	32	480	G1/4"	12	4.2	VT32..	○
VT32 C32X544VE	32	544	G1/4"	14	4.8	VT32..	○
VT40 C40X408V	40	408	G1/2"	7	4.6	VT40..	●
VT40 C40X528V	40	528	G1/2"	10	5.3	VT40..	●
VT40 C40X608VE	40	608	G3/8"	12	8.3	VT40..	○
VT40 C40X688VE	40	688	G3/8"	14	9.4	VT40..	○

- Suggested min. Length is 4xD.
- With coolant hole.
- The reducing head should be ordered separately.
- Suggest doing the maintenance when damping capacity is weaker than before.

SPARE PARTS

D	CLAMP SCREW FOR CARTRIDGE	ALLEN KEY FOR CARTRIDGE CLAMPING SCREW
16	SR55-2 M3X10	KEY01 M2.5
20	SR55-2 M3.5X10	KEY01 M2.5
25	SR55-2 M4X12	KEY01 M3
32	SR55-2 M5X12	KEY01 M4
40	SR55-2 M6X16	KEY01 M5

DAMPING TURNING TOOL HOLDER



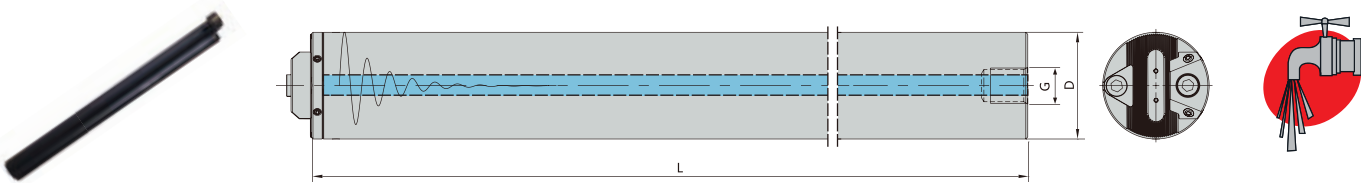
DESIGNATION	D	D1	L	G	L/D	DMIN	KG	CARTRIDGE	STOCK
VT40 C50X518V	50	40	518	G1/2"	7	60	7.2	VT40..	●
VT40 C50X668V	50	40	668	G1/2"	10	60	9.3	VT40..	●
VT40 C50X768VE	50	40	768	G1/2"	12	60	14.4	VT40..	○
VT40 C50X868VE	50	40	868	G1/2"	14	60	16.6	VT40..	○
VT40 C60X628V	60	40	628	G3/4"	7	70	12.5	VT40..	●
VT40 C60X808V	60	40	808	G3/4"	10	70	16.3	VT40..	●
VT40 C60X920VE	60	40	920	G3/4"	12	70	27.1	VT40..	○
VT40 C60X1040VE	60	40	1040	G3/4"	14	70	30.9	VT40..	○

- Suggested min. Length is 4xD.
- With coolant hole.
- The cartridge should be ordered separately.
- Suggest doing the maintenance when damping capacity is weaker than before.

SPARE PARTS

D1	CLAMP SCREW FOR CARTRIDGE	ALLEN KEY FOR CARTRIDGE CLAMPING SCREW
40	SR55-2 M6X16	KEY01 M5

DAMPING TURNING TOOL HOLDER



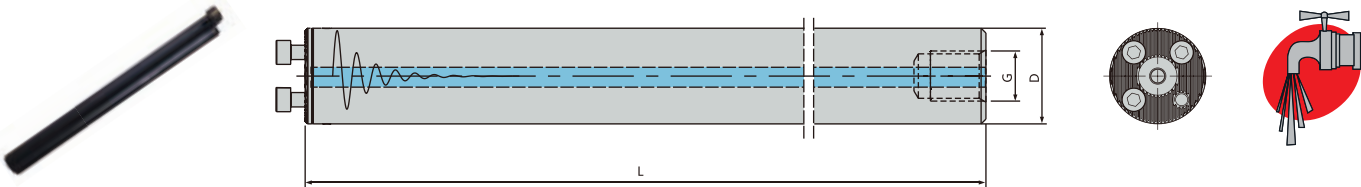
DESIGNATION	D	L	G	L/D	KG	CARTRIDGE	STOCK
VH80 C80X880V	80	880	G3/4"	7	31.8	VH80..	●
VH80 C80X1200V	80	1200	G3/4"	10	52.3	VH80..	●
VH80 C80X1240VE	80	1240	G3/4"	12	60	VH80..	○
VH80 C80X1400VE	80	1400	G3/4"	14	70	VH80..	○

- Suggested min. Length is 4xD.
- With coolant hole.
- The cartridge should be ordered separately.
- Suggest to do the maintenance when damping capacity is weaker than before.

SPARE PARTS

D1	CLAMP SCREW FOR INSERT	ALLEN KEY FOR CLAMPING	UPPER CLAMPING PAD	LOWER CLAMPING PAD	SPRING CLAMPING PAD	CLAMP SCREW FOR CARTRIDGE
40	SR55-2 M6X16	KEY01 M8	PB20 M10X16.0	PB20 M10X11	YH 12.5X0.9X18	SR55 M3X6

DAMPING TURNING TOOL HOLDER



DESIGNATION	D	L	G	L/D	KG	CARTRIDGE	STOCK
VT32 C32X256V.P	32	256	G3/8"	5	1.58	VT32..	●
VT40 C40X328V.P	40	328	G1/2"	5	3.01	VT40..	●
VT40 C50X418V.P	50	415	G1/2"	5	8.92	VT40..	●
VT40 C60X508V.P	60	508	G3/8"	5	10.48	VT40..	●

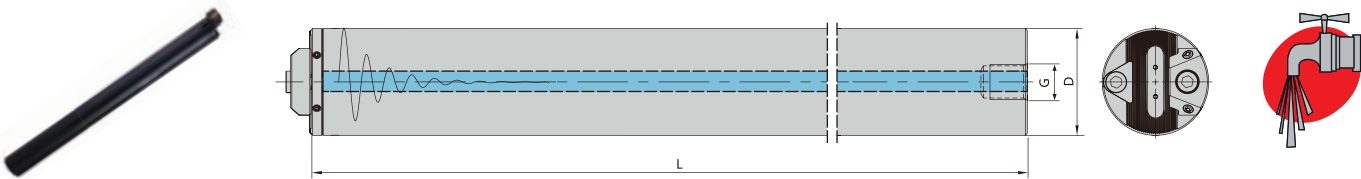
- Suggested min. Length is 4xD.
- With coolant hole.
- Suggest doing the maintenance when damping capacity is weaker than before.

SPARE PARTS



D	CLAMP SCREW FOR CARTRIDGE	ALLEN KEY FOR CARTRIDGE CLAMPING SCREW
32	SR55-2 M5X12	KEY01 M4
40/50/60	SR55-2 M6X16	KEY01 M4

DAMPING TURNING TOOL HOLDER



DESIGNATION	D	L	G	L/D	KG	CARTRIDGE	STOCK
VH80 C80X720V.P	80	720	G3/4"	5	27.05	VT80..	●

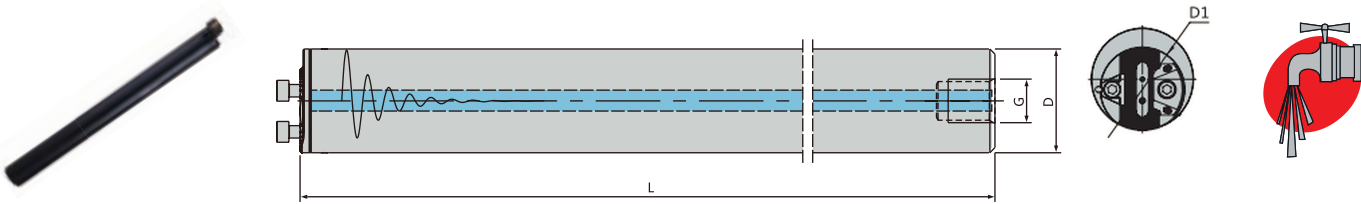
- Suggested min. Length is 4xD.
- With coolant hole.
- Suggest to do the maintenance when damping capacity is weaker than before.

SPARE PARTS



D1	CLAMP SCREW FOR INSERT	ALLEN KEY FOR CLAMPING	UPPER CLAMPING PAD	LOWER CLAMPING PAD	SPRING CLAMPING PAD	CLAMP SCREW FOR CARTRIDGE
40	SR55 M10X25	KEY01 M8	PB20 M10X16.0	PB20 M10X11	YH 12.5X0.9X18	SR55 M3X6

DAMPING TURNING TOOL HOLDER



DESIGNATION	D	D1	L	G	L/D	KG	CARTRIDGE	STOCK
VH80 C100X1100V	100	80	1100	G3/4"	7	63.4	VH80..	○
VH80 C100X1500V	100	80	1500	G3/4"	10	86.8	VH80..	○
VH80 C120X1900V.R/L	120	80	1900	G3/4"	10	134	VH80..	○
VH80 C130X2000V.R/L	130	80	2000	G3/4"	10	192.3	VH80..	○
VH80 C140X2200V.R/L	140	80	2200	G3/4"	10	241.5	VH80..	○
VH80 C150X2400V.R/L	150	80	2400	G3/4"	10	252.6	VH80..	○
VH80 C160X2600V.R/L	160	80	2600	G3/4"	10	339.3	VH80..	○
VH80 C180X2800V.R/L	180	80	2800	G3/4"	10	458.2	VH80..	○
VH80 C200X3200V.R/L	200	80	3200	G3/4"	10	657.7	VH80..	○
VH80 C220X3450V.R/L	220	80	3450	G1"	10	1059.3	VH80..	○
VH80 C250X4000V.R/L	250	80	4000	G1"	10	1229	VH80..	○

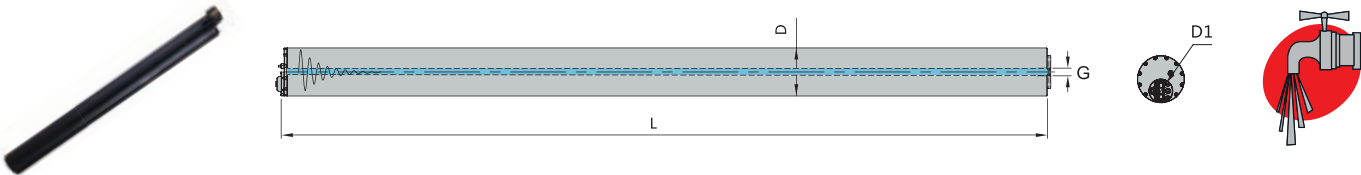
- Suggested min. Length is 4xD.
- With coolant hole.
- The cartridge should be ordered separately.
- Suggest doing the maintenance when damping capacity is weaker than before.

SPARE PARTS



D1	CLAMP SCREW FOR INSERT	ALLEN KEY FOR CLAMPING	UPPER CLAMPING PAD	LOWER CLAMPING PAD	SPRING CLAMPING PAD	CLAMP SCREW FOR CARTRIDGE
40	SR55 M10X25	KEY01 M8	PB20 M10X16.0	PB20 M10X11	YH 12.5X0.9X18	SR55 M3X6

DAMPING TURNING TOOL HOLDER



DESIGNATION	D	D1	L	G	L/D	KG	CARTRIDGE	STOCK
VH80 C100X1560VE	100	80	1560	G3/4"	12	117.6	VH80	○
VH80 C100X1760VE	100	80	1760	G3/4"	14	133.3	VH80..	○
VH80 C120X1870VE.R/L	120	80	1870	G3/4"	12	215.7	VH80..	○
VH80 C120X2110VE.R/L	120	80	2110	G3/4"	14	248.6	VH80.	○
VH80 C130X2030VE.R/L	130	80	2030	G3/4"	12	271.4	VH80..	○
VH80 C130X2290VE.R/L	130	80	2290	G3/4"	14	312.3	VH80..	○
VH80 C140X2190VE.R/L	140	80	2190	G3/4"	12	336.7	VH80..	○
VH80 C140X2470VE.R/L	140	80	2470	G3/4"	14	386.8	VH80..	○
VH80 C150X2350VE.R/L	150	80	2350	G3/4"	12	397.2	VH80..	○
VH80 C150X2650VE.R/L	150	80	2650	G3/4"	14	472.4	VH80..	○
VH80 C160X2510VE.R/L	160	80	2510	G3/4"	12	497.5	VH80..	○
VH80 C160X2830VE.R/L	160	80	2830	G3/4"	14	571.2	VH80..	○
VH80 C180X2830VE.R/L	180	80	2830	G3/4"	12	559.7	VH80..	○
VH80 C180X3190VE.R/L	180	80	3190	G3/4"	14	642.6	VH80..	○
VH80 C200X3150VE.R/L	200	80	3150	G3/4"	12	621.9	VH80	○
VH80 C200X3550VE.R/L	200	80	3550	G3/4"	14	714.3	VH80..	○
VH80 C220X3470VE.R/L	220	80	3470	G3/4"	12	684.1	VH80..	○
VH80 C220X3910VE.R/L	220	80	3910	G3/4"	14	785.7	VH80..	○
VH80 C250X3950VE.R/L	250	80	3950	G3/4"	12	777.4	VH80..	○
VH80 C250X4450VE.R/L	250	80	4450	G3/4"	14	892.8	VH80..	○

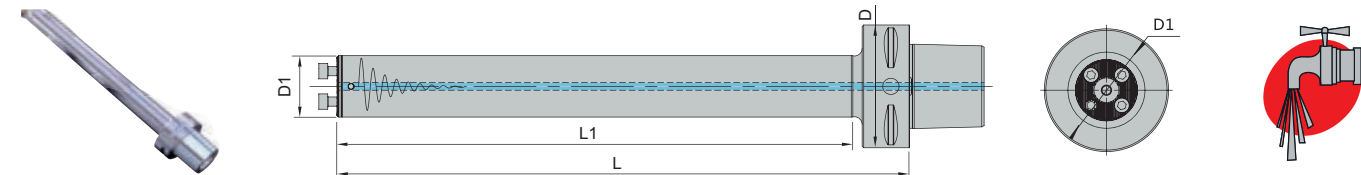
- Suggested min. Length is 4xD.
- With coolant hole.
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SPARE PARTS



D1	CLAMP SCREW FOR INSERT	ALLEN KEY FOR CLAMPING	UPPER CLAMPING PAD	LOWER CLAMPING PAD	SPRING CLAMPING PAD	CLAMP SCREW FOR CARTRIDGE
40	SR55 M10X25	KEY01 M8	PB20 M10X16.0	PB20 M10X11	YH 12.5X0.9X18	SR55 M3X6

DAMPING TURNING TOOL HOLDER



DESIGNATION	D	D1	L	G	L/D	KG	CARTRIDGE	STOCK
C3 AT16X082V	32	16	82	63	5	0.25	VT16	○
C3 AT20X101V	32	20	101	82	5	0.39	VT20	○
C3 AT25X125V	32	25	125	107	5	0.6	VT25	○
C3 AT25X180V	32	25	180	161	7	0.8	VT25	○
C3 AT32X133V	32	32	133	133	5	1	VT32	○
C3 AT32X224V	32	32	224	224	8	1.8	VT32	○
C4 AT16X088V	40	16	88	63	5	0.4	VT16	○
C4 AT20X107V	40	20	107	82	5	0.54	VT20	○
C4 AT25X132V	40	25	132	108	5	0.8	VT25	○
C4 AT25X180V	40	25	180	155	7	0.96	VT25	○
C4 AT32X154V	40	32	154	131	5	1.29	VT32	○
C4 AT32X224V	40	32	224	200	7	2.08	VT32	○
C4 AT40X173V	40	40	173	173	5	1.75	VT40...	○
C4 AT40X288V	40	40	288	288	8	3.42	VT40	○
C5 AT16X085V	50	16	85.	58	5	0.63	VT16	○
C5 AT20X109V	50	20	109	83	5	0.74	VT20..	○
C5 AT25X133V	50	25	133	107	5	1	VT25	○
CS AT25X230V	50	25	230	201	7	1.4	VT25	○
C5 AT32X154V	50	32	154	129	5	1.4	VT32.	○
C5 AT32X288V	50	32	288	261	9	2.4	VT32	○
C5 AT40X194V	50	40	194	170	5	2.24	VT40	○
C5 AT40X368V	50	40	368	344	9	4.2	VT40..	○
C6 AT16X088V	63	16	88	58	5	1.01	VT16	○
CE AT20X108V	63	20	108	73	5	1	VT20	○
C6 AT25X132V	63	25	132	103	5	1.35	VT25	○
CS AT25X230V	63	25	230	197	9	1.7	VT25	○
C6 AT32X159V	63	32	159	129	5	1.8	VT32	○
C6 AT32X288V	63	32	288	257	9	27	VT32	○
C6 AT40X198V	63	40	198	169	5	2.6	VT40	○
CE AT40X368V	63	40	368	338	9	4.2	VT40	○

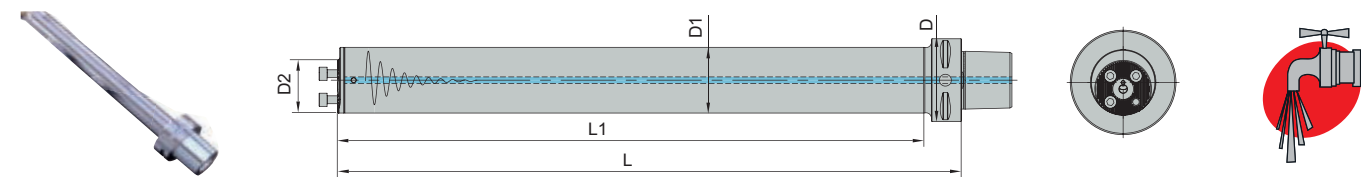
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- With coolant hole.
- Suggest doing the maintenance when damping capacity is weaker than before.

SPARE PARTS



D	CLAMP SCREW FOR CARTRIDGE	ALLEN KEY FOR CARTRIDGE CLAMPING SCREW
16	SR55-2 M3X10	KEY01 M2.5
20	SR55-2 M3.5X10	KEY01 M2.5
25	SR55-2 M4X12	KEY01 M3
32	SR55-2 M5X12	KEY01 M4
40	SR55-2 M6X16	KEY01 M5

DAMPING TURNING TOOL HOLDER



DESIGNATION	D	D1	D2	L	L1	L/D	KG	CARTRIDGE	STOCK
C5 AT40-D50X223V.R/L	50	50	40	223	223	5	3.6	VT40	○
GS AT40-D50X468V.R/L	50	50	40	468	468	9	10.79	VT40	○
C6 AT40-D50X247V.R/L	63	50	40	247	222	5	4.2	VT40..	○
C6 AT40-D50X468V.R/L	63	50	40	468	440	9	7.4	VT40.	○
C6 AT40-D60X295V.R/L	63	60	40	295	273	5	6.8	VT40.	○
C6 AT40-O60X568V.R/L	63	60	40	568	545	9	12.2	VT40..	○
C8 AT40-D50X297V.R/L	80	50	40	297	261	5	5.8	VT40	○
CB AT40-O50X468V.R/L	80	50	40	468	434	9	8.3	VT40..	○
C8 AT40-D60X355V.R/L	80	60	40	355	320	5	8.9	VT40	○
CB AT40-D60X568V.R/L	80	60	40	568	531	9	13	VT40	○

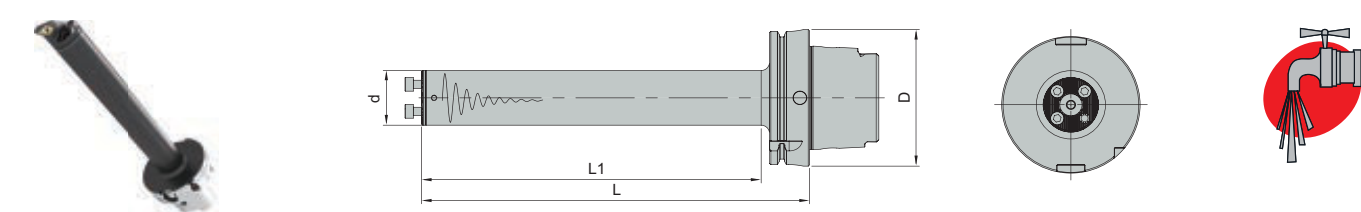
- With coolant hole.
- The cartridge should be ordered separately.
- Suggest doing the maintenance when damping capacity is weaker than before.

SPARE PARTS



D1	CLAMP SCREW FOR CARTRIDGE	ALLEN KEY FOR CARTRIDGE CLAMPING SCREW
16	SR55-2 M3X10	KEY01 M2.5
20	SR55-2 M3.5X10	KEY01 M2.5
25	SR55-2 M4X12	KEY01 M3
32	SR55-2 M5X12	KEY01 M4
40	SR55-2 M6X16	KEY01 M5

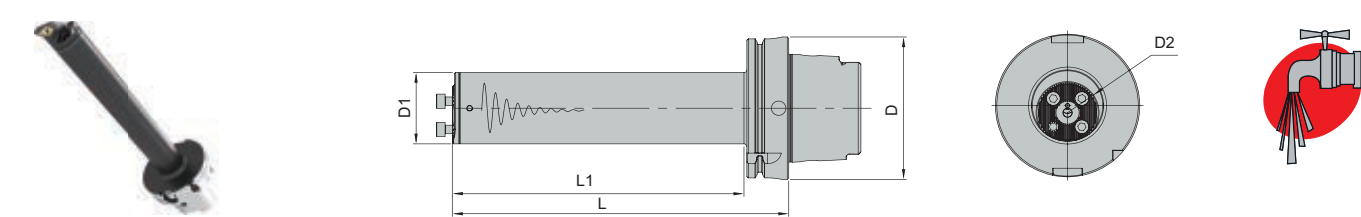
DAMPING TURNING TOOL HOLDER



DESIGNATION	D	d	L1	L	L/D	BAR	KG	STOCK
HSK T63 VT32X172.V	63.0	32.0	143.0	172.0	5	70	1.8	○
HSK T63 VT40X208 V	63.0	40.0	179.0	208.0	5	70	27	○
HSK T100 VT40X208.V	100.0	40.0	176.0	208.0	5	70	4.0	○

- With coolant hole.
- The cartridge should be ordered separately.
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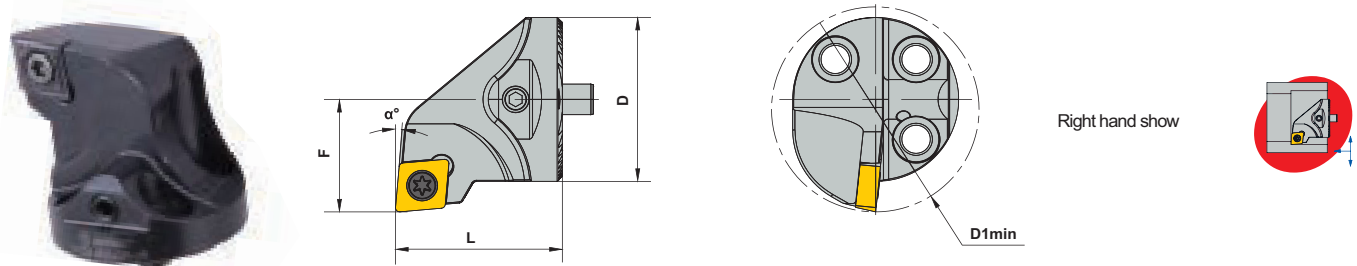
DAMPING TURNING TOOL HOLDER



DESIGNATION	D	D1	D2	L1	L	L/D	BAR	KG	STOCK
HSK T63 VT40-D50X268.V	63.0	50.0	40.0	239.0	268.0	5	70	4.6	○
HSK T100 VT40-O50X265.V	100.0	50.0	40.0	236.0	268.0	5	70	5.8	○
HSK T100 VT40-D60X328.V	100.0	60.0	40.0	296.0	328.0	5	70	8.7	○

- With coolant hole.
- Suggest doing the maintenance when damping capacity is weaker than before.

DAMPING TURNING TOOL HOLDER



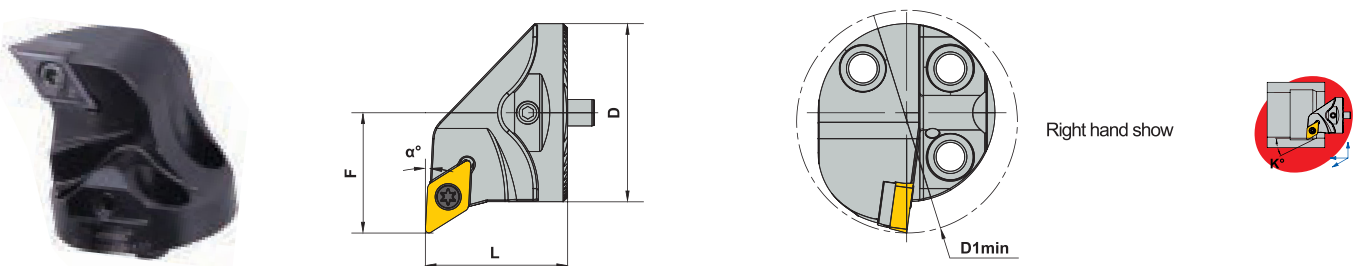
DESIGNATION	D	D1 min	F	L	α°	KG	INSERT	STOCK
VT16 SCLCR-06	16	20	11	20	5	0.02	CC..0602	○
VT20 SCLCR-09	20	25	13	20	5	0.03	CC.09T3..	○
VT25 SCLCR-09	25	32	17	20	5	0.04	CC 09T3.	○
VT32 SCLCR-09	32	40	22	32	5	0.1	CC..09T3..	○
VT40 SCLCR-12T	40	50	27	38	5	0.2	CC. I204.	○
VT18 SCLCL-06	16	20	11	20	5	0.02	CC..0602.	○
VT20 SCLCL-09	20	25	13	20	5	0.03	CC..09T3..	○
VT25 SCLCL-09	25	32	17	20	5	0.04	CC..09T3..	○
VT32 SCLCL-09	32	40	22	32	5	0.1	CC..09T3..	○
VT40 SCLCL-12T	40	50	27	38	5	0.2	CC..I204.	○

SPARE PARTS



D1	CLAMP SCREW FOR INSERT	ALLEN KEY FOR CLAMPING	SHIM	SLEEVE FOR SHIM	ALEN KEY FOR SHIM	LOCATING PIN
VT16..-06	SR21 M2.5X5.3	KEY03 I7	-	-	-	FT39 D4-3X7
VT20-09	SR21 M4X9.5	KEY03 T15	-	-	-	FT39 D6-5X8
VT25..-09	SR21 M4X9.5	KEY03 T15	-	-	-	FT39 D6-5X9
VT32-09	SR21 M4X9.5	KEY03 T15	-	-	-	FT39 D6-5X11
VT40..-12T	SR21 M5X12.8	KEY03 T20	ST01 CC12X2.8	SRT M7-M5X13	KEY01 M3	FT39 D6-5X11

DAMPING TURNING TOOL HOLDER



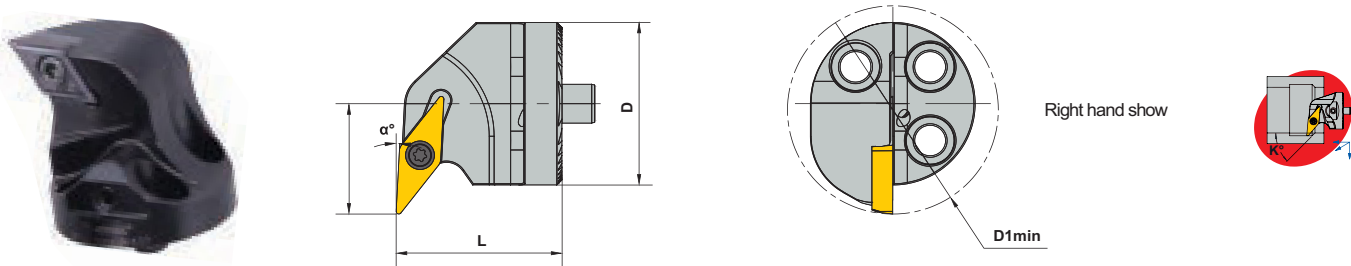
DESIGNATION	D	D1 min	F	L	α	K	KG	INSERT	STOCK
VT16 SDUCR-07	16	20	11	20	3°	27°	0.02	DC..0702.	○
VT20 SDUCR-11	20	25	13	20	3°	27°	0.03	DC..11T3..	○
VT25 SDUCR-11	25	32	17	20	3°	27°	0.04	DC..11T3	○
VT32 SDUCR-11T	32	40	22	32	3°	27°	0.1	DC..11T3..	○
VT40 SDUCR-11T	40	50	27	32	3°	27°	0.2	DC..11T3	○
VT16 SDUCL-07	16	20	11	20	3°	27°	0.02	DC..0702..	○
VT20 SDUCL-11	20	25	13	20	3°	27°	0.03	DC..11T3..	○
VT25 SDUCL-11	25	32	17	20	3°	27°	0.04	DC..11T3	○
VT32 SDUCL-11T	32	40	22	32	3°	27°	0.1	DC..11T3	○
VT40 SDUCL-11T	40	50	27	32	3°	27°	0.2	DC..11T3	○

SPARE PARTS



D1	CLAMP SCREW FOR INSERT	ALLEN KEY FOR CLAMPING	SHIM	SLEEVE FOR SHIM	ALEN KEY FOR SHIM	LOCATING PIN
VT16..-07	SR21 M2.5X5.3	KEY03 I7	-	-	-	FT39 D4-3X7
VT20-11	SR21 M4X11	KEY03 T15	-	-	-	FT39 D6-5X8
VT25..-11	SR21 M4X11	KEY03 T15	-	-	-	FT39 D6-5X9
VT32-117	SR21 M4X11	KEY03 T15	ST01 DC11X2.82	SRT M6-M4X6.9	KEY01 M4	FT39 D6-5X11
VT40..-11T	SR21 M4X11	KEY03 T15	ST01 DC11X2.82	SRT M6-M4X6.9	KEY01 M4	FT39 D6-5X11

DAMPING TURNING TOOL HOLDER



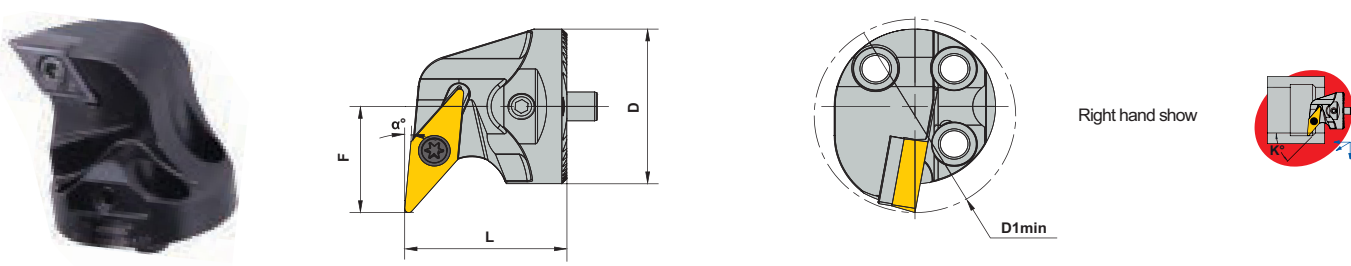
DESIGNATION	D	D1 min	F	L	α	K	KG	INSERT	STOCK
VT20 SVUCR-11	20	27	16	20	3°	50°	0.02	VC..1103.	○
VT25 SVUCR-11	25	31	17	25	3°	50°	0.04	VC 1103.	○
VT20 SVUCL-11	20	27	16	20	3°	50°	0.02	VC 1103..	○
VT25 SVUCL-11	25	31	17	25	3°	50°	0.04	VC 1103	○

SPARE PARTS



D1	CLAMP SCREW FOR INSERT	ALLEN KEY FOR CLAMPING	LOCATING PIN
VT20-11	SR20 M2.5X6	KEY03 TB	FT39 D6-5X8
SQRT(125 - 11)	SR20 M2.5X6	KEY03 TB	FT39 D6-5X9

DAMPING TURNING TOOL HOLDER



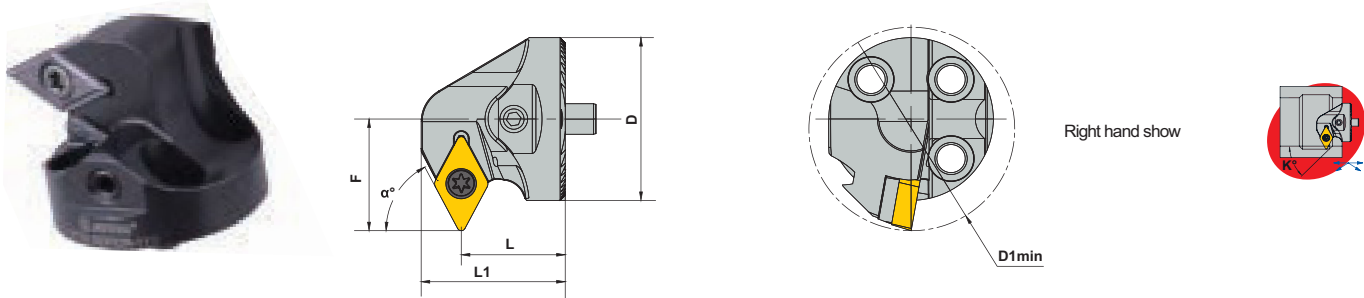
DESIGNATION	D	D1 min	F	L	α	K	KG	INSERT	STOCK
VT32 SVLCR-16T	32	40	22	32	5°	45°	0.1	VC..1604.	○
VT40 SVLCR-16T	40	50	27	32	5°	45°	0.15	VC 1604.	○
VT32 SVLCL-16T	32	40	22	32	5°	45°	0.1	VC 1604	○
VT40 SVLCL-16T	40	50	27	32	5°	45°	0.15	VC..1604	○

SPARE PARTS



D1	CLAMP SCREW FOR INSERT	ALLEN KEY FOR CLAMPING	SHIM	SLEEVE FOR SHIM	ALLEN KEY FOR SHIM	LOCATING PIN
VT32..-16T	SR21 M4X11	KEY03 T15	ST01 VC16X2.82	SRT M6-M4X6.9	KEY01 M4	FT39 D6-5X11
VT40-16T	SR21 M4X11	KEY03 T15	ST01 VC16X2.82	SRT M6-M4X6.9	KEY01 M4	FT39 D6-5X11

DAMPING TURNING TOOL HOLDER



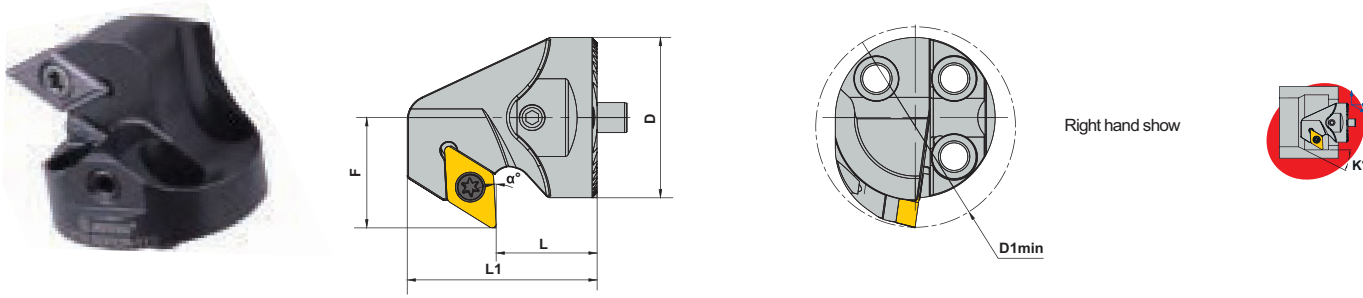
DESIGNATION	D	D1 min	F	L	L1	α	K	KG	INSERT	STOCK
VT16 SDPCR-07	16	22	13	15	19	62.5°	60°	0.01	DC 0702	○
VT20 SDPCR-07	20	27	15	15	19	62,51°	60°	0.02	DC. 0702.	○
VT25 SDPCR-07	25	33	18	15	19	62.5°	60°	0.03	DC..0702.	○
VT32 SDPCR-IIT	32	40	22	20	28	62.5°	60°	0.09	DC..IIT3.	○
VT40 SDPCR-IIT	40	50	27	20	28	62,5°	60°	0.14	DC..IIT3.	○
VT16 SDPCL-07	16	22	13	15	19	62.5°	60°	0.01	DC..0702.	○
VT20 SDPCL-07	20	27	15	15	19	62.5°	60°	0.02	DC..0702.	○
VT25 SDPCL-07	25	33	18	15	19	62,51°	60°	0.03	DC. 0702.	○
VT32 SDPCL-IIT	32	40	22	20	28	62.5°	60°	0.09	DC. IIT3.	○
VT40 SDPCL-I17	40	50	27	20	28	62.5°	60°	0.14	DC..IIT3..	○

SPARE PARTS



D1	CLAMP SCREW FOR INSERT	ALLEN KEY FOR CLAMPING	SHIM	SLEEVE FOR SHIM	ALEN KEY FOR SHIM	LOCATING PIN
VT16-07	SR21 M2.5X5.3	KEY03 T7	-	-	-	FT39 D4-3X7
VT20-07	SR21 M2.5X5.3	KEY03 T7	-	-	-	FT39 D6-5X8
VT25-07	SR21 M2.5X5.3	KEY03 I7	-	-	-	FT39 D6-5X9
VT32-IIT	SR21 M4X11	KEY03 T15	ST01 DC11X2.82	SRT M6-M4X6.9	KEY01 M4	FT39 D6-5X11
VT40..-IIT	SR21 M4X11	KEY03 T15	ST01 DC11X2.82	SRT M6-M4X6.9	KEY01 M4	FT39 D6-5X11

DAMPING TURNING TOOL HOLDER



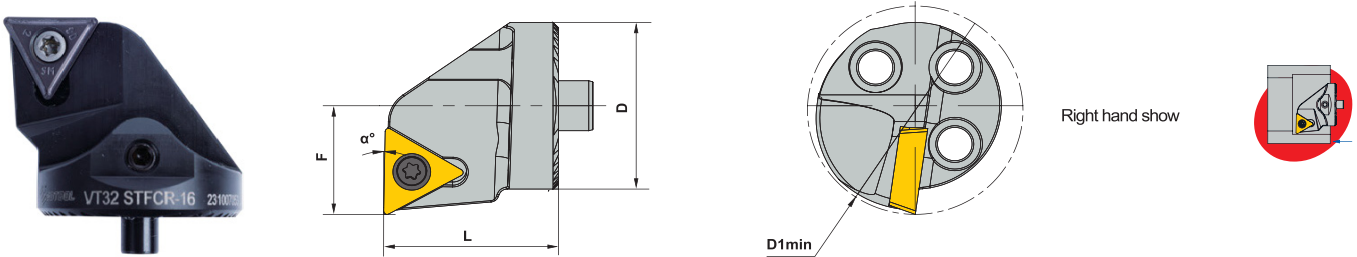
DESIGNATION	D	D1 min	F	L	L1	α	K	KG	INSERT	STOCK
VT16 SDZCR-07	16	22	13	15	27	3°	27°	0.03	DC..0702..	○
VT20 SDZCR-07	20	27	15	15	27	3°	27°	0.05	DC..0702..	○
VT25 SDZCR-07	25	33	18	15	27	3°	27°	0.12	DC. 0702	○
VT32 SDZCR-IIT	32	40	22	20	38	3°	27°	0.14	DC IIT3..	○
VT40 SDZCR-IIT	40	50	27	20	38	3°	27°	0.19	DC..IIT3..	○
VT16 5DZCL-07	16	22	13	15	27	3°	27°	0.03	DC..0702..	○
VT20 SDZCL-07	20	27	15	15	27	3°	27°	0.05	DC..0702..	○
VT25 SDZCL-07	25	33	18	15	27	3°	27°	0.12	DC..0702..	○
VT32 SDZCL-IIT	32	40	22	20	38	3°	27°	0.14	DC IIT3	○
VT40 SDZCL-I17	40	50	27	20	38	3°	27°	0.19	DC..IIT3..	○

SPARE PARTS



D1	CLAMP SCREW FOR INSERT	ALLEN KEY FOR CLAMPING	SHIM	SLEEVE FOR SHIM	ALEN KEY FOR SHIM	LOCATING PIN
VT16-07	SR21 M2.5X5.3	KEY03 T7	-	-	-	FT39 D4-3X7
VT20-07	SR21 M2.5X5.3	KEY03 T7	-	-	-	FT39 D6-5X8
VT25-07	SR21 M2.5X5.3	KEY03 I7	-	-	-	FT39 D6-5X9
VT32-IIT	SR21 M4X11	KEY03 T15	ST01 DC11X2.82	SRT M6-M4X6.9	KEY01 M4	FT39 D6-5X11
VT40..-IIT	SR21 M4X11	KEY03 T15	ST01 DC11X2.82	SRT M6-M4X6.9	KEY01 M4	FT39 D6-5X11

DAMPING TURNING TOOL HOLDER



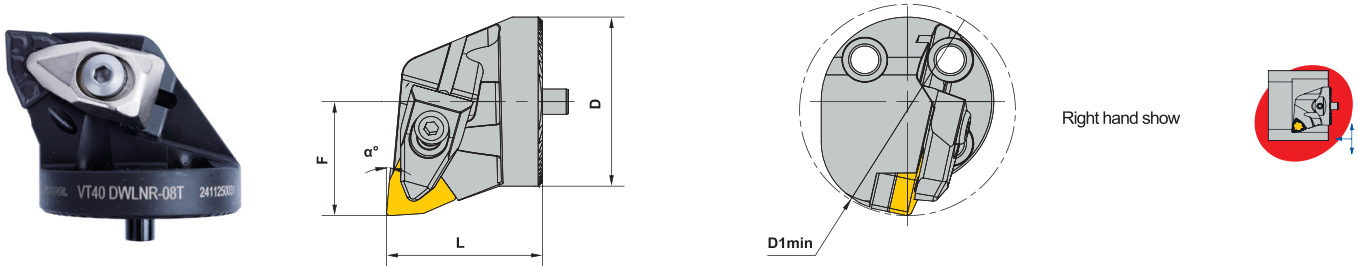
DESIGNATION	D	D1 min	F	L	α°	KG	INSERT	STOCK
VT16 STFCL-09	16	20	11	20	1°	0.02	TC..0902	○
VT16 STFCL-11	16	20	11	20	1°	0.02	TC..1102	○
VT20 STFCL-11	20	25	13	20	1°	0.03	TC..1102	○
VT25 STFCL-11	25	32	17	20	1°	0.04	TC..1102	○
VT32 STFCL-16	32	40	22	32	1°	0.10	TC..16T3..	○
VT40 STFCL-18	40	50	27	32	1°	0.20	TC..16T3..	○
VT16 STFCL-09	16	20	11	20	1°	0.02	TC..0902	○
VT16 STFCL-11	16	20	11	20	1°	0.02	TC..1102	○
VT20 STFCL-11	20	25	13	20	1°	0.03	TC..1102	○
VT25 STFCL-11	25	32	17	20	1°	0.04	TC..1102	○
VT32 STFCL-16	32	40	22	32	1°	0.10	TC.. 16T3.	○
VT40 STFCL-16	40	50	27	32	1°	0.20	TC..16T3..	○

SPARE PARTS



D1	CLAMP SCREW FOR INSERT	ALLEN KEY FOR CLAMPING	LOCATING PIN
VT16-09	SR20 M2.2X5.6.	KEY03 I7	FT39 D4-3X7
VT16-11	SR20 M2.5X6	KEY03 I8	FT39 D4-3X7
VT20-11	SR20 M2.5X6	KEY03 TB	FT39 D6-5X8
VT25-11	SR20 M2.5X6	KEY03 T8	FT39 D6-5X9
VT32.-16	SR21 M4X9.5	KEY03 T15	FT39 D6-5X11
VT40-16	SR21 M4X9.5	KEY03 T15	FT39 D6-5X11

DAMPING TURNING TOOL HOLDER



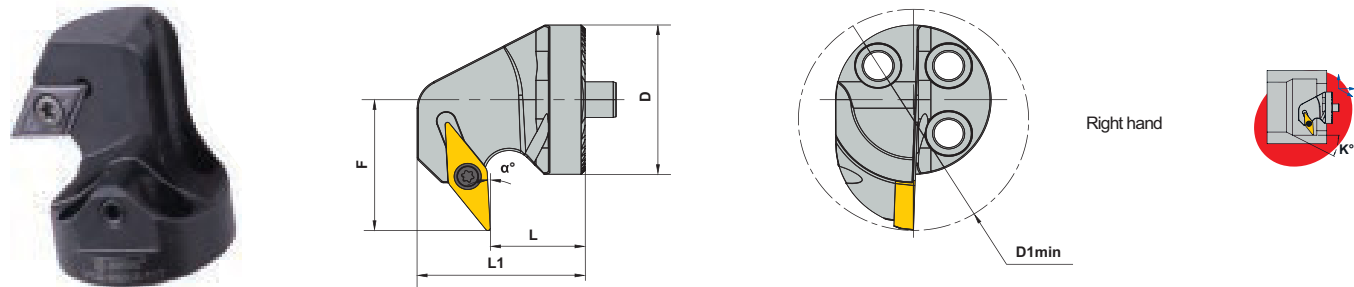
DESIGNATION	D	D1 min	F	L	α°	KG	INSERT	STOCK
VT32 DWLNR-06T	32	40	22	32	5°	0.11	WN..0604..	○
VT32 DWLNR-08T	32	46	24	36	5°	0.12	WN..0804..	○
VT40 DWLNR-08T	40	50	27	36	5°	0.23	WN..0804..	○
VT32 DWLNL-06T	32	40	22	32	5°	0.11	WN..0604..	○
VT32 DWLNL-08T	32	46	24	36	5°	0.12	WN. 0804	○
VT40 DWLNL-08T	40	50	27	36	5°	0.23	WN..0804..	○

SPARE PARTS



DESIGNATION	CLAMPING PAD	SPRING FOR CLAMPING PAD	SCREW FOR CLAMPING PAD	SHIM	ALLEN KEY FOR CLAMPING PAD	CLAMPING SCREW FOR SHIM	ALLEN KEY FOR SHIM	LOCATING PIN
VT32..-06T	PB10 DDNI1	YH 7X0.6X13	SR59 M4X16	ST01 WN06X3.18	KEY01 M2.5	SR20 M4X9.5	KEY03 T15	FT39 D6-5X11
VT32-087	PB10 DCN I2	YH 8X0.6X13	SR59 M5X20	ST01 WN08X3.18	KEY01 M3	SR20 M5X10	KEY03 T20	FT39 D6-5X11
VT40..-08T	PB10 DCNI2	YH 8X0.6X13	SR59 M5X20	ST01 WN08X3.18	KEY01 M3	SR20 M5X10	KEY03 T20	FT39 D6-5X11

DAMPING TURNING TOOL HOLDER



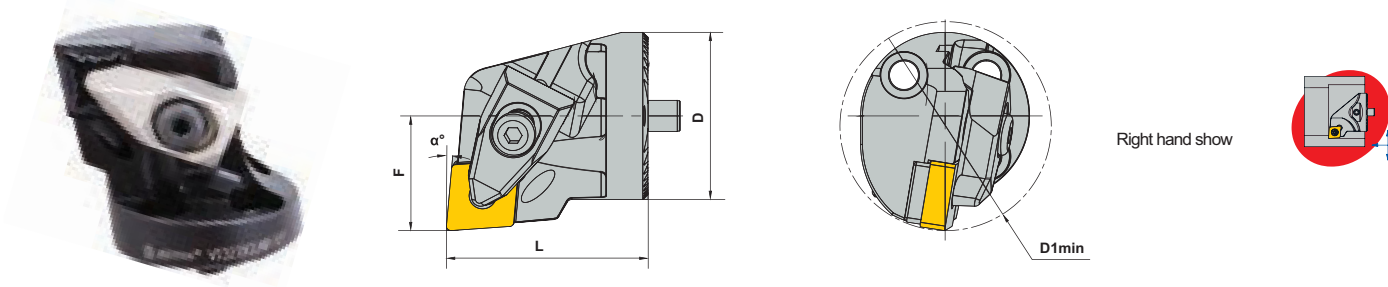
DESIGNATION	D	D1 min	F	L	L1	α	K	KG	INSERT	STOCK
VT20 SVZCR-11	20	32	20	15	27	3°	45°	0.03	VC 1103.	○
VT25 SVZCR-11	25	37	22	15	27	3°	45°	0.05	VC 1103..	○
VT20 SVZCL-11	20	32	20	15	27	3°	45°	0.03	VC.. 1103..	○
VT25 SVZCL-11	25	37	22	15	27	3°	45°	0.05	VC 1103.	○

SPARE PARTS



D1	CLAMP SCREW FOR INSERT	ALLEN KEY FOR CLAMPING	LOCATING PIN
VT20..-11	SR20 M2.5X6	KEY03 T8	FT39 06-5X8
VT25-11	SR20 M2.5X6	KEY03 T8	FT39 D6-5X9

DAMPING TURNING TOOL HOLDER



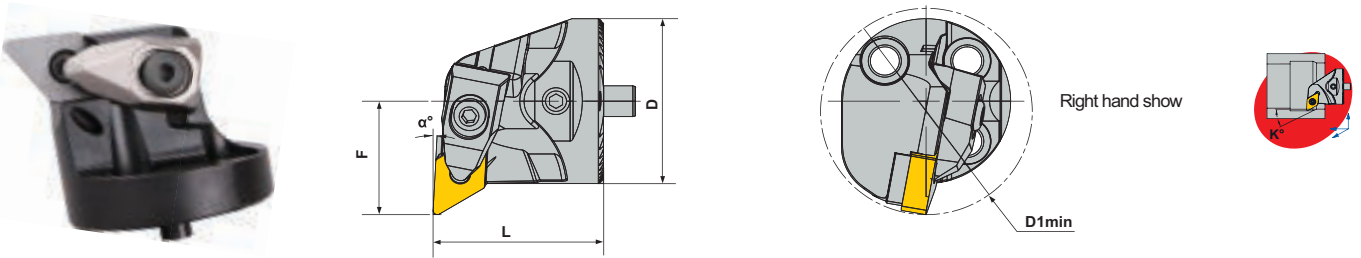
DESIGNATION	D	D1 min	F	L	α °	KG	INSERT	STOCK
VT32 DCLNR-12T	32	40	22	38	5°	0.12	CN.. 1204	○
VT40 DCLNR-12T	40	50	27	38	5°	0.21	CN 1204	○
VT32 DCLNL-12T	32	40	22	38	5°	0.12	CN.. 1204.	○
VT40 DCLNL-12T	40	50	27	38	5°	0.21	CN 1204.	○

SPARE PARTS



DESIGNATION	CLAMPING PAD	SPRING FOR CLAMPING PAD	SCREW FOR CLAMPING PAD	SHIM	ALLEN KEY FOR CLAMPING PAD	CLAMPING SCREW FOR SHIM	ALLEN KEY FOR SHIM	LOCATING PIN
VT32-12T	PB10 DCNI2	YH 8X0.6X13	SR59 M5X201	ST01 CNI2X3.2	KEY01 M3	SR20 M5X10	KEY03 T20	FT39 D6-5X11
VT40-12T	PB10 DCNI2	YH 8X0.6X13	SR59 M5X20	ST01 CNI2X3.2	KEY01 M3	SR20 M5X10	KEY03 T20	FT39 D6-5X11

DAMPING TURNING TOOL HOLDER



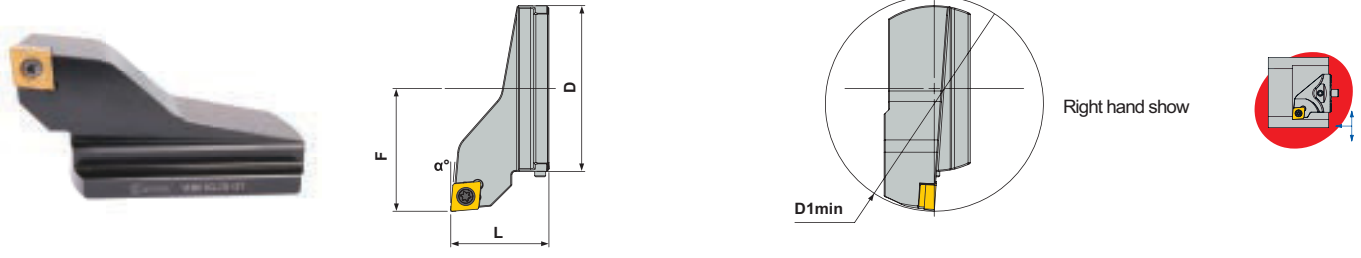
DESIGNATION	D	D1 min	F	L	α°	K	KG	INSERT	STOCK
VT32 DDUNL-11T	32	40	22	32	3°	27°	0.11	DN.. 1104..	○
VT40 DDUNL-15T	40	50	27	38	3°	27°	0.18	DN.. 1506.	○
VT32 DDUNR-11T	32	40	22	32	3°	27°	0.11	DN 1104	○
VT40 DDUNR-15T	40	50	27	38	3°	27°	0.18	DN.. 1506..	○
VT40 DVUNR-16T	40	56	34	38	3°	25°	0.2	VN.. 1604	○
VT40 DVUNL-16T	40	56	34	38	3°	25°	0.2	VN.. 1604	○

SPARE PARTS



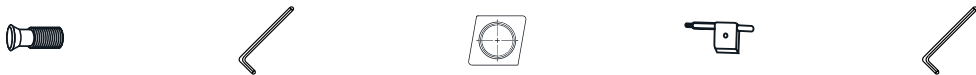
DESIGNATION	CLAMPING PAD	SPRING FOR CLAMPING PAD	SCREW FOR CLAMPING PAD	SHIM	ALLEN KEY FOR CLAMPING PAD	CLAMPING SCREW FOR SHIM	ALLEN KEY FOR SHIM	LOCATING PIN
VT32...-11T	PB10 DDN11	YH 7X0.6X13	SR59 M4X16	ST01 DN11X3.18	KEY01 M2.5	SR21 M4X9.5	KEY03 T15	FT39 D6-5X11
VT40-15T	PB10 DCN12	YH 8X0.6X13	SR59 M5X20	ST01 DN15X4.76	KEY01 M3	SR20 M4X11.5	KEY03 T15	FT39 D6-5X11
VT40...-16T	PB10 DVN 16	YH 9X0.8X14	SR59 M6X26.5	ST01 VN16X3.2	KEY01 M4	SR20 M3.5X8.5	KEY03 T10	FT39 D6-5X11

DAMPING TURNING TOOL HOLDER



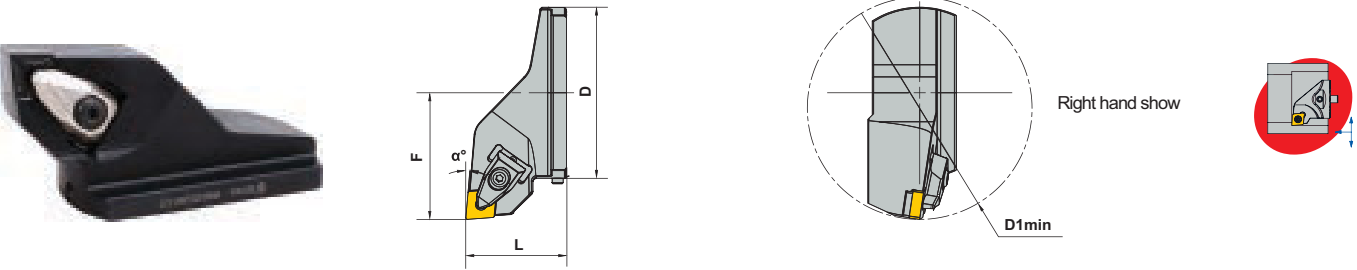
DESIGNATION	D	D1 min	F	L	α°	KG	INSERT	STOCK
VH80 SCLCR-12T	80	100	57	45	5°	0.5	CC.. 1204	○
VHB6 SCLCL-12T	80	100	57	45	5°	0.5	CC 1204	○

SPARE PARTS



DESIGNATION	CLAMPING SCREW FOR SHIM	ALLEN KEY FOR SHIM	SHIM	INSERT SOCKET FOR KNIFE	ALLEN KEY FOR SHIM
VT32...-11T	PB10 DDN11	YH 7X0.6X13	SR59 M4X16	ST01 DN11X3.18	KEY01 M2.5
VT40-15T	PB10 DCN12	YH 8X0.6X13	SR59 M5X20	ST01 DN15X4.76	KEY01 M3
VT40...-16T	PB10 DVN 16	YH 9X0.8X14	SR59 M6X26.5	ST01 VN16X3.2	KEY01 M4

DAMPING TURNING TOOL HOLDER



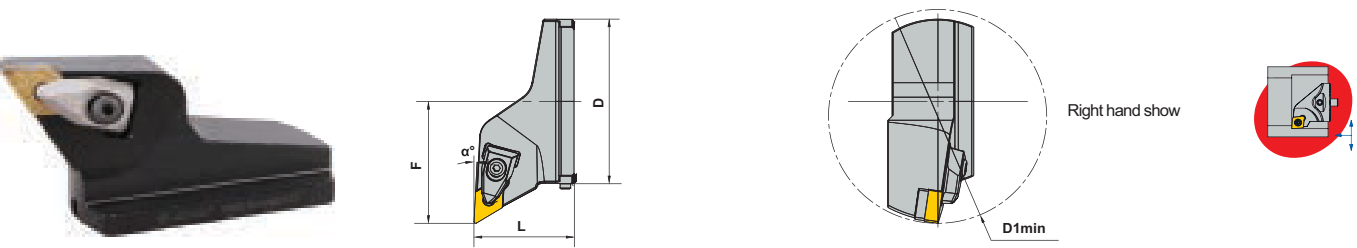
DESIGNATION	D	D1 min	F	L	α°	KG	INSERT	STOCK
VH80 DCLNR-12T	80	100	57	45	5°	0.49	CN 1204	○
VH80 DCLNL-127	80	100	57	45	5°	0.49	CN.. 1204	○

SPARE PARTS



DESIGNATION	CLAMPING PAD	SPRING FOR CLAMPING PAD	SCREW FOR CLAMPING PAD	SHIM	ALLEN KEY FOR CLAMPING PAD	CLAMPING SCREW FOR SHIM	ALLEN KEY FOR SHIM
VH80-12T	PB10 DCN12	YH BX0.6X13	SR59 M5X20	ST01 CN12X3.2	KEY01 M3	SR20 M5X10	KEY03 T20

DAMPING TURNING TOOL HOLDER



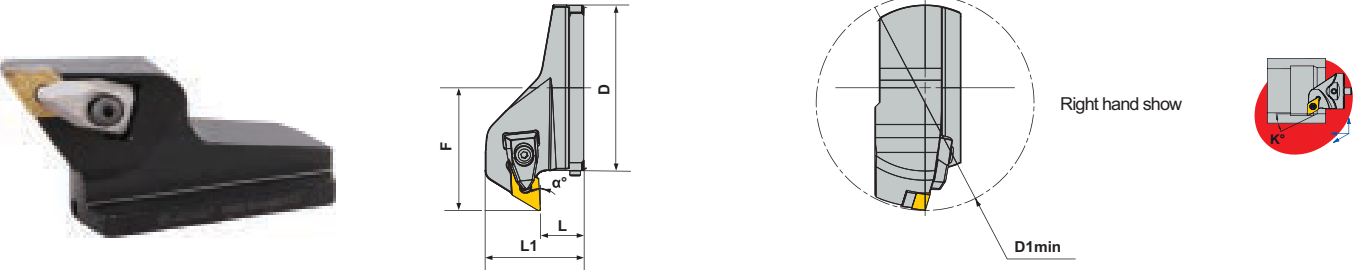
DESIGNATION	D	D1 min	F	L	α	K	KG	INSERT	STOCK
VH80 DDUNL-15T	80	100	57	46	3°	27°	0.5	DN.. 1506	○
VH80 DDUNR-15T	80	100	57	46	3°	27°	0.5	DN.. 1506..	○

SPARE PARTS



DESIGNATION	CLAMPING PAD	SPRING FOR CLAMPING PAD	SCREW FOR CLAMPING PAD	SHIM	ALLEN KEY FOR CLAMPING PAD	CLAMPING SCREW FOR SHIM	ALLEN KEY FOR SHIM
VH80-12T	PB10 DCN12	YH BX0.6X13	SR59 M5X20	ST01 DN15X4.76	KEY01 M3	SR20 M4X11.5	KEY03 T15

DAMPING TURNING TOOL HOLDER



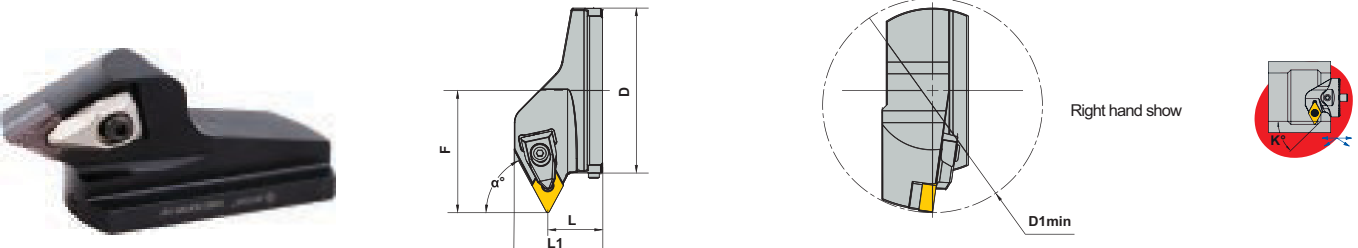
DESIGNATION	D	D1 min	F	L	L1	α	K	KG	INSERT	STOCK
VH80 DDZNR-15T	80	100	57	20	45	3°	27°	0.55	DN 1506	○
VH80 DDZNL-15T	80	100	57	20	45	3°	27°	0.55	DN 1506	○

SPARE PARTS



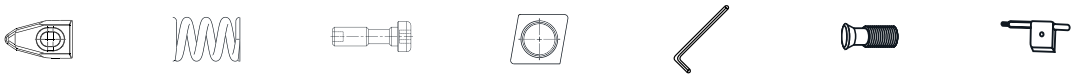
DESIGNATION	CLAMPING PAD	SPRING FOR CLAMPING PAD	SCREW FOR CLAMPING PAD	SHIM	ALLEN KEY FOR CLAMPING PAD	CLAMPING SCREW FOR SHIM	ALLEN KEY FOR SHIM
VH80..-15T	PB10 DCN12	YH BX0.6X13	SR59 M5X20	ST01 DN15X4.76	KEY01 M3	SR20 M4X11.5	KEY03 T15

DAMPING TURNING TOOL HOLDER



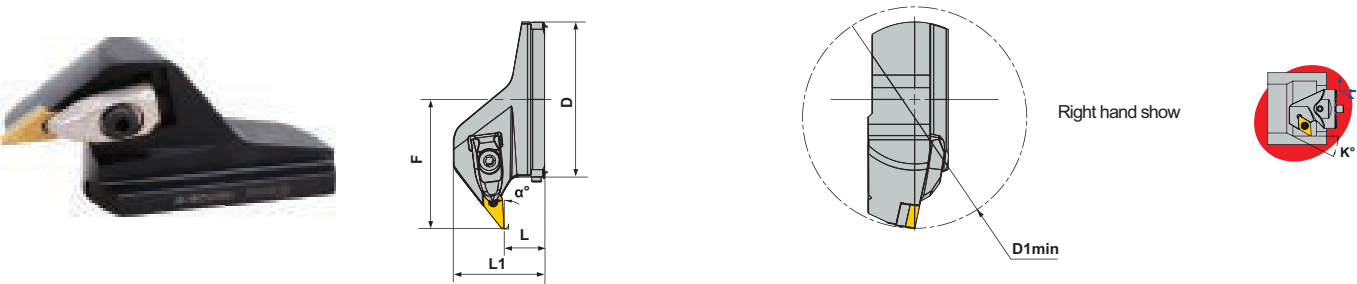
DESIGNATION	D	D1 min	F	L	L1	α	K	KG	INSERT	STOCK
VH80 DDPNR-15T	80	100	57	25	40.3	62.5°	60°	0.49	DN.. 1506..	○
VH80 DDPNL-15T	80	100	57	25	40.3	62.5°	60°	0.49	DN.. 1506	○

SPARE PARTS



DESIGNATION	CLAMPING PAD	SPRING FOR CLAMPING PAD	SCREW FOR CLAMPING PAD	SHIM	ALLEN KEY FOR CLAMPING PAD	CLAMPING SCREW FOR SHIM	ALLEN KEY FOR SHIM
VH80..-15T	PB10 DCN12	YH BX0.6X13	SR59 M5X20	ST01 DN15X4.76	KEY01 M3	SR20 M4X11.5	KEY03 T15

DAMPING TURNING TOOL HOLDER



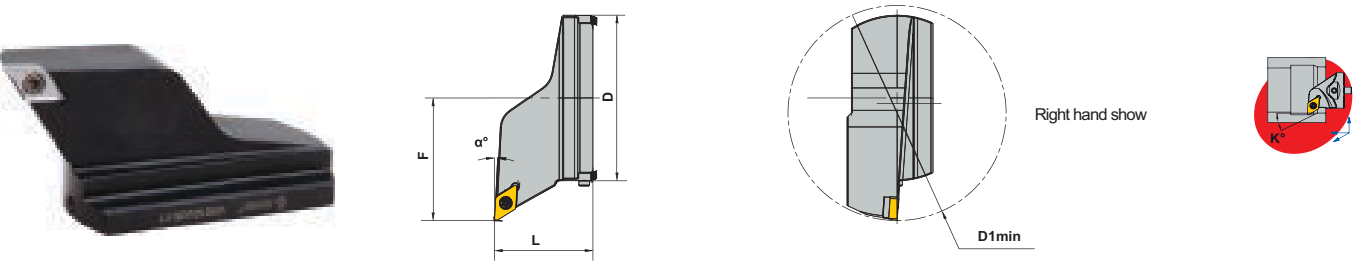
DESIGNATION	D	D1 min	F	L	L1	α	K	KG	INSERT	STOCK
VH80 DCLNR-12T	80	110	64	20	45	3°	30°	0.49	VN 1604	○
VH80 DCLNL-127	80	110	64	20	45	3°	30°	0.49	VN 1604	○

SPARE PARTS



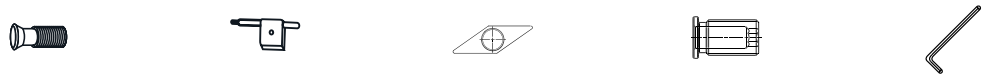
DESIGNATION	CLAMPING PAD	SPRING FOR CLAMPING PAD	SCREW FOR CLAMPING PAD	SHIM	ALLEN KEY FOR CLAMPING PAD	CLAMPING SCREW FOR SHIM	ALLEN KEY FOR SHIM
VH80..-16T	PB10 DVN 16	YH 9X0.8X14	SR59 M6X26,5	ST01 VN16X3.2	KEY01 M4	SR20 M3.5X8.5	KEY03 T10

DAMPING TURNING TOOL HOLDER



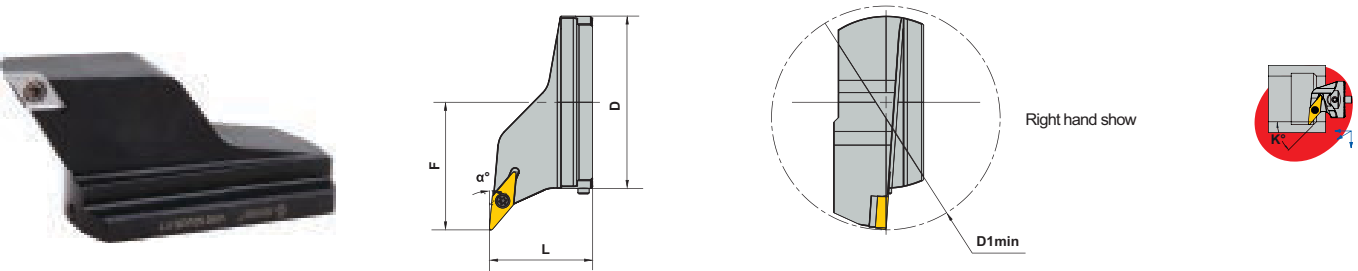
DESIGNATION	D	D1 min	F	L	α	K	KG	INSERT	STOCK
VH80 SDUCR-11T	80	100	57	45	3°	27°	0.5	DC 11T3.	○
VH50 SDUCL-11T	80	100	57	45	3°	27°	0.5	DC.. 11T3	○

SPARE PARTS



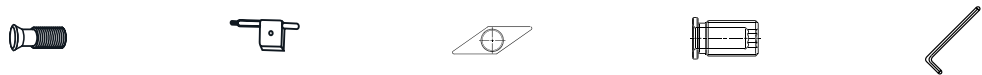
DESIGNATION	CLAMPING SCREW FOR INSERT	ALLEN KEY FOR CLAMPING	SHIM	SLEEVE FOR SHIM	ALLEN KEY FOR SHIM
VH80..-11T	SR21 M4X11	KEY03 T15	ST01 DC11X2.82	SRT M6-M4X6.9	KEY01 M4

DAMPING TURNING TOOL HOLDER



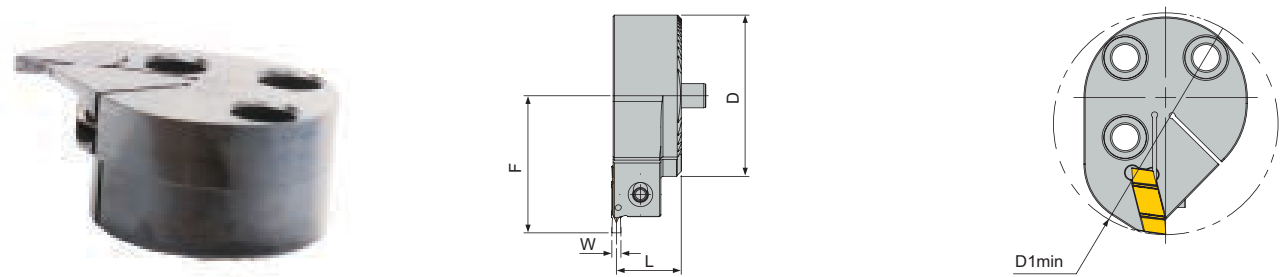
DESIGNATION	D	D1 min	F	L	α	K	KG	INSERT	STOCK
VH80 SVLCR-16T	80	100	57	45	5°	45°	0.44	VC 1604	○
VH80 SVLCL-16T	80	100	57	45	5°	45°	0.44	VC 1604	○

SPARE PARTS



DESIGNATION	CLAMPING SCREW FOR INSERT	ALLEN KEY FOR CLAMPING	SHIM	SLEEVE FOR SHIM	ALLEN KEY FOR SHIM
VH80..-16T	SR21 M4X11	KEY03 T15	ST01 VC16X2.82	SRT M6-M4X6.9	KEY01 M4

DAMPING TURNING TOOL HOLDER



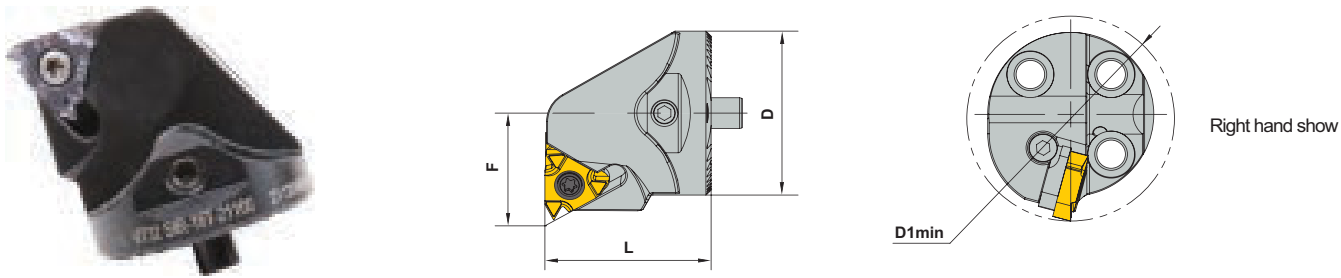
DESIGNATION	D1 min	W	D	F	L	INSERT	STOCK
VT25 GIR/L-2	31.00	2	25.00	17.50	14.00	HG2002	●
VT25 GIR/L-3	31.00	3	25.00	17.50	14.00	HG3003....	●
VT32 GIR/L-2	37.00	2	32.00	20.00	18.00	HG2002	●
VT32 GIR/L-3	37.00	3	32.00	20.00	18.00	HG3003.	●
VT40 GIR/L-2	45.00	2	40.00	24.00	18.00	HG2002	●
VT40 GIR/L-3	46.00	3	40.00	25.00	18.00	HG3003	●
VT40 GIR/L-4	49.00	4	40.00	28.00	18:00	HG4004	●

SPARE PARTS



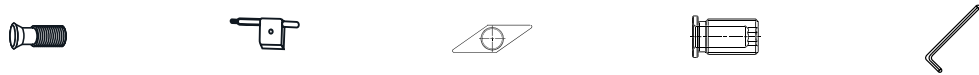
D1	CLAMP SCREW FOR INSERT	ALLEN KEY FOR CLAMPING	LOCATING PIN
VT25 GIR/L-2	SR55 M4X12	KEY01 M3	FT39 D6-5X9
VT25 GIR/L-3	SR55 M4X12	KEY01 M3	FT39 D6-5X9
VT32 GIR/L-2	SR55 M4X12	KEY01 M3	FT39 D6-5X11
VT32 GIR/L-3	SR55 M4X12	KEY01 M3	FT39 D6-5X11
VT40 GIR/L-2	SR55 M4X12	KEY01 M3	FT39 D6-5X11
VT40 GIR/L-3	SR55 M4X12	KEY01 M3	FT39 D6-5X11
VT40 GIR/L-4	SR55 M4X12	KEY01 M3	FT39 D6-5X11

DAMPING TURNING TOOL HOLDER



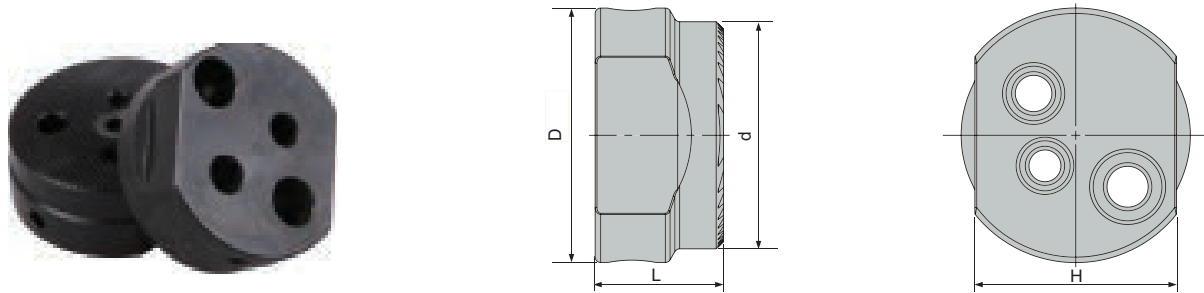
DESIGNATION	D	D1 min	F	L	KG	INSERT	STOCK
VT20 SIR/L-16	20	25	14	25	0.04	16IR/L	●
VT25 SIR/L-16T	25	32	17	25	0.05	16IR/L	●
VT32 SIR/L-16T	32	40	22	32	0.11	16IR/L	●
VT32 SIR/L-22T	32	40	22	32	0.11	221R/L	●
VT40 SIR/L-16T	40	50	27	32	0.17	16IR/L	●
VT40 SIR/L-227	40	50	27	32	0.17	221R/L	●

SPARE PARTS



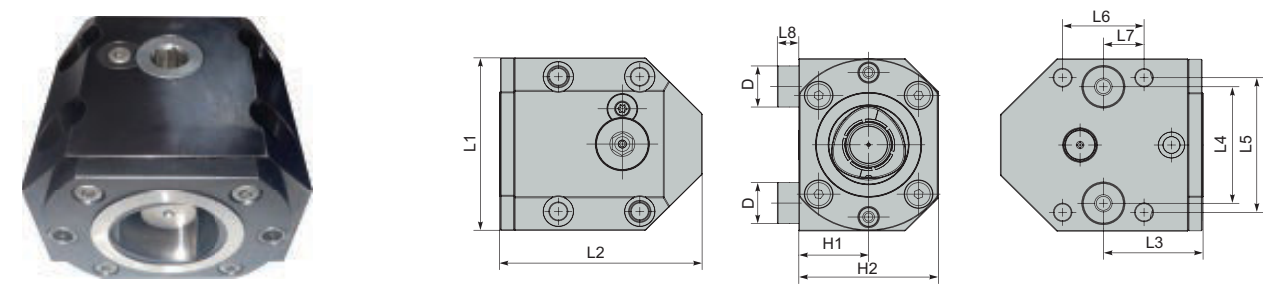
DESIGNATION	CLAMPING SCREW FOR INSERT	ALLEN KEY FOR CLAMPING	SHIM	SLEEVE FOR SHIM	ALLEN KEY FOR SHIM
VT20 SIR/L-16	SR20 M3.5X11.5	KEY02 T10	-	-	FT39 D6-5X8
VT25 SIR/L-16T	SR20 M3.5X11.5	KEY02 T10	A116	SR55 M3X6	FT39 D6-5X9
VT32 SIR/L-16T	SR20 M3.5X11.5	KEY02 T10	A116	SR55 M3X6	FT39 D6-5X11
VT32 SIRIL-22T	SR20 M4X15	KEY02 T15	A122	SR55 M3X6	FT39 D6-5X11
VT40 SIR/L-16T	SR20 M3.5X11.5	KEY02 T10	Al16	SR55 M3X6	FT39 D6-5X11
VT40 SIRIL-227	SR20 M4X15	KEY02 T15	A122	SR55 M3X6	FT39 D6-5X11

DAMPING TURNING TOOL HOLDER



DESIGNATION	D	d	H	L	BARING BAR	KG	STOCK
VTXZ 16-25	28	25	22	14	VT16/VT20/ VT25	0.05	●
VTXZ 32-60	62	60	52	25	VT32/ VT40/ VT50/VT60	0.45	●

DAMPING TURNING TOOL HOLDER

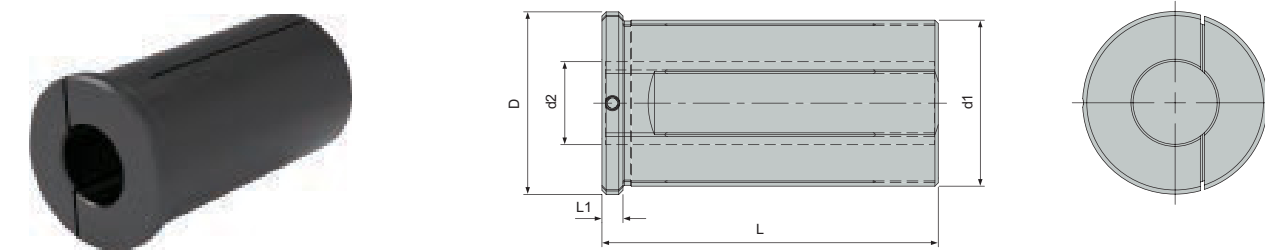


DESIGNATION	SIZE OF CONNECTION	H1	H2	L1	L2	L3	KG	STOCK
MGA 42XD25-60XC6.R	C6	42	84	105	122	60	5.85	○

DESIGNATION	ASSEMBLY SIZE						
	D (H7)	L4	L5	L6	L7	L8	CLAMPING SCREW
MGA 42XD25-60XC6.R	C6	42	84	105	122	60	○

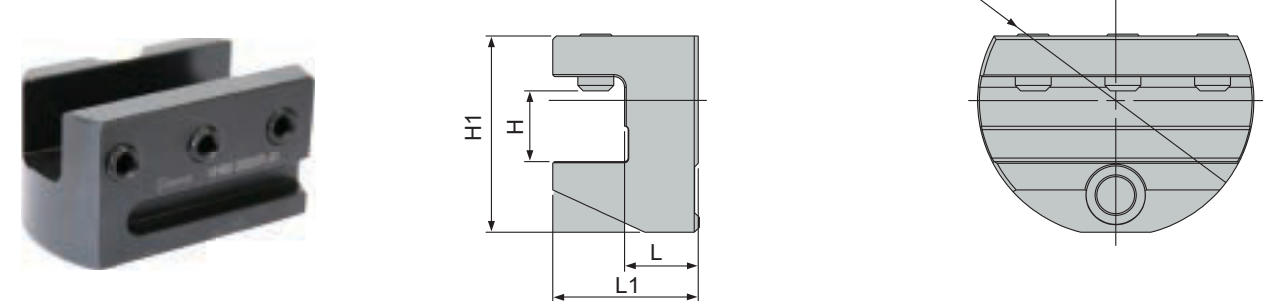
- Ordering sample: 1 PC MGA 42xD25-60xC6.R

DAMPING TURNING TOOL HOLDER



DESIGNATION	D1 min	d1	d2	L	L1	STOCK
RS D32-16X65	36	32	16	65	5	●
RS D32-20X65	36	32	20	65	5	●
RS D32-20X85	38	32	20	85	5	●
RS D40-16X75	44	40	16	75	5	●
RS D40-20X75	44	40	20	75	5	●
RS D40-25X75	44	40	25	75	5	●
RS D40-20X105	46	40	20	105	5	○
RS D40-25X105	46	40	25	105	5	○
RS D40-32X128	50	40	32	128	5	●
RS D50-20X125	56	50	20	125	5	●
RS D50-25X125	56	50	25	125	5	○
RS O50-32X128	60	50	32	128	5	○
RS D50-40X160	60	50	40	160	5	●
RS D60-32X128	70	60	32	128	5	●
RS D60-40X160	70	60	40	160	5	○
RS D60-50X200	70	60	50	200	5	○

DAMPING TURNING TOOL HOLDER

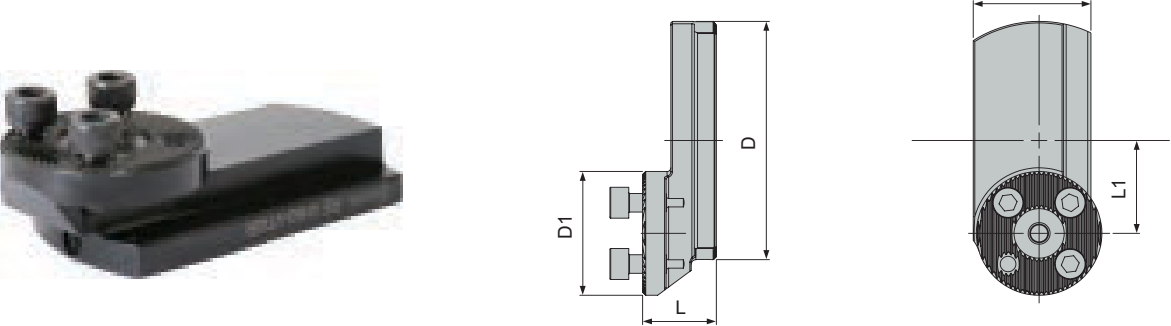


DESIGNATION	D	H	H1	L	L1	KG	STOCK
VH80 2020R.40	80	20	55	20	40	0.73	●

SPARE PARTS

D1	CLAMP SCREW FOR INSERT	ALLEN KEY FOR CLAMPING
VT25 GIR/L-2	SR54 M10X16	KEY01 M5

DAMPING TURNING TOOL HOLDER



DESIGNATION	D	D1	H1	L	L1	KG	STOCK
RE VH80-VT40R/L	80	40	37	23	30	0.33	●

SPARE PARTS

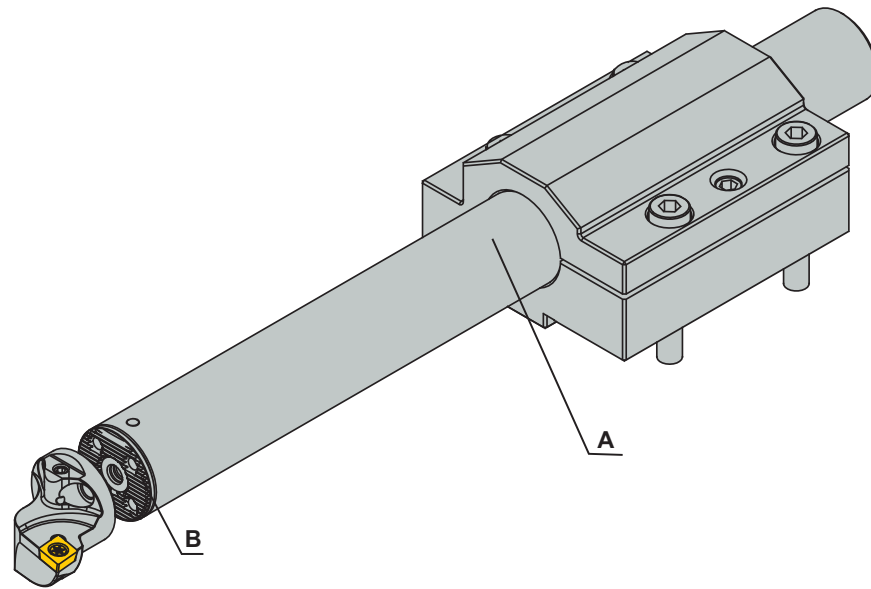
DESIGNATION	CLAMPING SCREW	ADJUSTING SCREW	ALLEN KEY FOR CLAMPING	ALLEN KEY FOR ADJUSTING SCREW
RE VH80-VT40R/L	SR50 M5X25	SR55 M6X12	KEY01 M5	KEY01 M2.5

ASSEMBLY AND ADJUSTING

PREPARATION

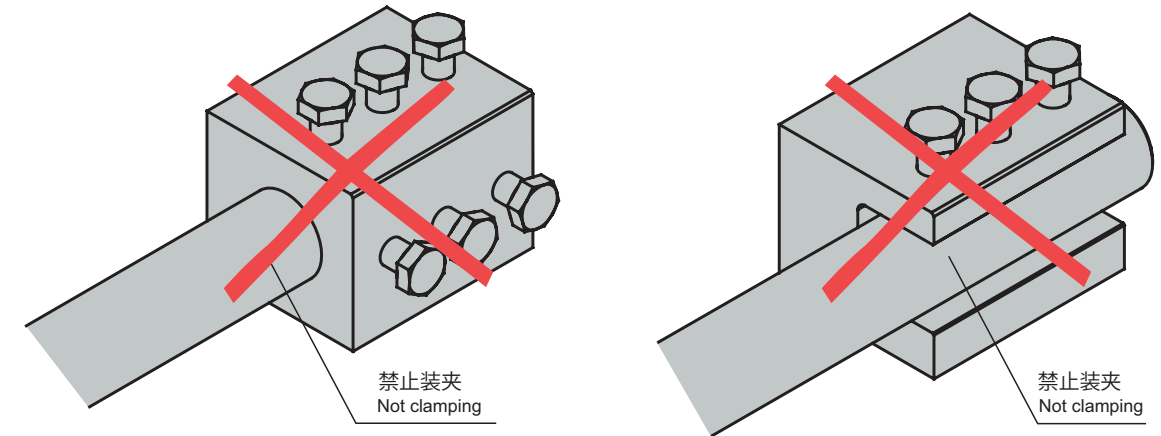
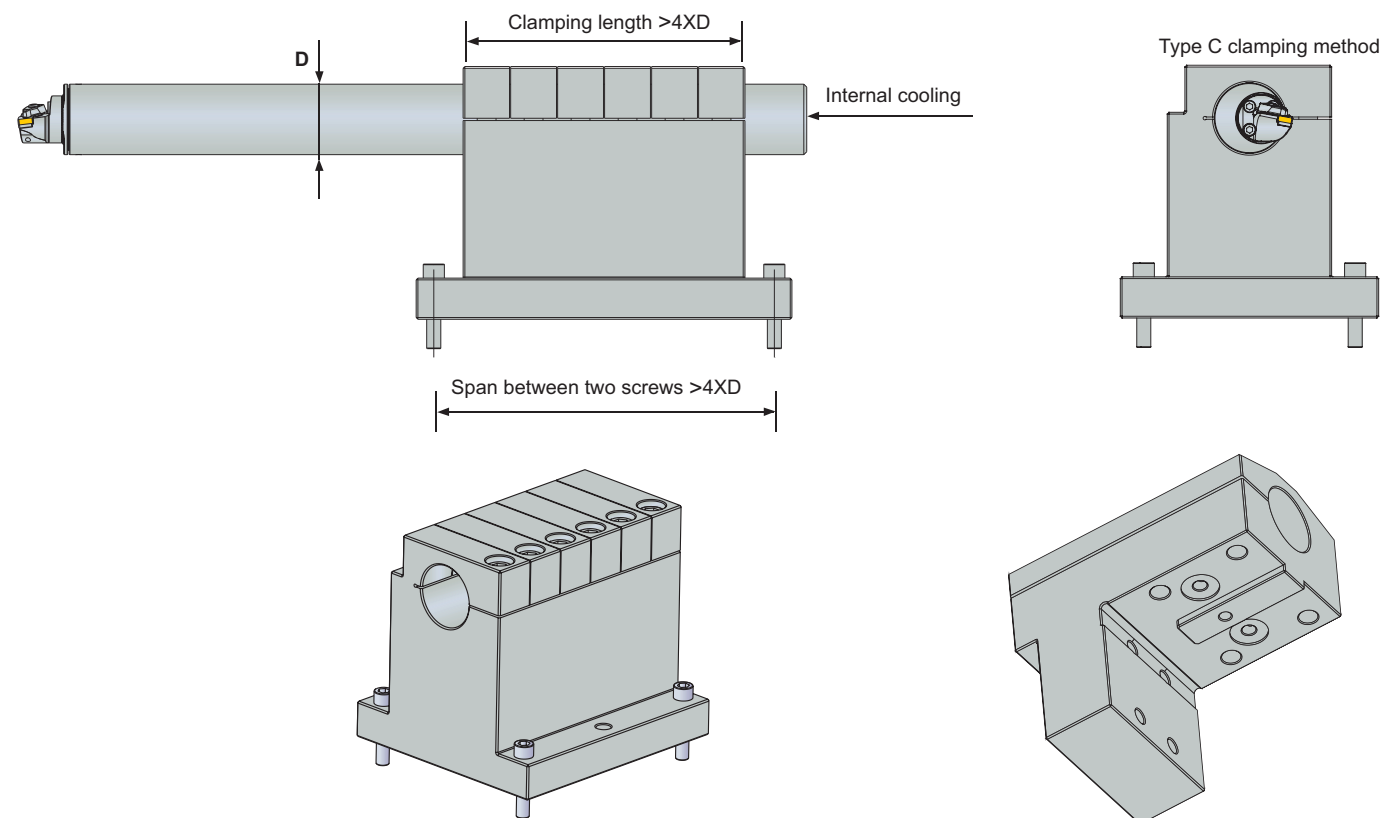
Wipe clean the positions which need to be assembled, like V geometric slot on the cartridge and shank, the end of the shank which will be connected with adaptor, and internal hole on the clamping holder.

See A and B position on the following visual.



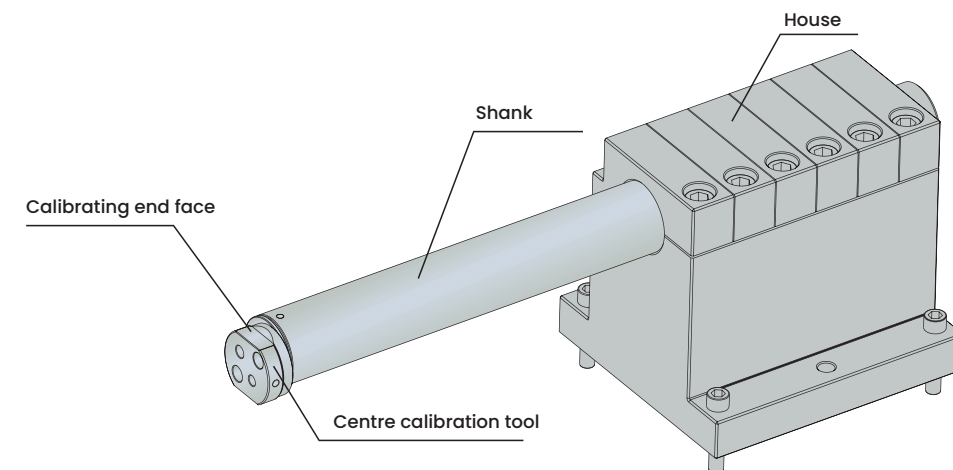
ASSEMBLY FOR THE SHANK

The clamping length should not be less than 4 L/D ratio. Suggest using the clamping cover with opening method and other holding clamping methods. Do not use screw clamping method. Use inner cooling please when working a long time.

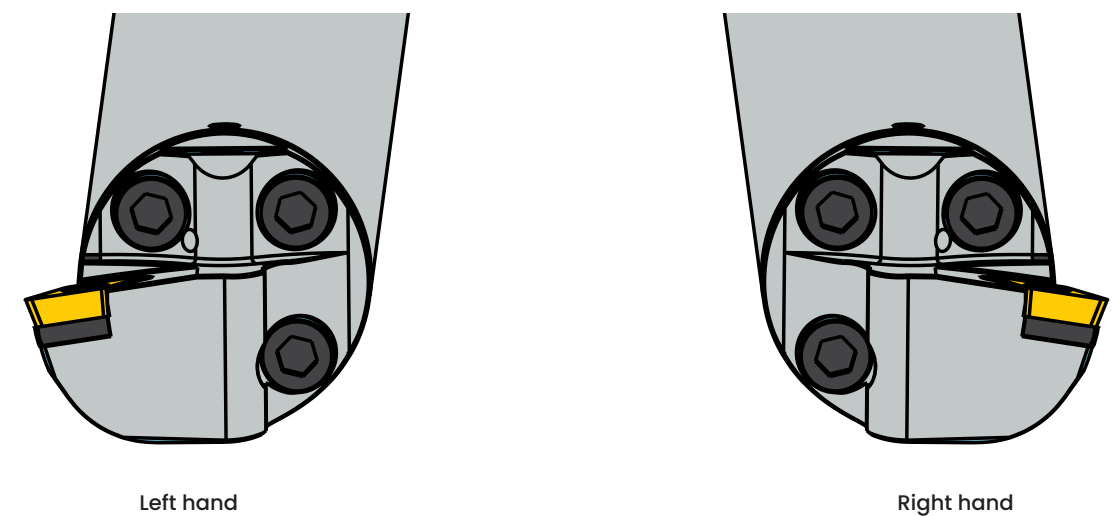


ADJUST THE HEIGHT OF THE CENTRE

Exclusive calibration tool for the height of centre should be used when assembling the shank at the first time. Assemble the shank into the V geometric slot firstly, then calibrate it within 0.01 tolerance on the X-axis direction.



To assemble the right cartridge, see below figure.

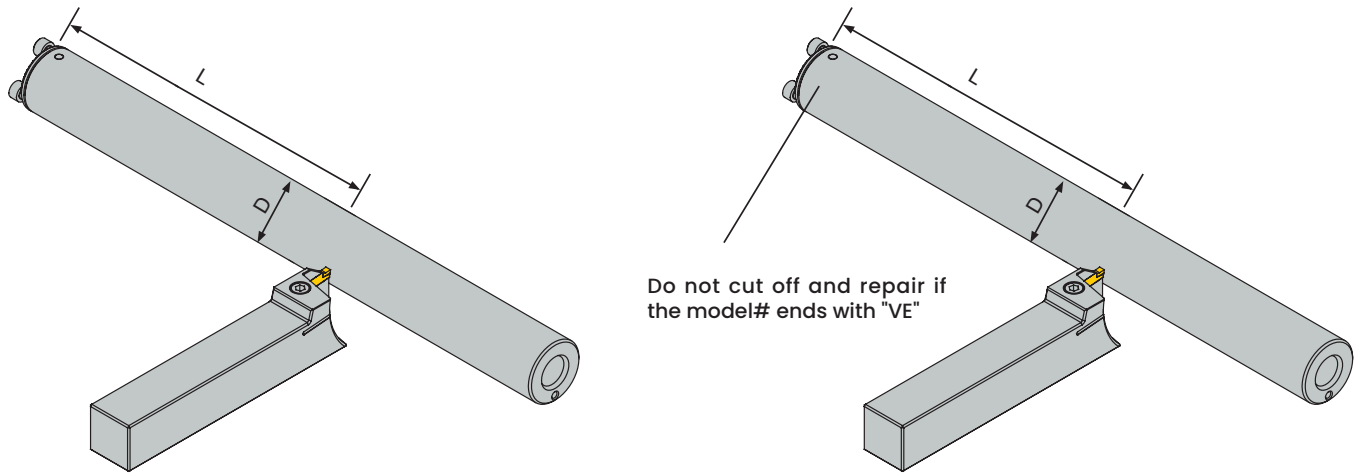


ADJUSTING THE LENGTH OF THE SHANK

- Suggested min. clamping length is 4xD
- The boring bar can be cut off , the fi nal length please see below fi gure:clamping holder. See A and B position on the following visual:

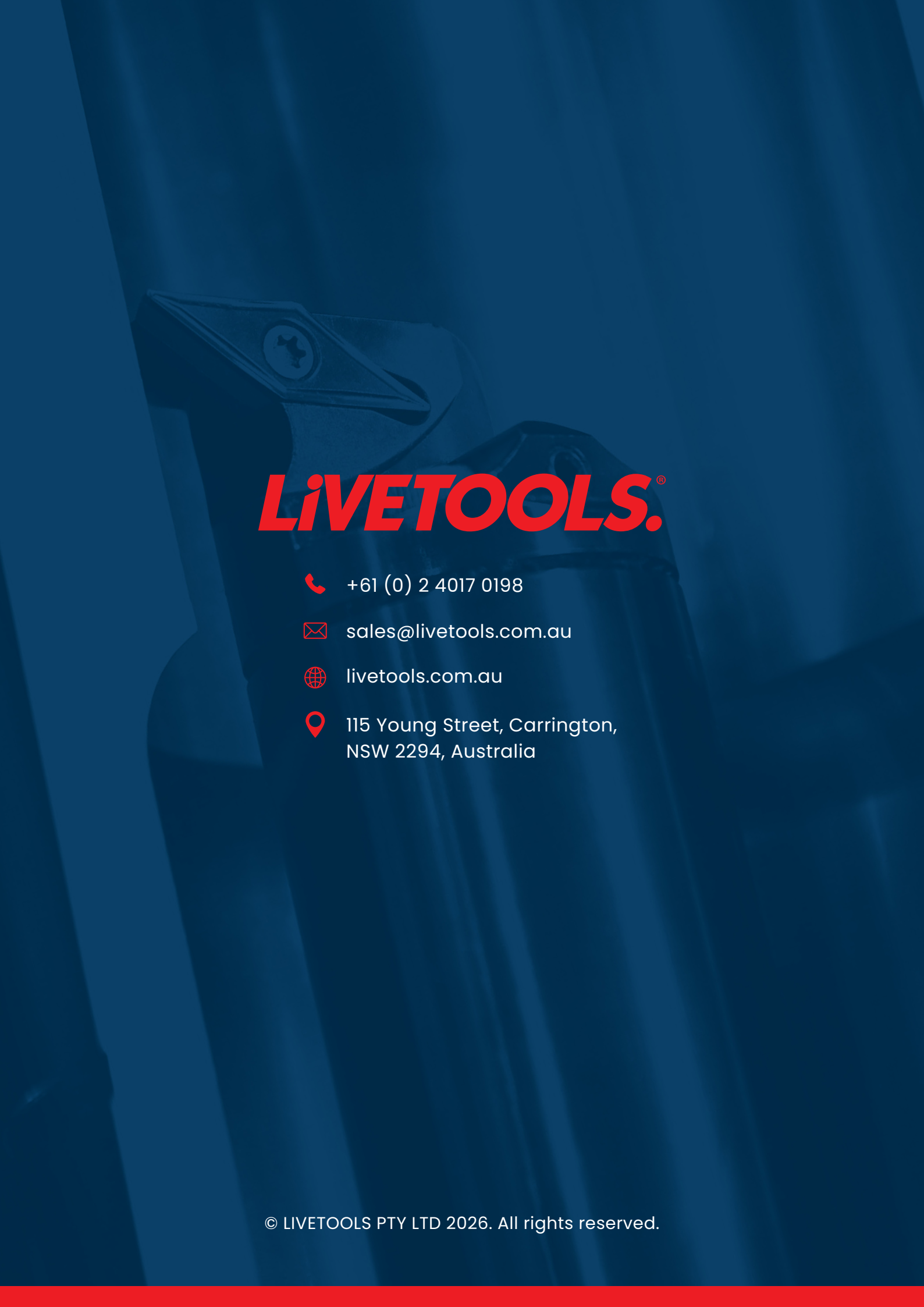
TYPE	MINIMUM LENGTH AFTER CUTTING OF	
D (mm)	4-7XD(MM)	7-10XD(MM)
16	100	-
20	125	-
25	155	255
32	190	320
40	240	410
50	305	520
60	380	630
80	630	630
100	770	770

- Please do not cut off the adjusting length if the shank designation ends in VE. Example: VT16 C16x204VE, see below figure:



ENVIRONMENT FOR THE DAMPING TURNING TOOL

DESIGNATION	OVERHANG LENGTH/ DIAMETER	MAXIMUM INTERNAL COOLING PRESSURE	MINIMUM LENGTH AFTER CUTTING OF
VT16 C16X156V	7	30	100
VT16 C16X204VE	10	30	100
VT20 C20X200V	7	30	100
VT20 C20X260VE	10	30	100
VT25 C25X255V	7	40	100
VT25 C25X330V	10	40	100
VT32 C32X320V	7	50	100
VT32 C32X416V	10	50	100
VT40 C40X408V	7	70	100
VT40 C40X528V	10	70	100
VT50 C50X518V	7	70	100
VT50 C50X668V	10	70	100
VT60 C60X628V	7	70	100
VT60 C60X808V	10	70	100
VH80 C80X880V	7	70	100
VH80 C80X1200V	10	70	100



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