

SCLCR 10-3 or 103 is a 5/8" square shank and takes a fairly-common CCMT or CCGT 32.5x insert that has a good strong 80° included angle to allow turning and facing with the same holder. CCMT/CCGT inserts are often used in boring bars, the 32.5 insert size boring bars are usually available 0.5", 0.625" and 0.75" diameters.

SCLC 80 Degree rhombic neutral rake uses CC..32.5 inserts such as CCMT or CCGT 32.51 or 32.52

Kennametal - SCLCRF 103B, Right Hand, -5 Degree Lead Angle, 5/8 Inch Shank Height

Kennametal - 1094483 - Indexable Turning Toolholders | Hand of Holder: Right Hand | Rake: Neutral

Kennametal - SCLCLF 103B, Left Hand, -5 Degree Lead Angle, 5/8 Inch Shank Height

Kennametal - 1094484 - Indexable Turning Toolholders | Hand of Holder: Left Hand | Rake: Neutral

Kennametal - SCMCN 103 Neutral, -5 Degree Lead Angle, 5/8 Inch Shank Height

Kennametal - 1094501 - Indexable Turning Toolholders | Hand of Holder: Neutral | Rake: Neutral



SDJC 55 Degree diamond neutral rake uses DC..32.5 Inserts such as DCMT or DCGT 32.51 or 32.52. This is a narrow profile insert, good for getting into tight (narrow) cutting areas, neutral works well for chamfering.

Kennametal - SDJCRF 103B, Right Hand, -3 Degree Lead Angle, 5/8 Inch Shank Height

Kennametal - 1094527 - Indexable Turning Toolholders | Hand of Holder: Right Hand | Rake: Neutral

Kennametal - SDJCLF 103B, Left Hand, -3 Degree Lead Angle, 5/8 Inch Shank Height

Kennametal - 1094528 - Indexable Turning Toolholders | Hand of Holder: Left Hand | Rake: Neutral

Kennametal - SDPCN103B, Neutral, 5/8 Inch Shank Height, 5/8 Inch Shank

Kennametal - 1772115 - Indexable Turning Toolholders | Hand of Holder: Neutral | Rake: Neutral



WNMG33x size trigon shape insert. It also has the 80° included angle, so it can face and turn like a CNMG but it's smaller and has 6 cutting edges vs. four. The holder for it in a 5/8" shank would be a MWLNR 10-3 or 103. The WNMG (trigon) insert gives you pretty much the same flexibility as the CNMG for general turning and facing, but has six cutting edges instead of four and easier to get in closer to the work piece. WNMG is also often used for boring bars. I have my WNMG holder setup for aluminum with 331 inserts.

MWLN Trigon negative rake

Seco - MWLNL 10-3A, Left Hand, -5 Degree Lead Angle, 5/8 Inch Shank Height

Seco - 56399 - Indexable Turning Toolholders | Hand of Holder: Right Hand | Rake: Negative

Seco - MWLNR 10-3A, Right Hand, -5 Degree Lead Angle, 5/8 Inch Shank Height, 5/8 Inch

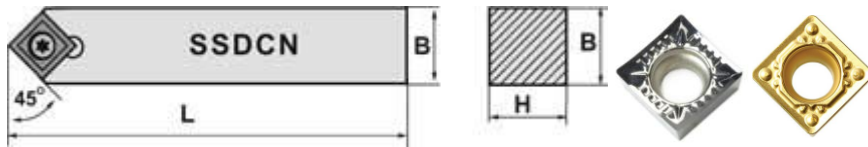
Seco - 56400 - Indexable Turning Toolholders | Hand of Holder: Left Hand | Rake: Negative



SSD Tool Holder SCMT SCGT square use with SCMT, SCGT SCGX 32..5. inserts, this is used primarily to cut 45 degree bevels. The Toolmex is inexpensive and works well.

SSDCN 10-3B Tool holder Toolmex Item #: 6-810-110

SSDCN Style, Neutral hand, 5/8 Inch Square Shank Toolholder, 4.50 OAL, with 45° Lead for SCxx 32.5X Inserts



Kennametal –SCLCRF 103B Tool Holder uses CCMT or CCGT 32.51 or 32.52



Seco - MWLNR 10-3A Tool Holder uses WNMG 33.. inserts



Kennametal -SDJCRF 103B Tool Holder uses DCMT or DCGT 32.51 or 32.52



Examples of inserts, in general for steel and tough alloys you want a coated insert (usually gold, grey or black) and the insert is usually Molded and less sharp, so CCMT 32.52 or 32.51. On softer materials you usually want a sharper positive Ground edge and usually uncoated (shiny polished surface), so CCGT 32.51. The last numeral is the nose of the insert, the lower the number the sharper the nose. Also to make things even more confusing there is two separate naming terminologies called ISO and ANSI: see <http://www.carbidedepot.com/formulas-insert-d.htm>

