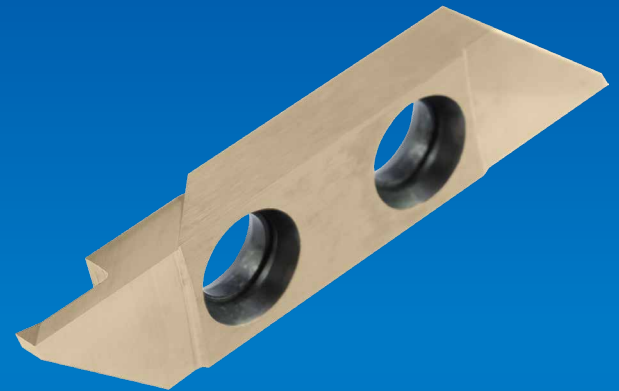
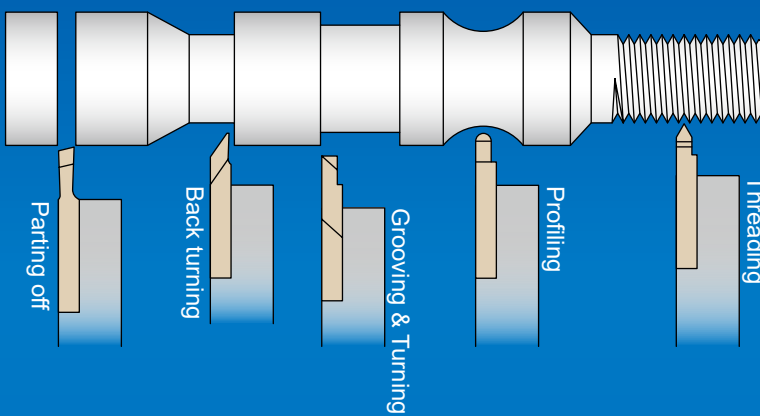
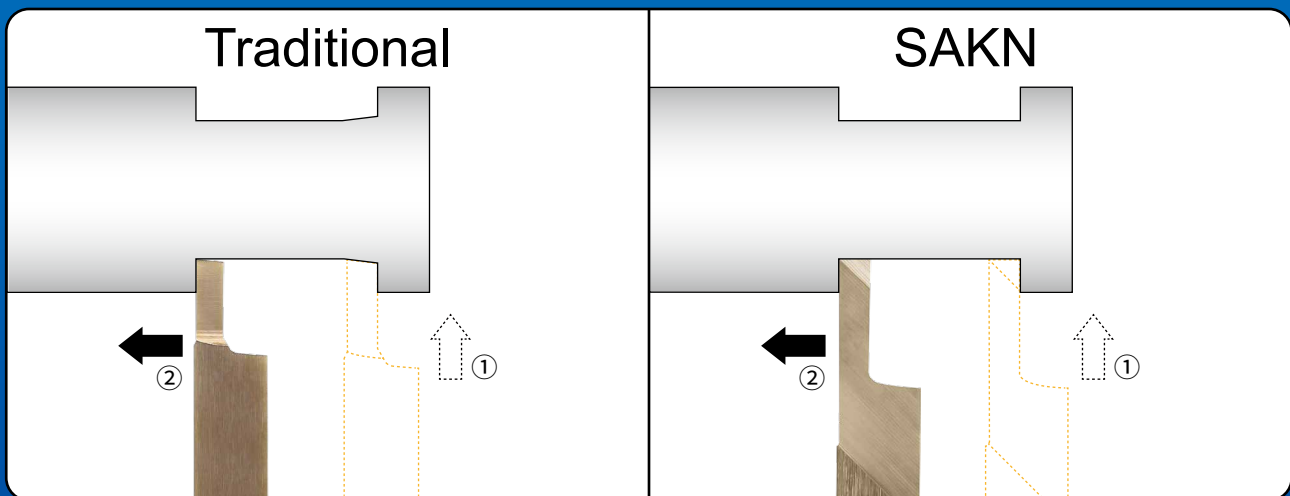


# SAKG Auto Lathe Turning Tools



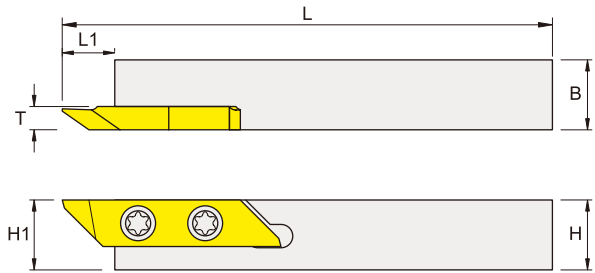
New Cutting Edge

- Multifunction turning tools:  
grooving & turning / back turning / parting off /  
profiling / threading.



Multifunction Turning - SAKG

Tool Holder Specifications

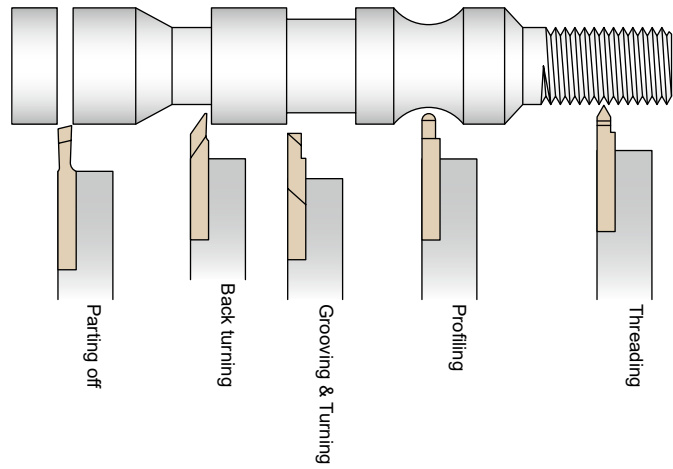


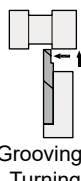
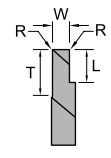
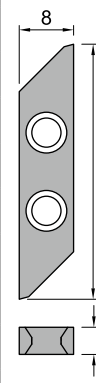
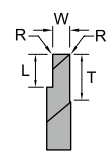
Right-hand shown

Order No.	Item Specification	Dimensions (mm)					Insert	Screw	Wrench
		H(H1)	B	L	L1	T			
ISAKGR1010K	SAKGR-1010K-374	10	10	125	9	4	SAK...	IMS3509A	ITK15
ISAKGL1010K	SAKGL-1010K-374	10	10	125	9	4			
ISAKGR1212K	SAKGR-1212K-374	12	12	125	9	4			
ISAKGL1212K	SAKGL-1212K-374	12	12	125	9	4			
ISAKGR1212M	SAKGR-1212M-374	12	12	150	9	4			
ISAKGL1212M	SAKGL-1212M-374	12	12	150	9	4			
ISAKGR1616M	SAKGR-1616M-374	16	16	150	9	4			
ISAKGL1616M	SAKGL-1616M-374	16	16	150	9	4			
ISAKGR2020K	SAKGR-2020K-374	20	20	125	9	4			
ISAKGL2020K	SAKGL-2020K-374	20	20	125	9	4			
ISAKGR2525M	SAKGR-2525M-374	25	25	150	9	4			
ISAKGL2525M	SAKGL-2525M-374	25	25	150	9	4			

Multifunction Turning - SAKG

Insert Specifications



Inserts	Designation	Grade No.				Dimensions (mm)					Drawing	
		CP6025				W	R	L	K	T		
 <p>Grooving / Turning</p>	 <p>Right hand</p>	SAKNR10012	✓				1.0	0.1	2	-	8	 <p>Right hand insert shown</p>
		SAKNR10022	✓				1.0	0.2	2	-	8	
		SAKNR15013	✓				1.5	0.1	3	-	8	
		SAKNR15023	✓				1.5	0.2	3	-	8	
		SAKNR20014	✓				2.0	0.1	4	-	8	
		SAKNR20024	✓				2.0	0.2	4	-	8	
		SAKNR25015	✓				2.5	0.1	5	-	8	
		SAKNR25025	✓				2.5	0.2	5	-	8	
		SAKNR30016	✓				3.0	0.1	6	-	8	
		SAKNR30026	✓				3.0	0.2	6	-	8	
	 <p>Left hand</p>	SAKNL10012	✓				1.0	0.1	2	-	8	
		SAKNL10022	✓				1.0	0.2	2	-	8	
		SAKNL15013	✓				1.5	0.1	3	-	8	
		SAKNL15023	✓				1.5	0.2	3	-	8	
		SAKNL20014	✓				2.0	0.1	4	-	8	
		SAKNL20024	✓				2.0	0.2	4	-	8	
		SAKNL25015	✓				2.5	0.1	5	-	8	
		SAKNL25025	✓				2.5	0.2	5	-	8	
		SAKNL30016	✓				3.0	0.1	6	-	8	
		SAKNL30026	✓				3.0	0.2	6	-	8	

Multifunction Turning - SAKG

Insert Specifications

Inserts	Designation	Grade No.					Dimensions (mm)					Drawing	
		CP6025					W	R	L	K	T		
<p>Grooving</p>	<p>Right hand</p>	SAKGR10012	✓					1.0	0.1	2.0	-	-	<p>Right hand insert shown</p>
		SAKGR15013	✓					1.5	0.1	3.0	-	-	
		SAKGR15023	✓					1.5	0.2	3.0	-	-	
		SAKGR20014	✓					2.0	0.1	4.0	-	-	
		SAKGR20024	✓					2.0	0.2	4.0	-	-	
		SAKGR25015	✓					2.5	0.1	5.0	-	-	
		SAKGR25025	✓					2.5	0.2	5.0	-	-	
		SAKGR30016	✓					3.0	0.1	6.0	-	-	
		SAKGR30026	✓					3.0	0.2	6.0	-	-	
	<p>Left hand</p>	SAKGL10012	✓					1.0	0.1	2.0	-	-	
		SAKGL15013	✓					1.5	0.1	3.0	-	-	
		SAKGL15023	✓					1.5	0.2	3.0	-	-	
		SAKGL20014	✓					2.0	0.1	4.0	-	-	
		SAKGL20024	✓					2.0	0.2	4.0	-	-	
		SAKGL25015	✓					2.5	0.1	5.0	-	-	
		SAKGL25025	✓					2.5	0.2	5.0	-	-	
		SAKGL30016	✓					3.0	0.1	6.0	-	-	
		SAKGL30026	✓					3.0	0.2	6.0	-	-	
<p>Back turning</p>	<p>Right hand</p>	SAKBR20005	✓					2.0	-	5.0	35°	0.5	
		SAKBR20015	✓					2.0	0.1	5.0	35°	0.5	
		SAKBR20025	✓					2.0	0.2	5.0	35°	0.5	
		SAKBR30015	✓					3.0	0.1	5.0	35°	0.75	
		SAKBR30025	✓					3.0	0.2	5.0	35°	0.75	
	<p>Left hand</p>	SAKBL20005	✓					2.0	-	5.0	35°	0.5	
		SAKBL20015	✓					2.0	0.1	5.0	35°	0.5	
		SAKBL20025	✓					2.0	0.2	5.0	35°	0.5	
		SAKBL30015	✓					3.0	0.1	5.0	35°	0.75	
		SAKBL30025	✓					3.0	0.2	5.0	35°	0.75	

Multifunction Turning - SAKG

Insert Specifications

Inserts	Designation	Grade No.					Dimensions (mm)					Drawing	
		CP6025					W	R	L	K	Pitch		
<p>Parting off</p>	<p>Right hand</p>	SAKCR15018	✓					1.5	0.1	8.5	15°	-	<p>Right hand insert shown</p>
		SAKCR20019	✓					2.0	0.1	9.0	15°	-	
		SAKCR25019	✓					2.5	0.1	9.0	15°	-	
		SAKCR30019	✓					3.0	0.1	9.0	15°	-	
	<p>Left hand</p>	SAKCL15018	✓					1.5	0.1	8.5	15°	-	
		SAKCL20019	✓					2.0	0.1	9.0	15°	-	
		SAKCL25019	✓					2.5	0.1	9.0	15°	-	
	SAKCL30019	✓					3.0	0.1	9.0	15°	-		
<p>Profiling</p>	<p>Right hand</p>	SAKPR10053	✓					1.0	0.5	3.0	-	-	
		SAKPR15075	✓					1.5	0.75	5.0	-	-	
		SAKPR20105	✓					2.0	1.0	5.0	-	-	
		SAKPR25125	✓					2.5	1.25	5.0	-	-	
		SAKPR30158	✓					3.0	1.5	8.0	-	-	
	<p>Left hand</p>	SAKPL10053	✓					1.0	0.5	3.0	-	-	
		SAKPL15075	✓					1.5	0.75	5.0	-	-	
		SAKPL20105	✓					2.0	1.0	5.0	-	-	
		SAKPL25125	✓					2.5	1.25	5.0	-	-	
		SAKPL30158	✓					3.0	1.5	8.0	-	-	
<p>Threading</p>	<p>Right hand</p>	SAKTR20655	✓					2.0	0.05	6.0	55°	0.5~2	
		SAKTR30655	✓					3.0	0.1	6.0	55°	1~3	
		SAKTR20660	✓					2.0	0.05	6.0	60°	0.5~2	
		SAKTR30660	✓					3.0	0.1	6.0	60°	1~3	
	<p>Left hand</p>	SAKTL20655	✓					2.0	0.05	6.0	55°	0.5~2	
		SAKTL30655	✓					3.0	0.1	6.0	55°	1~3	
		SAKTL20660	✓					2.0	0.05	6.0	60°	0.5~2	
		SAKTL30660	✓					3.0	0.1	6.0	60°	1~3	

Recommended Cutting Conditions

For Grooving & turning, Back turning and Parting off

Working Material	Vc (m/min)	fr (mm/rev)
Carbon Steel / Alloy Steel	50 ~ 200	0.02 ~ 0.10
Stainless Steel	50 ~ 200	0.02 ~ 0.10
Cast Iron	50 ~ 200	0.02 ~ 0.10
Aluminum Alloy	200 ~ 300	0.05 ~ 0.15
High Temperature Alloy	80 ~ 120	0.03 ~ 0.07
Hardened Steel	80 ~ 120	0.03 ~ 0.07