

CSV Series

Tooling for small diameter parts

Best tool for up to 5mm diameter materials



Features

- Very up- sharp edge with mirror finish provides superior precise machining
- Interchangeable tool : All the inserts can use the same toolholder
- Specially designed edge shape for small diameter machining



CSV toolholder



CSVF

Front turning



CSVT

Threading



CSVB

Back turning



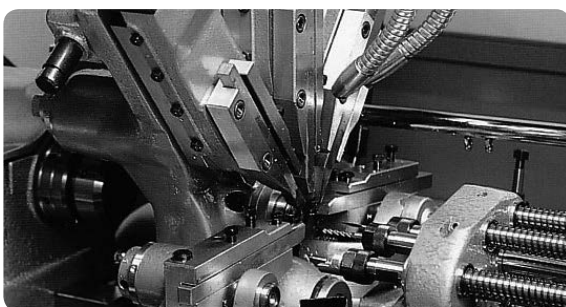
CSVC

Cut-off



CSVG

Grooving



- Holders for Cam-style machine also available

CSV Series

CSV

For Cam-style machine

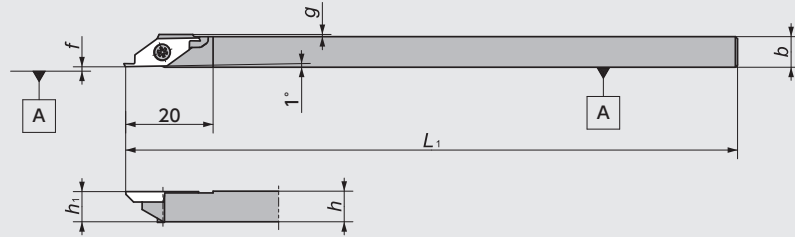


Figure-1

●Right-Hand style shown

CSV-NC

For Gang-style machine

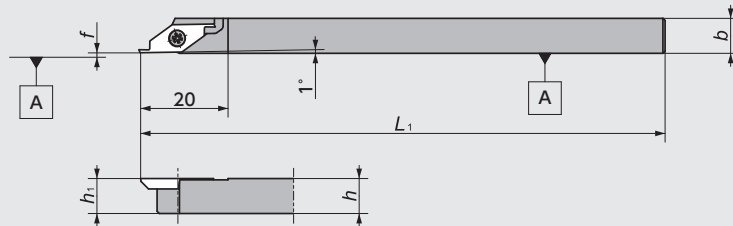


Figure-2

●Right-Hand style shown

CSV-NC-F

For Gang-style machine

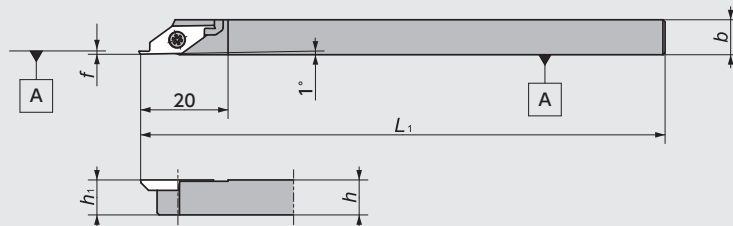


Figure-3

●Right-Hand style shown

CSV Series - Toolholders

Figure	Code No.		Item Number	Stock		Dimensions (mm)						Gage insert	Spare Parts		
	R	L		R	L	h	b	L ₁	h ₁	f	g		Clamp Screw	Wrench	
1	5492962		CSV ^{R/L} 07GX	●		7	7	85	7	0.1	0.5	CSVF CSVB CSVG CSVV CSVW G96~97	LRIS-2.5*7	CLR-15S	
	5303169	5303193	07	●	●			140							
	5492954		08GX	●		8	8	85	8						
	5303151	5303201	08	●	●			140							
	5303136		095	●		9.5	9.5	140	9.5						0.0
	5303144	5303177	10	●	●	10	10	10							
	5474770		12GX	●		12	12	85	12						
	5327929		12	●				140							
2	5514062	5514070	CSV ^{R/L} 08NC	●	●	8	8	120	8	0.1	-	CSVF CSVB CSVG CSVV CSVW G96~97	LRIS-2.5*7	CLR-15S	
	5563010		10GXNC	●		10	10	85	10						
	5477492	5477542	10NC	●	●			120							
	5477534	5477500	12NC	●	●	12	12	12							
3	5789615		CSV ^{R/L} 08NC-F	●		8	8	120	8	0.0~0.1	-	CSVF CSVB CSVG CSVV CSVW G96~97	LRIS-2.5*7	CLR-15S	

CSV Series - Inserts

Front turning

● CSVF Mirror finish

Shape	Item Number	Chip-breaker	Max Depth of cut (mm)	Dimensions (mm)			PVD Coated Carbide											
				Edge Geometry ($\alpha \times \beta^\circ$)	r_ϵ	ZM3				VM1				DT4				
						R	Stock	L	Stock	R	Stock	L	Stock	R	Stock	L	Stock	
<p>● Right-Hand style shown</p>	CSVF11F ^{R/L} V M	No	—	0.3×5°	0.0					5303516	●	5303557	●					
	11F ^{R/L} V-A M					0.3×2°					5358858	●						
	11F ^{R/L} V-M M					0.15×2°	5436019	●	5386248	●	5386255	●	5850235	●				
	11F ^{R/L} V-C M					0.15×5°					5358577	●						
<p>● Right-Hand style shown</p>	CSVF11F ^{R/L} VB M	Yes	3.0	0.3×5°	0.0					5313168	●	5313150	●					
	11F ^{R/L} VB-A M					0.3×2°					5358692	●						
	11F ^{R/L} VB-M M					0.15×2°	5436001	●	5386263	●	5386271	●	5850243	●				
	11F ^{R/L} VB-C M					0.15×5°					5358700	●						
<p>● Left-Hand style shown</p>	CSVF11F ^{R/L} VX M	No	—	—	0.0									5358866	●			

Note: All angles shown are obtained when insert is set in the holder.

Back turning

● CSVB Mirror finish

Shape	Item Number	Chip-breaker	Length of Blade a (mm)	Max Depth of cut (mm)	Dimensions (mm)			PVD Coated Carbide											
					W	Edge Geometry ($\alpha \times \beta^\circ$)	r_ϵ	ZM3				VM1				DT4			
								R	Stock	L	Stock	R	Stock	L	Stock	R	Stock	L	Stock
<p>● Right-Hand style shown</p>	CSVB11F ^{R/L} V M	No	0.7	2.0	1.00	0.0	0.3×5°					5303573	●	5303532	●				
	11F ^{R/L} V-A M		0.7					0.3×2°					5358791	●					
	11F ^{R/L} V-M M		0.7					0.15×2°	5435995	●	5386289	●	5386297	●	5827480	●			
	11F ^{R/L} V-C M		0.7					0.15×5°					5358809	●					
	11F ^{R/L} V12 M		0.8					0.3×5°					5344890	●					
	11F ^{R/L} V14 M		1.0					0.3×5°					5344908	●					
<p>● Right-Hand style shown</p>	CSVB11F ^{R/L} VB M	Yes	0.7	2.0	1.00	0.0	0.3×5°					5358825	●						
	11F ^{R/L} VB-A M		0.7					0.3×2°					5358833	●					
	11F ^{R/L} VB-M M		0.7					0.15×2°	5435987	●	5386305	●	5386313	●	5827472	●			
	11F ^{R/L} VB-C M		0.7					0.15×5°					5358841	●					
	11F ^{R/L} VB12 M		0.8					0.3×5°					5358718	●					
	11F ^{R/L} VB14 M		1.0					0.3×5°					5358726	●					
<p>● Left-Hand style shown</p>	CSVB11F ^{R/L} VX M	No	—	—	—	0.0									5358817	●			

Note: All angles shown are obtained when insert is set in the holder.

Cut-off

● CSVC Mirror finish

Shape	Item Number	Chip-breaker	※ 1 Max. Cut-off Dia (mm) ϕD	Dimensions (mm)			PVD Coated Carbide			
				A	r_ϵ	w	VM1			
							R	Stock	L	Stock
<p>Thickness:2.38</p> <p>● Right-Hand style shown</p>	CSVC11FR/V06	No	3.0	0.31	0.0	0.6	5352547	●		
	11FR/V07		0.36	0.7		5324272	●	5330840	●	
	11FR/V08		0.41	0.8		5324256	●	5330832	●	
	11FR/V09		0.46	0.9		5352554	●			
	11FR/V10		0.51	1.0		5303490	●	5303599	●	
	11FR/V13		0.65	1.3		5311824	●	5311816	●	
	11FR/V15		0.74	1.5		5303615	●	5303631	●	
<p>Thickness:2.38</p> <p>● Right-Hand style shown</p>	CSVC11FR/VB06	Yes	3.0	0.31	0.0	0.6	5358734	●		
	11FR/VB07		0.36	0.7		5358742	●			
	11FR/VB08		0.41	0.8		5358767	●			
	11FR/VB09		0.46	0.9		5358775	●			
	11FR/VB10		0.51	1.0		5358783	●			
	11FR/VB13		0.65	1.3		5358676	●			
	11FR/VB15		0.74	1.5		5358668	●			

※ 1: Max. cut-off diameter shows when X end point is 0.0. For more information, see page G67.

※ 2: All angles shown are obtained when insert is set in the holder.

Grooving

● CSVG Mirror finish

Shape	Item Number	Chip-breaker	Max Depth of cut (mm)	Dimensions (mm)			PVD Coated Carbide				
				w	L	r_ϵ	VM1				
							R	Stock	L	Stock	
<p>Thickness:2.38</p> <p>● Right-Hand style shown</p>	CSVG11FR/V025	No	0.15	0.25	0.50	0.0	0.25	5354634	●		
	11FR/V030						0.30	5344940	●		
	11FR/V035						0.35	5354402	●		
	11FR/V040		0.40	5344932	●						
	11FR/V045		0.45	5354394	●						
	11FR/V050		0.50	5354642	●						
	11FR/V055		0.55	5344924	●						
	11FR/V060		0.60	5344916	●						
	11FR/V065		0.65	5354410	●						
	11FR/V070		0.70	5354428	●						
	11FR/V075		0.75	5332812	●	5332820	●				
	11FR/V080		0.80	5358650	●						
	11FR/V085		0.85	5354436	●						
	11FR/V090		0.90	5354444	●						
	11FR/V095		0.95	5332846	●	5332838	●				
	11FR/V100		1.00	5352562	●						
	11FR/V110		1.10	5358643	●						
	11FR/V120		1.20	5352570	●	5357561	●				
	11FR/V130		1.30	5358627	●						
	11FR/V140		1.40	5358619	●						
11FR/V150	1.50	5358601	●								

Threading

● CSVT Mirror finish

Shape	Item Number	Chip-breaker	Pitch	Dimensions (mm)		PVD Coated Carbide			
				r_ϵ	VM1				
					R	Stock	L	Stock	
<p>Thickness:2.38</p> <p>● Right-Hand style shown</p>	CSVT11FR/LP60-035A	No	0.2 ~ 0.5	R0.03MAX	5344874	●	5386909	●	
<p>Thickness:2.38</p> <p>● Right-Hand style shown</p>	CSVT11FR/LP60-035B	No	0.2 ~ 0.5	R0.03MAX	5344882	●	5386917	●	

Note: All angles shown are obtained when insert is set in the holder.

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