

CUT DUO Series

Parting-off | CNC automatic lathe



New

Expanded lineup for **2.5mm (.098")** width insert parting-off toolholders
Internal coolant supply ensures efficient cutting edge cooling and extend tool life

CERtainly | but not only | *CERamics*
Outstanding solutions for demanding applications

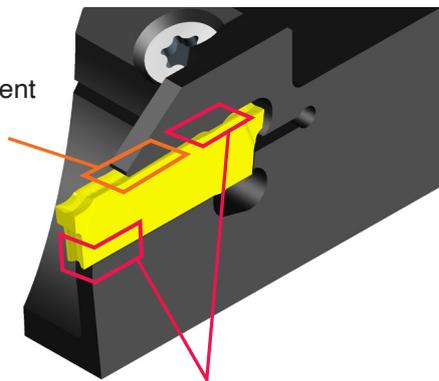


| Features

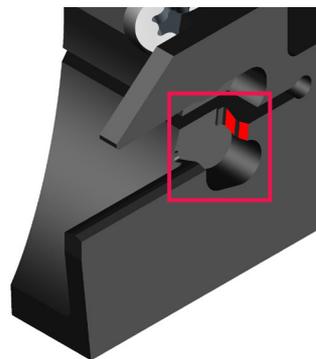
- Achieve stable machining with the combination of mold chipbreaker and high-rigidity toolholder
- Enhanced cutting performance with polished insert relief surfaces
- Extended tool life and improved chip control using internal coolant supply

| Toolholder Design and Structure

Pull-in structure to prevent insert dislodgement

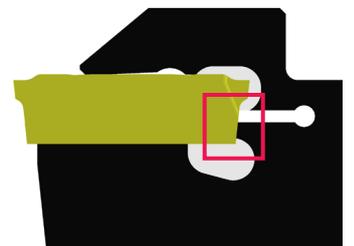


Effortless insertion with precision guide design



Reliable clamping for lead-angle inserts — thanks to convex-surface restraint!

Delivers stable performance even under high-feed conditions



CUT DUO Series

Parting-off | CNC automatic lathe

Expanded lineup

- Toolholder designed for a maximum parting-off diameter of $\phi 25.4\text{mm}(1.000\text{'})$, offering two insert widths [2.0 / 2.5mm(.079" / .098")]
- Optimized design delivers higher rigidity [maximum parting-off diameter $\phi 34.0\text{mm}(1.339\text{'})$]

Toolholder lineup expanded for insert width of 2.5mm(.098")

New



Max. Parting-off Dia.	$\phi 25.4\text{mm}$ (1.000")		$\phi 34\text{mm}$ (1.339")
Insert width	2.0mm (.079")	2.5mm (.098")	2.5mm (.098")
Shank			
16 x16mm (.630" x .630")	●	●	●

Chip control performance

- Chips are curled compactly to prevent chip problems

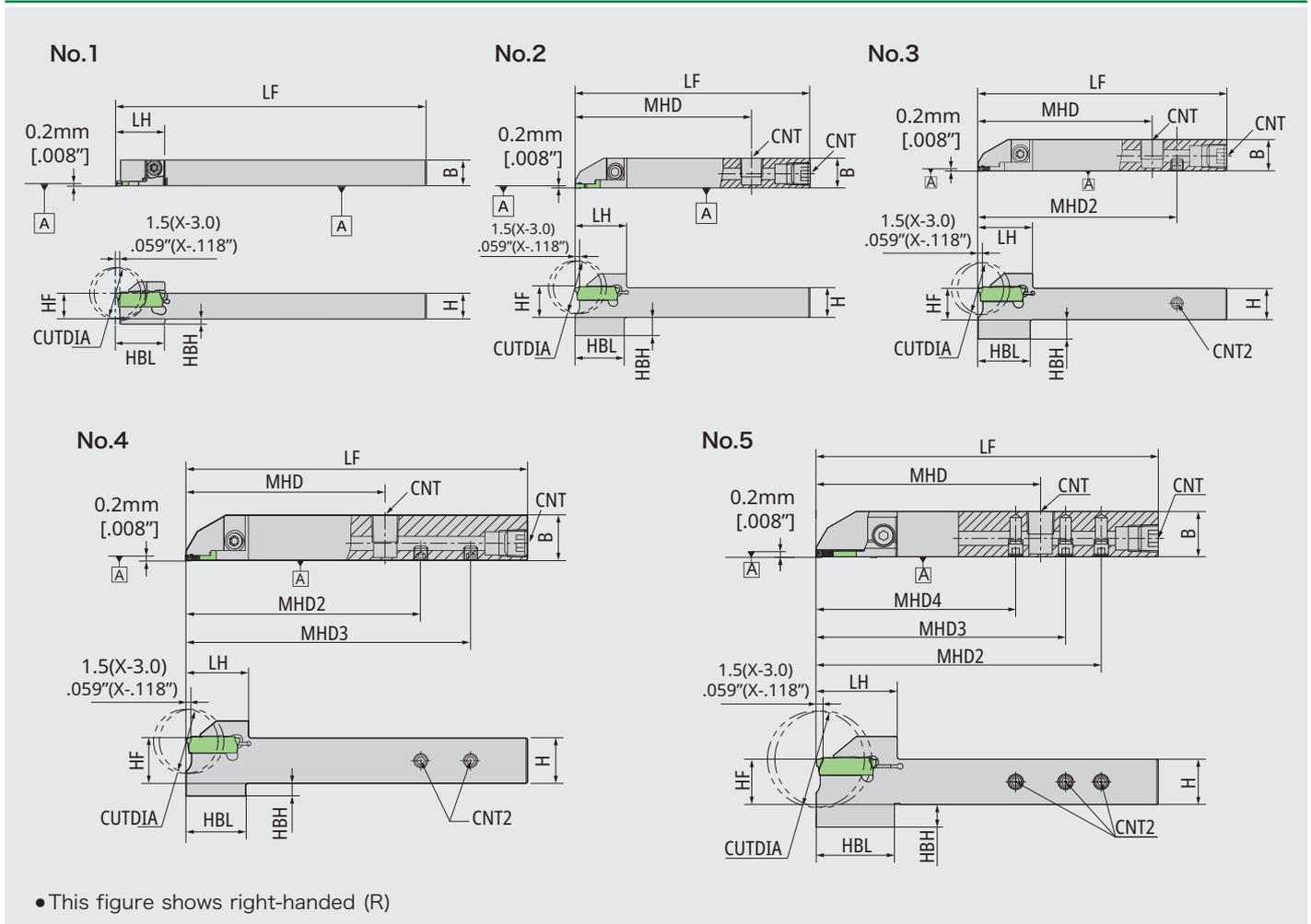
$V_c=80\text{m/min}(270\text{ SFM})$

Material	f	0.05mm/rev (.002 IPR)	0.08mm/rev (.003 IPR)	0.12mm/rev (.005 IPR)
		P SCM435		
M SUS304				

Recommended cutting condition

ISO Classification		P		M		S	
Workpiece material		Alloy steel	Carbon steel	Difficult-to-cut Stainless steel	Free-cutting Stainless steel	HRSA	Titanium (Alloy)
Representative workpiece material		SCM435 SCr420	S10C S45C	SUS316L 17-4PH SUS304	SUS303 SUS430F	Inco718 Hastelloy MP35N	Ti-6Al-4V
Grade	1st choice	QM3		ST4		DM4	
	2nd choice	TM4		DM4		QM3	
Cutting speed	(m/min)	30 - 60 - 90		30 - 60 - 90		30 - 50 - 70	
	(SFM)	100 - 200 - 300		100 - 200 - 300		100 - 160 - 230	
Feed	(mm/rev)	0.04 - 0.08 - 0.12		0.03 - 0.08 - 0.12		0.03 - 0.05 - 0.08	
	(IPR)	.0016 - .0031 - .0047		.0012 - .0031 - .0047		.0012 - .0020 - .0031	

Lineup: Toolholder



Internal coolant NEW

Designation	Hand		CUTDIA mm	B mm	H mm	HF mm	LF mm	LH mm	HBH mm	HBL mm	CNT	CNT2	MHD mm	MHD2 mm	MHD3 mm	MHD4 mm	Insert	Figure	
	R	L																	
CTDP ^R _L 10-20D20	●	●	20	10	10	10	120	19	2	19	-	-	-	-	-	-	-	CTDP20..	1
CTDP ^R _L 12-20D20	●	●	20	12	12	12	120	19	-	-	-	-	-	-	-	-	-	CTDP20..	1
CTDP ^R _L 12-20D25	●	●	25.4	12	12	12	120	22	-	-	-	-	-	-	-	-	-	CTDP20..	1
CTDP ^R _L 12-20D25-OH	●	●	25.4	12	12	12	100	22	8.5	21	Rc1/8	-	75	-	-	-	-	CTDP20..	2
CTDP ^R _L 12-20D25-OH2	●	●	25.4	12	12	12	100	22	8.5	21	Rc1/8	M5	70	80	-	-	-	CTDP20..	3
CTDP ^R _L 16-20D25	●	●	25.4	16	16	16	120	22	-	-	-	-	-	-	-	-	-	CTDP20..	1
CTDP ^R _L 16-25D25	●	●	25.4	16	16	15.5	120	28.5	-	-	-	-	-	-	-	-	-	CTDP25..	1
CTDP ^R _L 16-20D25-OH	●	●	25.4	16	16	16	100	22	4.5	21	Rc1/8	-	75	-	-	-	-	CTDP20..	2
CTDP ^R _L 16-20D25-OH2	●	●	25.4	16	16	16	120	22	4.5	21	Rc1/8	M5	70	82.5	100	-	-	CTDP20..	4
CTDP ^R _L 16-20D25-OH3	●	●	25.4	16	16	15.5	120	22	4.5	21	Rc1/8	M5	78.75	100	87.5	70	-	CTDP20..	5
CTDP ^R _L 16-25D25-OH3	●	●	25.4	16	16	15.5	120	28.5	8	27.5	Rc1/8	M5	78.8	100	87.5	70	-	CTDP25..	5
CTDP ^R _L 16-20D32A	●	●	32	16	16	16	120	27.5	-	-	-	-	-	-	-	-	-	CTDP20..	1
CTDP ^R _L 2012-20D32A	●	●	32	12	20	20	120	29.5	-	-	-	-	-	-	-	-	-	CTDP20..	1
CTDP ^R _L 20-20D32A	●	●	32	20	20	20	120	29.5	-	-	-	-	-	-	-	-	-	CTDP20..	1
CTDP ^R _L 16-25D34A	●	●	34	16	16	16	120	28.5	-	-	-	-	-	-	-	-	-	CTDP25..	1
CTDP ^R _L 16-25D34A-OH3	●	●	34	16	16	16	120	28.5	8	27.5	Rc1/8	M5	78.8	100	87.5	70	-	CTDP25..	5
CTDP ^R _L 2012-25D34A	●	●	34	12	20	20	120	29.5	-	-	-	-	-	-	-	-	-	CTDP25..	1
CTDP ^R _L 20-25D34A	●	●	34	20	20	20	120	29.5	-	-	-	-	-	-	-	-	-	CTDP25..	1
CTDP ^R _L 20-25D34A-OH2	●	●	34	20	20	20	120	28.5	4	27.5	Rc1/8	M5	75	100	-	-	-	CTDP25..	3

Attention : Tightening the screw without the insert in place may deform the slit section, potentially preventing it from returning to its original shape even after the screw is properly fastened.

Spare parts

Designation	Screw	Screw	Screw	Wrench	Wrench	Figure
CTDP ^R _{1/4} 10-20D20	LRIS-4*12	-	-	LLR-25S	-	1
CTDP ^R _{1/4} 12-20D20	LRIS-4*12	-	-	LLR-25S	-	1
CTDP ^R _{1/4} 12-20D25	LRIS-4*12	-	-	LLR-25S	-	1
CTDP ^R _{1/4} 12-20D25-OH	LRIS-4*12	SPR1/8	-	LLR-25S	-	2
CTDP ^R _{1/4} 12-20D25-OH2	LRIS-4*12	SPR1/8	SS0505SC	LLR-25S	LW-2.5	3
CTDP ^R _{1/4} 16-20D25	LRIS-4*12	-	-	LLR-25S	-	1
CTDP ^R _{1/4} 16-25D25	LRIS-5*10	-	-	LLR-28S	-	1
CTDP ^R _{1/4} 16-20D25-OH	LRIS-4*12	SPR1/8	-	LLR-25S	-	2
CTDP ^R _{1/4} 16-20D25-OH2	LRIS-4*12	SPR1/8L	SS0505SC	LLR-25S	LW-2.5	4
CTDP ^R _{1/4} 16-20D25-OH3	LRIS-4*12	SPR1/8L	SS0505SC	LLR-25S	LW-2.5	5
CTDP ^R _{1/4} 16-25D25-OH3	LRIS-5*10	SPR1/8L	SS0505SC	LLR-28S	LW-2.5	5
CTDP ^R _{1/4} 16-20D32A	LRIS-5*10	-	-	LLR-28S	-	1
CTDP ^R _{1/4} 2012-20D32A	LRIS-5*10	-	-	LLR-28S	-	1
CTDP ^R _{1/4} 20-20D32A	LRIS-5*10	-	-	LLR-28S	-	1
CTDP ^R _{1/4} 16-25D34A	CS0516LSH	-	-	LW-3	-	1
CTDP ^R _{1/4} 16-25D34A-OH3	CS0516LSH	SPR1/8L	SS0505SC	LW-3	LW-2.5	5
CTDP ^R _{1/4} 2012-25D34A	CS0516LSH	-	-	LW-3	-	1
CTDP ^R _{1/4} 20-25D34A	CS0516LSH	-	-	LW-3	-	1
CTDP ^R _{1/4} 20-25D34A-OH2	CS0516LSH	SPR1/8L	SS0505SC	LW-3	LW-2.5	3

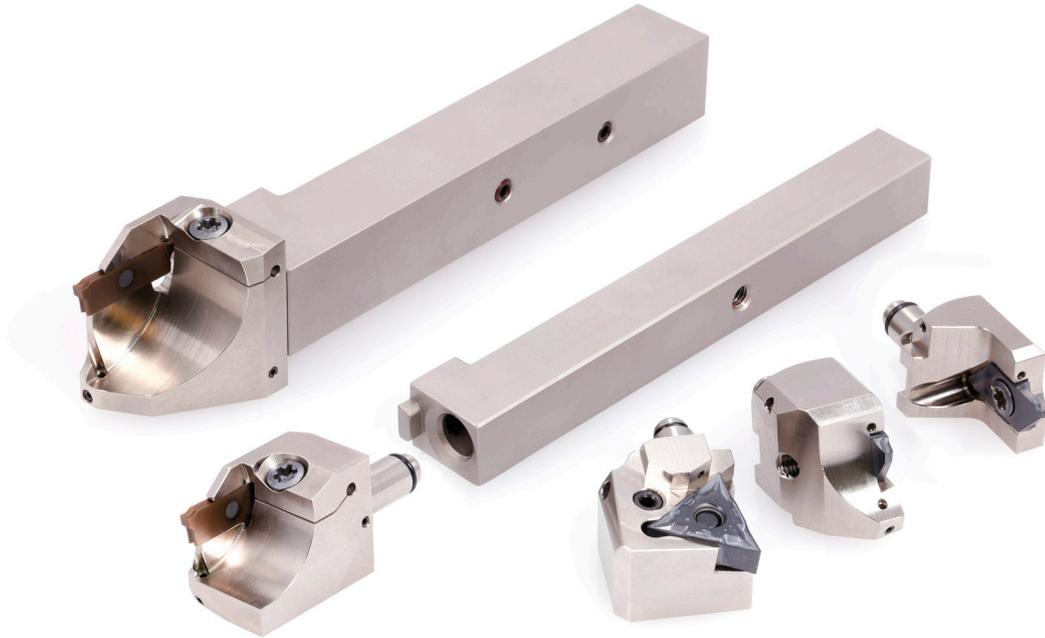
Lineup: Inch Toolholder

 Internal coolant

Designation	Hand		CUTDIA	B	H	HF	LF	LH	HBH	HBL	CNT	CNT2	MHD	MHD2	MHD3	MHD4	Insert	Figure
	R	L	inch	inch	inch	inch	inch	inch	inch	inch			inch	inch	inch	inch		
CTDP ^R _{1/4} 06-IN-20D20	●	●	.787	.394	3/8	3/8	4.724	.748	.020	.748	-	-	-	-	-	-	CTDP20..	1
CTDP ^R _{1/4} 08-IN-20D25	●	●	1.000	.500	1/2	1/2	4.724	.866	-	-	-	-	-	-	-	-	CTDP20..	1
CTDP ^R _{1/4} 08-IN-20D25-OH 	●	●	1.000	.500	1/2	1/2	3.937	.866	.307	.827	NPT1/8	-	2.756	-	-	-	CTDP20..	2
CTDP ^R _{1/4} 08-IN-20D25-OH2 	●	●	1.000	.500	1/2	1/2	3.937	.866	.307	.827	NPT1/8	M5	2.756	3.150	-	-	CTDP20..	3
CTDP ^R _{1/4} 10-IN-20D25-OH 	●	●	1.000	.625	5/8	5/8	3.937	.866	.182	.827	NPT1/8	-	2.756	-	-	-	CTDP20..	2
CTDP ^R _{1/4} 10-IN-20D25-OH2 	●	●	1.000	.625	5/8	5/8	4.724	.866	.182	1.083	NPT1/8	M5	2.756	3.248	3.937	-	CTDP20..	4
CTDP ^R _{1/4} 10-IN-20D25-OH3 	●	●	1.000	5/8	5/8	.605	4.724	.866	.182	.866	NPT1/8	M5	3.100	3.937	3.445	2.756	CTDP20..	5
CTDP ^R _{1/4} 10-IN-20D32	●	●	1.260	.625	5/8	5/8	4.724	1.083	-	-	-	-	-	-	-	-	CTDP20..	1
CTDP ^R _{1/4} 12-IN-20D32	●	●	1.260	.750	3/4	3/4	4.724	1.083	-	-	-	-	-	-	-	-	CTDP20..	1
CTDP ^R _{1/4} 12-IN-25D32-OH2 	●	●	1.260	.750	3/4	3/4	4.724	1.122	.157	1.083	-	-	2.953	3.937	-	-	CTDP25..	3
CTDP ^R _{1/4} 10-IN-25D34AOH3 	●	●	1.339	5/8	5/8	.605	4.724	1.122	.320	1.083	NPT1/8	M5	3.102	3.937	3.445	2.756	CTDP25..	5

Spare parts

Designation	Screw	Screw	Screw	Wrench	Wrench	Figure
CTDP ^R _{1/4} 06-IN-20D20	LRIS-4*12	-	-	LLR-25S	-	1
CTDP ^R _{1/4} 08-IN-20D25	LRIS-4*12	-	-	LLR-25S	-	1
CTDP ^R _{1/4} 08-IN-20D25-OH	LRIS-4*12	SPNPT1/8	-	LLR-25S	-	2
CTDP ^R _{1/4} 08-IN-20D25-OH2	LRIS-4*12	SPNPT1/8	SS0505SC	LLR-25S	LW-2.5	3
CTDP ^R _{1/4} 10-IN-20D25-OH	LRIS-4*12	SPNPT1/8	-	LLR-25S	-	2
CTDP ^R _{1/4} 10-IN-20D25-OH2	LRIS-4*12	SPNPT1/8	SS0505SC	LLR-25S	LW-2.5	4
CTDP ^R _{1/4} 10-IN-20D25-OH3	LRIS-4*12	SPNPT1/8	SS0505SC	LLR-25S	LW-2.5	5
CTDP ^R _{1/4} 10-IN-20D32	LRIS-5*10	-	-	LLR-28S	-	1
CTDP ^R _{1/4} 12-IN-20D32	LRIS-5*10	-	-	LLR-28S	-	1
CTDP ^R _{1/4} 12-IN-25D32-OH2	CS0516LSH	SPNPT1/8	SS0505SC	LW-3	LW-2.5	3
CTDP ^R _{1/4} 10-IN-25D34AOH3	CS0516LSH	SPNPT1/8	SS0505SC	LW-3	LW-2.5	5

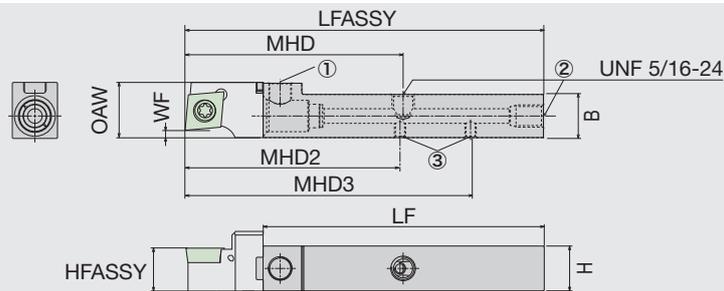


N-Swiss JOINT Modular Type New Quick-change tool series for automatic lathes

Reduces tool change and set-up times.
Easy-to-use mechanism for consistent repeatability.

| Shanks

QC-OH/OH2



Designation	Internal coolant	H mm	B mm	LF mm	OAW mm	WF ⁽²⁾ mm	MHD ⁽²⁾ mm	MHD2 ⁽²⁾ mm	MHD3 ⁽²⁾ mm	HFASSY ⁽²⁾ mm	LFASSY ⁽²⁾ mm	Torque ⁽³⁾ N·m	Coupling size
QC-1212F-OH		12	12	65	15	(2)	(67)	—	—	(12)	(86)	3	QC12-..
QC-1212X-OH2 ⁽¹⁾		12	12	100	15	(2)	(67)	(77)	—	(12)	(121)	3	QC12-..
QC-1616X-OH2 ⁽¹⁾		16	16	99	20	(2)	(71)	(69)	(94)	(16)	(120)	8.5	QC16-..

Inch shanks

Designation	Internal coolant	H inch	B inch	LF inch	OAW inch	WF ⁽²⁾ inch	MHD ⁽²⁾ inch	MHD2 ⁽²⁾ inch	MHD3 ⁽²⁾ inch	HFASSY ⁽²⁾ inch	LFASSY ⁽²⁾ inch	Torque ⁽³⁾ N·m	Coupling size
QC-08F-IN-OH		1/2	.500	2.56	.600	(.080)	(2.638)	—	—	(.472)	(3.386)	3	QC12-..
QC-08X-IN-OH2 ⁽¹⁾		1/2	.500	3.94	.600	(.080)	(2.638)	(3.031)	—	(.472)	(4.764)	3	QC12-..
QC-10X-IN-OH2 ⁽¹⁾		5/8	.625	3.90	.790	(.080)	(2.795)	(2.717)	(3.701)	(.630)	(4.724)	8.5	QC16-..

⁽¹⁾ OH2 :Compatible with direct coolant supply from the machine's tool post to the tool.

⁽²⁾ Dimensions with the QC...SCLCR09-F02-OH [LH=21mm(.827")] head installed are shown.

⁽³⁾ Recommended clamping torque (N·m)

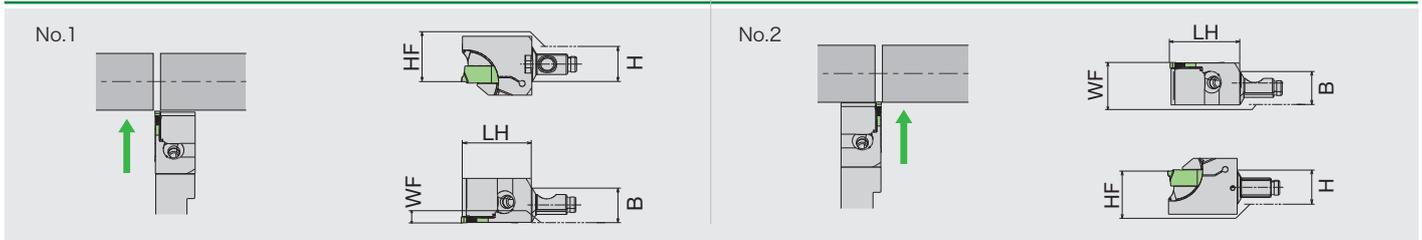
Spare parts



Designation	Screw ①	Screw ②	Screw ③	Wrench ①	Wrench ②	Wrench ③
QC-1212F-OH	M6*0.5-TSC	5/16UNF-TSC	-	TR-3	TR-4	-
QC-1212X-OH2	M6*0.5-TSC	5/16UNF-TSC	SSM4*6-T	TR-3	TR-4	TR-2
QC-1616X-OH2	M8*0.5-TSC	5/16UNF-TSC	SSM4*6-T	TR-5	TR-4	TR-2

Heads

QC-CTDP-OH



Metric

Designation	Internal coolant	CUTDIA mm	H mm	B mm	LH mm	HF mm	WF mm	Insert	Applicable shank size	Figure
QC12-CTDPR-20D20-OH	Blue drop icon	20	12	12	23.5	12	0.2	CTDP20..	QC-12..	1
QC12-CTDPL-20D20-OH	Blue drop icon	20	12	12	23.5	12	15.2	CTDP20..	QC-12..	2
QC16-CTDPR-20D32-OH	Blue drop icon	32	16	16	24.5	16	0.2	CTDP20..	QC-16..	1
QC16-CTDPL-20D32-OH	Blue drop icon	32	16	16	24.5	16	20.2	CTDP20..	QC-16..	2

Inch

Designation	Internal coolant	CUTDIA inch	H inch	B inch	LH inch	HF inch	WF inch	Insert	Applicable shank size	Figure
QC12-CTDPR-20D20-OH	Blue drop icon	.787	.472	.472	.925	.472	.008	CTDP20..	QC-08..	1
QC12-CTDPL-20D20-OH	Blue drop icon	.787	.472	.472	.925	.472	.598	CTDP20..	QC-08..	2
QC16-CTDPR-20D32-OH	Blue drop icon	1.260	.630	.630	.965	.630	.008	CTDP20..	QC-10..	1
QC16-CTDPL-20D32-OH	Blue drop icon	1.260	.630	.630	.965	.630	.795	CTDP20..	QC-10..	2

Spare parts



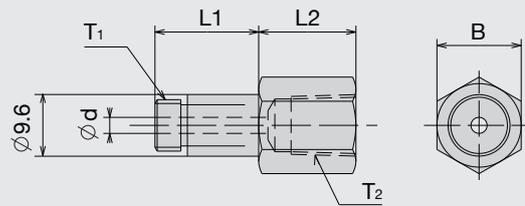
Designation	O-Rings	Screw	Wrench
QC12-CTDPR-20D20-OH	OR-450*10	LRIS-4*12	LLR-25S
QC12-CTDPL-20D20-OH	OR-450*10	LRIS-4*12	LLR-25S
QC16-CTDPR-20D32-OH	OR-750*10	LRIS-4*12	LLR-25S
QC16-CTDPL-20D32-OH	OR-750*10	LRIS-4*12	LLR-25S

Stopper By attaching a stopper to the unused shank, the coupling part is protected, and coolant discharge from the shank is prevented.



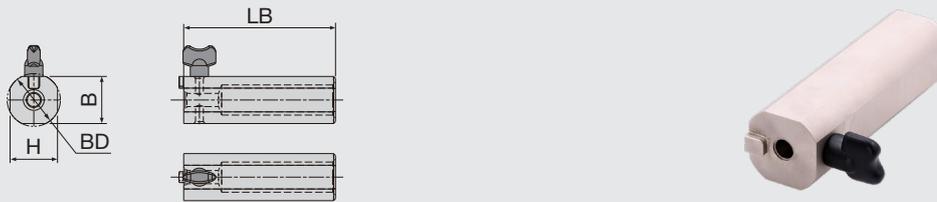
Designation	O-Rings	Applicable shank size	Figure
QC12-STOPPER-PLUG	OR-450*10	QC12	1
QC16-STOPPER-PLUG	OR-750*10	QC16	2

Thread conversion adapter When using conventional hoses and fittings, please use a threaded adapter.



Designation	T ₁	T ₂	L1 mm	L2 mm	φd mm	B mm
SCJ-5/16-RC1/8-L	5/16-24UNF	Rc1/8	16.0	15.0	2.5	13.0

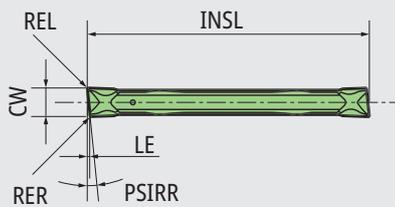
Accessories Dedicated accessory for easy replacement of inserts mounted on the modular head.



Designation	BD mm	LB mm	H mm	B mm	Screw	Coupling size
QC-12D28	28	80	25	25	TAB-5*10	QC12-..
QC-16D28	28	80	25	25	TAB-5*10	QC16-..

For more information on N-Swiss JOINT, please see the product brochure and website.

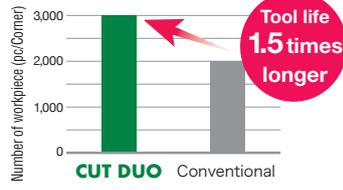
Lineup: Insert

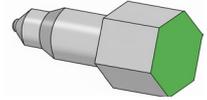


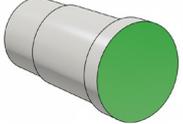
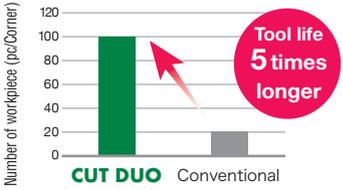
● NEW

Designation	Hand	CW mm	INSL mm	PSIRR °	LE mm	REL mm	RER mm	Carbide PVD Coated Carbide Grade			
								DM4	QM3	ST4	TM4
CTDP20N	N	2.0	19.1	0	0	0.05	0.05	●	●	●	●
CTDP20N02	N	2.0	19.1	0	0	0.20	0.20	●	●	●	●
CTDP20R6	R	2.0	19.1	6	0.24	0.05	0.05	●	●	●	●
CTDP20R15	R	2.0	19.1	15	0.57	0.05	0.05	●	●	●	●
CTDP25N	N	2.5	21.2	0	0	0.05	0.05	●	●	●	●
CTDP25N02	N	2.5	21.2	0	0	0.20	0.20	●	●	●	●
CTDP25R6	R	2.5	21.2	6	0.29	0.05	0.05	●	●	●	●
CTDP25R15	R	2.5	21.2	15	0.71	0.05	0.05	●	●	●	●

Practical examples

		NTK	Conventional
Component		Electronic parts	
Insert	CTDP20R6	Width : 2.2mm(.090")	
Grade	QM3	PVD Carbide	
Workpiece		Alloy steel (SCM435)	
			
		φ12mm (.472")	
Cutting conditions	Cutting speed	75m/min (250SFM)	
	Feed	0.04mm/rev (.002IPR)	
	Coolant	WET	
Results			
	<p>The conventional tool suffered from poor cutting performance, leading to burr formation and reduced tool life. In contrast, CUT DUO maintained sharpness and achieved a 1.5x increase in tool life.</p>		

		NTK	Conventional
Component		Automotive parts	
Insert	CTDP20N02	Width : 2.0mm(.080")	
Grade	ST4	PVD Carbide	
Workpiece		SUS316	
			
		AF:11.5mm (.453")	
Cutting conditions	Cutting speed	90m/min (300SFM)	
	Feed	0.08mm/rev (.003IPR)	
	Coolant	WET	
Results			
	<p>The conventional tool lacked sharpness, causing burrs and early failure under interrupt cutting due to edge chipping. CUT DUO suppressed burrs and doubled tool life.</p>		

		NTK	Conventional
Component		Fuel cell parts	
Insert	CTDP20N02	Width : 2.0mm(.080")	
Grade	DM4	PVD Carbide	
Workpiece		Inconel718	
			
		φ18mm (.710")	
Cutting conditions	Cutting speed	80m/min (260SFM)	
	Feed	0.03mm/rev (.001IPR)	
	Coolant	WET	
Results			
	<p>The cutting edge of the conventional product wore out after machining 20 pieces, leading to poor machining surface and tool breakage. CUT DUO reduced cutting resistance and achieved 5 times longer tool life.</p>		

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