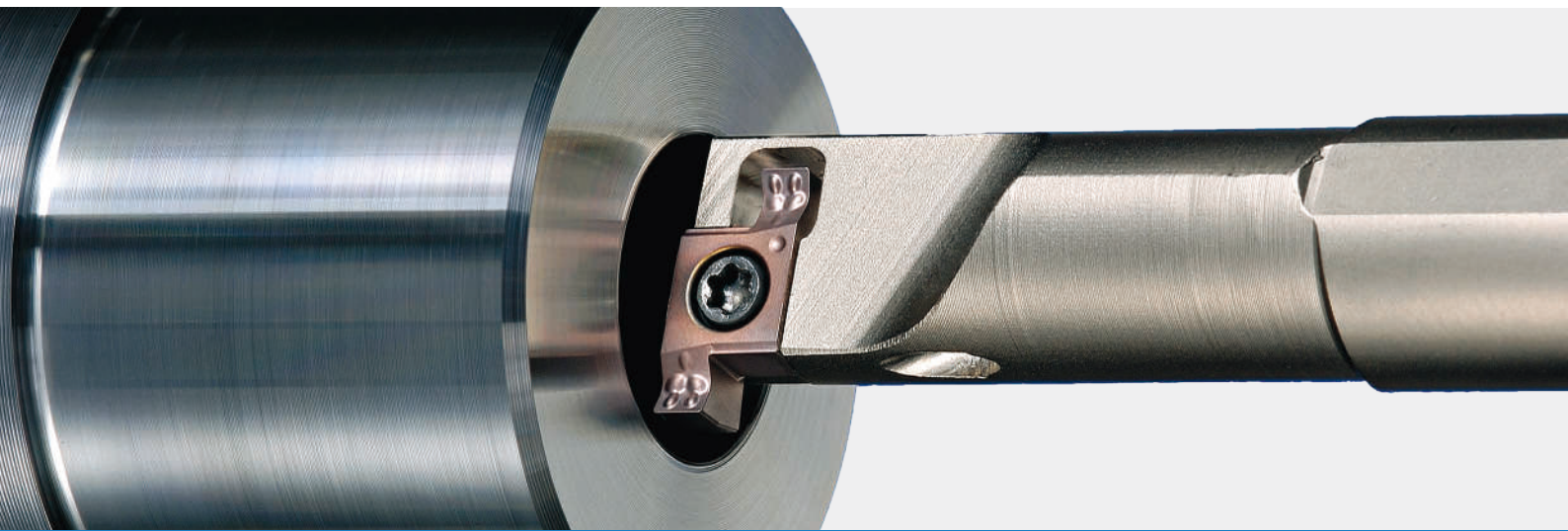


Internal Grooving

SIGE



Internal Screw Clamp Toolholder Provides Excellent Chip Evacuation

Superior chip control with molded chipbreaker
ø8mm minimum cutting diameter with a 2 edge design
Toolholders for automatic lathe available

Comprehensive insert lineup for
various machining applications



Internal Grooving

SIGE

Internal screw clamp toolholder provides excellent chip evacuation
Superior chip control with molded chipbreaker

1 Internal screw clamp toolholder provides excellent chip evacuation

Large chip pocket on screw clamp toolholder enables excellent chip evacuation.

Screw Clamp

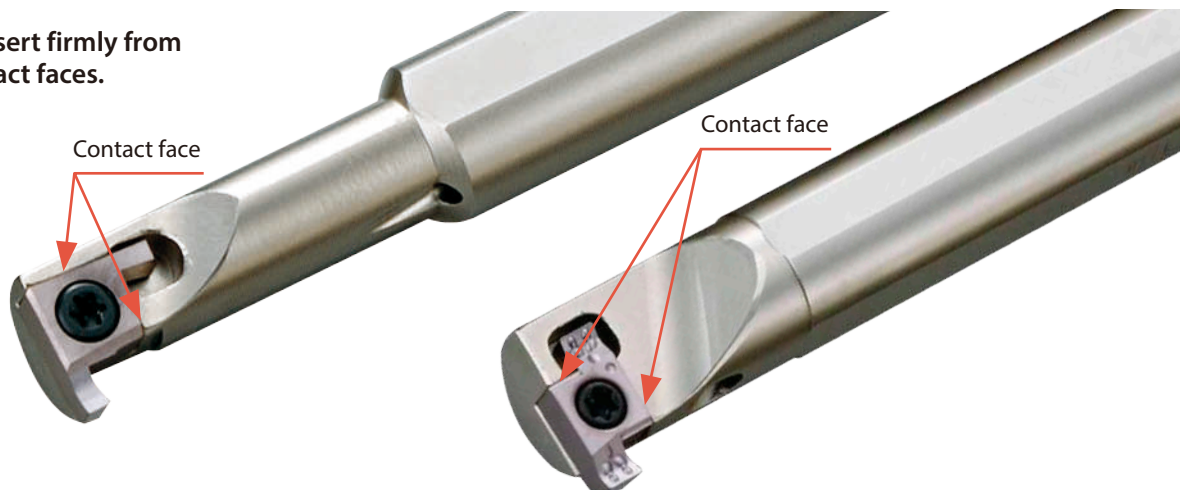


Conventional Clamp



2 Reduces chattering with firm insert clamping system

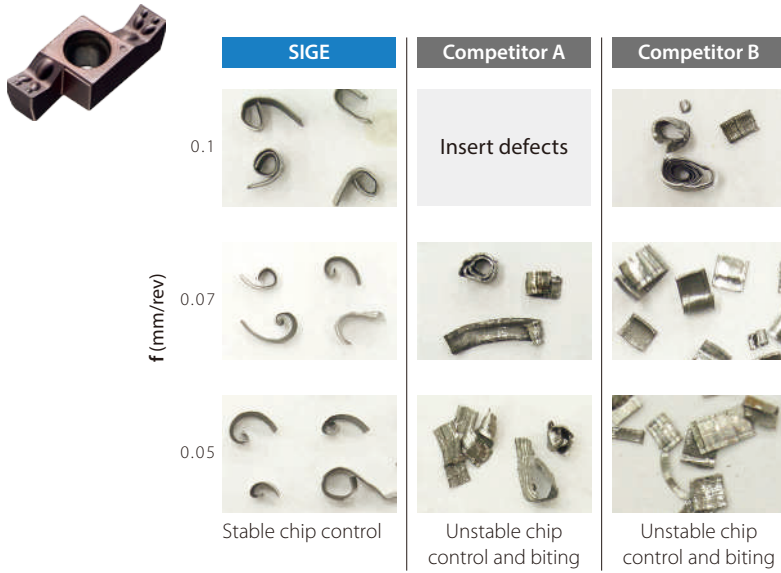
Clamp the insert firmly from the two contact faces.



3 Superior chip control with a 2 edge design

Excellent chip evacuation with molded chipbreaker

Chip evacuation comparison (Internal evaluation)



Cutting Conditions : Vc = 100 m/min, ap = 2.0 mm, Minimum bore dia. ø16, Width 3 mm, Wet
Workpiece SCM415
SIGER1612C-EH, GER300-020CM

ø8mm minimum cutting diameter

Chip evacuation comparison (Internal evaluation)



Cutting Conditions : Vc = 50 m/min, ap = 1.25 mm
f = 0.02 mm/rev, Width 2mm, Wet, Workpiece SCM415
SIGER0808A-EH, GER200-010A

4 Variety of toolholders for automatic lathe available

Shank diameter compatible with automatic lathe.

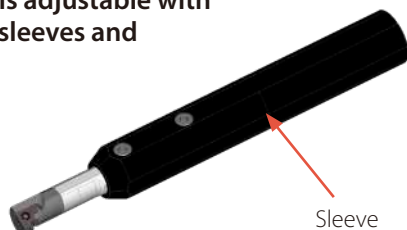
Tool overhang length can be shortened by mounting sleeve till near the shank tip.

The toolholder is tightly restrained by the sleeve, which suppresses chatter when using automatic lathe.



Applicable Sleeve

Overhang length is adjustable with a combination of sleeves and toolholders.



5 PVD coating MEGACOAT provides excellent wear resistance



PR1225 MEGACOAT

Consistent machining MEGACOAT with a high hardness and good oxidation resistance makes longer tool life.

Workpiece	Steel				
Classification	P01	P10	P20	P30	P40
Applicable Range			PR1225		

Workpiece	Stainless Steel			
Classification	M10	M20	M30	P40
Applicable Range		PR1225		

Applicable Inserts (Ground Chipbreaker)

Shape Right-hand shown	Description	Dimensions (mm)								Cermet		MEGACOAT		Carbide		Applicable Toolholders
		CW	CDX	RE	W1	INSL	S	D1	TN6020	PR1225	GW15	KW10				
		R	L	R	L	R	L	R	L							
 2-edge	GE ^{R/L} 100-005A	1.00							●	●					SIGER ^{R/L} 0808A-EH SIGER ^{R/L} 0808A-WH	
	120-005A	1.20		0.05					●	●						
	125-005A	1.25	1.5		6.69	6.5	2.58	2.5		●	●					
	150-010A	1.50							●	●						
	200-010A	2.00		0.1					●	●						
	GE ^{R/L} 100-005B	1.00							●	●					SIGER ^{R/L...B} -EH SIGER ^{R/L...B} -WH SIGER ^{R/L...B} -WH-90	
	120-005B	1.20		0.05					●	●						
	125-005B	1.25								●	●					
	145-010B	1.45	2.2		8.46	8.2	3.18	2.7	●	●						
	150-010B	1.50		0.1					●	●						
200-010B	2.00							●	●							
250-020B	2.50		0.2					●	●							
300-020B	3.00							●	●							
 2-edge/Full-R	GER 100-050AR	1.00		0.5						●				SIGER0808A-EH SIGER0808A-WH		
	200-100AR	2.00		1.0						●						
	GER 100-050BR	1.00		0.5						●				SIGER ^{R/L...B} -EH SIGER ^{R/L...B} -WH SIGER ^{R/L...B} -WH-90		
	200-100BR	2.00		1.0						●						

* CDX shows available grooving depth.
* Inserts are sold in 10 piece boxes.

● : Standard Stock

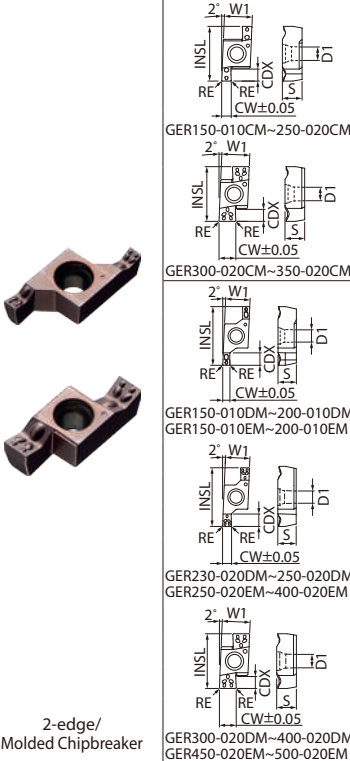
Recommended Cutting Conditions ★ 1st recommendation ☆ 2nd recommendation

SIGE (Ground Chipbreaker : GE^{R/L...A}(R), GE^{R/L...B}(R))

Workpiece	Recommended insert grades (Vc : m/min)			(1) f for grooving (mm/rev)			Remarks
	Cermet	MEGACOAT	Carbide	(2) f for turning (mm/rev)			
				(3) ap for turning (mm)			
				TN6020	PR1225	KW10	
Carbon Steel (SxxC etc.)	☆ 50 ~ 80	★ 50 ~ 80	-	(1) 0.01 ~ 0.03 (2) 0.01 ~ 0.03 (3) Max. 0.05	(1) 0.02 ~ 0.04 (2) 0.02 ~ 0.04 (3) Max. 0.05	(1) 0.02 ~ 0.04 (2) 0.02 ~ 0.04 (3) Max. 0.1	Wet
Alloy Steel (SCM etc.)	☆ 50 ~ 80	★ 50 ~ 80	-	(1) 0.01 ~ 0.03 (2) 0.01 ~ 0.03 (3) Max. 0.05	(1) 0.02 ~ 0.04 (2) 0.02 ~ 0.04 (3) Max. 0.05	(1) 0.02 ~ 0.04 (2) 0.02 ~ 0.04 (3) Max. 0.1	
Stainless Steel (SUS304 etc.)	-	★ 50 ~ 80	-	(1) 0.01 ~ 0.03 (2) 0.01 ~ 0.03 (3) Max. 0.05	(1) 0.01 ~ 0.03 (2) 0.01 ~ 0.03 (3) Max. 0.05	(1) 0.01 ~ 0.03 (2) 0.01 ~ 0.03 (3) Max. 0.1	
Cast Iron (FC, FCD etc.)	-	-	★ 50 ~ 80	(1) 0.01 ~ 0.03 (2) 0.01 ~ 0.03 (3) Max. 0.05	(1) 0.02 ~ 0.04 (2) 0.02 ~ 0.04 (3) Max. 0.05	(1) 0.02 ~ 0.04 (2) 0.02 ~ 0.04 (3) Max. 0.1	
Aluminum	-	-	★ 50 ~ 100	(1) 0.01 ~ 0.03 (2) 0.01 ~ 0.03 (3) Max. 0.1	(1) 0.02 ~ 0.04 (2) 0.02 ~ 0.04 (3) Max. 0.1	(1) 0.02 ~ 0.04 (2) 0.02 ~ 0.04 (3) Max. 0.2	
Brass	-	-	★ 50 ~ 100	(1) 0.01 ~ 0.03 (2) 0.01 ~ 0.03 (3) Max. 0.1	(1) 0.02 ~ 0.04 (2) 0.02 ~ 0.04 (3) Max. 0.1	(1) 0.02 ~ 0.04 (2) 0.02 ~ 0.04 (3) Max. 0.2	

*Use PR1225 or KW10 for turning with edge width 1mm. (GE& 100-005A / 100-005B)

Applicable Inserts (Molded Chipbreaker)

Shape Right-hand shown	Description	Dimensions (mm)								Cermet		MEGACOAT		Carbide		Applicable Toolholders
		CW	CDX	RE	W1	INSL	S	D1	TN6020	PR1225	GW15	KW10				
		R	L	R	L	R	L	R	L							
 <p>2-edge/ Molded Chipbreaker</p>	GER 150-010CM	1.50														SIGER...C-EH SIGER...C-WH SIGER...C-WH-90
	200-010CM	2.00														
	GER150-010CM~250-020CM	250-020CM	2.50	2.5		5.8	11.48	4.05	2.8							
	300-020CM	3.00		0.2												
	GER300-020CM~350-020CM	350-020CM	3.50													
	GER 150-010DM	1.50	3.0													SIGER2020D-EH
	200-010DM	2.00														
	GER150-010DM~200-010DM	230-020DM	2.30	3.2												
	GER150-010DM~200-010DM	250-020DM	2.50		6.8	16.44	5.05	3.4								
	GER150-010EM~200-010EM	300-020DM	3.00	0.2												
	GER 150-010EM	1.50	3.0													SIGER...E-EH
	GER230-020DM~250-020DM	200-010EM	2.00	3.2												
	GER250-020EM~400-020EM	250-020EM	2.50													
	GER300-020DM~400-020DM	300-020EM	3.00	4.5												
	GER450-020EM~500-020EM	350-020EM	3.50		9.54	21.66	5.55	4.4								
		400-020EM	4.00	5.5												
		450-020EM	4.50	6.5												
		500-020EM	5.00													

• CDX shows available grooving depth.
• Inserts are sold in 10 piece boxes.


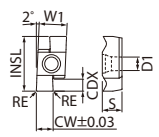

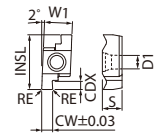

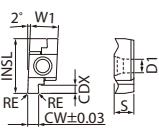

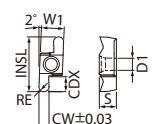
● : Standard Stock

Recommended Cutting Conditions ★ 1st recommendation ☆ 2nd recommendation

SIGE (Molded Chipbreaker : GER...CM, GER...DM, GER...EM)

Workpiece	Recommended insert grades (Vc: m/min)	(1) f for grooving (mm/rev)						Remarks
		(2) f for turning (mm/rev)						
		(3) ap for turning (mm)						
		GER 150 ~ 200 - 010CM	GER 250 ~ 350 - 020CM					
Carbon Steel (SxxC etc.)	★ 60 ~ 160	(1) 0.03 ~ 0.1	(1) 0.03 ~ 0.12	(1) 0.04 ~ 0.12	(1) 0.05 ~ 0.12	(1) 0.05 ~ 0.12	(1) 0.05 ~ 0.12	Wet
		(2) 0.03 ~ 0.1	(2) 0.03 ~ 0.1	(2) 0.04 ~ 0.1	(2) 0.05 ~ 0.1	(2) 0.05 ~ 0.1	(2) 0.05 ~ 0.1	
		(3) Max. 1.0	(3) Max. 1.5	(3) Max. 1.5	(3) Max. 1.5	(3) Max. 1.5	(3) Max. 1.5	
Alloy Steel (SCM etc.)	★ 60 ~ 140	(1) 0.03 ~ 0.1	(1) 0.03 ~ 0.1	(1) 0.04 ~ 0.12	(1) 0.05 ~ 0.12	(1) 0.05 ~ 0.12	(1) 0.05 ~ 0.12	
		(2) 0.03 ~ 0.1	(2) 0.03 ~ 0.1	(2) 0.04 ~ 0.1	(2) 0.05 ~ 0.1	(2) 0.05 ~ 0.1	(2) 0.05 ~ 0.1	
		(3) Max. 1.0	(3) Max. 1.5	(3) Max. 1.5	(3) Max. 1.5	(3) Max. 1.5	(3) Max. 1.5	
Stainless Steel (SUS304 etc.)	★ 60 ~ 110	(1) 0.03 ~ 0.08	(1) 0.03 ~ 0.08	(1) 0.04 ~ 0.08	(1) 0.05 ~ 0.1	(1) 0.05 ~ 0.1	(1) 0.05 ~ 0.1	
		(2) 0.03 ~ 0.1	(2) 0.03 ~ 0.1	(2) 0.04 ~ 0.1	(2) 0.05 ~ 0.1	(2) 0.05 ~ 0.1	(2) 0.05 ~ 0.1	
		(3) Max. 1.0	(3) Max. 1.5	(3) Max. 1.5	(3) Max. 1.5	(3) Max. 1.5	(3) Max. 1.5	

Applicable Inserts (Ground Chipbreaker)

Shape Right-hand shown		Description	Dimensions (mm)								Cermet		MEGACOAT		Carbide		Applicable Toolholders
			CW	CDX	RE	W1	INSL	S	D1	TN6020	PR1225	GW15		KW10			
										R	L	R	L	R	L	R	
 2-edge	 GER/L 100-005C 1.00 120-005C 1.20 125-005C 1.25 140-005C 1.40 145-010C 1.45 150-010C 1.50 170-010C 1.70 185-010C 1.85 195-010C 1.95 200-010C 2.00 250-020C 2.50 300-020C 3.00 350-020C 3.50	0.05	2.5	0.1	5.8	11.48	4.05	3.1	●	●	●	●	●	●			
		●								●	●	●					
		●								●	●	●	●				
		●								●	●	●					
										●	●	●					
										●	●	●					
				●	●	●	●										
				●	●	●	●	●									
				●	●	●	●	●	●								
				●	●	●	●	●	●								
				●	●	●	●	●	●								
				●	●	●	●	●	●								
 2-edge	 GER/L 100-005D 1.00 140-005D 1.40 145-010D 1.45 150-010D 1.50 170-010D 1.70 185-010D 1.85 195-010D 1.95 200-010D 2.00 225-010D 2.25 230-020D 2.30 250-020D 2.50 280-020D 2.80 300-020D 3.00 330-020D 3.30 350-020D 3.50 400-020D 4.00	0.05	2.5	0.1	6.8	16.44	5.05	3.6	●	●	●	●	●				
		●								●	●	●					
		●								●	●	●	●				
				●	●	●											
				●	●	●											
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				●	●	●	●	●									
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				●	●	●	●	●	●								
				●	●	●	●	●	●								
				●	●	●	●	●	●								
				●	●	●	●	●	●								
				●	●	●	●	●	●								
		 2-edge	 GER/L 100-005E 1.00 150-010E 1.50 170-010E 1.70 185-010E 1.85 195-010E 1.95 200-010E 2.00 225-010E 2.25 230-020E 2.30 250-020E 2.50 275-020E 2.75 280-020E 2.80 300-020E 3.00 330-020E 3.30 350-020E 3.50 400-020E 4.00 430-020E 4.30 450-020E 4.50 460-020E 4.60 500-020E 5.00	0.05	2.5	0.1	9.54	21.66	5.55	4.6	●	●	●	●	●		
				●								●	●	●	●		
●				●							●	●	●	●			
				●	●	●											
				●	●	●											
				●	●	●											
				●	●	●	●										
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				●	●	●	●	●	●								
				●	●	●	●	●	●								
				●	●	●	●	●	●								
				●	●	●	●	●	●								
				●	●	●	●	●	●								
 2-edge/Full-R	 GER 200-100CR 2.00 250-125CR 2.50 300-150CR 3.00 GER 200-100DR 2.00 300-150DR 3.00	1.0	2.5	1.25	5.8	11.48	4.05	3.1		●	●						
		1.25								●	●						
		1.5								●	●						
		1.0	3.2	1.0	6.8	16.44	5.05	3.6		●	●						
		1.5								●	●						
		1.5								●	●						

* CDX shows available grooving depth.
 * Inserts are sold in 10 piece boxes.

● : Standard Stock

Recommended Cutting Conditions ★ 1st recommendation ☆ 2nd recommendation

SIGE(Ground Chipbreaker : GE R/L...C(R), GE R/L...D(R), GE R/L...E)

Workpiece	Recommended insert grades (Vc: m/min)			(1) f for grooving (mm/rev)							Remarks
	Cermet	MEGACOAT	Carbide	(2) f for turning (mm/rev)							
				(3) ap for turning (mm)							
				GER/L 100~200-010C 200-100CR	GER/L 250~350-020C 250~300-150CR					GER/L 300~400-020D 300-150DR	
TN6020	PR1225	GW15	GER/L 100~145-010D	GER/L 150~195-010D	GER/L 200~280-020D 200-100DR						
			GER/L 100-010E	GER/L 150~195-010E	GER/L 200~225-010E 230-020E	GER/L 250~330-020E			GER/L 350~430-020E	GER/L 450~500-020E	
Carbon Steel (SxxC etc.)	☆ 120~180	★ 60~140	-	(1) 0.03~0.08 (2) 0.03~0.08 (3) Max. 0.3	(1) 0.03~0.08 (2) 0.03~0.08 (3) Max. 0.3	(1) 0.04~0.09 (2) 0.04~0.09 (3) Max. 0.3	(1) 0.04~0.09 (2) 0.04~0.09 (3) Max. 0.3	(1) 0.05~0.12 (2) 0.05~0.1 (3) Max. 0.5	(1) 0.05~0.12 (2) 0.05~0.1 (3) Max. 0.5	(1) 0.05~0.12 (2) 0.05~0.1 (3) Max. 0.5	
Alloy Steel (SCM etc.)	☆ 100~160	★ 60~120	-	(1) 0.03~0.07 (2) 0.03~0.1 (3) Max. 0.3	(1) 0.03~0.07 (2) 0.03~0.1 (3) Max. 0.3	(1) 0.04~0.08 (2) 0.04~0.08 (3) Max. 0.3	(1) 0.04~0.08 (2) 0.04~0.08 (3) Max. 0.3	(1) 0.05~0.1 (2) 0.05~0.1 (3) Max. 0.5	(1) 0.05~0.1 (2) 0.05~0.1 (3) Max. 0.5	(1) 0.05~0.1 (2) 0.05~0.1 (3) Max. 0.5	
Stainless Steel (SUS304 etc.)	☆ 70~130	★ 60~110	-	(1) 0.03~0.07 (2) 0.03~0.1 (3) Max. 0.3	(1) 0.03~0.07 (2) 0.03~0.1 (3) Max. 0.3	(1) 0.04~0.08 (2) 0.04~0.08 (3) Max. 0.3	(1) 0.04~0.08 (2) 0.04~0.08 (3) Max. 0.3	(1) 0.05~0.1 (2) 0.05~0.1 (3) Max. 0.5	(1) 0.05~0.1 (2) 0.05~0.1 (3) Max. 0.5	(1) 0.05~0.1 (2) 0.05~0.1 (3) Max. 0.5	
Cast Iron (FC, FCD etc.)	-	-	★ 60~100	(1) 0.03~0.08 (2) 0.03~0.08 (3) Max. 0.3	(1) 0.03~0.08 (2) 0.03~0.08 (3) Max. 0.3	(1) 0.04~0.09 (2) 0.04~0.09 (3) Max. 0.3	(1) 0.04~0.09 (2) 0.04~0.09 (3) Max. 0.3	(1) 0.05~0.12 (2) 0.05~0.1 (3) Max. 0.5	(1) 0.05~0.12 (2) 0.05~0.1 (3) Max. 0.5	(1) 0.05~0.12 (2) 0.05~0.1 (3) Max. 0.5	
Aluminum	-	-	★ 150~300	(1) 0.05~0.12 (2) 0.05~0.12 (3) Max. 0.5	(1) 0.05~0.12 (2) 0.05~0.12 (3) Max. 0.5	(1) 0.05~0.15 (2) 0.05~0.15 (3) Max. 0.5	(1) 0.05~0.15 (2) 0.05~0.15 (3) Max. 0.5	(1) 0.08~0.15 (2) 0.08~0.15 (3) Max. 0.8	(1) 0.08~0.15 (2) 0.08~0.15 (3) Max. 0.8	(1) 0.08~0.15 (2) 0.08~0.15 (3) Max. 0.8	
Brass	-	-	★ 100~250	(1) 0.05~0.12 (2) 0.05~0.12 (3) Max. 0.5	(1) 0.05~0.12 (2) 0.05~0.12 (3) Max. 0.5	(1) 0.05~0.15 (2) 0.05~0.15 (3) Max. 0.5	(1) 0.05~0.15 (2) 0.05~0.15 (3) Max. 0.5	(1) 0.08~0.15 (2) 0.08~0.15 (3) Max. 0.8	(1) 0.08~0.15 (2) 0.08~0.15 (3) Max. 0.8	(1) 0.08~0.15 (2) 0.08~0.15 (3) Max. 0.8	

*Use PR1225 or GW15 for turning with edge width 1mm. (GE& 100-010C / 100-010D / 100-010E)

SIGE Lineup

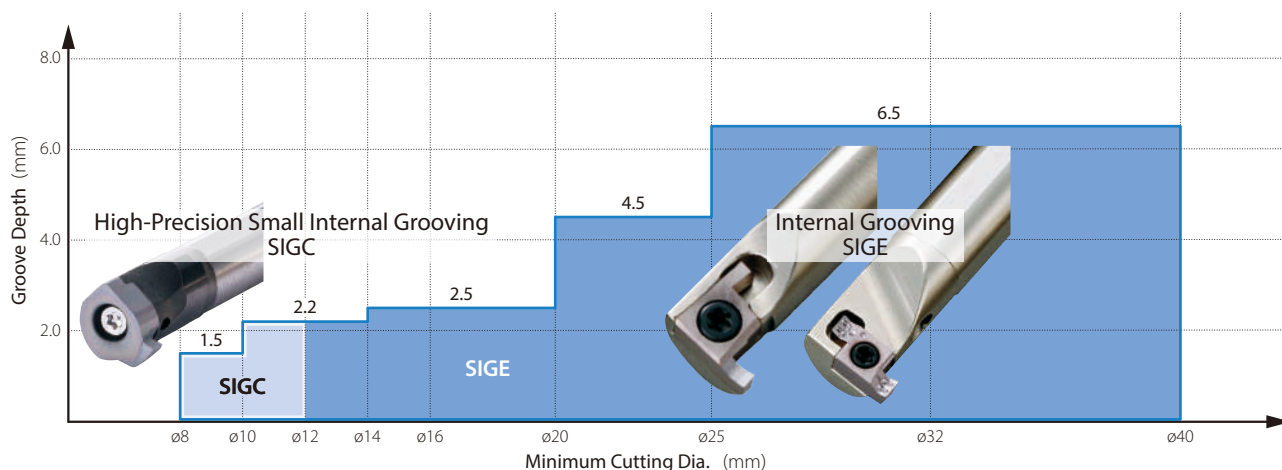
Insert	Shape	Ground Chipbreaker			Molded Chipbreaker						Ground Chipbreaker																
	Description	GER/L...A GER...AR	GER/L...B	GER...BR	GER...CM	GER...DM	GER...EM			GER/L...C	GER...CR	GER/L...D			GER...DR	GER/L...E											
	Groove Width	1.0 2.0	1.0 3.0	1.0 2.0	1.5 3.5	1.5	2.0 2.5	3.0 4.0	1.5	2.0	2.5 3.0	3.5 4.0	4.5 5.0	1.0 3.5	2.0 3.0	1.0 1.45	1.5 1.95	2.0 2.8	3.0 4.0	2.0	3.0	1.0	1.5 1.95	2.0 2.3	2.5 3.3	3.5 4.3	4.5 5.0
	Available Groove Depth (mm)	1.5	2.2	2.2	2.5	3.0	3.2	4.5	3.0	3.2	4.5	5.5	6.5	2.5	2.5	2.5	3.0	3.2	4.5	4.5	2.5	3.0	3.2	4.5	5.5	6.5	
Toolholder	Minimum Cutting Dia. (mm)	ø8	ø10,ø12		ø14,ø16		ø20	ø25,ø32,ø40			ø14,ø16		ø20			ø25,ø32,ø40											
	Excellent Bar	SIGER/L 0808A-EH	SIGER/L...B-EH		SIGER/L...C-EH	SIGER/L 2020D-EH	SIGER...E-EH			SIGER/L...C-EH		SIGER/L 2020D-EH			SIGER/L...E-EH												
	Carbide Shank Bar	SIGER/L 0808A-WH	SIGER/L...B-WH(-90)		SIGER/L...C-WH(-90)	-	-			SIGER/L...C-WH(-90)		-			-												

Applicable Insert & Rake Angle (α) after Installement of Insert

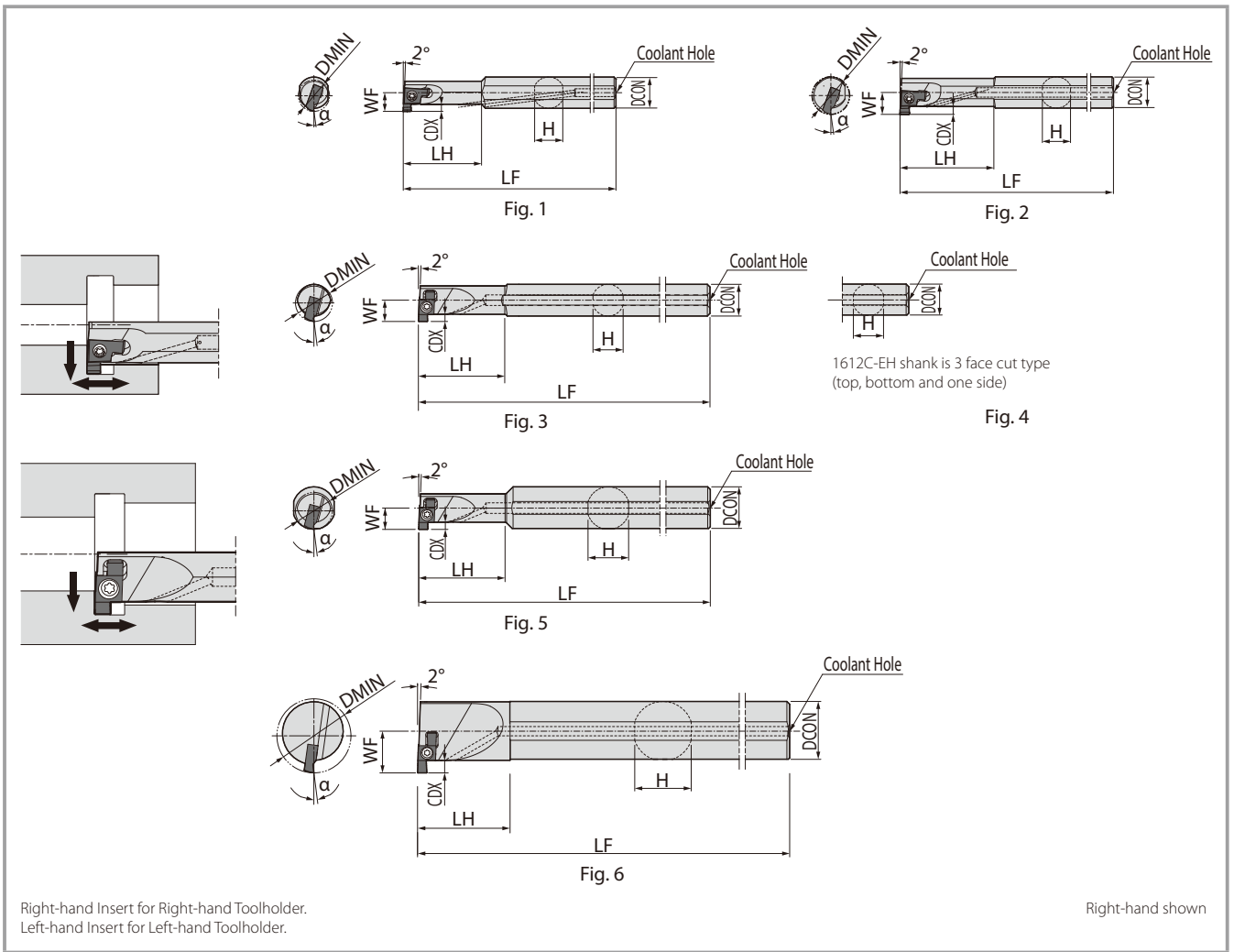
Description		Ground Chipbreaker	α	Molded Chipbreaker	α
SIGER/L	0808A-EH	GER/L100-005A ~ GER/L200-010A GER100-050AR ~ GER200-100AR	5°	—	—
	1010B-EH	GER/L100-005B ~ GER/L300-020B GER100-050BR ~ GER200-100BR	5°	—	—
	1210B-EH				
	1412C-EH	GER/L100-005C ~ GER/L350-020C GER200-100CR ~ GER300-150CR	8°	GER150-010CM ~ GER350-020CM	10°
	1612C-EH				
	1616C-EH				
	2020D-EH	GER/L100-005D ~ GER/L400-020D GER200-100DR ~ GER300-150DR	9°	GER150-010DM ~ GER400-020DM	10°
	2525E-EH	GER/L100-005E ~ GER/L500-020E	10°	GER150-010EM ~ GER500-020EM	10°
	3232E-EH				
4032E-EH					
SIGER/L	0808A-WH	GER/L100-005A ~ GER/L200-010A GER100-050AR ~ GER200-100AR	5°	—	—
	1010B-WH	GER/L100-005B ~ GER/L300-020B GER100-050BR ~ GER200-100BR	5°	—	—
	1210B-WH				
	1008B-WH-90				
	1210B-WH-90				
	1412C-WH	GER/L100-005C ~ GER/L350-020C GER200-100CR ~ GER300-150CR	8°	GER150-010CM ~ GER350-020CM	10°
	1612C-WH				
	1412C-WH-90				

α indicates the rake angle at the center of the edge width after installing insert

Applicable Range of Internal Grooving Tool (SIGE and SIGC)



SIGE Excellent Bar (With Coolant hole)



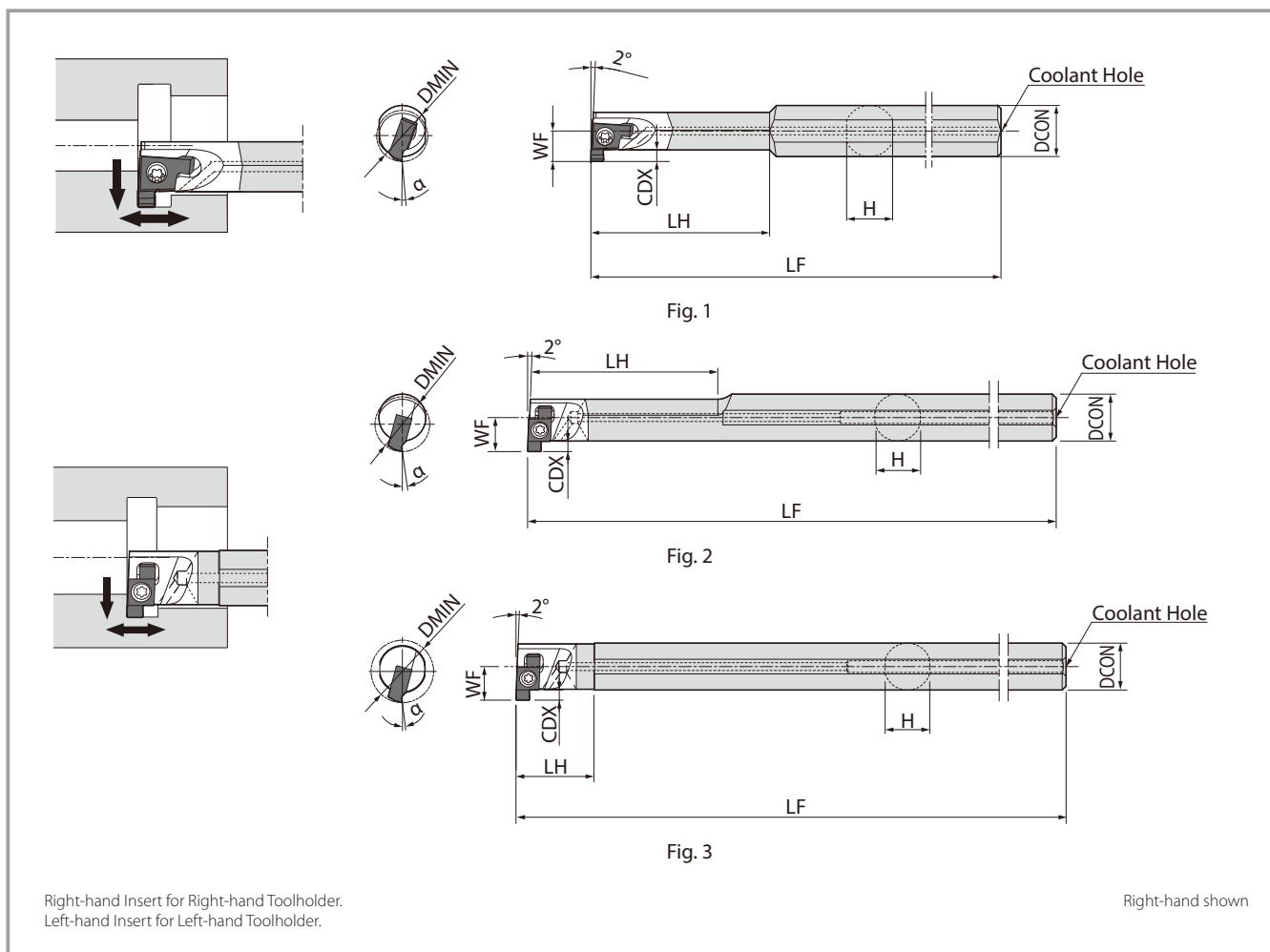
Toolholder Dimentions

Description	Stock		Minimum Cutting Dia. (mm)	Dimensions (mm)						Coolant Hole	Shape	Spare Parts				Applicable Insert				
	R	L		DCON	H	LF	LH	WF	CDX			Clamp Screw	Wrench							
SIGER/L 0808A-EH	●	●	8	8	7.2	100	20	4.8	1.5	Yes	Fig. 1	SB-2045TRN	-	-	FT-6	GER/L...A/AR				
SIGER/L 1010B-EH	●	●	10	10	9	125	25	6.2	2.2	Yes	Fig. 1	SB-2255STR	-	DT-7	-	GER/L...B GER/L...BR				
1210B-EH	●	●	12				30	7									Fig. 2			
SIGER/L 1412C-EH	●	●	14	12	11.4	150	33	8	2.5	Yes	Fig. 3	SB-2570TR	-	-	FT-8	GER/L...C GER/L...CM GER/L...CR				
1612C-EH	●	●	16				16	15									160	20	8.5	Fig. 4
1616C-EH	●	●																36	9	Fig. 5
SIGER/L 2020D-EH	●	●	20	20	19	180	40	12.1	4.5	Yes	Fig. 5	SB-3080TR	-	-	FT-10	GER/L...D/DM/DR				
SIGER/L 2525E-EH	●	●	25	25	24	200	45	15.6	6.5	Yes	Fig. 5	SB-4085STR	FT-15	-	-	GER/L...E GER/L...EM				
3232E-EH	●	●	32				32	30.4									220	55	19	Fig. 5
4032E-EH	●	●	40														250	45	23	Fig. 6




CDX shows the distance from the toolholder to the cutting edge. Available groove depth: "CDX" of insert

● : Standard Stock

SIGE Carbide Anti-vibratoin Bar (With Coolant hole)



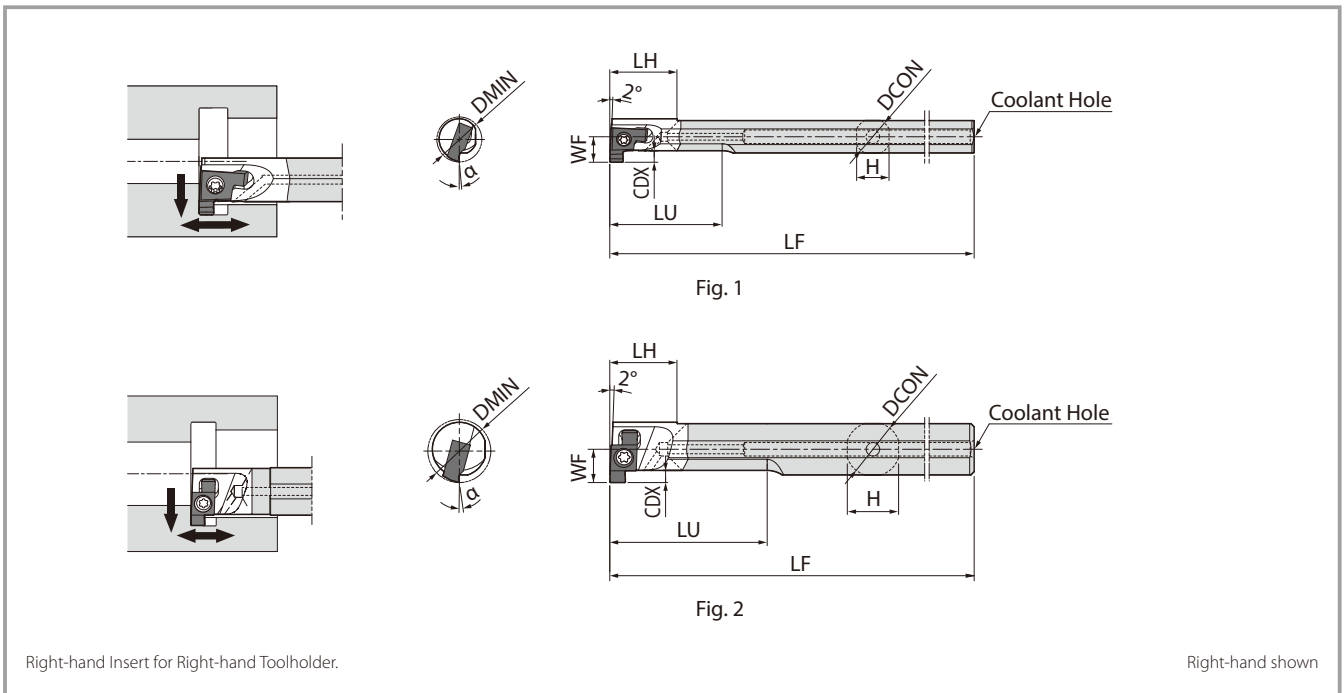
Toolholder Dimentions

Description	Stock		Minimum Cutting Dia. (mm)	Dimensions (mm)						Coolant Hole	Shape	Spare Parts			Applicable Insert
	R	L		DCON	H	LF	LH	WF	CDX			Clamp Screw	Wrench		
															
SIGER/L 0808A-WH	●	●	8	8	7.2	125	28	4.8	1.5	Yes	Fig. 1	SB-2045TRN	-	FT-6	GER/L...A/AR
SIGER/L 1010B-WH	●	●	10	10	9	125	35	6.2	2.2	Yes	Fig. 1	SB-2255TR	DT-7	-	GER/L...B GER/L...BR
1210B-WH	●	●	12			140	45	7							
SIGER/L 1412C-WH	●	●	14	12	11.4	150	50	8.7	2.5	Yes	Fig. 2 Fig. 3	SB-2570TR	-	FT-8	GER/L...C GER/L...CM GER/L...CR
1612C-WH	●	●	16			180	20	8.5							



CDX shows the distance from the toolholder to the cutting edge. Available groove depth: "CDX" of insert

● : Standard Stock

SIGE Carbide Anti-vibratoin Bar (With Coolant hole • For Automatic Lathe)



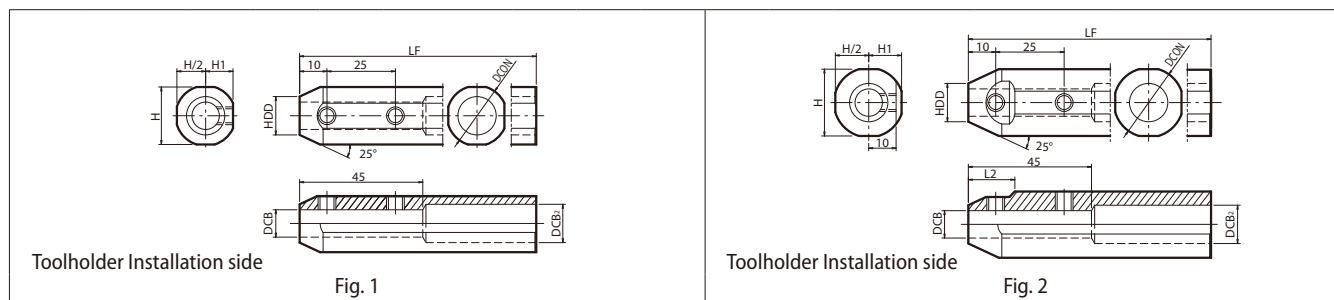
Toolholder Dimention See next page for applicable sleeves



Description	Stock	Minimum Cutting Dia. (mm)	Dimensions (mm)							Coolant Hole	Shape	Spare Parts		Applicable Insert		
			R	DMIN	DCON	H	LF	LH	LU			WF	CDX		Clamp Screw	Wrench
																
SIGER 1008B-WH-90	●	10	8	7.2	90	15	25	5.6	2.2	Yes	Fig. 1	SB-2255TR	FT-7	GER/L...B GER/L...BR		
1210B-WH-90	●	12	10	9.4			30	6.6								
SIGER 1412C-WH-90	●	14	12	11.4	90	15	35	7.4	2.5	Yes	Fig. 2	SB-2570TR	FT-8	GER/L...C/CM/CR		

CDX shows the distance from the toolholder to the cutting edge. Available groove depth: "CDX" of insert
 LH shows minimum overhang length (Distance from the cutting edge to the rear flat cut end position).

● : Standard Stock

Applicable Sleeve (For Automatic Lathe)



Description	Stock	Dimensions (mm)									Shape	Spare Parts		Applicable Machine Manufacturer (Random order)
		DCB	DCON	HDD	DCB ₂	H	H1	LF	L2	Clamp Screw		Wrench		
														
SHA 0820-120	●	8	20	14	12	19	9.25	120	-	Fig. 1	HS6X4P	LW-3	EGURO TSUGAMI CITIZEN MACHINERY	
SHA 1020-120	●	10												
SHA 0825.0-135	●	8	25	14	14	24	11.5	135	17	Fig. 2				
SHA 1025.0-135	●	10												
SHA 1225.0-135	●	12												
SHA 0819-120	●	8	19.05	14	12	18	8.75	120	-	Fig. 1				
SHA 1019-120	●	10												
SHA 0820-120	●	8	20	14	12	19	9.25	120	-	Fig. 1				
SHA 1020-120	●	10												
SHA 0825.4-120	●	8	25.4	14	14	24.4	12	120	17	Fig. 2				
SHA 1025.4-120	●	10												
SHA 1225.4-120	●	12												
SHA 0822-125	●	8	22	14	14	21	10	125	-	Fig. 1				
SHA 1022-125	●	10												
SHA 1222-125	●	12												
SHA 0823-120	●	8	23	14	14	22	10.5	120	16	Fig. 2				
SHA 1023-120	●	10												
SHA 1223-120	●	12												

Length of DCB ... 45mm (all SHA types)

Select the sleeve DCB to match the DCON dimension of the toolholder.