

DO-GRIP • SELF-GRIP

New SELF-GRIP Holders

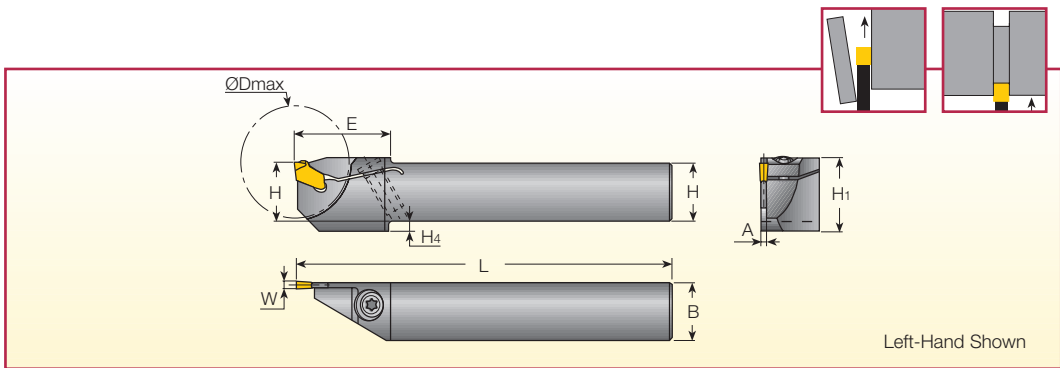
SELF-GRIP SGFR/L-..B-..D-..SH Integral Shank Holders for Small Swiss-Type CNC Machines

These new holders are designed for Swiss-type automatics where tools slide during parting applications, in the radial direction, and require very small head heights to avoid collision. The new holders have head heights very close to the shank size, allowing it to move towards center. The new upper jaw resiliency results in easy, fast insert indexing, while the slant screw guarantees strong and safe clamping of the insert in the seat.

The users of Swiss-type automatics requiring short head heights will now be able to take advantage of ISCAR's large selection of SELF-GRIP type inserts for improved parting efficiency and performance. In many

of these machines, the parting tools slide downward during operation. Operator safety demands very secure clamping, an additional feature of these screw-clamped holders. The GFN/R/L type inserts feature rear stoppers for exact insert positioning.

All of the SELF-GRIP inserts are available with J, JS and C type chipformers in combination with frontal angles in neutral, 6°, 8° or 15° and are available in TiCN PVD coated grades IC328 and IC308.



SGFR/L-B-D-SH

W range	Dmax	Designation	HxB	A	L	E	H ₁	H ₄	Screw	Insert
1.2	15	SGFR/L 8B-1.2D15SH	8x8	0.9	120	14	9	—	—	GF□-1.2
1.6	15	SGFR/L 8B-1.6D15SH	8x8	1.2	120	14	9	—	SR 14-541	GF□-1.6
1.2	15	SGFR/L 10B-1.2D15SH	10x10	0.9	120	14	11	—	—	GF□-1.2
1.6	15	SGFR/L 10B-1.6D15SH	10x10	1.2	120	14	11	—	SR 16-236	GF□-1.6
1.80-2.69	20	SGFR/L 10B-2D20SH	10x10	1.6	120	18	13	2	—	GF□-2;2,4
1.2	24	SGFR/L 12B-1.2D24SH	12x12	0.9	140	18	13	—	—	GF□-1.2
1.6	24	SGFR/L 12B-1.6D24SH	12x12	1.2	140	18	13	—	SR 16-236P	GF□-1.6
1.80-2.69	24	SGFR/L 12B-2D24SH	12x12	1.6	140	18	13	—	—	GF□-2;2,4
1.80-2.69	24	SGFR/L 16B-2D24SH	16x16	1.6	140	18	17	—	SR 16-236P	GF□-2;2,4

Key: T-15/5

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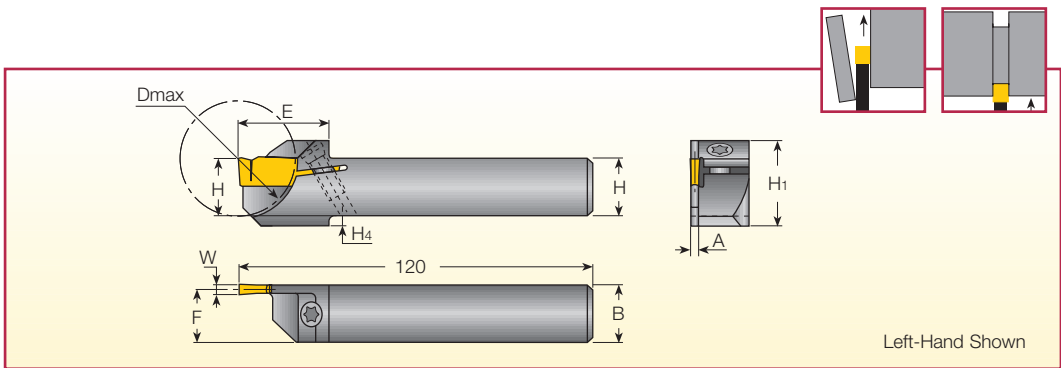
New DO-GRIP and SELF-GRIP Tools

DO-GRIP DGTR/L-...B-..D..SH Integral Shank Holders for Small Swiss-Type CNC Machines

These new holders feature screw clamping, short heads and smaller overhangs for improved stability, rigidity and machine performance. Head lengths have been reduced by 15% compared to previous holders, as requested by machine producers.

These holders function best on machines such as Tsugami, Traub, Star, Miyano and Citizen, all having sideways moving slides and tools. This growing market can now take advantage of ISCAR's economical double-ended DO-GRIP inserts and their high

accuracy and versatility. The ISCAR DGTR/L holders with DO-GRIP inserts provide excellent productivity and are a preferred alternative to solid HSS, carbide and brazed tools as well as many indexable inserts in a variety of parting applications. All inserts are clamped with a slanted screw for fast indexing, optimal clamping forces and safety.



Left-Hand Shown

DGTR/L-B-D-SH

H	W	Designation	B	A	F	E	Dmax	H ₁	H ₄	Insert
10	1.4	DGTR/L 10B-1.4D20SH ⁽¹⁾	10	1.0	9.5	18	20	13.7	—	DG...-14...
10	1.0/2.0/2.2	DGTR/L 10B-2D20SH ⁽¹⁾	10	1.6	9.2	19	20	15.7	2	DG...-10../DG.-2..
12	1.4	DGTR/L 12B-1.4D24SH	12	1.0	11.5	19	24	15.7	—	DG...-14...
12	1.0/2.0/2.2	DGTR/L 12B-2D24SH	12	1.6	11.2	19	24	15.7	—	DG...-10../DG.-2..
12	1.0/3.0/3.1	DGTR/L 12B-3D24SH	12	2.4	10.8	19	24	15.7	—	DG...-10../DG.-3..
16	1.0/2.0/2.2	DGTR/L 16B-2D25SH	16	1.6	15.2	20	25.4	19.7	—	DG...-10../DG.-2..
16	1.0/3.0/3.1	DGTR/L 16B-3D25SH	16	2.4	14.8	20	25.4	19.7	—	DG...-10../DG.-3..

Screw: SR 34-510

⁽¹⁾ Screw: SR 16-236/P

Supplied Key: T-15/5

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New DO-GRIP and SELF-GRIP Tools

Iscar has developed a unique family of tools for parting applications on Swiss-type automatics, single and multi-spindle screw machines and small CNC-controlled machines.

These new tools are ideally suited for mass production industries, such as hydraulics, bearings and automotive parts.

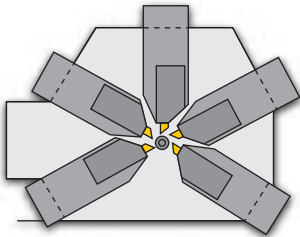
DGTR-B-D-SH



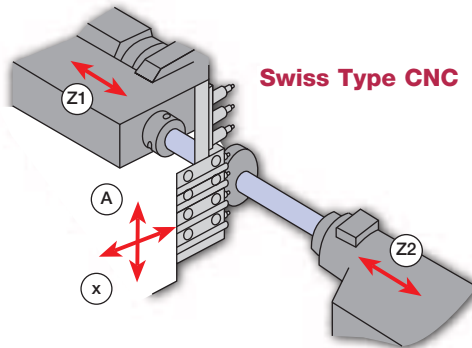
Holders for Adapters



Machine Types:

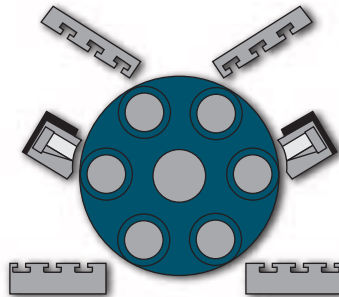


Swiss Type Automatics



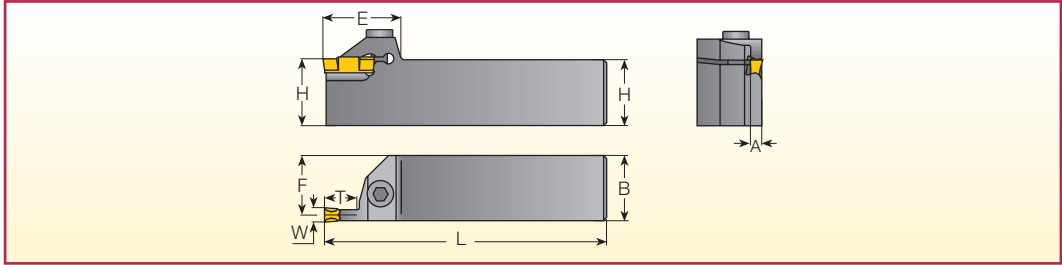
Swiss Type CNC

**Single and Multi-Spindle
(Screw Machines)**

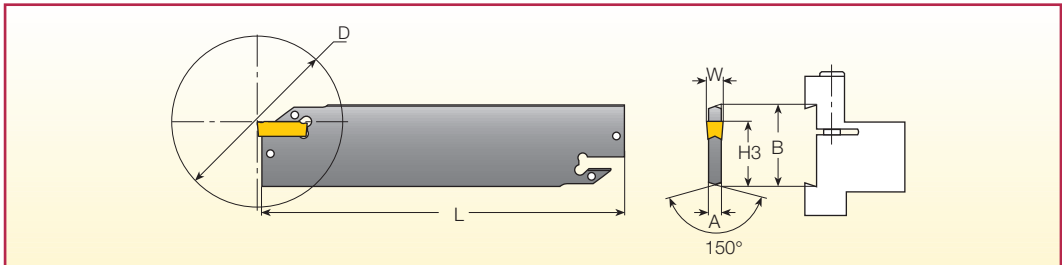


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Tools for HGN 3mm Double-Ended Insert



Designation	HXB	L	F	A	Tmax.	E	Screw	W	Insert
HELIR/L-1212-3T12	12X12	135	10.8	2.4	12	30	SR-M5X20	3	HGN-3 or GRIP-3
HELIR/L-1616-3T12	16X16	135	14.8	2.4	12	30	SR-M5X20	3	HGN-3 or GRIP-3
HELIR/L-1616-3T20	16X16	140	14.8	2.4	20	36.4	SR-M6X20	3	HGN-3 or GRIP-3
HELIR/L-2020-3T12	20X20	135	18.8	2.4	12	30	SR-M5X20	3	HGN-3 or GRIP-3
HELIR/L-2020-3T20	20X20	140	18.8	2.4	20	36.4	SR-M6X20	3	HGN-3 or GRIP-3
HELIR/L-2525-3T12	25X25	135	23.8	2.4	12	30	SR-M5X25	3	HGN-3 or GRIP-3
HELIR/L-2525-3T20	25X25	140	23.8	2.4	20	36.4	SR-M6X25	3	HGN-3 or GRIP-3



Designation	B	W	A	L	H3	D(1)max	Extractor	Insert
HGFH 26-3	26	3.0	2.4	110	21.4	75	EDG-23B	HGN-3 or GRIP-3
HGFH 32-3	32	3.0	2.4	150	24.8	100	EDG-23B	HGN-3 or GRIP-3