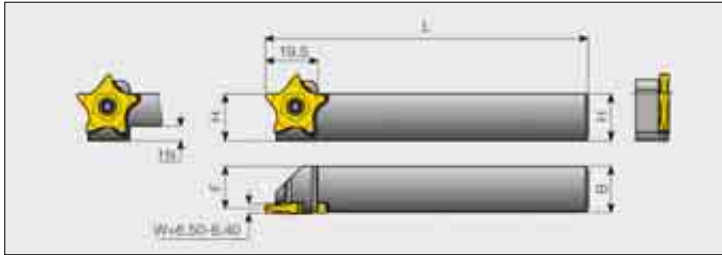




**PENTACUT**

ISCAR has developed a new insert designated PENTACUT, with 5 cutting edges, for multifunction applications including grooving, parting, recessing and chamfering.

This cost effective insert is designed to perform shallow grooving operations and parting of small solid bars up to 12.5 mm in diameter. Each cutting edge on the pentagonal shaped insert is equipped with a unique J-type positive chipformer that provides excellent chip control in grooving, parting and recessing (light side turning) applications.



**PCHR/L Integral Shank Toolholders**

Designation	HxB	F	L	H4	Screw	Torx Key	Insert	Order Code <b>ISC-134</b>		Offer Price/1
								Left Hand	Right Hand	
PCHR/L 10-24	10x10	8.5	120	6				<b>-4173R</b>	<b>-4179E</b>	<b>£53.05</b>
PCHR/L 12-24	12x12	10.5	120	4				<b>-4174S</b>	<b>-4180F</b>	<b>£55.80</b>
PCHR/L 16-24	16x16	14.5	120	—	SR 16-212-01397 <sup>(1)</sup>	T2010/5	PENTA 24...	<b>-4175T</b>	<b>-4180T</b>	<b>£59.42</b>
PCHR/L 20-24	20x20	18.5	120	—	SR 16-212-01397L <sup>(2)</sup>	T2010/5		<b>-4176V</b>	<b>-4181G</b>	<b>£73.01</b>
PCHR/L 25-24	25x25	23.5	135	—				<b>-4177W</b>	<b>-4182H</b>	<b>£77.54</b>

<sup>(1)</sup> For right-hand holders.

<sup>(2)</sup> For left-hand holders.

**PENTA 24N — Precision Grooving, Parting and Recessing**

W <sup>±0.02</sup>	Designation	R	Tmax	Tmax/Dmax	T≤3.0	T≤3.5	T≤4.0	T≤4.5	T≤5.0	T≤5.5	T≤6.0	T≤6.5	Order Code <b>ISC-131</b>		Offer Price/1
													IC908	IC1008	
0.50	24N050J000	0.00	1.0	1.0/N.L.	—	—	—	—	—	—	—	—	<b>-5060S</b>		<b>£31.66</b>
0.50	24N050J004 <sup>(2)</sup>	0.04	2.5	2.5/N.L.	—	—	—	—	—	—	—	—	<b>-5080X</b>		<b>£27.87</b>
0.80	24N080J000	0.00	1.6	1.6/N.L.	—	—	—	—	—	—	—	—	<b>-5082S</b>		<b>£29.73</b>
1.00	24N100J006 <sup>(2)</sup>	0.06	3.5		N.L.	250	—	—	—	—	—	—	<b>-5085X</b>		<b>£24.22</b>
1.04	24N050J000	0.00	2.0	2.0/N.L.	—	—	—	—	—	—	—	—	<b>-5086S</b>		<b>£27.52</b>
1.20	24N120J000	0.00	2.0	2.0/N.L.	—	—	—	—	—	—	—	—	<b>-5087S</b>		<b>£27.52</b>
1.40	24N140J000	0.00	2.0	2.0/N.L.	—	—	—	—	—	—	—	—	<b>-5088S</b>		<b>£27.52</b>
1.47	24N147J000	0.00	2.5	2.5/N.L.	—	—	—	—	—	—	—	—	<b>-5089S</b>		<b>£27.52</b>
1.50	24N150J010 <sup>(2)</sup>	0.10	5.0		N.L.	470	210	70	30	—	—	—	<b>-5090S</b>	<b>-5090X</b>	<b>£24.22</b>
1.57	24N157J015	0.15	3.0		N.L.	—	—	—	—	—	—	—	<b>-5098S</b>		<b>£27.52</b>
1.57	24N157J079	0.79	3.0		N.L.	—	—	—	—	—	—	—	<b>-5100S</b>		<b>£29.15</b>
1.70	24N170J010	0.10	3.0		N.L.	—	—	—	—	—	—	—	<b>-5110S</b>		<b>£27.52</b>
1.78	24N178J018	0.18	3.0		N.L.	—	—	—	—	—	—	—	<b>-5120S</b>		<b>£27.52</b>
1.96	24N196J015	0.15	3.0		N.L.	—	—	—	—	—	—	—	<b>-5130S</b>		<b>£27.52</b>
2.00	24N200J020 <sup>(2)</sup>	0.20	6.0		N.L.	470	210	130	75	45	20	—	<b>-5140S</b>	<b>-5140X</b>	<b>£24.22</b>
2.00	24N200J000	1.00	3.0		N.L.	—	—	—	—	—	—	—	<b>-5142S</b>		<b>£29.15</b>
2.22	24N222J015	0.15	3.5		N.L.	250	—	—	—	—	—	—	<b>-5146S</b>		<b>£27.52</b>
2.30	24N230J020	0.20	3.5		N.L.	250	—	—	—	—	—	—	<b>-5148S</b>		<b>£27.52</b>
2.39	24N239J015	0.15	5.0		N.L.	470	210	70	30	—	—	—	<b>-5150S</b>		<b>£27.52</b>
2.39	24N239J120	1.20	5.0		N.L.	470	210	70	30	—	—	—	<b>-5152S</b>		<b>£29.15</b>
2.47	24N247J020	0.20	5.0		N.L.	470	210	70	30	—	—	—	<b>-5160S</b>		<b>£28.38</b>
2.70	24N270J010	0.10	5.0		N.L.	470	210	135	100	80	67	40	<b>-5170S</b>		<b>£28.38</b>
2.87	24N287J020	0.20	6.5		N.L.	470	210	135	100	80	67	40	<b>-5180S</b>		<b>£28.38</b>
3.00	24N300J000	0.00	6.5		N.L.	470	210	135	100	80	67	40	<b>-5200S</b>		<b>£28.38</b>
3.00	24N300J020	0.20	6.5		N.L.	470	210	135	100	80	67	40	<b>-5210S</b>		<b>£28.38</b>
3.00	24N300J040	0.40	6.5		N.L.	470	210	135	100	80	67	40	<b>-5214S</b>		<b>£28.38</b>
3.00	24N300J150	1.50	6.5		N.L.	470	210	135	100	80	67	40	<b>-5220S</b>		<b>£30.11</b>
3.15	24N315J015	0.15	6.5		N.L.	470	210	135	100	80	67	40	<b>-5240S</b>		<b>£28.38</b>
3.18	24N318J020	0.20	6.5		N.L.	470	210	135	100	80	67	40	<b>-5250S</b>		<b>£28.38</b>

<sup>(1)</sup> Recessing is possible only with 2.39mm and wider inserts.

<sup>(2)</sup> Available also in IC1008 grade.

**Recommended Machining Conditions for Grooving**

f (mm/rev)	Material	← <b>TOUGHER</b>	
		IC908	IC1008
0.05-0.18	●	Vc (m/min)	
	●	140-260	150-300
	●	110-240	80-230
		110-210	95-240

**PENTA R/L/N — Parting and Grooving**

W <sup>±0.02</sup>	Designation	R	K°	Parting To Center Dmax	Parting Hollow Bars		Order Code <b>ISC-131</b>		Offer Price/1
					Tmax	Dmax	Right Hand	Left Hand	
1.00	24R/L100J15D	0.06	15	7.0	3.5	30	<b>-5260X</b>	<b>-5040X</b>	<b>£24.22</b>
1.50	24R/L150J06D	0.06	6	10.0	50.0	30	<b>-5262X</b>	<b>-5042X</b>	<b>£24.22</b>
1.50	24R/L150J15D	0.06	15	10.0	50.0	30	<b>-5264X</b>	<b>-5044X</b>	<b>£24.22</b>
2.00	24R/L200J06D	0.10	6	12.0	6.0	20	<b>-5266X</b>	<b>-5046X</b>	<b>£24.22</b>
2.00	24R/L200J15D	0.10	15	12.0	6.0	20	<b>-5268X</b>	<b>-5048X</b>	<b>£24.22</b>

<sup>(1)</sup> If T is not defined, or T>3.0, grooving depth is limited by the holder.