motherson

DELTACARB
HARDMETAL Switzerland

Soft tools for Lathe



Brochure/MDC/2025/007

motherson

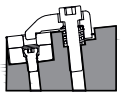
DELTACARB
HARDMETAL Switzerland

Nomenclature - Tool Holders

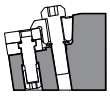
D	C	L	N	R	20	20	K	12	–	M
1	2	3	4	5	6	7	8	9		Motherson

1.Clamp type

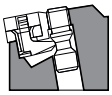
Double Clamp **D**



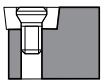
Top Clamp+ Pin Locks **M**



Lever Lock **P**



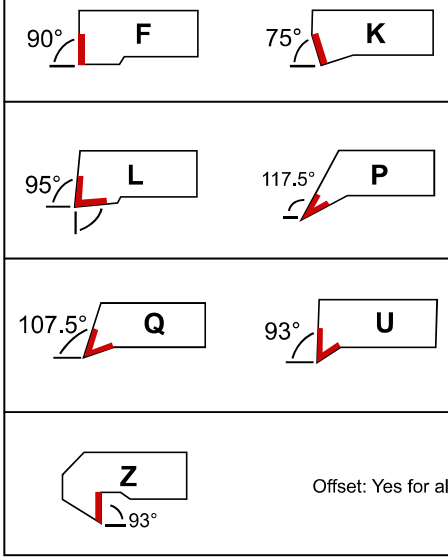
Top Screw **S**



2. Insert Shape

Symbol	Insert Shape		Apex Angle
C		Diamond	80°
D			55°
E			75°
F			50°
V			35°
R		Round	—
S		Square	90°
T		Triangle	60°
W		Trigon	80°
A		Paralello--gram	85°
B			82°
K			55°
H		Hexagon	120°
O		Octagon	135°
P		Pentagon	108°
L		Rectangle	90°
M		Diamond	86°

3. Holder approach angle



4. Relief angle

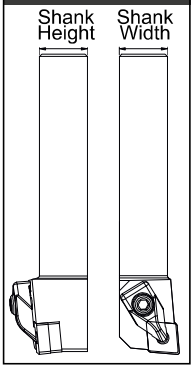
Symbol	Relief Angle
A	3°
B	5°
C	7°
D	15°
E	20°
F	25°
G	30°
N	0°
P*	11°
O	Others

★ mark indicates inserts that are sometimes used with a 10° relief angle

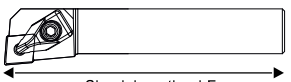
5. Side

R	Right
L	Left

Shank Size 6 7

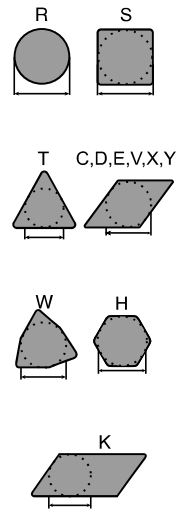


8. Shank Length(mm)



F	80	P	170
G	90	Q	180
H	100	R	200
J	110	S	250
K	125	T	300
L	140	U	350
M	150	V	400
N	160	W	450

9. IC



motherson

DELTACARB
HARDMETAL Switzerland

Nomenclature - Boring Bars

A	08	K	S	C	L	C	R	06	–	M
1	2	3	4	5	6	7	8	9		Motherson

1. Shank Material

S - Steel Shank

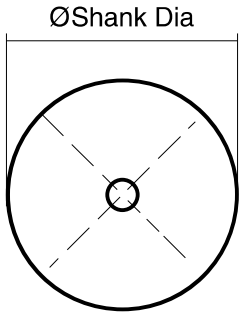
A - Steel Shank with coolant hole

C - Carbide Shank

E - Coolant Through Carbide Shank

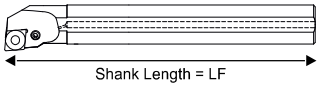
X - Special

2. Shank Dia (mm)



ØShank Dia = Dc			
08	12	20	32
10	16	25	40

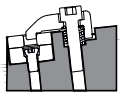
3. Shank Length(mm)



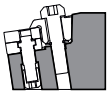
F	80	P	170
G	90	Q	180
H	100	R	200
J	110	S	250
K	125	T	300
L	140	U	350
M	150	V	400
N	160	W	450

4.Clamp type

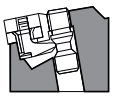
Double Clamp **D**



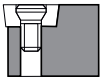
Top Clamp+ Pin Locks **M**



Lever Lock **P**



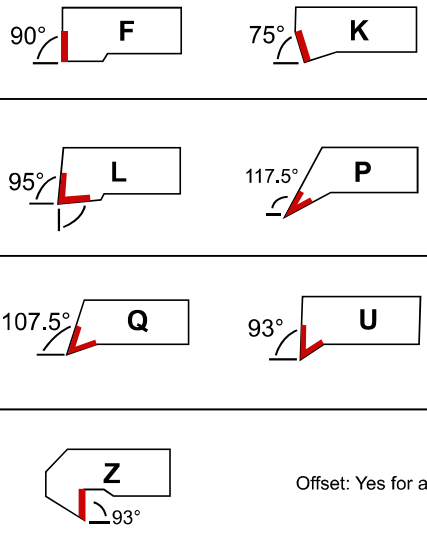
Top Screw **S**



5. Insert Shape

Symbol	Insert Shape		Apex Angle
C		Diamond	80°
D			55°
E			75°
F			50°
V			35°
R		Round	–
S		Square	90°
T		Triangle	60°
W		Trigon	80°
A		Paralello--gram	85°
B			82°
K			55°
H		Hexagon	120°
O		Octagon	135°
P		Pentagon	108°
L		Rectangle	90°
M		Diamond	86°

6. Holder approach angle



7. Relief angle

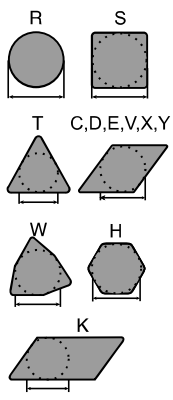
Symbol	Relief Angle
A	3°
B	5°
C	7°
D	15°
E	20°
F	25°
G	30°
N	0°
P*	11°
O	Others

★ mark indicates inserts that are sometimes used with a 10° relief angle

8. Side

R	Right
L	Left

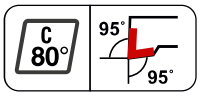
9. IC



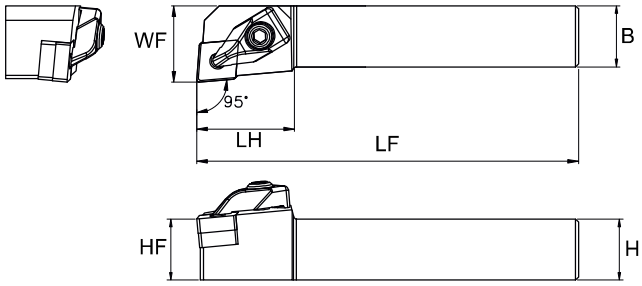
motherson

DELTACARB
HARDMETAL Switzerland

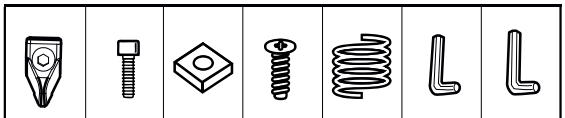
Holder series C type



DCLN type — Turning Holder

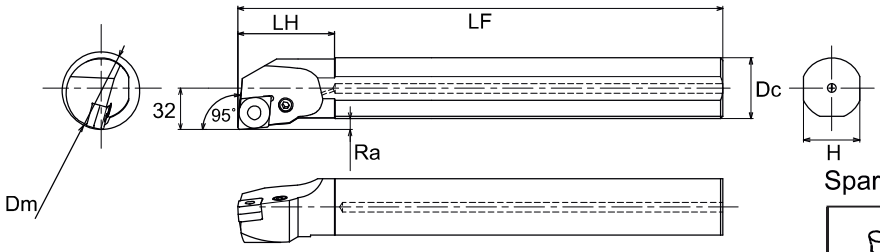


Spare Parts

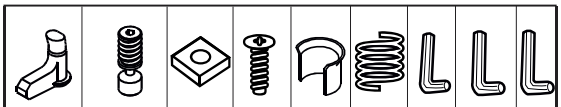


Cat. No.	Stock		Dimensions (mm)						Applicable Inserts	Top Clamp	Top Clamp Screw	Shim	Shim Screw	Spring	Key for top	Key for bottom
	R	L	H	B	LF	WF	HF	LH	Description							
DCLN R/L2020K12-M	●	●	20	20	125	25	20	32	CN.....1204.....	TC-DLM-4	TCS-DLM-4-M5X20-P	SM-CN-12-D	SW-M5X12-C	SG-Ø7X10	KY-2.5MM	KY-3MM
DCLN R/L2525M12-M	●	●	25	25	150	32	25	32								

A-PCLN type — Boring Bar

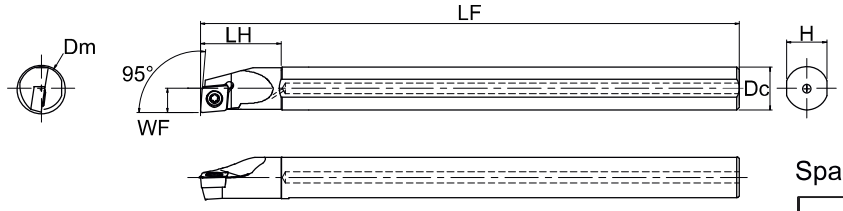


Spare Parts

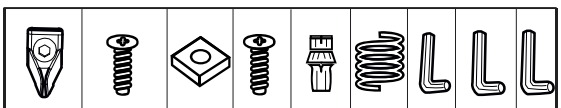


Cat. No.	Stock		Min. machining diameter	Diameter	Height	Length	Head	Cutting edge distance	Offset	Applicable inserts	Lever	Lever Screw	Shim	Shim Screw	Lever Pin	Spring	Key for top	Key for bottom	Key
	R	L	Dm	Dc	H	LF	LH	WF	Ra°	Description									
A25R-PCLNR12-M	●		32	25	23	200	40	17	4.5	CN.....1204.....	LR-CN12	LS-M8X1X18 MM	SM-CN12-P	-	SP-CN12	-	-	KY-3.5MM	-
A4OU-PCLNR12-M	●		30	40	37	350	65	25	5.0										
A50U-PCLNR12-M	●		63	50	47	350	65	32	7.0										

A-SCLC type — Boring Bar



Spare Parts

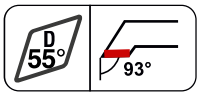


Cat. No.	Stock		Min. machining diameter	Diameter	Height	Length	Head	Cutting edge distance	Offset	Applicable inserts	Top Clamp	Clamp Screw	Shim	Shim Screw	Shim Pin	Spring	Key for top	Key for bottom	Key
	R	L	Dm	Dc	H	LF	LH	WF	Ra°	Description									
A08K-SCLCR06-M	●		**10**	08	07	125	19	5.5	1.5	CC.....0602.....	-	SC-M2.5X55°X4.5 MM	-	-	-	-	-	-	KY-T08F
A10L-SCLCR06-M	●		**12**	10	09	140	21	6.0	1.0										
A16R-SCLCR09-M	●		**18**	16	15	200	30	9.0	1.0	CC.....09T3.....	-	SC-M4X60°X8 MM	-	-	-	-	-	-	KY-T15F
A20S-SCLCR09-M	●		**22**	20	18	250	30	11.0	1.0										

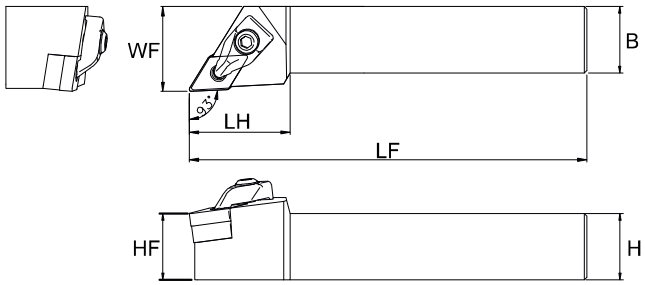
motherson

DELTACARB
HARDMETAL Switzerland

Holder series D type



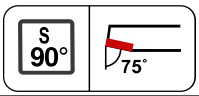
DDJN type — **Turning Holder**



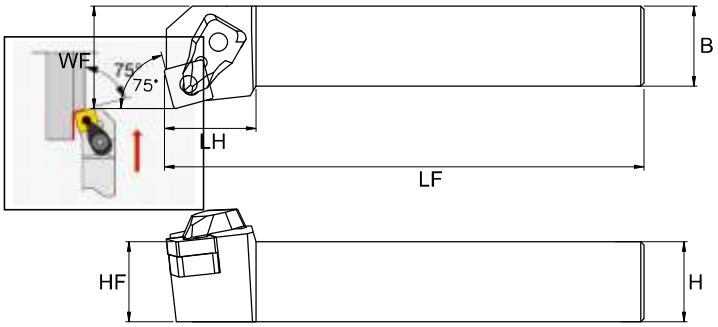
Spare Parts

Cat. No.	Stock		Dimensions (mm)						Applicable Inserts	Top Clamp	Top Clamp Screw	Shim	Shim Screw	Spring	Key for top	Key for bottom
	R	L	H	B	LF	WF	HF	LH	Description							
DDJN R2525M1504-M	●		25	25	150	32	25	38	DN.....1504.....	TC-DLM-4	TCS-DLM-4-M5X 20-P	SM -DN-15	SW-M5 X12-S	SG-Ø7X10	KY-2.5MM	KY-3MM
DDJN R2525M1506-M	●		25	25	150	32	25	38	DN.....1506.....	TC-DLM-4	TCS-DLM-4-M5X 20-P	SM -DN-15	SW-M5 X12-S	SG-Ø7X10	KY-2.5MM	KY-3MM

Holder series S type



DSKN type — **Turning Holder**



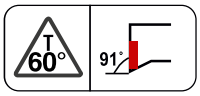
Spare Parts

Cat. No.	Stock		Dimensions (mm)						Applicable Inserts	Top Clamp	Top Clamp Screw	Shim	Shim Screw	Spring	Key for top	Key for bottom
	R	L	H	B	LF	WF	HF	LH	Description							
DSKN R/L2525M12-M	●	●	25	25	150	32	25	29	SN.....1204.....	TC-DLM-4	TCS-DLM-4-M5X 20-P	SM -SN-12	SW-M5 X12-C	SG-Ø7X10	KY-2.5MM	KY-3MM

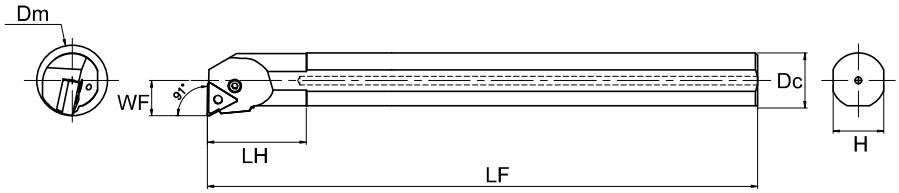
motherson

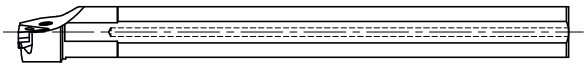
DELTACARB
HARDMETAL Switzerland

Holder series T type

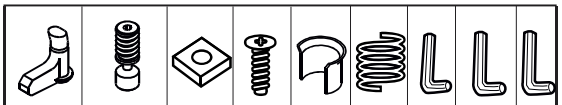


A-PTFN type — Boring Bar



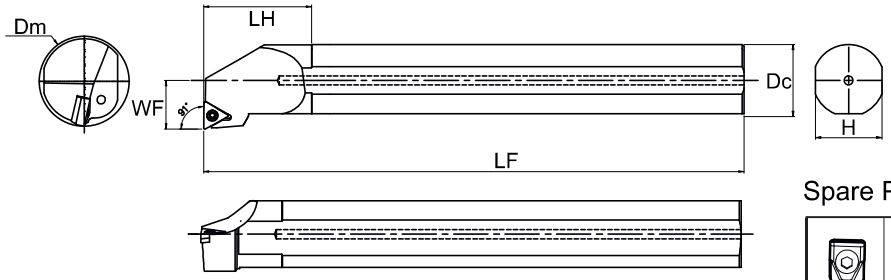


Spare Parts

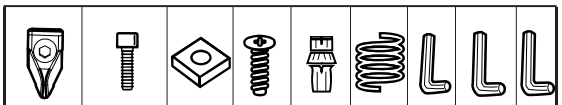


Cat. No.	Stock		Min. machining diameter	Diameter	Height	Length	Head	Cutting edge distance	Offset	Applicable inserts	Lever	Lever Screw	Shim	Lever Screw	Lever Pin	Spring	Key for top	Key for bottom	Key
	R	L	Dm	Dc	H	LF	LH	WF	Ra°	Description									
A25S-PTFNR16-M	●		32	25	23	250	45	16	3.5	TN.....1604.....	LR-TN16	LS-M6X1	SM-TN 16-LE	-	SP-TN 16	-	-	KY-2.5MM	-

A-STFCR type — Boring Bar

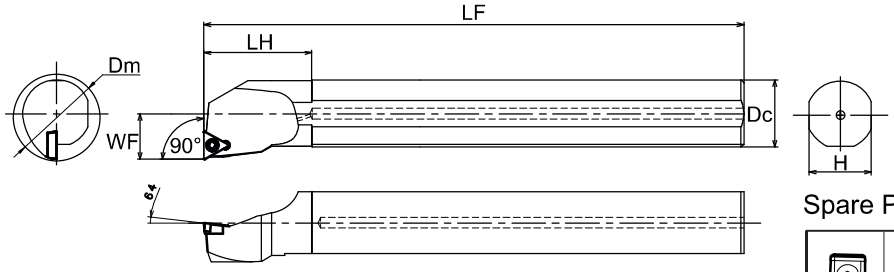


Spare Parts

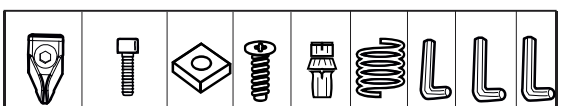


Cat. No.	Stock		Min. machining diameter	Diameter	Height	Length	Head	Cutting edge distance	Offset	Applicable inserts	Top Clamp	Clamp Screw	Shim	Shim Screw	Shim Pin	Spring	Key for top	Key for bottom	Key
	R	L	Dm	Dc	H	LF	LH	WF	Ra°	Description									
A32S-STFCR16-M	●		40	32	30	250	45	22	6	TC.....16T3.....	-	SC-M3,5 X11MM	SM-TC16	SW-TC 16-DT-M5X0.5	-	-	-	KY-3.5MM	KY-T 15F
A40T-STFCR16-M	●		50	40	37	300	60	27	7										

A-STFPR type — Boring Bar



Spare Parts

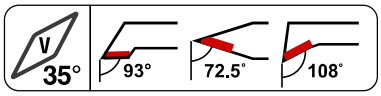


Cat. No.	Stock		Min. machining diameter	Diameter	Height	Length	Head	Cutting edge distance	Offset	Applicable inserts	Top Clamp	Clamp Screw	Shim	Shim Screw	Shim Pin	Spring	Key for top	Key for bottom	Key
	R	L	Dm	Dc	H	LF	LH	WF	Ra°	Description									
A25R-STFPR11-M	●		32	25	23	200	40	17	4.5	TP.....1103.....	-	SC-M2,5 X55°X 6MM	-	-	-	-	-	-	KY-T08F

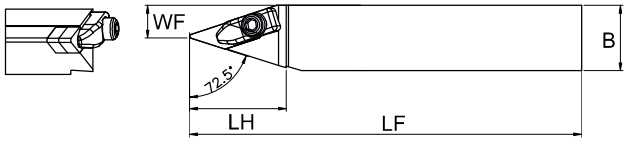
motherson

DELTACARB
HARDMETAL Switzerland

Holder series V type



DVVN type — Turning Holder

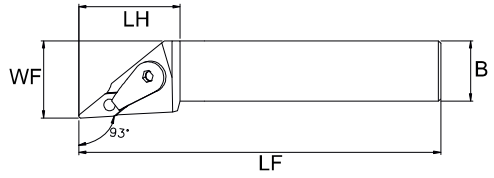


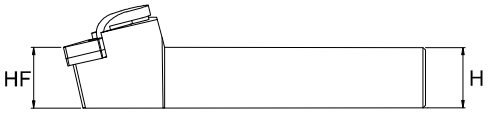


Spare Parts

Cat. No.	Stock	Dimensions (mm)						Applicable Inserts	Top Clamp	Top Clamp Screw	Shim	Shim Screw	Spring	Key for top	Key for bottom
		H	B	LF	WF	HF	LH	Description							
DVVN N2525M16-M	●	25	25	150	12.5	25	37	VN.....1604.....	TC -DLM-3V	TCS-M5 X20	SM -VN-16	SW-VN16-DT -M5X20	SG-Ø6X10	KY-3.5MM	KY-3MM

MVJN type — Turning Holder

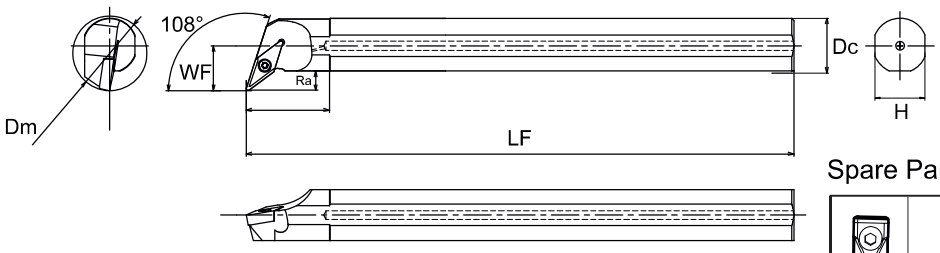




Spare Parts

Cat. No.	Stock		Dimensions (mm)						Applicable Inserts	Top Clamp	Top Clamp Screw	Shim	Shim Screw	Spring	Key for top	Key for bottom
	R	L	H	B	LF	WF	HF	LH	Description							
MVJN L2525M16-M		●	25	25	150	32	25	42	VN.....1604.....	TC-E-VN16	TCS-E-VN16-M6LH/RH	SM-VN16-EC	SW-MLP-3-EC	-	KY-2MM	KY-3MM

A-SVQBR type — Boring Bar



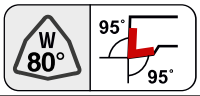
Spare Parts

Cat. No.	Stock		Min. machining diameter	Diameter	Height	Length	Head	Cutting edge distance	Offset	Applicable inserts	Top Clamp	Clamp Screw	Shim	Shim Screw	Shim Pin	Spring	Key for top	Key for bottom	Key
	R	L	Dm	Dc	H	LF	LH	WF	Ra°	Description									
A25S-SVQBR16-M	●		34	25	23	250	38	20.5	4.5	VB.....1604.....	-	SC-M3.5 X60°X 8.0MM	-	-	-	-	-	-	KY-T 15F
A40T-SVQBR16-M	●		50	40	37	300	55	27	7.0				SM-VB16	SW-V B16-DT-M5X0.5				KY-3.5MM	

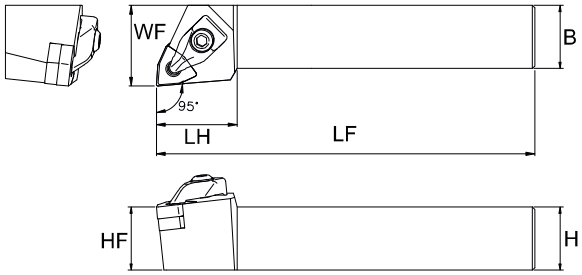
motherson

DELTACARB
HARDMETAL Switzerland

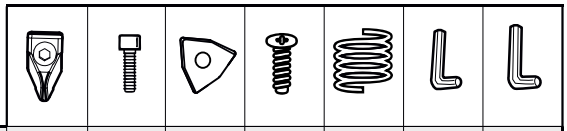
Holder series W type



DWLN type — Turning Holder

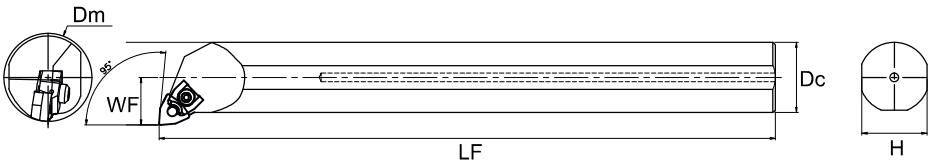


Spare Parts

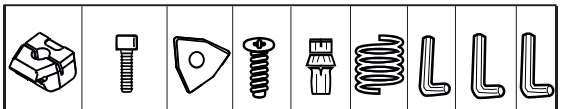


Cat. No.	Stock		Dimensions (mm)						Applicable Inserts	Top Clamp	Top Clamp Screw	Shim	Shim Screw	Spring	Key for top	Key for bottom
	R	L	H	B	LF	WF	HF	LH	Description							
DWLN R/L2020K06-M	●	●	20	20	125	25	20	32	WN.....0604.....	TC -DLM3	TCS -M4X16	SM -WN06	SW -WN06-DT -M5X0.5	SG-Ø6X10	KY-3.5MM	KY-3MM
DWLN R/L2525M06-M	●	●	25	25	150	32	25	32								
DWLN R/L2525M08-M	●	●	25	25	150	32	25	32	WN.....0804.....	TC -DLM-4	TCS -DLM-4-M5X20-S	SM -WN08	SW-M5X12.5 MM	SG-Ø7X10	KY-T20	KY-3MM

A-MWLN type — Boring Bar

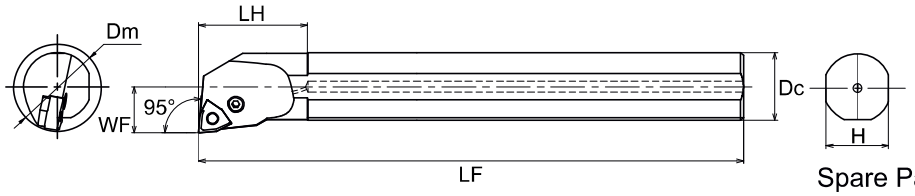


Spare Parts

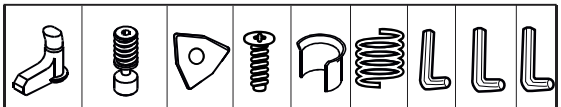


Cat. No.	Stock		Min. machining diameter	Diameter	Height	Length	Head	Cutting edge distance	Offset	Applicable inserts	Top Clamp	Clamp Screw	Shim	Shim Screw	Shim Pin	Spring	Key for top	Key for bottom	Key
	R	L	Dm	Dc	H	LF	LH	WF	Ra°	Description									
A40U-MWLNR06-M		●	50	40	37	350	20	27	7	WN.....0604.....	CL-051 WN06	CS-WN 06-M6	SM-WN06	-	SP-THRD-M5 X14L	-	KY-2.5 MM	KY-3MM	-
A40U-MWLNR08-M		●	50	40	37	350	20	27	7	WN.....0804.....	CL-051 WN08	CS-WN 08-M6 X23	SM-WN08	SPS-M4X12	SP-PLAIN-6 X20L	-	KY-3 MM	KY-3MM	-

A-PWLN type — Boring Bar



Spare Parts



Cat. No.	Stock		Min. machining diameter	Diameter	Height	Length	Head	Cutting edge distance	Offset	Applicable inserts	Lever	Lever Screw	Shim	Lever Screw	Lever Pin	Spring	Key for top	Key for bottom	Key
	R	L	Dm	Dc	H	LF	LH	WF	Ra°	Description									
A25R-PWLNR06-M	●		**32**	25	23	200	40	17	1.5	WN.....0604.....	LR-WN06	LS-M5 X10MM	SM-WN06-I	-	SP-WN06	-	-	KY-2.5MM	-

motherson

DELTACARB

HARDMETAL Switzerland



Double Hexa Cast Iron Milling



MGSM General Shoulder Milling



DTC3000K Cast Iron Turning



DTC2000P Steel Turning



DTP5035M Stainless Steel Turning



DTP4015S Exotic Alloys Turning



Powered by

Motherson Techno Tools Limited

Communication Add: A-2, Sector 84, Noida - 201301, Uttar Pradesh, India.
Reg. Office: 2nd floor, Block B1, Mohan Cooperative Industrial Estate, Mathura Road, New Delhi - 110044, India.
CIN No.: U74999DL1992PLC049607

Ph.: +91-120-6110000 | marketing.mttl@motherson.com

www.mothersontools.com

Motherson Deltacarb Advanced Metal Solutions SA

Via Al Molino 29,
CH-6915 Pambio Noranco-Lugano, Switzerland

info.deltacarb@motherson.com

www.deltacarb.ch | www.motherson.com

Innovations that drive future