



Swiss Style Tools

MTC™
New Products

Separator®
Cutoff

Chipmaker®
O.D. & I.D. Grooving

Ranger™
Face Grooving

Octicut®
Threading

Swiss
Style Tools

Holeshot®
OTM™

MANCHESTER
LOWER COST PER CUT
CUTTING TOOLS

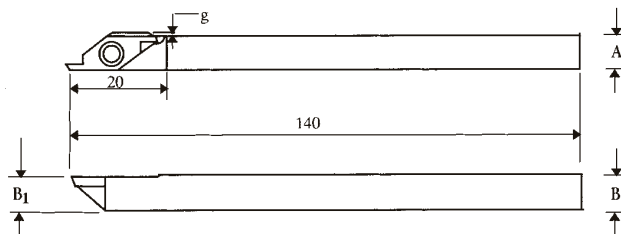
www.manchestertools.com

CSV STYLE TOOLHOLDER

For Cam-Style (CSV) Screw Machines
and Small CNC Machines

INSERTS

Front Turning, Back Turning, Cutoff



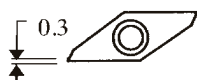
Right Hand Shown

CSV Style Toolholder

METRIC

Left Hand		Dimensions				Right Hand	
Descriptive Part No.	Manchester Part No.	B	A	B ₁	G	Manchester Part No.	Descriptive Part No.
CSVL07	241-106	7	7	7	0.5	241-101	CSVR07
—	—	8	8	8	0	241-102	CSVR08
CSVL095	241-108	9.5	9.5	9.5	0	241-103	CSVR095
—	—	10	10	10	0	241-104	CSVR10
—	—	12	12	12	0	241-105	CSVR12

For associated spare parts for this toolholder, see page F12.



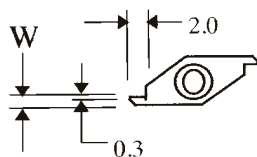
Right Hand Shown

Front Turning Inserts

METRIC

Left Hand		Dimensions (mm)					Right Hand	
Descriptive Part No.	Manchester Part No.	D.O.C.	R	I.C.	Thickness	Chipbreaker	Manchester Part No.	Descriptive Part No.
CSVF11FLV	580-113	3.00	0.0	6.35	2.38		580-111	CSVF11FRV
CSVF11FLVB	580-114	3.00	0.0	6.35	2.38	X	580-112	CSVF11FRVB

Front Turning Inserts are available in TiCN (M95).
X = includes chipbreaker



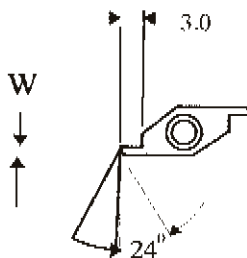
Right Hand Shown

Back Turning Inserts

METRIC

Left Hand		Dimensions (mm)					Right Hand	
Descriptive Part No.	Manchester Part No.	W	D.O.C.	R	I.C.	Thickness	Manchester Part No.	Descriptive Part No.
CSVB11FLV	580-116	1.0	1.5	0.0	6.35	2.38	580-115	CSVB11FRV

Back Turning Inserts are available in TiCN (M95).



Right Hand Shown

Cutoff Inserts

METRIC

Left Hand		Dimensions (mm)					Right Hand	
Descriptive Part No.	Manchester Part No.	W	D.O.C.	R	I.C.	Thickness	Manchester Part No.	Descriptive Part No.
—	—	0.7	2.0	0.0	6.35	2.38	580-101	CSVC11FRV07
—	—	0.8	2.0	0.0	6.35	2.38	580-102	CSVC11FRV08
CSVC11FLV10	580-108	1.0	2.5	0.0	6.35	2.38	580-103	CSVC11FRV10
CSVC11FLV13	580-109	1.3	2.5	0.0	6.35	2.38	—	—
—	—	1.5	2.5	0.0	6.35	2.38	580-105	CSVC11FRV15

Cutoff Inserts are available in TiCN (M95).

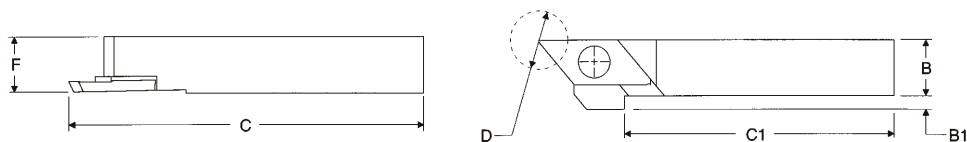


CUTOFF TOOLS

CTP Type Toolholders

INSERTS

Cutoff Tools (CTP Type)



Screw accessible from either side.

Right Hand Shown

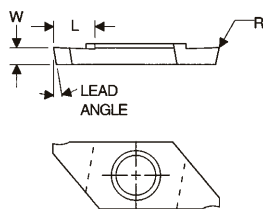
CTP Type Toolholders									METRIC	
Left Hand			Dimensions					Right Hand		
Descriptive Part No.	Manchester Part No.	D*	B	B ₁	C	C ₁	F	Manchester Part No.	Descriptive Part No.	
CTPL08	239-106	12	8	4	120	105	10	239-101	CTPR08	
CTPL10	239-107	12	10	2	120	105	10	239-102	CTPR10	

*Note: When using either CTPO7FL or CTP07FR, "D" is 8mm.
For associated spare parts for this toolholder, see page F12.

CTP Type Toolholders									INCH	
Left Hand			Dimensions					Right Hand		
Descriptive Part No.	Manchester Part No.	D*	B	B ₁	C	C ₁	F	Manchester Part No.	Descriptive Part No.	
CTPL06-IN	239-114	15/32	.375	.080	5	4.41	.375	239-111	CTPR06-IN	
CTPL08-IN	239-115	15/32	.500	—	5	—	.500	239-112	CTPR08-IN	

*Note: When using either CTPO7FL or CTP07FR, "D" is 5/16".
For associated spare parts for this toolholder, see page F12.

Right Hand Shown



Cutoff Tools (CTP Type) Inserts							METRIC / INCH		
Left Hand		Dimensions mm			Right Hand				
Descriptive Part No.	Manchester Part No.	W	L	Lead Angle	R	Manchester Part No.	Descriptive Part No.		
CTP10FLN	538-116	1.0	6.7	0°	.05	538-105	CTP10FRN		
CTP15FLN	538-117	1.5	6.7	0°	.05	538-106	CTP15FRN		
CTP20FLN	538-118	2.0	6.7	0°	.05	538-107	CTP20FRN		
CTP07FL	538-112	.7	4.5	16°	.05	538-101	CTP07FR		
CTP10FL	538-113	1.0	6.7	16°	.05	538-102	CTP10FR		
CTP15FL	538-114	1.5	6.7	16°	.05	538-103	CTP15FR		
CTP20FL	538-115	2.0	6.7	16°	.05	538-104	CTP20FR		
CTP10FLK*	538-120	1.0	6.7	16°	.05	538-109	CTP10FRK*		
CTP15FLK*	538-121	1.5	6.7	16°	.05	538-110	CTP15FRK*		
CTP20FLK*	538-122	2.0	6.7	16°	.05	—	—		

*Inserts have opposite hand lead angles to hand (e.g. left hand lead, right hand insert).
CTP inserts are available in TiN (M40). TiCN (M45) available upon request.

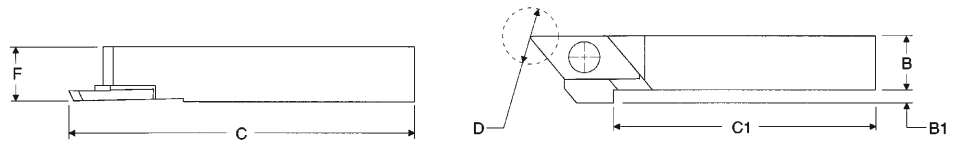


CUTOFF TOOLS

CTPA Type Toolholders

INSERTS

Cutoff Tools (CTPA Type)



Screw accessible from either side.

Right Hand Shown

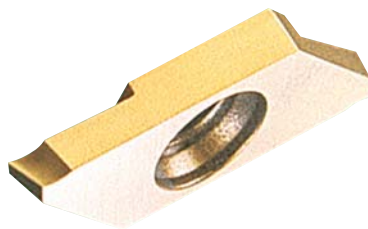
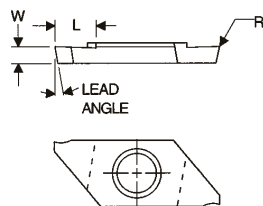
CTPA Type Toolholders

METRIC

Left Hand		Dimensions						Right Hand	
Descriptive Part No.	Manchester Part No.	D	B	B ₁	C	C ₁	F	Manchester Part No.	Descriptive Part No.
CTPAL12	239-140	16	12	0	120	0	12	239-136	CTPAR12
CTPAL16	239-141	16	16	0	120	0	16	239-137	CTPAR16

For associated spare parts for this toolholder, see page F12.

Right Hand Shown



Cutoff Tools (CTPA Type) Inserts

METRIC

Left Hand		Dimensions mm				Right Hand	
Descriptive Part No.	Manchester Part No.	W	L	Lead Angle	R	Manchester Part No.	Descriptive Part No.
CTPA20FLN	538-137	2.0	9.2	0°	.05	538-134	CTPA20FRN
—	—	2.0	9.2	16°	.05	538-133	CTPA20FR
CTPA20FLK*	538-138	2.0	9.2	16°	.05	—	—

*Inserts have opposite hand lead angles to hand (e.g. left hand lead, right hand insert).

CTPA inserts are available in TiN (M40). TiCN (M45) available upon request.

See Section A – MTC™ Products for additional Swiss tools.

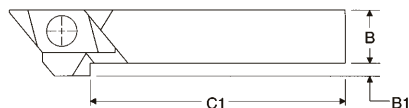
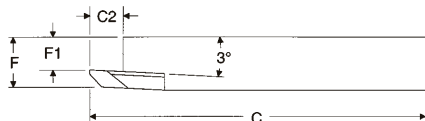


BACK TURNING TOOLS

TBP Type Toolholders, Screw On

INSERTS

Back Turning Tools (TBP Type)



Screw accessible from either side.

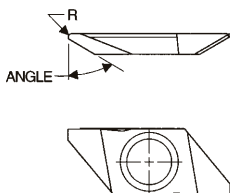
Right Hand Shown

TBP Type Toolholders, Screw On										METRIC	
Left Hand					Dimensions					Right Hand	
Descriptive Part No.	Manchester Part No.	B	B ₁	C	C ₁	C ₂	F	F ₁	Manchester Part No.	Descriptive Part No.	
TBPL08	239-125	8	4	120	105	5.5	10	4.5	239-120	TBPR08	
—	—	10	2	120	105	5.5	10	6.5	239-121	TBPR10	
—	—	12	0	120	0	5.5	12	8.5	239-122	TBPR12	
TBPL13	239-128	13	0	120	0	5.5	13	9.5	—	—	

TBP Type Toolholders, Screw On										INCH	
Left Hand					Dimensions					Right Hand	
Descriptive Part No.	Manchester Part No.	B	B ₁	C	C ₁	C ₂	F	F ₁	Manchester Part No.	Descriptive Part No.	
TBPL06-IN	239-133	.375	.080	5	4.41	.216	.375	.237	239-130	TBPR06-IN	
TBPL08-IN	239-134	.500	0	5	0	.216	.500	.362	239-131	TBPR08-IN	

For associated spare parts for this toolholder, see page F12.

Right Hand Shown



Back Turning Tools (TBP Type) Inserts METRIC / INCH

Left Hand		Components Dimensions mm		Right Hand	
Descriptive Part No.	Manchester Part No.	Angle	R	Manchester Part No.	Descriptive Part No.
TBP55FL00	538-128	58°	0	538-123	TBP55FR00
TBP55FL10	538-129	58°	.10	538-124	TBP55FR10
TBP60FL00	538-130	63°	0	538-125	TBP60FR00
TBP60FL10	538-131	63°	.10	538-126	TBP60FR10

TBP inserts are available in TiN (M40). TiCN (M45) available upon request.

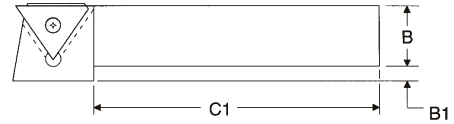
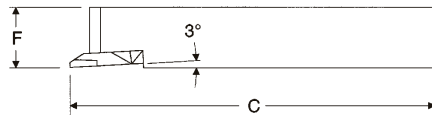


FRONT TURNING TOOLS

TF Type Toolholders, Screw On

INSERTS

Front Turning Tools (TF Type)



Screw accessible from either side.

Right Hand Shown

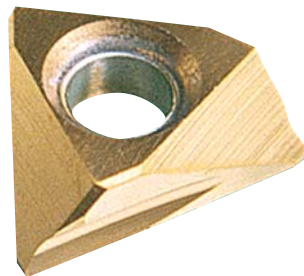
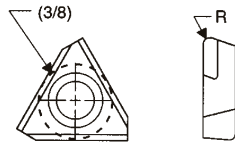
TF Type Toolholders, Screw On

METRIC

Left Hand		Dimensions					Right Hand	
Descriptive Part No.	Manchester Part No.	B	B ₁	C	C ₁	F	Manchester Part No.	Descriptive Part No.
—	—	10	3.0	120	110	10	240-156	TFTR10N
TFTL12	240-160	12	1.0	120	110	12	240-157	TFTR12N
—	—	16	—	120	—	16	240-158	TFTR16N
TFTL-06 IN	240-164	.375	.118	5.0	4.409	.375	240-162	TFTR06-IN
TFTL-08 IN	240-165	.500	.039	5.0	4.409	.500	240-163	TFTR08-IN

For associated spare parts for this toolholder, see page F12.

Right Hand Shown



Front Turning Tools (TF Type) Inserts

METRIC

Left Hand			Right Hand	
Descriptive Part No.	Manchester Part No.	Dimensions mm R	Manchester Part No.	Descriptive Part No.
TF3300L	539-148	0	539-145	TF3300R
TF3305L	539-149	.05	539-146	TF3305R
TF3315L	539-150	.15	539-147	TF3315R

TF inserts are available in TiN (M40) and TiCN (M45) only.
Maximum depth of cut is 4mm

See Section A – MTC™ Products for additional Swiss tools.



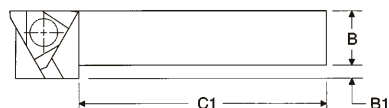
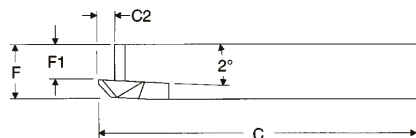
BACK TURNING TOOLS

TBT Type Toolholders, Screw On



INSERTS

Back Turning Tools (TBT Type) Screw On



Screw accessible from either side.

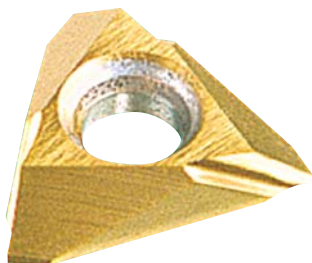
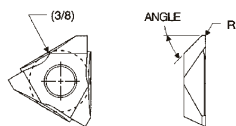
Right Hand Shown

TBT Type Toolholders, Screw On									METRIC	
Left Hand				Dimensions					Right Hand	
Descriptive Part No.	Manchester Part No.	B	B ₁	C	C ₁	C ₂	F	F ₁	Manchester Part No.	Descriptive Part No.
—	—	8	5	80	65	5	8	4	240-131	TBTR08F
TBTL10F	240-139	10	3	80	65	5	10	6	240-132	TBTR10F
TBTL12F	240-140	12	1	80	65	5	12	8	—	—
—	—	10	3	120	105	5	10	6	240-135	TBTR10K
TBTL12K	240-143	12	1	120	105	5	12	8	240-136	TBTR12K

TBT Type Toolholders, Screw On									INCH	
Left Hand				Dimensions					Right Hand	
Descriptive Part No.	Manchester Part No.	B	B ₁	C	C ₁	C ₂	F	F ₁	Manchester Part No.	Descriptive Part No.
TBTL06-IN	240-147	.375	.125	5	4.41	.197	.375	.217	240-145	TBTR06-IN
TBTL08-IN	240-148	.500	.040	5	4.41	.197	.500	.342	240-146	TBTR08-IN

For associated spare parts for this toolholder, see page F12.

Right Hand Shown



Back Turning Tools (TBT Type) Screw On METRIC / INCH

Left Hand		Components Dimensions mm		Right Hand	
Descriptive Part No.	Manchester Part No.	Angle	R	Manchester Part No.	Descriptive Part No.
—	—	45°	0	539-129	TB3200R
—	—	45°	.05	539-130	TB3205R
TB3210L	539-139	45°	.10	539-131	TB3210R
TB3215L	539-140	45°	.15	539-132	TB3215R

TB inserts available in TiN (M40) and Cermet (M74), except TB3200R and TB3200L, which are available in TiN (M40) ONLY. TiCN (M45) grade available upon request.

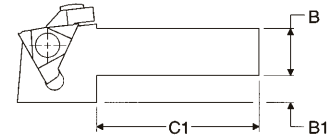
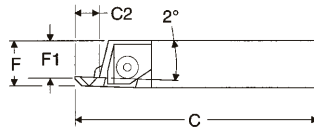


BACK TURNING TOOLS

TBT Type Toolholders, Clamp On

INSERTS

Back Turning Tools (TBT Type) Clamp On



Screw accessible from either side.

Right Hand Shown

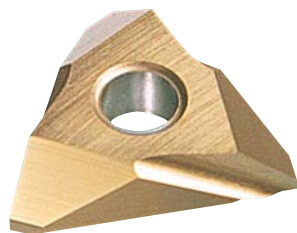
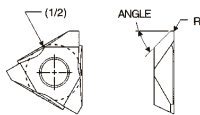
TBT Type Toolholders, Clamp On

METRIC

Left Hand		Dimensions							Right Hand	
Descriptive Part No.	Manchester Part No.	B	B ₁	C	C ₁	C ₂	F	F ₁	Manchester Part No.	Descriptive Part No.
—	—	16	9	78	53	9	16	10	240-150	TBR16N
—	—	16	9	125	100	9	16	10	240-151	TBR16N-K
TBL20N	240-154	20	5	100	75	9	20	14	—	—

For associated spare parts for this toolholder, see page F12.

Right Hand Shown



Back Turning Tools (TBT Type) Clamp On

METRIC

Left Hand		Components Dimensions mm		Right Hand	
Descriptive Part No.	Manchester Part No.	Angle	R	Manchester Part No.	Descriptive Part No.
—	—	45°	.05	539-134	TB4305R
—	—	45°	.15	539-135	TB4315R
TB4340L	539-144	45°	.40	539-136	TB4340R

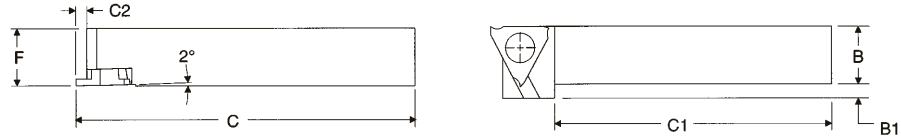
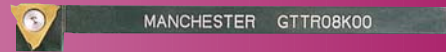
TB inserts available in TiN (M40) and Cermet (M74). TiCN (M45) grade available upon request.

See Section A – MTC™ Products for additional Swiss tools.



GROOVING TOOLS

GTT Type Toolholders, Screw On



Screw accessible from either side. Right Hand Shown

GTT Type Toolholders, Screw On METRIC

Left Hand				Dimensions				Insert Group	Right Hand	
Descriptive Part No.	Manchester Part No.	B	B ₁	C	C ₁	C ₂ *	F		Manchester Part No.	Descriptive Part No.
GTTL08F00	240-111	8	5	80	65	3	8	A	240-101	GTTR08F00
—	—	12	1	120	105	3	12	A	240-108	GTTR12K00
GTTL10K25	240-120	10	3	120	105	3	10	C	—	—

GTT Type Toolholders, Screw On INCH

Left Hand				Dimensions				Insert Group	Right Hand	
Descriptive Part No.	Manchester Part No.	B	B ₁	C	C ₁	C ₂ *	F		Manchester Part No.	Descriptive Part No.
GTTL06A-IN	240-123	.375	.125	5	4.41	.079	.375	A	240-121	GTTR06A-IN
GTTL08A-IN	240-124	.500	.040	5	4.41	.079	.500	A	240-122	GTTR08A-IN

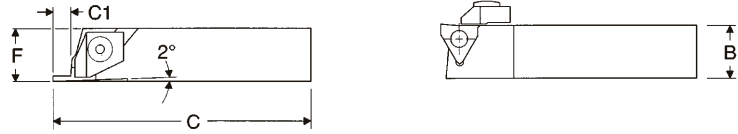
*Note: This is max. extension. For depth of cut see insert "L" dimension.
 For associated spare parts for this toolholder, see page F12.
 Find inserts for GTT Type Toolholders on next page.

GROOVING TOOLS

NGTN Type Toolholders, Clamp On

INSERTS

Grooving Tools (GTT and NGTN Type)



Right Hand Shown

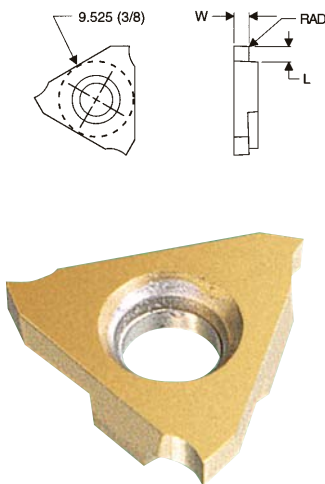
NGTN Type Toolholders, Clamp On

METRIC

Left Hand		Dimensions					Insert Group	Right Hand	
Descriptive Part No.	Manchester Part No.	B	C	C ₁ *	F	Manchester Part No.		Descriptive Part No.	
NGTNL161632-00	240-129	16	78	3	16	A	240-127	NGTNR161632-00	
—	—	16	78	3	16	B	240-128	NGTNR161632-15	

*This is max. extension. For depth of cut see insert "L" dimension.
For associated spare parts for this toolholder, see page F12.

Right Hand Shown



Grooving Tools (GTT and NGTN Type)

METRIC

Left Hand		Dimensions inch (mm)					Right Hand	
Descriptive Part No.	Manchester Part No.	Group	W	L	R	Manchester Part No.	Descriptive Part No.	
—	—	A	.012	.024 (.6)	.001	539-101	TMG32012RE	
TMG32020LE	539-116	A	.020	.047 (1.2)	.002	539-102	TMG32020RE	
—	—	A	.031	.079 (2)	.004	539-103	TMG32031R	
TMG32039L	539-118	A	.039	.079 (2)	.004	539-104	TMG32039R	
TMG32049L	539-119	A	.049	.079 (2)	.004	539-105	TMG32049R	
TMG32062L	539-120	B	.062	.118 (3)	.008	539-106	TMG32062R	
—	—	B	.079	.118 (3)	.008	539-107	TMG32079R	
TMG32094L	539-122	C	.094	.118 (3)	.008	539-108	TMG32094R	
—	—	C	.125	.118 (3)	.008	539-109	TMG32125R	

Match toolholder with appropriate insert choices using Insert Group designations.
TMG inserts available in TiN (M40). TiCN (M45) available upon request.

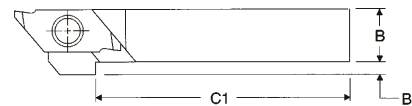
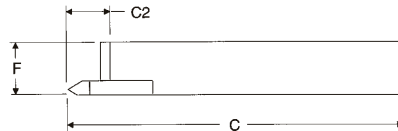


THREADING TOOLS

TTP Type Toolholders

INSERTS

Threading Tools (TTP Type)



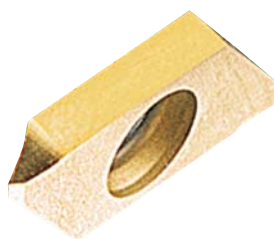
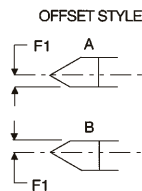
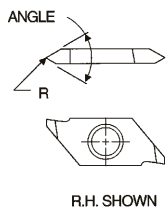
Screw accessible from either side.

Right Hand Shown

TTP Type Toolholders

METRIC

Left Hand		Dimensions						Right Hand	
Descriptive Part No.	Manchester Part No.	B	B ₁	C	C ₁	C ₂	F	Manchester Part No.	Descriptive Part No.
—	—	8	4	120	105	7	10	239-150	TTPR08
TTPL10	239-154	10	2	120	105	7	10	239-151	TTPR10
TTPL12	239-155	12	0	120	105	7	12	239-152	TTPR12



Threading Tools (TTP Type)

METRIC

Left Hand		Dimensions (mm)					Right Hand	
Descriptive Part No.	Manchester Part No.	Angle	Offset Style	F ₁	R	Pitch Range	Manchester Part No.	Descriptive Part No.
—	—	60°	A	0.4	.05 max flat	0.2-.75	538-145	TTP60FR4A
—	—	60°	B	0.4	.05 max flat	0.2-.75	538-146	TTP60FR4B
TTP60FL8A	538-152	60°	A	0.8	.05 rad	0.5-1.25	538-147	TTP60FR8A
TTP60FL8B	538-153	60°	B	0.8	.05 rad	0.5-1.25	538-148	TTP60FR8B

TTP inserts available in TiN (M40). TiCN (M45) available upon request.

See Section A – MTC™ Products for additional Swiss tools.



SPARE PARTS

Spare Parts

	Toolholder No.	Clamp Screw		Wrench	
		Descriptive Part No.	Manchester Part No.	Descriptive Part No.	Manchester Part No.
CSV Style (Page F2)	CSVR/L07-12	LRIS-2.5 x 7	606-240	FLR-155	608-105
CTP Style (Page F3)	CTPR/L06-10	LRIS-4x10PW	606-231	FLR-155	608-105
	CTPR/L12-13	LRIS-4x12PW	606-232	FLR-155	608-105
CTPA Style (Page F4)	CTPAR/L10	LRIS-4x10PW	606-231	FLR-155	608-105
	CTPAR/L12-16	LRIS-4x12PW	606-232	FLR-155	608-105
TBP Style (Page F5)	TBPR/L06-10	LRIS-4x10PW	606-231	FLR-155	608-105
	TBPR/L12-13	LRIS-4x12PW	606-232	FLR-155	608-105
TF Style (Page F6)	All TFT	LR-5-4x10PW	606-230	FLR-155	608-105
TBT Style (Page F7)	All TBTR/L	LR-5-4x10PW	606-230	FLR-155	608-105
GTT Style (Page F9)	All GTTR/L	LR-5-4x10PW	606-230	FLR-155	608-105
TTP Style (Page F11)	TTPR/L08-10	LRIS-4x10PW	606-231	FLR-155	608-105
	TTPR/L12	LRIS-4x12PW	606-232	FLR-155	608-105

Spare Parts

Toolholder No.	Clamp		Clamp Screw		Spring		Wrench	
	Descriptive Part No.	Manchester Part No.	Descriptive Part No.	Manchester Part No.	Descriptive Part No.	Manchester Part No.	Descriptive Part No.	Manchester Part No.
TB Style (Page F8)								
TBR16N								
TBR16N-K	CPR5S	415-101	AOS-5x25	606-228	ASG-5	700-103	LW-2.5	608-107
TBL16N								
TBL20N	CPL5S	415-102	AOS-5x25	606-228	ASG-5	700-103	LW-2.5	608-107
NGTN Style (Page F10)								
NGTNR161632-00								
NGTNR161632-15	CPR5S	415-101	AOS-5x25	606-228	ASG-5	700-103	LW-2.5	608-107
NGTNL161632-00	CPL5S	415-102	AOS-5x25	606-228	ASG-5	700-103	LW-2.5	608-107



GANG TOOL LAYOUTS

