






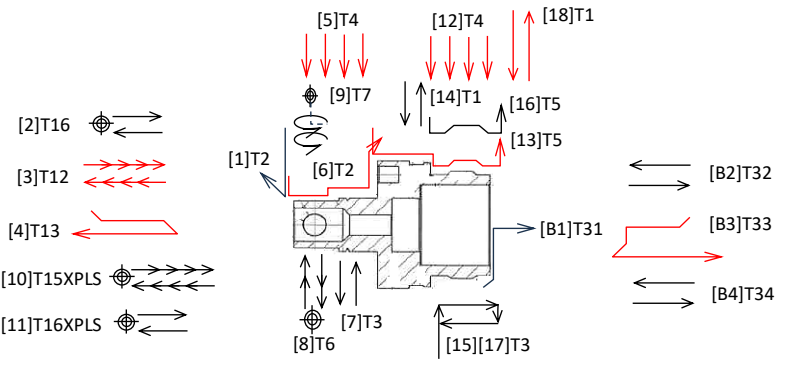










CITIZEN		TOOLING SHEET		Pinthing show 2024	
Machine model.	Serial Number	Program No.	Parts Name		
A20-3F7-LFV					
Material dia.	Material.	B.sp collet chuck dia	Processing direction		
ø20.0	Aluminum	ø19.0	➔		
Cycle Time.	Date. 08.Aug.2024	Preson in change			
A:machining process B:insert model number C:tool holder/gang rotary tool D:turret holder/gang tool holder E:sleeve F:rego G:remarks					
Rev.2					
Note: Red color is LFV Cutting					
T01	A	CUT-OFF	T06	A	CROSS FLAT DRILL
	B	CTDP20N / TM4 / NTK		B	ADF-2D-3.2 / OSG
	C	CTDPL12-20D25 / NTK		C	
	D	GTF3612		D	U34B
	E			E	
	F			F	ER16-6.0
	G	CMA STOCK		G	
	T02	A		FRONT TURNING	T07
	B	DCGT11T302MRTMV /ST4 /NTK		B	HY-QCC-R1.4
	C	SDJCR1212X11N		C	
	D	GTF3612		D	U34B
	E			E	
	F			F	ER16-4.0
	G	CMA STOCK		G	
	T03	A		THREADING	T08
	B	TTP60FR-N / ZM3 / NTK		B	
	C	TTPR12 / NTK		C	
	D	GTF3612		D	
	E			E	
	F			F	
	G			G	
	T04	A		GROOVE ROUGH	T09
	B	GWPG400N04E-GW / DM4 / NTK		B	
	C	GTWPR1216-4E07 / NTK		C	
	D	GTF3612		D	
	E			E	
	F			F	
	G	CMA STOCK		G	
	T05	A		REAR TURNING	T11
	B	TBP72FR10M-BM / TM4 / NTK		B	
	C	TBP12 / NTK		C	
	D	GTF3612		D	
	E			E	
	F			F	
	G			G	
					
T12	A	DRILLING Ø3.0	T17	A	
	B	EX-SUS-GDS-ø3.0/ OSG		B	
	C			C	
	D	BDF2007		D	
	E			E	
	F	ADS710/ER16-ø3.0		F	
	G			G	
	T13	A		BORING	T31
	B	SBFS025R015S / ZM3 /NTK		B	DCGT11T302MRTMV /ST4 /NTK
	C	NBH02525K / NTK		C	DS-SDUL25-11 / NTK
	D	BDF2007		D	U154B
	E			E	
	F			F	
	G			G	CMA STOCK
	T14	A			T32
	B			B	ADF-2D-9.6 / OSG
	C			C	
	D			D	U154B
	E			E	ADS810/ER16-8.0
	F			F	
	G			G	CMA STOCK
	T15	A		ENF-FACE FLAT DRILLING	T33
	B	ADF-2D-2.5 / OSG		B	MBL015FRF1 / TM4 / NTK
	C			C	NBH06025K / NTK
	D	U34B / BSF607		D	U154B
	E			E	C06F-MBRD05-OH / NTK
	F	ER11-4.0		F	
	G			G	CMA STOCK
	T16	A		ENF-FACE CENTER CHAMFER	T34
	B	TIN-NC-LDS-ø4.0x90° / OSG		B	TIN-NC-LDS-ø 4.0x90° / OSG
	C			C	
	D	U34B / BSF607		D	U154B
	E			E	ADS810/ER16-ø 4.0
	F	ER11-ø 4.0		F	
	G	CMA STOCK		G	CMA STOCK