

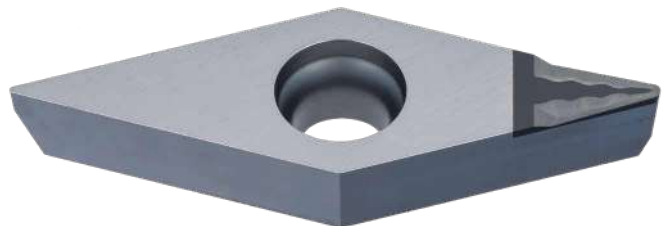
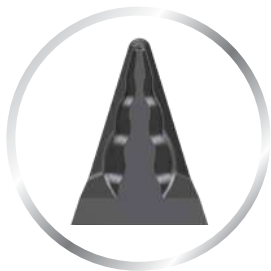
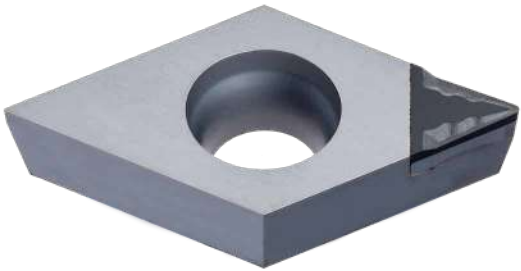
# NPN

New Product News



## T-TURN

### PCD CF Super Finishing Chip Breaker



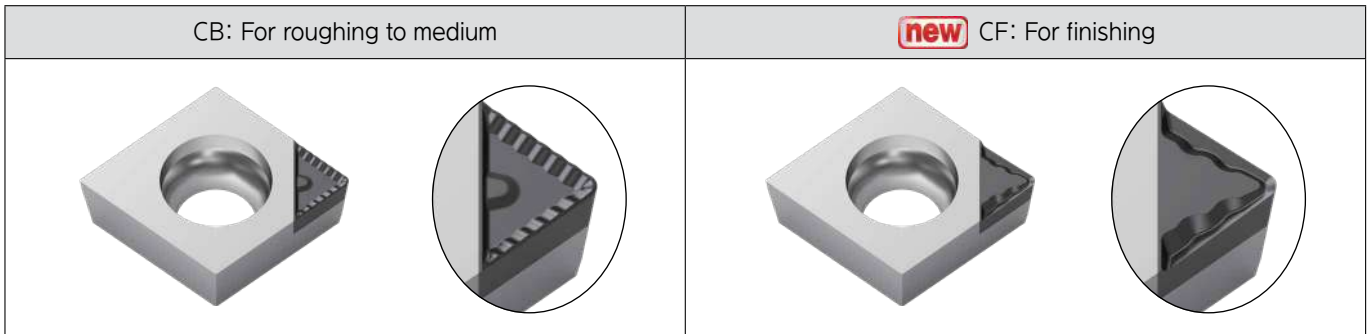
## KEY POINT

**TaeguTec introduces a new PCD CF chip breaker for super finishing in nonferrous machining.**

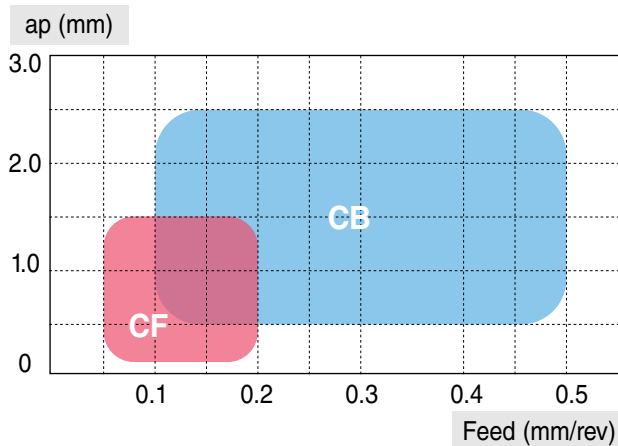
The new PCD CF chip breaker is capable of fine chip segmenting even in low depth of cut machining applications. Furthermore, the chip segmenting reduces machine downtime caused by long chips, resulting in higher productivity.

For further details, please contact the relevant product manager.

### PCD Type Chip Breakers:



### Chip control range

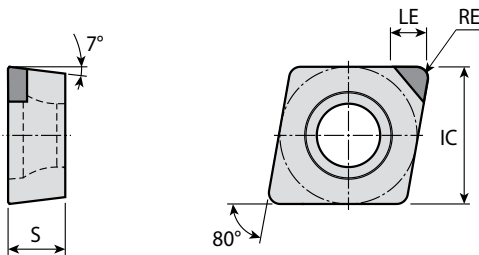


- Insert: DCGT 11T304 CB/CF TD1020
- Cutting speed(V): 800 m/min
- Material: Aluminum alloy (AC4C-T6)

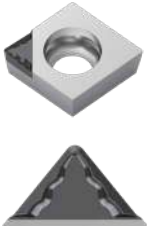
## CCGT-CF



### Positive 80° rhombic inserts

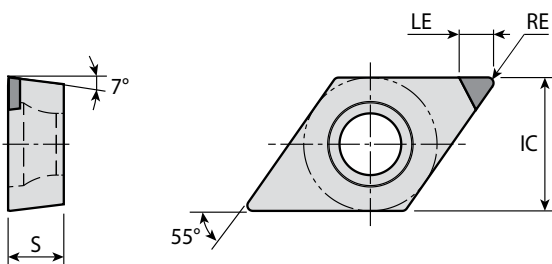


Size	Dimension (mm)		
	IC	S	RE
09	9.52	3.97	0.2-0.4
12	12.7	4.76	0.4-0.8

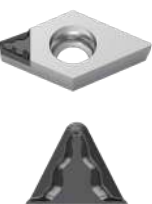
Insert	Designation	LE (mm)	ap (mm)	Feed (mm/rev)	PCD		
					TD1010	TD1020	TD1030
 PCD chip breakers	<b>CCGT 09T302 CF</b>	4.1	0.1-1.0	0.05-0.20		•	
	<b>09T304 CF</b>	4.1	0.1-1.0	0.05-0.20		•	
	<b>120404 CF</b>	4.1	0.1-1.0	0.05-0.20		•	
	<b>120408 CF</b>	4.0	0.1-1.0	0.05-0.20		•	

## DCGT-CF

### Positive 55° rhombic inserts



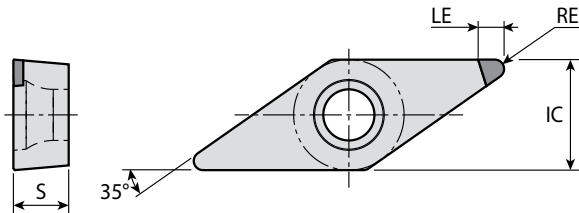
Size	Dimension (mm)		
	IC	S	RE
07	6.35	2.38	0.2-0.4
11	9.52	3.97	0.2-0.8

Insert	Designation	LE (mm)	ap (mm)	Feed (mm/rev)	PCD		
					TD1010	TD1020	TD1030
 PCD chip breakers	<b>DCGT 070202 CF</b>	3.4	0.1-1.0	0.05-0.20		•	
	<b>070204 CF</b>	3.3	0.1-1.0	0.05-0.20		•	
	<b>11T302 CF</b>	4.9	0.1-1.5	0.05-0.20		•	
	<b>11T304 CF</b>	4.7	0.1-1.5	0.05-0.20		•	
	<b>11T308 CF</b>	4.6	0.1-1.5	0.05-0.20		•	





## VCGT-CF

Positive 35° rhombic inserts



Size	Dimension (mm)		
	IC	S	RE
16	9.52	4.76	0.4-0.8

Insert	Designation	LE (mm)	ap (mm)	Feed (mm/rev)	PCD		
					TD1010	TD1020	TD1030
  PCD chip breakers	<b>VCGT 160404 CF</b>	7.3	0.1-2.0	0.05-0.20		•	
	<b>VCGT 160408 CF</b>	6.4	0.1-2.0	0.05-0.20		•	

## Recommended Cutting Conditions



ISO	Material	Condition	Tensile strength (N/mm <sup>2</sup> )	Hardness HB	Material No.	Cutting speed Vc(m/min)		
						PCD		
						TD1020		
N	Aluminum - wrought alloy	Not cureable		60	21	300-2300		
		Cured		100	22	300-2300		
	Aluminum-cast, alloyed	<=12% Si	Not cureable		75	23	200-1400	
			Cured		90	24	200-1400	
		>12% Si	High temp.		130	25	80-900	
		>1% Pb	Free cutting		110	26	60-550	
	Copper alloys		Brass		90	27	60-550	
			Electrolitic copper		100	28	30-380	
	Non-metallic		Duroplastics, fiber plastics			29	100-900	
			Hard rubber			30	100-550	

 Nonferrous