

NPN

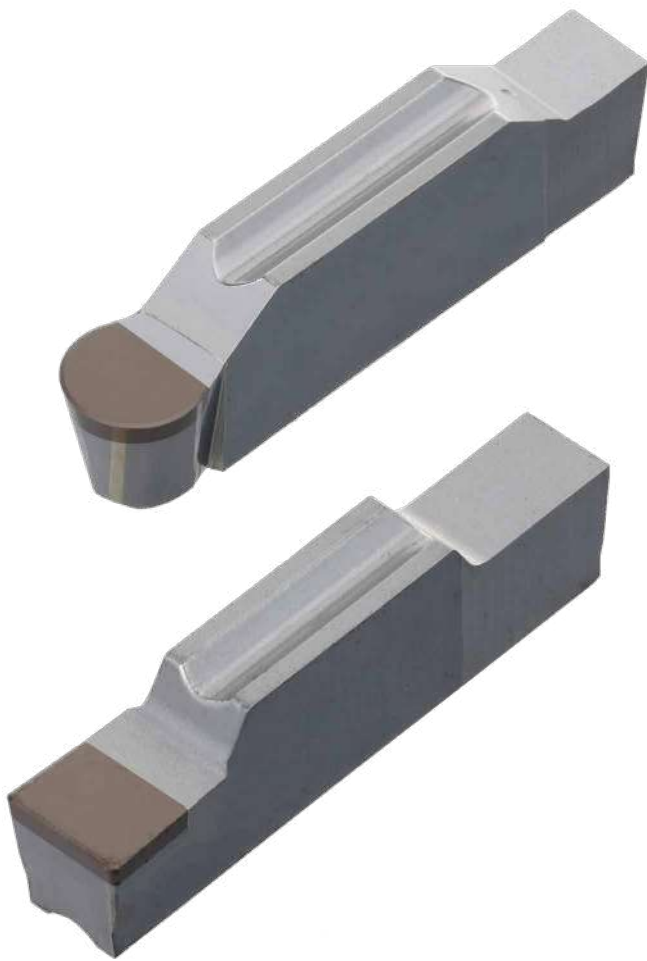
New Product News



T-CLAMP

PARTING & GROOVING

Grooving and Profiling CBN Inserts for Hard Material Machining



KEY POINT

TaeguTec introduces grooving and profiling CBN inserts for hard material machining.

T-CLAMP's TB2015 grade CBN inserts provide excellent machining performance even in continuous as well as intermittent machining of hard materials. Following the current line of the high-feed turning TSG-HF insert, other TSG inserts suitable for grooving and profiling have been added to provide more diverse machining solutions for hard materials.

For further information, please contact the product manager.

Features

- Grooving and profiling CBN insert for hard material machining
- Compatible with T-CLAMP holders for a diverse range of applications
- Excellent surface finish
- TB2015 grade
 - CBN grade with high wear resistance and optimal toughness
 - Appropriate for intermittent and continuous cutting of hard materials

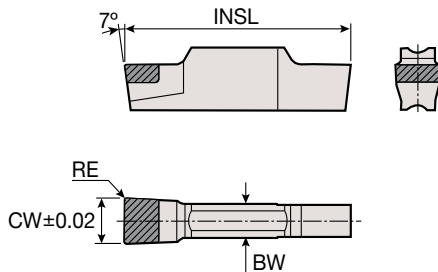
T-Clamp CBN inserts

new For turning and grooving	new For turning and grooving profiling	For high feed turning
 <p>TSG</p>	 <p>TSG (Full-Radius)</p>	 <p>TSG-HF</p>

TSG



Single-ended CBN inserts for turning and grooving



Size	Dimension (mm)			
	CW	RE	BW	INSL
3	3.0	0.2	2.25	20.0
4	4.0	0.2	3.0	30.0
5	5.0	0.4	4.0	25.0
6	6.0	0.4	5.0	25.0
8	8.0	0.4	6.0	30.0

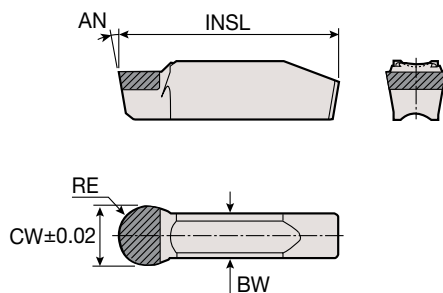
Insert	Designation	Insert seat size	Turning		Grooving	CBN					PCD			
			ap (mm)	Feed (mm/rev)	Feed (mm/rev)	TB610	TB650	TB670	TB2015	TB7015	TB7020	TD1010	TD1020	TD1030
	TSG 3.00H-0.20	3	0.0-0.3	0.02-0.07	0.02-0.05				●					
	4.00H-0.20	4	0.0-0.4	0.03-0.09	0.02-0.07				●					
	5.00H-0.40	5	0.0-0.5	0.05-0.13	0.03-0.10				●					
	6.00H-0.40	6	0.0-0.6	0.05-0.15	0.04-0.12				●					
	8.00H-0.40	8	0.0-0.8	0.07-0.20	0.05-0.16				●					

●: Standard items

TSG (Full-Radius)



Single-ended CBN inserts for turning and grooving



Size	Dimension (mm)				
	CW	RE	BW	INSL	AN
3	3.0	1.5	2.4	20.0	7
4	4.0	2.0	3.0	20.0	7
5	5.0	2.5	4.0	25.0	7
6	6.0	3.0	5.0	25.0	7
8	8.0	4.0	6.0	30.0	10

Insert	Designation	Insert seat size	Turning		Grooving	CBN					PCD			
			ap (mm)	Feed (mm/rev)	Feed (mm/rev)	TB610	TB650	TB670	TB2015	TB7015	TB7020	TD1010	TD1020	TD1030
	TSG 3.00H-1.50	3	0.0-0.3	0.03-0.10	0.02-0.06				●					
	4.00H-2.00	4	0.0-0.4	0.04-0.14	0.02-0.09				●					
	5.00H-2.50	5	0.0-0.5	0.05-0.18	0.03-0.11				●					
	6.00H-3.00	6	0.0-0.6	0.06-0.22	0.04-0.13				●					
	8.00H-4.00	8	0.0-0.8	0.08-0.29	0.05-0.17				●					

●: Standard items

Recommended Cutting Conditions

Grooving and Turning

ISO	Material	Condition	Tensile Strength (N/mm ²)	Hardness HB	Material No.	Cutting speed Vc(m/min)
						TB2015
H	Hardened steel	Hardened		55HRC	38	90-110
		Hardened		60HRC	39	80-100
	Chilled cast iron	Cast		400	40	180-200
	Cast iron nodular (GGG)	Hardened		55HRC	41	90-110

■ Hardened steel