

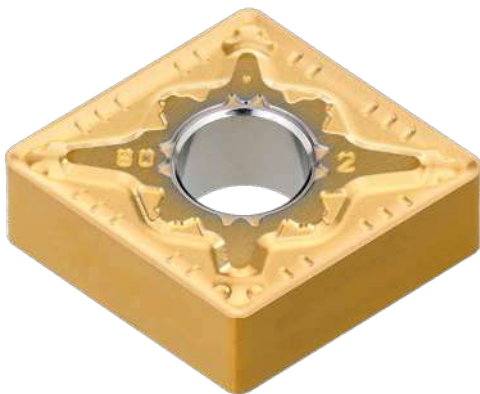
NPN

New Product News



T-TURN

TT2010: New Carbide Grade for Hardened Steel Machining

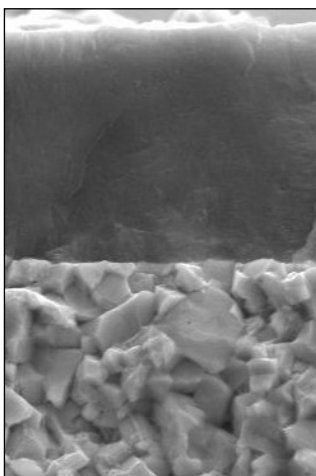


KEY POINT

TaeguTec introduces the TT2010 carbide grade for hardened steel machining.

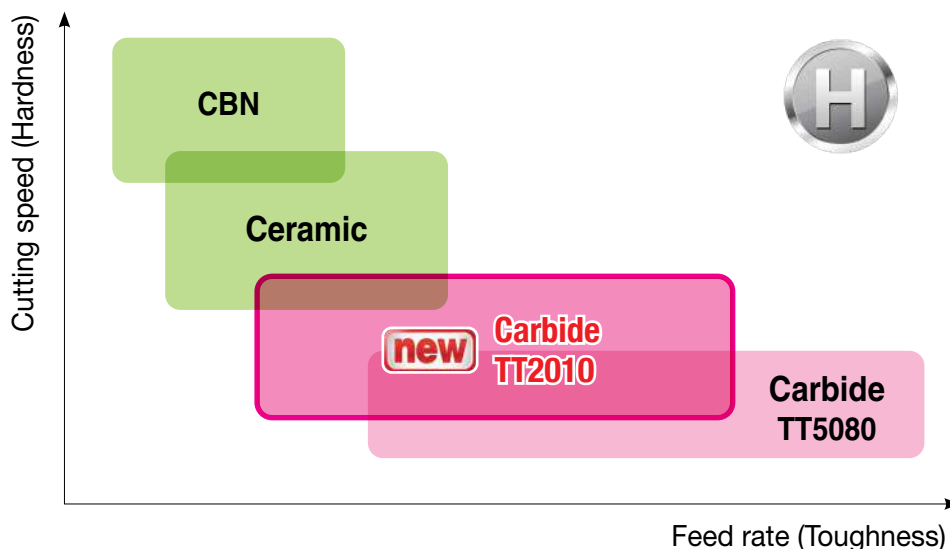
With superior hardness and adequate toughness, the TT2010 grade provides higher tool life even in heat-treated hardened steel machining. This new grade is an economical alternative to ceramic and CBN grades for customers requiring a cost-competitive solution.

new TT2010 grade features



- Ultra fine-grained substrate for extremely high wear resistance
- An AlTiN-based PVD coating layer enables high deformation resistance
- ISO H05-H10 turning grade is optimally designed for HRC 40-62 hardened steel
- Excellent machining performance in finish and light interrupted cutting

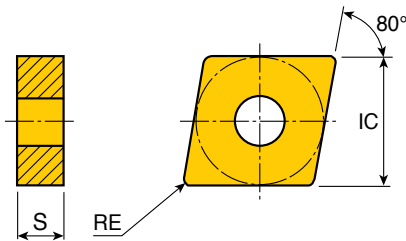
For hardened steel (HRC 40-62)






CNMG

Negative 80° rhombic inserts



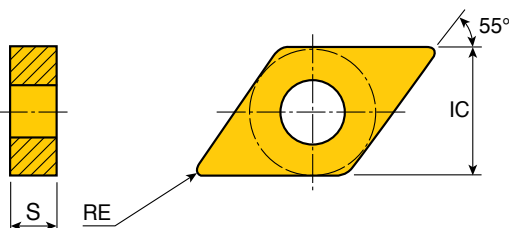
Size	Dimension (mm)		
	IC	S	RE
12	12.7	4.76	0.4-1.2

Insert	Designation	ap (mm)	Feed (mm/rev)	PVD coated
				new TT2010
 Medium	CNMG 120404 MGP	0.4-3.0	0.10-0.40	●
	120408 MGP	0.5-3.0	0.15-0.55	●
	120412 MGP	0.6-3.0	0.17-0.55	●


●: Standard items

DNMG

Negative 55° rhombic inserts



Size	Dimension (mm)		
	IC	S	RE
15	12.7	6.35	0.4-1.2

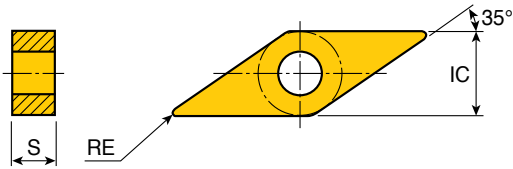
Insert	Designation	ap (mm)	Feed (mm/rev)	PVD coated
				new TT2010
 Medium	DNMG 150604 MGP	0.4-2.0	0.10-0.40	●
	150608 MGP	0.5-2.0	0.15-0.50	●
	150612 MGP	0.6-2.0	0.17-0.55	●

●: Standard items



VNMG VNMX



Negative 35° rhombic inserts



Size	Dimension (mm)		
	IC	S	RE
13	7.94	4.76	0.4-0.8
16	9.52	4.76	0.4-0.8

Insert	Designation	ap (mm)	Feed (mm/rev)	PVD coated
				new TT2010
 Medium	VNMG 160404 MLP	0.1-1.5	0.05-0.20	●
	VNMG 160408 MLP	0.2-1.5	0.08-0.30	●
 Finishing	VNMX 130404 FX	0.1-1.0	0.05-0.20	●
	VNMX 130408 FX	0.2-1.0	0.07-0.20	●

●: Standard items

Recommended Cutting Conditions



Machining data

ISO	Material	Condition	Tensile Strength (N/mm ²)	Hardness HRC	Material No.	Cutting speed Vc(m/min)
						TT2010
H	Hardened steel	Hardened		35-55	38	80-200
		Hardened		55-65	39	50-100

■ Hardened steel