

# NEW PRODUCT NEWS

## TOP DUTY



## Double Sided H Series Chip Breaker

**New double-sided chip breaker insert for rough and finish machining**

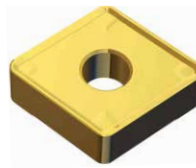
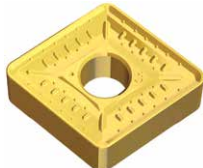
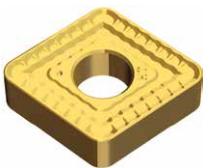
CNMD

HT

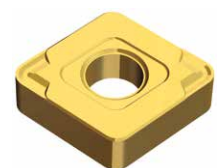
HD

HY

HZ



+



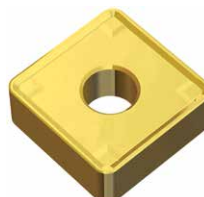
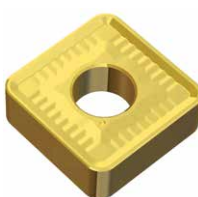
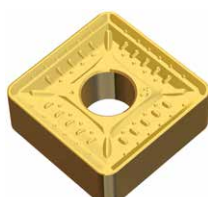
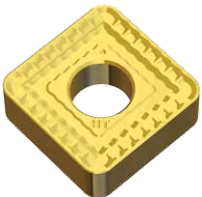
SNMD

HT

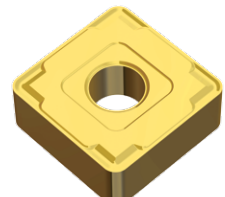
HD

HY

HZ



+



# TOP DUTY

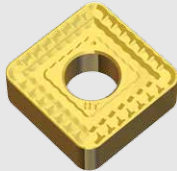
## Double sided H series chip breaker

New double-sided chip breaker insert for rough and finish machining

### FEATURES

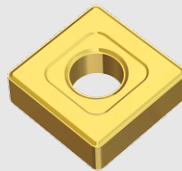
- Utilizes both sides to improve economy & cost reduction
- Offers a variety of sizes and chip breakers to meet customers specific heavy rough machining requirements
- Economy is further improved by using one tool holder for rough to finish machining

#### Single-sided



Top face

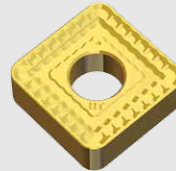
Rough machining



Bottom face

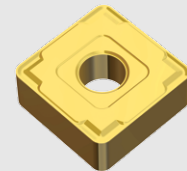
not available

#### Double-sided



Top face

Rough machining



Bottom face

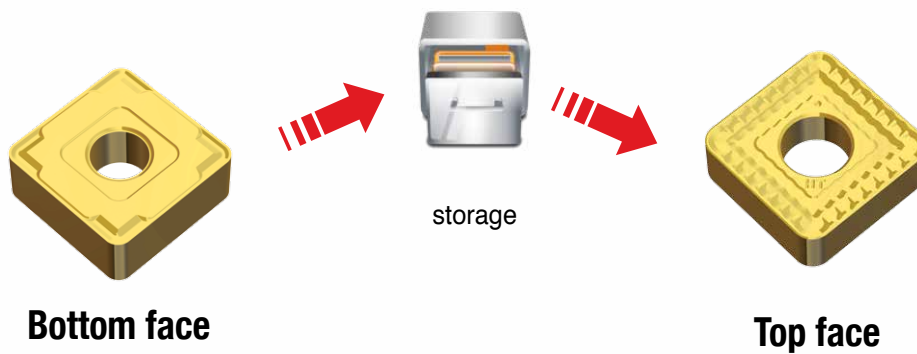
Finish machining

The upper-side of the double sided insert can be used, as it is with the single-sided insert. The underside can then be used when finish machining is required.

Most cutting tool manufacturers design and produce single-sided inserts to maintain toughness levels. However, TaeguTec has developed its new double-sided inserts for multiple tasks that incorporate an extra side for finish machining.

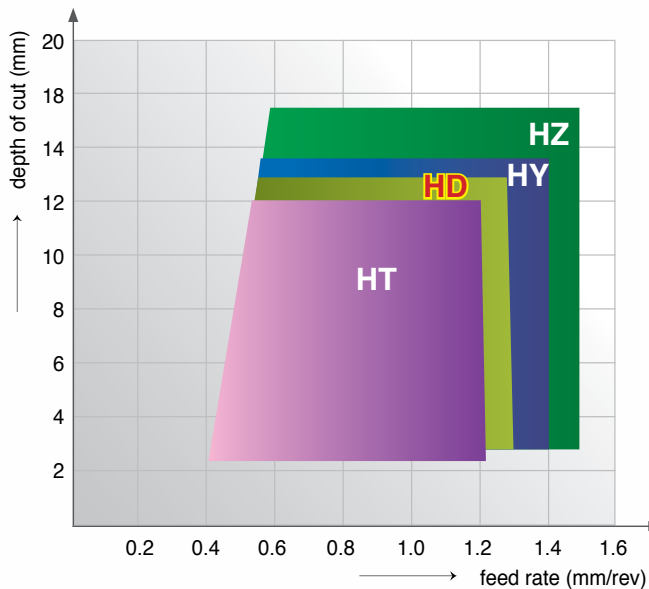
The new concept of double-sided inserts has utilised the most sought after chip breaker geometry types such as the HT, HY and HZ for 80° CNMD and 90° SNMD inserts for heavy rough machining. TaeguTec has now developed its HD type insert as a double-sided chip breaker insert. This protects the inserts with a smooth chip breaking action when machining deeply stepped parts such as shafts. The new design now makes it possible to conduct heavy roughing operations under a variety of machining conditions. This new product sizes the TaeguTec spirit that never stops developing innovative new products to improve cost reduction solutions to its customers.

## Guideline for finish machining



- Commence operation on finish machining first with the bottom face of insert
- Operate rough machining with the top face when required, after four corners of the bottom face are worn-out

## Chip breaking range



- Insert: CNMD 250924 HD
- Cutting speed: 100 m/min
- Material: 0.45% Carbon steel

## The top face finish machining conditions

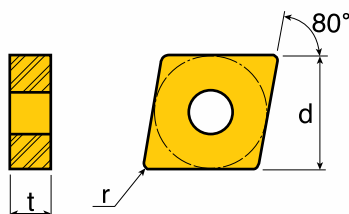
Details	Depth of cut (mm)	Feed rate (mm/rev)
Cutting condition	3.0 (2.0~5.0)	0.6 (0.4~0.8)

## Chip breaking features


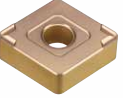

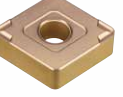
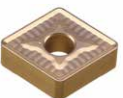



Chip breaker	Appearance	Features	Priority of performance		
			Chip-control	Cutting edge toughness	Cutting force
HT		<ul style="list-style-type: none"> <li>• Low cutting force for low horse power machines</li> <li>• Excellent chip control due to changeable land and a flexible chip breaker</li> </ul>	○		○
HD		<ul style="list-style-type: none"> <li>• For all kinds of shafts, connecting-rods and ship building components</li> <li>• Flexible chip breaker offers excellent chip evacuation</li> </ul>	○		○
HY		<ul style="list-style-type: none"> <li>• For large depth of cut and high feed</li> <li>• Strong cutting edge credit to a wide land and large land angle</li> </ul>	○	○	
HZ		<ul style="list-style-type: none"> <li>• For large depth of cut and high feed</li> <li>• Extremely strong cutting edge credit to a wide land and large land angle</li> <li>• Suitable for high cutting conditions</li> </ul>	○	○	

# CNMD HD HT HY HZ

Designation	d	t	r
<b>CNMD 190624</b>	19.05	6.35	2.4
<b>CNMD 250924</b>	25.40	9.52	2.4



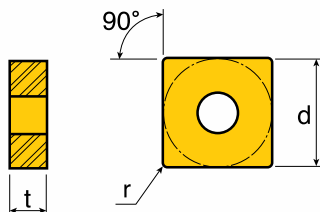
- P** Carbon steel C: 0.45%
- M** Austenitic stainless steel
- K** High tensile cast iron
- N** Aluminum
- S** Inconel
- H** Hardened steel

Insert	Designation	Recommended machining conditions		Grade & Vc (m/min)																			
				Cermet		CVD Coated								PVD Coated		Uncoated							
				feed (mm/rev)	ap (mm)	PV3010	CT3000	TT7005	TT7015	TT7310	TT8115	TT8125	TT8135	TT9215	TT9225	TT9235	TT5100	TT7100	TT5080	TT8020	TT9020	TT9080	P20
 For roughing  For finishing	<b>CNMD 250924 HD</b>	0.55-1.50	4.0-15.0																				
									●270	●245													
 For roughing  For finishing	<b>CNMD 190624 HT</b>	0.35-0.90	4.0-9.0						●	●													
	<b>250924 HT</b>	0.55-1.30	5.0-12.0						●270	●245													
 For roughing  For finishing	<b>CNMD 190624 HY</b>	0.50-1.10	4.0-12.0						●	●													
	<b>250924 HY</b>	0.55-1.50	4.0-15.0						●260	●235													
 For roughing  For finishing	<b>CNMD 250924 HZ</b>	0.55-1.50	4.0-15.0																				
										●260	●235												





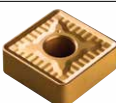



●Marked: Standard items

# SNMD HD HT HY HZ

Designation	d	t	r
SNMD 190624	19.05	6.35	2.4
SNMD 250924	25.40	9.52	2.4



- P** Carbon steel C: 0.45%
- M** Austenitic stainless steel
- K** High tensile cast iron
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- S** Inconel
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Insert	Designation	Recommended machining conditions		Grade & Vc (m/min)																			
				Cermet		CVD Coated								PVD Coated		Uncoated							
				feed (mm/rev)	ap (mm)	PV3010	CT3000	TT7005	TT7015	TT7310	TT8115	TT8125	TT8135	TT9215	TT9225	TT9235	TT5100	TT7100	TT5080	TT8020	TT9020	TT9080	P20
 For roughing  For finishing	SNMD 250924 HD	0.55-1.50	4.0-15.0																				
											● 270	● 245											
 For roughing  For finishing	SNMD 190624 HT	0.55-1.20	4.0-9.0																				
	250924 HT	0.55-1.30	5.0-12.0																				
 For roughing  For finishing	SNMD 190624 HY	0.50-1.10	4.0-12.0																				
	250924 HY	0.55-1.50	4.0-15.0																				
 For roughing  For finishing	SNMD 250924 HZ	0.55-1.50	4.0-15.0																				

• Other grades are made by order  
 • The relevant holders are recommended to use genuine holders provided by TaeguTec

● Marked: Standard items