

40mm Helix Cutting Edge

For large part machining in the wind power, shipbuilding and power plant industries



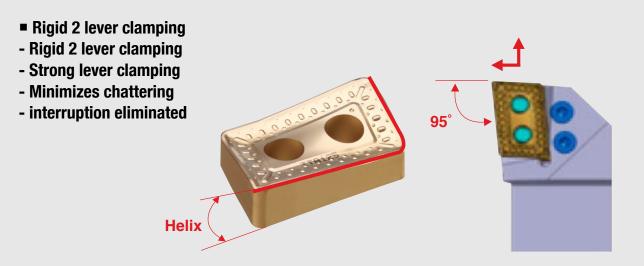
TOPDUTY

40mm helix cutting edge

For large part machining in the wind power, shipbuilding and power plant industries

FEATURES

- High helix cutting edge
- Double lever clamping for maximum clamping stability
- Unique geometry gives low cutting force
- Enhanced productivity with 40mm cutting edge
- Suitable for low-powered machines
- Facing and external turning possible & available in R & L type
- Versatile usage
- 80 degree corner angle allows it to be used for the same purpose of CNMG/CNMM
- 95 degree entrance angle permits facing and external machining



TaeguTec has now introduced its helix-type 40mm TOPDUTY turning insert for smooth cutting and enhanced productivity when large part machining on medium-powered machines.

The helix-type HX chipbreaker with 40mm cutting edges enables smooth cutting at depths of up to 32mm. Moreover, the innovative insert can demonstrate stable chip breaking to enhance productivity without increasing the load on the machine tool. With an 80 degree corner angle, the insert enables simultaneous facing and external turning with no residual marks at the end of the part.

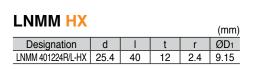
The new TOPDUTY not only achieves simple and strong clamping with its double lever geometry, it also demonstrates longer tool life and stabilised operation. This is attained with minimized chatter and improved chip removal.

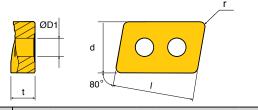




Insert







Р	Carbon Steel C: 0.45%
M	Austenitic Stainless Steel
K	High Tensile Cast Iron

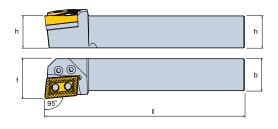
N	Aluminum
S	Inconel
Н	Hardened Steel

		Recommended Machining Conditions			Grade & Vc (m/min) Cermet CVD Coated PVD Coated Uncoated															ed		
Insert	Designation	feed (mm/rev)	ap (mm)	PV3010	СТ3000	TT1300	TT7310	TT8115	TT8125	TT8135	TT9215	TT9225	TT9235	TT5100	TT7100	TT5080	TT8020	ТТ9020	ТТ9080	P20	K10	K20
\$1000000 DE	LNMM 401224R/L-HX	0.70 - 1.50	6.0 - 32.0						• [50					• 90							

• Marked: Standard Items

2PLLNR/L Holder





			Di	monci	on (m	m)	Insert	Components									
		Dimension (mm)					IIISEIL	Lever	Screw	Shim	Shim Pin	Wrench					
Designation	R	L	h	b	-	f											
2PLLNR/L 4040 S4012	•	•	40	40	250	50	LNMM 401224R/L-HX	LCL 8	LCS 8-L39	LN 4025-T6.35 R/L	LSP 8	L-W 5					
5050 T4012	•	•	50	50	300	60	LINIVIIVI 401224R/L-TA	LOL 8	LOS 6-L39	LIN 4020-10.35 H/L	LOP 6	L-W S					

Marked: Standard Items



