

NEW PRODUCT NEWS

TOP DUTY



**Double Sided Insert
with 32mm Cutting Edge**
Brand new double-sided insert



Double sided insert with 32mm cutting edge Brand new double-sided insert

FEATURES

- **The upper-side has a negative chip breaker type that is suitable for heavy machining**
- **The bottom-side is designed to minimize the cutting load and break chips effectively when machining depths of cut less than 5mm**
- **Strong clamping force due to hooked lever system**

Machining large workpieces such as components for the wind power and shipbuilding industries, where most cases demand heavy rough machining, the correct tool selection is a necessity to achieve high productivity and cost reduction levels.

With its optimized configuration, the new HD and HT chip breakers from TaeguTec offer reduced cutting loads and deliver a stable chip breaking force. This makes the inserts the perfect choice for heavy rough machining applications. In addition, the special large lever clamping type insert with 32mm cutting edges delivers a strong clamping force that enables simple but stable and rigid clamping of the insert while improving productivity.

In general, single-sided inserts are commonly used in such operations. However, TaeguTec has developed double-sided inserts to reduce customer tooling costs. The new inserts are also multi-functional with the second side of the insert designed for finish machining.

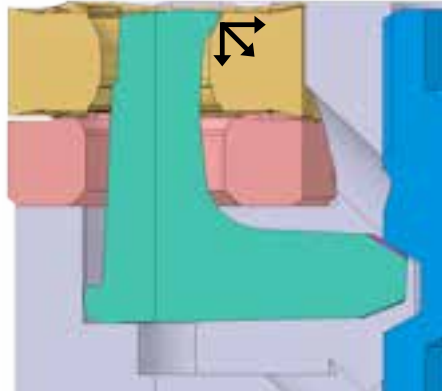
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Clamping structure and features

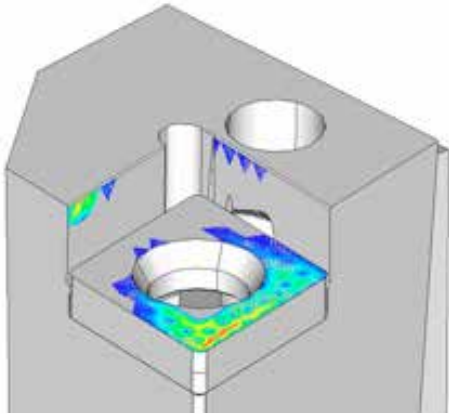
- Improved clamping rigidity and easy assembly structure due to hooked lever clamping technology
(Increased clamping force in direction of under and lateral side)



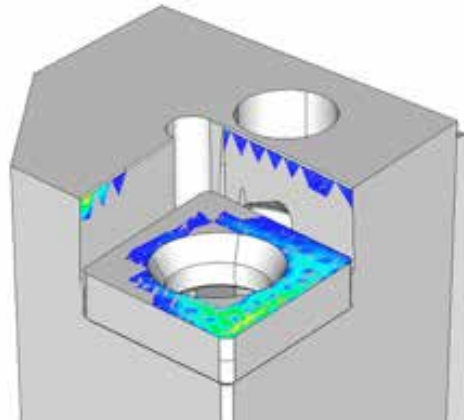
Conventional lever type



Double clamping force



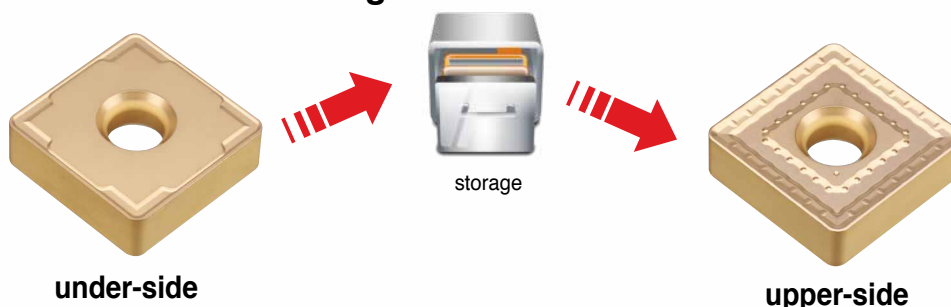
Not strong clamping power due to one directional force



Function for double clamping
(Downward clamping force increased)

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Guideline for finish machining



- 1) Commence operation on finish machining first with the under-side of insert
- 2) Operate rough machining with the upper-side when required, after four corners of the under-side are worn-out

The upper-side (rough machining) conditions

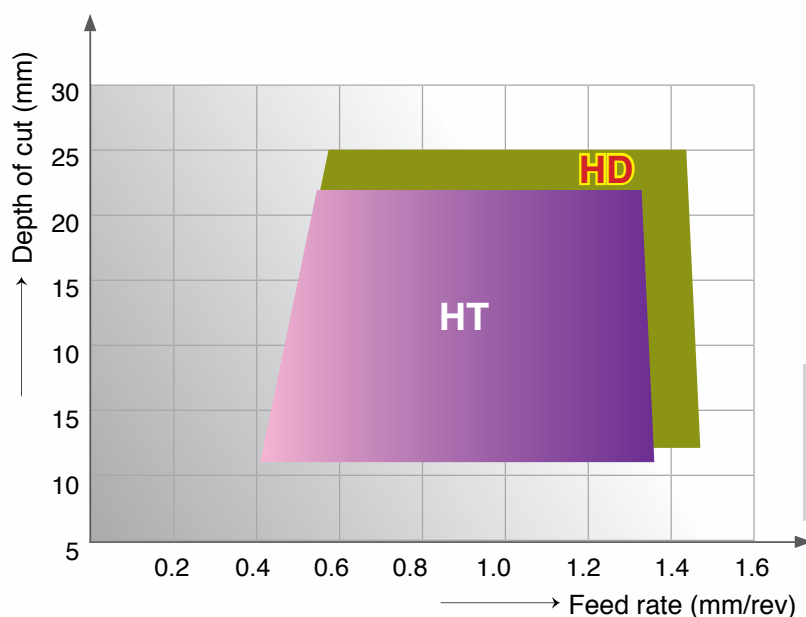
Designation	Feed Rate (mm/rev)	Depth of Cut (mm)
SNMD 310924 HD	1.0 (0.60 - 1.5)	15.0 (7.0 - 25.0)
SNMD 310924 HT	1.0 (0.50 - 1.4)	15.0 (6.0 - 22.0)

• Other grades are made by order.

The under-side (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)

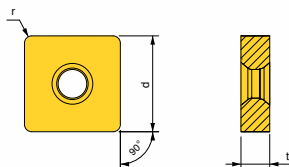
Chip breaking range (The upper-side rough machining range)



▶ Insert: SNMD 310924 HD
 ▶ Cutting speed: 100 m/min
 ▶ Material: 0.45% Carbon Steel

Insert





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SNMD 31 HD HT (mm)

Designation	d	t	r
SNMD 310924	31.75	9.525	2.4

- P** Carbon Steel C: 0.45%
- M** Austenitic Stainless Steel
- K** High Tensile Cast Iron
- N** Aluminum
- S** Inconel
- H** Hardened Steel

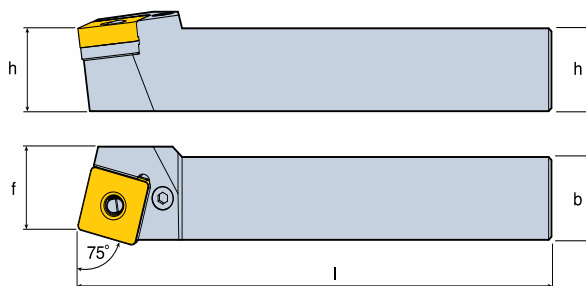
Insert	Designation	Recommended Machining Conditions		Grade & Vc (m/min)																		
				Cermet		CVD Coated								PVD Coated		Uncoated						
		feed (mm/rev)	ap (mm)	PV3010	CT3000	TT1300	TT7310	TT8115	TT8125	TT8135	TT9215	TT9225	TT9235	TT5100	TT7100	TT5080	TT8020	TT9020	TT9080	P20	K10	K20
 For Heavy  For Finishing	SNMD 310924 HD	0.60 - 1.50	7.0 - 25.0																			
 For Heavy  For Finishing	SNMD 310924 HT	0.50 - 1.40	6.0 - 22.0																			

• Other grades are made by order.

• Marked: Standard Items

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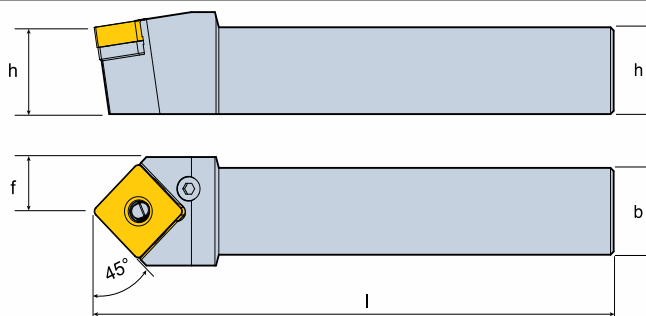
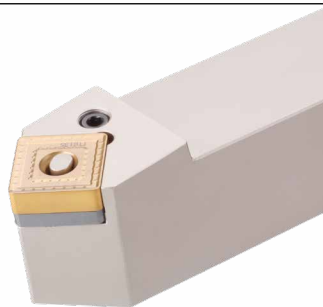
HSBNR/L holder



Designation			Dimension (mm)				Insert	Components				
	R	L	h	b	l	f		Lever	Screw	Shim	Shim Pin	Wrench
HSBNR/L 4040 S3109	●	●	40	40	250	35	SNM□3109□□					
5050 T3109	●	●	50	50	300	43						

●Marked: Standard Items

HSDNN holder



Designation			Dimension (mm)				Insert	Components				
			h	b	l	f		Lever	Screw	Shim	Shim Pin	Wrench
HSDNN 4040 S3109	●		40	40	250	20	SNM□3109□□					
5050 T3109	●		50	50	300	25						

●Marked: Standard Items