

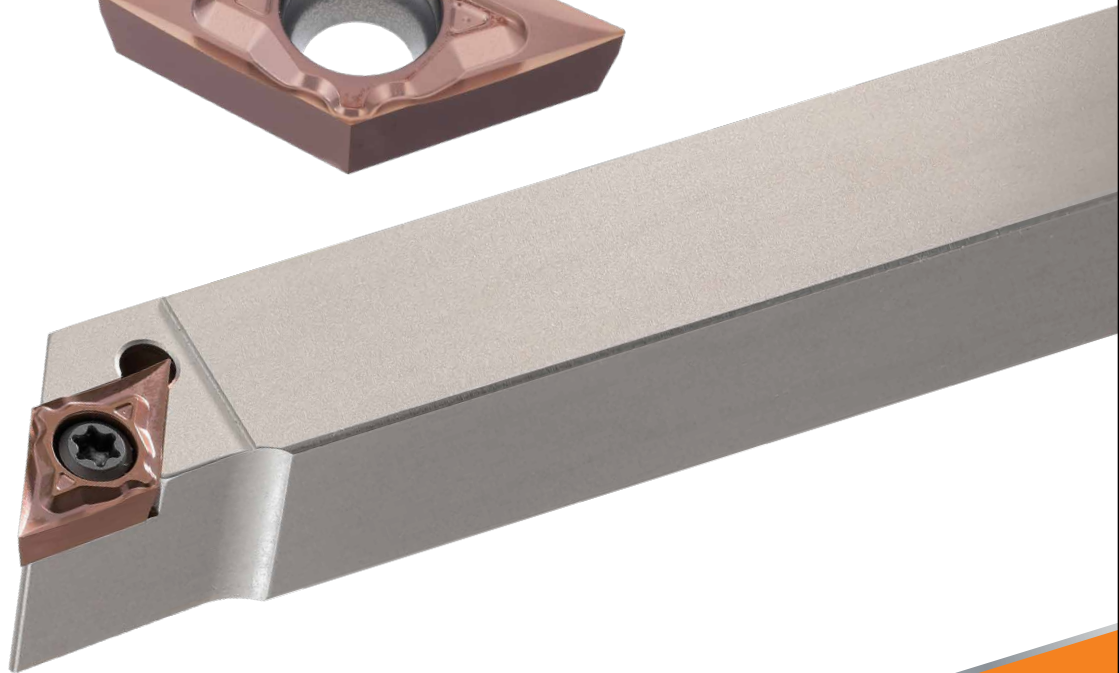
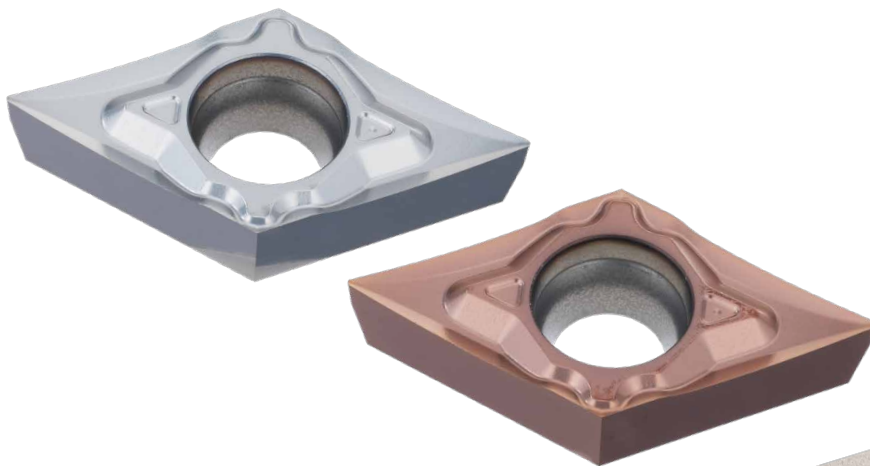
# NPN

New Product News



## TOP MINI

### DCGT-ST Insert for Deep Depth of Cut Machining



## KEY POINT

**TaeguTec introduces the DCGT-ST insert for deep depth of cut machining on Swiss type machines.**

Compatible with ISO turning holders, the 2-corner positive DCGT-ST insert with a high rake angle designed new chip breaker provides excellent machining performance and stable tool life due to the low cutting force generated during machining. The new chip breaker enables deep depth of cut machining up to 5.0 mm so that the number of required machining paths is reduced, resulting in higher productivity.

For further details, please contact the relevant product manager.



### Features

- 2-corner positive insert for small part machining
- 5.0 mm maximum depth of cut
  - Reduced number of machining paths for higher productivity
- Higher rake angle design for low cutting force
- Compatible with ISO turning holders

### Insert designation system

**DCGT 11T302M ST-F**  
1 2 3

1. **M**: Corner radius minus tolerance  
(ex 02M: lower than R0.2)

2. Chip breaker

**SL**: Low depth of cut for finishing

**SM**: Medium depth of cut for medium

**SH**: 3.5 mm maximum depth of cut for roughing

**new ST**: 5.0 mm maximum depth of cut for roughing

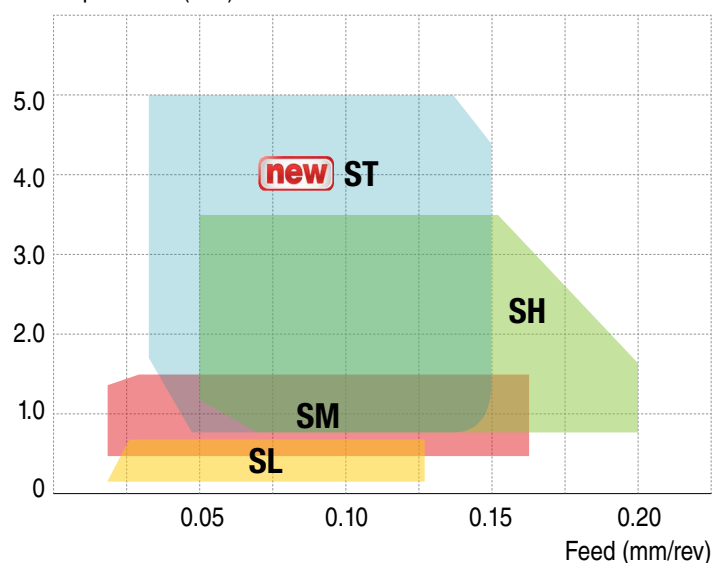
3. Edge specification

**F**: Sharp edge

**E**: Micro honing edge

### Chip breaker range










Depth of cut (mm)



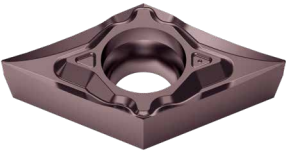
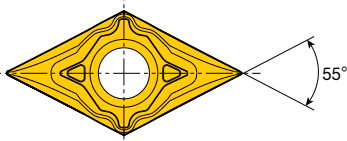
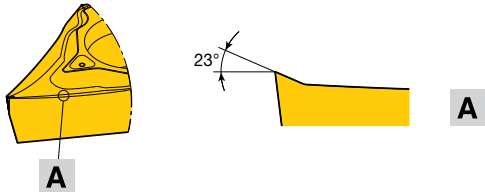
- ▶ Insert: DCGT 11T302
- ▶ Cutting speed: 80 m/min
- ▶ Material: Stainless steel (AISI 304)

## Chip curl by cutting conditions

-Excellent chip control even in deep depths of cut up to 5.0 mm

Material	Stainless steel (AISI 304)	Application	Ø20 external turning	RPM	2,000 rpm
ap (mm)	Feed (mm/rev)				
	0.05	0.08	0.1		
5.0					
3.0					
1.0					

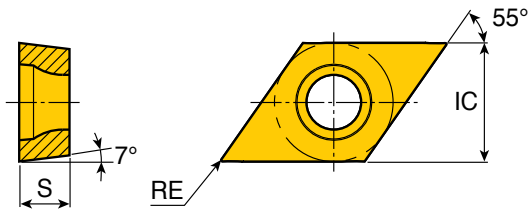
## DCGT-ST insert geometry

Chip breaker	Geometry
 <p>ST: for roughing</p>	 


## DCGT-ST new



Positive 7° clearance 55° rhombic inserts



Size	Dimension (mm)		
	IC	S	RE
<b>11</b>	9.52	3.97	0.1-0.4

Insert	Designation	ap (mm)	Feed (mm/rev)	Cermet		PVD coated							Uncoated		
				PV3010	CT3000	TT5080	TT8020	TT9080	TT3010	TT9020	TT9225	TT4410	TT4430	P20	K10
 Roughing For Swiss	<b>DCGT 11T301M ST-E</b>	0.3-5.0	0.03-0.08											●	
	<b>11T302M ST-E</b>	0.5-5.0	0.03-0.10											●	
	<b>11T304M ST-E</b>	0.7-5.0	0.05-0.12											●	
	<b>11T301M ST-F</b>	0.3-5.0	0.03-0.08							●				●	
	<b>11T302M ST-F</b>	0.5-5.0	0.03-0.10							●				●	
	<b>11T304M ST-F</b>	0.7-5.0	0.05-0.12							●				●	

●: Standard items