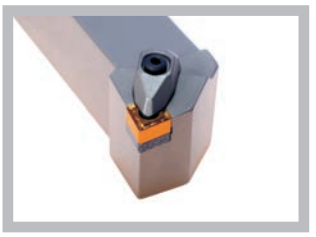
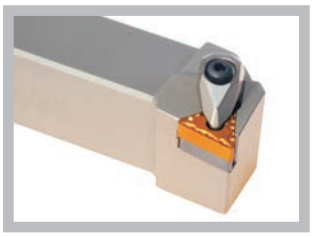
D-CLAMP

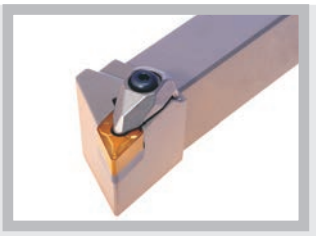
THE SMARTEST INSERT CLAMPING MECHANISM FOR ALL TURNING OPERATIONS.

D-Clamp provides the most secure insert clamping with simple structure.D-Clamp holders give longer tool life to insert because it decreases vibrations or movement of insert during cutting, thanks to its very strong clamping.

- Secure and rigid bi-directional clamping
- Simple clamping action
- Easy and accurate indexing
- Bigger seat for superior stability
- Longer tool life
- First choice for interrupted cuts







D-CLAMP PROGRAM

DCLNR/L 2020 K12	DTJNR/L 2020 K16
DCLNR/L 2525 M12	DTJNR/L 2525 M16
DDJNR/L 2020 K15	DWLNR/L 2020 K06-C
DDJNR/L 2525 M15	DWLNR/L 2525 K06-C
DSDNN 2020 K12	DWLNR/L 2020 K08-C
DSDNN 2525 M12	DWLNR/L 2525 K08-C

SMARTTURN

30% savings GUARANTEED

SMARTER TURNING SOLUTIONS FOR INCREASED SAVINGS

When depths of cut in turning are predominantly in the range of 2 to 3 mm, why use the conventional ISO turning inserts with 12~15 mm cutting edge lengths? Focus on cost reduction with smaller but durable Smart-Turn inserts. Increase competitiveness with reduced machining costs.

Smart-Turn inserts are available in popular shapes of C and T. Smart-Turn external holders are available in secure D-Clamp style for C shape inserts and a nifty wedge-lock style for T shape inserts.

Smart-Turn internal holders are available in form of versatile screw clamped boring bars in 16 and 20mm shanks.

PROGRAM:

INSERTS:

CNMA 090412	Smart Turn inserts are available in popular grades: DC9015, DC9025, DC9800, DC 9235, DP5010 and DC820.
CNMG 090408*	
CNMG 090412*	
TNMA 130408	
TNMG 130404*	
TNMG 130408*	* available in popular chipbreakers: M3, D3, D5 and R5.
TNMG 130412*	

EXTERNAL HOLDERS:

DCLNR/L 2020 K0904
DCLNR/L 2525 M0904
WTJNR/L 2020 K1304-C
WTJNR/L 2525 K1304-C

INTERNAL HOLDERS:

S16Q/S20Q SCLNR/L 0904-C
S16Q/S20Q STJNR/L 1304-C
S16Q/S20Q STUNR/L 1304-C

DURACARB is the smart choice.

Chipbreakers

No more excuses for Birdnesting.

Poor chip breaking produces long, stringy chips, commonly referred to as birdnests. When chips form in birdnests, they get wrapped up around the chuck and the workpiece causing damage and poor surface finish. Long chips take up more room in the hopper, which requires it to be emptied more often. Time is lost in stopping the machine to remove chips, productivity is reduced, cycle time is increased and per-part costs are higher. Birdnesting is also a health and safety issue for the machinist.

Smart chip control is key to successful turning operation. Duracarb presents, the choicest range of chip breakers that can not only improve chip control but also reduce cutting thickness. Duracarb's smart chip breakers cut short the chips to suitable lengths, reduce cutting resistance and load, decrease the temperature at the cutting edge and delays tool wear.

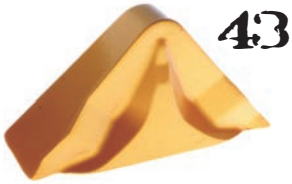
NEGATIVE

41

- For medium and finishing
- Good chip evacuation in low feed and depth of cut
- Excellent chip control

42

- For medium machining in stainless steel and low carbon steel
- Low cutting force with sharp edge geometry



43

- Balance between strength and sharpness
- For semi finishing to medium machining in steel and alloy steel
- Good chip control in profiling

45

- For medium machining in steel, low carbon steel and low carbon alloy steel
- Semi finishing in cast iron
- Minimum of built-up edge from sharp edge geometry

46

- Medium for carbon steel and alloy steel
- From medium to finishing of cast iron machining
- Suitable for continuous to interrupted
- Geometry of low cutting force

53

- Medium to roughing in steel and cast iron
- Strong cutting edge
- Recommended for unstable conditions

POSITIVE

41

- Finishing on boring applications
- Good chip evacuation in low feed and depth of cut
- Low cutting force and good chip control for steel and stainless steel machining

51

- Medium machining in steel, stainless steel and cast iron
- Applicable to both interrupted and continuous machining

52

- For medium to semi-roughing
- For steel and cast iron

Grades

	WORKPIECE MATERIAL	HARDER ⟷ TOUGHER	FINISH/ LIGHT ⟷ MEDIUM/ ROUGH
P	CARBON STEEL ALLOY STEEL MILD STEEL	DC610	
		DC8035	
		DC9235	
		DC9015	
		DC9025	
		DC9800	
M	STAINLESS STEEL	DC610	
		DP5010	
		DC8035	
		DC9800	
K	CAST IRON	DC610	
		DC210	
		DC820	
		DC9800	
N	NON FERROUS	DC210	
S	HEAT RESISTANT ALLOY	DP5010	
		DC8035	
		DC9235	
		DC9800	

APPLICATION GUIDELINE FOR NEGATIVE INSERTS

WORKPIECE MATERIAL	SHARPER / FINISH/ LIGHT ⟷ STRONGER / MEDIUM/ ROUGH
P CARBON STEEL, ALLOY STEEL, MILD STEEL	41, 42, 43, 45, 46, 53
M STAINLESS STEEL	41, 42, 45
K CAST IRON	41, 45, 46, 53
N NON FERROUS	AU
S HEAT RESISTANT ALLOY	41, 43, 46
	CONTINUOUS / LOW DEPTH ⟷ INTERRUPTED / HIGH DEPTH