

NPA

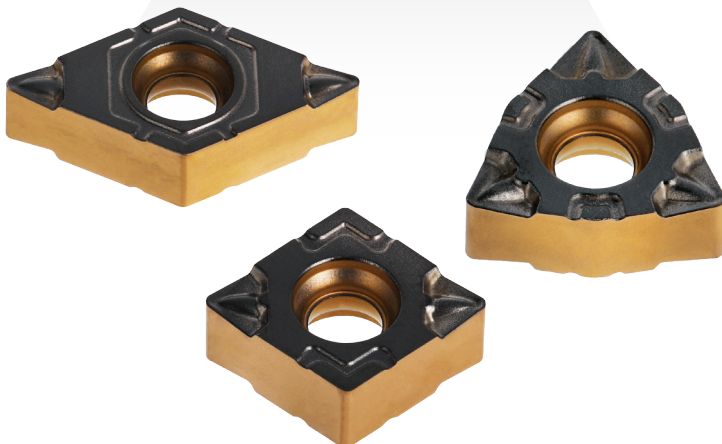
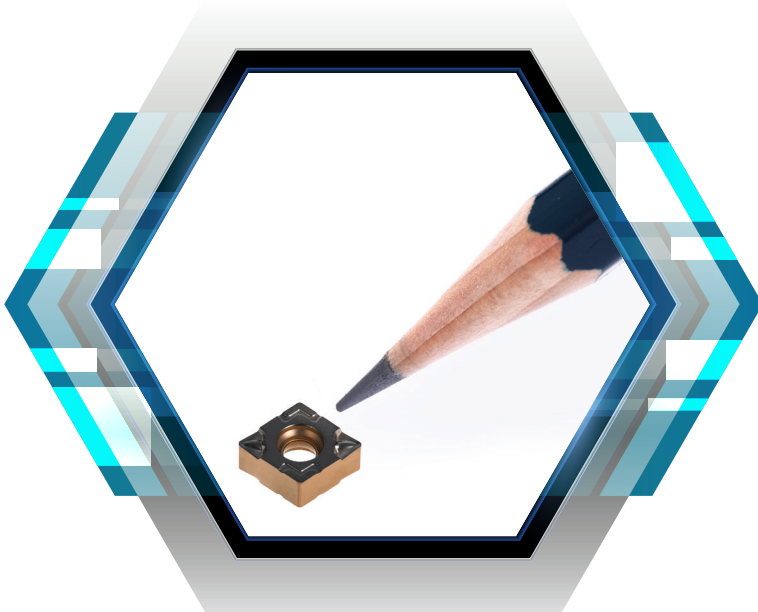
New Product Announcement No. 2019-24



RHINO M TURN

MINI LINE

Economical Double-Sided
Mini Size Inserts and Holders



KEY POINT

TaeguTec has launched a new double-sided mini size insert and holder line, the RHINO-M-TURN, replacing standard positive small inserts.

RHINO-M-TURN is a compact, double-sided mini size insert that is suitable for the internal and external turning of small parts and can replace standard positive small inserts like CCMT 06 and DCMT 07.

Although the insert is a double-sided type, it has the same edge angle as the conventional positive insert type when mounted to the holder. This results in minimal vibration due to the low cutting force, as well as good workpiece surface finish and machining accuracy; particularly at low depths of cut. In addition, the strong screw clamping design exerts stable machining during operations.

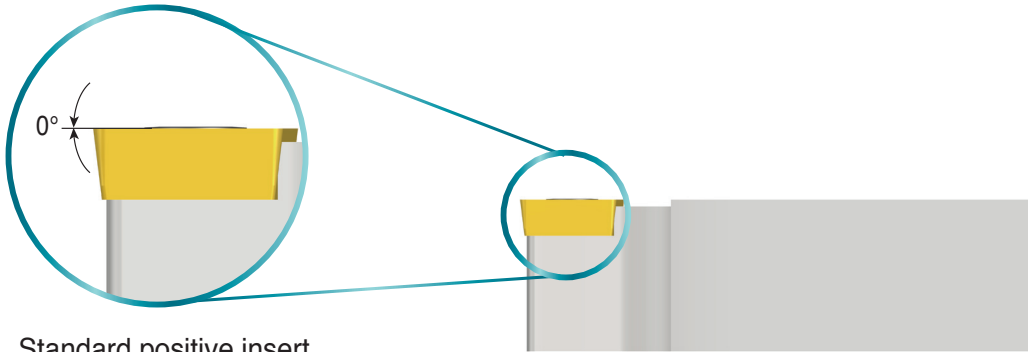
The inserts are available as CNMX, DNMX, WNMX type for finishing, and a precise DNGX type suitable for Swiss type automatic lathes. The square holders are available in shank sizes 1212, 1616 for Swiss type automatic lathes, and 1616, 2020 for general machining while the boring bars are available in Ø12 mm and Ø16 mm.

Features

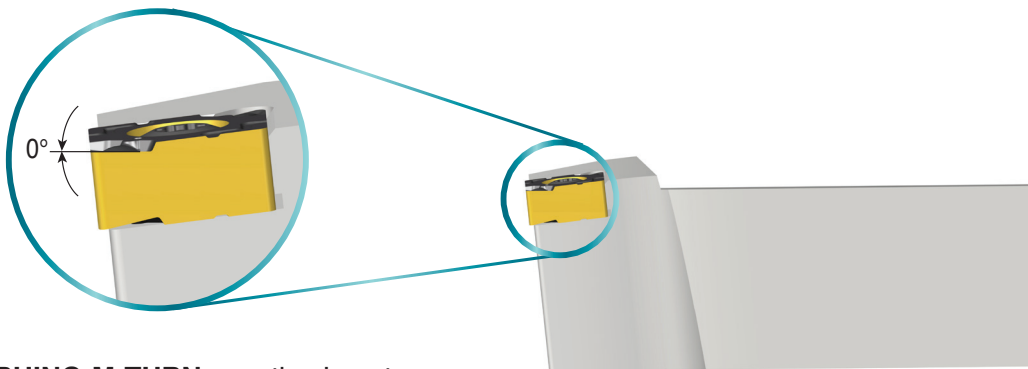
- Double-sided mini size inserts (IC 7 mm), optimized turning for low depths of cut less than 2 mm
- **RHINO-M-TURN** inserts have the same cutting edge angle of zero degree as standard positive inserts when mounted to holders
 - Low cutting force and minimal vibration
 - Good surface finish of the workpiece
- Excellent chip control at low depths of cut
- Stable screw clamping suitable for general-purpose machining of small parts and Swiss type automatic lathes



Same cutting edge angle as the standard positive insert



Standard positive insert



RHINO-M-TURN negative Insert

New chip breaker designation

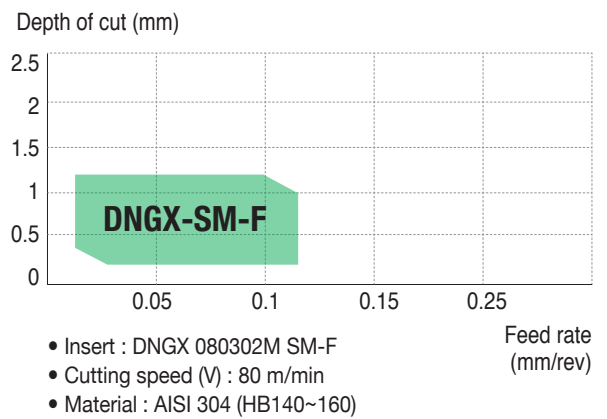
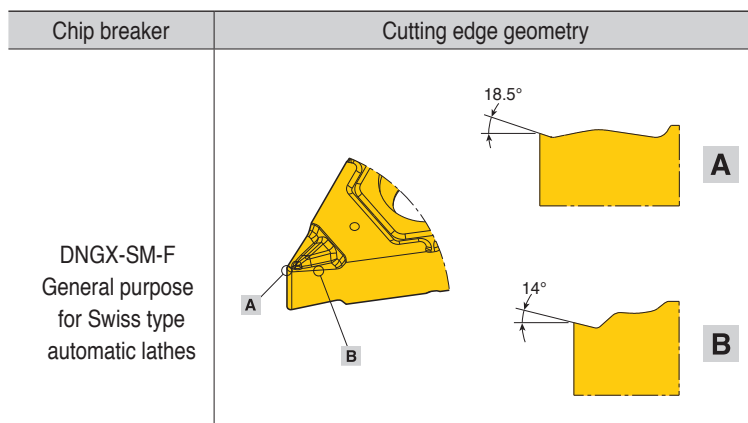
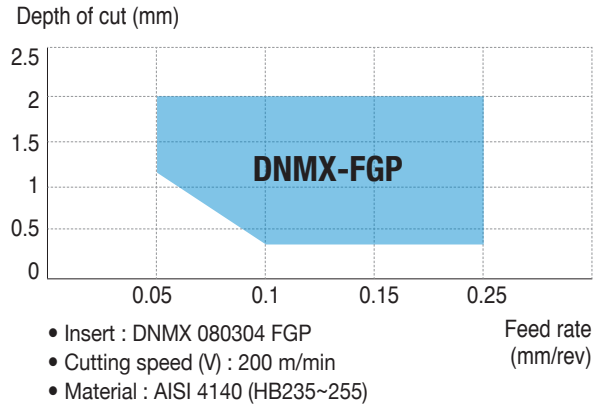
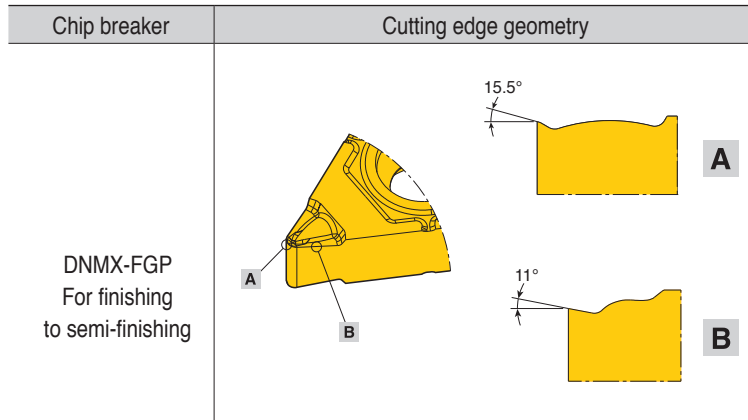
F	G	P
1	2	3

1 Applications	
F	Finishing
M	Medium
R	Roughing

2 Cutting conditions	
L	Light cutting
G	General cutting
T	Tough cutting

3 Workpiece materials	
P	Steel
M	Stainless steel
K	Cast iron
S	High temperature alloys

DNMX chip breaker geometry and chip control range



Availability

In stock

Price

Available in the GAL system

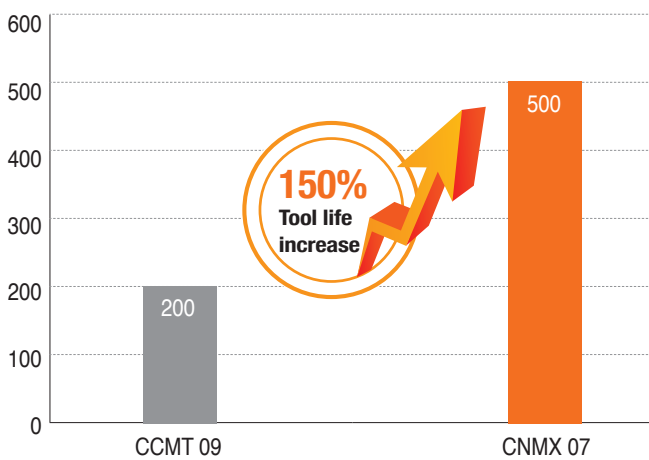
Sincerely,
TaeguTec

Bae Dae-wi
Non-Rotating General PM

Case study 1

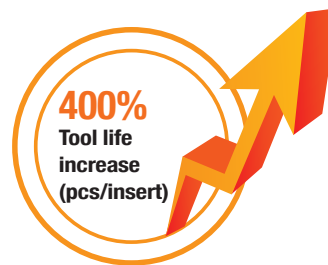
		TaeguTec	TaeguTec
Material		AISI 1045	
Holder		S16R SCLCL 09	A16Q SCLNR 0703
Insert		CCMT 09T308 MT TT8115	CNMX 070304 FGP CT3000
Cutting speed	V (m/min)	215	215
Feed rate	f (mm/tooth)	0.2	0.2
Depth of cut	ap (mm)	0.5	0.5
Coolant		wet	wet
Tool life (pcs/corner)		200	500

Tool life (pcs/corner)



CCMT 09: 2 corners X 200 pcs = 400 pcs

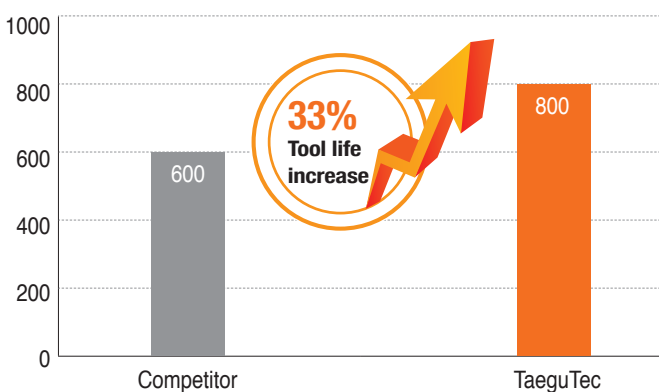
CNMX 07: 4 corners X 500 pcs = 2,000 pcs



Case study 2

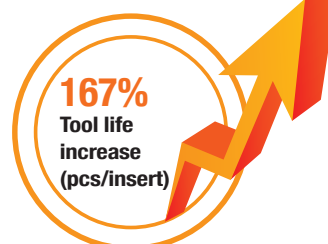
		Competitor	TaeguTec
Material		AISI 1045	
Holder		Ø16 boring bar	A16Q SDUNR 0803
Insert		DCMT 070204 (CVD coated)	DNMX 080304 FGP TT8125
Cutting speed	V (m/min)	119-157	119-157
Feed rate	f (mm/tooth)	0.13-0.23	0.13-0.23
Depth of cut	ap (mm)	0.05-0.15	0.05-0.15
Coolant		wet	wet
Tool life (pcs/corner)		600	800

Tool life (pcs/corner)



CCMT 07: 2 corners X 600 pcs = 1,200 pcs

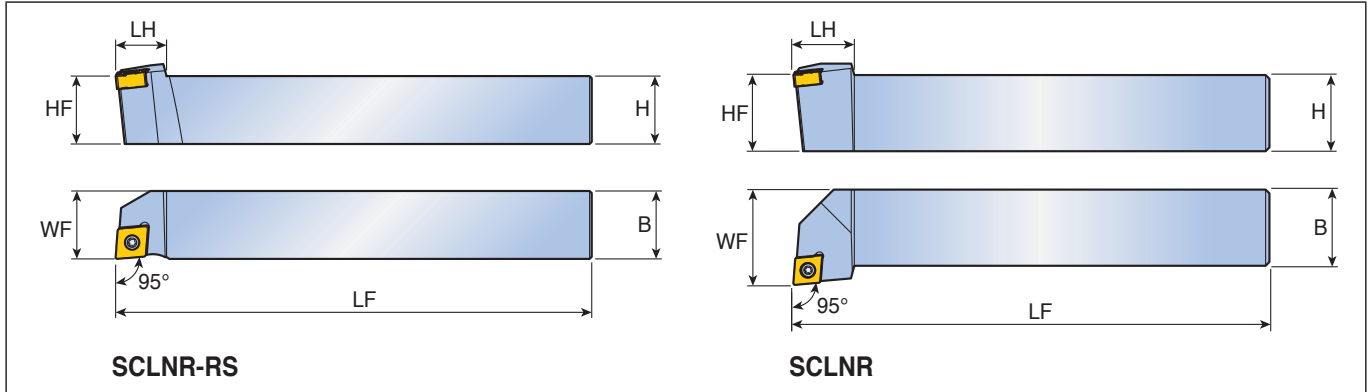
CNMX 08: 4 corners X 800 pcs = 3,200 pcs



SCLNR/L-RS SCLNR/L



Screw type holders



Approach angle	Designation	Dimension (mm)						Insert
		H	HF	B	LF	LH	WF	
95°	SCLNR/L 1212 K0703-RS	12	12	12	125	12	12	CNMX 0703...
	1616 K0703-RS	16	16	16	125	12	16	
95°	SCLNR/L 1616 H0703	16	16	16	100	12	20	
	2020 K0703	20	20	20	125	16	25	

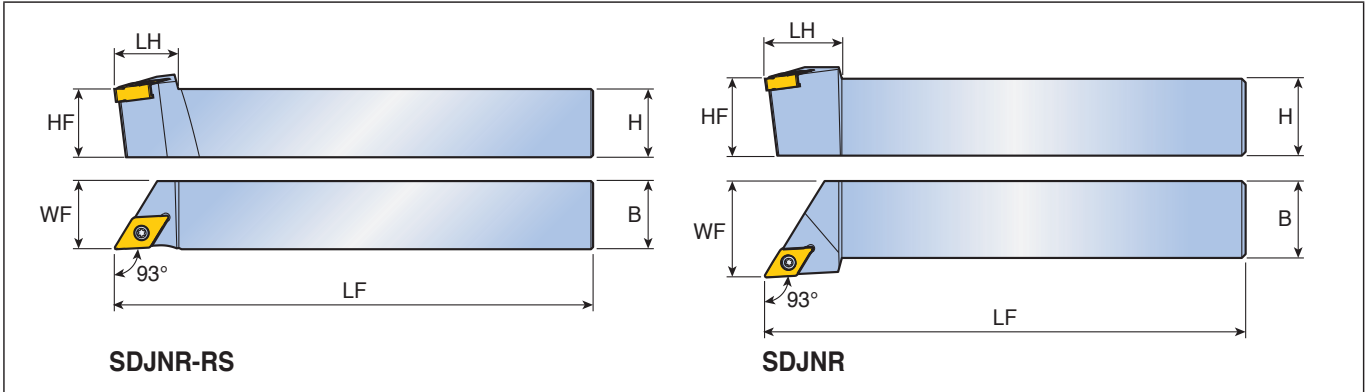
Spare parts

Designation	Screw	Wrench			
...0703...	TS 25D060/HG-P	T 7P			

SDJNR/L-RS SDJNR/L



Screw type holders



Approach angle	Designation	Dimension (mm)						Insert
		H	HF	B	LF	LH	WF	
93°	SDJNR/L 1212 K0803-RS	12	12	12	125	15	12	DN...X 0803...
	1616 K0803-RS	16	16	16	125	15	16	
93°	SDJNR/L 1616 H0803	16	16	16	100	16	20	
	2020 K0803	20	20	20	125	20	25	

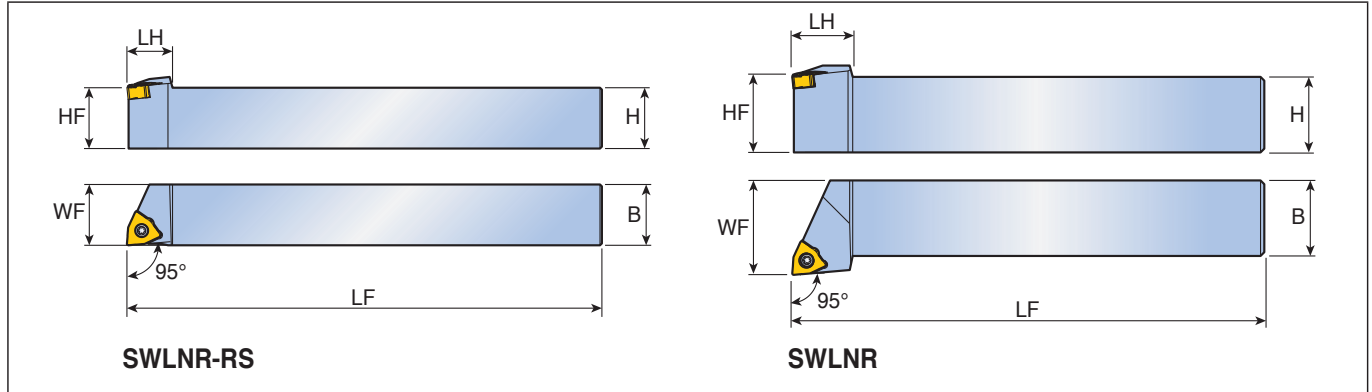
Spare parts

Designation	Screw	Wrench			
...0803...	TS 25D060/HG-P	T 7P			

SWLNR/L-RS SWLNR/L



Screw type holders



Approach angle	Designation	Dimension (mm)						Insert
		H	HF	B	LF	LH	WF	
95°	SWLNR/L 1212 K0403-RS	12	12	12	125	12	12	WNMX 0403...
	1616 K0403-RS	16	16	16	125	12	16	
95°	SWLNR/L 1616 H0403	16	16	16	100	16	20	
	2020 K0403	20	20	20	125	16	25	

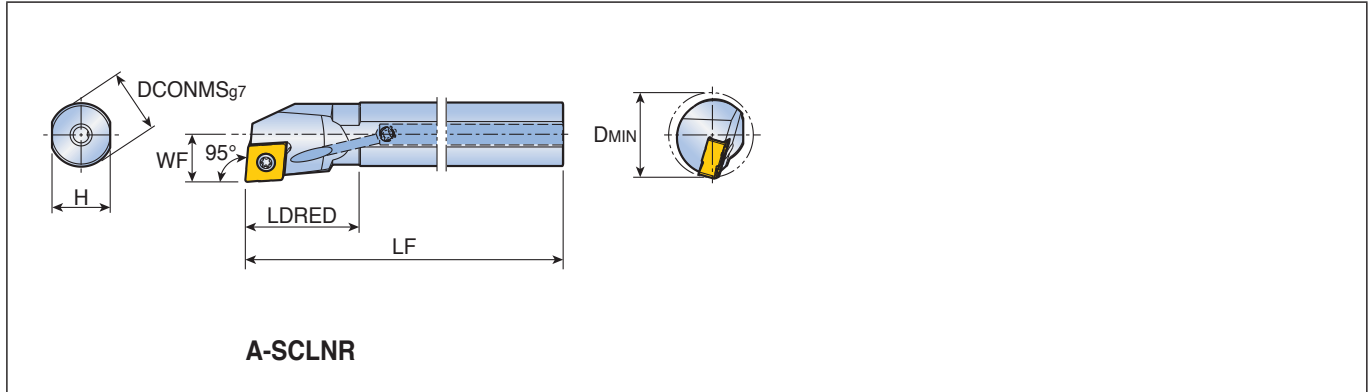
Spare parts

Designation	Screw	Wrench			
...0403...	TS 25D060/HG-P	T 7P			

A-SCLNR/L



Screw type boring bars



Approach angle	Designation	Dimension (mm)						Insert
		DCONMS	H	LF	LDRED	WF	DMIN	
95°	A12M SCLNR/L 0703	12	11	150	21.5	9	16	CNMX 0703...
	A16Q SCLNR/L 0703	16	15	180	24.5	11	20	

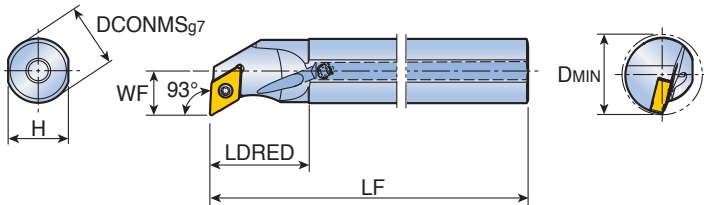
Spare parts

Designation	Screw	Wrench			
...0703	TS 25D060/HG-P	T 7P			

A-SDUNR/L

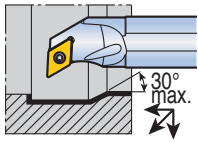


Screw type boring bars



A-SDUNR

Approach angle	Designation	Dimension (mm)						Insert
		DCONMS	H	LF	LDRED	WF	DMIN	
93°	A12M SDUNR/L 0803	12	11	150	21.5	9	16	DN...X 0803...
	A16Q SDUNR/L 0803	16	15	180	24.5	11	20	



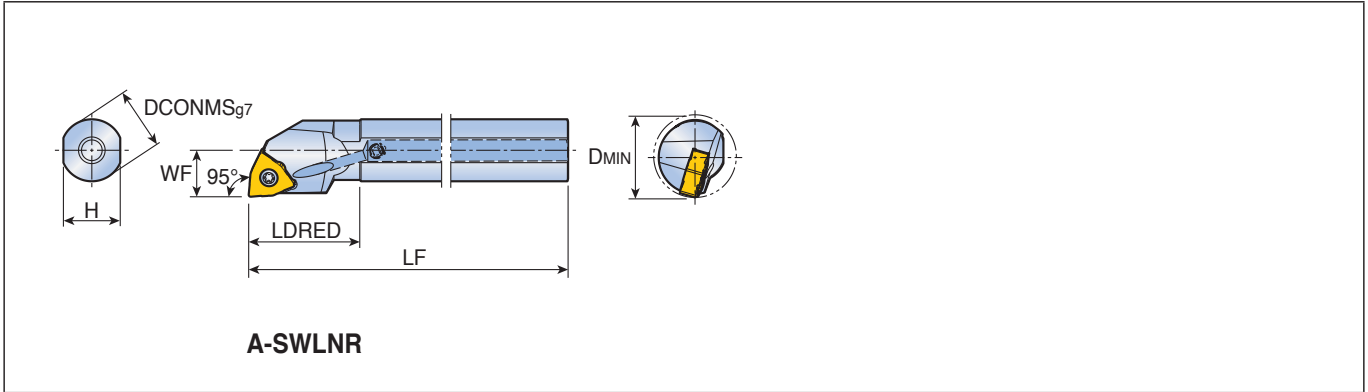
Spare parts

Designation	Screw	Wrench			
...0803	TS 25D060/HG-P	T 7P			

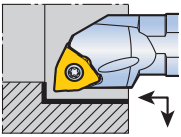
A-SWLNRL



Screw type boring bars



Approach angle	Designation	Dimension (mm)						Insert
		DCONMS	H	LF	LDRED	WF	DMIN	
95°	A12M SWLNR/L 0403	12	11	150	21.5	9	16	WNMX 0403...
	A16Q SWLNR/L 0403	16	15	180	24.5	11	20	



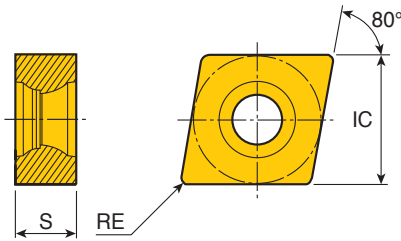
Spare parts

Designation	Screw	Wrench			
...0403	TS 25D060/HG-P	T 7P			

CNMX



Negative 80° rhombic inserts



Size	Dimension (mm)		
	IC	S	RE
07	7	3.18	0.4

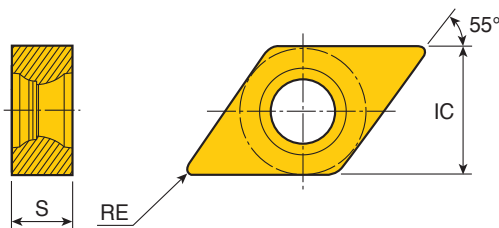
Insert	Designation	ap (mm)	Feed (mm/rev)	Cermet		CVD coated								PVD coated							
				PV3010	CT3000	TT7005	TT7015	TT8105	TT8115	TT8125	TT8135	TT9215	TT9225	TT9235	TT5100	TT7100	TT5080	TT8020	TT9020	TT9080	
	CNMX 070304 FGP	0.3-2.0	0.05-0.25	●						●	●							●			

●: Standard items

DNGX/DNMX



Negative 55° rhombic inserts



Size	Dimension (mm)		
	IC	S	RE
08	7	3.18	0.2-0.4

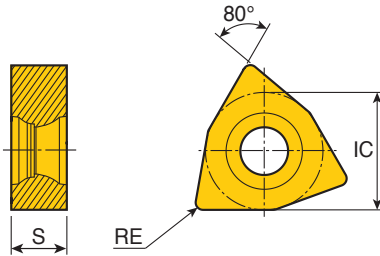
Insert	Designation	ap (mm)	Feed (mm/rev)	Cermet		CVD coated								PVD coated							
				PV3010	CT3000	TT7005	TT7015	TT8105	TT8115	TT8125	TT8135	TT9215	TT9225	TT9235	TT5100	TT7100	TT5080	TT8020	TT9020	TT9080	
	DNGX 080302M SM-F	0.2-1.2	0.02-0.12																		●
	DNMX 080304 FGP	0.3-2.0	0.05-0.25	●																	●

●: Standard items

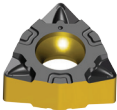
WNMX



Negative 80° trigon inserts



Size	Dimension (mm)		
	IC	S	RE
04	7	3.18	0.4

Insert	Designation	ap (mm)	Feed (mm/rev)	Cermet		CVD coated										PVD coated					
				PV3010	CT3000	TT7005	TT7015	TT8105	TT8115	TT8125	TT8135	TT9215	TT9225	TT9235	TT5100	TT7100	TT5080	TT8020	TT9020	TT9080	
	WNMX 040304 FGP	0.3-2.0	0.05-0.25	●					●	●								●			

●: Standard items

KIT COLLECTIONS

These kit products are available in the format listed below.



Cat. No	Designation	Bill of materials	Qty.
6334746	KISFT-A16Q S-CN0703 FGP	A16Q SCLNR 0703	1
		CNMX 070304 FGP TT8115	3
6334747	KISFT-A16Q S-DN0803 FGP	A16Q SDUNR 0803	1
		DNMX 080304 FGP TT8115	3
6334748	KISFT-A16Q S-WN0403 FGP	A16Q SWLNR 0403	1
		WNMX 040304 FGP TT8115	3



Cat. No	Designation	Bill of materials	Qty.
6334759	KISFS-A16Q S-CN0703 FGP	A16Q SCLNR 0703	1
		CNMX 070304 FGP TT8115	30
6334760	KISFS-A16Q S-DN0803 FGP	A16Q SDUNR 0803	1
		DNMX 080304 FGP TT8115	30
6334761	KISFS-A16Q S-WN0403 FGP	A16Q SWLNR 0403	1
		WNMX 040304 FGP TT8115	30



Cat. No	Designation	Bill of materials	Qty.
6338381	KISFF-A-C070304FGP TT8115	CNMX 070304 FGP TT8115	100
6338382	KISFF-B-C070304FGP TT8115		300
6338383	KISFF-C-C070304FGP TT8115		500
6338384	KISFF-A-D080304FGP TT8115	DNMX 080304 FGP TT8115	100
6338385	KISFF-B-D080304FGP TT8115		300
6338386	KISFF-C-D080304FGP TT8115		500
6338387	KISFF-A-W040304FGP TT8115	WNMX 040304 FGP TT8115	100
6338388	KISFF-B-W040304FGP TT8115		300
6338389	KISFF-C-W040304FGP TT8115		500