

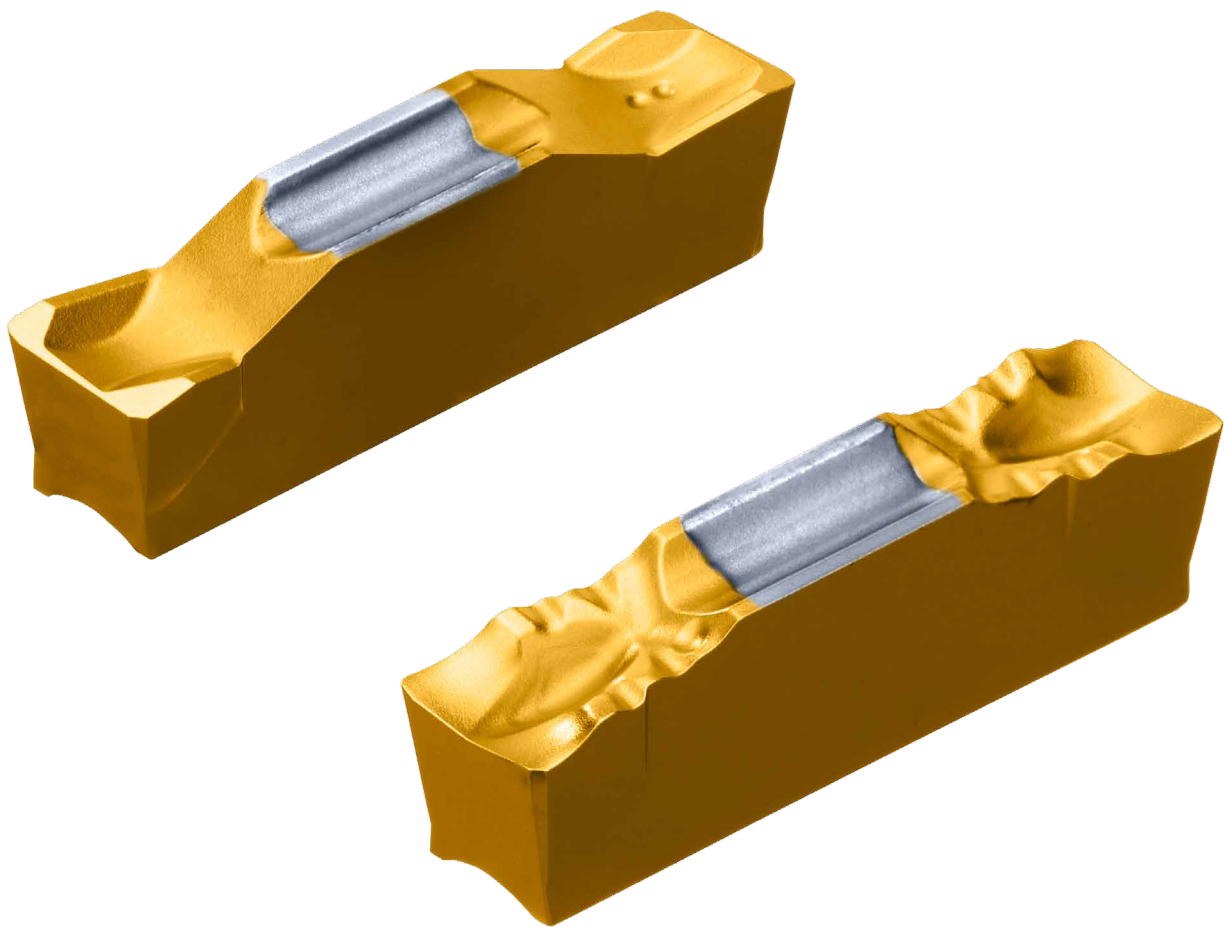
NPN

New Product News



RHINO GROOVE

Lead Angle Type Expansion for
RDC/RDJ 2 and 3 mm Inserts



KEY POINT

TaeguTec expands the RHINO-GROOVE line with 6° and 15° lead angle type inserts.

The RHINO-GROOVE line, known for excellent performance in shallow grooving and parting operation, has been expanded with a new 6° and 15° lead angle type double-ended RDC and RDJ inserts.

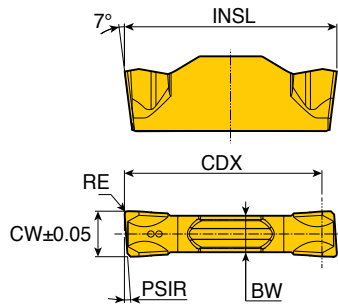
Features

- Lead angle 6° and 15° type inserts for the double-ended RDC 2 and 3 mm line
- Lead angle 6° and 15° type inserts for the double-ended RDJ 2 and 3 mm line
- Available in TT9080, TT7220 and TT8020 grades to cover all materials



RDC

Double-ended inserts for shallow grooving and parting with “C” type chip breaker



Right hand shown

Size	Dimension (mm)					
	CW	RE	BW	INSL	PSIR	CDX
2 (..R)	2	0.2	1.7	14	0-6	13
2 RS	2	0.02	1.7	13.6	15	13
3 (..R)	3	0.2	2.4	14	0-15	13
4	4	0.3	3	14	-	13
5	5	0.3	4	17.5	-	17

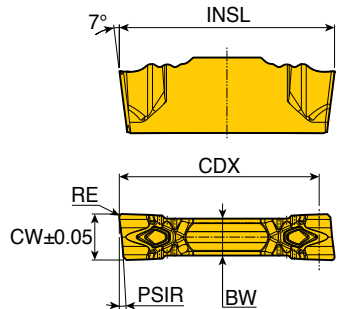
Insert	Designation	Insert seat size	Feed (mm/rev)	Coated		
				TT9080	TT7220	TT8020
	RDC 2	2	0.05-0.18	●	●	●
	2-6R new	2	0.04-0.14	●	●	●
	2-15R new	2	0.04-0.14	●	●	●
	2-15RS new	2	0.04-0.13	●	●	●
	3	3	0.07-0.25	●	●	●
	3-6R new	3	0.06-0.18	●	●	●
	3-15R new	3	0.06-0.18	●	●	●
	4	4	0.08-0.30	●	●	●
	5	5	0.09-0.35	●	●	●

● : Standard items

RDJ



Double-ended inserts for shallow grooving and parting with “J” type chip breaker



Right hand shown

Size	Dimension (mm)					
	CW	RE	BW	INSL	PSIR	CDX
2 (..R)	2	0.2	1.7	14	0-15	13
2 RS	2	0.02	1.7	13.6	15	13
3 (..R)	3	0.2	2.4	14	0-15	13
3 RS	3	0.02	2.4	13.6	6-15	13
4	4	0.3	3	14	-	13
5	5	0.3	4	17.5	-	17

Insert	Designation	Insert seat size	Feed (mm/rev)	Coated		
				TT9080	TT7220	TT8020
	RDJ 2	2	0.05-0.18	●	●	●
	2-6R new	2	0.03-0.08	●	●	●
	2-15R new	2	0.03-0.08	●	●	●
	2-15RS new	2	0.03-0.07	●	●	●
	3	3	0.07-0.25	●	●	●
	3-6R new	3	0.03-0.12	●	●	●
	3-6RS new	3	0.03-0.10	●	●	●
	3-15R new	3	0.03-0.12	●	●	●
	3-15RS new	3	0.03-0.10	●	●	●
	4	4	0.08-0.30	●	●	●
5	5	0.09-0.35	●	●	●	

● : Standard items

Recommended Cutting Conditions

ISO	Material	Condition	Tensile strength (N/mm ²)	Hardness HB	Material No.	Cutting speed Vc(m/min)		
						TT9080	TT8020 TT7220	
P	Non-alloy steel, cast steel, free cutting steel	<0.25%C	Annealed	420	125	1	140-250	80-120
		>=0.25%C	Annealed	650	190	2	130-220	80-110
		<0.55%C	Quenched and tempered	850	250	3	90-200	70-90
		>=0.55%C	Annealed	750	220	4	100-220	70-100
			Quenched and tempered	1000	300	5	70-170	40-70
	Low alloy steel and cast steel (less than 5% of alloying elements)	Annealed		600	200	6	90-120	70-100
				930	275	7	80-170	50-70
		Quenched and tempered		1000	300	8	70-130	40-60
				1200	350	9	50-120	30-50
	High alloy steel, cast steel and tool steel	Annealed		680	200	10	60-140	50-80
Quenched and tempered			1100	325	11	50-70	30-60	
M	Stainless steel and cast steel	Ferritic / martensitic		680	200	12	70-170	80-120
		Martensitic		820	240	13	60-150	60-90
		Austenitic		600	180	14	90-180	60-90
K	Gray cast iron (GG)	Ferritic			160	15	100-230	
		Pearlitic			250	16	90-180	
	Cast iron nodular (GGG)	Ferritic			180	17	190-300	
		Pearlitic			260	18	120-220	
	Malleable cast iron	Ferritic			130	19	120-250	
Pearlitic				230	20	100-210		
S	High temp. alloys	Fe based	Annealed			200	31	40-70
			Cured			280	32	30-50
		Ni or Co based	Annealed			250	33	30-40
			Cured			350	34	15-25
	Titanium, Ti alloys			Rm 400			36	90-190
			Alpha+beta alloys cured	Rm 1050			37	30-60

■ Steel
 ■ Stainless steel
 ■ Cast iron
 ■ High temp. alloys