



For more information

Grooving and parting-off tool

TUNGCUT

Tungaloy Report No. 391S10-G

New **DTV** profile turning inserts
with **35° nose angle**

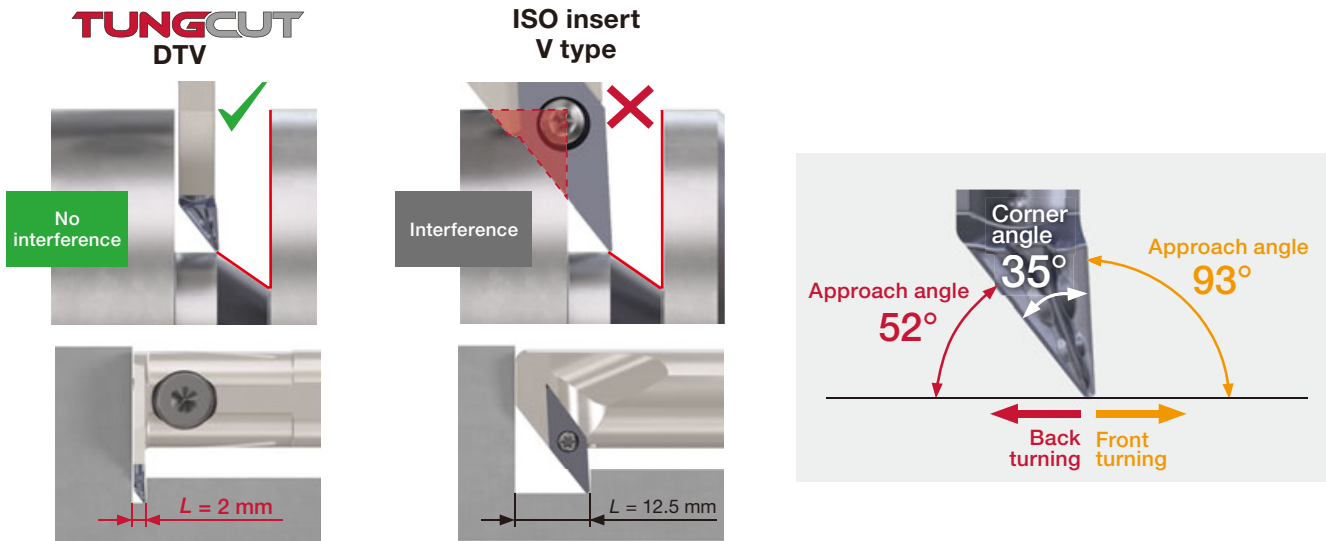


New TungCut DTV profiling insert with a 35° nose angle

Features

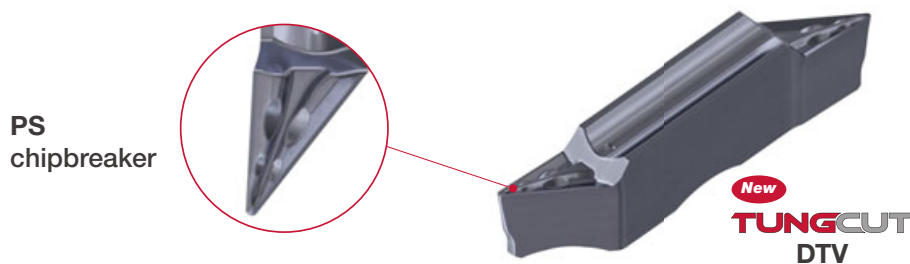
1 Produces various profiles

- Offered in the shape of a grooving insert, the new insert allows complex profiling without tool interference, which is not possible with conventional ISO turning inserts.



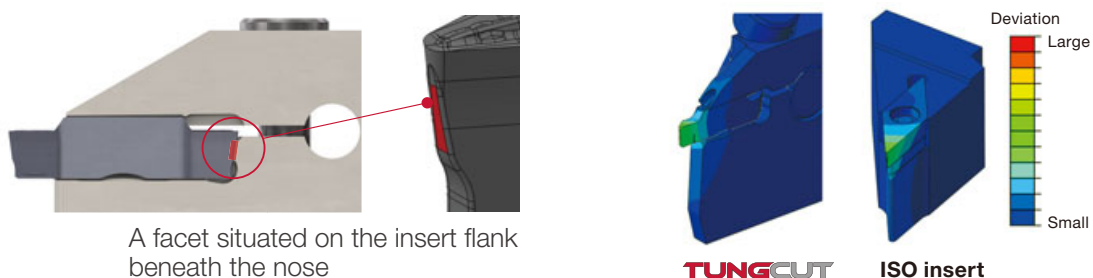
2 Excellent chip control

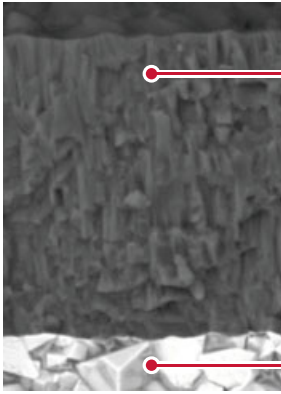
- PS chipbreaker provides superior chip control in finishing operation.
- Consistent chip forming during profiling operation in which the insert moves in multiple directions.



3 Strong insert clamping for part accuracy

- Strong and secure insert clamping method with unique interface provides high cutting edge accuracy superior to ISO turning tools.





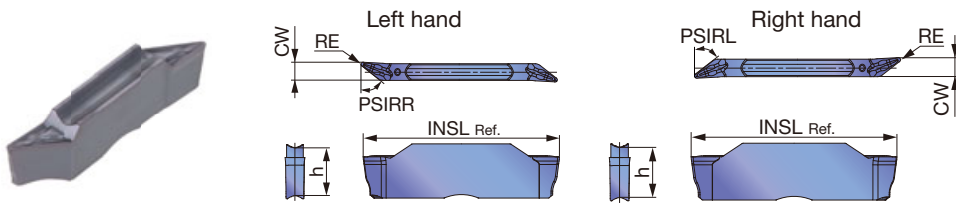
AH7025 uses the latest coating technology of a nano-scale multi-layered AlTiN PVD coating with high Al content, featuring

- Coating hardness increased by 20%
- A multi-layered coating structure impedes micro-crack propagation, reducing insert failures
- Enhanced adhesion strength between the coating and carbide substrate layer

High wear and fracture resistant carbide substrate for optimal grooving performance

INSERTS

DTV



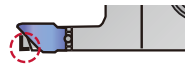
P	Steel	★									
M	Stainless	★									
K	Cast iron	★									
N	Non-ferrous										
S	Superalloys	★									
H	Hard materials										

★ : First choice

Designation	R/L	Seat size	CW±0.05	RE	Coated								INSL	h	PSIRR	PSIRL
					AH7025											
DTV2-020-35L-PS	L	2	1.85	0.2	●								20	5	52°	0°
DTV2-020-35R-PS	R	2	1.85	0.2	●								20	5	0°	52°
DTV5-020-35L-PS	L	5	4.5	0.2	●								25	5.5	52°	0°
DTV5-020-35R-PS	R	5	4.5	0.2	●								25	5.5	0°	52°
DTV5-040-35L-PS	L	5	4.5	0.4	●								25	5.5	52°	0°
DTV5-040-35R-PS	R	5	4.5	0.4	●								25	5.5	0°	52°

Recommended toolholder: CAEFR/L or CTEFR/L

Note: For toolholders other than the above, the insert support may require modification to avoid tool collision.

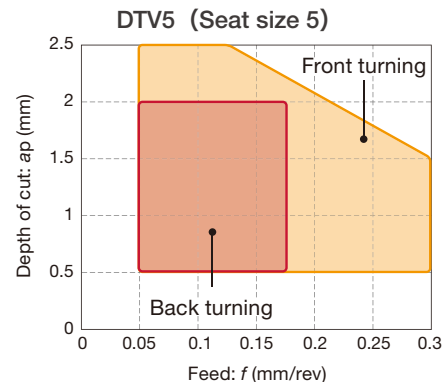
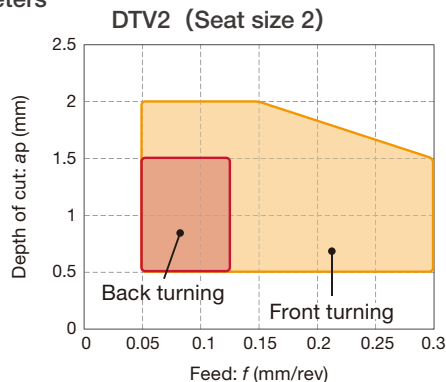
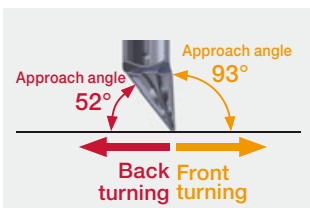


● : New

For Internal grooving

Insert	Seat size	Min. diameter DMIN
DTV	2	25
DTV	5	40

Recommended cutting parameters



STANDARD CUTTING CONDITIONS

ISO	Workpiece materials	Grade	Cutting speed Vc (m/min)	Feed f (mm/rev)
P	Low carbon steels S15C, SS400, etc. C15E4, E275A, etc.	AH7025	50 - 180	0.05 - 0.3
	Carbon steels, Alloy steels S55C, SCM440, etc. C55, 42CrMo4, etc.	AH7025	50 - 180	0.05 - 0.3
	Free cutting steels SUH22, SUH23, etc.	AH7025	50 - 180	0.05 - 0.3
M	Stainless steels SUS304, X5CrNi18-9, etc.	AH7025	50 - 120	0.05 - 0.3
K	Grey cast iron FC250, etc. 250, etc.	AH7025	50 - 180	0.05 - 0.3
	Ductile cast iron FCD450, etc. 450-10S, etc.	AH7025	50 - 120	0.05 - 0.3
S	Titanium alloys Ti-6Al-4V, etc.	AH7025	20 - 80	0.05 - 0.3
	Superalloys Inconel718, etc.	AH7025	20 - 80	0.05 - 0.3



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