

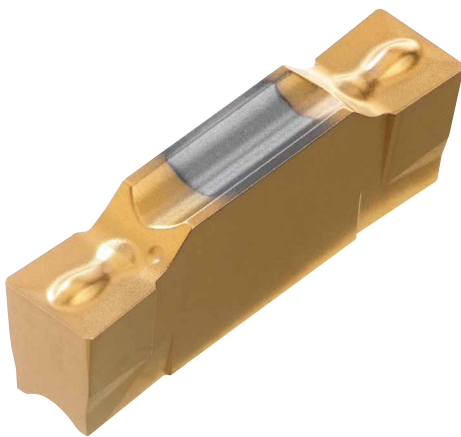
NPN

New Product News



RHINO GROOVE

RDT Inserts and Reinforced Holders



KEY POINT

RDT inserts and reinforced holders have been added to the RHINO-GROOVE family.

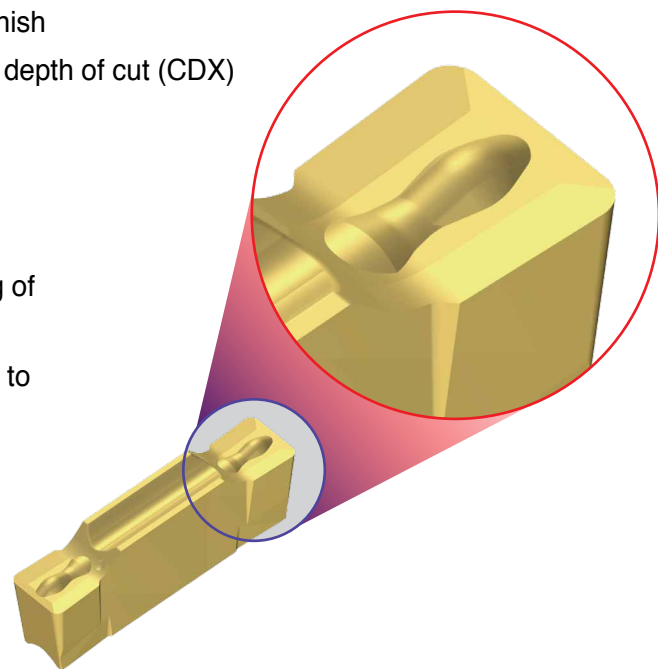
TaeguTec has added **RDT** inserts and reinforced holders to the RHINO-GROOVE family. The **RDT** inserts with a T-type chip breaker are ideal for turning and grooving. The reinforced holders feature a shorter depth of cut (CDX) in order to reduce vibration and improve machinability.

Features

- Precision T-type chip breaker inserts are ideal for turning and grooving
- High precision external turning and grooving with G tolerance insert
- Available in various widths and corner radii upon request
- Insert's cutting edge for flat workpiece bottom machining
- Cermet grade CT3000 available for good surface finish
- Higher rigidity holders for shallow grooving: shorter depth of cut (CDX)
- Stable tool life

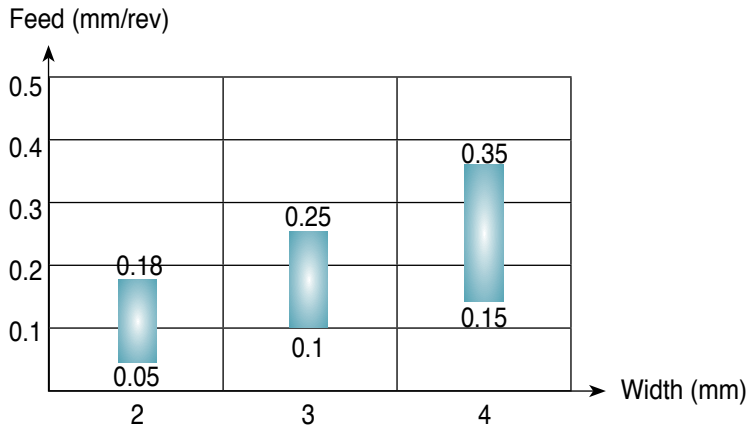
RDT insert features

- T-type chip breaker is ideal for grooving and turning of steel, stainless steel and especially cast iron
- Good chip control in multidirectional machining due to the insert's unique chip breaker

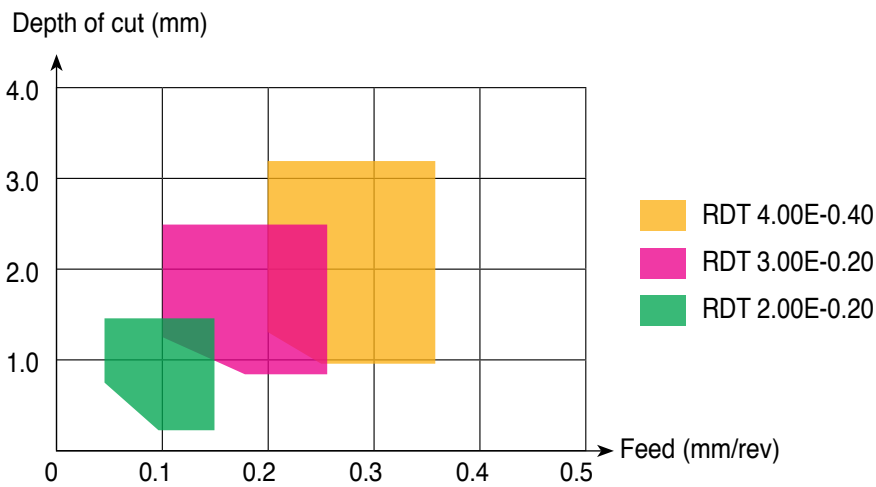


Cutting conditions

■ Grooving

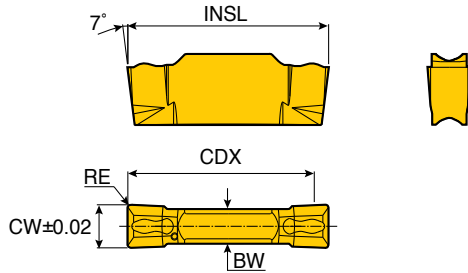


■ Turning



RDT new

Double-ended precision inserts for shallow grooving and turning with T-type chip breaker



Size	Dimension (mm)				
	CW	RE	BW	INSL	CDX
2	2.00	0.10-1.00	1.7	14.0	13
3	3.00	0.20-1.50	2.4	14.0	13
4	4.00	0.40-2.00	3.0	14.0	13

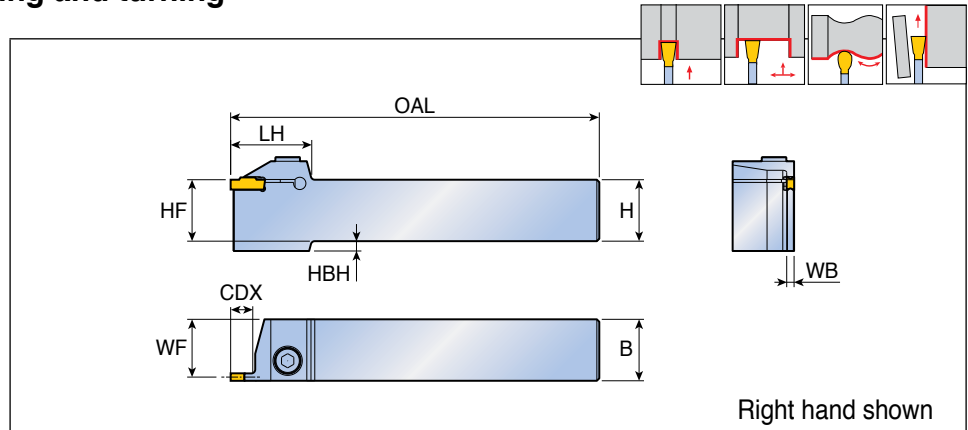
Insert	Designation	Insert seat size	Turning		Grooving	Coated	
			ap (mm)	Feed (mm/rev)	Feed (mm/rev)	CT3000	TT9080
	RDT 2.00E-0.10	2	0.2-1.4	0.12-0.18	0.03-0.13	●	●
	2.00E-0.20	2	0.3-1.4	0.12-0.18	0.03-0.13		●
	2.00E-1.00*	2	0.0-1.0	0.10-0.25	0.05-0.15		●
	3.00E-0.20	3	0.3-2.0	0.12-0.20	0.07-0.13	●	●
	3.00E-0.40	3	0.5-2.0	0.15-0.22	0.07-0.15		●
	3.00E-1.50*	3	0.0-1.5	0.15-0.28	0.08-0.18		●
	4.00E-0.40	4	0.5-2.4	0.18-0.30	0.09-0.18	●	●
	4.00E-0.80	4	1.0-2.4	0.18-0.30	0.09-0.18		●
	4.00E-2.00*	4	0.0-2.0	0.18-0.35	0.10-0.20		●

*: Full radius insert

●: Standard items



RGER/L

Holders for external grooving and turning



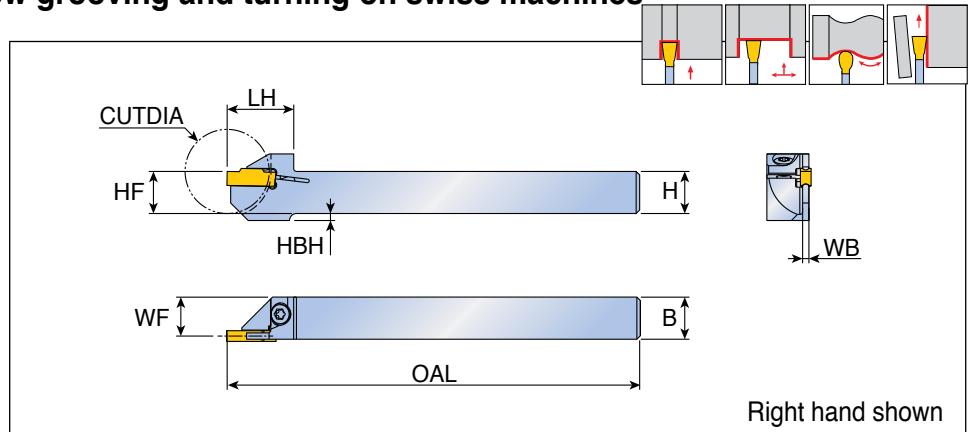
Designation	Insert seat size	Dimensions (mm)								Torque (N.m)	Insert
		H(HF)	B	OAL	WF	LH	WB	HBH	CDX		
RGER/L 1616-2T09 <small>(new)</small>	2	16	16	110	15.1	33	1.8	4	9	8	RDC/J RSC/J RDT
1616-2T16	2	16	16	110	15.1	35	1.8	4	16	8	
2020-2T09 <small>(new)</small>	2	20	20	125	19.1	33	1.8	-	9	8	
2020-2T16	2	20	20	125	19.1	35	1.8	-	16	8	
2525-2T09 <small>(new)</small>	2	25	25	150	24.1	33	1.8	-	9	8	
2525-2T16	2	25	25	150	24.1	35	1.8	-	16	8	
1616-3T09 <small>(new)</small>	3	16	16	110	14.8	33	2.4	4	9	8	
1616-3T16	3	16	16	110	14.8	35	2.4	4	16	8	
2020-3T09 <small>(new)</small>	3	20	20	125	18.8	33	2.4	-	9	8	
2020-3T16	3	20	20	125	18.8	35	2.4	-	16	8	
2525-3T09 <small>(new)</small>	3	25	25	150	23.8	33	2.4	-	9	8	
2525-3T16	3	25	25	150	23.8	35	2.4	-	16	8	
1616-4T10 <small>(new)</small>	4	16	16	110	14.5	33	3	4	10	8	
2020-4T10 <small>(new)</small>	4	20	20	125	18.5	33	3	-	10	8	
2020-4T16	4	20	20	125	18.5	35	3	-	16	8	
2525-4T10 <small>(new)</small>	4	25	25	150	23.5	33	3	-	10	8	
2525-4T16	4	25	25	150	23.5	35	3	-	16	8	
2020-5T12 <small>(new)</small>	5	20	20	125	18.1	37	3.9	-	12	8	
2020-5T20	5	20	20	125	18.1	37	3.9	-	20	8	
2525-5T12 <small>(new)</small>	5	25	25	150	23.1	37	3.9	-	12	8	
2525-5T20	5	25	25	150	23.1	37	3.9	-	20	8	

Spare parts

Designation	Screw	Wrench		
				
RGER/L 16/20	SH M6x1x20	L-W 5		
RGER/L 25	SH M6x1x25	L-W 5		

RGER/L-SH

HOLDERS FOR EXTERNAL SHALLOW GROOVING AND TURNING ON SWISS MACHINES



Designation	Insert seat size	Dimensions (mm)								Torque (N.m)	Insert
		H(HF)	B	OAL	WF	LH	WB	HBH	CUTDIA		
RGER/L 10-20-2SH <small>(new)</small>	2	10	10	125	9.1	19	1.8	2	20	2.0	RDC/J RSC/J RDT
12-24-2SH	2	12	12	125	11.1	19	1.8	2	24	2.0	
16-24-2SH	2	16	16	125	15.1	24	1.8	-	24	2.0	
12-24-3SH	3	12	12	125	10.8	19	2.4	2	24	2.0	
14-24-3SH	3	14	14	125	12.8	19	2.4	-	24	2.0	
16-24-3SH	3	16	16	125	14.8	19	2.4	-	24	2.0	

Spare parts

Designation	Screw	Wrench		
	RGER/L-SH	TS 40A115I	T 15	

Recommended Cutting Conditions

Grooving and Turning

ISO	Material	Condition	Tensile strength (N/mm ²)	Hardness HB	Material No.	Cutting speed Vc(m/min)		
						CT3000	TT9080	
P	Non-alloy steel, cast steel, free cutting steel	<0.25%C	Annealed	420	125	1	100-200	100-180
		>=0.25%C	Annealed	650	190	2	80-180	80-160
		<0.55%C	Quenched and tempered	850	250	3	80-180	80-160
		>=0.55%C	Annealed	750	220	4	70-150	70-130
			Quenched and tempered	1000	300	5	100-180	100-160
	Low alloy steel and cast steel (less than 5% of alloying elements)	Annealed	600	200	6	90-180	80-160	
		Quenched and tempered	930	275	7	80-170	80-150	
			1000	300	8	80-150	80-130	
			1200	350	9	90-130	90-130	
	High alloy steel, cast steel and tool steel	Annealed	680	200	10	50-80	50-80	
Quenched and tempered		1100	325	11	80-170	80-170		
M	Stainless steel and cast steel	Ferritic / martensitic	680	200	12	80-150	80-150	
		Martensitic	820	240	13	80-170	80-170	
		Austenitic	600	180	14			
S	High temp. alloys	Fe based	Annealed		200	31		20-40
			Cured		280	32		20-30
		Ni or Co based	Annealed		250	33		15-20
			Cured		350	34		15-20
			Cast		320	35		130-170
			Titanium, Ti alloys		Rm 400		36	
	Alpha+beta alloys cured	Rm 1050		37				

■ Steel
 ■ Stainless steel
 ■ High temp. alloys