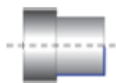


APPLICATION

Longitudinal

Profiling



GEOMETRY



**D**

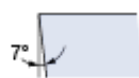
**C**

**M**

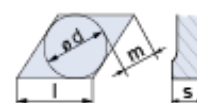
**T**



Shape



Clearance Angle



Tolerance  
 $d \pm 0.05$   
 $m \pm 0.08$   
 $s \pm 0.13$



Fixing  
Chip breaker

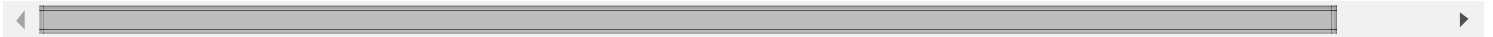
Product designation	Catalog Nr.	l	s	r	Tool Holders	Cutting Data			
DCMT 070204 NN LT 10	T0000064	7.00	2.38	0.4					
DCMT 11T304 NN LT 10	T0000065	11.00	3.97	0.4					
DCMT 11T308 NN LT 10	T0000721	11.00	3.97	0.8					
NN All purpose Chipbreaker	55° Diamond shape inserts, suitable for Internal Turning due to a unique chip removal geometry	Generates low cutting forces, most suitable for small work-pieces							

Application Guide	Finishing	Medium	Roughing / Interrupted cut
DCMT 070204 NN LT 10			

DCMT 11T304 NN LT 10			
DCMT 11T308 NN LT 10			

<p>Finishing: d.o.c. = 0.30 - 1.50 mm fn = 0.08 - 0.20 mm/rev</p>	<p>Medium: d.o.c. = 0.70 - 4.50 mm fn = 0.15 - 0.45 mm/rev</p>	<p>Roughing: d.o.c. = 3.00 - 7.00 mm fn = 0.35 - 0.70 mm/rev</p>	<p> Good  Acceptable  Not Recommended</p>
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