



Features:

- More economical than .500" I.C. DNMG inserts
- High positive geometry for reduced axial & radial forces
- Ideal for long, slender work pieces

Nose Radii:

- .016"
- .031"

Grades:

- TT8115
- TT8125
- TT9225
- TT5100
- TT9080



Four Cutting Edge DNUX Insert with Low Cutting Force

Ingersoll has launched a new "DNUX" series of inserts for the T-Tank product line that significantly reduce cutting forces that occur during machining.

The DNUX inserts feature a high positive rake and inclination angle at the cutting edge that minimizes radial and axial cutting forces that often cause vibration during machining, particularly in long, slender work pieces and in applications where a tail stock or steady rest is not utilized. The result is a more consistent surface finish and tool life compared to ISO-DNMG style inserts.

Compared to ISO-KNUX style inserts which have similar geometry, the DNUX inserts provide an advantage by offering four cutting edges compared to two.

These inserts are fully compatible with our existing T-Tank holders for DNMG inserts. Dimensions and details for these holders are located in our Fine Gold catalog.



FEATURES

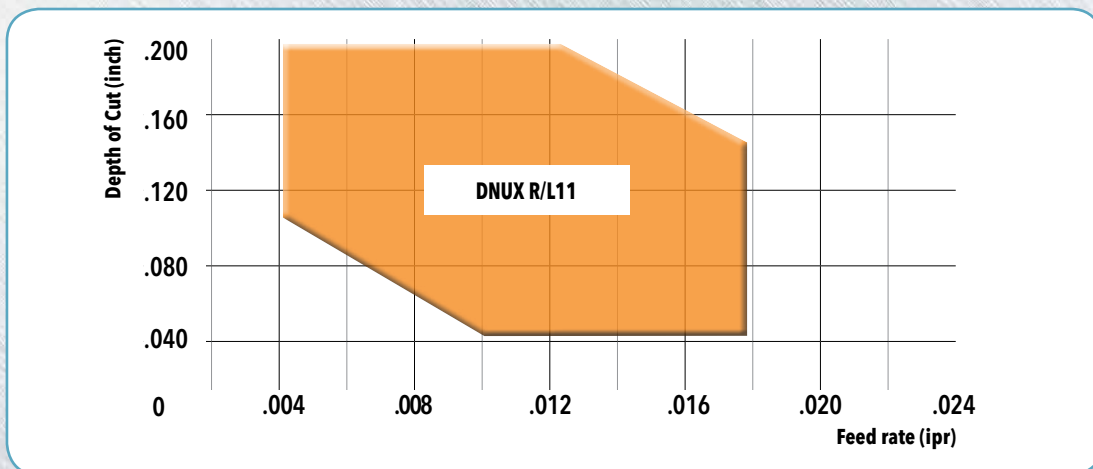
- 4 cutting edges for productivity and economy
- For medium light to medium applications
- Steel and stainless steel machining
- Decreased cutting forces due to high positive rake angle geometry
- Suitable for machining slender bars and thin-wall components

CHIPBREAKER GEOMETRY

T•TANK DNUX R/L11 chip breaker & cutting condition

	Insert	Edge geometry
DNUX R/L11		

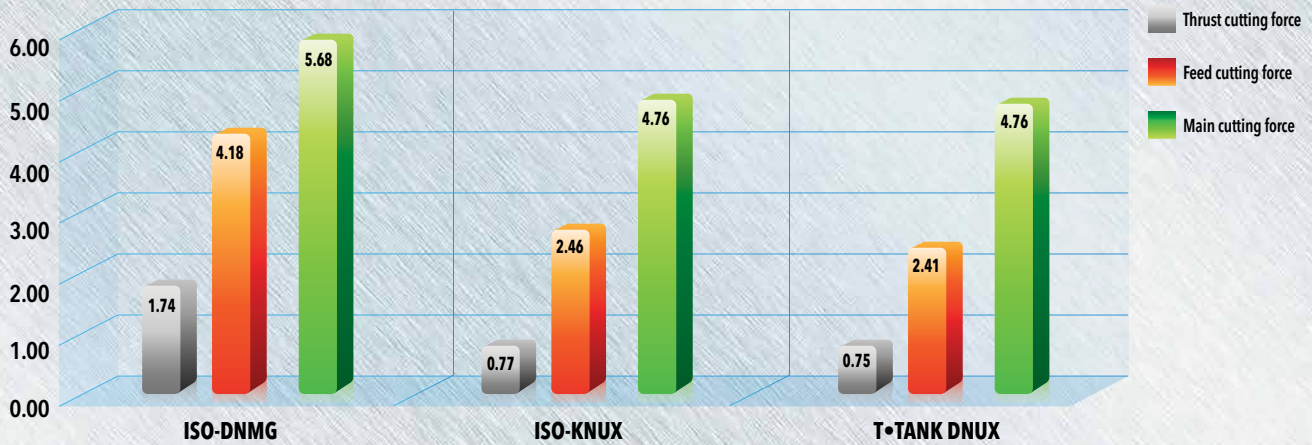
CHIPBREAKER RANGE



- Insert : DNUX 3.53.51 R11
- Cutting speed (V) : 650 sfm
- Material : 0.45% carbon steel (HB200~230)

■ COMPARISON OF CUTTING FORCE

Workpiece	Vc	f	Cutting depth	Coolant	Remark
0.45% Carbon steel (Ø.750")	650 sfm	.012 ipr	.120"	Dry	External continuous

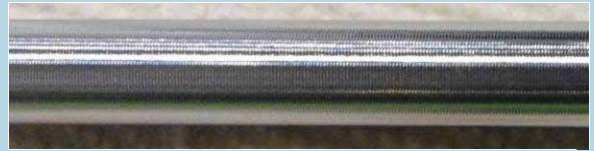


■ SURFACE ROUGHNESS

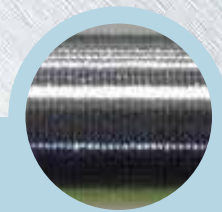
ISO-DNMG



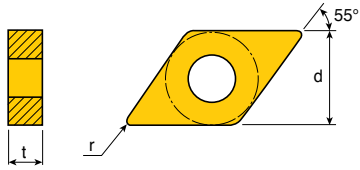
ISO-KNUX




T•TANK DNUX



■ DNUX Negative 55° rhombic inserts



Size	Dimension (inch)		
	d	t	r
3.5	0.437	0.219	0.016-0.031

Insert	Designation	feed (mm/rev)	ap (mm)	CVD Coated				PVD Coated
				TT8115	TT8125	TT9225	TT5100	TT9080
 Right Hand Shown	DNUX 3.53.51 R11	.006 - .014	.060 - .200	●	●	●	●	●
	DNUX 3.53.51 L11	.006 - .014	.060 - .200	●	●	●	●	●
	DNUX 3.53.52 R11	.008 - .018	.080 - .200	●	●	●	●	●
	DNUX 3.53.52 L11	.008 - .018	.080 - .200	●	●	●	●	●

- : Standard items
- External holder : L-hand insert for L-Hand toolholder, R-hand insert for R-hand toolholder
- Internal holder : L-hand insert for R-Hand toolholder, R-hand insert for L-hand toolholder