NPA

EXPANSION

Member IMC Group Ingersoll Cutting Tools

New Product Announcement

TURNING

TMODULAR™

Square Shanks (External)
Inch: .75, 1.00, 1.25, 1.50"
Metric: 20, 25, 32, 40 mm

Round Bars (Internal)
Inch: Ø .625-2.500"
Metric: Ø 16-60 mm

C-Adapter Bar Sizes
C4, C5, C6

C-Adapter Bar Diameters
16, 20, 25, 32, 40 mm

C-Adapter Bar Lengths
Steel: 2.5xD, 3xD, 4xD
Carbide Core: 5xD

Head/Insert Styles
Positive:
» CCMT 21.5/32.5/43
» DCMT 21.5/32.5
NEW » **TCMT 21.5/32.5**
» VBMT 22/33

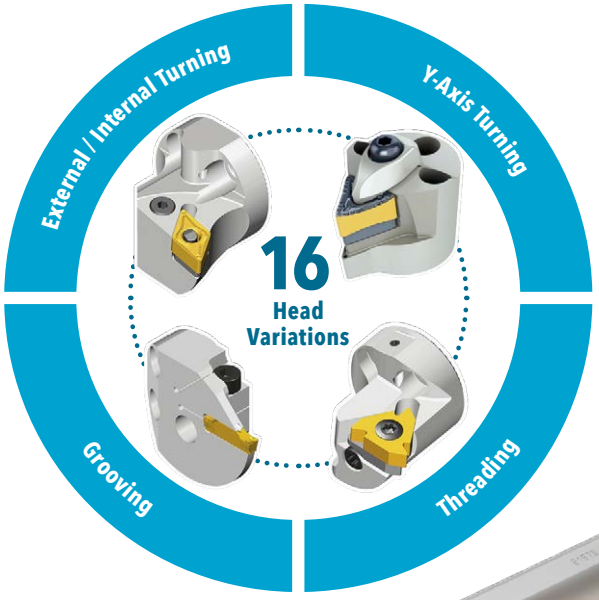
Negative:
NEW » **CNMG 43**
» CNMX 2.22
» CNMX 43.5
NEW » **DNMG 43**
» DNMG 3.53.5
» DNMX 2.22
» VNMX 2.53
» WNMX 2.22

Y-Axis Turning:
» **TNMV**
NEW » **ZNMV-BF**

ID Grooving:
» **TClamp Ultra+ 2-6 mm**

ID Threading:
» 16IR/L, 22IR/L

Heads (All)
With or without CoolBurst
(high pressure thru coolant)



External and Internal Modular Shanks for Various Turning Applications

» Modular system with excellent stability.
» Featuring 7 new head styles including Y-axis heads for mill-turn applications.
» New 4xD round shank bars.
» New square shank holders.
» New C-Adapter shank holders.



Round Bar | Square Shank | C-Adapter



Compatible with TABSORBER™ anti-vibration bars

WINSFEED™ ADVANCED MACHINING

ingersoll-imc.com

See it in action! »

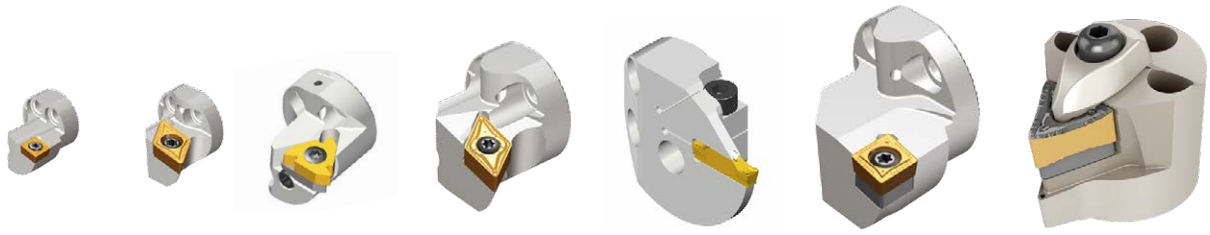
Line of Modular Shanks With Changeable Heads for Various Turning Operations

Ingersoll has introduced a new modular-type-head for changeable holders that is compatible with both external and internal turning applications. The line is available in three modular types: round bar for internal machining, square shank for external machining, and a C-adapter for internal, external and Y-axis machining. Additionally, the current **TModular** head can be mounted to **TModular** shanks, thereby widening the range of applications even further.

The **TModular's** Y-axis turning head provides excellent machining stability and a dramatic productivity increase. The new Y-axis head also demonstrates high performance machining due to its compatibility with Ingersoll's TNMV and ZNMV insert lines.

Head Changeable TModular Shanks

ROUND BAR	SQUARE SHANK	C-ADAPTER
		
NEW TMODULAR™ DTA	NEW TMODULAR™ DTA	NEW TMODULAR™ C...DTA



DTA Round Bar Features

- Round type modular shank for internal turning.
- Compatible with TModular heads.
- Available shank sizes: Ø .625, .750, 1.00, 1.25, 1.50, 2.00, 2.50";
  Ø 16, 20, 25, 32, 40, 50, 60 mm
- One holder for both right and left handed machining.

DTA-D1.00-4D-A

1 2 3 4

1. TModular connection
2. Round shank sizes:
   - Inch - Ø .625, .75, 1.00, 1.25, 1.50, 2.00, 2.50"
   - Metric - Ø 16, 20, 25, 32, 40, 50, 60 mm
3. Shank lengths:
   4xD, 7xD, 10xD, 12xD, 14xD
4. Shank material and coolant hole:
   A: steel; internal supply type
   C: steel; internal supply type, absorber
   E: carbide; internal supply type, absorber

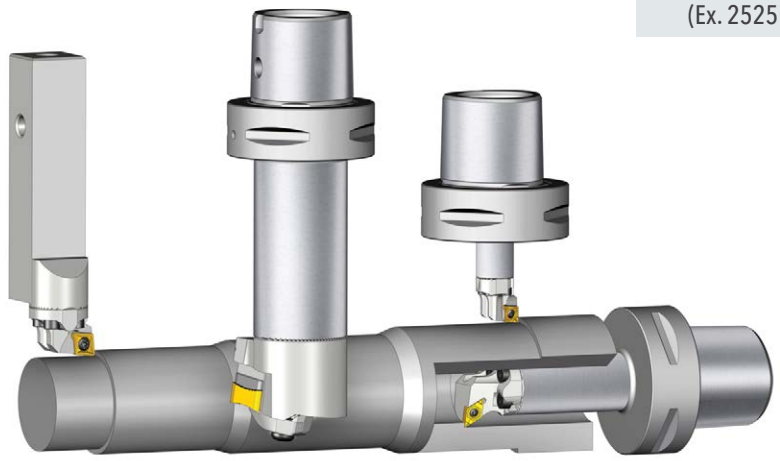
DTA Square Shank Features

- Square type modular shank for external turning.
- Compatible with TModular heads.
- Available shank sizes: Ø .75, 1.00, 1.25, 1.50";
  Ø 20x20, 25x25, 32x32, 40x40 mm.
- One holder for both right and left handed machining.

DTA-16N-D25-TB

1 2 3 4 5

1. TModular connection
2. Square shank sizes:
   - Inch - 1/16" increments (Ex. 16N = 16/16 or 1.00")
   - Metric - Height X width (Ex. 2525N = 25 X 25 mm)
3. Hand type (N: neutral)
4. Head connection sizes:
   Ø 20, 25, 32, 40, mm
5. CoolBurst
   (high pressure thru coolant)



C...DTA C-Adapter Bar Features

- C-ADAPTER type modular shank for external, internal and Y-axis turning.
- Compatible with existing TModular heads and the new Y-axis turning heads.
- Available shank diameter sizes: Ø 16, 20, 25, 32, 40 mm.
- One holder for both right and left handed machining.

C6-DTA-25E-5D

1 2 3 4 5

1. C-Adapter size
2. TModular connection
3. C-Adapter shank sizes: Ø 16, 20, 25, 32, 40 mm
4. Shank material types: A: Steel; E: Carbide core C: steel; absorber
5. Tool lengths: 2.5xBD, 3xBD, 4xBD, 5xBD

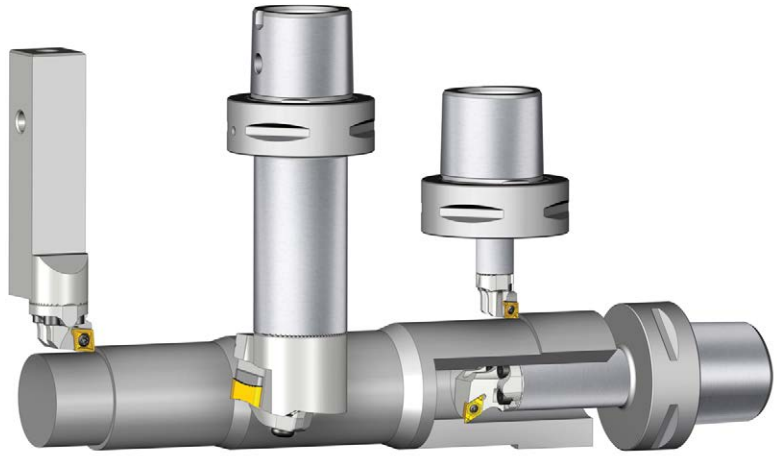
DTC Head Features

- A variety of types for internal, external, grooving, and threading operations.
- Compatible with TModular shanks.
- Available head sizes: Ø 16, 20, 25, 32, 40 mm.
- Right and left hand options available.

DTC-D25-SCLCR-09

1 2 3 4

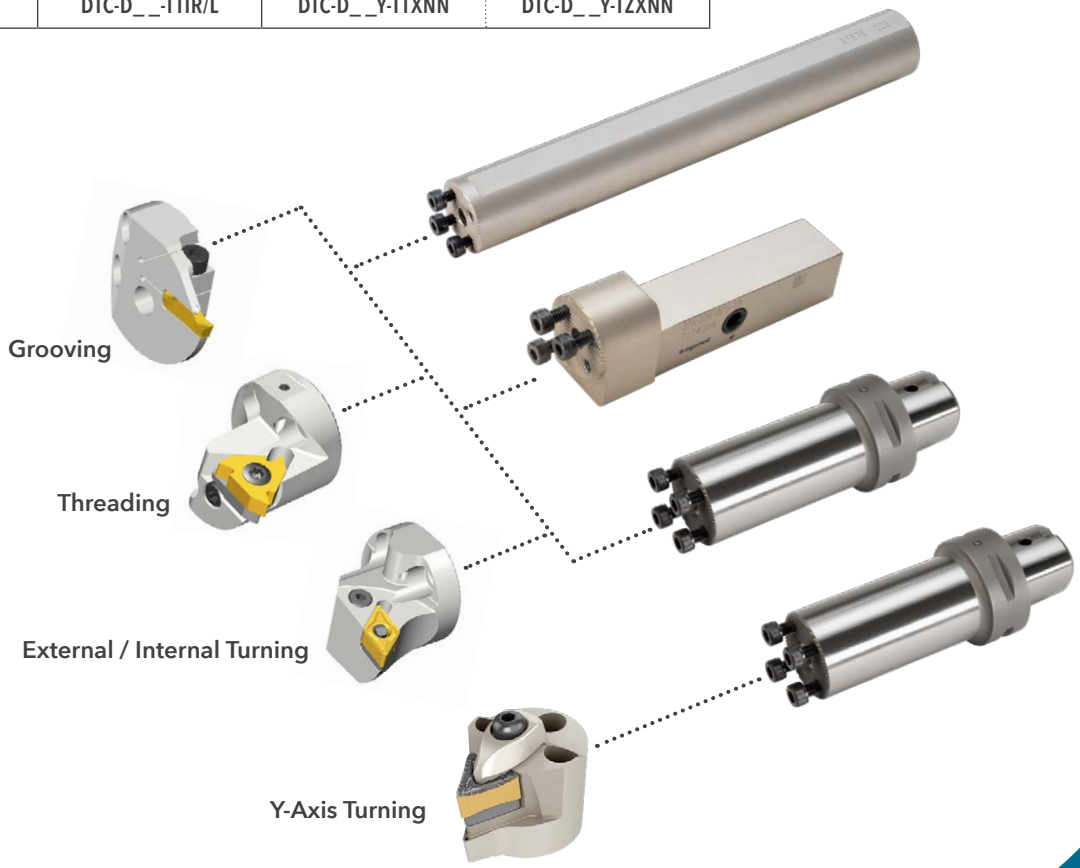
1. TModular head
2. Head connection sizes: Ø 16, 20, 25, 32, 40 mm
3. Head type (same as standard boring bars)
4. Insert IC size (ISO)



Heads by Application

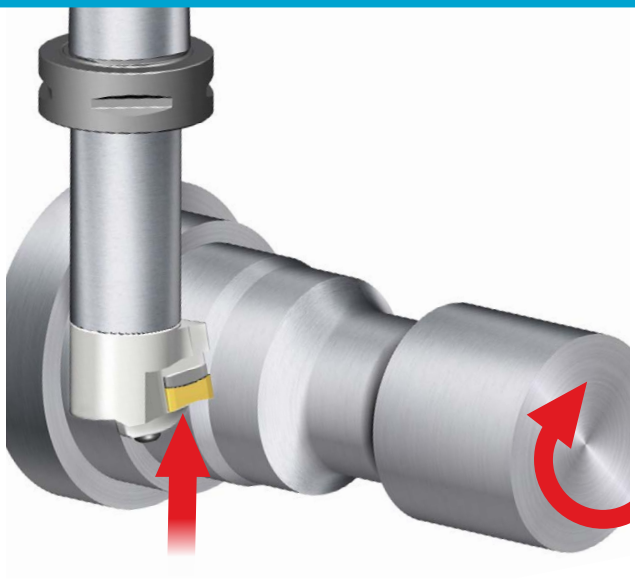
For external and internal turning					
 DTC-D_ _-HCLNR/L	 DTC-D_ _-HDUNR/L	 DTC-D_ _-HVUNR/L	 DTC-D_ _-SCLCR/L	 DTC-D_ _-SCLNR/L	 DTC-D_ _-SDUCR/L
 DTC-D_ _-SDUNR/L	NEW  DTC-D_ _-STFCR/L	 DTC-D_ _-SVUBR/L	 DTC-D_ _-SWLNR/L	NEW  DTC-D_ _-TCLNR/L	NEW  DTC-D_ _-TDUNR/L

For threading	For grooving	NEW For Y-axis turning	
 DTC-D_ _-SIR/L	NEW  DTC-D_ _-TTIR/L	 DTC-D_ _Y-TTXNN	 DTC-D_ _Y-TZXNN



DTC-D_ _Y Head Features

- Y-axis turning heads
  - High rigidity head design enables excellent machining stability.

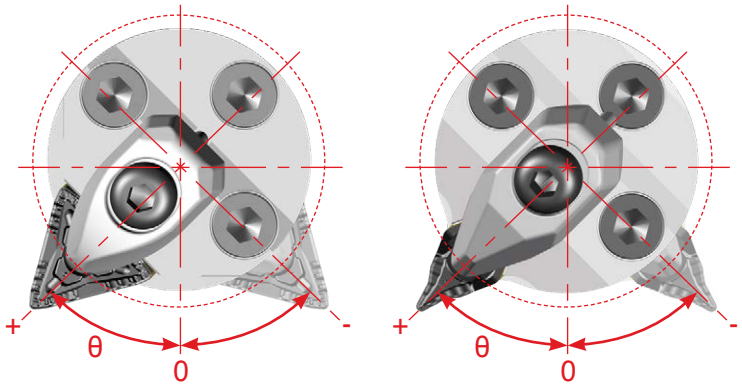
GENERAL TURNING	Y-AXIS TURNING
	
Perpendicular cutting force to the holder: **vibration**	Parallel cutting force to the holder: **stable machining**

- Excellent chip evacuation design minimizes workpiece damage by chips. Y-axis turning means chips fall to the ground thus avoiding collision with the workpiece.

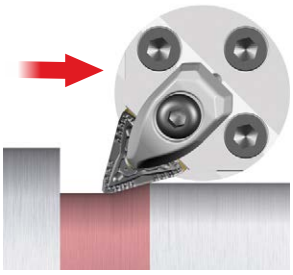
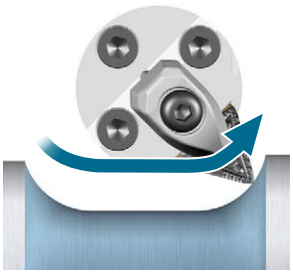
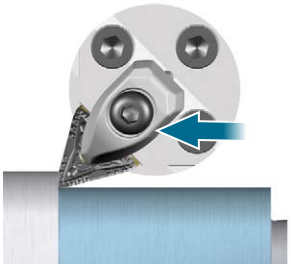
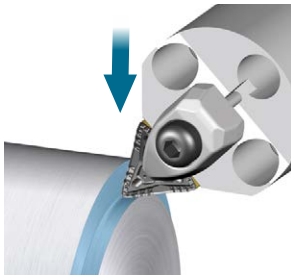
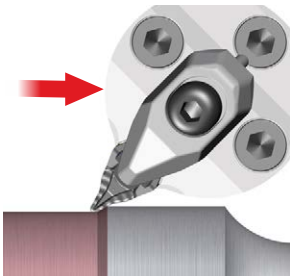
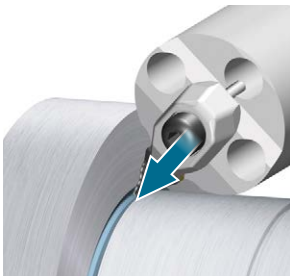
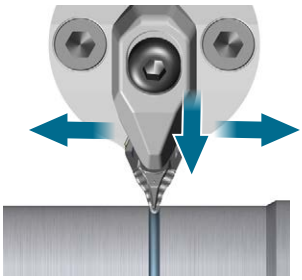
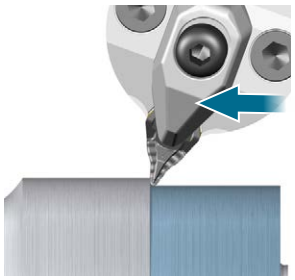


DTC-D_ _Y Head Features (continued)

- Compatible with the TNMV and ZNMV-BF high productivity insert lines.
- Maximize productivity by applying one tool to all turning applications.



Various Applications

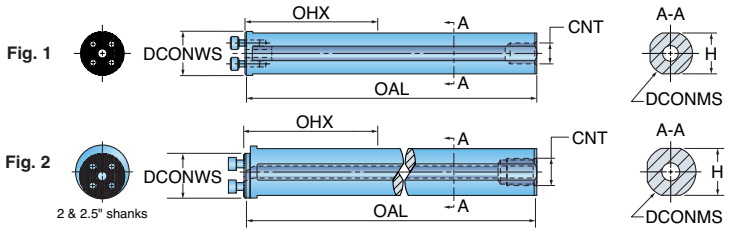
	Hi-feed backward turning θ = 45°	Profiling θ = 45~-45°	Forward turning θ = 45°	Forward facing θ = 45°
TNMV inserts and Y-TTXNN holder				
	Hi-feed backward turning θ = 45°	Undercutting θ = 45°	Grooving and turning θ = 0°	Forward turning θ = 20°
ZNMV inserts and Y-TZXNN holder				

Coolant

4xD • Series DTA-D__

MODULAR BARS





Part Number	DCONMS Connection Dia. Machine Side	DCONWS Connection Dia. Workpiece Side	OAL Overall Length	OHX Maximum Overhang	H Shank Height	CNT Coolant Entry Thread Size	Fig.	BMC* Body Material Code
INCH								
DTA-D.625-4D-A	.625	16.00 mm	4.21	1.70	.574	3/8-16 UNC-2B	1	Steel
DTA-D.750-4D-A	.750	20.00 mm	5.23	2.30	.677	3/8-24 UNF-2B	1	Steel
DTA-D1.00-4D-A	1.000	25.00 mm	7.20	3.10	.921	1/2-20 UNF-2B	1	Steel
DTA-D1.25-4D-A	1.250	32.00 mm	8.74	3.80	1.142	1/2-20 UNF-2B	1	Steel
DTA-D1.50-4D-A	1.500	40.00 mm	10.75	4.50	1.339	1/2-20 UNF-2B	1	Steel
DTA-D2.00-4D-A	2.000	40.00 mm	14.72	6.50	1.811	1/2-20 UNF-2B	2	Steel
DTA-D2.50-4D-A	2.500	40.00 mm	18.74	8.50	2.283	1/2-20 UNF-2B	2	Steel

Hardware

Part Number	Screw	Wrench	Seal
DTA-D.625-4D-A	SRM3X10DIN912	L-W2.5	PL062
DTA-D.750-4D-A	SRM3.5XL10-D5.5	L-W2.5	PL075
DTA-D1.00-4D-A	SRM4X12DIN912	L-W3	PL100
DTA-D1.25-4D-A	SRM5X12DIN912	L-W4	PL125
DTA-D1.50-4D-A	SRM6X16DIN912	L-W5	PL150
DTA-D2.00-4D-A	SRM6X16DIN912	L-W5	PL40
DTA-D2.50-4D-A	SRM6X16DIN912	L-W5	PL40

TABSORBER™ COMPATIBLE

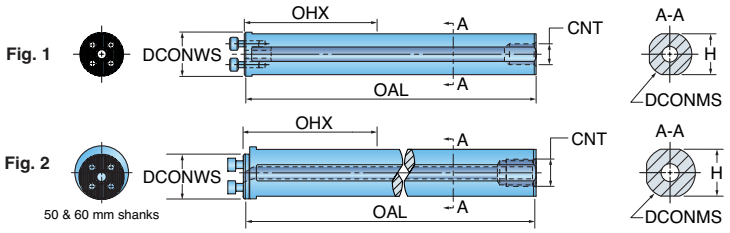
SCAN/CLICK/TAP to view longer anti-vibration bars:

Coolant

4xD • Series DTA-D__

MODULAR BARS





Part Number	DCONMS Connection Dia. Machine Side	DCONWS Connection Dia. Workpiece Side	OAL Overall Length	OHX Maximum Overhang	H Shank Height	CNT Coolant Entry Thread Size	Fig.	BMC* Body Material Code
METRIC								
DTA-D16-4D-A	16.00 mm	16.00 mm	105.0 mm	44.00 mm	15.00 mm	3/8-16 UNC-2B	1	Steel
DTA-D20-4D-A	20.00 mm	20.00 mm	140.0 mm	60.00 mm	18.00 mm	3/8-24 UNF-2B	1	Steel
DTA-D25-4D-A	25.00 mm	25.00 mm	200.0 mm	80.00 mm	23.00 mm	1/2-20 UNF-2B	1	Steel
DTA-D32-4D-A	32.00 mm	32.00 mm	218.0 mm	96.00 mm	29.00 mm	1/2-20 UNF-2B	1	Steel
DTA-D40-4D-A	40.00 mm	40.00 mm	283.0 mm	128.00 mm	36.00 mm	1/2-20 UNF-2B	1	Steel
DTA-D50-4D-A	50.00 mm	40.00 mm	368.0 mm	168.00 mm	46.00 mm	1/2-20 UNF-2B	2	Steel
DTA-D60-4D-A	60.00 mm	40.00 mm	468.0 mm	208.00 mm	57.00 mm	1/2-20 UNF-2B	2	Steel

Hardware

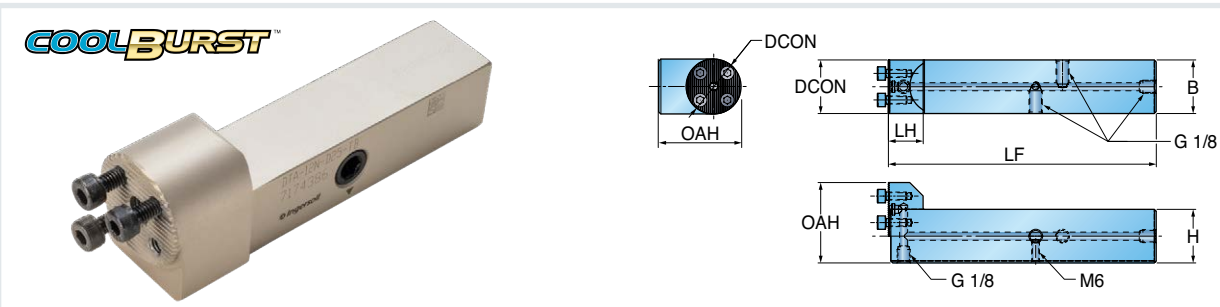
Part Number	Screw	Wrench	Seal
DTA-D16-4D-A	SRM3X10DIN912	L-W2.5	PL16
DTA-D20-4D-A	SRM3.5XL10-D5.5	L-W2.5	PL20
DTA-D25-4D-A	SRM4X12DIN912	L-W3	PL25
DTA-D32-4D-A	SRM5X12DIN912	L-W4	PL32
DTA-D40-4D-A	SRM6X16DIN912	L-W5	PL40
DTA-D50-4D-A	SRM6X16DIN912	L-W5	PL40
DTA-D60-4D-A	SRM6X16DIN912	L-W5	PL40

TABSORBER™ COMPATIBLE

SCAN/CLICK/TAP to view longer anti-vibration bars:

Series DTA-__N

MODULAR SQUARE SHANKS WITH HIGH PRESSURE COOLANT



Part Number	H Shank Height	B Shank Width	OAH Overall Height	LF Functional Length	LH Head Length	DCON Connection Diameter (mm)
INCH						
DTA-12N-D20-TB	.750	.750	1.146	3.622	.827	20 mm
DTA-12N-D25-TB	.750	.750	1.244	3.622	.827	25 mm
DTA-12N-D32-TB	.750	.750	1.382	3.622	.827	32 mm
DTA-16N-D25-TB	1.000	1.000	1.492	4.213	.827	25 mm
DTA-16N-D32-TB	1.000	1.000	1.630	4.213	.827	32 mm
DTA-16N-D40-TB	1.000	1.000	1.787	4.213	.827	40 mm
DTA-20N-D32-TB	1.250	1.250	1.882	5.984	.827	32 mm
DTA-20N-D40-TB	1.250	1.250	2.039	5.984	1.024	40 mm
DTA-24N-D40-TB	1.500	1.500	2.287	7.874	1.024	40 mm

Hardware

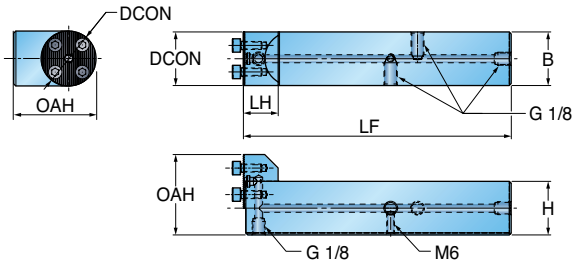
Part Number	Screw	Plug	Plug	Hex Driver
DTA-12N-D20-TB	SH M3.5X0.6X10	RSS M6	PLG G1/8-L6.5	L-W2.5
DTA-12N-D25-TB	SH M4X0.7X12	RSS M6	PLG G1/8-L6.5	L-W3
DTA-12N-D32-TB	SH M5X0.8X12	RSS M6	PLG G1/8-L6.5	L-W4
DTA-16N-D25-TB	SH M4X0.7X12	RSS M6	PLG G1/8-L6.5	L-W3
DTA-16N-D32-TB	SH M5X0.8X12	RSS M6	PLG G1/8-L6.5	L-W4
DTA-16N-D40-TB	SH M6X1X16	RSS M6	PLG G1/8-L6.5	L-W5
DTA-20N-D32-TB	SH M5X0.8X12	-	PLG G1/8-L6.5	L-W4
DTA-20N-D40-TB	SH M6X1X16	-	PLG G1/8-L6.5	L-W5
DTA-24N-D40-TB	SH M6X1X16	-	PLG G1/8-L6.5	L-W5

Coolant

Series DTA-__N

MODULAR SQUARE SHANKS WITH HIGH PRESSURE COOLANT





Part Number	H Shank Height	B Shank Width	OAH Overall Height	LF Functional Length	LH Head Length	DCON Connection Diameter
METRIC						
DTA-2020N-D20-TB	20 mm	20 mm	30.0 mm	92 mm	21 mm	20 mm
DTA-2020N-D25-TB	20 mm	20 mm	32.5 mm	92 mm	21 mm	25 mm
DTA-2020N-D32-TB	20 mm	20 mm	36.0 mm	92 mm	21 mm	32 mm
DTA-2525N-D25-TB	25 mm	25 mm	37.5 mm	107 mm	21 mm	25 mm
DTA-2525N-D32-TB	25 mm	25 mm	41.0 mm	107 mm	21 mm	32 mm
DTA-2525N-D40-TB	25 mm	25 mm	45.0 mm	107 mm	21 mm	40 mm
DTA-3232N-D32-TB	32 mm	32 mm	48.0 mm	152 mm	21 mm	32 mm
DTA-3232N-D40-TB	32 mm	32 mm	52.0 mm	152 mm	26 mm	40 mm
DTA-4040N-D40-TB	40 mm	40 mm	60.0 mm	200 mm	26 mm	40 mm

Hardware

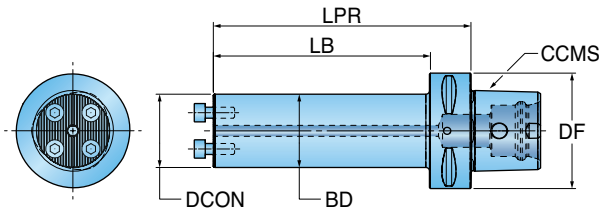
Part Number	Screw	Plug	Plug	Hex Driver
DTA-12N-D20-TB	SH M3.5X0.6X10	RSS M6	PLG G1/8-L6.5	L-W2.5
DTA-12N-D25-TB	SH M4X0.7X12	RSS M6	PLG G1/8-L6.5	L-W3
DTA-12N-D32-TB	SH M5X0.8X12	RSS M6	PLG G1/8-L6.5	L-W4
DTA-16N-D25-TB	SH M4X0.7X12	RSS M6	PLG G1/8-L6.5	L-W3
DTA-16N-D32-TB	SH M5X0.8X12	RSS M6	PLG G1/8-L6.5	L-W4
DTA-16N-D40-TB	SH M6X1X16	RSS M6	PLG G1/8-L6.5	L-W5
DTA-20N-D32-TB	SH M5X0.8X12	-	PLG G1/8-L6.5	L-W4
DTA-20N-D40-TB	SH M6X1X16	-	PLG G1/8-L6.5	L-W5
DTA-24N-D40-TB	SH M6X1X16	-	PLG G1/8-L6.5	L-W5

Coolant

Series C_-DTA

MODULAR C-ADAPTER BARS WITH HIGH PRESSURE COOLANT





Part Number	CCMS Connection Code Machine Side	DCON(1) Connection Diameter	LPR Protruding Length	LB Body Length	BD Body Diameter	DF Flange Diameter	BMC(2) Body Material Code
METRIC							
C4-DTA-16A-2.5D	C4	16 mm	40 mm	20 mm	16 mm	40 mm	S
C4-DTA-20A-2.5D	C4	20 mm	50 mm	30 mm	20 mm	40 mm	S
C4-DTA-25A-2.5D	C4	25 mm	55 mm	35 mm	25 mm	40 mm	S
C4-DTA-32A-2.5D	C4	32 mm	75 mm	55 mm	32 mm	40 mm	S
C4-DTA-40A-3D	C4	40 mm	80 mm	80 mm	40 mm	40 mm	S
C5-DTA-16A-2.5D	C5	16 mm	40 mm	20 mm	16 mm	50 mm	S
C5-DTA-20A-2.5D	C5	20 mm	50 mm	30 mm	20 mm	50 mm	S
C5-DTA-25A-2.5D	C5	25 mm	55 mm	35 mm	25 mm	50 mm	S
C5-DTA-32A-2.5D	C5	32 mm	75 mm	55 mm	32 mm	50 mm	S
C5-DTA-40A-3D	C5	40 mm	100 mm	80 mm	40 mm	50 mm	S
C6-DTA-16A-2.5D	C6	16 mm	40 mm	18 mm	16 mm	63 mm	S
C6-DTA-16E-5D	C6	16 mm	80 mm	58 mm	16 mm	63 mm	H
C6-DTA-20A-2.5D	C6	20 mm	50 mm	28 mm	20 mm	63 mm	S
C6-DTA-20E-5D	C6	20 mm	100 mm	27 mm	20 mm	63 mm	H
C6-DTA-25A-2.5D	C6	25 mm	65 mm	43 mm	25 mm	63 mm	S
C6-DTA-25E-5D	C6	25 mm	115 mm	93 mm	25 mm	63 mm	H
C6-DTA-32A-3D	C6	32 mm	90 mm	68 mm	32 mm	63 mm	S
C6-DTA-32A-4D	C6	32 mm	125 mm	103 mm	32 mm	63 mm	S
C6-DTA-32E-5D	C6	32 mm	150 mm	128 mm	32 mm	63 mm	H
C6-DTA-40A-3D	C6	40 mm	100 mm	78 mm	40 mm	63 mm	S
C6-DTA-40A-4D	C6	40 mm	140 mm	118 mm	40 mm	63 mm	S
C6-DTA-40E-5D	C6	40 mm	185 mm	163 mm	40 mm	63 mm	H

(1) DCON dimension of bar must match DCONMS dimension of head
(2) S = steel body, H = carbide core

Hardware

Part Number	 Screw	 Hex Driver
C_-DT16...	SHM3X0.5X10	L-W2.5
C_-DT20...	SHM3.5X0.6X10	L-W2.5
C_-DT25...	SHM4X0.7X12	L-W3
C_-DT32...	SHM5X0.8X12	L-W4
C_-DT40...	SHM6X1X16	L-W5

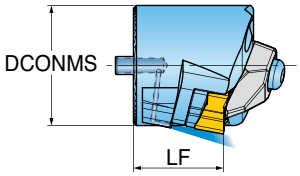
Coolant

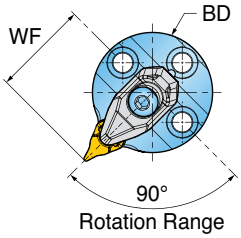
Series DTC-TZXNN-TB

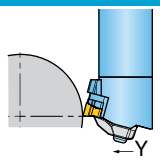
Y-AXIS TURNING HEADS (ZNMV_Y-BF INSERT) W/ HIGH PRESSURE COOLANT

COOLBURST







Approach Angle	Part Number	DCONMS Connection Dia. Machine Side	LF Functional Length	WF Functional Width	BD Body Diameter	Insert*
METRIC						
	DTC-TZXNN-1410-TB	40 mm	30 mm	32 mm	40 mm	ZNMV 3.36.3...Y-BF

* Use only ZNMV 3.36.3...Y-BF inserts

Hardware

Part Number	 Clamp	 Clamp Screw	 Clamp Spring	 Shim	 Shim Screw	 Hex Driver	 Torx Driver
DTC-TZ...3.36.3-TB	DLM 3.3Z-NV	DLS 5	DSP 5	TSZ 140310	TS 35083I/HG	L-W 4	T 10

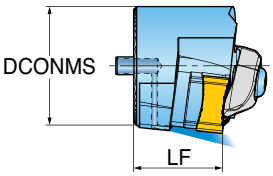
Coolant

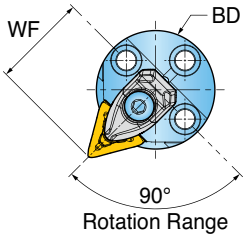
Series DTC-TTXNN-TB

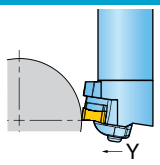
Y-AXIS TURNING HEADS (TNMV INSERT) W/ HIGH PRESSURE COOLANT

COOLBURST™







Approach Angle	Part Number	DCONMS Connection Dia. Machine Side	LF Functional Length	WF Functional Width	BD Body Diameter	Insert
METRIC						
	DTC-TTXNN-2109-TB	40 mm	30 mm	32 mm	40 mm	TNMV 3.95.7...

Hardware

Part Number	 Clamp	 Clamp Screw	 Clamp Spring	 Shim	 Shim Screw	 Hex Driver	 Torx Driver
DTC-TT...3.95.7-TB	DLM4.4T-NV	DLS 5	DSP 5	TSTV 210510	TS 35083I/HG	L-W 4	T 10

Coolant

Series DTC-D_ _TCLNR/L NEW

T-TYPE CLAMPING BORING HEADS (NEGATIVE CN_G INSERTS)



Fig. 1

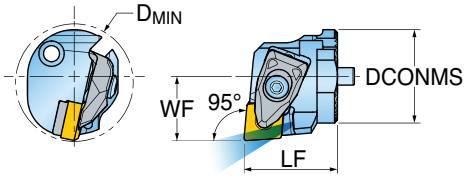
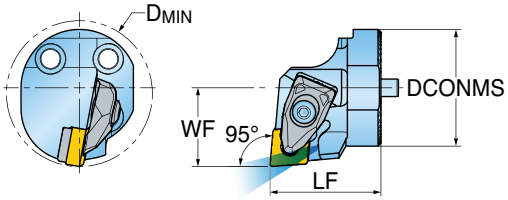
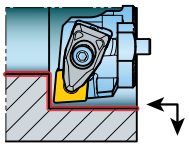


Fig. 2



Approach Angle	Part Number	DCONMS Connection Dia. Machine Side	LF Functional Length	WF Functional Width	DMIN Minimum Bore Dia.	Fig.	Insert
INCH							
95° 	DTC-D32-TCLNL-12	32.00 mm	1.260	.866	1.575	1	CN_G43...
	DTC-D32-TCLNR-12	32.00 mm	1.260	.866	1.575	1	
	DTC-D40-TCLNL-12	40.00 mm	1.496	1.063	1.968	2	
	DTC-D40-TCLNR-12	40.00 mm	1.496	1.063	1.968	2	

Hardware

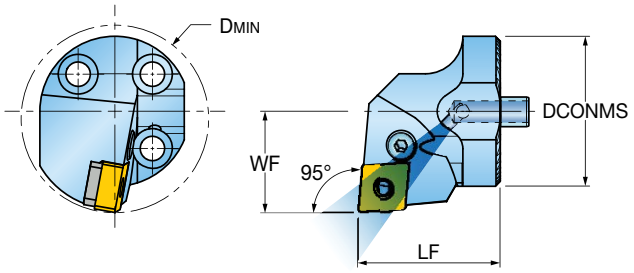
Part Number	Clamp	Clamp Screw	Clamp Spring	Shim	Shim Screw	Coolant Plug	Driver for Shim Screw	Wrench for Clamp Screw
DTC-D32-TCLNR/L-12	DLM4	DLS4	DSP4	LSC42	SM50-107-10	SS-M4X0.7X4-NL	DS-T20F	L-W3
DTC-D40-TCLNR/L-12	DLM4	DLS4	DSP4	LSC42	SM50-107-10	SS-M4X0.7X4-NL	DS-T20F	L-W3

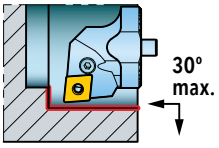
Coolant

Series DTC-HCLNR

HOOK LEVER TYPE BORING HEADS (NEGATIVE CNMX INSERTS)





Approach Angle	Part Number	DCONMS Connection Dia. Machine Side	LF Functional Length	WF Functional Width	DMIN Minimum Bore Dia.	Insert
INCH						
95°  30° max.	✓DTC-D40-HCLNR-1205	1.575	1.496	1.063	1.968	CNMX43.5...

✓Marked: for GoldDuty insert

Hardware

Part Number	Lever	Lever Screw	Shim	Shim Pin	Shim Pin Punch	Wrench
DTC-D40-HCLNR-1205	LCL 12-NX	LCS 5	LSC 42-NXS	LSP 4	SPP 3-4	L-W 3

Coolant

Series DTC-SCLCR/L

SCREW TYPE BORING HEADS (POSITIVE CC_T INSERTS)



Fig. 1

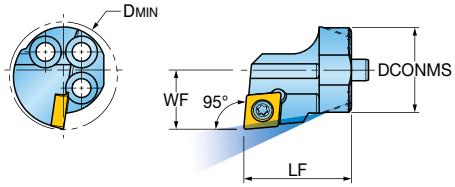
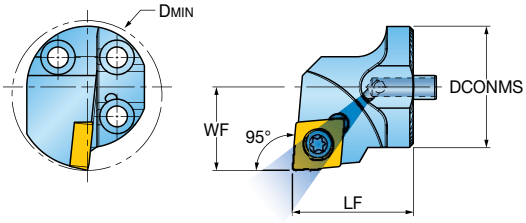
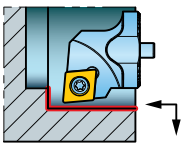


Fig. 2



Approach Angle	Part Number	DCONMS Connection Dia. Machine Side	LF Functional Length	WF Functional Width	DMIN Minimum Bore Dia.	Fig.	Insert
INCH							
95° 	DTC-D16-SCLCR/L-06	.630	.787	.433	.787	1	CC_T 21.5...
	DTC-D20-SCLCR/L-09	.787	.787	.512	.984	2	CC_T 32.5...
	DTC-D25-SCLCR/L-09	.984	.787	.664	1.260	2	
	DTC-D32-SCLCR/L-12	1.260	1.260	.866	1.575	2	CC_T 43...
	DTC-D40-SCLCR/L-12	1.575	1.496	1.063	1.968	2	

Hardware

Part Number	Screw	Shim	Shim Screw	Wrench	Wrench
DTC-D16-SCLCR/L-06	SO 25065I	-	-	T 7	-
DTC-D20-SCLCR/L-09	SO 35080I	-	-	T 15	-
DTC-D25-SCLCR/L-09	SO 35080I	-	-	T 15	-
DTC-D32-SCLCR/L-12	SO 45100I	-	-	T 20	-
DTC-D40-SCLCR/L-12	SO 45130I	SSC 43N	SO 60105S	T 20	L-W 5

Coolant

Series DTC-SCLNR/L

SCREW TYPE BORING HEADS (NEGATIVE CNMX INSERTS)



Fig. 1

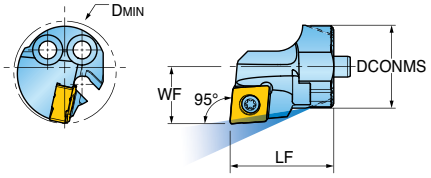
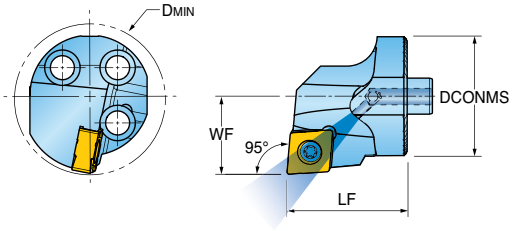
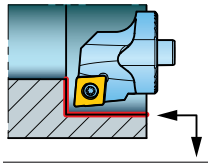


Fig. 2



Approach Angle	Part Number	DCONMS Connection Dia. Machine Side	LF Functional Length	WF Functional Width	DMIN Minimum Bore Dia.	Fig.	Insert
INCH							
95° 	✓ DTC-D16-SCLNR/L-0703	.630	.787	.433	.787	1	CN_X 2.22...
	✓ DTC-D20-SCLNR/L-0703	.787	.787	.512	.984	2	

✓ Marked: for RhinoTurnM insert

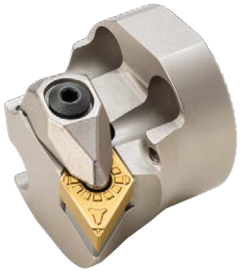
Hardware

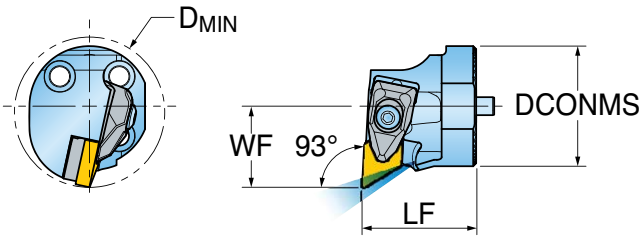
Part Number	 Screw	 Wrench
DTC-D16-SCLNR/L-0703	SM25-060-90	T7P
DTC-D20-SCLNR/L-0703	SM25-060-90	T7P

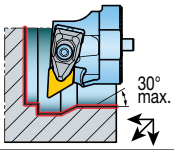
Coolant

Series DTC-D_ _TDUNR/L

T-TYPE CLAMPING BORING HEADS (NEGATIVE DN_G INSERTS)





Approach Angle	Part Number	DCONMS Connection Dia. Machine Side	LF Functional Length	WF Functional Width	DMIN Minimum Bore Dia.	Insert
INCH						
93° 	DTC-D40-TDUNL-1504	40.00 mm	1.570	1.378	1.968	DN_G43...
	DTC-D40-TDUNR-1504	40.00 mm	1.570	1.063	1.968	

Hardware

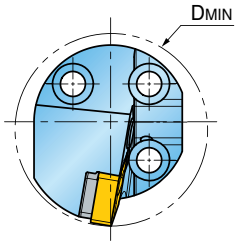
Part Number	Clamp	Clamp Screw	Clamp Spring	Shim	Shim Screw	Coolant Plug	Driver for Shim Screw	Wrench for Clamp Screw
DTC-D40-TDUNL-1504	DLM4	DLS4	DSP4	LSD42	SM50-122-50	SS-M4X0.7X4-NL	DS-T20F	L-W3
DTC-D40-TDUNR-1504	DLM4	DLS4	DSP4	LSD42	SM50-122-50	SS-M4X0.7X4-NL	DS-T20F	L-W3

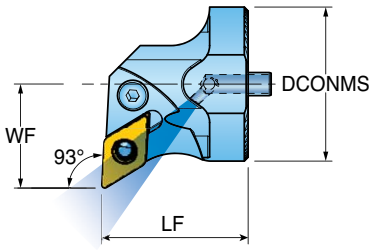
Coolant

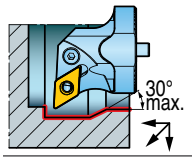
Series DTC-HDUNR/L

HOOK LEVER TYPE BORING HEADS (NEGATIVE DN_G INSERTS)







Approach Angle	Part Number	DCONMS Connection Dia. Machine Side	LF Functional Length	WF Functional Width	DMIN Minimum Bore Dia.	Insert
INCH						
93° 	✓DTC-D40-HDUNR/L-1305	1.575	1.496	1.063	1.968	DN_G 3.53.5...

✓Marked: for RhinoTurn insert

Hardware

Part Number	Lever	Lever Screw	Shim	Shim Pin	Shim Pin Punch	Wrench
DTC-D40-HDUNR/L-1305	LCL 11-NX	LCS 4S	LSD 3.52B	LSP 4	SPP 3-4	L-W 3

Coolant

Series DTC-SDUNR/L

SCREW TYPE BORING HEADS (NEGATIVE DNMX & DN_G INSERTS)



Fig. 1

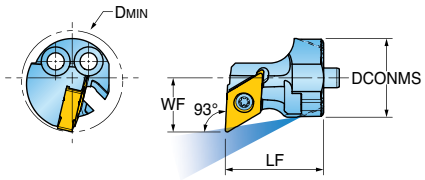
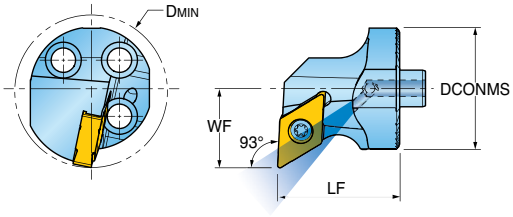
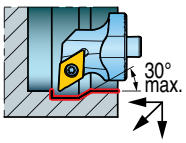


Fig. 2



Approach Angle	Part Number	DCONMS Connection Dia. Machine Side	LF Functional Length	WF Functional Width	DMIN Minimum Bore Dia.	Fig.	Insert
INCH							
93° 	✓ DTC-D16-SDUNR/L-0803	.630	.787	.433	.787	1	DN_X 2.22...
	✓ DTC-D20-SDUNR/L-0803	.787	.787	.512	.984	2	
	◆ DTC-D32-SDUNR/L-1305	1.260	1.260	.866	1.575	2	DN_G 3.53.5...

✓ Marked: for RhinoTurnM insert

◆ Marked: for RhinoTurn insert

Hardware

Part Number	Screw	Wrench
DTC-D16-SDUNR/L-0803	SM25-060-90	T 7P
DTC-D20-SDUNR/L-0803	SM25-060-90	T 7P
DTC-D32-SDUNR/L-1305	SM40-110-00	T 15

Coolant

Series DTC-SDUCR/L

SCREW TYPE BORING HEADS (POSITIVE DC_T INSERTS)



Fig. 1

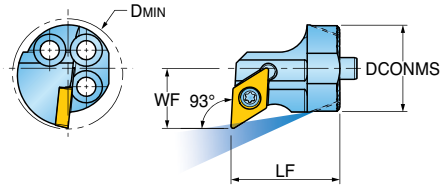
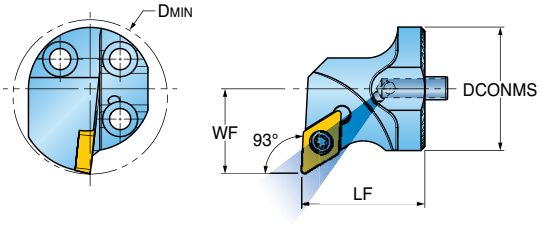
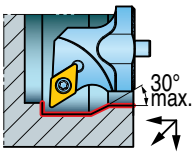


Fig. 2



Approach Angle	Part Number	DCONMS Connection Dia. Machine Side	LF Functional Length	WF Functional Width	DMIN Minimum Bore Dia.	Fig.	Insert
INCH							
93° 	DTC-D16-SDUCR/L-07	.630	.787	.433	.787	1	DC_T 21.5...
	DTC-D20-SDUCR/L-11	.787	.787	.512	.984	2	DC_T 32.5...
	DTC-D25-SDUCR/L-11	.984	.787	.668	1.260	2	
	DTC-D32-SDUCR/L-11	1.260	1.260	.866	1.575	2	
	DTC-D40-SDUCR/L-11	1.575	1.496	1.063	1.968	2	

Hardware

Part Number	Screw	Shim	Shim Screw	Wrench	Wrench
DTC-D16-SDUCR/L-07	SO 25065I	-	-	T 7	-
DTC-D20-SDUCR/L-11	SO 35080I	-	-	T 15	-
DTC-D25-SDUCR/L-11	SO 35080I	-	-	T 15	-
DTC-D32-SDUCR/L-11	SO 35080I	-	-	T 15	-
DTC-D40-SDUCR/L-11	SO 35124I	SSD 32	SO 50090S	T 15	L-W 3.5

Coolant

Series DTC-D_ _STFCR/L NEW

SCREW TYPE BORING HEADS (POSITIVE TCMT INSERTS)



Fig. 1

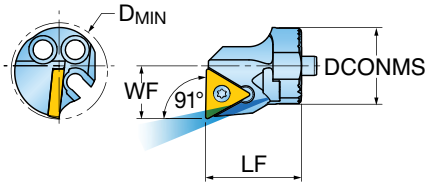
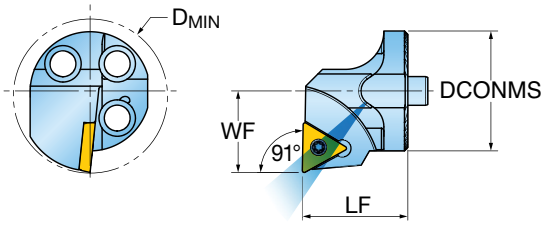
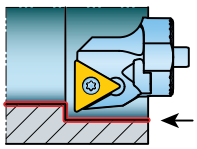


Fig. 2



Approach Angle	Part Number	DCONMS Connection Dia. Machine Side	LF Functional Length	WF Functional Width	DMIN Minimum Bore Dia.	Fig.	Insert
INCH							
91° 	DTC-D16-STFCR/L-11	16 mm	.787	.433	.787	1	TC__21.5_
	DTC-D20-STFCR/L-11	20 mm	.787	.512	.984	2	
	DTC-D25-STFCR/L-11	25 mm	.866	.669	1.260	2	
	DTC-D32-STFCR/L-16	32 mm	1.260	.866	1.575	2	TC__32.5_
	DTC-D40-STFCR/L-16	40 mm	1.496	1.063	1.969	2	

Hardware

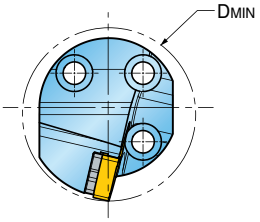
Part Number	Insert Screw	Driver for Insert Screw	Shim	Shim Screw	Wrench for Shim Screw
DTC-D16-STFCR/L-11	SM25-065-70	DS-T07F	-	-	-
DTC-D20-STFCR/L-11	SM25-065-70	DS-T07F	-	-	-
DTC-D25-STFCR/L-11	SM25-065-70	DS-T07F	-	-	-
DTC-D32-STFCR/L-16	SO35124I	DS-T15F	SST32	SO50090S	DS-H035T
DTC-D40-STFCR/L-16	SO35124I	DS-T15F	SST32	SO50090S	DS-H035T

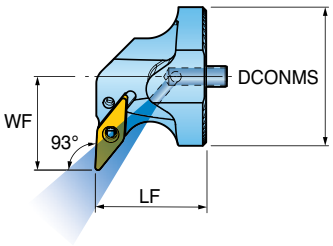
Coolant

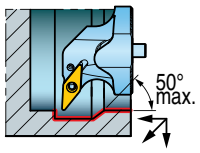
Series DTC-HVUNR/L

HOOK LEVER TYPE BORING HEADS (NEGATIVE VNMX INSERTS)







Approach Angle	Part Number	DCONMS Connection Dia. Machine Side	LF Functional Length	WF Functional Width	DMIN Minimum Bore Dia.	Insert
INCH						
93° 	✓DTC-D40-HVUNR/L-1304	1.575	1.256	1.063	1.968	VN_X 2.53...

✓Marked: for RhinoTurn insert

Hardware

Part Number	Lever	Lever Screw	Shim	Shim Pin	Shim Pin Punch	Wrench
DTC-D40-HVUNR/L-1304	LCL 08-NX	LCS 4-DH	LSV 2.51.8H	LSP 3B	SPP 3-3L	L-W 2.5

Coolant

Series DTC-SVUBR/L

SCREW TYPE BORING HEADS (POSITIVE VB_T INSERTS)



Fig. 1

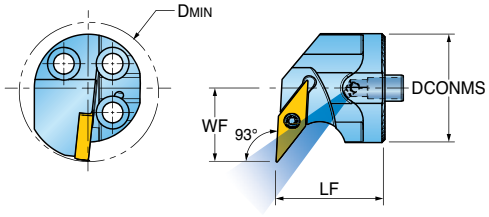
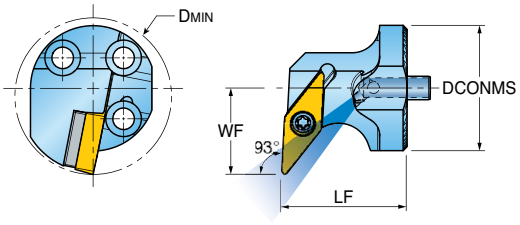
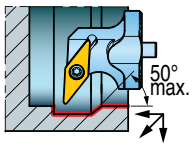


Fig. 2



Approach Angle	Part Number	DCONMS Connection Dia. Machine Side	LF Functional Length	WF Functional Width	DMIN Minimum Bore Dia.	Fig.	Insert
INCH							
93° 	DTC-D20-SVUBR/L-11	.787	.787	.630	1.063	1	VB_T 22...
	DTC-D25-SVUBR/L-11	.984	.984	.670	1.220	1	
	DTC-D32-SVUBR/L-16	1.260	1.260	.866	1.575	2	VB_T 33...
	DTC-D40-SVUBR/L-16	1.575	1.260	1.063	1.968	2	

Hardware

Part Number	Screw	Shim	Shim Screw	Wrench	Wrench
DTC-D20-SVUBR/L-11	SO 25065I	-	-	T 7	-
DTC-D25-SVUBR/L-11	SO 25065I	-	-	T 7	-
DTC-D32-SVUBR/L-16	SO 35124I	SSV 32	SO 50090S	T 15	L-W 3.5
DTC-D40-SVUBR/L-16	SO 35124I	SSV 32	SO 50090S	T 15	L-W 3.5

Coolant

Series DTC-SWLNR/L

SCREW TYPE BORING HEADS (NEGATIVE WNMX INSERTS)



Fig. 1

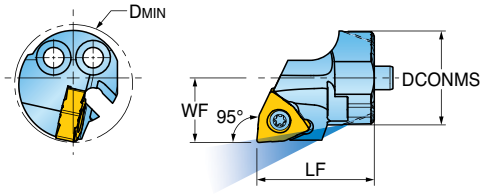
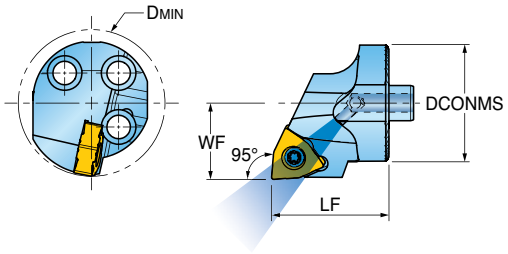
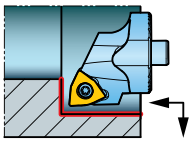


Fig. 2



Approach Angle	Part Number	DCONMS Connection Dia. Machine Side	LF Functional Length	WF Functional Width	DMIN Minimum Bore Dia.	Fig.	Insert
INCH							
95° 	✓ DTC-D16-SWLNR/L-0403	.630	.787	.433	.787	1	WN_X 2.22...
	✓ DTC-D20-SWLNR/L-0403	.787	.787	.512	.984	2	

✓ Marked: for RhinoTurnM insert

Hardware

Part Number	Screw	Wrench
DTC-D16-SWLNR/L-0403	SM25-060-90	T 7P
DTC-D20-SWLNR/L-0403	SM25-060-90	T 7P

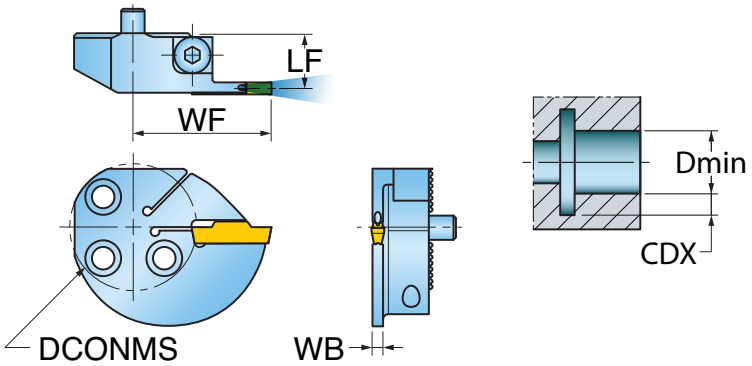
Coolant

Series DTC-D_ _TTIR/L-TB NEW

SCREW TYPE BORING HEADS FOR GROOVING AND TURNING (TCLAMP-ULTA+ INSERTS) W/ HIGH PRESSURE COOLANT

COOLBURST™





Part Number	SSC Insert Seat Size	DCONMS Connection Dia. Machine Side	LF Functional Length	WF Functional Width	WB Body Width	CDX Cutting Depth Max.	DMIN* Minimum Bore Dia.	Insert
INCH								
DTC-D25-TTIR/L-2T12-TB	2	25 mm	.563	1.260	.071	.472	2.283	TDC/J/T TDXU/XT/XC/XY TSC/J TDUF/TDV
DTC-D25-TTIR/L-3T12-TB	3	25 mm	.551	1.260	.094	.472	2.283	
DTC-D32-TTIR/L-2T12-TB	2	32 mm	.563	1.378	.071	.472	2.283	
DTC-D32-TTIR/L-3T12-TB	3	32 mm	.551	1.378	.094	.472	2.283	
DTC-D32-TTIR/L-4T12-TB	4	32 mm	.539	1.378	.118	.472	2.283	
DTC-D32-TTIR/L-5T17-TB	5	32 mm	.594	1.575	.154	.669	2.283	
DTC-D40-TTIR/L-3T12-TB	3	40 mm	.551	1.516	.094	.472	2.362	
DTC-D40-TTIR/L-4T12-TB	4	40 mm	.539	1.516	.118	.472	2.362	
DTC-D40-TTIR/L-5T17-TB	5	40 mm	.594	1.693	.154	.669	2.520	
DTC-D40-TTIR/L-6T17-TB	6	40 mm	.575	1.693	.193	.669	2.520	

*For possible smaller DMIN values, see tables on page 28.

SEE NEXT PAGE FOR RECOMMENDED CUTTING CONDITIONS

Hardware

Part Number	Screw	Hex Driver
DTC-D...TTIR/L-TB	SHM5x0.8x16	L-W4

Coolant

Series DTC-D_ _TTIR/L-TB (continued) NEW

RECOMMENDED CUTTING CONDITIONS » CARBON STEEL: 1045

TAbsorber Shank	Cutting Conditions	TAbsorber Head				
		DTC-D25-TTIR/L-2T12-TB	DTC-D25-TTIR/L-3T12-TB	DTC-D32-TTIR/L-4T12-TB	DTC-D32-TTIR/L-5T17-TB	DTC-D40-TTIR/L-6T17-TB
DTA-...-7D	Vc (SFM)	260–330	200–260	200–260	130–165	130–165
	fn (ipr)	.004–.005	.004–.005	.003–.004	.003–.004	.003–.004
DTA-...-10D	Vc (SFM)	130–165	130–165	130–165	130–165	80–100
	fn (ipr)	.003–.004	.003–.004	.003–.004	.003–.004	.003–.004

RECOMMENDED CUTTING CONDITIONS » ALLOY STEEL: 4140

TAbsorber Shank	Cutting Conditions	TAbsorber Head				
		DTC-D25-TTIR/L-2T12-TB	DTC-D25-TTIR/L-3T12-TB	DTC-D32-TTIR/L-4T12-TB	DTC-D32-TTIR/L-5T17-TB	DTC-D40-TTIR/L-6T17-TB
DTA-...-7D	Vc (SFM)	260–330	200–260	200–260	130–165	100–130
	fn (ipr)	.004–.005	.004–.005	.003–.004	.003–.004	.003–.004
DTA-...-10D	Vc (SFM)	130–165	130–165	100–130	100–130	80–100
	fn (ipr)	.003–.004	.003–.004	.003–.004	.003–.004	.003–.004

Series DTC-D25-TTIR/L and DTC-D32-TTIR/L Heads NEW

CDX	DMIN	
Cutting Depth Max.	DTC-D25...	DTC-D32...
.079"	1.811"	2.047"
.157"	1.811"	2.047"
.236"	1.811"	2.047"
.315"	1.811"	2.047"
.394"	1.969"	2.047"
.472"	2.283"	2.283"

Series DTC-D40-TTIR/L Heads NEW

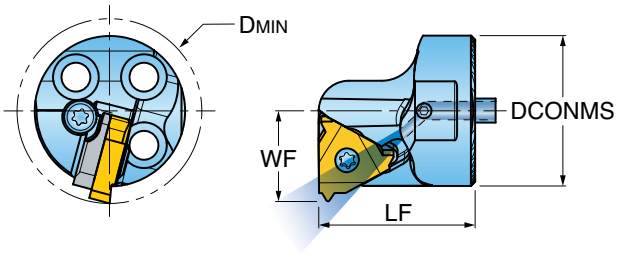
Minimum Bore Diameters (DMIN) by Insert Width and Shank Diameter			
DTC-D40-TTIR/L-3T12-TB • DTC-D40-TTIR/L-4T12-TB		DTC-D40-TTIR/L-5T17-TB • DTC-D40-TTIR/L-6T17-TB	
Shank Ø	DMIN	Shank Ø	DMIN
1.500"	2.362"	1.500"	2.520"
2.000"	2.756"	2.000"	2.914"
2.500"	3.149"	2.500"	3.307"
40 mm	60 mm	40 mm	64 mm
50 mm	70 mm	50 mm	74 mm
60 mm	80 mm	60 mm	84 mm

Coolant

Series DTC-SIR/L

SCREW TYPE BORING HEADS (LAYDOWN THREADING INSERTS)





Part Number	DCONMS Connection Dia. Machine Side	LF Functional Length	WF Functional Width	DMIN Minimum Bore Dia.	Insert
INCH					
DTC-D25-SIR/L-16	.984	1.024	.638	1.142	16IR/L
DTC-D32-SIR/L-16	1.260	1.063	.776	1.417	
DTC-D40-SIR/L-16	1.575	1.181	.433	1.733	
DTC-D32-SIR/L-22	1.260	1.260	.850	1.417	22IR/L
DTC-D40-SIR/L-22	1.575	1.496	1.008	1.811	

Hardware

Part Number	Anvil Ext.L/Int.R	Anvil Ext.R/Int.L	Anvil Screw	Wrench	Screw
DTC-D25-SIR-16	AI16	-	A16	T-10/5	S16
DTC-D25-SIL-16	-	AE16	A16	T-10/5	S16
DTC-D32-SIR-16	AI16	-	A16	T-10/5	S16
DTC-D32-SIL-16	-	AE16	A16	T-10/5	S16
DTC-D40-SIR-16	AI16	-	A16	T-10/5	S16
DTC-D40-SIL-16	-	AE16	A16	T-10/5	S16
DTC-D32-SIR-22	AI22	-	A22	T-20/5	S22
DTC-D32-SIL-22	-	AE22	A22	T-20/5	S22
DTC-D40-SIR-22	AI22	-	A22	T-20/5	S22
DTC-D40-SIL-22	-	AE22	A22	T-20/5	S22