



## Series DTC-D\_\_TTIR/L-TB (continued) NEW

### RECOMMENDED CUTTING CONDITIONS » CARBON STEEL: 1045

T Absorber Shank	Cutting Conditions	T Absorber 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

T Absorber Shank	Cutting Conditions	T Absorber 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	
	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