

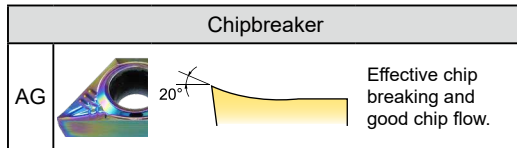
Turning Tools

G Class Inserts for Aluminum



- *Suitable for accurate cutting of small size workpiece.*
- *Wear resistant substrate improve insert life.*
- *Sharp geometry design is suitable for Finishing.*

Positive Turning Inserts for Aluminum alloys with Silicon

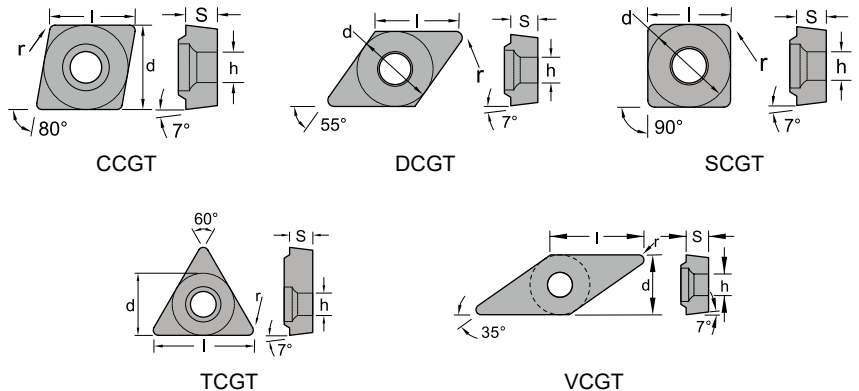


Grade	
CX1010	Nano DLC coated Inserts for Non-ferrous metals, such as Aluminum (Si ≥ 4%) and Copper.

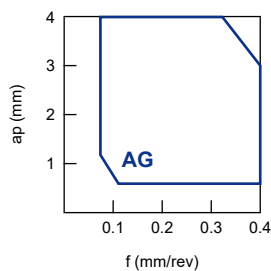
Inserts	Order No.	Specification	r	Working Material					
				P	M	K	N	S	H
	ICCGT060202AG1010	CCGT060202-AG-CX1010	0.2				●		
	ICCGT060204AG1010	CCGT060204-AG-CX1010	0.4				●		
	ICCGT09T308AG1010	CCGT09T308-AG-CX1010	0.8				●		
	IDCGT070202AG1010	DCGT070202-AG-CX1010	0.2				●		
	IDCGT11T302AG1010	DCGT11T302-AG-CX1010	0.2				●		
	ISCGT09T304AG1010	SCGT09T304-AG-CX1010	0.4				●		
	ITCGT090204AG1010	TCGT090204-AG-CX1010	0.4				●		
	ITCGT110202AG1010	TCGT110202-AG-CX1010	0.2				●		
	ITCGT16T304AG1010	TCGT16T304-AG-CX1010	0.4				●		
	ITCGT16T308AG1010	TCGT16T308-AG-CX1010	0.8				●		
	IVCGT110302AG1010	VCGT110302-AG-CX1010	0.2				●		
	IVCGT110304AG1010	VCGT110304-AG-CX1010	0.4				●		
	IVCGT160402AG1010	VCGT160402-AG-CX1010	0.2				●		
	IVCGT160404AG1010	VCGT160404-AG-CX1010	0.4				●		
	IVCGT160408AG1010	VCGT160408-AG-CX1010	0.8				●		

Insert Dimensions (mm)

Insert	d	l	S	h
CCGT0602	6.35	6.4	2.38	2.8
CCGT09T3	9.525	9.7	3.97	4.4
DCGT0702	6.35	7.7	2.38	2.8
DCGT11T3	9.525	11.6	3.97	4.4
SCGT09T3	9.525	9.525	3.97	4.4
TCGT0902	5.56	9.6	2.38	2.5
TCGT1102	6.35	11.0	2.38	2.8
TCGT16T3	9.525	16.5	3.97	4.4
VCGT1103	11.1	6.35	3.18	2.8
VCGT1604	9.525	16.6	4.76	4.4



Cutting Condition



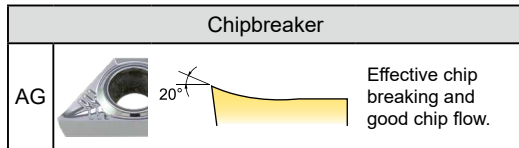
Cutting Speed for CX1010

Working Material	Silicon	VC (m/min)
N	Forged Aluminum alloys	< 4%
		≥ 4%
N	Cast Aluminum alloys	< 4%
		≥ 4%
Copper	-	150 ~ 300



Turning Tools - G Class Inserts

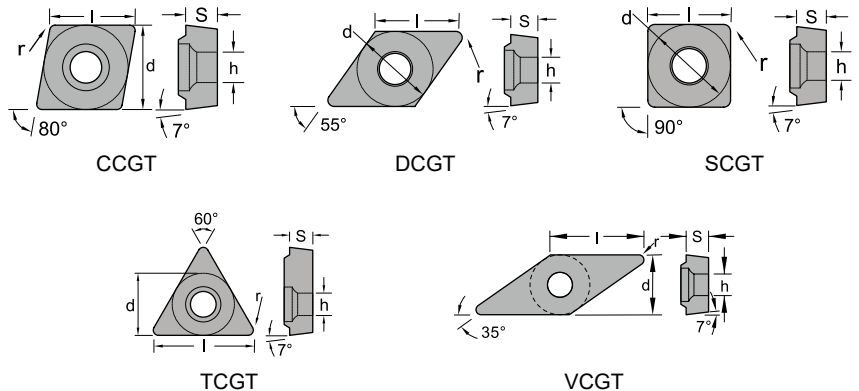
Positive Turning Inserts for Aluminum alloys



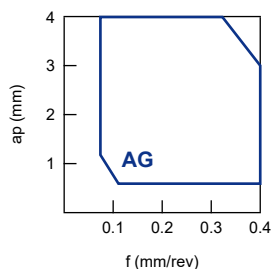
Inserts	Order No.	Specification	r	Working Material					
				P	M	K	N	S	H
	ICCGT060202AG10	CCGT060202-AG-CX10	0.2				●		
	ICCGT060204AG10	CCGT060204-AG-CX10	0.4				●		
	ICCGT09T308AG10	CCGT09T308-AG-CX10	0.8				●		
	IDCGT070202AG10	DCGT070202-AG-CX10	0.2				●		
	IDCGT11T302AG10	DCGT11T302-AG-CX10	0.2				●		
	ISCGT09T304AG10	SCGT09T304-AG-CX10	0.4				●		
	ITCGT090204AG10	TCGT090204-AG-CX10	0.4				●		
	ITCGT110202AG10	TCGT110202-AG-CX10	0.2				●		
	ITCGT16T304AG10	TCGT16T304-AG-CX10	0.4				●		
	ITCGT16T308AG10	TCGT16T308-AG-CX10	0.8				●		
	IVCGT110302AG10	VCGT110302-AG-CX10	0.2				●		
	IVCGT110304AG10	VCGT110304-AG-CX10	0.4				●		
	IVCGT160402AG10	VCGT160402-AG-CX10	0.2				●		
	IVCGT160404AG10	VCGT160404-AG-CX10	0.4				●		
	IVCGT160408AG10	VCGT160408-AG-CX10	0.8				●		

Insert Dimensions (mm)

Insert	d	l	S	h
CCGT0602	6.35	6.4	2.38	2.8
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SCGT09T3	9.525	9.525	3.97	4.4
TCGT0902	5.56	9.6	2.38	2.5
TCGT1102	6.35	11.0	2.38	2.8
TCGT16T3	9.525	16.5	3.97	4.4
VCGT1103	11.1	6.35	3.18	2.8
VCGT1604	9.525	16.6	4.76	4.4



Cutting Condition



Cutting Speed for CX01

Working Material	HB	VC (m/min)
N Forged Aluminum alloys	50 ~ 70	300 ~ 1000
	90 ~ 100	250 ~ 800
Cast Aluminum alloys	70 ~ 80	250 ~ 800
	80 ~ 100	200 ~ 600

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