

PARTING 4x FASTER

Pockets
Profitability
Productivity
Performance

MULTIFGRIP
HIGH FEED GRIP HOLDER

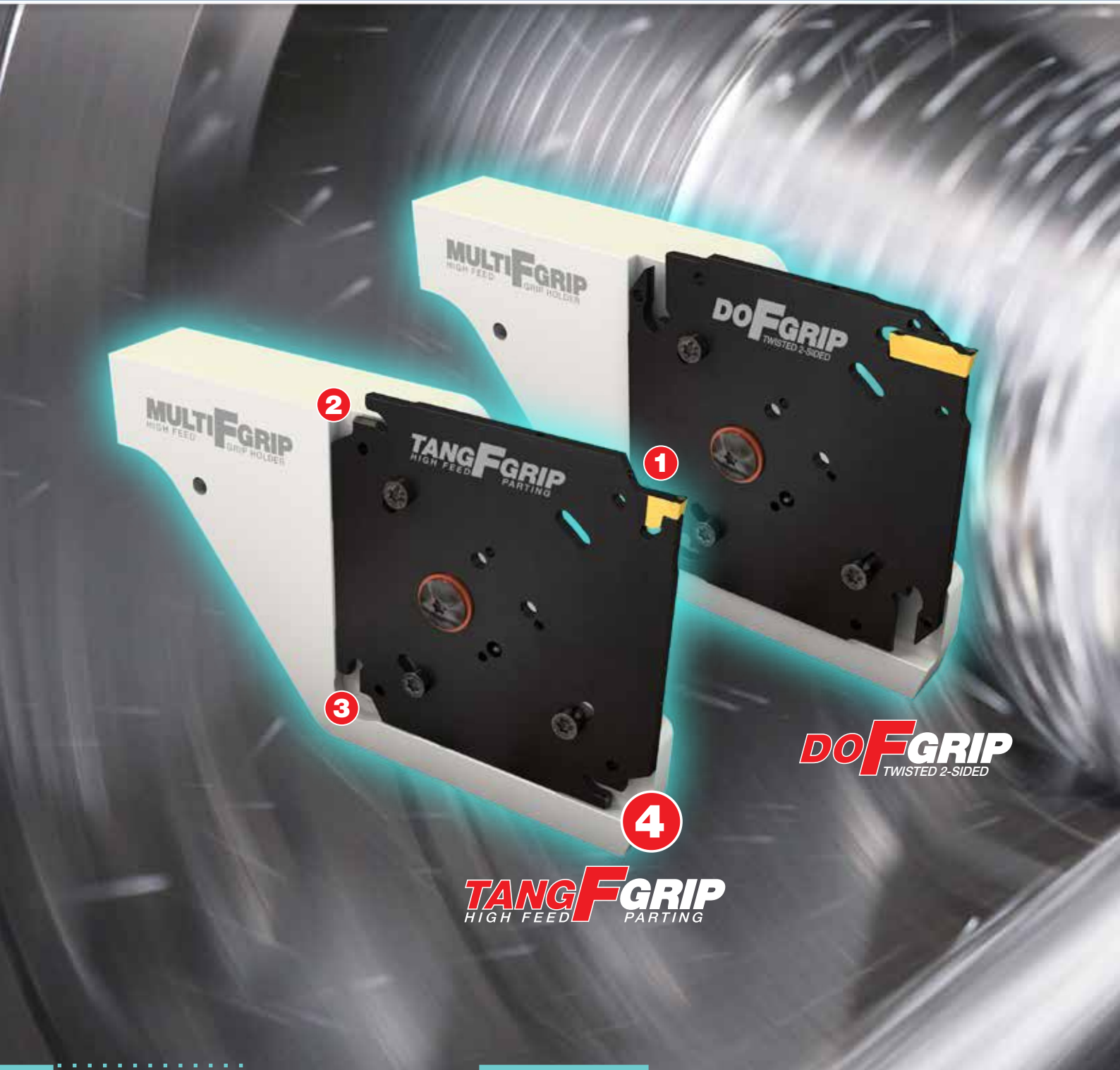


TANG-GRIP IQ
350 LINE

TANGFGRIP
HIGH FEED PARTING

DOFGRIP
TWISTED 2-SIDED

Parting with Extra Stability



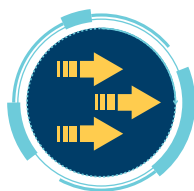
MULTIFGRIP
HIGH FEED GRIP HOLDER

**Reinforced and Robust Tool
Provides Extra Stability and Higher Productivity
Block Suitable for All Machine Types**

and Higher Productivity



Rigid Clamping



Extra High Feed



High Pressure Coolant



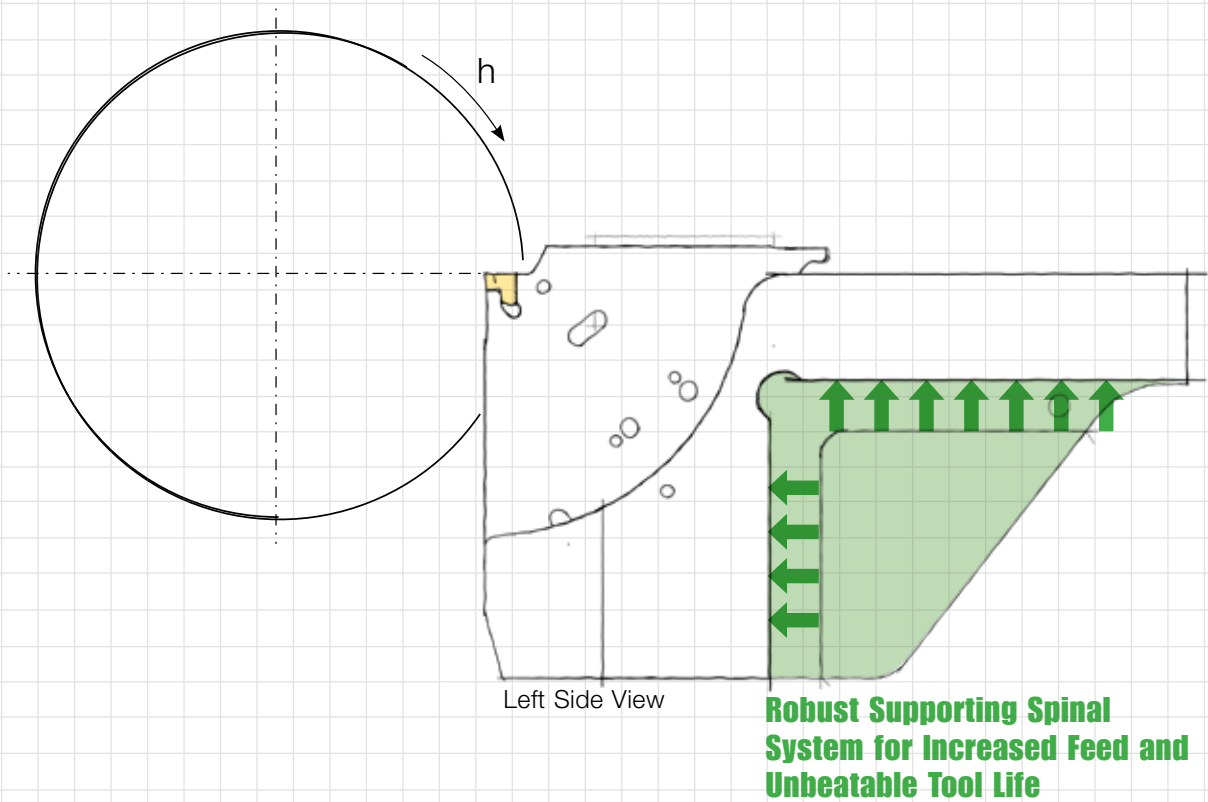
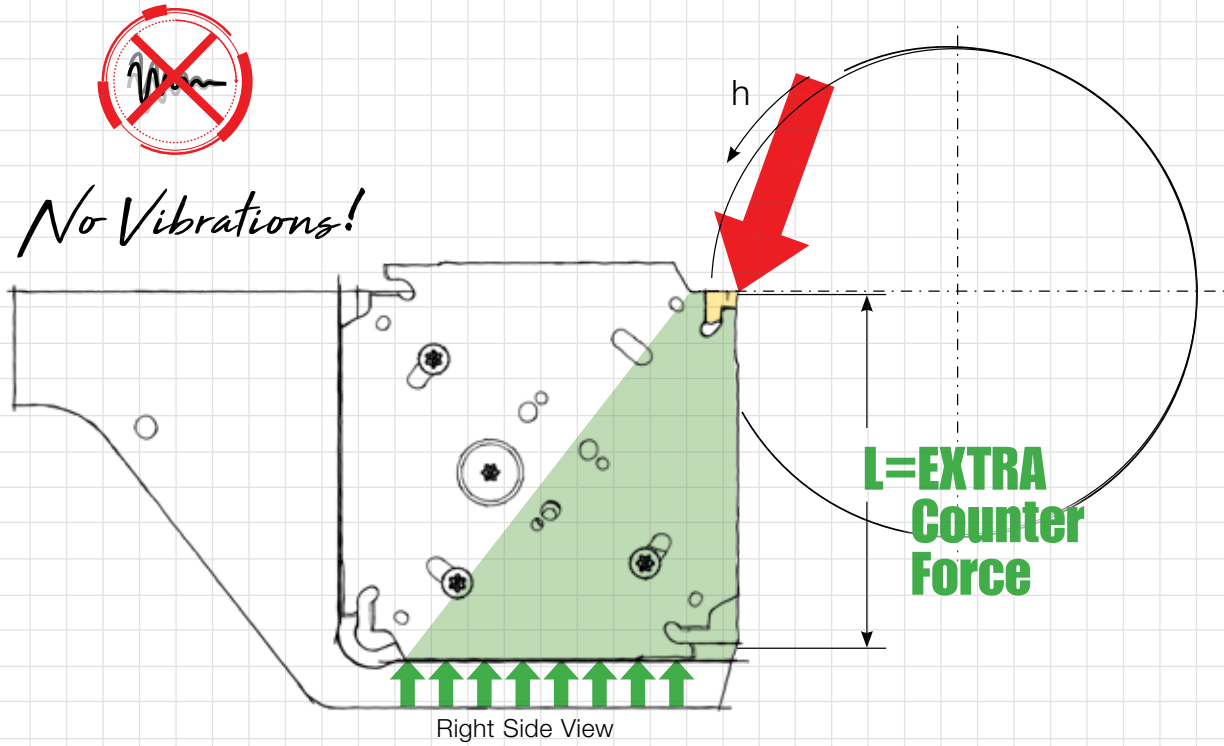
Cost Effective



Anti-Vibration

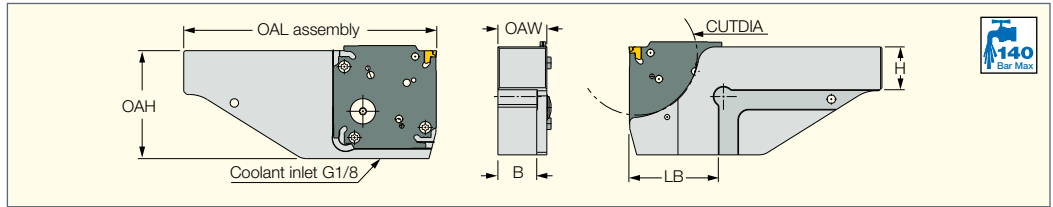
MULTIFGRIP

HIGH FEED GRIP HOLDER



TGTBQ-JHP

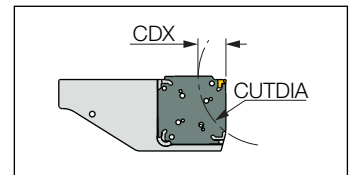
Tool Blocks for Parting and Grooving Square Blades
Tang-F-Grip & Do-F-Grip for High Pressure Coolant



Designation	OAH	H	B	OAW	OAL	LB	CUTDIA
TGTBQ 20L-D52-JHP	50.0	20.0	20.5	26.50	122.00	34.00	52.0
TGTBQ 20R-D52-JHP	50.0	20.0	20.5	26.50	122.00	34.00	52.0
TGTBQ 25L-D52-JHP	50.0	25.0	25.5	31.50	132.00	34.00	52.0
TGTBQ 25R-D52-JHP	50.0	25.0	25.5	31.50	132.00	34.00	52.0
TGTBQ 20L-D82-JHP	64.0	20.0	20.5	26.50	140.00	53.00	82.0
TGTBQ 20R-D82-JHP	64.0	20.0	20.5	26.50	140.00	53.00	82.0
TGTBQ 25L-D82-JHP	64.0	25.0	25.5	31.50	150.00	53.00	82.0
TGTBQ 25R-D82-JHP	64.0	25.0	25.5	31.50	150.00	53.00	82.0
TGTBQ 32L-D82-JHP	64.0	32.0	32.5	38.50	150.50	53.50	82.0
TGTBQ 32R-D82-JHP	64.0	32.0	32.5	38.50	150.50	53.50	82.0
TGTBQ 25L-D120-JHP	95.0	25.0	25.5	31.50	165.00	67.00	120.0
TGTBQ 25R-D120-JHP	95.0	25.0	25.5	31.50	165.00	67.00	120.0
TGTBQ 32L-D120-JHP	95.0	32.0	32.5	38.50	165.00	67.00	120.0
TGTBQ 32R-D120-JHP	95.0	32.0	32.5	38.50	165.00	67.00	120.0

Table determining depth of cut for grooving as function of workpiece diameter

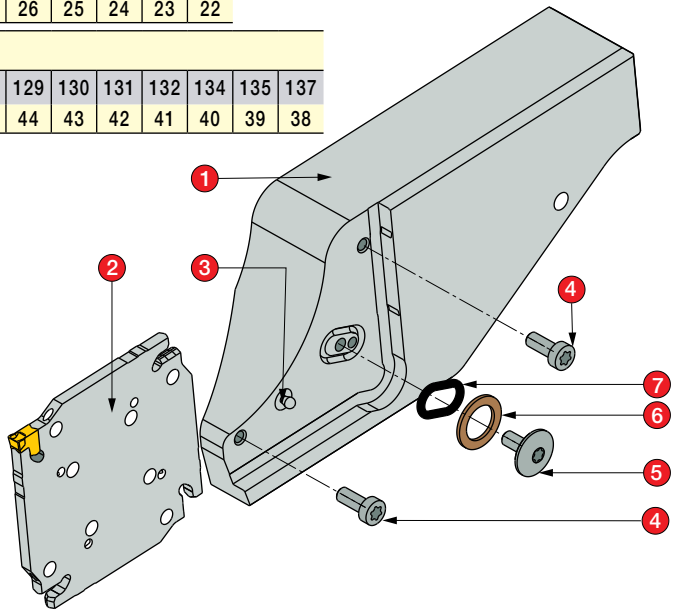
Designation	CUTDIA																	
	53	54	55	56	57	59	61	64	67	71	75	81	88	96	107	122	141	169
TGTBQ...D52-JHP	107	110	114	119	124	130	137	145	154	165	178	194	213	237	267	308	363	443
TGTBQ...D82-JHP	202	210	219	229	240	253	267	283	302	324	349	380	417	462	518	592	689	827
CDX	21	20	19	18	17	16	15	14	13	12	11	10	9	8	7	6	5	4



Designation	CUTDIA															
	83	83	84	84	85	86	87	88	89	91	92	94	96	98	101	103
TGTBQ...D82-JHP	139	141	143	145	148	150	153	156	160	164	168	172	177	183	188	195
TGTBQ...D120-JHP	37	36	35	34	33	32	31	30	29	28	27	26	25	24	23	22

Designation	CUTDIA																
	121	122	123	123	124	125	125	126	127	128	129	130	131	132	134	135	137
TGTBQ...D120-JHP	56-60	53-55	52	51	50	49	48	47	46	45	44	43	42	41	40	39	38

1. Block: TGTBQ...D...
2. Blade: T/DGAQ...
3. Locating Pin: Side thrust Pin 3mm
4. Screw: SR M4x10 ISO 14580
5. Screw: SR M4x9-Seal-JHP
6. Seal washer: CSW 1/8"
7. O-ring: O-ring 10x2 NBR



Spare Parts

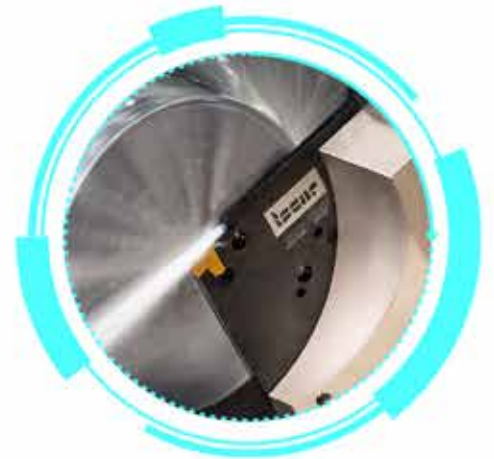
Designation						
TGTBQ-JHP	SR M4X9-SEAL-JHP	SIDE THRUST PIN 3mm	JHP COPPER SEAL 1/8"	SR ISO 14580 M4X10	SW6-SD	BLD T20/S7

Parting with Extra Stability

TANGFGRIP
HIGH FEED PARTING

The New Square Blade with the 4-Pocket Parting Concept Enables Mounting the Block on All Machine Types

- Vibration free, excellent surface finish and part straightness
- Parting up to 120mm diameter with 3 mm insert, leads to increased material savings
- Guaranteed higher productivity with HF (high feed) insert
- Enables mounting of all types of TANG-GRIP inserts



High Feed Insert



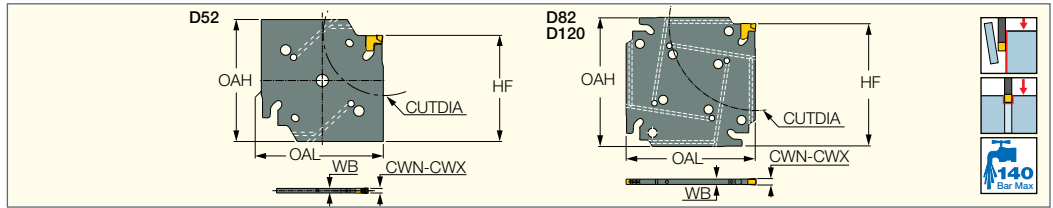
Economical
4-Pocket Blade

and Higher Productivity



TGAQ-JHP

Parting and Grooving Square Blades for TANG-GRIP Tangentially Clamped Inserts



Designation	OAL	OAH	CWN ⁽¹⁾	CWX ⁽²⁾	WB	HF				CUTDIA	Inserts
TGAQ D52-2-2Z-JHP	50.00	50.0	1.80	2.50	1.65	43.5	SR M4X9-SEAL-JHP	JHP COPPER SEAL 1/8"	ETG 2"	52.0	TAG 2
TGAQ D52-3-2Z-JHP	50.00	50.0	2.80	3.50	2.50	43.5	SR M4X9-SEAL-JHP	JHP COPPER SEAL 1/8"	ETG 3-4-SH*	52.0	TAG 3
TGAQ D52-4-2Z-JHP	50.00	50.0	3.70	4.50	3.40	43.5	SR M4X9-SEAL-JHP	JHP COPPER SEAL 1/8"	ETG 3-4-SH*	52.0	TAG 4
TGAQ D82-2-4Z-JHP	61.00	61.0	1.80	2.50	1.65	58.0	SR M4X9-SEAL-JHP	JHP COPPER SEAL 1/8"	ETG 2"	82.0	TAG 2
TGAQ D82-3-4Z-JHP	61.00	61.0	2.80	3.50	2.50	58.0	SR M4X9-SEAL-JHP	JHP COPPER SEAL 1/8"	ETG 3-4-SH*	82.0	TAG 3
TGAQ D82-4-4Z-JHP	61.00	61.0	3.70	4.50	3.40	58.0	SR M4X9-SEAL-JHP	JHP COPPER SEAL 1/8"	ETG 3-4-SH*	82.0	TAG 4
TGAQ D120-3-4Z-JHP	90.50	90.5	2.80	3.50	2.50	84.0	SR M4X9-SEAL-JHP	JHP COPPER SEAL 1/8"	ETG 3-4-SH*	120.0	TAG 3
TGAQ D120-4-4Z-JHP	90.50	90.5	3.70	4.50	3.40	84.0	SR M4X9-SEAL-JHP	JHP COPPER SEAL 1/8"	ETG 3-4-SH	120.0	TAG 4
TGAQ D120-5-4Z-JHP	90.50	90.5	4.70	5.50	4.00	84.0	SR M4X9-SEAL-JHP	JHP COPPER SEAL 1/8"	ETG 5-7*	120.0	TAG 5

• Suitable for all TANG-GRIP inserts

* Optional, should be ordered separately

⁽¹⁾ Minimum cutting width

⁽²⁾ Maximum cutting width

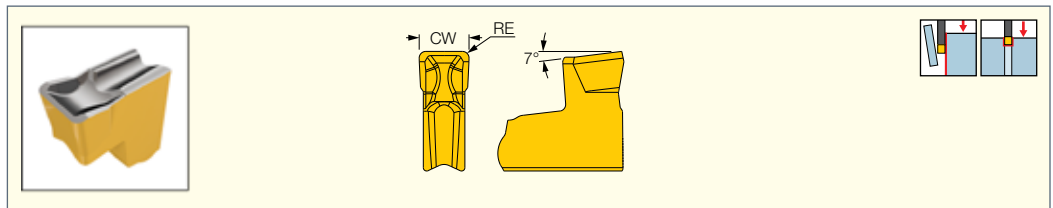
Flow Rate vs. Pressure

Designation	70 Bar	100 Bar	140 Bar
	Flow Rate (liters/min)	Flow Rate (liters/min)	Flow Rate (liters/min)
TGAQ D52/82/-2...-JHP	4-7	5-8	6-9
TGAQ D52/82/120-3...-JHP			
TGAQ D52/82/120-4...-JHP	6-7	7-8	8-9
TGAQ D120-5-JHP			



TAG N-HF

Single-Ended Inserts for High Feed Parting and Grooving, Hard Materials and Tough Applications

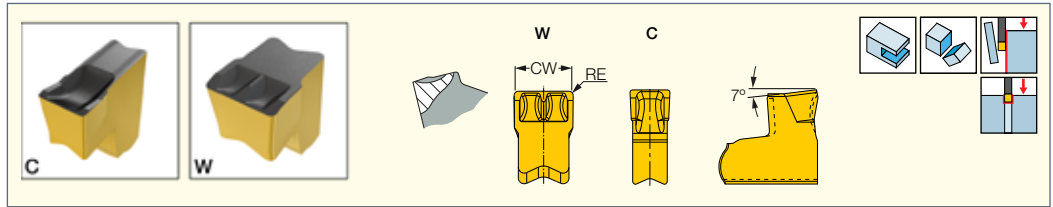


Designation	Dimensions			Tough ↔ Hard		Recommended Machining Data
	CW	CWTOL ⁽¹⁾	RE	IC830	IC808	
TAG N3HF	3.00	0.040	0.40	•	•	f groove (mm/rev) 0.25-0.35
TAG N4HF	4.00	0.040	0.50	•	•	0.30-0.40
TAG N5HF	5.00	0.040	0.50	•	•	0.30-0.40

⁽¹⁾ Cutting width tolerance (+/-)

TAG N-C/W/M

Single-Ended Inserts for Parting, Grooving and Slitting Bars, Hard Materials and Tough Applications



Designation	Dimensions			Tough ↔ Hard								Recommended Machining Data	
	CW	CWTOL ⁽³⁾	RE	IC830	IC1030	IC5400	IC1010	IC808	IC908	IC30N	IC20	IC807	f groove (mm/rev)
TAG N2C	2.00	0.05	0.20	●	●	●	●	●		●	●		0.05-0.16
TAG N2.4C	2.40	0.04	0.16	●				●					0.06-0.18
TAG N3CB ⁽¹⁾	3.00	0.05	0.35	●				●					0.12-0.30
TAG N3C	3.05	0.05	0.20	●	●	●	●	●	●	●	●	●	0.10-0.25
TAG N3M ⁽²⁾	3.05	0.05	0.20	●					●				0.06-0.18
TAG N3W	3.05	0.05	0.20	●					●				0.10-0.25
TAG N4C	4.00	0.05	0.24	●	●	●	●	●	●		●	●	0.10-0.30
TAG N4CB ⁽¹⁾	4.00	0.05	0.40	●					●				0.10-0.33
TAG N4M ⁽²⁾	4.00	0.05	0.24	●					●				0.06-0.20
TAG N4W	4.00	0.05	0.24	●					●				0.10-0.30
TAG N4.8C	4.80	0.05	0.30	●				●					0.10-0.35
TAG N5C	5.05	0.05	0.25	●				●			●		0.10-0.35

• Feed values for grade IC20 should be decreased by 50%

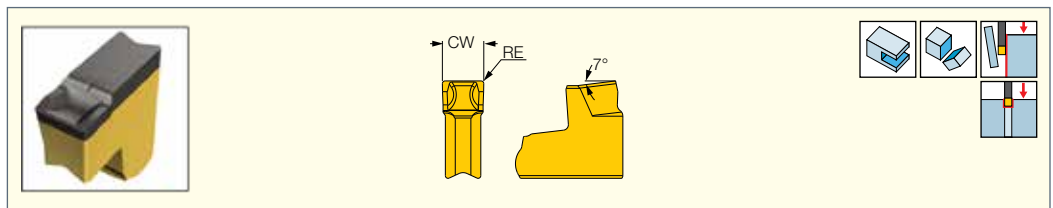
⁽¹⁾ Larger corner radii for interrupted cut and high feed applications

⁽²⁾ Similar to C-type, but with a modified edge; improved chip control at medium feeds

⁽³⁾ Cutting width tolerance (+/-)

TAG N-MF

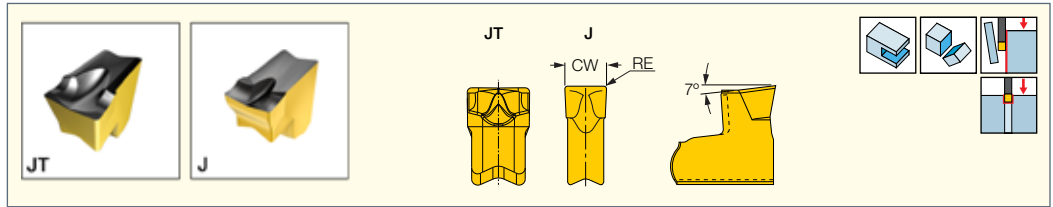
Single-Ended Inserts for Parting, Grooving and Slitting Stainless and Alloy Steel at Medium Feed



Designation	Dimensions			Tough ↔ Hard					Recommended Machining Data
	CW	CWTOL ⁽¹⁾	RE	IC830	IC1030	IC5400	IC1010	IC808	f groove (mm/rev)
TAG N2MF	2.00	0.05	0.20	●	●	●	●	●	0.04-0.12
TAG N3MF	3.00	0.05	0.20	●	●	●	●	●	0.06-0.18
TAG N4MF	4.00	0.05	0.25	●	●	●	●	●	0.07-0.22
TAG N5MF	5.00	0.05	0.25	●				●	0.08-0.25

⁽¹⁾ Cutting width tolerance (+/-)

TAG N-J/JS/JT
Single-Ended Inserts for Parting, Grooving and Slitting Soft Materials



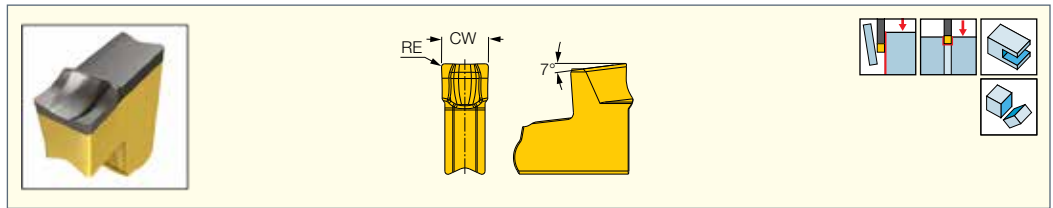
Designation	Dimensions				Tough ↔ Hard								Recommended Machining Data
	CW	RE	CWTOL ⁽²⁾	RETOL ⁽³⁾	IC830	IC1030	IC5400	IC1010	IC808	IC908	IC20	IC807	f groove (mm/rev)
TAG N2J	2.00	0.20	0.04	0.050	●	●	●	●	●	●	●	●	0.04-0.12
TAG N2JS	2.00	0.02	0.04	0.020	●				●				0.03-0.08
TAG N2JT	2.00	0.20	0.04	0.050	●		●		●	●			0.04-0.10
TAG N3J	3.05	0.20	0.04	0.050	●	●	●	●	●	●	●	●	0.04-0.16
TAG N3JS	3.05	0.02	0.04	0.020	●				●				0.04-0.10
TAG N3JT	3.05	0.20	0.04	0.050	●		●		●	●			0.05-0.18
TAG N3.2JT	3.25	0.20	0.04	0.050	●				●				0.05-0.18
TAG N4J	4.00	0.24	0.04	0.050	●	●	●	●	●	●		●	0.04-0.18
TAG N4JT	4.05	0.24	0.04	0.050	●		●		●	●			0.06-0.20
TAG N5J	5.05	0.25	0.04	0.050	●				●				0.05-0.20
TAG N5JT	5.05	0.25	0.04	0.050	●				●	●			0.06-0.22

● JT chipformer has the basic positive configuration of the J-type and a reinforced negative frontal edge; most suitable for soft materials at low to medium feeds.

⁽²⁾ Cutting width tolerance (+/-)

⁽³⁾ Corner radius tolerance (+/-)

TAG N-LF
Single-Ended Inserts for Parting, Grooving and Slitting Stainless Steel



Designation	Dimensions				Tough ↔ Hard					Recommended Machining Data
	CW	RE	CWTOL ⁽¹⁾	RETOL ⁽²⁾	IC830	IC1030	IC5400	IC1010	IC808	f groove (mm/rev)
TAG N2LF	2.00	0.20	0.04	0.030	●	●	●	●	●	0.03-0.08
TAG N3LF	3.05	0.20	0.04	0.030	●	●	●	●	●	0.04-0.10

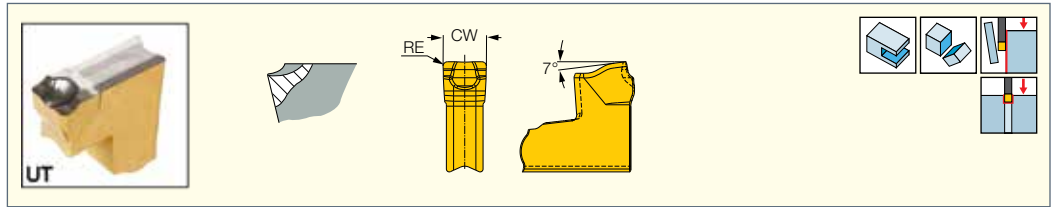
⁽¹⁾ Cutting width tolerance (+/-)

⁽²⁾ Corner radius tolerance (+/-)



TAG N-UT

Single-Sided Inserts for Parting, Grooving & Slitting at Low Feeds on Cr-Ni Alloys, Ductile Materials and Low Carbon Steel



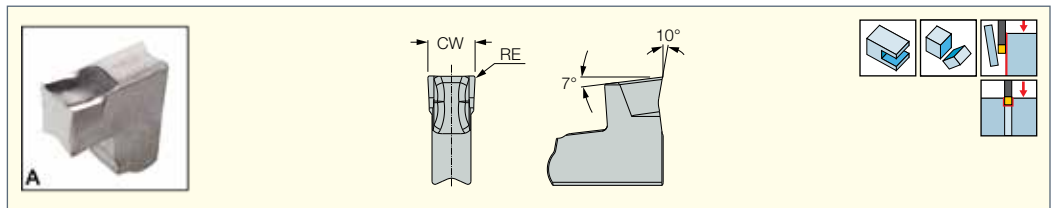
Designation	Dimensions				Tough ↔ Hard			Recommended Machining Data f groove (mm/rev)
	CW	RE	CWTOL ⁽¹⁾	RETOL ⁽²⁾	IC830	IC808	IC908	
TAG N2UT	2.00	0.20	0.04	0.040	●	●	●	0.03-0.10
TAG N3UT	3.00	0.30	0.04	0.040	●	●	●	0.04-0.12
TAG N4UT	4.00	0.30	0.04	0.040	●	●	●	0.05-0.15
TAG N5UT	5.00	0.30	0.04	0.040	●	●	●	0.05-0.18

⁽¹⁾ Cutting width tolerance (+/-)

⁽²⁾ Corner radius tolerance (+/-)

TAG N-A

Single-Ended Inserts for Parting, Grooving and Slitting Aluminum



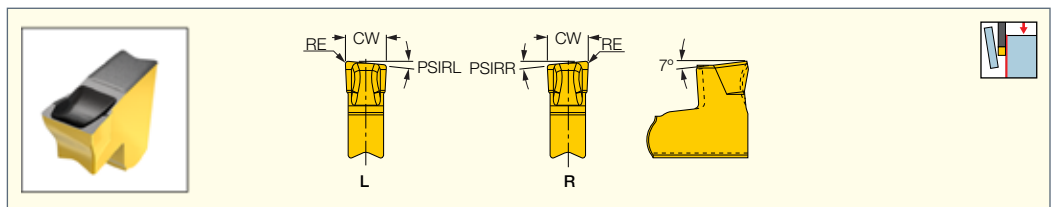
Designation	Dimensions				IC20	Recommended Machining Data f groove (mm/rev)
	CW	RE	CWTOL ⁽¹⁾	RETOL ⁽²⁾		
TAG N2A	2.00	0.20	0.04	0.050	●	0.02-0.10
TAG N3A	3.05	0.20	0.04	0.050	●	0.03-0.14
TAG N4A	4.05	0.24	0.04	0.050	●	0.03-0.16

⁽¹⁾ Cutting width tolerance (+/-)

⁽²⁾ Corner radius tolerance (+/-)

TAG R/L-C

Single-Ended Inserts for Parting Bars, Hard Materials and Tough Parting Applications

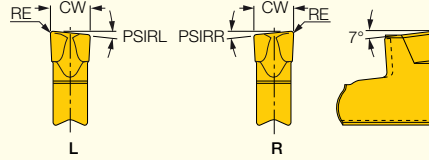


Designation	Dimensions					Tough ↔ Hard				Recommended Machining Data f groove (mm/rev)
	CW	CWTOL ⁽¹⁾	RE	PSIRR	PSIRL	IC830	IC808	IC908	IC30N	
TAG L2C-6D	2.05	0.10	0.20	-	6.0	●	●			0.04-0.12
TAG R2C-6D	2.05	0.10	0.20	6.0	-	●	●			0.04-0.12
TAG R2.4C-8D	2.40	0.10	0.16	8.0	-	●	●			0.05-0.13
TAG L3C-6D	3.00	0.10	0.20	-	6.0	●	●	●		0.08-0.18
TAG R3C-6D	3.00	0.10	0.20	6.0	-	●	●	●		0.08-0.18
TAG R3C-8D	3.00	0.10	0.20	8.0	-	●	●		●	0.06-0.16
TAG L3C-15D	3.00	0.10	0.20	-	15.0	●	●	●		0.08-0.16
TAG R3C-15D	3.00	0.10	0.20	15.0	-	●	●	●		0.08-0.16
TAG L4C-4D	4.05	0.10	0.24	-	4.0	●	●			0.08-0.20
TAG R4C-4D	4.05	0.10	0.24	4.0	-	●	●			0.08-0.20
TAG L5C-4D	5.05	0.10	0.25	-	4.0	●	●			0.10-0.25
TAG R5C-4D	5.05	0.10	0.25	4.0	-	●	●			0.10-0.25

⁽¹⁾ Cutting width tolerance (+/-)

TAG R/L-J/JS

TANG-GRIP Inserts for Parting
Soft Materials, Tubes, Small
Diameters and Thin-Walled Parts



Designation	Dimensions				Tough ↔ Hard			Recommended Machining Data
	CW	RE	PSIRL	PSIRR	IC880	IC808	IC908	
TAG L2J-6D	2.00	0.20	6.0	-	●	●		f groove (mm/rev)
TAG R2J-6D	2.00	0.20	-	6.0	●	●		0.03-0.10
TAG L2JS-6D	2.00	0.02	6.0	-	●	●		0.02-0.08
TAG R2JS-6D	2.00	0.02	-	6.0	●	●		0.02-0.08
TAG L2J-15D	2.00	0.20	15.0	-	●	●		0.03-0.08
TAG R2J-15D	2.00	0.20	-	15.0	●	●		0.03-0.08
TAG L2JS-15D	2.00	0.02	15.0	-	●	●		0.02-0.06
TAG R2JS-15D	2.00	0.02	-	15.0	●	●		0.02-0.06
TAG L3J-6D	3.00	0.20	6.0	-	●	●	●	0.04-0.14
TAG R3J-6D	3.00	0.20	-	6.0	●	●	●	0.04-0.14
TAG L3JS-6D	3.00	0.02	6.0	-	●	●		0.03-0.10
TAG R3JS-6D	3.00	0.02	-	6.0	●	●		0.03-0.10
TAG L3J-15D	3.00	0.20	15.0	-	●	●	●	0.04-0.12
TAG R3J-15D	3.00	0.20	-	15.0	●	●	●	0.04-0.12
TAG L3JS-15D	3.00	0.02	15.0	-	●	●		0.03-0.08
TAG R3JS-15D	3.00	0.02	-	15.0	●	●		0.03-0.08
TAG L4J-4D	4.00	0.24	4.0	-	●	●		0.04-0.15
TAG R4J-4D	4.00	0.24	-	4.0	●	●	●	0.04-0.15
TAG L5J-4D	5.05	0.25	4.0	-	●	●		0.05-0.18
TAG R5J-4D	5.05	0.25	-	4.0	●	●		0.05-0.18

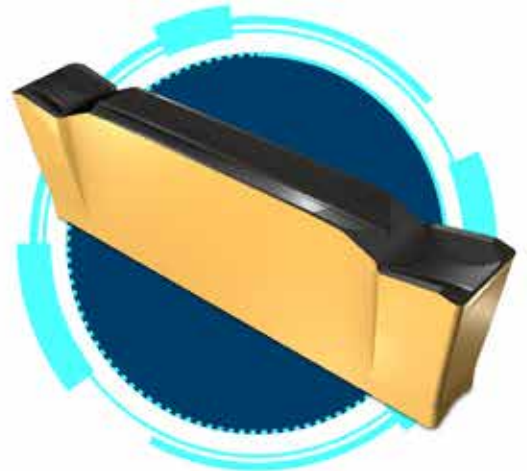
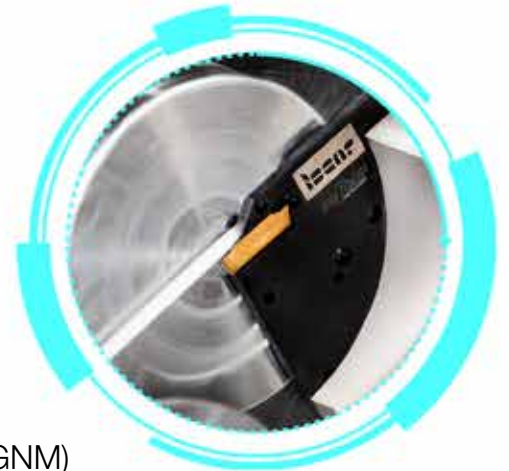


Parting with Extra Stability

DOFGRIP
TWISTED 2-SIDED

The New Square Blade with 4-Pocket Parting Concept Enables Mounting the Block on All Machine Types

- Vibration free, excellent surface finish and part straightness
- Parting up to 120mm diameter with 4,5mm double-sided insert
- Parting up to 120mm diameter with 3mm single-sided insert (DGNM)
- Guaranteed higher productivity
- Enables mounting of all types of DO-GRIP inserts



Double-Sided Insert



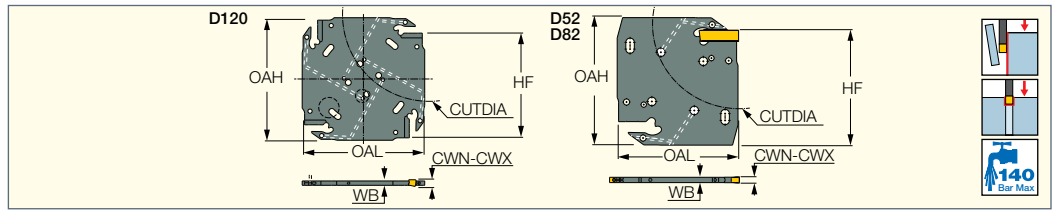
Economical
4-Pocket Blade

and Higher Productivity



DGAQ-JHP

Parting and Grooving Square
Blades for DO-GRIP Inserts



Designation	OAL	OAH	CWN ⁽¹⁾	CWX ⁽²⁾	WB	HF				CUTDIA	Inserts
DGAQ D52-2-2Z-JHP	50.00	50.0	1.90	2.50	1.72	43.5	SR M4X9-SEAL-JHP	JHP COPPER SEAL 1/8"	EDG 33A*	52.0	DG 2
DGAQ D52-3-2Z-JHP	50.00	50.0	3.00	3.18	2.50	43.5	SR M4X9-SEAL-JHP	JHP COPPER SEAL 1/8"	EDG 33A*	52.0	DG 3
DGAQ D52-4-2Z-JHP	50.00	50.0	4.00	4.00	3.20	43.5	SR M4X9-SEAL-JHP	JHP COPPER SEAL 1/8"	EDG 33A*	52.0	DG 4
DGAQ D82-3-2Z-JHP	61.00	64.4	3.00	3.18	2.50	58.0	SR M4X9-SEAL-JHP	JHP COPPER SEAL 1/8"	EDG 33A*	82.0	DG 3
DGAQ D82-4-2Z-JHP	61.00	64.4	4.00	4.00	3.20	58.0	SR M4X9-SEAL-JHP	JHP COPPER SEAL 1/8"	EDG 33A*	82.0	DG 4
DGAQ D82-5-2Z-JHP	61.00	64.4	5.00	5.00	4.00	58.0	SR M4X9-SEAL-JHP	JHP COPPER SEAL 1/8"	EDG 33A*	82.0	DG 5
DGAQ D120-4-4Z-JHP	90.50	90.5	4.00	4.00	3.20	84.0	SR M4X9-SEAL-JHP	JHP COPPER SEAL 1/8"	EDG 33A*	120.0	DG 4
DGAQ D120-5-4Z-JHP	90.50	90.5	5.00	5.00	4.00	84.0	SR M4X9-SEAL-JHP	JHP COPPER SEAL 1/8"	EDG 33A*	120.0	DG 5

• When using 2 and 3mm double-sided inserts, the depth of cut is limited up to 19mm. For larger depth, use a DGNM type single-ended insert.

* Optional, should be ordered separately

⁽¹⁾ Minimum cutting width

⁽²⁾ Maximum cutting width

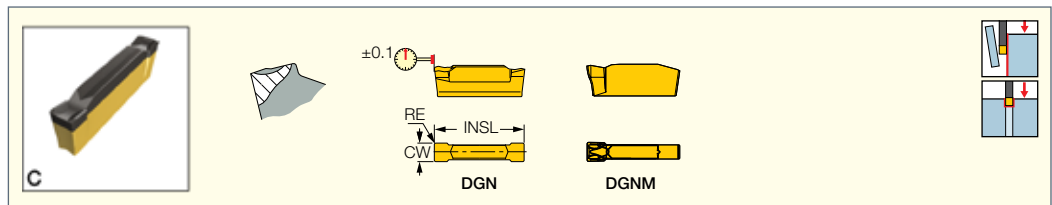
Flow Rate vs. Pressure

Designation	70 Bar Flow Rate (liters/min)	100 Bar Flow Rate (liters/min)	140 Bar Flow Rate (liters/min)
DGAQ D52-2-2Z-JHP			
DGAQ D52/82-3-2Z-JHP	4-7	5-8	6-9
DGAQ D52/82/120-4-...-JHP			
DGAQ D82/120-5-...-JHP	6-7	7-8	8-9



DGN/DGNM-C

Double-Sided Parting Inserts for
Parting and Grooving Bars, Hard
Materials and Tough Applications



Designation	Dimensions						Tough ↔ Hard									Recommended Machining Data	
	CW	CWTOL ⁽³⁾	RE	RETOL ⁽⁴⁾	CDX	INSL	IC830	IC1030	IC5400	IC1010	IC808	IC908	IC30N	IC20	IC807		IC907
DGN 2002C	2.00	0.03	0.20	0.020	18.00	19.90	•	•	•	•	•	•	•	•	•	•	0.05-0.16
DGN 2202C	2.20	0.03	0.20	0.020	18.00	19.80	•	•	•	•	•	•	•	•	•	•	0.05-0.16
DGN 2502C	2.50	0.03	0.20	0.020	18.00	20.70	•	•	•	•	•	•	•	•	•	•	0.08-0.20
DGN 3102C	3.10	0.04	0.20	0.020	18.00	20.10	•	•	•	•	•	•	•	•	•	•	0.10-0.25
DGNM 3202C ⁽²⁾	3.18	0.04	0.20	0.020	- ⁽⁵⁾	20.40						•					0.10-0.25
DGN 4003C	4.00	0.04	0.30	0.030	- ⁽⁵⁾	18.80	•				•	•	•	•	•	•	0.10-0.30
DGN 4803C	4.80	0.04	0.30	0.030	- ⁽⁵⁾	19.90					•	•	•	•	•	•	0.12-0.35
DGN 5003C	5.00	0.04	0.30	0.030	- ⁽⁵⁾	19.10	•				•	•	•	•	•	•	0.12-0.35

• Feed values for grade IC20 should be decreased by 50% • For full range see CMS Catalog

⁽²⁾ Single-ended insert

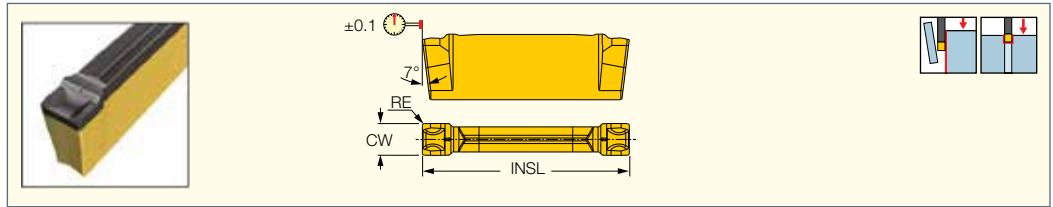
⁽³⁾ Cutting width tolerance (+/-)

⁽⁴⁾ Corner radius tolerance (+/-)

⁽⁵⁾ No depth limit

DGN-MF

Double-Sided Inserts for Parting and Grooving Soft and Hard Materials at Medium Feeds



Designation	Dimensions					Tough ↔ Hard					Recommended Machining Data
	CW	RE	CWTOL ⁽¹⁾	CDX ⁽²⁾	INSL	IC830	IC1030	IC5400	IC1010	IC808	f groove (mm/rev)
DGN 2002MF	2.00	0.20	0.04	18.00	19.90	●	●	●	●	●	0.04-0.12
DGN 2202MF	2.20	0.20	0.04	18.00	19.90		●		●		0.04-0.12
DGN 3002MF	3.00	0.20	0.04	18.00	20.10			●			0.06-0.18
DGN 3102MF	3.10	0.20	0.04	18.00	20.10	●	●	●	●	●	0.06-0.18
DGN 4003MF	4.00	0.30	0.04	- ⁽³⁾	18.80	●				●	0.08-0.20

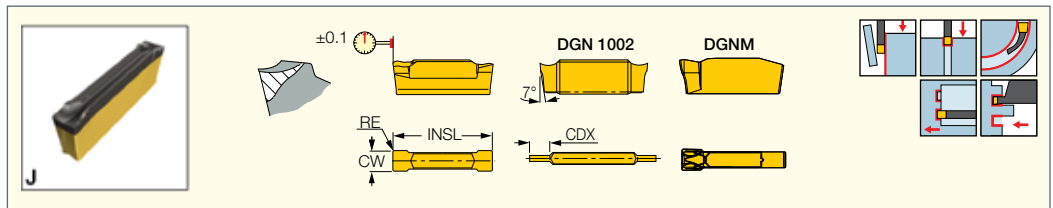
⁽¹⁾ Cutting width tolerance (+/-)

⁽²⁾ Cutting depth maximum

⁽³⁾ No depth limit

DGN/DGNM-J/JS/JT

Double-Sided Inserts for Parting and Grooving Soft Materials, Parting Tubes, Small Diameters and Thin-Walled Parts



Designation	Dimensions						Tough ↔ Hard							Recommended Machining Data		
	CW	CWTOL ⁽³⁾	RE	RETOL ⁽⁴⁾	CDX ⁽⁵⁾	INSL	IC830	IC1030	IC5400	IC1010	IC808	IC908	IC20	IC807	IC907	f groove (mm/rev)
DGN 2002JT	2.00	0.03	0.20	0.020	18.00	19.80					●					0.04-0.14
DGN 2200JS ⁽¹⁾	2.20	0.03	0.02	0.020	18.00	19.40	●									0.03-0.08
DGN 2202J	2.20	0.03	0.20	0.020	18.00	19.80	●	●	●	●	●	●	●	●		0.04-0.12
DGN 2202JT	2.20	0.03	0.20	0.020	18.00	19.80	●		●		●					0.04-0.14
DGN 3100JS ⁽¹⁾	3.10	0.04	0.02	0.020	18.00	19.70										0.03-0.10
DGN 3102J	3.10	0.04	0.20	0.020	18.00	20.10	●	●	●	●	●	●	●		●	0.04-0.16
DGN 3102JT	3.10	0.04	0.20	0.020	18.00	20.10	●		●		●				●	0.05-0.18
DGN 3202J	3.18	0.04	0.20	0.020	18.00	20.10					●					0.04-0.16
DGNM 3202J ⁽²⁾	3.18	0.04	0.20	0.020	- ⁽⁶⁾	20.30					●					0.04-0.16
DGN 4003J	4.00	0.04	0.30	0.030	- ⁽⁶⁾	18.90	●				●	●	●	●		0.05-0.18
DGN 4003JT	4.00	0.04	0.30	0.030	- ⁽⁶⁾	18.90	●				●					0.05-0.18
DGN 4803J	4.80	0.04	0.30	0.030	- ⁽⁶⁾	20.40					●					0.05-0.20
DGN 5003J	5.00	0.04	0.30	0.030	- ⁽⁶⁾	19.00	●				●	●				0.05-0.20
DGN 5003JT	5.00	0.04	0.30	0.030	- ⁽⁶⁾	19.00					●					0.05-0.20

• JT chipformer has the basic positive configuration of the J-type and a reinforced negative frontal edge; most suitable for soft materials at low to medium feeds

⁽¹⁾ Sharp corners

⁽²⁾ Single-ended insert

⁽³⁾ Cutting width tolerance (+/-)

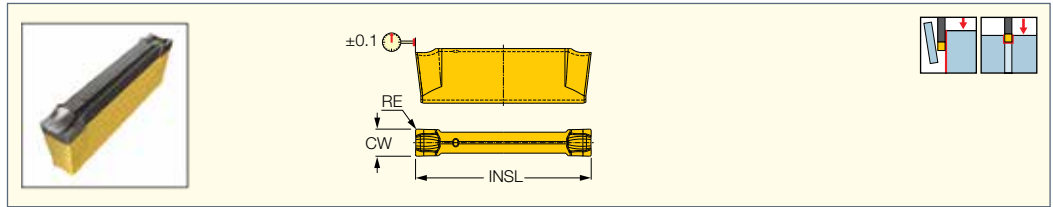
⁽⁴⁾ Corner radius tolerance (+/-)

⁽⁵⁾ Cutting depth maximum

⁽⁶⁾ No depth limit

DGN-LF/LFT

Double-Sided Inserts for Parting and Grooving Stainless Steel



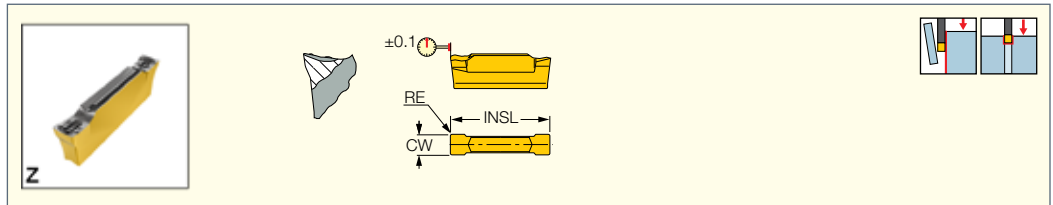
Designation	Dimensions						Tough ↔ Hard						Recommended Machining Data f groove (mm/rev)
	CW	CWTOL ⁽¹⁾	RE	RETOL ⁽²⁾	CDX ⁽³⁾	INSL	IC880	IC1030	IC5400	IC1010	IC808	IC908	
DGN 2002LF	2.00	0.03	0.20	0.020	18.00	19.80	•	•	•	•	•	•	0.03-0.08
DGN 2202LF	2.20	0.03	0.20	0.020	18.00	19.80	•	•	•	•	•	•	0.03-0.08
DGN 3102LF	3.10	0.04	0.20	0.020	18.00	20.10	•	•	•	•	•	•	0.04-0.10
DGN 3102LFT	3.10	0.04	0.20	0.020	18.00	21.10						•	0.04-0.12

• The LFT chipformer features basically the same design as the LF chipformer, except that it is reinforced by a T-land to improve its durability in interrupted-cut or on hard materials applications. It can be applied at higher feeds than the LF chipformer

- ⁽¹⁾ Cutting width tolerance (+/-)
- ⁽²⁾ Corner radius tolerance (+/-)
- ⁽³⁾ Cutting depth maximum

DGN-Z

Double-Sided Inserts for Parting Tubes, Thin-Walled and Small Parts

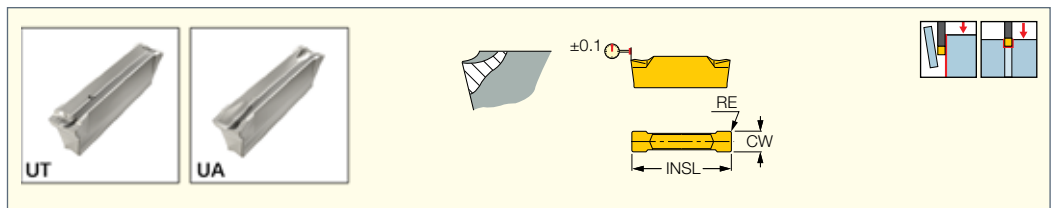


Designation	Dimensions						Tough ↔ Hard				Recommended Machining Data f groove (mm/rev)
	CW	CDX ⁽¹⁾	CWTOL ⁽²⁾	RE	RETOL ⁽³⁾	INSL	IC1080	IC1010	IC808	IC908	
DGN 2002Z	2.00	18.00	0.03	0.20	0.020	20.90	•	•	•	•	0.03-0.12
DGN 3002Z	3.00	18.00	0.03	0.20	0.020	20.90	•	•	•	•	0.03-0.16

- ⁽¹⁾ Cutting depth maximum
- ⁽²⁾ Cutting width tolerance (+/-)
- ⁽³⁾ Corner radius tolerance (+/-)

DGN-UT/UA

Double-Sided Inserts for Parting and Grooving Cr-Ni Alloys, Low Carbon Steel and Ductile Materials at Low Feeds

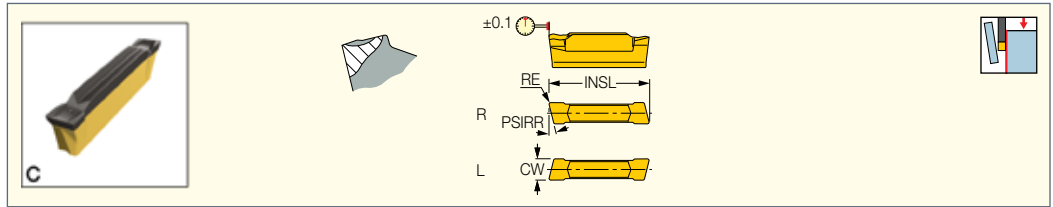


Designation	Dimensions						Tough ↔ Hard		Recommended Machining Data f groove (mm/rev)
	CW	CWTOL ⁽¹⁾	RE	RETOL ⁽²⁾	CDX ⁽³⁾	INSL	IC908	IC20	
DGN 2202UA	2.20	0.03	0.20	0.020	18.00	19.90			0.04-0.13
DGN 2202UT	2.20	0.03	0.20	0.020	18.00	19.60	•		0.03-0.11
DGN 3003UA	3.00	0.03	0.25	0.020	18.00	20.50		•	0.04-0.15
DGN 3003UT	3.00	0.03	0.25	0.020	18.00	20.50	•		0.04-0.13
DGN 4003UA	4.00	0.04	0.30	0.020	- ⁽⁴⁾	19.40			0.05-0.16
DGN 4003UT	4.00	0.04	0.30	0.020	- ⁽⁴⁾	19.30	•		0.04-0.15
DGN 5003UT	5.00	0.04	0.30	0.020	- ⁽⁴⁾	19.00	•		0.05-0.18

- ⁽¹⁾ Cutting width tolerance (+/-)
- ⁽²⁾ Corner radius tolerance (+/-)
- ⁽³⁾ Cutting depth maximum
- ⁽⁴⁾ No depth limit

DGR/L-C

Double-Sided Inserts for Parting Bars, Hard Materials and Tough Applications



Designation	Dimensions						Tough ↔ Hard				Recommended Machining Data f groove (mm/rev)
	CW	RE	CDX ⁽²⁾	PSIRL	PSIRR	INSL	IC830	IC808	IC908	IC20	
DGL 2202C-6D	2.20	0.20	18.00	6.0	-	20.80			●	●	0.04-0.12
DGR 2202C-6D	2.20	0.20	18.00	-	6.0	20.80	●	●	●	●	0.04-0.12
DGL 3102C-15D	3.10	0.20	18.00	15.0	-	21.00	●				0.08-0.14
DGL 3102C-6D	3.10	0.20	18.00	6.0	-	21.00	●	●	●	●	0.08-0.18
DGR 3102C-15D	3.10	0.20	18.00	-	15.0	20.90	●				0.08-0.14
DGR 3102C-6D	3.10	0.20	18.00	-	6.0	21.00	●	●	●	●	0.08-0.18
DGR 3102C-8D	3.10	0.20	18.00	-	8.0	21.10	●				0.05-0.15
DGL 4003C-4D	4.00	0.30	- ⁽³⁾	4.0	-	18.90			●	●	0.08-0.20
DGR 4003C-4D	4.00	0.30	- ⁽³⁾	-	4.0	18.80	●		●	●	0.08-0.20
DGR 4800CS-4D	4.80	0.02	- ⁽³⁾	-	4.0	19.70					0.05-0.15
DGR 4800CS-8D	4.80	0.02	- ⁽³⁾	-	8.0	19.70					0.05-0.15
DGR 4803C-4D	4.80	0.30	- ⁽³⁾	-	4.0	20.30					0.10-0.25
DGR 4803C-8D	4.80	0.30	- ⁽³⁾	-	8.0	20.30					0.10-0.20
DGL 5003C-4D	5.00	0.30	- ⁽³⁾	4.0	-	19.10				●	0.10-0.25
DGR 5003C-4D	5.00	0.30	- ⁽³⁾	-	4.0	19.20				●	0.10-0.25

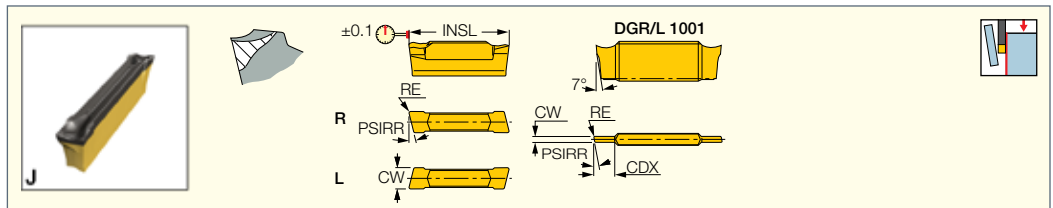
• Feed values for grade IC20 should be decreased by 50%

⁽²⁾ Cutting depth maximum

⁽³⁾ No depth limit

DGR/L-J/JS

Double-Sided Inserts for Parting Soft Materials, Parting Tubes, Small Diameters and Thin-Walled Parts



Designation	Dimensions						Tough ↔ Hard				Recommended Machining Data f groove (mm/rev)
	CW	RE	CDX ⁽²⁾	INSL	PSIRL	PSIRR	IC830	IC808	IC908	IC20	
DGL 2200JS-15D ⁽¹⁾	2.20	0.02	18.00	20.60	15.0	-			●		0.03-0.07
DGL 2200JS-6D ⁽¹⁾	2.20	0.02	18.00	20.60	6.0	-			●		0.03-0.08
DGR 2200JS-15D ⁽¹⁾	2.20	0.02	18.00	20.60	-	15.0			●	●	0.03-0.07
DGR 2200JS-6D ⁽¹⁾	2.20	0.02	18.00	20.60	-	6.0	●		●		0.03-0.08
DGL 2202J-6D	2.20	0.20	18.00	21.00	6.0	-			●	●	0.03-0.10
DGR 2202J-15D	2.20	0.20	18.00	21.00	-	15.0	●				0.03-0.08
DGR 2202J-6D	2.20	0.20	18.00	21.00	-	6.0	●		●	●	0.03-0.10
DGL 3100JS-15D ⁽¹⁾	3.10	0.02	18.00	20.60	15.0	-			●		0.03-0.07
DGL 3100JS-6D ⁽¹⁾	3.10	0.02	18.00	20.60	6.0	-			●		0.03-0.08
DGR 3100JS-15D ⁽¹⁾	3.10	0.02	18.00	20.60	-	15.0	●		●		0.03-0.07
DGR 3100JS-6D ⁽¹⁾	3.10	0.02	18.00	20.60	-	6.0	●		●		0.03-0.08
DGL 3102J-15D	3.10	0.20	18.00	21.00	15.0	-			●		0.04-0.10
DGL 3102J-6D	3.10	0.20	18.00	21.00	6.0	-	●		●	●	0.04-0.14
DGR 3102J-15D	3.10	0.20	18.00	21.00	-	15.0			●		0.04-0.10
DGR 3102J-6D	3.10	0.20	18.00	21.00	-	6.0	●	●	●	●	0.04-0.14
DGR 4000JS-15D ⁽¹⁾	4.00	0.20	- ⁽³⁾	19.30	-	15.0					0.04-0.10
DGL 4003J-4D	4.00	0.30	- ⁽³⁾	18.90	4.0	-			●	●	0.04-0.15
DGR 4003J-4D	4.00	0.30	- ⁽³⁾	18.90	-	4.0	●	●	●	●	0.04-0.15
DGR 4800JS-4D ⁽¹⁾	4.80	0.03	- ⁽³⁾	19.80	-	4.0					0.04-0.12
DGR 4800JS-8D ⁽¹⁾	4.80	0.03	- ⁽³⁾	19.80	-	8.0					0.04-0.14
DGR 4803J-4D	4.80	0.30	- ⁽³⁾	19.80	-	4.0					0.04-0.18
DGR 4803J-8D	4.80	0.30	- ⁽³⁾	19.80	-	8.0					0.04-0.15
DGL 5003J-4D	5.00	0.30	- ⁽³⁾	19.80	4.0	-					0.05-0.20
DGR 5003J-4D	5.00	0.30	- ⁽³⁾	19.80	-	4.0				●	0.05-0.20

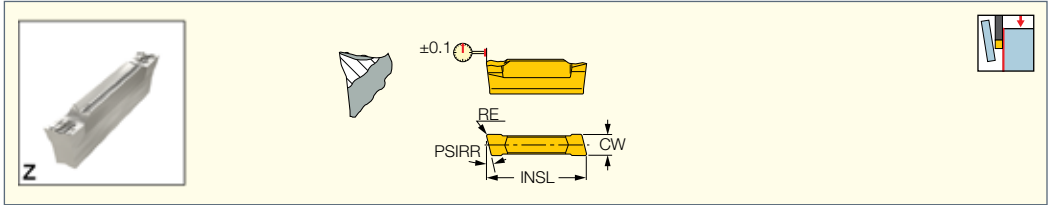
⁽¹⁾ Sharp corners

⁽²⁾ Cutting depth maximum

⁽³⁾ No depth limit

DGR-Z/ZS

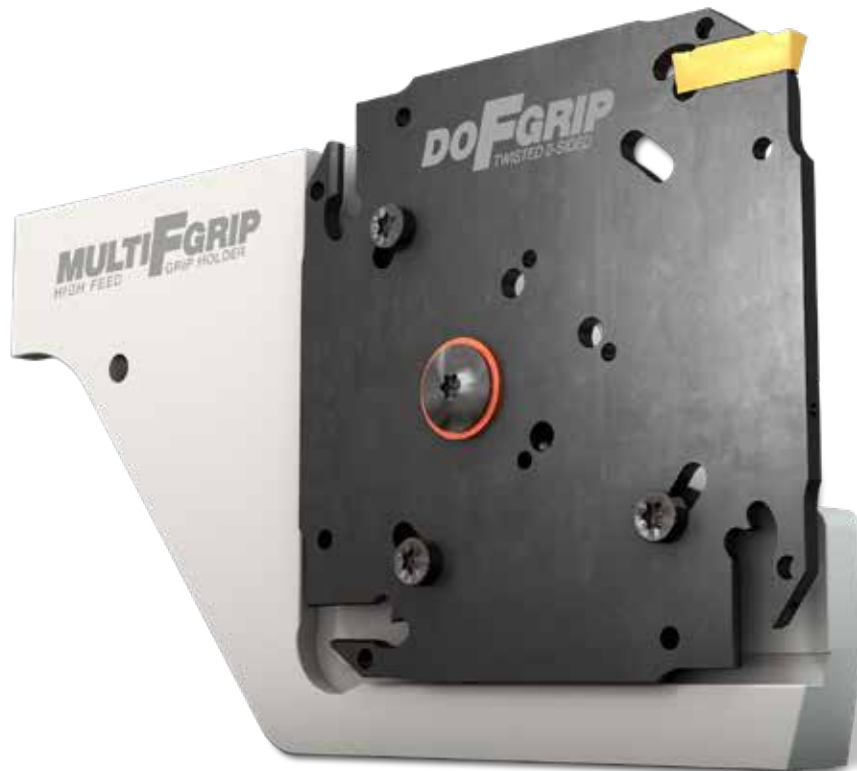
Double-Sided Inserts with Very Positive Rake for Parting Tubes and Thin-Walled and Small Parts



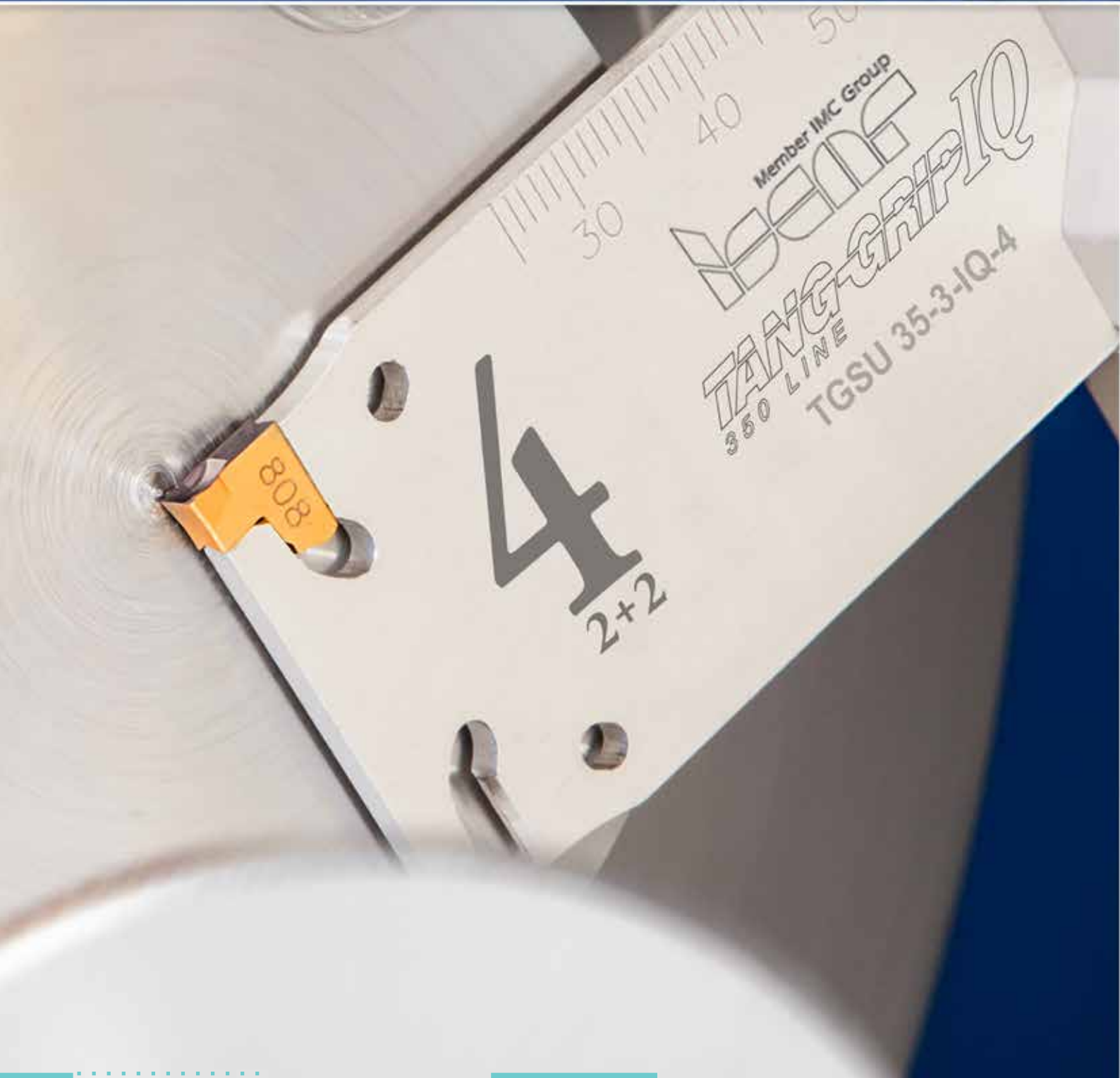
Designation	Dimensions						IC908	Recommended Machining Data
	CW	RE	INSL	CDX ⁽²⁾	PSIRR	f groove (mm/rev)		
DGR 2000ZS-15D ⁽¹⁾	2.00	0.02	20.40	18.00	15.0	●	0.03-0.07	
DGR 2000ZS-6D ⁽¹⁾	2.00	0.02	20.40	18.00	6.0	●	0.03-0.08	
DGR 2002Z-15D	2.00	0.20	20.90	18.00	15.0	●	0.03-0.10	
DGR 2002Z-6D	2.00	0.20	20.90	18.00	6.0	●	0.03-0.10	
DGR 3000ZS-15D ⁽¹⁾	3.00	0.02	20.40	18.00	15.0	●	0.03-0.10	
DGR 3000ZS-6D ⁽¹⁾	3.00	0.02	20.40	18.00	6.0	●	0.03-0.12	
DGR 3002Z-6D	3.00	0.20	20.90	18.00	6.0	●	0.03-0.14	

⁽¹⁾ Sharp corners

⁽²⁾ Cutting depth maximum



Parting with Extra Stability



TANG-GRIP IQ
350 LINE

**Economical Blade with 4 Pockets,
Flat Top for Excellent Chip Evacuation**

and Higher Productivity

TANG-GRIP IQ 350 LINE

Flat Top TANG-GRIP IQ Blades Engineered for Easy Chip Flow

Economical Blade

- Offers free, unobstructed chip flow, since there is no upper jaw as in other clamping systems (very important in parting large diameters and deep grooving applications)
- For **TANG-GRIP** single-ended parting insert with an unbeatable clamping method



Rigid Clamping



Cost Effective



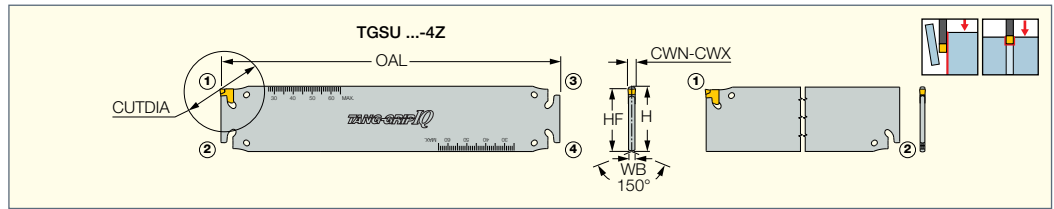
High Productivity



Deep Parting

TGSU

Parting and Grooving Flat Top Blades with Tangential Pockets Carrying TANG-GRIP Single-Ended Inserts



Designation	H	CWN ⁽²⁾	CWX ⁽³⁾	CUTDIA	NOP ⁽⁴⁾	WB	OAL	HF	CSP ⁽⁵⁾	Insert	
TGSU 35-1.4-IQ	35.0	1.40	1.40	35.0	2	2.50 ⁽⁶⁾	180.00	33.2	0	TAG 1.4	ETG 1.4/1.6*
TGSU 35-2-IQ	35.0	1.80	2.40	59.5	2	2.50 ⁽⁷⁾	160.00	33.2	0	TAG 2	ETG 2*
TGSU 35-3-IQ-4Z	35.0	2.80	3.50	120.0	4	2.50	180.00	33.2	0	TAG 3	ETG 3-4-SH*
TGSU 35-4-IQ-4Z	35.0	3.70	4.50	120.0	4	3.40	180.00	33.2	0	TAG 4	ETG 3-4-SH*
TGSU 35-5-IQ	35.0	4.70	5.50	144.0	2	4.00	180.00	33.2	0	TAG 5	ETG 5-7*
TGSU 35-6-IQ	35.0	5.70	6.50	144.0	2	5.20	180.00	33.2	0	TAG 6	ETG 5-7*
TGSU 35-7-IQ	35.0	6.80	7.50	144.0	2	6.00	180.00	33.2	0	TAG 7	ETG 5-7*
TGSU 35C-8-IQ ⁽¹⁾	35.0	7.70	8.50	144.0	2	7.20	180.00	33.2	1	TAG 8	ETG 8-12*
TGSU 35C-9-IQ ⁽¹⁾	35.0	8.70	10.00	144.0	2	8.20	180.00	33.2	1	TAG 9	ETG 8-12*
TGSU 56C-7-IQ ⁽¹⁾	56.0	6.80	7.50	220.0	2	6.00	260.00	53.6	1	TAG 7	ETG 5-7*
TGSU 56C-8-IQ ⁽¹⁾	56.0	7.70	8.50	220.0	2	7.20	260.00	53.6	1	TAG 8	ETG 8-12
TGSU 56C-9-IQ ⁽¹⁾	56.0	8.70	10.00	220.0	2	8.20	260.00	53.6	1	TAG 9	ETG 8-12*

⁽¹⁾ C - Internal coolant, use with TGTBU HD blocks only; cooling tube SGCU 341 should be ordered separately

⁽²⁾ Minimum cutting width

⁽³⁾ Maximum cutting width

⁽⁴⁾ Number of pockets

⁽⁵⁾ 0 - Without coolant supply, 1 - With coolant supply

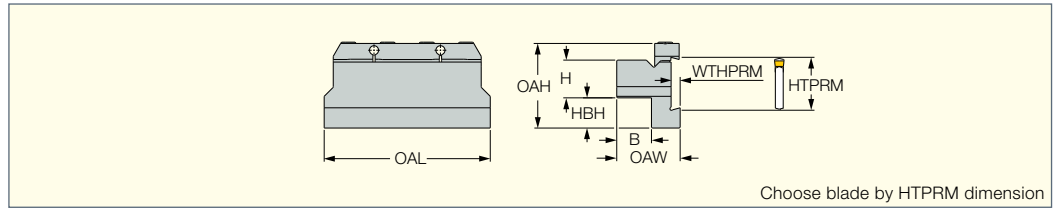
⁽⁶⁾ Thickness at the D.O.C. area is 1.05 mm

⁽⁷⁾ Thickness at the D.O.C. area is 1.65 mm

* Optional, should be ordered separately

TGTBU

Tool Blocks for TGSU Parting and Grooving Blades



Designation	H	B	HTPRM	WTHPRM	OAW	OAH	HBH	OAL			
TGTBU 20-35	20.0	19.0	35.0	6.00	38.00	56.0	23.7	110.00	BKU 110	SR M6X16 DIN912	HW 5.0
TGTBU 25-35	25.0	23.0	35.0	6.00	42.00	56.0	18.7	110.00	BKU 110	SR M6X16 DIN912	HW 5.0
TGTBU 32-35	32.0	29.0	35.0	6.00	48.00	56.0	11.7	110.00	BKU 110	SR M6X16 DIN912	HW 5.0
TGTBU 32-35 HD ⁽¹⁾	32.0	30.0	35.0	8.00	55.00	64.0	18.0	130.00	BK 509	SR M8X20 DIN912	HW 6.0
TGTBU 40-35	40.0	41.0	35.0	6.00	60.00	56.0	3.7	110.00	BKU 110	SR M6X16 DIN912	HW 5.0
TGTBU 40-35 HD ⁽¹⁾	40.0	41.0	35.0	8.00	66.00	64.0	10.0	130.00	BK 509	SR M8X20 DIN912	HW 6.0
TGTBU 40-56 HD ⁽¹⁾	40.0	41.0	56.0	8.00	66.00	72.0	28.0	130.00	BK 509	SR M8X20 DIN912	HW 6.0

⁽¹⁾ HD - recommended blocks for TGSU...-8, TGSU...-9 blades

*For inserts in width 1.4, 6, 7, 8, 9 mm refer to the full ISCAR Catalog





808

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In

Out

ISCAR's Unique, Innovative,



DO-GRIP



Double-Sided
Twisted Parting Insert
with no Depth of
Cut Limitation



PENTA IQ GRIP
PARTING LINE



Powerful Insert with
5 Edges for Accurate
Parting and Grooving
Operations



Trendsetting Parting Systems



TANG-GRIP IQ
350 LINE



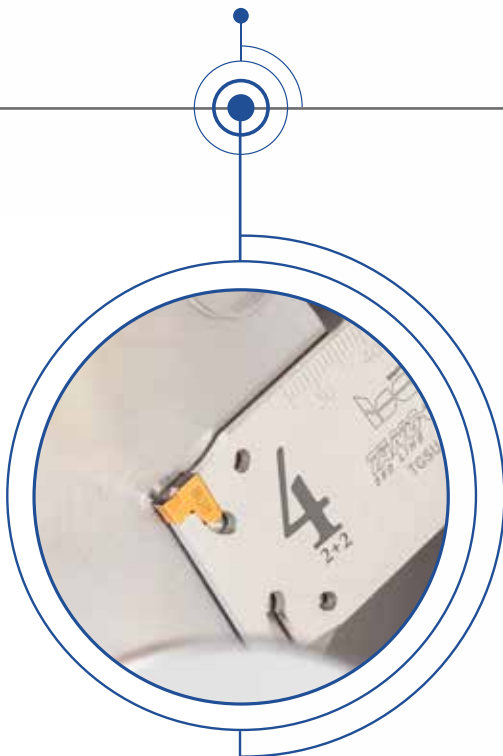
New Flat Top Tools
Engineered for Easy
Chip Flow and
Higher Productivity



MULTIFGRIP
HIGH FEED GRIP HOLDER



Reinforced and Robust
Tool Provides
Extra Stability and
Higher Productivity





Parting up to 120mm



**Parting from the Smallest to the Largest Diameter
with ISCAR's Square Blades**

