DCGT-ML

ZANHO Cutting Tools



Feature

ZANHO **DCGT-ML series**: Precision ground **55° diamond inserts** featuring the ML chipbreaker for high-performance finishing. Optimized for **Stainless Steel** and **Hardened Steel (50HRC+)**, these

inserts deliver exceptional surface quality at high line speeds. Engineered for stable chip control and low cutting forces in intricate CNC profiling.

Descriptions

Technical Features

- **55° Diamond Profile:** Ideal for complex profiling and finishing in narrow access areas.
- **ML Chipbreaker:** Engineered for mandatory chip curling in adhesive and hardened materials.
- **Dual-Material Focus:** High efficiency on both Stainless Steel and Hardened Steel (50HRC+).
- **High Speed Stability:** Supports line speeds up to 200 m/min on stainless steel.
- **Precision Ground:** G-class tolerance ensures maximum repeatability and edge sharpness.

DCGT-ML Dimensions (mm)

Designation	L	øI.C	S	D1	RE
DCGT070201-ML	7.8	6.35	2.38	2.8	0.1
DCGT070202-ML					0.2
DCGT070204-ML					0.4
DCGT11T301-ML	11.6	9.525	3.97	4.4	0.1
DCGT11T302-ML					0.2
DCGT11T304-ML					0.4

Recommended Cutting Parameters

Tip Radius (RE)	ap (mm)	Vc Stainless (m/min)	Vc HRC50+ (m/min)	f (mm/rev)
R0.1	0.05-1.0	70-200	30-70	0.01-0.05
R0.2	0.08-1.5			0.02-0.08
R0.4	0.15-2.5			0.03-0.15