T-REX Tool Holders

RIGIDITY - ECONOMY - PRECISION

The Biting Force Behind

SumiTurn T-REX

● T-REX clamping for maximum rigidity 50% more cutting edges than a DNMG Insert

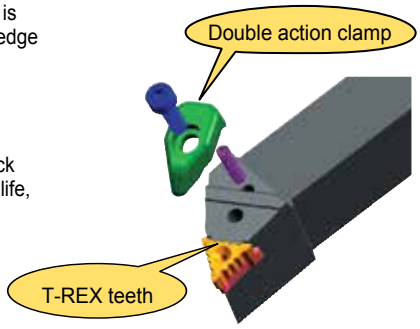
■ Advantages

● T-REX Inserts for Maximum Economy

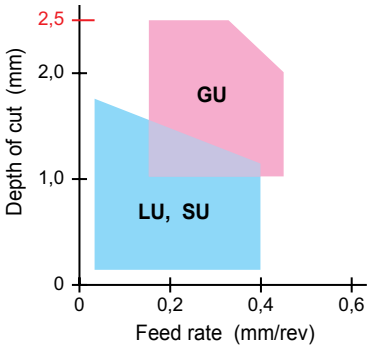
With 6 cutting edges and a 55 degree included angle - T-Rex is the intelligent alternative to profile turning with a traditional 4 edge DNMG insert.

● Biting Performance from T-REX Teeth

The double clamp tool holder and powerful teeth of T-REX lock the insert to eliminate movement, dramatically improving tool life, machining accuracy, and cutting edge security.

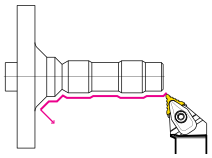


● Application Range

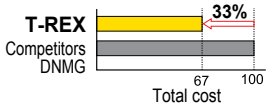


■ Application Examples

● 20Cr4 Shaft

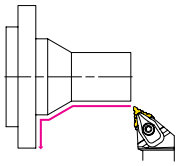


[Results]
33% cost saving

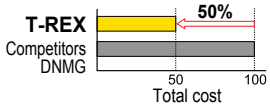


Insert: TRM551708-GU, AC2000
Cutting data: v_c= 150m/min, f = 0,25mm/rev, d_{oc} < 2,0mm, Wet

● 25CrMo4 Gear



[Results]
1,3 times long tool life



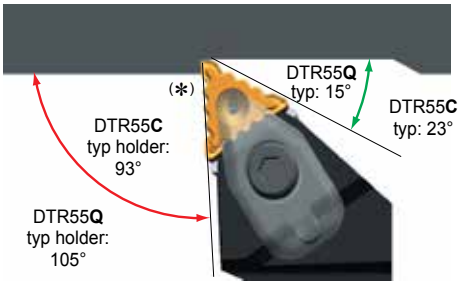
Insert: TRM551708-LU, AC900G
Cutting data: v_c= 220m/min, f = 0,2~0,3mm/rev, d_{oc} < 1,0mm, Wet

■ Recommendations

● Depth of Cut

Max. a_p = 2,5 mm

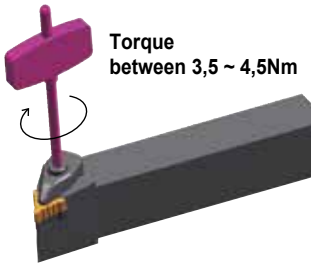
● Approach Angle



(*) Angle of major cutting edge

C-Type: 95,5°
Q-Type: 107,5°

● Insert Clamping



● = Eurostock
○ = Japanstock

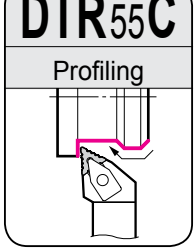
▲ = To be replaced by new item

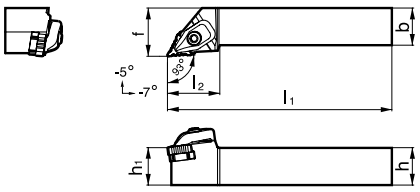
Recommended Tightening Torque (N·m)

SumiTurn

External Turning & Copying

DTR55C
Profiling



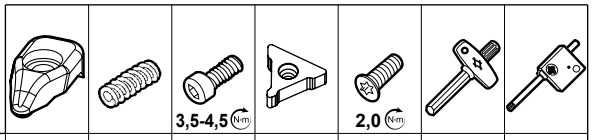


Holders

Above figures show right hand tools.

Ordering No.	Stock R	Stock L	h	h_1	b	l_1	l_2	f
DTR 55C-R/L 2020–K17	●	●	20	20	20	125	35	25
DTR 55C-R/L 2525–M17	●	●	25	25	25	150	35	32

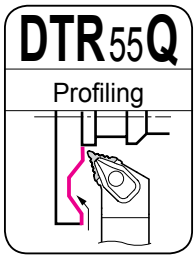
Spare Parts

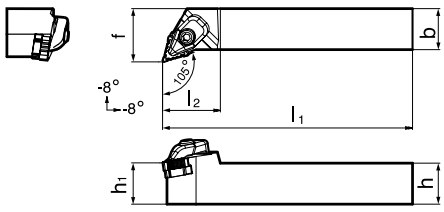


Clamp	Spring	Screw	Shim	Screw	Wrench	Wrench
TRCP3	S-SP4-20	BX0520	TRW5505	BFTX0307N	TSW040	TRX10(*)

(*) Note: Wrench (TRX) for shim clamp screw is not included.

DTR55Q
Profiling



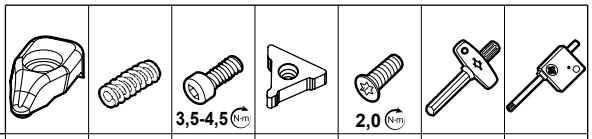


Holders

Above figures show right hand tools.

Ordering No.	Stock R	Stock L	h	h_1	b	l_1	l_2	f
DTR 55Q-R/L 2020–K17	●	●	20	20	20	125	35	28,5
DTR 55Q-R/L 2525–M17	●	●	25	25	25	150	35	32

Spare Parts



Clamp	Spring	Screw	Shim	Screw	Wrench	Wrench
TRCP3	S-SP4-20	BX0520	TRW5505	BFTX0307N	TSW040	TRX10(*)

(*) Note: Wrench (TRX) for shim clamp screw is not included.

Inserts

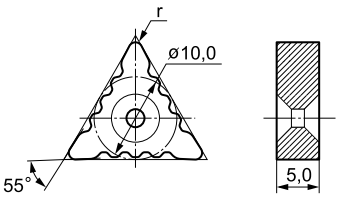
● Type **LU**

● Type **SU**

Application P Steel
M Stainles steel

	Ordering No.	r	AC900G	AC810P	AC820P	AC830P	AC2000	AC3000	AC610M	AC630M	T2000Z	T3000Z
			Coated Carbide								Coated Cermet	
Finishing	TRM 551704 -LU	0,4	▲	●	●		▲	▲			▲	❍
	TRM 551708 -LU	0,8	▲	●	●		▲	▲			▲	❍
	TRM 551712 -LU	1,2	▲	●	●			▲			▲	❍
	TRM 551704 -SU	0,4			❍				●	●	▲	❍
	TRM 551708 -SU	0,8			❍				●	●	▲	❍
	TRM 551712 -SU	1,2			❍				●	●	▲	❍

● Type **GU**



	Ordering No.	r	AC900G	AC810P	AC820P	AC830P	AC2000	AC3000	AC610M	AC630M	T2000Z	T3000Z
			Coated Carbide								Coated Cermet	
Light Cut	TRM 551704 -GU	0,4	▲	●	●	●	▲	▲		●		
	TRM 551708 -GU	0,8	▲	●	●	●	▲	▲		●		
	TRM 551712 -GU	1,2	▲	●	●	●	▲	▲		❍		

● Recommended Cutting Conditions

Cutting speed (m/min)

Grade		Coated Carbide AC810P	AC820P (AC2000)	AC830P (AC3000)	AC610M	AC630M	Coated Cermet T2000Z	T3000Z
Work materials	Low carbon steel	220 400	150 350	120 300	180 350	120 300	100 400	100 350
	Alloy steel	150 300	100 250	80 200	180 300	80 230	100 300	100 250
	Stainless steel			50 150	130 210	100 160		
Application range	Finishing	◎	❍	❍	◎	❍	◎	◎
	Medium cutting	❍	◎	❍	❍	◎	❍	❍
	Interrupted cutting		❍	◎		❍		❍

◎ Preferred choice ❍ Suitable