

Imperial version

PARTING 4x FASTER

Pockets
Profitability
Productivity
Performance

MULTIFGRIP
HIGH FEED GRIP HOLDER

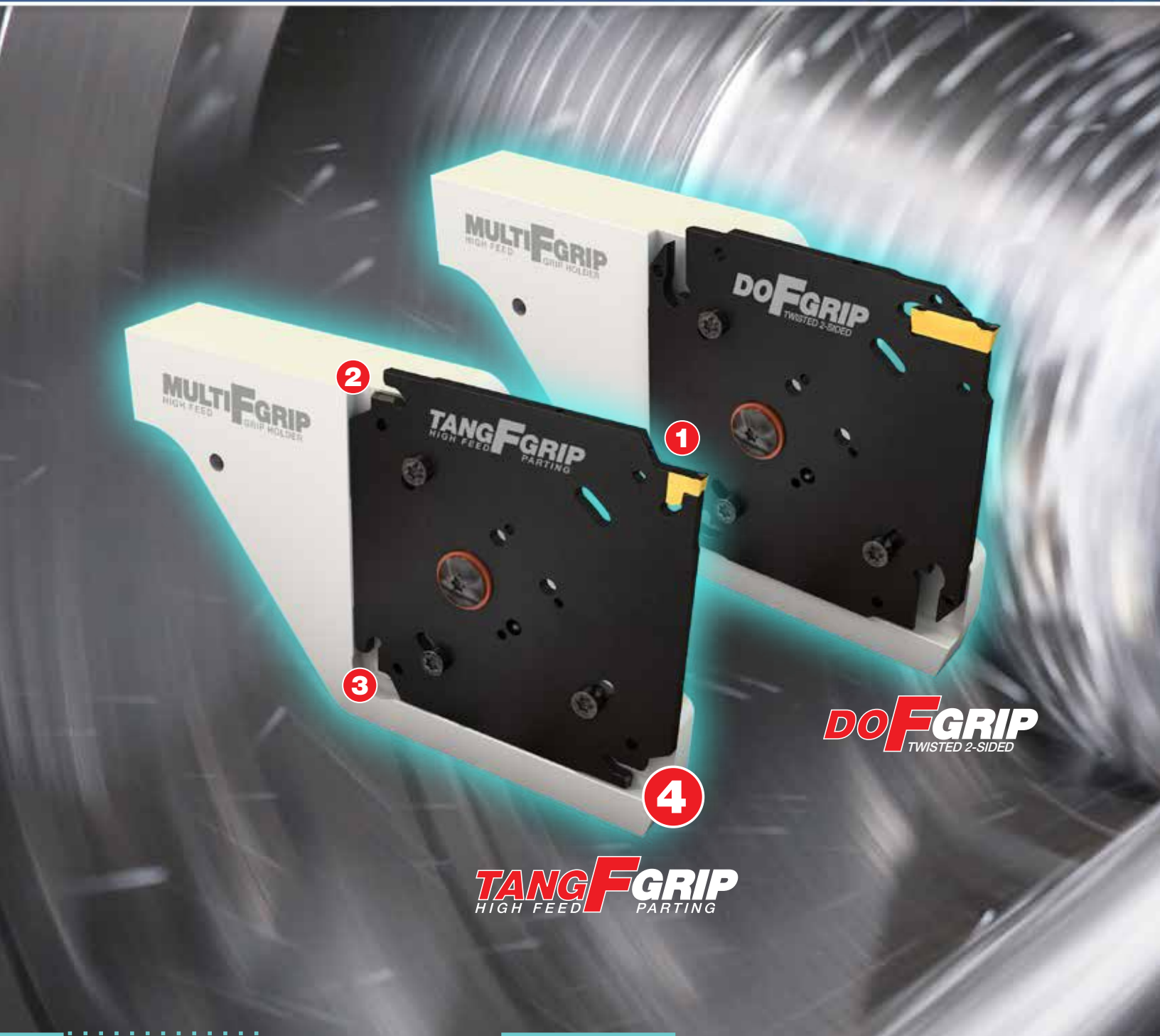


TANG-GRIP IQ
350 LINE

TANGFGRIP
HIGH FEED PARTING

DOFGRIP
TWISTED 2-SIDED

Parting with Extra Stability



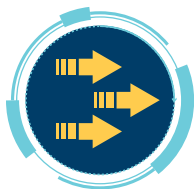
MULTI FGRIP
HIGH FEED GRIP HOLDER

**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



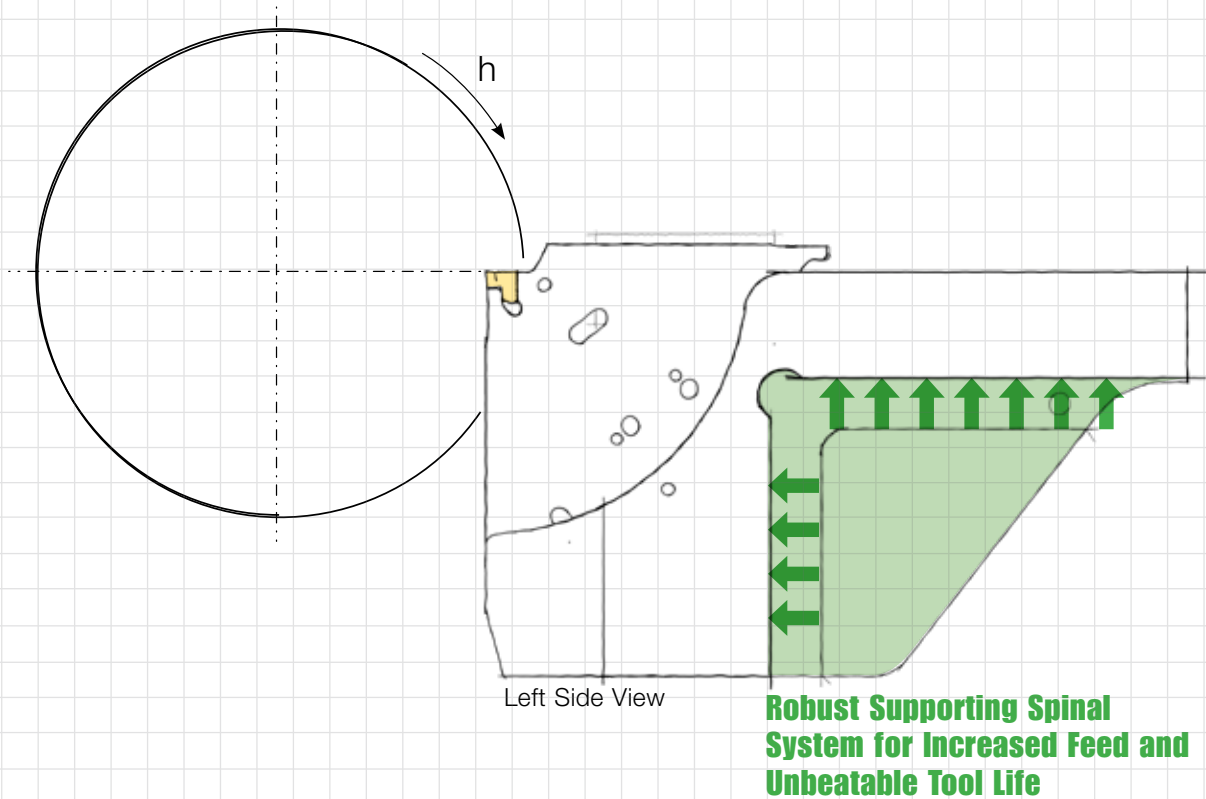
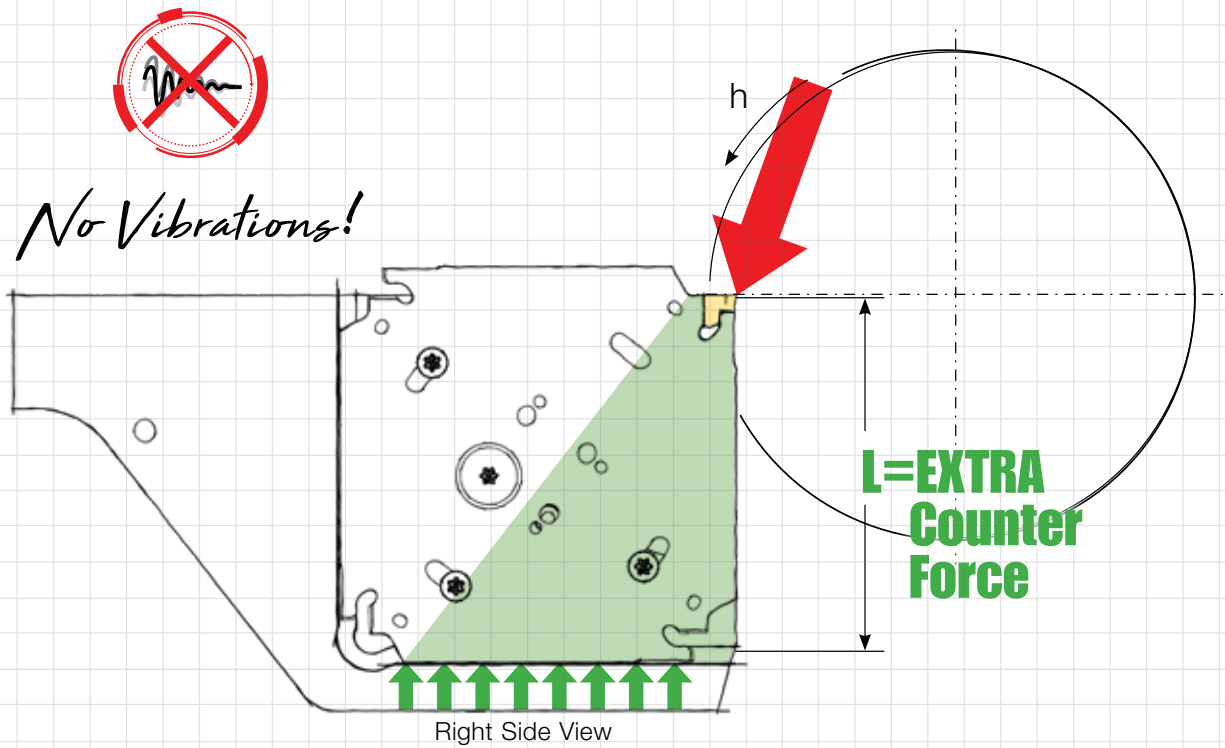
Cost Effective



Anti-Vibration

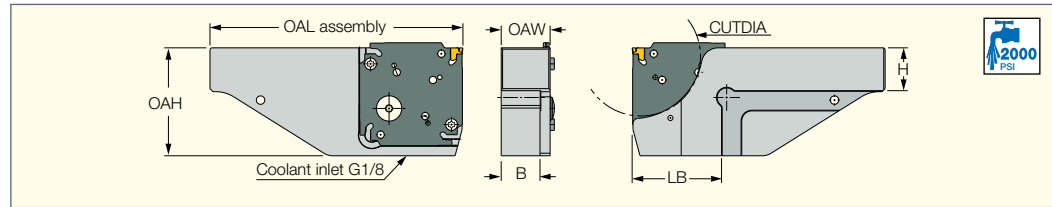
MULTI**F**GRIP

HIGH FEED GRIP HOLDER



TGTBQ-JHP

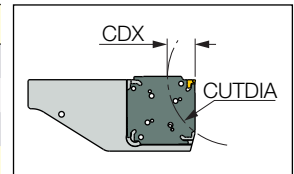
Tool Blocks for Parting and Grooving Square Blades
Tang-F-Grip & Do-F-Grip for High Pressure Coolant



Designation	OAH	H	B	OAW	OAL	LB	CUTDIA
TGTBQ 19L-D52-JHP	1.97	.750	.772	1.008	4.803	1.339	2.05
TGTBQ 19R-D52-JHP	1.97	.750	.772	1.008	4.803	1.339	2.05
TGTBQ 25.4L-D52-JHP	1.97	1.000	1.024	1.260	5.197	1.339	2.05
TGTBQ 25.4R-D52-JHP	1.97	1.000	1.024	1.260	5.197	1.339	2.05
TGTBQ 19L-D82-JHP	2.52	.750	.772	1.008	5.512	2.087	3.22
TGTBQ 19R-D82-JHP	2.52	.750	.772	1.008	5.512	2.087	3.22
TGTBQ 25.4L-D82-JHP	2.52	1.000	1.024	1.260	5.906	2.087	3.22
TGTBQ 25.4R-D82-JHP	2.52	1.000	1.024	1.260	5.906	2.087	3.22
TGTBQ 31.8L-D82-JHP	2.52	1.250	1.280	1.516	5.925	2.106	3.22
TGTBQ 31.8R-D82-JHP	2.52	1.250	1.280	1.516	5.925	2.106	3.22
TGTBQ 25.4L-D120-JHP	3.74	1.000	1.024	1.260	6.496	2.638	4.72
TGTBQ 25.4R-D120-JHP	3.74	1.000	1.024	1.260	6.496	2.638	4.72
TGTBQ 31.8L-D120-JHP	3.74	1.250	1.280	1.516	6.496	2.638	4.72
TGTBQ 31.8R-D120-JHP	3.74	1.250	1.280	1.516	6.496	2.638	4.72

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

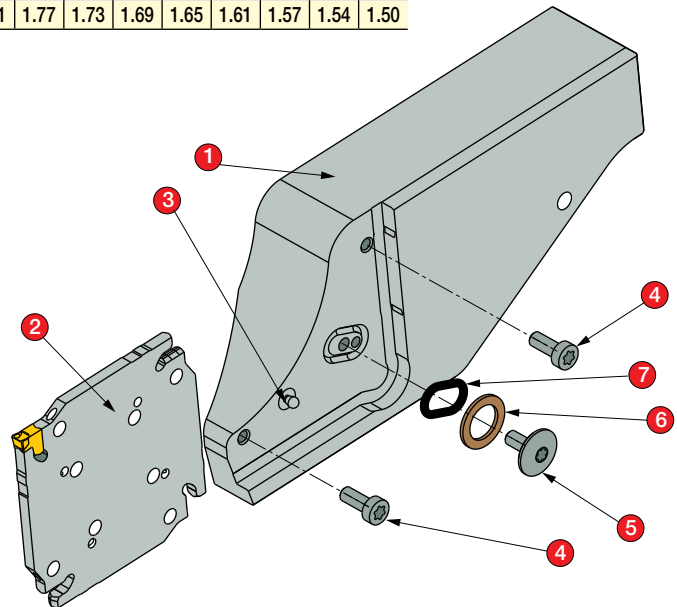
Designation	CUTDIA															
TGTBQ...D52-JHP	2.09	2.13	2.17	2.20	2.24	2.32	2.40	2.52	2.64	2.80	2.95	3.19	3.46	3.78	4.21	4.80
TGTBQ...D82-JHP	4.21	4.33	4.49	4.69	4.88	5.12	5.39	5.71	6.06	6.50	7.01	7.64	8.39	9.33	10.51	12.13
TGTBQ...D120-JHP	7.95	8.27	8.62	9.02	9.45	9.96	10.51	11.14	11.89	12.76	13.74	14.96	16.42	18.19	20.39	23.31
CDX	.83	.79	.75	.71	.67	.63	.59	.55	.51	.47	.43	.39	.35	.31	.28	.24



Designation	CUTDIA															
TGTBQ...D82-JHP	3.27	3.27	3.31	3.31	3.35	3.39	3.43	3.46	3.50	3.58	3.62	3.70	3.78	3.86	3.98	4.06
TGTBQ...D120-JHP	5.47	5.55	5.63	5.71	5.83	5.91	6.02	6.14	6.30	6.46	6.61	6.77	6.97	7.20	7.40	7.68
CDX	1.46	1.42	1.38	1.34	1.30	1.26	1.22	1.18	1.14	1.10	1.06	1.02	.98	.94	.91	.87

Designation	CUTDIA															
TGTBQ...D120-JHP	4.76	4.80	4.84	4.84	4.88	4.92	4.92	4.96	5.00	5.04	5.08	5.12	5.16	5.20	5.28	5.31
CDX	2.20-2.36	2.09-2.17	2.05	2.01	1.97	1.93	1.89	1.85	1.81	1.77	1.73	1.69	1.65	1.61	1.57	1.54

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

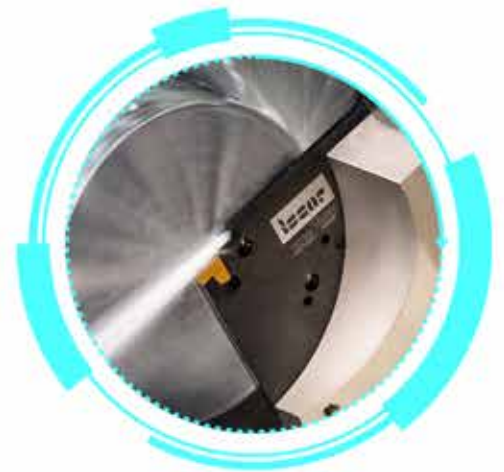
Designation						
TGTBQ-JHP	SR M4X9-SEAL-JHP	SIDE THRUST PIN 3mm	JHP COPPER SEAL 1/8"	SR ISO 14580 M4X10	SW6-SD	BLD T20/S7

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 4.72" diameter with .118" 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



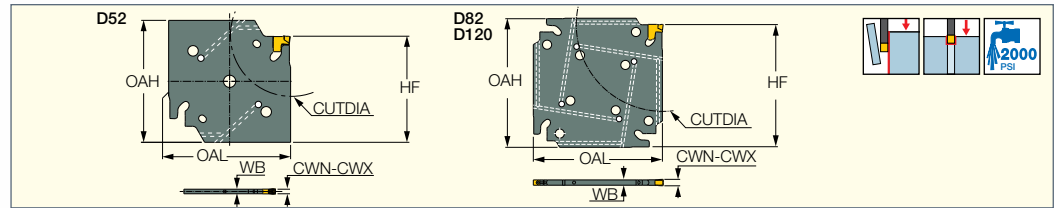
Economical
4-Pocket Blade

and Higher Productivity

TANG-GRIP
HIGH FEED PARTING

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	1.968	1.97	.071	.098	.065	1.713	2.05	TAG 2
TGAQ D52-3-2Z-JHP	1.968	1.97	.110	.138	.098	1.713	2.05	TAG 3
TGAQ D52-4-2Z-JHP	1.968	1.97	.146	.177	.134	1.713	2.05	TAG 4
TGAQ D82-2-4Z-JHP	2.402	2.40	.071	.098	.065	2.283	3.23	TAG 2
TGAQ D82-3-4Z-JHP	2.402	2.40	.110	.138	.098	2.283	3.23	TAG 3
TGAQ D82-4-4Z-JHP	2.402	2.40	.146	.177	.134	2.283	3.23	TAG 4
TGAQ D120-3-4Z-JHP	3.563	3.56	.110	.138	.098	3.307	4.72	TAG 3
TGAQ D120-4-4Z-JHP	3.563	3.56	.146	.177	.134	3.307	4.72	TAG 4
TGAQ D120-5-4Z-JHP	3.563	3.56	.185	.217	.157	3.307	4.72	TAG 5

• Suitable for all TANG-GRIP inserts

⁽¹⁾ Minimum cutting width

⁽²⁾ Maximum cutting width

Flow Rate vs. Pressure

Designation	1000 PSI Flow Rate (GPM)	1450 PSI Flow Rate (GPM)	2000 PSI Flow Rate (GPM)
TGAQ D52/82/120-2-...-JHP	1.1-1.9	1.3-2.1	1.6-2.4
TGAQ D52/82/120-3-...-JHP			
TGAQ D52/82/120-4-...-JHP	1.6-1.9	1.9-2.1	2.1-2.4
TGAQ D120-5-4Z-JHP			

Spare Parts

Designation			
TGAQ D52-2-2Z-JHP	SR M4X9-SEAL-JHP	JHP COPPER SEAL 1/8"	ETG 2"
TGAQ D52-3-2Z-JHP	SR M4X9-SEAL-JHP	JHP COPPER SEAL 1/8"	ETG 3-4-SH*
TGAQ D52-4-2Z-JHP	SR M4X9-SEAL-JHP	JHP COPPER SEAL 1/8"	ETG 3-4-SH*
TGAQ D82-2-4Z-JHP	SR M4X9-SEAL-JHP	JHP COPPER SEAL 1/8"	ETG 2"
TGAQ D82-3-4Z-JHP	SR M4X9-SEAL-JHP	JHP COPPER SEAL 1/8"	ETG 3-4-SH*
TGAQ D82-4-4Z-JHP	SR M4X9-SEAL-JHP	JHP COPPER SEAL 1/8"	ETG 3-4-SH*
TGAQ D120-3-4Z-JHP	SR M4X9-SEAL-JHP	JHP COPPER SEAL 1/8"	ETG 3-4-SH*
TGAQ D120-4-4Z-JHP	SR M4X9-SEAL-JHP	JHP COPPER SEAL 1/8"	ETG 3-4-SH
TGAQ D120-5-4Z-JHP	SR M4X9-SEAL-JHP	JHP COPPER SEAL 1/8"	ETG 5-7"

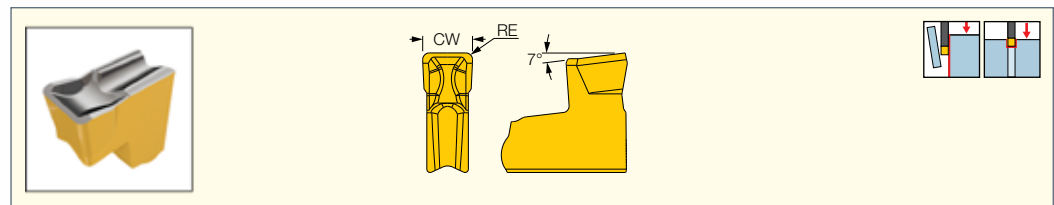
* Optional, should be ordered separately

TANG-GRIP
HIGH FEED PARTING

TANG-GRIP
PARTING LINE

TAG N-HF

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

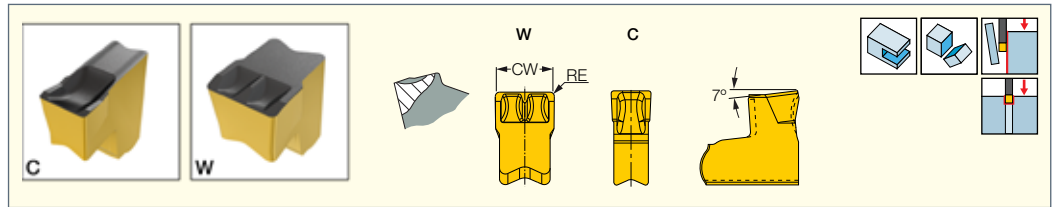


Designation	Dimensions			Tough ↔ Hard		Recommended Machining Data
	CW	CWTOL ⁽¹⁾	RE	IC830	IC808	
TAG N3HF	.118	.00157	.0157	•	•	.0098-.0138
TAG N4HF	.157	.00157	.0197	•	•	.0118-.0157
TAG N5HF	.197	.00157	.0197	•	•	.0118-.0157

⁽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 ^(a)	RE	IC830	IC1030	IC5400	IC1010	IC808	IC908	IC30N	IC20	IC807	f groove (IPR)
TAG N2C	.079	.0016	.0079	●	●	●	●	●	●	●	●		.0020-.0063
TAG N2.4C	.094	.0016	.0063	●				●					.0024-.0071
TAG N3CB ⁽¹⁾	.118	.0016	.0138	●				●					.0047-.0118
TAG N3C	.120	.0016	.0079	●	●	●	●	●	●	●	●	●	.0039-.0098
TAG N3M ⁽²⁾	.120	.0016	.0079	●					●				.0024-.0071
TAG N3W	.120	.0016	.0079	●					●				.0039-.0098
TAG N4C	.157	.0016	.0094	●	●	●	●	●	●		●	●	.0039-.0118
TAG N4CB ⁽¹⁾	.157	.0016	.0157	●					●				.0039-.0130
TAG N4M ⁽²⁾	.157	.0016	.0094	●					●				.0024-.0079
TAG N4W	.157	.0016	.0094	●					●				.0039-.0118
TAG N4.8C	.189	.0016	.0118	●				●					.0039-.0138
TAG N5C	.199	.0016	.0098	●				●			●		.0039-.0138

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

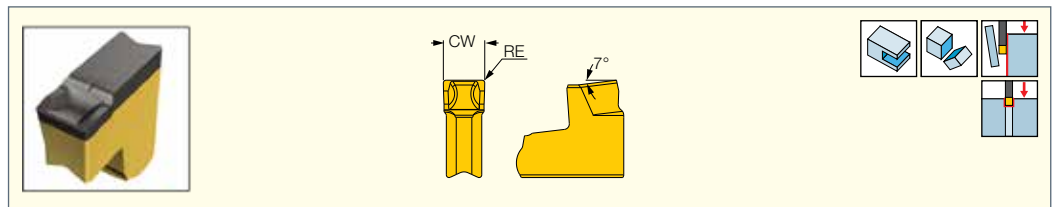
⁽¹⁾ Larger corner radii for interrupted cut and high feed applications

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

⁽³⁾ Cutting width tolerance (+/-)

TAG N-MF

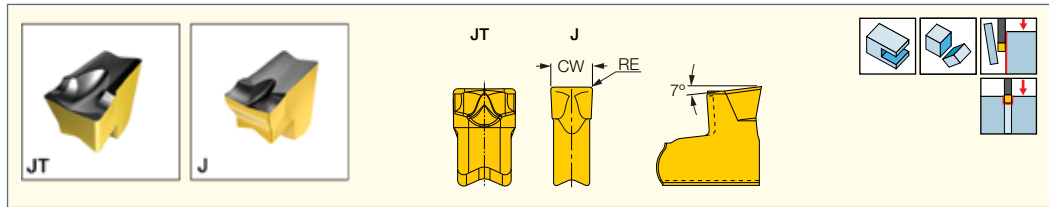
Single-Ended Inserts for Parting Grooving and Slitting Stainless and Alloy Steel at Medium Feed



Designation	Dimensions			Tough ↔ Hard					Recommended Machining Data
	CW	CWTOL ⁽¹⁾	RE	IC830	IC1030	IC5400	IC1010	IC808	f groove (IPR)
TAG N2MF	.079	.0020	.008	•	•	•	•	•	.0016-.0047
TAG N3MF	.118	.0020	.008	•	•	•	•	•	.0024-.0071
TAG N4MF	.157	.0020	.010	•	•	•	•	•	.0027-.0087
TAG N5MF	.197	.0020	.010	•	•	•	•	•	.0031-.0098

⁽¹⁾ Cutting width tolerance (+/-)

TAG N-J/JS/JT

 Single-Ended Inserts for
 Parting, Grooving and
 Slitting Soft Materials


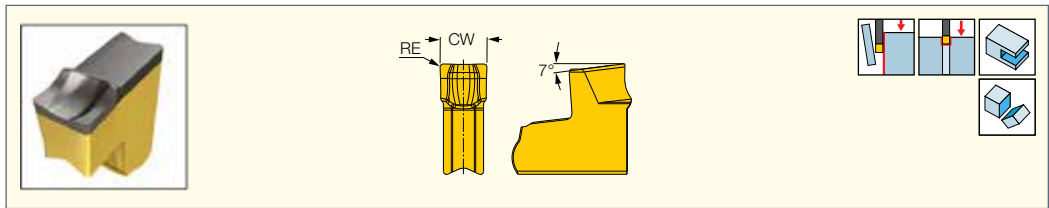
Designation	Dimensions				Tough ↔ Hard								Recommended Machining Data
	CW	RE	CWTOL ⁽²⁾	RETOL ⁽³⁾	IC830	IC1030	IC5400	IC1010	IC808	IC908	IC20	IC807	f groove (IPR)
TAG N2J	.079	.008	.0016	.0016	•	•	•	•	•		•		.0016-.0047
TAG N2JS	.079	.001	.0016	.0008	•				•				.0012-.0031
TAG N2JT	.079	.008	.0016	.0016	•		•		•				.0016-.0039
TAG N3J	.120	.008	.0016	.0012	•	•	•	•	•	•	•	•	.0016-.0063
TAG N3JS	.120	.001	.0016	.0008	•				•				.0016-.0039
TAG N3JT	.120	.008	.0016	.0012	•		•		•	•			.0020-.0071
TAG N3.2JT	.128	.008	.0016	.0012					•				.0020-.0071
TAG N4J	.157	.009	.0016	.0012	•	•	•	•	•	•		•	.0016-.0071
TAG N4JT	.159	.009	.0016	.0012	•		•		•	•			.0024-.0079
TAG N5J	.199	.010	.0016	.0016	•				•				.0020-.0079
TAG N5JT	.199	.010	.0016	.0016	•				•	•			.0024-.0087

• 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


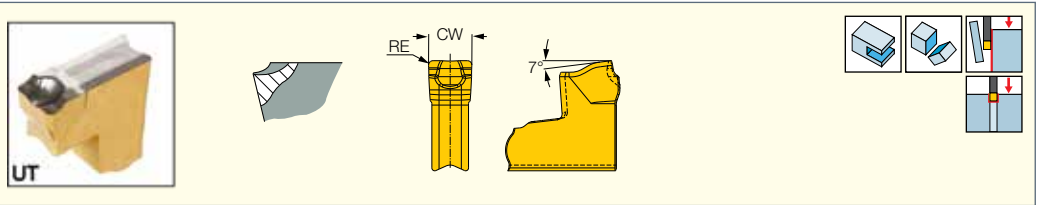
Designation	Dimensions				Tough ↔ Hard					Recommended Machining Data
	CW	RE	CWTOL ⁽¹⁾	RETOL ⁽²⁾	IC830	IC1030	IC5400	IC1010	IC808	f groove (IPR)
TAG N2LF	.079	.008	.0016	.0012	•	•	•	•	•	.0012-.0031
TAG N3LF	.120	.008	.0016	.0012	•	•	•	•	•	.0016-.0039

⁽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 & Low Carbon Steel



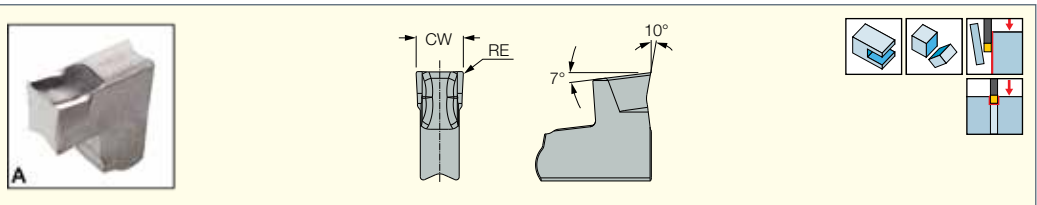
Designation	Dimensions				Tough ↔ Hard			Recommended Machining Data f groove (IPR)
	CW	RE	CWTOL ⁽¹⁾	RETOL ⁽²⁾	IC830	IC808	IC908	
TAG N2UT	.079	.0079	.0016	.0016	●	●	●	.0012-.0039
TAG N3UT	.118	.0118	.0016	.0016	●	●		.0016-.0047
TAG N4UT	.157	.0118	.0016	.0016			●	.0020-.0059
TAG N5UT	.197	.0118	.0016	.0016			●	.0020-.0071

⁽¹⁾ Cutting width tolerance (+/-)

⁽²⁾ Corner radius tolerance (+/-)

TAG N-A

Single-Ended Inserts for Parting, Grooving and Slitting Aluminum



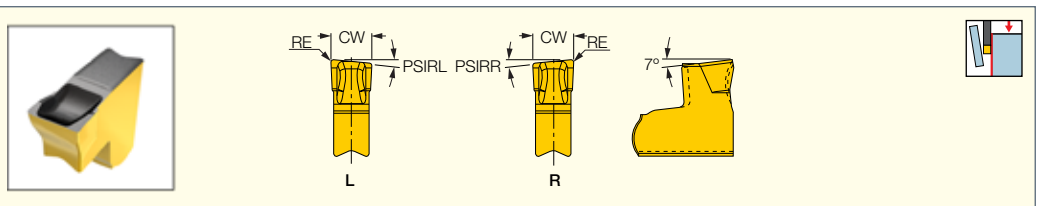
Designation	Dimensions				IC20	Recommended Machining Data f groove (IPR)
	CW	RE	CWTOL ⁽¹⁾	RETOL ⁽²⁾		
TAG N2A	.079	.008	.0016	.0016	●	.0008-.0039
TAG N3A	.118	.008	.0016	.0016	●	.0012-.0055
TAG N4A	.157	.009	.0016	.0012	●	.0012-.0063

⁽¹⁾ Cutting width tolerance (+/-)

⁽²⁾ Corner radius tolerance (+/-)

TAG R/L-C

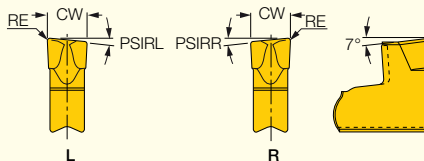
Single-Ended Inserts for Parting Bars, Hard Materials and Tough Parting Applications



Designation	Dimensions					Tough ↔ Hard				Recommended Machining Data f groove (IPR)
	CW	CWTOL ⁽¹⁾	RE	PSIRR	PSIRL	IC830	IC808	IC908	IC30N	
TAG L2C-6D	.081	.0039	.008	-	6.0	●	●			.0016-.0047
TAG R2C-6D	.081	.0039	.008	6.0	-	●	●			.0016-.0047
TAG R2.4C-8D	.094	.0039	.006	8.0	-	●	●			.0020-.0051
TAG L3C-6D	.118	.0039	.008	-	6.0	●	●	●		.0031-.0071
TAG R3C-6D	.118	.0039	.008	6.0	-	●	●	●		.0031-.0071
TAG R3C-8D	.118	.0039	.008	8.0	-				●	.0024-.0063
TAG L3C-15D	.118	.0039	.008	-	15.0	●	●	●		.0031-.0063
TAG R3C-15D	.118	.0039	.008	15.0	-	●	●	●		.0031-.0063
TAG L4C-4D	.159	.0039	.009	-	4.0	●	●			.0031-.0079
TAG R4C-4D	.159	.0039	.009	4.0	-	●	●	●		.0031-.0079
TAG L5C-4D	.199	.0039	.010	-	4.0	●	●			.0039-.0098
TAG R5C-4D	.199	.0039	.010	4.0	-	●	●			.0039-.0098

⁽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	IC830	IC808	IC908	
TAG L2J-6D	.079	.008	6.0	-	●	●		.0012-.0039
TAG R2J-6D	.079	.008	-	6.0	●	●		.0012-.0039
TAG L2JS-6D	.079	.001	6.0	-	●	●		.0008-.0031
TAG R2JS-6D	.079	.001	-	6.0	●	●		.0008-.0031
TAG L2J-15D	.079	.008	15.0	-	●	●		.0012-.0031
TAG R2J-15D	.079	.008	-	15.0	●	●		.0012-.0031
TAG L2JS-15D	.079	.001	15.0	-	●	●		.0008-.0024
TAG R2JS-15D	.079	.001	-	15.0	●	●		.0008-.0024
TAG L3J-6D	.118	.008	6.0	-	●	●	●	.0016-.0055
TAG R3J-6D	.118	.008	-	6.0	●	●	●	.0016-.0055
TAG L3JS-6D	.118	.001	6.0	-	●	●		.0012-.0039
TAG R3JS-6D	.118	.001	-	6.0	●	●		.0012-.0039
TAG L3J-15D	.118	.008	15.0	-	●	●	●	.0016-.0047
TAG R3J-15D	.118	.008	-	15.0	●	●	●	.0016-.0047
TAG L3JS-15D	.118	.001	15.0	-	●	●		.0012-.0031
TAG R3JS-15D	.118	.001	-	15.0	●	●		.0012-.0031
TAG L4J-4D	.157	.009	4.0	-	●	●		.0016-.0059
TAG R4J-4D	.157	.009	-	4.0	●	●	●	.0016-.0059
TAG L5J-4D	.199	.010	4.0	-	●	●		.0020-.0071
TAG R5J-4D	.199	.010	-	4.0	●	●		.0020-.0071

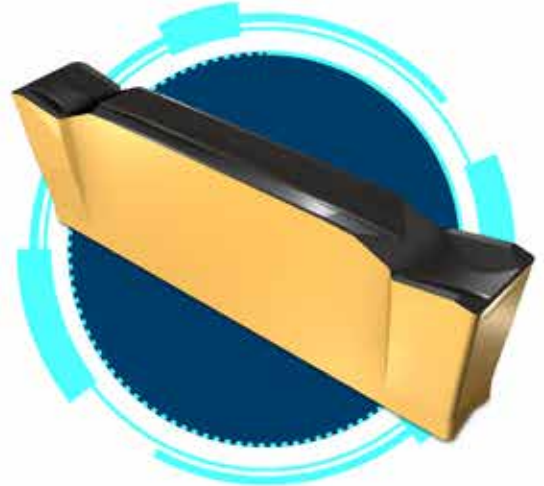


Parting with Extra Stability

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 4.72" diameter with 0.157" or 0.197" double-sided insert
- Parting up to 4.72" diameter with 0.118" single-sided insert (DGNM)
- Guaranteed higher productivity
- Enables mounting of all types of DO-GRIP inserts



Double-Sided Insert



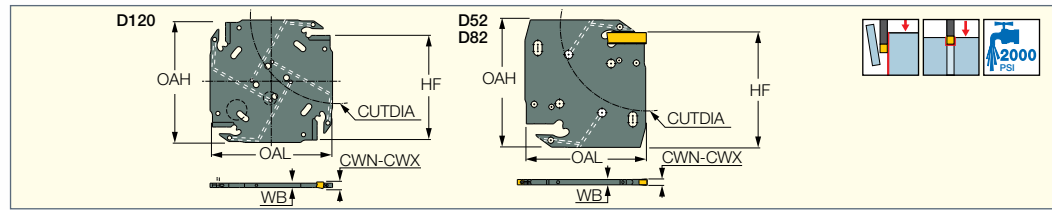
Economical
4-Pocket Blade

and Higher Productivity

DO-GRIP
TWISTED 2-SIDED

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	1.968	1.97	.075	.098	.068	1.713	2.05	DG 2
DGAQ D52-3-2Z-JHP	1.968	1.97	.118	.125	.098	1.713	2.05	DG 3
DGAQ D52-4-2Z-JHP	1.968	1.97	.157	.157	.126	1.713	2.05	DG 4
DGAQ D82-3-2Z-JHP	2.402	2.54	.118	.125	.098	2.283	3.23	DG 3
DGAQ D82-4-2Z-JHP	2.402	2.54	.157	.157	.126	2.283	3.23	DG 4
DGAQ D82-5-2Z-JHP	2.402	2.54	.197	.197	.157	2.283	3.23	DG 5
DGAQ D120-4-4Z-JHP	3.563	3.56	.157	.157	.126	3.307	4.72	DG 4
DGAQ D120-5-4Z-JHP	3.563	3.56	.197	.197	.157	3.307	4.72	DG 5

• When using .079 and .118" double-sided inserts, the depth of cut is limited up to .75". For larger depth, use a DGNM type single-ended insert.

⁽¹⁾ Minimum cutting width

⁽²⁾ Maximum cutting width

Flow Rate vs. Pressure

Designation	1000 PSI Flow Rate (GPM)	1450 PSI Flow Rate (GPM)	2000 PSI Flow Rate (GPM)
DGAQ D52-2-2Z-JHP	1.1-1.9	1.3-2.1	1.6-2.4
DGAQ D52/82-3-2Z-JHP			
DGAQ D52/82/120-4-...-JHP	1.6-1.9	1.9-2.1	2.1-2.4
DGAQ D82/120-5-...-JHP			

Spare Parts

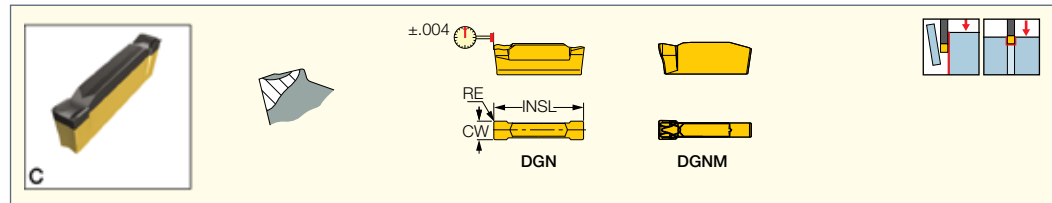
Designation			
DGAQ-JHP	SR M4X9-SEAL-JHP	JHP COPPER SEAL 1/8"	EDG 33A*

* Optional, should be ordered separately

DO-GRIP
TWISTED 2-SIDED

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 ⁽⁵⁾	INSL	IC830	IC1030	IC5400	IC1010	IC808	IC908	IC30N	IC20	IC807	IC907	
DGN 2002C	.079	.0012	.008	.0008	.709	.783	•	•	•	•	•	•	•	•	•	•	.0020-.0063
DGN 2202C	.087	.0012	.008	.0008	.709	.780	•	•	•	•	•	•	•	•	•	•	.0020-.0063
DGN 2502C	.098	.0012	.008	.0008	.709	.815	•	•	•	•	•	•	•	•	•	•	.0031-.0079
DGN 3102C	.122	.0016	.008	.0008	.709	.791	•	•	•	•	•	•	•	•	•	•	.0039-.0098
DGNM 3202C ⁽²⁾	.125	.0016	.008	.0008	-(6)	.803	•	•	•	•	•	•	•	•	•	•	.0039-.0098
DGN 4003C	.157	.0016	.012	.0012	-(6)	.740	•	•	•	•	•	•	•	•	•	•	.0039-.0118
DGN 4803C	.189	.0016	.012	.0012	-(6)	.783	•	•	•	•	•	•	•	•	•	•	.0047-.0138
DGN 5003C	.197	.0016	.012	.0012	-(6)	.752	•	•	•	•	•	•	•	•	•	•	.0047-.0138

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

⁽²⁾ Single-ended insert.

⁽³⁾ Cutting width tolerance (+/-)

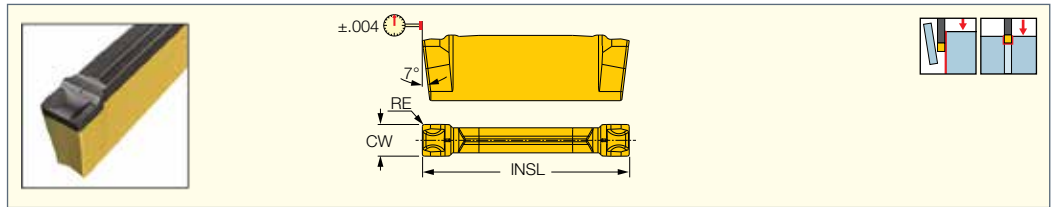
⁽⁴⁾ Corner radius tolerance (+/-)

⁽⁵⁾ Cutting depth maximum

⁽⁶⁾ No depth limit

DGN-MF

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



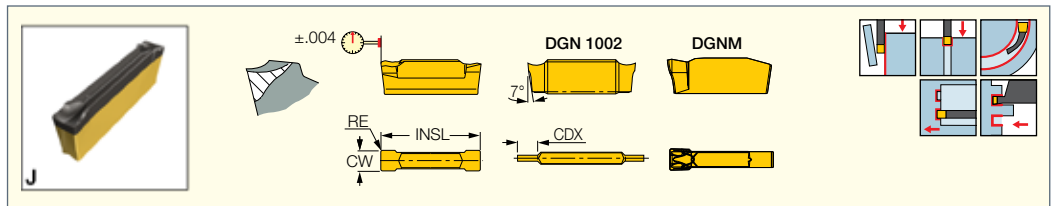
Designation	Dimensions					Tough ↔ Hard					Recommended Machining Data
	CW	RE	CWTOL ⁽¹⁾	CDX ⁽²⁾	INSL	IC830	IC1030	IC5400	IC1010	IC808	
DGN 2002MF	.079	.008	.0016	.709	.783	●	●	●	●	●	.0016-.0047
DGN 2202MF	.087	.008	.0016	.709	.783		●		●		.0016-.0047
DGN 3002MF	.118	.008	.0016	.709	.791			●			.0024-.0071
DGN 3102MF	.122	.008	.0016	.709	.791	●	●	●	●	●	.0024-.0071
DGN 4003MF	.157	.012	.0016	-	.740	●				●	.0031-.0079

⁽¹⁾ Cutting width tolerance (+/-)

⁽²⁾ Cutting depth maximum

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 ⁽²⁾	RE	RETOL ⁽⁴⁾	CDX ⁽⁵⁾	INSL	IC830	IC1030	IC5400	IC1010	IC808	IC908	IC20	IC807	IC907	
DGN 2002JT	.079	.0012	.008	.0008	.709	.780					●					.0016-.0055
DGN 2200JS ⁽¹⁾	.087	.0012	.001	.0008	.709	.764	●									.0012-.0031
DGN 2202J	.087	.0012	.008	.0008	.709	.780	●	●	●	●	●	●	●	●		.0016-.0047
DGN 2202JT	.087	.0012	.008	.0008	.709	.780	●		●		●					.0016-.0055
DGN 3100JS ⁽¹⁾	.122	.0016	.001	.0008	.709	.776										.0012-.0039
DGN 3102J	.122	.0016	.008	.0008	.709	.791	●	●	●	●	●	●	●		●	.0016-.0063
DGN 3102JT	.122	.0016	.008	.0008	.709	.791	●		●		●				●	.0020-.0071
DGN 3202J	.125	.0016	.008	.0008	.709	.791						●				.0016-.0063
DGNM 3202J ⁽²⁾	.125	.0016	.008	.0008	- ⁽⁶⁾	.799						●				.0016-.0063
DGN 4003J	.157	.0016	.012	.0012	- ⁽⁶⁾	.744	●				●	●	●	●		.0020-.0071
DGN 4003JT	.157	.0016	.012	.0012	- ⁽⁶⁾	.744	●									.0020-.0071
DGN 4803J	.189	.0016	.012	.0012	- ⁽⁶⁾	.803										.0020-.0079
DGN 5003J	.197	.0016	.012	.0012	- ⁽⁶⁾	.748	●				●	●	●			.0020-.0079
DGN 5003JT	.197	.0016	.012	.0012	-	.748						●				.0020-.0079

• 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 (+/-)

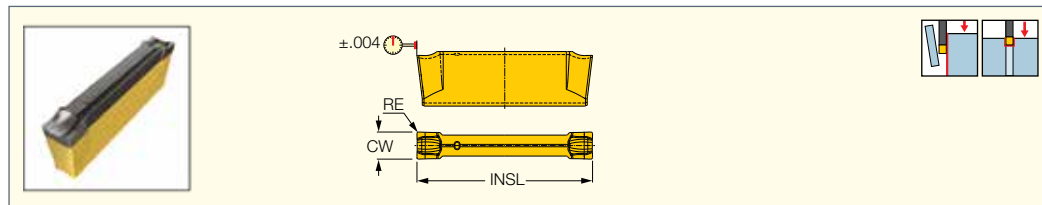
⁽⁴⁾ Corner radius tolerance (+/-)

⁽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
	CW	CWTOL ⁽¹⁾	RE	RETOL ⁽²⁾	CDX ⁽³⁾	INSL	IC830	IC1030	IC5400	IC1010	IC808	IC908	f groove (IPR)
DGN 2002LF	.079	.0012	.008	.0008	.709	.780	•	•	•	•	•	•	.0012-.0031
DGN 2202LF	.087	.0012	.008	.0008	.709	.780	•	•	•	•	•	•	.0012-.0031
DGN 3102LF	.122	.0016	.008	.0008	.709	.791	•	•	•	•	•	•	.0016-.0039
DGN 3102LFT	.122	.0016	.008	.0008	.709	.831	•	•	•	•	•	•	.0016-.0047

• 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

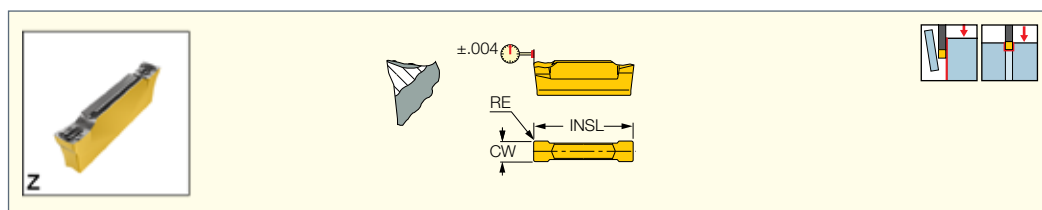
⁽¹⁾ Cutting width tolerance (+/-)

⁽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
	CW	CDX ⁽¹⁾	CWTOL ⁽²⁾	RE	RETOL ⁽³⁾	INSL	IC1030	IC1010	IC808	IC908	f groove (IPR)
DGN 2002Z	.079	.709	.0012	.008	.0008	.823	•	•	•	•	.0012-.0047
DGN 3002Z	.118	.709	.0012	.008	.0008	.823	•	•	•	•	.0012-.0063

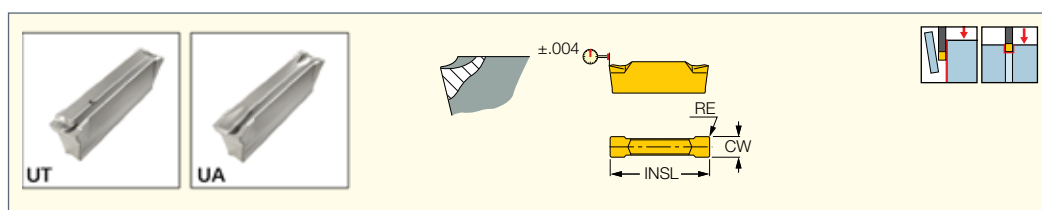
⁽¹⁾ Cutting depth maximum

⁽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
	CW	CWTOL ⁽¹⁾	RE	RETOL ⁽²⁾	CDX ⁽³⁾	INSL	IC908	IC20	f groove (IPR)
DGN 2202UA	.087	.0012	.008	.0008	.709	.783	•		.0016-.0051
DGN 2202UT	.087	.0012	.008	.0008	.709	.772	•		.0012-.0043
DGN 3003UA	.118	.0012	.010	.0008	.709	.807	•	•	.0016-.0059
DGN 3003UT	.118	.0012	.010	.0008	.709	.807	•		.0016-.0051
DGN 4003UA	.157	.0016	.012	.0008	- ⁽⁴⁾	.764	•		.0020-.0063
DGN 4003UT	.157	.0016	.012	.0008	- ⁽⁴⁾	.760	•		.0016-.0059
DGN 5003UT	.197	.0016	.012	.0008	- ⁽⁴⁾	.748	•		.0020-.0071

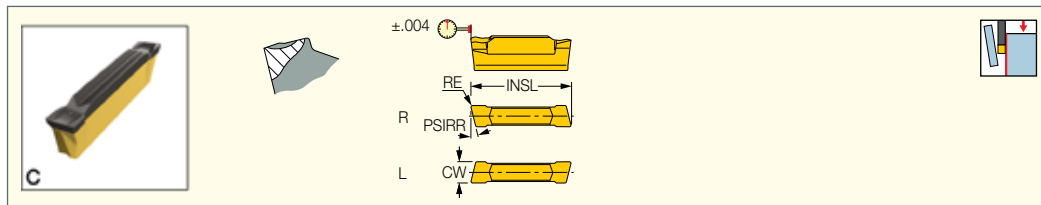
⁽¹⁾ Cutting width tolerance (+/-)

⁽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


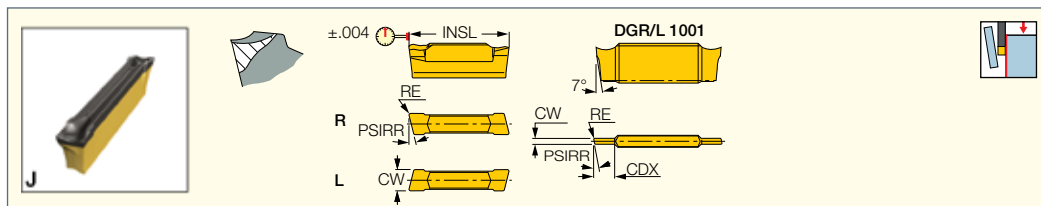
Designation	Dimensions						Tough $\leftrightarrow$ Hard				Recommended Machining Data
	CW	RE	CDX ⁽¹⁾	PSIRL	PSIRR	INSL	IC830	IC808	IC908	IC20	
DGL 2202C-6D	.087	.008	.709	6.0	-	.819	●	●	●	●	.0016-.0047
DGR 2202C-6D	.087	.008	.709	-	6.0	.819	●	●	●	●	.0016-.0047
DGL 3102C-15D	.122	.008	.709	15.0	-	.827	●	●	●	●	.0031-.0055
DGL 3102C-6D	.122	.008	.709	6.0	-	.827	●	●	●	●	.0031-.0071
DGR 3102C-15D	.122	.008	.709	-	15.0	.823	●	●	●	●	.0031-.0055
DGR 3102C-6D	.122	.008	.709	-	6.0	.827	●	●	●	●	.0031-.0071
DGR 3102C-8D	.122	.008	.709	-	8.0	.831	●	●	●	●	.0020-.0059
DGL 4003C-4D	.157	.012	- (2)	4.0	-	.744	●	●	●	●	.0031-.0079
DGR 4003C-4D	.157	.012	- (2)	-	4.0	.740	●	●	●	●	.0031-.0079
DGR 4800CS-4D	.189	.001	- (2)	-	4.0	.776	●	●	●	●	.0020-.0059
DGR 4800CS-8D	.189	.001	- (2)	-	8.0	.776	●	●	●	●	.0020-.0059
DGR 4803C-4D	.189	.012	- (2)	-	4.0	.799	●	●	●	●	.0039-.0098
DGR 4803C-8D	.189	.012	- (2)	-	8.0	.799	●	●	●	●	.0039-.0079
DGL 5003C-4D	.197	.012	- (2)	4.0	-	.752	●	●	●	●	.0039-.0098
DGR 5003C-4D	.197	.012	- (2)	-	4.0	.756	●	●	●	●	.0039-.0098

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

(1) Cutting depth maximum

(2) 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 $\leftrightarrow$ Hard				Recommended Machining Data
	CW	RE	CDX ⁽²⁾	INSL	PSIRL	PSIRR	IC830	IC808	IC908	IC20	
DGL 2200JS-15D ⁽¹⁾	.087	.001	.709	.811	15.0	-	●	●	●	●	.0012-.0027
DGL 2200JS-6D ⁽¹⁾	.087	.001	.709	.811	6.0	-	●	●	●	●	.0012-.0031
DGR 2200JS-15D ⁽¹⁾	.087	.001	.709	.811	-	15.0	●	●	●	●	.0012-.0027
DGR 2200JS-6D ⁽¹⁾	.087	.001	.709	.811	-	6.0	●	●	●	●	.0012-.0031
DGL 2202J-6D	.087	.008	.709	.827	6.0	-	●	●	●	●	.0012-.0039
DGR 2202J-15D	.087	.008	.709	.827	-	15.0	●	●	●	●	.0012-.0031
DGR 2202J-6D	.087	.008	.709	.827	-	6.0	●	●	●	●	.0012-.0039
DGL 3100JS-15D ⁽¹⁾	.122	.001	.709	.811	15.0	-	●	●	●	●	.0012-.0027
DGL 3100JS-6D ⁽¹⁾	.122	.001	.709	.811	6.0	-	●	●	●	●	.0012-.0031
DGR 3100JS-15D ⁽¹⁾	.122	.001	.709	.811	-	15.0	●	●	●	●	.0012-.0027
DGR 3100JS-6D ⁽¹⁾	.122	.001	.709	.811	-	6.0	●	●	●	●	.0012-.0031
DGL 3102J-15D	.122	.008	.709	.827	15.0	-	●	●	●	●	.0016-.0039
DGL 3102J-6D	.122	.008	.709	.827	6.0	-	●	●	●	●	.0016-.0055
DGR 3102J-15D	.122	.008	.709	.827	-	15.0	●	●	●	●	.0016-.0039
DGR 3102J-6D	.122	.008	.709	.827	-	6.0	●	●	●	●	.0016-.0055
DGR 4000JS-15D ⁽¹⁾	.157	.000	- (3)	.760	-	15.0	●	●	●	●	.0016-.0039
DGL 4003J-4D	.157	.012	- (3)	.744	4.0	-	●	●	●	●	.0016-.0059
DGR 4003J-4D	.157	.012	- (3)	.744	-	4.0	●	●	●	●	.0016-.0059
DGR 4800JS-4D ⁽¹⁾	.189	.001	- (3)	.780	-	4.0	●	●	●	●	.0016-.0047
DGR 4800JS-8D ⁽¹⁾	.189	.001	- (3)	.780	-	8.0	●	●	●	●	.0016-.0055
DGR 4803J-4D	.189	.012	- (3)	.780	-	4.0	●	●	●	●	.0016-.0071
DGR 4803J-8D	.189	.012	- (3)	.780	-	8.0	●	●	●	●	.0016-.0059
DGL 5003J-4D	.197	.012	- (3)	.780	4.0	-	●	●	●	●	.0020-.0079
DGR 5003J-4D	.197	.012	- (3)	.780	-	4.0	●	●	●	●	.0020-.0079

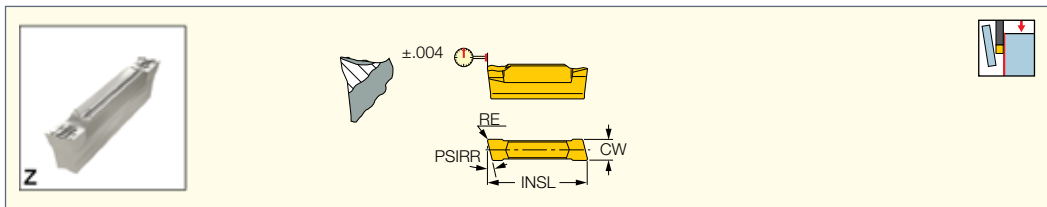
(1) Sharp corners

(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



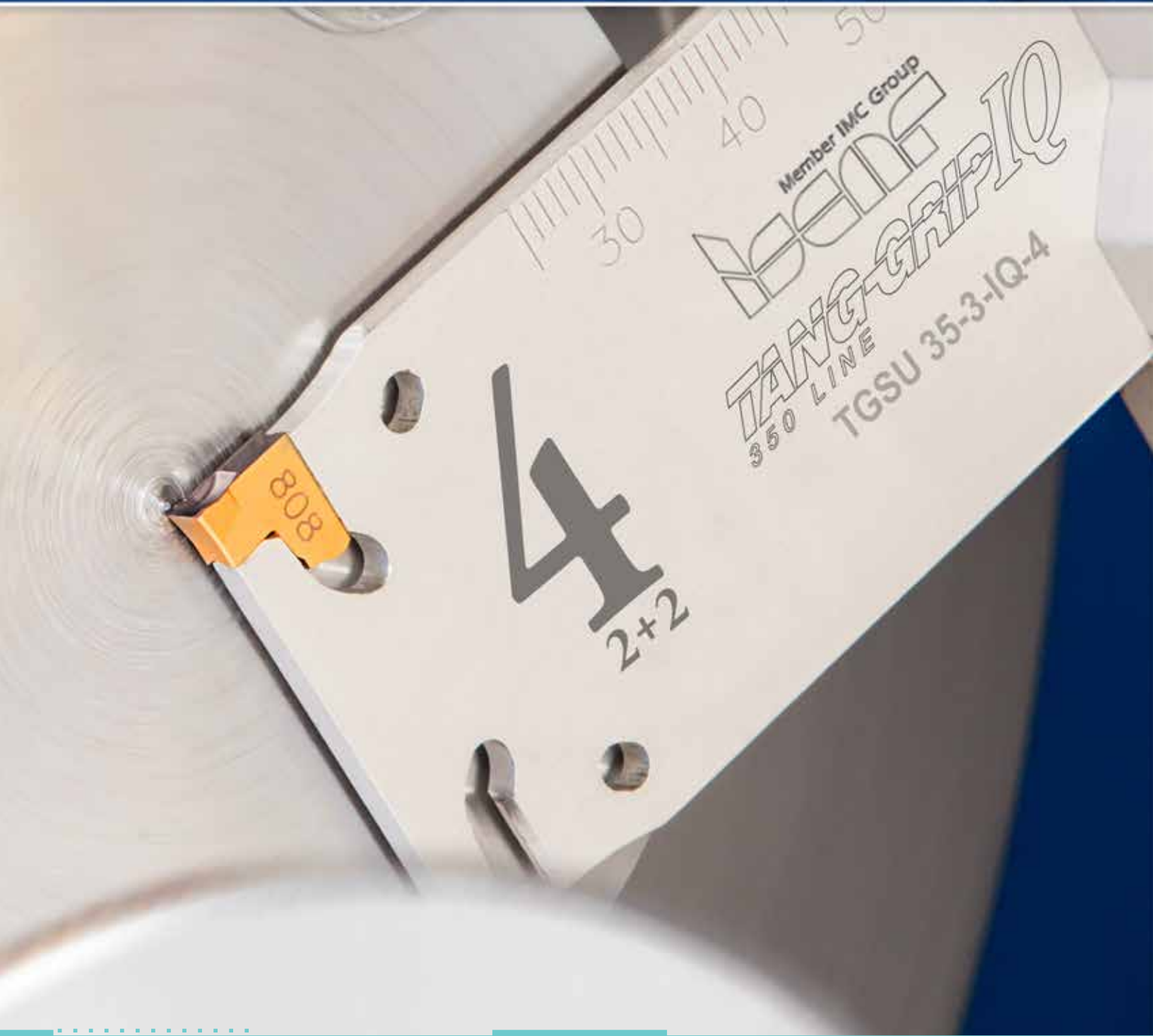
Designation	Dimensions						Recommended Machining Data
	CW	RE	INSL	CDX ⁽²⁾	PSIRR	IC908	f groove (IPR)
DGR 2000ZS-15D ⁽¹⁾	.079	.001	.803	.709	15.0	●	.0012-.0027
DGR 2000ZS-6D ⁽¹⁾	.079	.001	.803	.709	6.0	●	.0012-.0031
DGR 2002Z-15D	.079	.008	.823	.709	15.0	●	.0012-.0039
DGR 2002Z-6D	.079	.008	.823	.709	6.0	●	.0012-.0039
DGR 3000ZS-15D ⁽¹⁾	.118	.001	.803	.709	15.0	●	.0012-.0039
DGR 3000ZS-6D ⁽¹⁾	.118	.001	.803	.709	6.0	●	.0012-.0047
DGR 3002Z-6D	.118	.008	.823	.709	6.0	●	.0012-.0055

⁽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



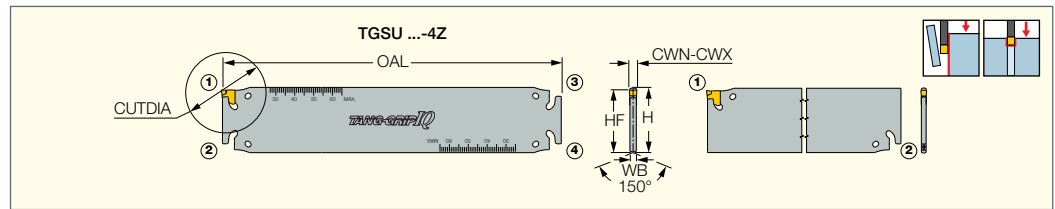
High Productivity



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	1.378	.055	.055	1.38	2	.098 ⁽⁶⁾	7.087	1.307	0	TAG 1.4	ETG 1.4/1.6"
TGSU 35-2-IQ	1.378	.071	.094	2.34	2	.098 ⁽⁷⁾	6.299	1.307	0	TAG 2	ETG 2"
TGSU 35-3-IQ-4Z	1.378	.110	.138	4.72	4	.098	7.087	1.307	0	TAG 3	ETG 3-4-SH*
TGSU 35-4-IQ-4Z	1.378	.146	.177	4.72	4	.134	7.087	1.307	0	TAG 4	ETG 3-4-SH*
TGSU 35-5-IQ	1.378	.185	.217	5.67	2	.157	7.087	1.307	0	TAG 5	ETG 5-7*
TGSU 35-6-IQ	1.378	.224	.256	5.67	2	.205	7.087	1.307	0	TAG 6	ETG 5-7*
TGSU 35-7-IQ	1.378	.268	.295	5.67	2	.236	7.087	1.307	0	TAG 7	ETG 5-7*
TGSU 35C-8-IQ ⁽¹⁾	1.378	.303	.335	5.67	2	.283	7.087	1.307	1	TAG 8	ETG 8-12*
TGSU 35C-9-IQ ⁽¹⁾	1.378	.343	.394	5.67	2	.323	7.087	1.307	1	TAG 9	ETG 8-12*
TGSU 56C-7-IQ ⁽¹⁾	2.205	.268	.295	8.66	2	.236	10.236	2.110	1	TAG 7	ETG 5-7*
TGSU 56C-8-IQ ⁽¹⁾	2.205	.303	.335	8.66	2	.283	10.236	2.110	1	TAG 8	ETG 8-12
TGSU 56C-9-IQ ⁽¹⁾	2.205	.343	.394	8.66	2	.323	10.236	2.110	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

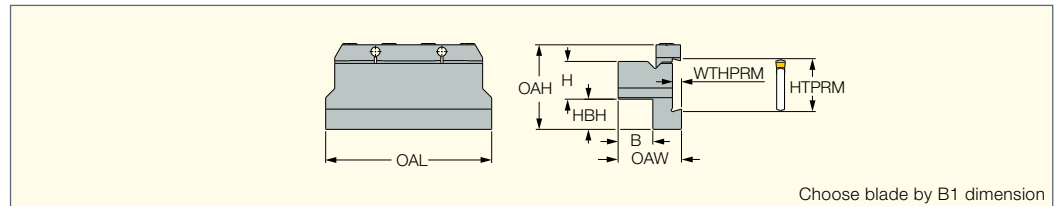
⁽⁶⁾ Thickness at the D.O.C. area is .041"

⁽⁷⁾ Thickness at the D.O.C. area is .065"

* Optional, should be ordered separately

TGTBU

Tool Blocks for TGSU Parting
and Grooving Blades



Choose blade by B1 dimension

Designation	H	B	HTPRM	WTHPRM	OAW	OAH	HBH	OAL			
TGTBU 19-35	.750	.750	1.378	.236	1.535	2.20	1.02	4.331	BKU 110	SR M6X16 DIN912	HW 5.0
TGTBU 25.4-35	1.000	1.024	1.378	.236	1.772	2.20	.72	4.331	BKU 110	SR M6X16 DIN912	HW 5.0
TGTBU 31.8-35	1.250	1.142	1.378	.236	1.890	2.20	.47	4.331	BKU 110	SR M6X16 DIN912	HW 5.0
TGTBU 31.8-35 HD ⁽¹⁾	1.250	1.181	1.378	.315	2.165	2.56	.72	5.118	BK 509	SR M8X20 DIN912	HW 6.0
TGTBU 38.1-35 HD ⁽¹⁾	1.250	1.181	1.378	.315	2.598	2.56	.47	5.118	BK 509	SR M8X20 DIN912	HW 6.0
TGTBU 38.1-35	1.500	1.535	1.378	.236	2.283	2.20	.22	4.331	BKU 110	SR M6X16 DIN912	HW 5.0
TGTBU 38.1-56 HD ⁽¹⁾	1.500	1.614	2.205	.315	2.598	3.27	1.18	5.118	BK 509	SR M8X20 DIN912	HW 6.0

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

*For inserts in width 0.06", 0.24", 0.275", 0.314", 0.35" refer to the full ISCAR Catalog





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



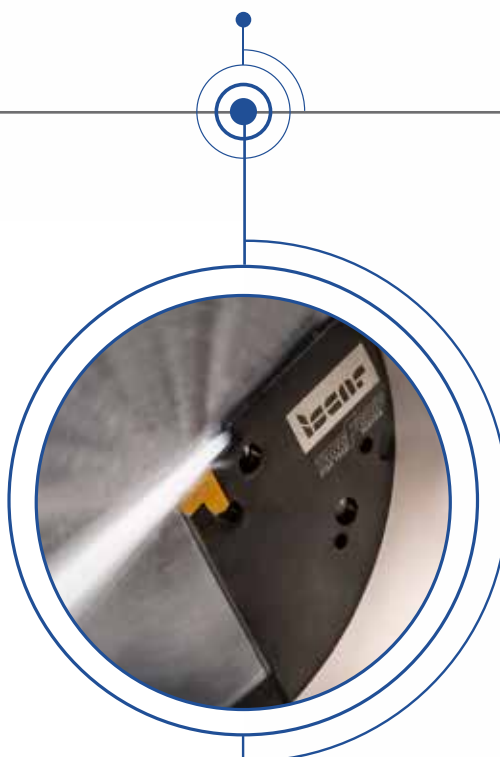
New Flat Top Tools
Engineered for Easy
Chip Flow and
Higher Productivity



MULTI FGRIP
HIGH FEED GRIP HOLDER



Reinforced and Robust
Tool Provides
Extra Stability and
Higher Productivity





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

