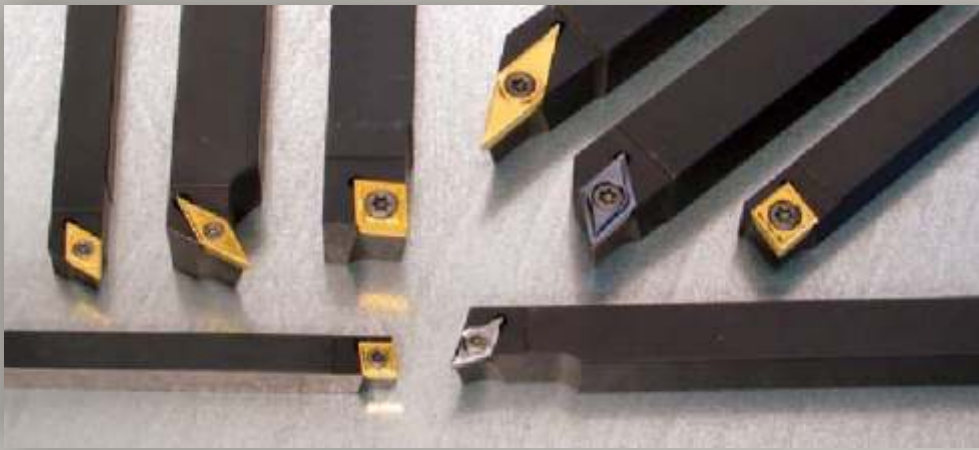


DIAMOND TIPPED ISO INSERT TURNING TOOLS

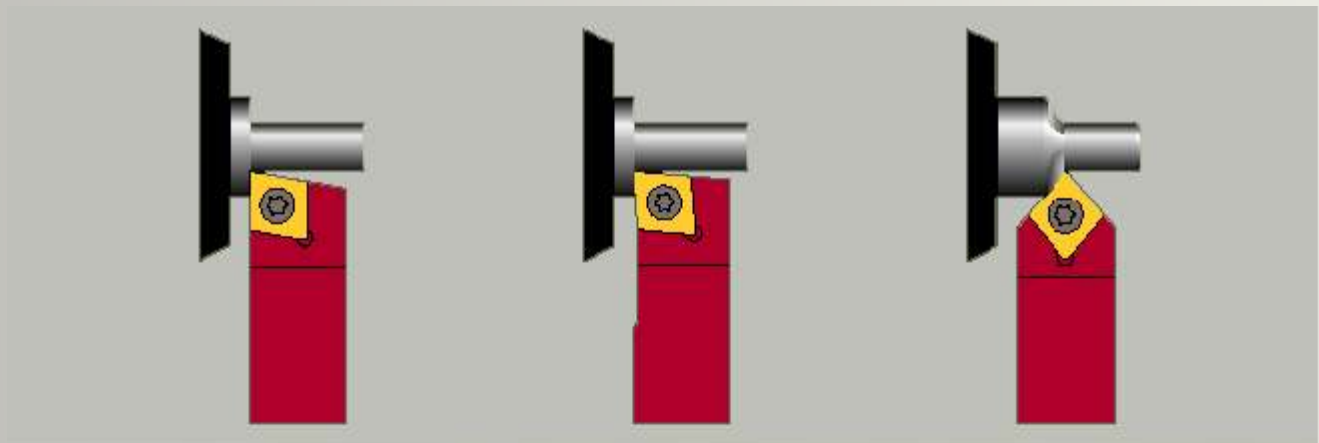


For applications requiring micro finished surface quality on non-ferrous turned components.

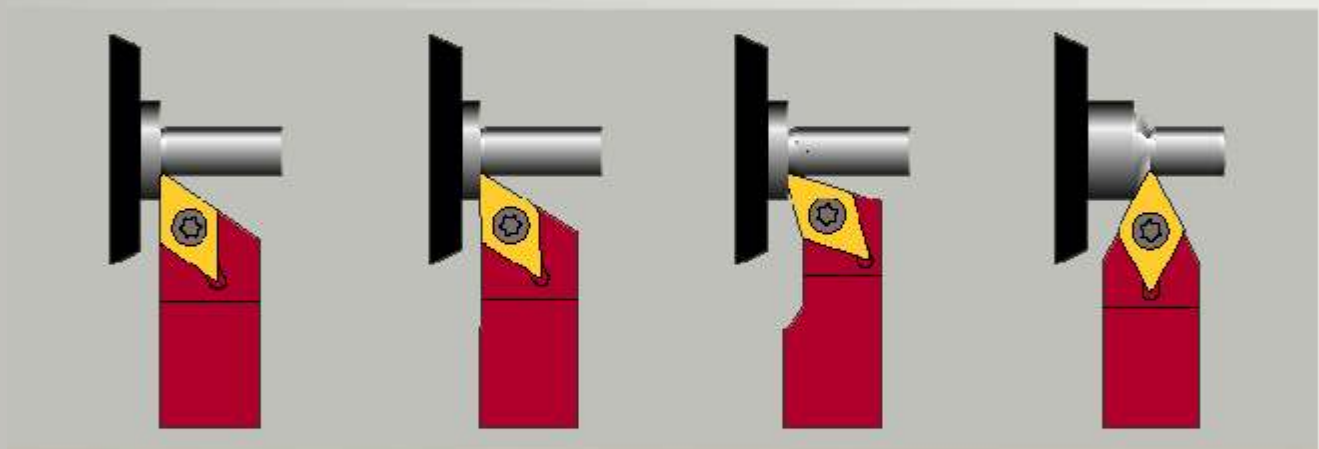
Mono Crystal Diamond tip mounted on ISO inserts.



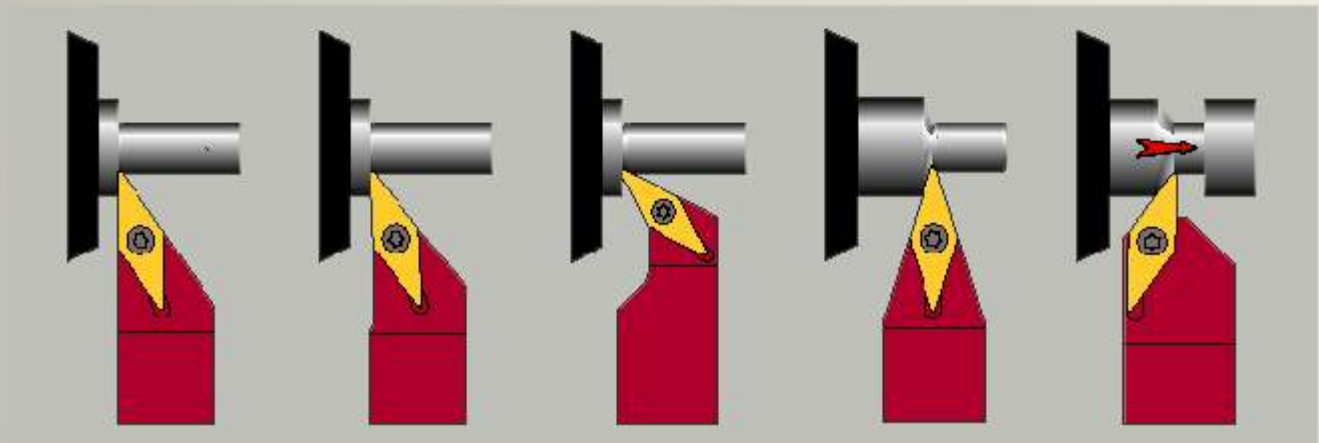
TOOL CONFIGURATIONS



80 Deg



55 Deg



35 Deg

GENERAL INFORMATION

Chase applies its single crystal diamond technology to standard ISO inserts thus producing a tool which can out perform PCD, CVD coated inserts.

A single mono crystal diamond is brazed onto the insert with a customer specified geometry to suit the application. This insert together with Swiss made shanks from Applitec form a finishing turning tool that can produce micro surface finish on non-ferrous materials.

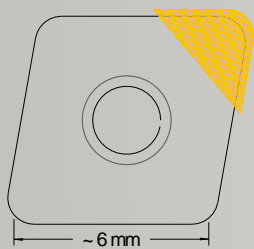
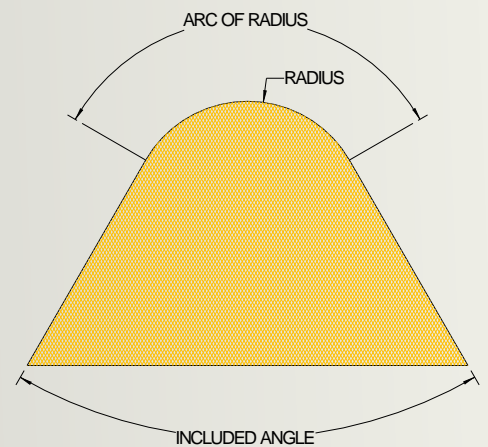
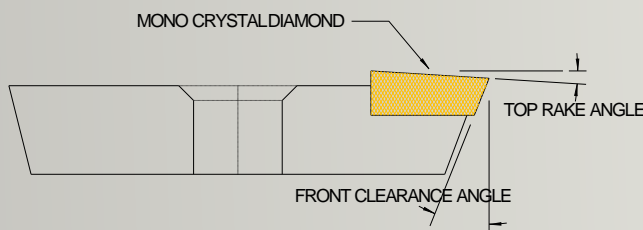
With a wide of insert sizes, cutting geometries and shank forms, the range covers most turning applications.



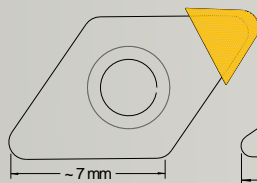
DIAMOND TIPPED INSERTS

Using mono crystal diamonds mounted on standard ISO inserts, surface finishes of 1 micro-inch are possible.

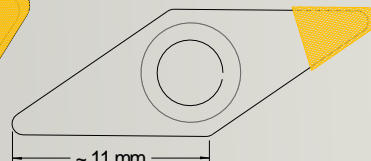
Chase supply many different geometries but selection of the correct tool for your application is easy.



80 DEG INSERT



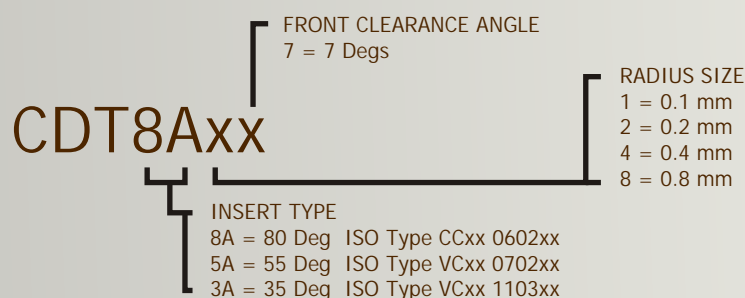
55 DEG INSERT



35 DEG INSERT

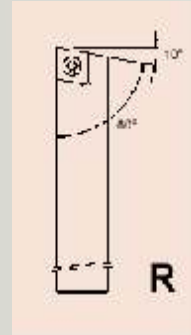
DIAMOND TIP GEOMETRY

RADIUS SIZE (mm)	FRONT CLEARANCE ANGLE	TOP RAKE ANGLE	INCLUDED ANGLE	INSERT TYPE	CHASE PART NUMBER
(0.1) (0.2) (0.4) (0.8)	7 Deg (s)	- 2 Deg	80 Deg	80 Deg	CDT8Ax7
(0.1) (0.2) (0.4) (0.8)	Specify	Specify	80 Deg	80 Deg	CDT8Axxx
(0.1) (0.2) (0.4) (0.8)	7 Deg (s)	- 2 Deg	55 Deg	55 Deg	CDT5Ax7
(0.1) (0.2) (0.4) (0.8)	Specify	Specify	55 Deg	55 Deg	CDT5Axxx
(0.2) (0.2) (0.4) (0.8)	7 Deg (s)	- 2 Deg	35 Deg	35 Deg	CDT3Ax7
(0.1) (0.2) (0.4) (0.8)	Specify	Specify	35 Deg	35 Deg	CDT3Axxx

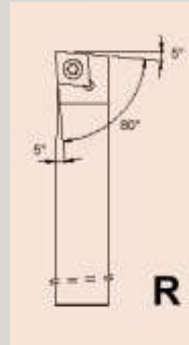
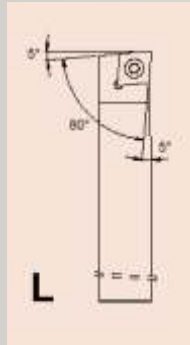


HOLDERS 80 DEGREE

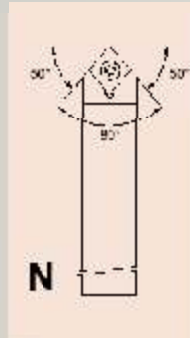
LEFT HAND			RIGHT HAND		
DIMENSIONS (H x W x L)	PART #	INSERT TYPE	DIMENSIONS (H x W x L)	PART #	INSERT TYPE
8 x 8 x 115	ISO-2112	CCxx-0602xx	8 x 8 x 115	ISO-2122	CCxx-0602xx
10 x 10 x 115	ISO-2113	CCxx-0602xx	10 x 10 x 115	ISO-2123	CCxx-0602xx
12 x 12 x 130	ISO-2114	CCxx-0602xx	12 x 12 x 130	ISO-2124	CCxx-0602xx
12 x 12 x 90	ISO-2114-90	CCxx-0602xx	12 x 12 x 90	ISO-2124-90	CCxx-0602xx
16 x 16 x 130	ISO-2115	CCxx-0602xx	16 x 16 x 130	ISO-2125	CCxx-0602xx
16 x 16 x 75	ISO-2115-75	CCxx-0602xx	16 x 16 x 75	ISO-2125-75	CCxx-0602xx



LEFT HAND			RIGHT HAND		
DIMENSIONS (H x W x L)	PART #	INSERT TYPE	DIMENSIONS (H x W x L)	PART #	INSERT TYPE
8 x 8 x 115	ISO-2132	CCxx-0602xx	8 x 8 x 115	ISO-2142	CCxx-0602xx
10 x 10 x 115	ISO-2133	CCxx-0602xx	10 x 10 x 115	ISO-2143	CCxx-0602xx
12 x 12 x 130	ISO-2134	CCxx-0602xx	12 x 12 x 130	ISO-2144	CCxx-0602xx
12 x 12 x 90	ISO-2134-90	CCxx-0602xx	12 x 12 x 90	ISO-2144-90	CCxx-0602xx
16 x 16 x 130	ISO-2135	CCxx-0602xx	16 x 16 x 130	ISO-2145	CCxx-0602xx
16 x 16 x 75	ISO-2135-75	CCxx-0602xx	16 x 16 x 75	ISO-2145-75	CCxx-0602xx

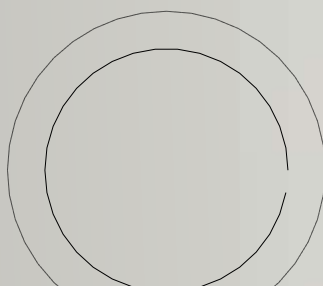
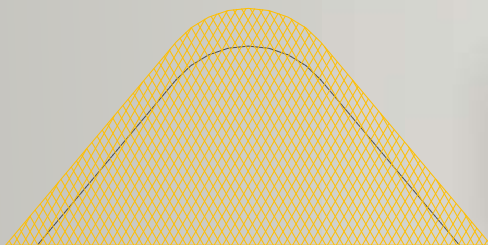


STRAIGHT		
DIMENSIONS (H x W x L)	PART #	INSERT TYPE
8 x 8 x 115	ISO-2102	CCxx-0602xx
10 x 10 x 115	ISO-2103	CCxx-0602xx
12 x 12 x 130	ISO-2104	CCxx-0602xx
12 x 12 x 90	ISO-2104-90	CCxx-0602xx
16 x 16 x 130	ISO-2105	CCxx-0602xx
16 x 16 x 75	ISO-2105-75	CCxx-0602xx



80 DEG INSERT

CCxx-602xx



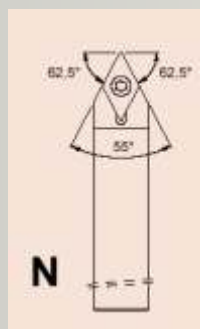
HOLDERS 55 DEGREE

LEFT HAND			RIGHT HAND		
DIMENSIONS (H x W x L)	PART #	INSERT TYPE	DIMENSIONS (H x W x L)	PART #	INSERT TYPE
8 x 8 x 115	ISO-2312	DCxx-0702xx	8 x 8 x 115	ISO-2322	DCxx-0702xx
10 x 10 x 115	ISO-2313	DCxx-0702xx	10 x 10 x 115	ISO-2323	DCxx-0702xx
12 x 12 x 130	ISO-2314	DCxx-0702xx	12 x 12 x 130	ISO-2324	DCxx-0702xx
12 x 12 x 90	ISO-2314-90	DCxx-0702xx	12 x 12 x 90	ISO-2324-90	DCxx-0702xx
16 x 16 x 130	ISO-2315	DCxx-0702xx	16 x 16 x 130	ISO-2325	DCxx-0702xx
16 x 16 x 75	ISO-2315-75	DCxx-0702xx	16 x 16 x 75	ISO-2325-75	DCxx-0702xx

LEFT HAND			RIGHT HAND		
DIMENSIONS (H x W x L)	PART #	INSERT TYPE	DIMENSIONS (H x W x L)	PART #	INSERT TYPE
8 x 8 x 115	ISO-2332	DCxx-0702xx	8 x 8 x 115	ISO-2342	DCxx-0702xx
10 x 10 x 115	ISO-2333	DCxx-0702xx	10 x 10 x 115	ISO-2343	DCxx-0702xx
12 x 12 x 130	ISO-2334	DCxx-0702xx	12 x 12 x 130	ISO-2344	DCxx-0702xx
12 x 12 x 90	ISO-2334-90	DCxx-0702xx	12 x 12 x 90	ISO-2344-90	DCxx-0702xx
16 x 16 x 130	ISO-2335	DCxx-0702xx	16 x 16 x 130	ISO-2345	DCxx-0702xx
16 x 16 x 75	ISO-2335-75	DCxx-0702xx	16 x 16 x 75	ISO-2345-75	DCxx-0702xx

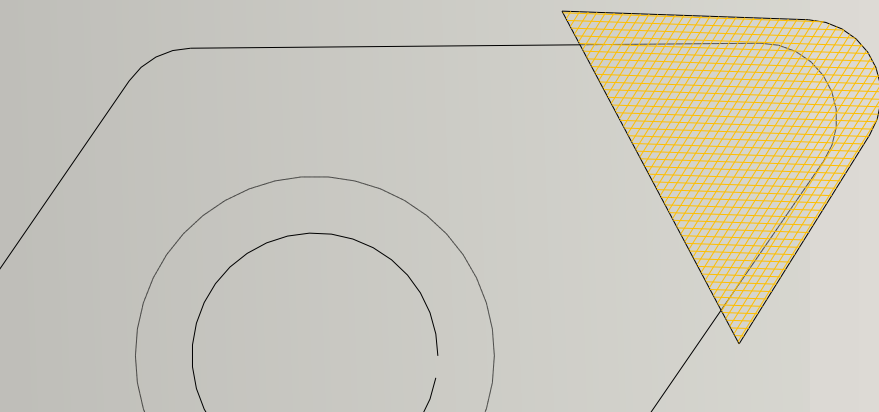
LEFT HAND			RIGHT HAND		
DIMENSIONS (H x W x L)	PART #	INSERT TYPE	DIMENSIONS (H x W x L)	PART #	INSERT TYPE
10 x 10 x 115	ISO-2353	DCxx-0702xx	10 x 10 x 115	ISO-2363	DCxx-0702xx
12 x 12 x 130	ISO-2354	DCxx-0702xx	12 x 12 x 130	ISO-2364	DCxx-0702xx
12 x 12 x 90	ISO-2354-90	DCxx-0702xx	12 x 12 x 90	ISO-2364-90	DCxx-0702xx
16 x 16 x 130	ISO-2355	DCxx-0702xx	16 x 16 x 130	ISO-2365	DCxx-0702xx
16 x 16 x 75	ISO-2355-75	DCxx-0702xx	16 x 16 x 75	ISO-2365-75	DCxx-0702xx

STRAIGHT		
DIMENSIONS (H x W x L)	PART #	INSERT TYPE
8 x 8 x 115	ISO-2302	DCxx-0702xx
10 x 10 x 115	ISO-2303	DCxx-0702xx
12 x 12 x 130	ISO-2304	DCxx-0702xx
12 x 12 x 90	ISO-2304-90	DCxx-0702xx
16 x 16 x 130	ISO-2305	DCxx-0702xx
16 x 16 x 75	ISO-2305-75	DCxx-0702xx



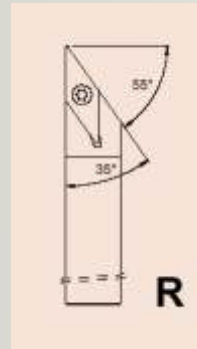
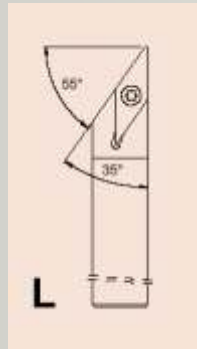
DCxx-0702xx

55 DEG INSERT



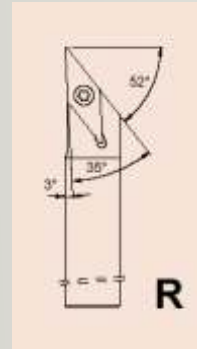
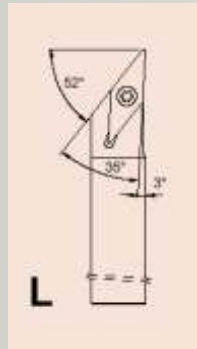
HOLDERS 35 DEGREE

LEFT HAND		
DIMENSIONS (H x W x L)	PART #	INSERT TYPE
8 x 8 x 115	ISO-2612	VCxx-1103xx
10 x 10 x 115	ISO-2613	VCxx-1103xx
12 x 12 x 130	ISO-2614	VCxx-1103xx
12 x 12 x 90	ISO-2614-90	VCxx-1103xx
16 x 16 x 130	ISO-2615	VCxx-1103xx
16 x 16 x 75	ISO-2615-75	VCxx-1103xx



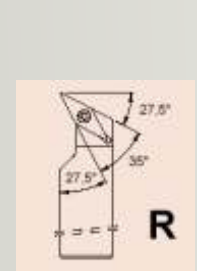
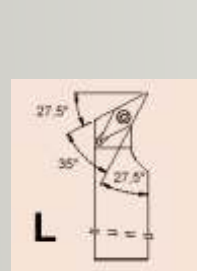
RIGHT HAND		
DIMENSIONS (H x W x L)	PART #	INSERT TYPE
8 x 8 x 115	ISO-2622	VCxx-1103xx
10 x 10 x 115	ISO-2623	VCxx-1103xx
12 x 12 x 130	ISO-2624	VCxx-1103xx
12 x 12 x 90	ISO-2624-90	VCxx-1103xx
16 x 16 x 130	ISO-2625	VCxx-1103xx
16 x 16 x 75	ISO-2625-75	VCxx-1103xx

LEFT HAND		
DIMENSIONS (H x W x L)	PART #	INSERT TYPE
8 x 8 x 115	ISO-2632	VCxx-1103xx
10 x 10 x 115	ISO-2633	VCxx-1103xx
12 x 12 x 130	ISO-2634	VCxx-1103xx
12 x 12 x 90	ISO-2634-90	VCxx-1103xx
16 x 16 x 130	ISO-2635	VCxx-1103xx
16 x 16 x 75	ISO-2635-75	VCxx-1103xx



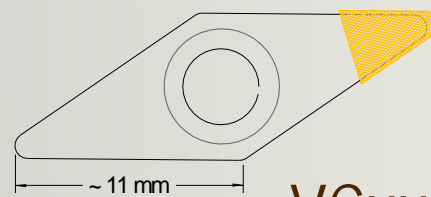
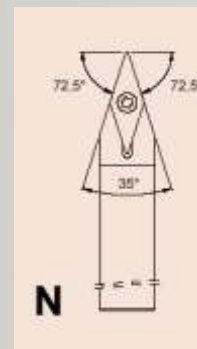
RIGHT HAND		
DIMENSIONS (H x W x L)	PART #	INSERT TYPE
8 x 8 x 115	ISO-2642	VCxx-1103xx
10 x 10 x 115	ISO-2643	VCxx-1103xx
12 x 12 x 130	ISO-2644	VCxx-1103xx
12 x 12 x 90	ISO-2644-90	VCxx-1103xx
16 x 16 x 130	ISO-2645	VCxx-1103xx
16 x 16 x 75	ISO-2645-75	VCxx-1103xx

LEFT HAND		
DIMENSIONS (H x W x L)	PART #	INSERT TYPE
16 x 16 x 130	ISO-2655	VCxx-1103xx
16 x 16 x 75	ISO-2655-75	VCxx-1103xx
20 x 20 x 120	ISO-2656	VCxx-1103xx



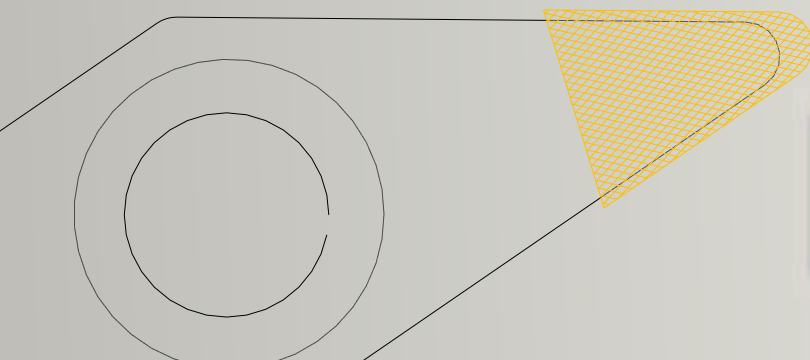
RIGHT HAND		
DIMENSIONS (H x W x L)	PART #	INSERT TYPE
16 x 16 x 130	ISO-2665	VCxx-1103xx
16 x 16 x 75	ISO-2665-75	VCxx-1103xx
20 x 20 x 120	ISO-2666	VCxx-1103xx

STRAIGHT		
DIMENSIONS (H x W x L)	PART #	INSERT TYPE
8 x 8 x 115	ISO-2602	VCxx-1103xx
10 x 10 x 115	ISO-2603	VCxx-1103xx
12 x 12 x 130	ISO-2604	VCxx-1103xx
12 x 12 x 90	ISO-2604-90	VCxx-1103xx
16 x 16 x 130	ISO-2605	VCxx-1103xx
16 x 16 x 75	ISO-2605-75	VCxx-1103xx



VCxx-1103xx

35 DEG INSERT



Diamond Insert Specification

- DE Beers grade one dia quality diamonds.
- Vacuum brazed.
- Chip free edge to 400x.
- Consistent edge sharpness.
- Uniform diamond hardness.
- Even ratio in use.
- Low co-efficient of friction.
- High thermal conductivity.
- Low co-efficient of expansion.
- Low compressibility.
- Ideal for interrupted cut machining.

Other Tool holder designs available

Custom designs catered for.

Volume discounts available.

