

# **LACH DIAMANT<sup>®</sup>** **»IC-PLUS« World's best** **PCD Chipbreaker**



**NEW** *complete Programme*  
*for process-reliable Turning*

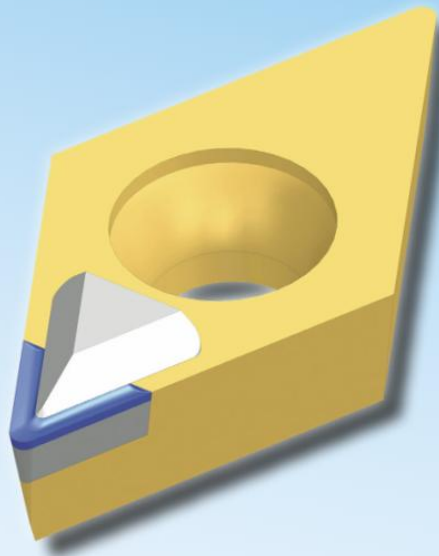
**World's best Chipbreaker**  
**A "Must have" for the Turning of Aluminium**

**»IC-plus world's best«**

## **PCD insert with active chipbreaker**

**A quantum leap for the process-reliable  
turning especially with long chipping  
aluminium alloys\***

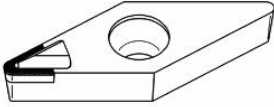


**International Patents**

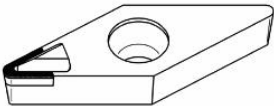




**\* and for all brass and  
bronze alloys**





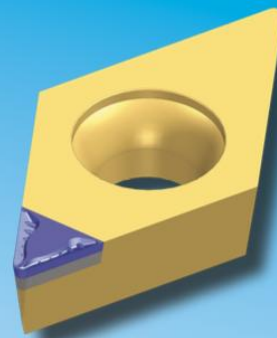
Type IC Plus Finishing	Cutting Depth	Order Reference	Order No.
<b>VCMT</b> 	0,1 - 1,5 mm	D-VCMT-110302-IC-plus	42222110
	0,1 - 1,5 mm	D-VCMT-110304-IC-plus	42222111
	0,1 - 1,5 mm	D-VCMT-160402-IC-plus	42222112
	0,1 - 1,5 mm	D-VCMT-160404-IC-plus	42222113
	0,3 - 1,5 mm	D-VCMT-160408-IC-plus	42222114
<b>DCMT</b> 	0,1 - 1,5 mm	D-DCMT-070202-IC-plus	42222120
	0,1 - 1,5 mm	D-DCMT-070204-IC-plus	42222121
	0,1 - 1,5 mm	D-DCMT-11T302-IC-plus	42222122
	0,1 - 1,5 mm	D-DCMT-11T304-IC-plus	42222123
	0,3 - 1,5 mm	D-DCMT-11T308-IC-plus	42222124
<b>CCMT</b> 	0,1 - 1,5 mm	D-CCMT-060202-IC-plus	42222130
	0,1 - 1,5 mm	D-CCMT-060204-IC-plus	42222131
	0,1 - 1,5 mm	D-CCMT-09T304-IC-plus	42222132
	0,1 - 1,5 mm	D-CCMT-120404-IC-plus	42222134
	0,3 - 1,5 mm	D-CCMT-09T308-IC-plus	42222133
	0,3 - 1,5 mm	D-CCMT-120408-IC-plus	42222135

Type IC Plus for higher Finishing Depth	Cutting Depth	Order Reference	Order No.
<b>VCMT</b> 	0,6 - 4,0 mm	D-VCMT-110304-XIS	42220357
	0,6 - 4,0 mm	D-VCMT-160404-XIS	42220329
	0,8 - 4,0 mm	D-VCMT-160408-XXIS	42220328
<b>DCMT</b> 	0,6 - 3,0 mm	D-DCMT-070202-XIS	42210836
	0,6 - 3,0 mm	D-DCMT-070204-XIS	42220243
	0,6 - 4,0 mm	D-DCMT-11T304-XIS	42220253
	0,8 - 4,0 mm	D-DCMT-11T308-XXIS	42220245
<b>CCMT</b> 	0,6 - 3,0 mm	D-CCMT 060202-XIS	42220950
	0,6 - 3,0 mm	D-CCMT-120404-XIS	42220951
	0,6 - 4,0 mm	D-CCMT-09T304-XIS	42220289
	0,6 - 4,0 mm	D-CCMT-120404-XIS	42211012
	0,8 - 4,0 mm	D-CCMT-09T308-XXIS	42220427
	0,8 - 4,0 mm	D-CCMT-120408-XXIS	42220616

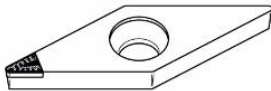
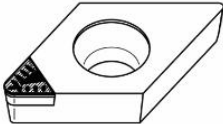
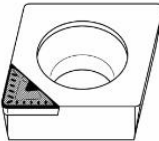
The mentioned cutting depths refer to standard holder systems with cutting angles 93°/95°.

»IC-plus world's best«

**PCD Insert  
with Laser Chip Groove  
Type CO  
with positive Cut**



**For especially thin and unstable elements**

Type CO	Cutting Depth	Order Reference	Order No.
<b>VCMT</b> 	0,1 - 1,5 mm	D-VCMT 110302-XCO	42221162
	0,1 - 1,5 mm	D-VCMT-110304-XCO	42221004
	0,1 - 1,5 mm	D-VCMT-160404-XCO	42221005
	0,6 - 3,0 mm	D-VCMT-160408-XXCO	42221006
<b>DCMT</b> 	0,1 - 1,5 mm	D-DCMT-070202-XCO	42221000
	0,1 - 1,5 mm	D-DCMT-070204-XCO	42221001
	0,1 - 1,5 mm	D-DCMT-11T304-XCO	42221002
	0,6 - 3,0 mm	D-DCMT-11T308-XXCO	42221003
<b>CCMT</b> 	0,1 - 1,5 mm	D-CCMT-060202-XCO	42221011
	0,1 - 1,5 mm	D-CCMT-060204-XCO	42221012
	0,1 - 1,5 mm	D-CCMT-09T304-XCO	42221013
	0,1 - 1,5 mm	D-CCMT-120404-XCO	42221015
	0,6 - 3,0 mm	D-CCMT-09T308-XXCO	42221014
	0,6 - 3,0 mm	D-CCMT-120408-XXCO	42221016

The mentioned cutting depths refer to standard holder systems with cutting angles 93°/95°.

**Recommended cutting values**

**IC-Plus**

**for finish machining**

$v_c$ : 800 - 2500 m/min  
 $R_{0,2}/R_{0,4}$   $f_n$ : 0,05 - 0,2 mm/U  
 $R_{0,8}$   $f_n$ : 0,1 - 0,25 mm/U

**XIS**

**for higher finishing depths**

$v_c$ : 800 - 2500 m/min  
 $R_{0,2}/R_{0,4}$   $f_n$ : 0,1 - 0,35 mm/U  
 $R_{0,8}$   $f_n$ : 0,1 - 0,4 mm/U

**XCO**

**for finish machining**

$v_c$ : 800 - 2500 m/min  
 $f_n$ : 0,05 - 0,2 mm/U

**XXCO**

**for higher finishing depths**

$v_c$ : 800 - 2500 m/min  
 $f_n$ : 0,1 - 0,3 mm/U

Delivery from stock - subject to prior sale.  
 Further ISO and customized inserts are available on request.

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