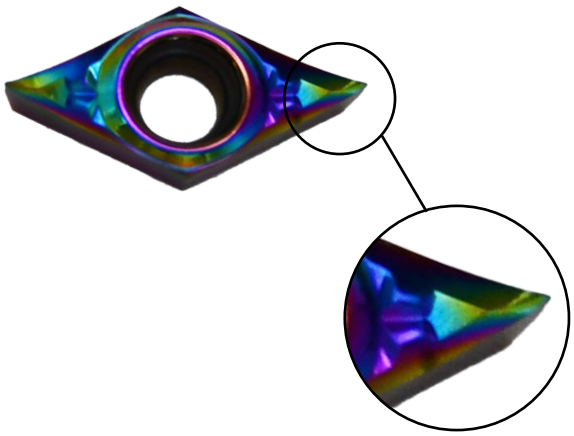
Nr. 380-1/2026-DE

Tech-News

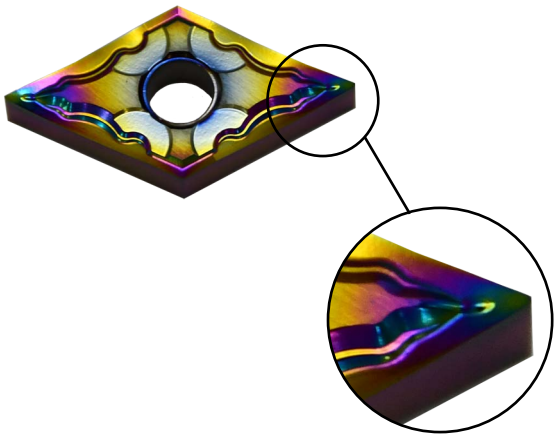
Hochleistungs-Drehwendeplatten mit DLC-Beschichtung
High Performance Turning Inserts with DLC-coating

einseitige WP / *Inserts* ALX



Seite / *Page* 2-4

doppelseitige WP / *Inserts* A20

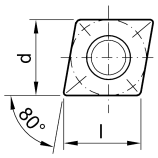


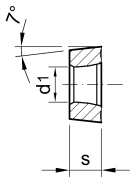
Seite / *Page* 5-7

- **Neue DLC-Sorte zur Bearbeitung von Si-Aluminium, NE-Metallen, GFK/CFK/HNBR, Kupfer, Titan und Magnesium**
  New DLC-grade for machining Si-Aluminium, non-ferrous metals, GFK/CFK/HNBR, copper, titanium and magnesium
- **Exzellente Oberflächen dank geringer Reibung und Verklebeneigung**
  Excellent surface thanks to low friction and anti-adhesion
- **Auch Fräswendeplatten mit DLC-Beschichtung auf Anfrage lieferbar**
  Also milling inserts with DLC-coating can be supplied on request

CCGT

80°

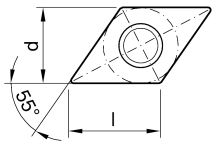


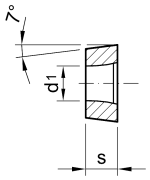


Wendeplatten *Inserts*	Bezeichnung *Part Number*	Bestellnummer *Order number*	Beschichtet *Coated*	Maße *Dimensions* [mm]					Schnittdaten *Cutting Data* [mm]	
			TD 5105	l	Ø d	s	Ø d_1	r	fn (mm/rev)	ap (mm)
CCGT-ALX	**06 02 01- ALX**	**10007299061**	●	06	6.35	2.38	2.80	0.1	0,008~0,15	0,05~2,50
	06 02 02- ALX	**10007300061**	●	06	6.35	2.38	2.80	0.2	0,01~0,30	0,05~3,00
	06 02 04- ALX	**10007301061**	●	06	6.35	2.38	2.80	0.4	0,02~0,40	0,10~3,00
	06 02 08- ALX	**10007302061**	○	06	6.35	2.38	2.80	0.8	0,03~0,50	0,10~3,00
	09 T3 01- ALX	**10007303061**	○	09	9.52	3.97	4.40	0.1	0,008~0,15	0,05~2,50
	09 T3 02- ALX	**10007304061**	●	09	9.52	3.97	4.40	0.2	0,01~0,30	0,05~3,00
	09 T3 04- ALX	**10007287061**	●	09	9.52	3.97	4.40	0.4	0,02~0,40	0,10~4,00
	09 T3 08- ALX	**10007305061**	●	09	9.52	3.97	4.40	0.8	0,03~0,50	0,10~5,00
	12 04 02- ALX	**10007306061**	●	12	12.70	4.76	5.50	0.2	0,01~0,30	0,05~5,00
	12 04 04- ALX	**10007288061**	●	12	12.70	4.76	5.50	0.4	0,02~0,40	0,05~5,00
	12 04 08- ALX	**10007307061**	●	12	12.70	4.76	5.50	0.8	0,03~0,50	0,10~5,00
	12 04 12- ALX	**10007308061**	○	12	12.70	4.76	5.50	1.2	0,04~0,55	0,13~5,00

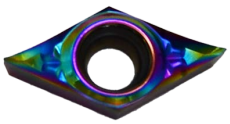
DCGT

55°





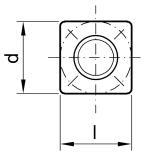
Wendeplatten *Inserts*	Bezeichnung *Part Number*	Bestellnummer *Order number*	Beschichtet *Coated*	Maße *Dimensions* [mm]					Schnittdaten *Cutting Data* [mm]	
			TD 5105	l	Ø d	s	Ø d_1	r	fn (mm/rev)	ap (mm)
DCGT-ALX	**07 02 01- ALX**	**10007311061**	●	07	6.35	2.38	2.80	0.1	0,008~0,15	0,05~3,50
	07 02 02- ALX	**10007312061**	●	07	6.35	2.38	2.80	0.2	0,01~0,30	0,05~3,00
	07 02 04- ALX	**10007289061**	●	07	6.35	2.38	2.80	0.4	0,02~0,40	0,10~4,00
	07 02 08- ALX	**10007314061**	○	07	6.35	2.38	2.80	0.8	0,02~0,40	0,10~4,00
	11 T3 01- ALX	**10007269061**	●	11	9.52	3.97	4.40	0.1	0,008~0,15	0,05~3,50
	11 T3 02- ALX	**10007270061**	●	11	9.52	3.97	4.40	0.2	0,02~0,30	0,05~4,00
	11 T3 04- ALX	**10007271061**	●	11	9.52	3.97	4.40	0.4	0,03~0,50	0,10~5,00
	11 T3 08- ALX	**10007315061**	●	11	9.52	3.97	4.40	0.8	0,03~0,50	0,10~5,00

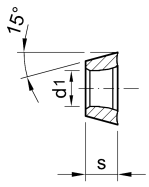


● JD-Lager / *JD-Stock* ○ begrenzte Lagerhaltung - auf Anfrage / *limited stock - upon request*

SCGT

90°

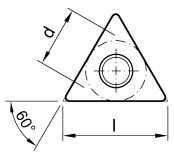


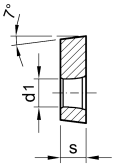


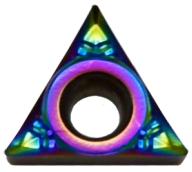
Wendeplatten *Inserts*	Bezeichnung *Part Number*	Bestellnummer *Order number*	Beschichtet *Coated*	Maße *Dimensions* [mm]					Schnittdaten *Cutting Data* [mm]	
			TD 5105	l	Ø d	s	Ø d_1	r	fn (mm/rev)	ap (mm)
SCGT-ALX	**09 T3 02- ALX**	**10007322061**	○	09	9.52	3.97	4.40	0.2	0,02~0,30	0,10~4,00
	09 T3 04- ALX	**10007291061**	●	09	9.52	3.97	4.40	0.4	0,02~0,40	0,10~4,00
	09 T3 08- ALX	**10007323061**	○	09	9.52	3.97	4.40	0.8	0,03~0,50	0,10~4,00
	12 04 02- ALX	**10007324061**	○	12	12.70	4.76	5.50	0.2	0,02~0,30	0,10~5,00
	12 04 04- ALX	**10007292061**	●	12	12.70	4.76	5.50	0.4	0,02~0,40	0,10~5,00
	12 04 08- ALX	**10007325061**	○	12	12.70	4.76	5.50	0.8	0,03~0,50	0,10~5,00

TCGT

60°

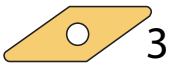


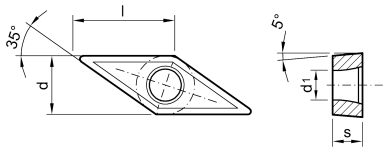


Wendeplatten *Inserts*	Bezeichnung *Part Number*	Bestellnummer *Order number*	Beschichtet *Coated*	Maße *Dimensions* [mm]					Schnittdaten *Cutting Data* [mm]	
			TD 5105	l	Ø d	s	Ø d_1	r	fn (mm/rev)	ap (mm)
TCGT-ALX 	**09 02 02- ALX**	**10007329061**	●	09	5.56	2.38	2.50	0.2	0,01~0,12	0,05~2,50
	09 02 04- ALX	**10007330061**	●	09	5.56	2.38	2.50	0.4	0,02~0,15	0,30~3,00
	09 02 08- ALX	**10007331061**	○	09	5.56	2.38	2.50	0.8	0,03~0,40	0,30~3,00
	11 02 01- ALX	**10007332061**	○	11	6.35	2.38	2.80	0.1	0,008~0,15	0,05~4,00
	11 02 02- ALX	**10007333061**	●	11	6.35	2.38	2.80	0.2	0,01~0,30	0,05~5,50
	11 02 04- ALX	**10007334061**	●	11	6.35	2.38	2.80	0.4	0,02~0,40	0,10~4,00
	11 02 08- ALX	**10007335061**	○	11	6.35	2.38	2.80	0.8	0,03~0,50	0,10~5,00
	16 T3 02- ALX	**10007336061**	●	16	9.25	3.97	4.40	0.2	0,01~0,30	0,05~4,50
	16 T3 04- ALX	**10007337061**	●	16	9.25	3.97	4.40	0.4	0,02~0,40	0,10~5,00
	16 T3 08- ALX	**10007338061**	○	16	9.25	3.97	4.40	0.8	0,03~0,50	0,10~5,00

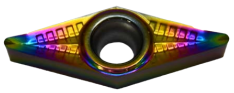
● JD-Lager / *JD-Stock* ○ begrenzte Lagerhaltung - auf Anfrage / *limited stock - upon request*

VBGT

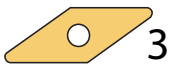


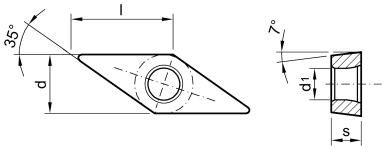


Wendeplatten *Inserts*	Bezeichnung *Part Number*	Bestellnummer *Order number*	Beschichtet *Coated*	Maße *Dimensions* [mm]					Schnittdaten *Cutting Data* [mm]	
			TD 5105	l	Ø d	s	Ø d_1	r	fn (mm/rev)	ap (mm)
VBGT -ALX	**11 03 02- ALX**	**10007344061**	●	11	6.35	3.18	2.80	0.2	0,01~0,30	0,05~3,50
	11 03 04- ALX	**10007345061**	●	11	6.35	3.18	2.80	0.4	0,02~0,40	0,10~4,00
	11 03 08- ALX	**10007346061**	○	11	6.35	3.18	2.80	0.8	0,03~0,50	0,10~5,00
	16 04 02- ALX	**10007347061**	●	16	9.52	4.76	4.40	0.2	0,01~0,30	0,05~4,50
	16 04 04- ALX	**10007348061**	●	16	9.52	4.76	4.40	0.4	0,02~0,40	0,10~5,00
	16 04 08- ALX	**10007349061**	○	16	9.52	4.76	4.40	0.8	0,02~0,40	0,10~5,00

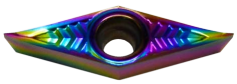


VCGT





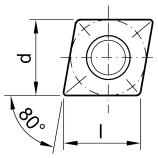
Wendeplatten *Inserts*	Bezeichnung *Part Number*	Bestellnummer *Order number*	Beschichtet *Coated*	Maße *Dimensions* [mm]					Schnittdaten *Cutting Data* [mm]	
			TD 5105	l	Ø d	s	Ø d_1	r	fn (mm/rev)	ap (mm)
VCGT-ALX	**07 02 02- ALX**	**10007803061**	○	07	4,76	2.38	2.15	0.2	0,02~0,25	0,05~1,50
	07 02 04- ALX	**10007804061**	○	07	4,76	2.38	2.15	0.4	0,02~0,30	0,05~1,70
	11 03 01- ALX	**10007350061**	●	11	6.35	3.18	2.80	0.1	0,008~0,15	0,05~2,50
	11 03 02- ALX	**10007351061**	●	11	6.35	3.18	2.80	0.2	0,01~0,30	0,05~3,50
	11 03 04- ALX	**10007272061**	●	11	6.35	3.18	2.80	0.4	0,02~0,40	0,10~4,00
	11 03 08- ALX	**10007352061**	○	11	6.35	3.18	2.80	0.8	0,03~0,50	0,10~5,00
	13 03 02- ALX	**10007353061**	●	13	7.94	3.18	4.40	0.2	0,01~0,30	0,10~4,50
	13 03 04- ALX	**10007354061**	●	13	7.94	3.18	4.40	0.4	0,02~0,40	0,10~4,50
	16 04 01- ALX	**10007355061**	●	16	9.52	4.76	4.40	0.1	0,008~0,20	0,07~2,50
	16 04 02- ALX	**10007356061**	●	16	9.52	4.76	4.40	0.2	0,01~0,30	0,05~4,50
	16 04 04- ALX	**10007273061**	●	16	9.52	4.76	4.40	0.4	0,02~0,40	0,10~5,00
	16 04 08- ALX	**10007357061**	●	16	9.52	4.76	4.40	0.8	0,03~0,50	0,10~5,00
	16 04 12- ALX	**10007358061**	○	16	9.52	4.76	4.40	1.2	0,03~0,50	0,10~5,00
	22 05 30- ALX	**10007359061**	●	22	12.70	5.56	5.60	3.0	0,08~1,00	0,15~7,00

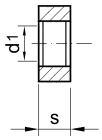


● JD-Lager / *JD-Stock* ○ begrenzte Lagerhaltung - auf Anfrage / *limited stock - upon request*

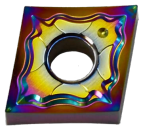
CNGG

80°



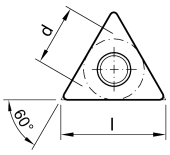


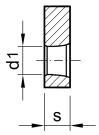
Wendeplatten *Inserts*	Bezeichnung *Part Number*	Bestellnummer *Order number*	Beschichtet *Coated*	Maße *Dimensions* [mm]					Schnittdaten *Cutting Data* [mm]	
			TD 5105	l	Ø d	s	Ø d_1	r	fn (mm/rev)	ap (mm)
CNGG-A20	**12 04 02- A20**	**10007309061**	●	12	12.70	4.76	5.16	0.2	0,05~0,15	0,23~3,50
	12 04 04- A20	**10007297061**	●	12	12.70	4.76	5.16	0.4	0,05~0,25	0,23~3,50
	12 04 08- A20	**10007298061**	●	12	12.70	4.76	5.16	0.8	0,10~0,40	0,80~3,50
	12 04 12- A20	**10007310061**	○	12	12.70	4.76	5.16	1.2	0,13~0,55	0,80~3,50



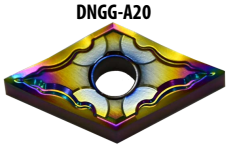
DNGG

55°





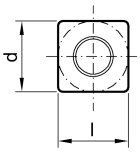
Wendeplatten *Inserts*	Bezeichnung *Part Number*	Bestellnummer *Order number*	Beschichtet *Coated*	Maße *Dimensions* [mm]					Schnittdaten *Cutting Data* [mm]	
			TD 5105	l	Ø d	s	Ø d_1	r	fn (mm/rev)	ap (mm)
DNGG-A20	**15 04 02- A20**	**10007316061**	○	15	12.70	4.76	3.81	0.2	0,05~0,15	0,80~3,50
	15 04 04- A20	**10007317061**	○	15	12.70	4.76	3.81	0.4	0,05~0,25	0,80~3,50
	15 04 08- A20	**10007318061**	○	15	12.70	4.76	3.81	0.8	0,10~0,40	0,80~3,50
	15 06 02- A20	**10007319061**	●	15	12.70	6.35	5.16	0.2	0,05~0,15	0,80~3,50
	15 06 04- A20	**10007320061**	●	15	12.70	6.35	5.16	0.4	0,05~0,25	0,80~3,50
	15 06 08- A20	**10007321061**	●	15	12.70	6.35	5.16	0.8	0,05~0,40	0,80~3,50

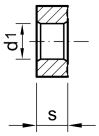


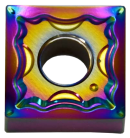
● JD-Lager / *JD-Stock* ○ begrenzte Lagerhaltung - auf Anfrage / *limited stock - upon request*

SNGG

90°

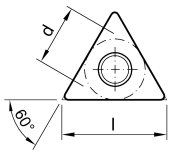


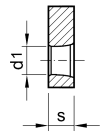


Wendeplatten *Inserts*	Bezeichnung *Part Number*	Bestellnummer *Order number*	Beschichtet *Coated*	Maße *Dimensions* [mm]					Schnittdaten *Cutting Data* [mm]	
			TD 5105	l	Ø d	s	Ø d_1	r	fn (mm/rev)	ap (mm)
SNGG -A20 	**12 04 04- A20**	**10007326061**	○	12	12.70	4.76	5.16	0.4	0,10~0,35	0,80~3,50
	12 04 08- A20	**10007327061**	○	12	12.70	4.76	5.16	0.8	0,10~0,40	0,80~3,50
	12 04 12- A20	**10007328061**	○	12	12.70	4.76	5.16	1.2	0,12~0,50	0,80~3,50

TNGG

60°

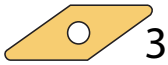


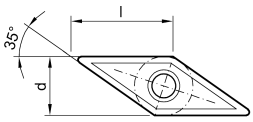


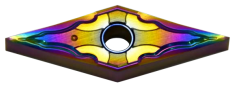
Wendeplatten *Inserts*	Bezeichnung *Part Number*	Bestellnummer *Order number*	Beschichtet *Coated*	Maße *Dimensions* [mm]					Schnittdaten *Cutting Data* [mm]	
			TD 5105	l	Ø d	s	Ø d_1	r	fn (mm/rev)	ap (mm)
TNGG-ALX	**16 04 02- A20**	**10007339061**	○	16	9.52	4.76	3.81	0.2	0,05~0,15	1,00~3,00
	16 04 04- A20	**10007340061**	○	16	9.52	4.76	3.81	0.4	0,12~0,30	1,00~3,50
	16 04 08- A20	**10007341061**	○	16	9.52	4.76	3.81	0.8	0,15~0,35	1,30~3,50
	16 04 12- A20	**10007342061**	○	16	9.52	4.76	3.81	1.2	0,15~0,55	1,30~3,50
	22 04 08- A20	**10007343061**	○	22	12.70	4.76	5.16	0.8	0,10~0,40	0,80~3,50

● JD-Lager / *JD-Stock* ○ begrenzte Lagerhaltung - auf Anfrage / *limited stock - upon request*

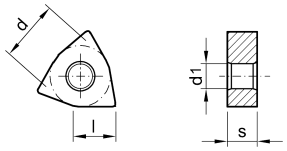
VNGG

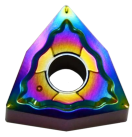




Wendeplatten *Inserts*	Bezeichnung *Part Number*	Bestellnummer *Order number*	Beschichtet *Coated*	Maße *Dimensions* [mm]					Schnittdaten *Cutting Data* [mm]	
			TD 5105	l	Ø d	s	Ø d_1	r	fn (mm/rev)	ap (mm)
VNGG-A20 	**16 04 01- A20**	**10007360061**	○	16	9.52	4.76	3.81	0.1	0,02~0,10	0,80~3,00
	16 04 02- A20	**10007361061**	●	16	9.52	4.76	3.81	0.2	0,05~0,15	0,80~3,00
	16 04 04- A20	**10007362061**	●	16	9.52	4.76	3.81	0.4	0,08~0,30	0,80~3,50
	16 04 08- A20	**10007363061**	○	16	9.52	4.76	3.81	0.8	0,10~0,35	0,80~3,50

WNGG



Wendeplatten *Inserts*	Bezeichnung *Part Number*	Bestellnummer *Order number*	Beschichtet *Coated*	Maße *Dimensions* [mm]					Schnittdaten *Cutting Data* [mm]	
			TK 1310	l	Ø d	s	Ø d_1	r	fn (mm/rev)	ap (mm)
WNGG-A20 	**06 04 04- A20**	**10007364061**	●	06	9.52	4.76	3.81	0.4	0,10~0,30	0,50~3,00
	06 04 08- A20	**10007365061**	●	06	9.52	4.76	3.81	0.8	0,10~0,40	0,80~3,50
	06 04 12- A20	**10007366061**	○	06	9.52	4.76	3.81	1.2	0,12~0,50	0,80~3,50
	08 04 02- A20	**10007367061**	●	08	12.70	4.76	5.20	0.2	0,05~0,25	0,40~4,00
	08 04 04- A20	**10007368061**	●	08	12.70	4.76	5.20	0.4	0,10~0,45	0,50~4,50
	08 04 08- A20	**10007369061**	●	08	12.70	4.76	5.20	0.8	0,10~0,45	0,50~4,50
	08 04 12- A20	**10007370061**	○	08	12.70	4.76	5.20	1.2	0,10~0,50	0,50~4,50

● JD-Lager / *JD-Stock* ○ begrenzte Lagerhaltung - auf Anfrage / *limited stock - upon request*

Schnittdaten-Empfehlungen zum Drehen
Cutting Data Recommendations for Turning

	Werkstückwerkstoff *Material*	Legierung *Alloy*	Brinell-Härte *hardness* HB	VDI 3323 *Gruppe*	Schnittgeschwindigkeiten / *Cutting Speeds* v_c [m/min]
					TD 5105 (K10-DLC)
A (P)	unlegierter Stahl *mild steel*	geglüht *annealed* ≤ 0,15% C	125	1	-
		geglüht *annealed* 0,15% - 0,45% C	150-250	2	-
		vergütet *heat treated* ≥ 0,45% C	300	3	-
	niedriglegierter Stahl *lower alloyed steel*	geglüht *annealed*	180	6	-
		vergütet *heat treated*	275	7	-
		vergütet *heat treated*	300	8	-
		vergütet *heat treated*	350	9	-
	hochlegierter Stahl *highly alloyed steel*	geglüht *annealed*	200	10	-
		vergütet *heat treated*	350	11	-
	nichtrostender Stahl *corrosion-resistant steel*	geglüht *annealed*	200	12	-
		vergütet *heat treated*	350	13	-
R (M)	rostfreier Stahl *stainless steel*	ferritisch / martensitisch / geglüht *ferritic / martensitic / annealed*	200	14	-
		austenitisch *austenitic*	180	14	-
		Duplex	230-260	14	-
		austenitisch/ferritisch *austenitic/ferritic*	330	14	-
F (K)	Grauguss *grey cast iron*	perlitisch/ferritisch *pearlitic/ferritic*	180	15	-
		perlitisch/martensitisch *pearlitic/martensitic*	260	16	-
	Grauguss mit Kugelgraphit *nodular cast iron*	ferritisch *ferritic*	160	17	-
		perlitisch *pearlitic*	250	18	-
	Temperguss *malleable cast iron*	ferritisch *ferritic*	130	19	-
		perlitisch *pearlitic*	230	20	-
N	Aluminium - Knetlegierungen *forging alloy*	nicht aushärtbar *not hardenable*	60	21	300 - 3200
		aushärtbar *hardenable*	100	22	200 - 2800
	Aluminium - Gusslegierungen *casting alloy*	nicht aushärtbar *not hardenable* < 8% Si	80	23	450 - 2300
		aushärtbar *hardenable* < 8% Si	90	24	400 - 1400
	Kupfer und Kupferlegierungen *copper and copper alloys* (Bronze, Messing) *(bronze, brass)*	Automatenlegierungen *free cutting alloys (1% Pb)*	-	26	200 - 1500
		Messing, Rotguss *brass, red bronze*	-	27	150 - 1100
		Bronze *bronze*	90	28	150 - 600
		bleifreies Kupfer und Elektrolytkupfer *unleaded copper*	100	29	130 - 500
	nichtmetallische Werkstoffe *non metallic materials*	Duroplaste *thermoset*	100	29	80 - 220
		faserverstärkte Kunststoffe *fiber reinforced plastic*	-	29	60 - 250
		Hartgummi *ebonite*	-	30	80 - 300
S	warmfeste Legierungen *heat resistant alloys*	Fe-Basis/*base* / geglüht *annealed*	200	31	-
		Fe-Basis/*base*(Incoloy)/ausgehärtet *hardened*	280	32	-
		Ni-Basis/*base* (Inconel)/geglüht *annealed*	250	33	-
		Ni- oder Co-Basis/ausgehärtet *hardened*	30-58 HRC	24	-
		Ni- oder Co-Basis / gegossen *cast*	1500-2200 Nmm²	35	-
	Titanlegierungen *titanium alloys*	Reintitan *Pure titanium*	R_m 400	36	80 - 160
		Alpha- + Beta-Legierungen *alloys*	R_m 1050	37	50 - 140
H	gehärteter Stahl *hardened steel*	gehärtet und angelassen *hardened and tempered*	55 HRC	38	-
			60 HRC	39	-
	Hartguss *chilled cast iron*	gegossen *cast*	400	40	-
	Gehärtetes Gusseisen *hardened cast iron*	gehärtet und angelassen *hardened and tempered*	55 HRC	40	-

Technische Änderungen vorbehalten, keine Haftung für Druckfehler. Abbildungen ähnlich.
Technical changes reserved, we bear no liability for misprints. Drawings/pictures similar.

Jörn Detjens Zerspanungstechnik GmbH
Bookkoppel 3
DE-22926 Ahrensburg

Tel.: +49-(0)41 07 - 90 73-0
Fax.: +49-(0)41 07 - 90 73-22
E-Mail: info@jd-tools.de

www.jd-tools.de