

HRSA TURNING **DOMX**



Designed specifically for the turning of HRSA, the DOMX insert offers exceptional performance when working with these difficult to machine materials. This novel geometry, combined with the advanced PHH coating, is sure to improve your productivity even in the toughest of challenges.

Desenvolvido especificamente para a maquinação de HRSA, a pastilha DOMX oferece um desempenho excepcional ao trabalhar com estes materiais de difícil maquinação. Esta geometria inovadora, combinada com o revestimento avançado PHH, certamente irá melhorar a sua produtividade mesmo nos desafios mais difíceis.

Diseñado específicamente para el torneado de HRSA, el plaquita DOMX ofrece un rendimiento excepcional al trabajar con estos materiales difíciles de mecanizar. Esta geometría novedosa, combinada con el avanzado recubrimiento PHH, seguramente mejorará su productividad incluso en los desafíos más difíciles.

DOMX 1506 > page 479

- > Available in size 15 and right or left

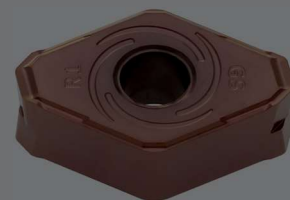
Disponível no tamanho 15 e para mãos direita ou esquerda | Disponible en talla 15 y para manos derecha o izquierda.

- > Available in PHH910 and PHH920

Disponível nos graus PHH910 e PHH920 | Disponible en las calidades PHH910 y PHH920

- > First choice for HRSA medium to rough turning

Primeira escolha para torneamento médio a desbaste de superligas | Primera elección para torneado medio a desbaste de superaleaciones



A - DDJN-DX1 45° > page 480

- > External toolholder with internal coolant

Suporte de torneamento externo com refrigeração interna | Porta-herramienta de torneado externo con refrigeración interna

- > With length from 125 mm to 170 mm

Com comprimento de 125 mm até 170 mm | Con longitud de 125 mm hasta 170 mm



PSC-DDJN-DX1 45° > page 481

- > PSC toolholder with internal coolant

Suporte PSC com refrigeração interna | Porta-herramienta PSC con refrigeración interna

- > With PSC size from 40 mm to 80 mm

Com tamanho de PSC de 40 mm até 80 mm | Con talla de PSC de 40 mm hasta 80 mm



DOMX® - the revolution in HRSA medium to rough turning

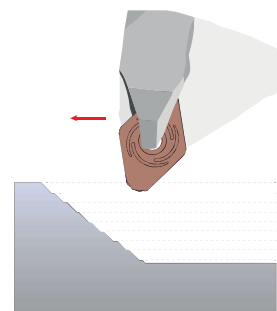
Proprietary turning line

Designed especially for HRSA, the DOMX® combined with PHH technology, offers exceptional performance in exotic materials machining. When your material has high Ni or Co content DOMX® is the choice!

🔧 First choice for **HRSA** medium to rough turning;

🔧 **4 positive cutting edges on double sided negative insert.**

DOMX®



🔧 Machine at 45° with a 93° holder;

🔧 **Up to + 140% tool life improvement.**

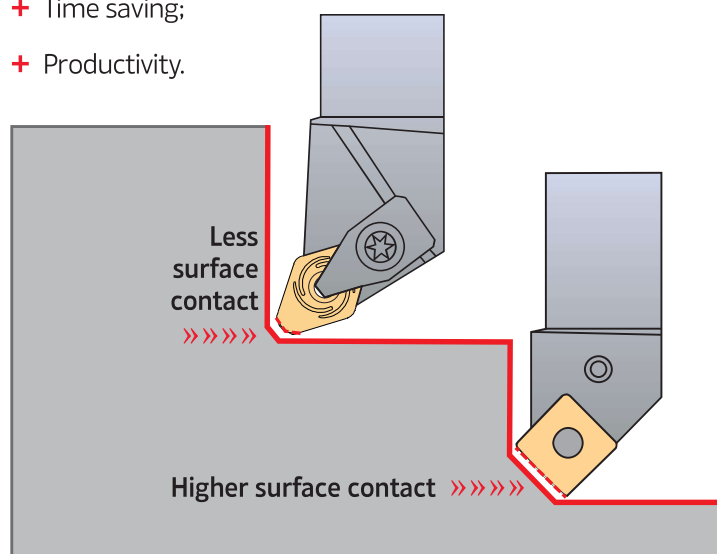
DOMX VS SNMG

- Surface contact;
- Heating;
- Vibration;
- Cutting effort;
- + Time saving;
- + Productivity.

COMERICAL
VIDEO

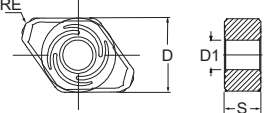
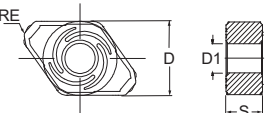


TECHNICAL
VIDEO



APPLICATION
GUIDE

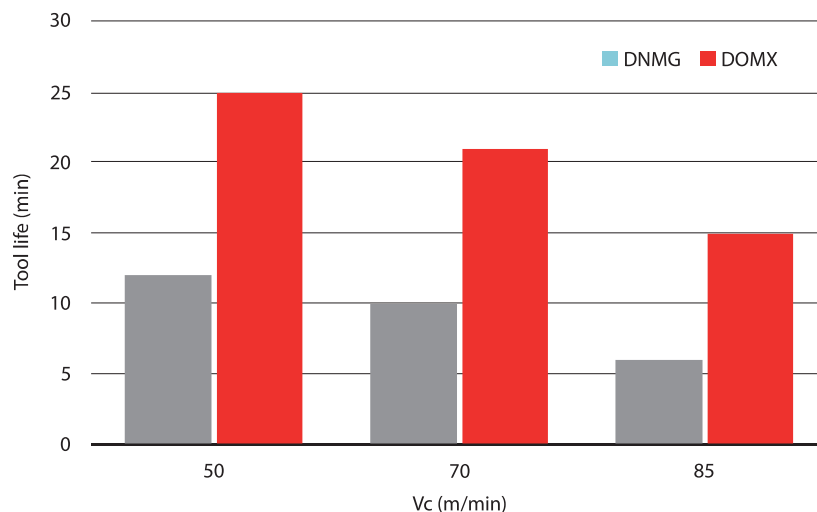
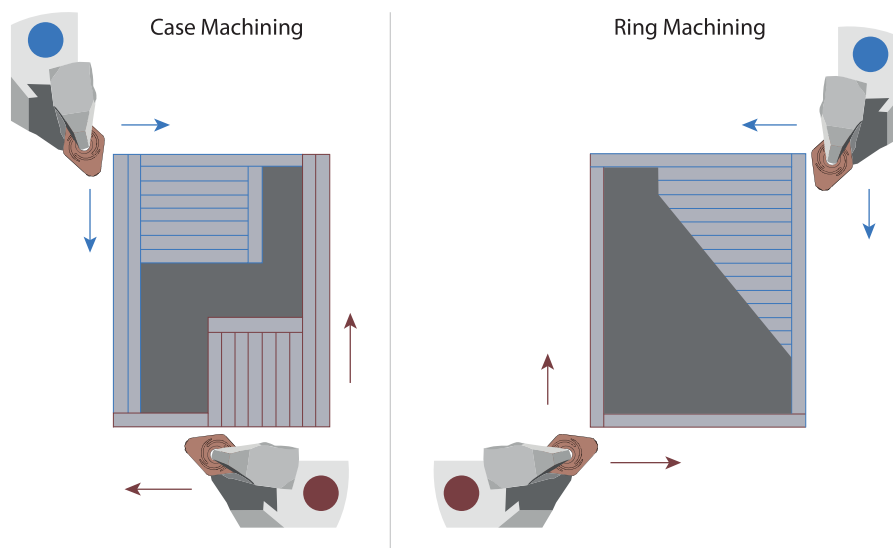


			S		Dimensions (mm) Dimensões (mm) Dimensiones (mm)				Cutting Conditions Condições de Corte Condiciones de Corte						Technical drawing Desenho técnico Dibujo técnico	
			PVD													
			⁽²⁾ Grade code													
Inserts Pastilhas Plaquetas	⁽¹⁾ Geometry code	ISO Reference	PHH910	PHH920	D	S	RE	D1	AP (mm)	MIN	MAX	FN (mm/rev)	MIN	MAX		
	1124595	DOMX 1506R1-GS			12,70	6,35	0,80	5,16	1,50	0,30	1,50	0,30	0,20	0,50		
	1124493	DOMX 1506L1-GS			12,70	6,35	0,80	5,16	1,50	0,30	1,50	0,30	0,20	0,50		

 First choice | 1ª Escolha | 1ª Opción  Stock Items | Itens de stock

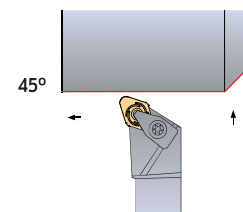
Insert Order Code: (1) Geometry code + (2) Grade code

DOMX® can be used in several types of turning operations, from facing, external/internal turning to case and ring machining as seen in the examples below:

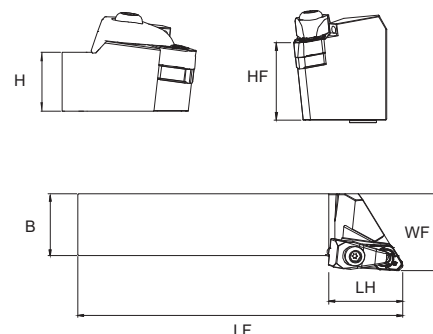
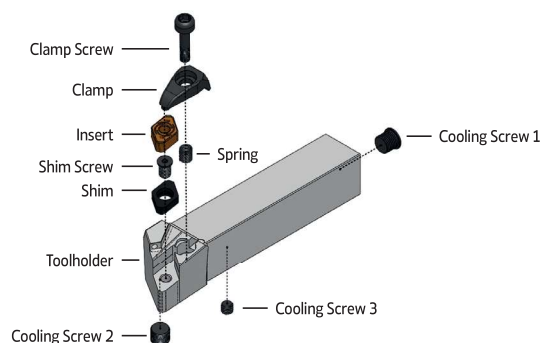


Tool life test – Inconel 625, AP 1,5mm, FN 0.15mm/r

(D) Dimple lock toolholders



Axial: -6,25°
Radial: -6,75°



Order code Código	Reference Referência Referencia	Dimensions Dimensões Dimensiones (mm)					Insert Pastilha Inserto	WT	Stock
		HF = H	B	LF	LH	WF			
Right toolholder									
182000900	DDJN R 2020 K15-A-DX1	20	20	125	42	25	DOMX 1506R1	0,40	Ⓢ
182001000	DDJN R 2525 M15-A-DX1	25	25	150	42	32	DOMX 1506R1	0,75	Ⓢ
182001100	DDJN R 3232 P15-A-DX1	32	32	170	42	40	DOMX 1506R1	1,30	Ⓢ
Left toolholder									
182001200	DDJN L 2020 K15-A-DX1	20	20	125	42	25	DOMX 1506L1	0,40	Ⓢ
182001300	DDJN L 2525 M15-A-DX1	25	25	150	42	32	DOMX 1506L1	0,75	Ⓢ
182001400	DDJN L 3232 P15-A-DX1	32	32	170	42	40	DOMX 1506L1	1,30	Ⓢ

⊗ Stock item | Produto de stock | Itens de stock

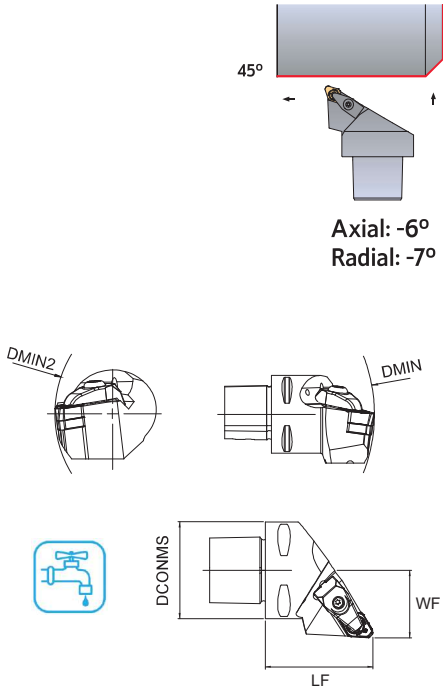
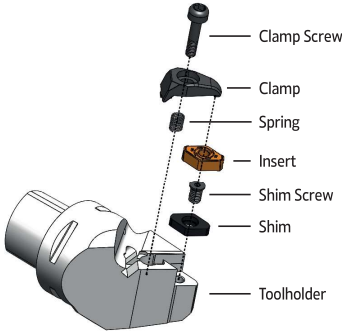
○ Available under request | Disponível sobre consulta | Disponible bajo consulta

SPARE PARTS Acessórios | Repuestos

Cutter Reference	Shim R	Shim L	Shim Screw	Spring	Clamp	Clamp Screw	Wrench	Coolant Screw 1	Coolant Screw 2	Coolant Screw 3
DDJN R/L 2020 K15-A-DX1										
DDJN R/L 2020 K15-A-DX1	CD150503	CD150502	T06010000	M09513	GA07002	D0602900	SS40	H0600475	H1000875	T1000875
DDJN R/L 2525 M15-A-DX1	CD150503	CD150502	T06010000	M09513	GA07002	D0602900	SS40	H0600475	H1000875	T1000875
DDJN R/L 3232 P15-A-DX1	CD150503	CD150502	T06010000	M09513	GA07002	D0602900	SS40	-	H1000875	-

(D) Dimple lock toolholders

Roughing to Heavy Roughing	Roughing to Heavy Roughing
DOMX (L1)	DOMX (R1)
	
(15)	(15)



Order code Código	Reference Referência Referencia	Dimensions (mm)					Insert Pastilha Inserto	WT	Stock
		DCONMS	DMIN	DMIN2	WF	LF			
Right toolholder									
182000100	PSC40-DDJN R 27055-15-DX1	40	110	145	27	55	DOMX 1506R1	0,42	
182000200	PSC50-DDJN R 35060-15-DX1	50	110	165	35	60	DOMX 1506R1	0,80	
182000300	PSC63-DDJN R 45065-15-DX1	63	110	190	45	65	DOMX 1506R1	1,10	
182000400	PSC80-DDJN R 55080-15-DX1	80	110	250	55	80	DOMX 1506R1	2,74	
Left toolholder									
182000500	PSC40-DDJN L 27055-15-DX1	40	110	145	27	55	DOMX 1506L1	0,42	
182000600	PSC50-DDJN L 35060-15-DX1	50	110	165	35	60	DOMX 1506L1	0,80	
182000700	PSC63-DDJN L 45065-15-DX1	63	110	190	45	65	DOMX 1506L1	1,10	
182000800	PSC80-DDJN L 55080-15-DX1	80	110	250	55	80	DOMX 1506L1	2,74	
 Stock item Produto de stock Itens de stock  Available under request Disponível sobre consulta Disponible bajo consulta									

SPARE PARTS Acessórios | Repuestos

Cutter Reference	Shim R	Shim L	Shim Screw	Spring	Clamp	Clamp Screw	Wrench
							
PSC40-DDJNR/L27055-15-DX1	CD150503	CD150502	T06010000	M09513	GA07002	D0602900	SS40
PSC50-DDJNR/L35060-15-DX1	CD150503	CD150502	T06010000	M09513	GA07002	D0602900	SS40
PSC63-DDJNR/L45065-15-DX1	CD150503	CD150502	T06010000	M09513	GA07002	D0602900	SS40
PSC80-DDJNR/L55080-15-DX1	CD150503	CD150502	T06010000	M09513	GA07002	D0602900	SS40