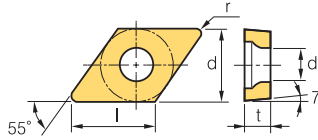


## DC

Rhombic **55° Positive**  
Relief Angle: 7°



| Dimensions (mm) |       |      |                |
|-----------------|-------|------|----------------|
| Size            | d     | t    | d <sub>1</sub> |
| 07              | 6.35  | 2.38 | 2.8            |
| 11              | 9.525 | 3.97 | 4.4            |

| Workpiece                            | Machining types |   |   |   |   |   |   |   |   |   |   |   |   |
|--------------------------------------|-----------------|---|---|---|---|---|---|---|---|---|---|---|---|
|                                      | P               | M | K | N | S | H |   |   |   |   |   |   |   |
| Steel                                | ●               | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● |
| Stainless steel                      | ●               | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● |
| Cast iron                            | ●               | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● |
| Non-ferrous metal                    | ●               | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● |
| Heat resistant alloy, Titanium alloy | ●               | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● |
| Hardened steel                       | ●               | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● |

● Continuous cutting  
● General cutting  
✱ Interrupted cutting

| Inserts                 | Designation     | Cermet |        | Coated |        | Coated |        |        |        |        |        |        |        |        |        | Uncoated |        | Cutting Condition |        |        |        |        |     |     |                            |                        |           |           |
|-------------------------|-----------------|--------|--------|--------|--------|--------|--------|--------|--------|--------|--------|--------|--------|--------|--------|----------|--------|-------------------|--------|--------|--------|--------|-----|-----|----------------------------|------------------------|-----------|-----------|
|                         |                 | CN1500 | CN2000 | CN2500 | CC1500 | CC2500 | NC3215 | NC3120 | NC3225 | NC3030 | NC5330 | NC6310 | NC6315 | NC9115 | NC9125 | NC9135   | PC5300 | PC5400            | PC8105 | PC8110 | PC8115 | PC9030 | H01 | H05 | f <sub>n</sub><br>(mm/rev) | a <sub>p</sub><br>(mm) |           |           |
| Finishing<br>           | DCMT 070202-VL  |        |        |        |        |        |        |        |        |        |        |        |        |        |        |          |        |                   |        |        |        |        |     |     |                            | 0.02~0.10              | 0.06~0.80 |           |
|                         | DCMT 070204-VL  | ●      | ●      | ●      | ●      | ●      | ●      | ●      | ●      | ●      | ●      | ●      | ●      | ●      | ●      | ●        | ●      | ●                 | ●      | ●      | ●      | ●      | ●   | ●   | ●                          | ●                      | 0.04~0.10 | 0.08~0.90 |
|                         | DCMT 070208-VL  |        |        |        |        |        | ●      | ●      | ●      | ●      | ●      | ●      | ●      | ●      | ●      | ●        | ●      | ●                 | ●      | ●      | ●      | ●      | ●   | ●   | ●                          | ●                      | 0.06~0.12 | 0.10~1.00 |
|                         | DCMT 11T302-VL  |        |        |        |        |        |        |        |        |        |        |        |        |        |        |          |        |                   |        |        |        |        |     |     |                            |                        | 0.03~0.10 | 0.07~0.80 |
|                         | DCMT 11T304-VL  | ●      | ●      | ●      | ●      | ●      | ●      | ●      | ●      | ●      | ●      | ●      | ●      | ●      | ●      | ●        | ●      | ●                 | ●      | ●      | ●      | ●      | ●   | ●   | ●                          | ●                      | 0.05~0.10 | 0.10~1.00 |
|                         | DCMT 11T308-VL  | ●      | ●      | ●      | ●      | ●      | ●      | ●      | ●      | ●      | ●      | ●      | ●      | ●      | ●      | ●        | ●      | ●                 | ●      | ●      | ●      | ●      | ●   | ●   | ●                          | ●                      | 0.08~0.15 | 0.10~1.00 |
| DCMT 11T312-VL          |                 |        |        |        |        |        |        |        |        |        |        |        |        |        |        |          |        |                   |        |        |        |        |     |     |                            | 0.08~0.15              | 0.30~1.50 |           |
| Finishing<br>           | DCMT 070204-VP1 |        |        |        |        |        |        |        |        |        |        |        |        |        |        |          |        |                   |        |        |        |        |     |     |                            | 0.05~0.12              | 0.10~1.50 |           |
|                         | DCMT 11T304-VP1 |        |        |        |        |        |        |        |        |        |        |        |        |        |        |          |        |                   |        |        |        |        |     |     |                            |                        | 0.06~0.20 | 0.10~1.50 |
|                         | DCMT 11T308-VP1 |        |        |        |        |        |        |        |        |        |        |        |        |        |        |          |        |                   |        |        |        |        |     |     |                            |                        | 0.08~0.23 | 0.10~1.50 |
| Medium to finishing<br> | DCMT 070202-HMP |        |        |        |        |        |        |        |        |        |        |        |        |        |        |          |        |                   |        |        |        |        |     |     |                            | 0.03~0.12              | 0.10~1.50 |           |
|                         | DCMT 070204-HMP |        |        |        |        |        |        |        |        | ●      | ●      | ●      | ●      | ●      | ●      | ●        | ●      | ●                 | ●      | ●      | ●      | ●      | ●   | ●   | ●                          | ●                      | 0.06~0.17 | 0.20~2.30 |
|                         | DCMT 070208-HMP |        |        |        |        |        |        |        |        | ●      | ●      | ●      | ●      | ●      | ●      | ●        | ●      | ●                 | ●      | ●      | ●      | ●      | ●   | ●   | ●                          | ●                      | 0.08~0.23 | 0.40~2.30 |
|                         | DCMT 11T302-HMP |        |        |        |        |        |        |        |        |        |        |        |        |        |        |          |        |                   |        |        |        |        |     |     |                            |                        | 0.04~0.22 | 0.10~2.00 |
|                         | DCMT 11T304-HMP |        |        | ●      |        |        |        |        |        | ●      | ●      | ●      | ●      | ●      | ●      | ●        | ●      | ●                 | ●      | ●      | ●      | ●      | ●   | ●   | ●                          | ●                      | 0.08~0.23 | 0.30~3.00 |
|                         | DCMT 11T308-HMP |        |        |        |        |        |        |        |        | ●      | ●      | ●      | ●      | ●      | ●      | ●        | ●      | ●                 | ●      | ●      | ●      | ●      | ●   | ●   | ●                          | ●                      | 0.10~0.30 | 0.50~3.00 |
| Medium to finishing<br> | DCMT 070202-MP  | ●      | ●      | ●      | ●      | ●      | ●      | ●      | ●      | ●      | ●      | ●      | ●      | ●      | ●      | ●        | ●      | ●                 | ●      | ●      | ●      | ●      | ●   | ●   | ●                          | 0.04~0.12              | 0.12~1.80 |           |
|                         | DCMT 070204-MP  | ●      | ●      | ●      | ●      | ●      | ●      | ●      | ●      | ●      | ●      | ●      | ●      | ●      | ●      | ●        | ●      | ●                 | ●      | ●      | ●      | ●      | ●   | ●   | ●                          | ●                      | 0.05~0.15 | 0.30~1.80 |
|                         | DCMT 070208-MP  | ●      | ●      | ●      | ●      | ●      | ●      | ●      | ●      | ●      | ●      | ●      | ●      | ●      | ●      | ●        | ●      | ●                 | ●      | ●      | ●      | ●      | ●   | ●   | ●                          | ●                      | 0.08~0.22 | 0.30~1.80 |
|                         | DCMT 11T302-MP  | ●      | ●      | ●      | ●      | ●      | ●      | ●      | ●      | ●      | ●      | ●      | ●      | ●      | ●      | ●        | ●      | ●                 | ●      | ●      | ●      | ●      | ●   | ●   | ●                          | ●                      | 0.04~0.15 | 0.30~2.00 |
|                         | DCMT 11T304-MP  | ●      | ●      | ●      | ●      | ●      | ●      | ●      | ●      | ●      | ●      | ●      | ●      | ●      | ●      | ●        | ●      | ●                 | ●      | ●      | ●      | ●      | ●   | ●   | ●                          | ●                      | 0.08~0.20 | 0.50~2.30 |
|                         | DCMT 11T308-MP  | ●      | ●      | ●      | ●      | ●      | ●      | ●      | ●      | ●      | ●      | ●      | ●      | ●      | ●      | ●        | ●      | ●                 | ●      | ●      | ●      | ●      | ●   | ●   | ●                          | ●                      | 0.10~0.30 | 0.50~2.30 |
|                         | DCMT 11T312-MP  |        |        |        |        |        |        |        |        |        |        |        |        |        |        |          |        |                   |        |        |        |        |     |     |                            |                        | 0.25~0.35 | 0.80~3.00 |
| Medium cutting<br>      | DCMT 070202-C25 | ●      | ●      | ●      | ●      | ●      | ●      | ●      | ●      | ●      | ●      | ●      | ●      | ●      | ●      | ●        | ●      | ●                 | ●      | ●      | ●      | ●      | ●   | ●   | ●                          | 0.03~0.15              | 0.30~2.00 |           |
|                         | DCMT 070204-C25 | ●      | ●      | ●      | ●      | ●      | ●      | ●      | ●      | ●      | ●      | ●      | ●      | ●      | ●      | ●        | ●      | ●                 | ●      | ●      | ●      | ●      | ●   | ●   | ●                          | ●                      | 0.05~0.20 | 0.50~2.50 |
|                         | DCMT 070208-C25 | ●      | ●      | ●      | ●      | ●      | ●      | ●      | ●      | ●      | ●      | ●      | ●      | ●      | ●      | ●        | ●      | ●                 | ●      | ●      | ●      | ●      | ●   | ●   | ●                          | ●                      | 0.06~0.25 | 0.80~2.50 |
|                         | DCMT 11T302-C25 | ●      | ●      | ●      | ●      | ●      | ●      | ●      | ●      | ●      | ●      | ●      | ●      | ●      | ●      | ●        | ●      | ●                 | ●      | ●      | ●      | ●      | ●   | ●   | ●                          | ●                      | 0.04~0.25 | 0.50~2.50 |
|                         | DCMT 11T304-C25 | ●      | ●      | ●      | ●      | ●      | ●      | ●      | ●      | ●      | ●      | ●      | ●      | ●      | ●      | ●        | ●      | ●                 | ●      | ●      | ●      | ●      | ●   | ●   | ●                          | ●                      | 0.08~0.30 | 0.80~3.00 |
|                         | DCMT 11T308-C25 | ●      | ●      | ●      | ●      | ●      | ●      | ●      | ●      | ●      | ●      | ●      | ●      | ●      | ●      | ●        | ●      | ●                 | ●      | ●      | ●      | ●      | ●   | ●   | ●                          | ●                      | 0.10~0.30 | 1.00~3.00 |

🔄 Cutting edge geometry A52~A61
🔄 Recommended chip breaker B04~B11
🔄 Code system B26~B27
● : Stock item

| Available tool holders |           |             |      |
|------------------------|-----------|-------------|------|
| Designation            | Page      | Designation | Page |
| SDACR/L                | B178      | SDQCR/L     | B206 |
| SDJCR/L                | B113, 179 | SDUCR/L     | B207 |
| SDNCN                  | B114, 179 | SDZCR/L     | B208 |

