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New uncoated turning grade - Polished so perfect, it reflects!

DTU6015N

ISO
N

Minimum Chipping • Maximum Productivity

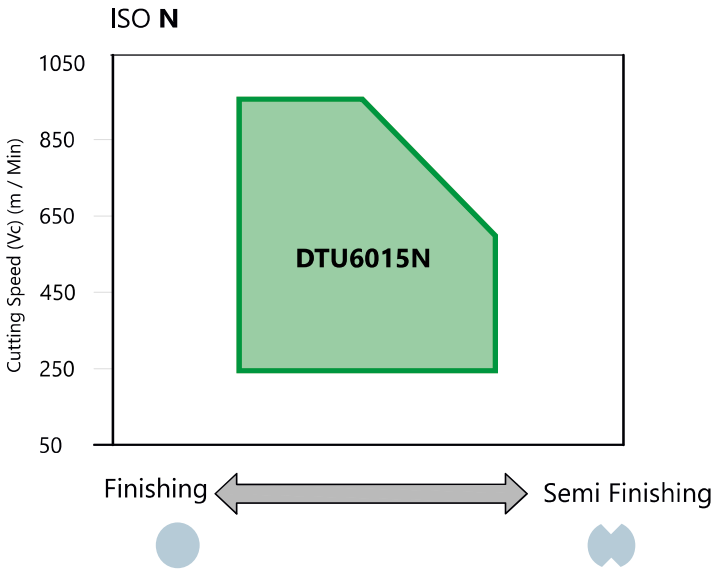


Brochure/MDC/2026/003

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Application area



Aluminium turning operation, which have become quite widespread, pose peculiar issues during machining - primarily due to the high ductility of the workpiece material.

The sticky nature of the workpiece often leads to built-up-edge formation and consequently, the unexpected insert chipping off.
Precisely these issues are effectively handled using the our grades for Aluminium turning called **DTU6015N**.

Application area : N10-N20

Polished Rake Face Advantage

Fine ground and polished rake face of the inserts is instrumental in smooth movement of the sticky Aluminium chips, thereby eliminating the process of built up edge formation.

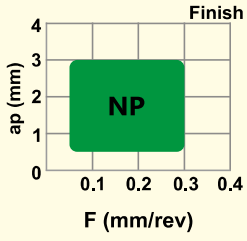
DTU6015N is a fine grained uncoated grade engineered for **Aluminium turning operations. Recommended for semi-finishing to finishing operations.**

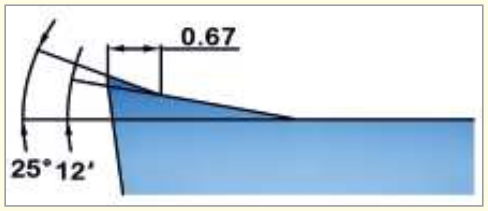
RECOMMENDED **Cutting parameters**

Materials	Parameters	for DTU6015N
Aluminium	Speed (m/min)	250 **650** 950 (Ideal)
	Feed (mm/rev)	0.05 **0.1** 0.25

Chipbreaker application range

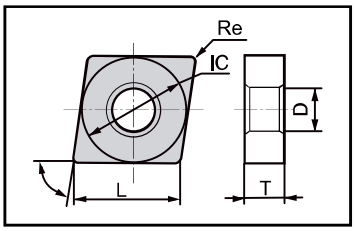
Aluminium turning polished rake insert comes with a special geometry named - **NP**.
This geometry features a **high rake angle of 25 degrees** resulting into a **sharp positive cutting edge** which is vital for aluminium machining.





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In Stock - ● Make to Order - ○ **(All dimensions are in mm)**

Shape	Catalogue No.	Re Nose Radius	Grade DTU6015N	IC Inscribed circle	T Thickness	D Hole Dia.
Positive with Chip Breaker Geometry						
C 80°	CCGX060202-NP	0.2	●	6.35	2.38	2.8
	CCGX060204-NP	0.4	●	6.35	2.38	2.8
	CCGX060208-NP	0.8	●	6.35	2.38	2.8
	CCGX09T302-NP	0.2	●	9.525	3.97	4.4
	CCGX09T304-NP	0.4	●	9.525	3.97	4.4
	CCGX09T308-NP	0.8	●	9.525	3.97	4.4
	CCGX120402-NP	0.2	●	12.7	4.76	5.5
	CCGX120404-NP	0.4	●	12.7	4.76	5.5
	CCGX120408-NP	0.8	●	12.7	4.76	5.5
D 55°	DCGX070202-NP	0.2	●	6.35	2.38	2.8
	DCGX070204-NP	0.4	●	6.35	2.38	2.8
	DCGX070208-NP	0.8	●	6.35	2.38	2.8
	DCGX11T302-NP	0.2	●	9.525	3.97	4.4
	DCGX11T304-NP	0.4	●	9.525	3.97	4.4
	DCGX11T308-NP	0.8	●	9.525	3.97	4.4
S 90°	SCGX09T304-NP	0.4	●	9.525	3.97	4.4
	SCGX09T308-NP	0.4	●	9.525	3.97	4.4
	SCGX120404-NP	0.4	●	12.7	4.76	5.5
	SCGX120408-NP	0.8	●	12.7	4.76	5.5
T 60°	TCGX090204-NP	0.4	●	5.56	2.38	2.5
	TCGX110202-NP	0.2	●	6.35	2.38	2.8
	TCGX110204-NP	0.4	●	6.35	2.38	2.8
	TCGX110208-NP	0.8	●	6.35	2.38	2.8
	TCGX16T302-NP	0.2	●	9.525	3.97	4.3
	TCGX16T304-NP	0.4	●	9.525	3.97	4.3
	TCGX16T308-NP	0.8	●	9.525	3.97	4.3
V 35°	VCGX110302-NP	0.2	●	6.35	3.18	2.8
	VCGX110304-NP	0.4	●	6.35	3.18	2.8
	VCGX110308-NP	0.8	●	6.35	3.18	2.8
	VCGX160402-NP	0.2	●	9.525	4.76	4.4
	VCGX160404-NP	0.4	●	9.525	4.76	4.4
	VCGX160408-NP	0.8	●	9.525	4.76	4.4
	VCGX160412-NP	1.2	●	9.525	4.76	4.4

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Motherson Techno Tools Limited

Communication address: A-2, Sector 84, Noida - 201301, Uttar Pradesh, India.
Reg. Office: 2nd floor, Block B1, Mohan Cooperative Industrial Estate,
Mathura Road, New Delhi - 110044, India.
CIN No.: U74999DL1992PLC049607

Ph.: +91-120-6110000 | marketing.mttl@motherson.com

www.mothersontools.com

Motherson Deltacarb Advanced Metal Solutions SA

Via Al Molino 29,
CH-6915 Pambio Noranco-Lugano, Switzerland

info.deltacarb@motherson.com

www.deltacarb.ch | www.motherson.com

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