

PRODUCT NEWS



T-CLAMP **ULTRA+**[™]

TAILOR MADE INSERTS DELIVERED IN 4 WEEKS!

INSERT STYLES

TDT - Turn/Groove with chip breaker

TDG - Flat Top

Single or Double End

T-Clamp Ultra Plus Inserts Only

OPTIONS

Special Widths

Special Corner Radii

Special Lead Angles

Special Forms

GRADES

TT9080 - General Purpose

TT7280 - For Steel, high toughness

Uncoated grades upon request

WIDTHS

2mm - 10mm

LEAD TIME

4 weeks!

(Subject to blank availability)

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T-CLAMP ULTRA+™

For over 100 years Ingersoll has recognized that not all components are made using standard inserts. When it comes to grooving applications, work piece features will often require special widths, angles, corner radii, depths, or entirely special forms on an insert. In many cases a special insert can also provide a more efficient way to produce a groove, particularly in high production environments.

Ingersoll also recognizes that its customers need fast deliveries. The sooner our customers have the insert they need, the faster they can machine their parts.

*To address this need, Ingersoll is pleased to announce a new program that offers a 4-week delivery for Special T-Clamp Ultra Plus inserts!**



The inserts available within this program feature the TDT style, turn-groove style geometry, and can range anywhere from 2-10mm wide, single or double-ended, for external, internal or face-grooving applications. TDG style, flat-top inserts can also be produced with a slightly longer delivery for applications that do not require a chip breaker. These special inserts will be tailor-made in our state-of-the-art manufacturing facilities in Rockford, Illinois.



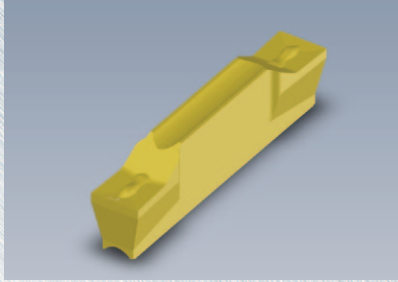
**Additional lead time may be required for very complex forms. Contact Ingersoll for more details.*

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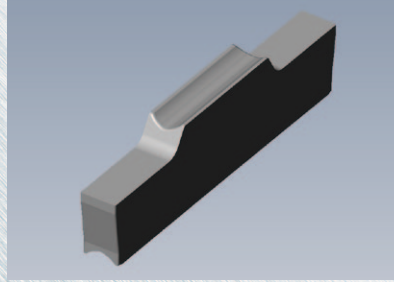
TOCLAMP^{ULTRA+}

GEOMETRY OPTIONS

TDT Chipbreaker
For Turning or Grooving



TDG (Flat Top)
For Grooving



GRADE OPTIONS

P20-P40 M20-M40 S20-S40

TT9080 - Universal grade. Exceptional performance in alloy steel, stainless steel & high temp alloys.

P25-P45 M25-M45

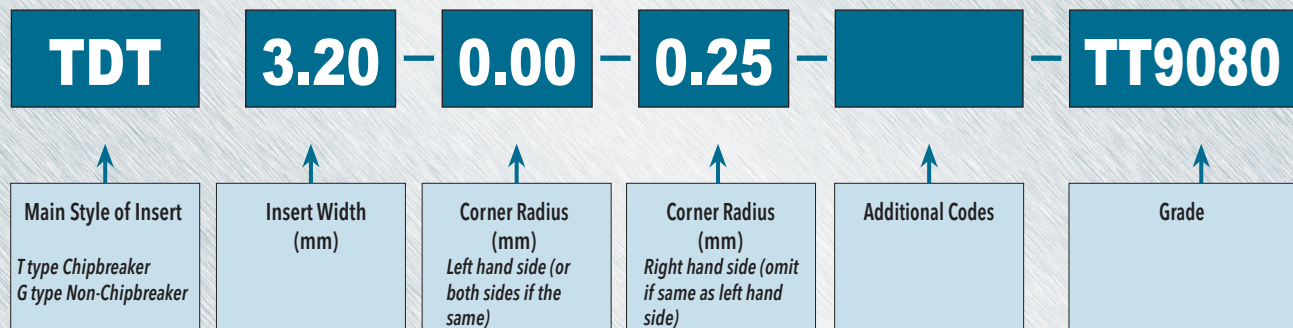
TT7280 - Tough substrate. First choice in difficult applications.

K05-K15 N05-N15

UF10 - Uncoated. First choice in nonferrous materials and cast iron

All coated grades feature our **GOLD•RUSH** technology, the latest in coating and special post-coat treatment that improves wear resistance and cutting edge toughness while reducing build up.

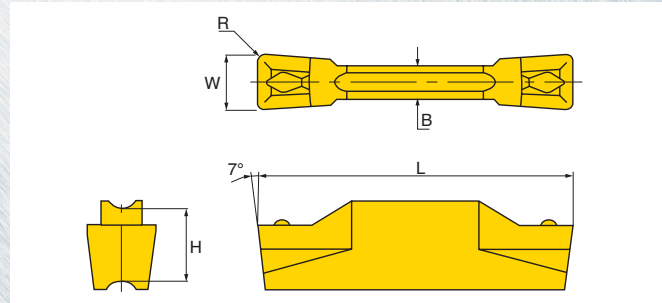
INSERT DESCRIPTION NOMENCLATURE



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INSERT SEAT SIZE REFERENCE CHART



TDT Blank	Flat Top Blank	W Insert Width Range	Seat Size	B (mm)	L (mm)
	BTDBG2.2	1.50mm* - 2.00mm	2	2.20	20
	BTDBG2.6	2.10mm* - 2.40mm	2	2.25	20
B TDBT2.6		1.50mm* - 2.40mm	2	2.25	20
B TDBT3.4	BTDBG3.4	2.41mm - 3.20mm	3	2.25	20
B TDBT4.4	BTDBG4.4	3.21mm - 4.20mm	4	3.05	20
B TDBT5.4	BTDBG5.4	4.21mm - 5.20mm	5	4.05	25
B TDBT6.4	BTDBG6.4	5.21mm - 6.20mm	6	5.05	25
B TDBT8.5	BTDBG8.5	6.21mm - 8.30mm	8	6.05	25
B TDBT10.5		8.31mm - 10.30mm	8	8.05	30

* Limited groove depth.

Inserts are ground to +/- .0008" tolerance on width.

For blades and holders please refer to Ingersoll's catalog or website: www.ingersoll-imc.com

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INSERT DESCRIPTION EXAMPLES

Shape	Designation	Remarks
<p>R0.5 TYP 4.0</p>	TDT 4.00-0.50	Symmetrical Type
<p>R0.25 3.2 R0.0</p>	TDIT 3.20-0.00-0.25	Non-Symmetrical Type
<p>R1.65 3.30</p>	TDT 3.30-1.65	Full-R Type
<p>R0.0 4.0 R0.3 5°</p>	TDT 4.00-0.30-5RA	L: Chamfer on left hand side R: Chamfer on right hand side
<p>15° 3.1 R0.1 TYP</p>	TDT 3.10-0.10-15LA	
<p>R1.2 5.28 4.1 R0.0 25°</p>	TDG 5.28-1.20-R25A	
<p>R0.0 25° 5.28 4.1 R1.2</p>	TDT 5.28-1.20-L25A	
<p>R0.35 TYP 4.4 1.82 29°</p>	TDG 4.40-1.82-0.35-29A	
<p>R0.35 4.4 1.5 30° R0.1</p>	TDT 4.40-1.50-0.10-0.35-30A	
<p>R0.2 45° 5.28 4.1 2.05 R0.0 25°</p>	TDT 5.28-4.10-2.05-0.00-0.20-L25A-R45A	

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INSERT DESCRIPTION EXAMPLES

Shape	Designation	Remarks
	TDG 4.40-0.15-60A	
	TDG 5.40-0.10-L50A-R30A	
	TDT 3.90-4.00	
	TDT 2.00-1.90-0.30-0.05-3.50T	
	TDT 1.90-0.30-4.20T	
	TDG 1.98-0.00-4.5T-45A-0.2	
	TDFT 3.80-0.25-4.50T	
	TDIT 2.60-1.30	
The Others	Available upon customer's request	