

SA CHIPBREAKER

Ground positive ISO inserts for high precision turning



Insert Styles:

CCGT
DCGT
TCGT
VBGT
VCGT

Grades:

TT5030
TT9020

Corner Radii:

.004, .008, .016 inches

Feed Rates:

.0005~.008 ipr (0.01~0.2 mm/rev)

Cutting Depths:

.004~.100 inches (0.1~2.5 mm)

Applications:

- Grade TT9020 suitable for Swiss sliding head turning centers
- Grade TT5030 ideal for precision aerospace applications

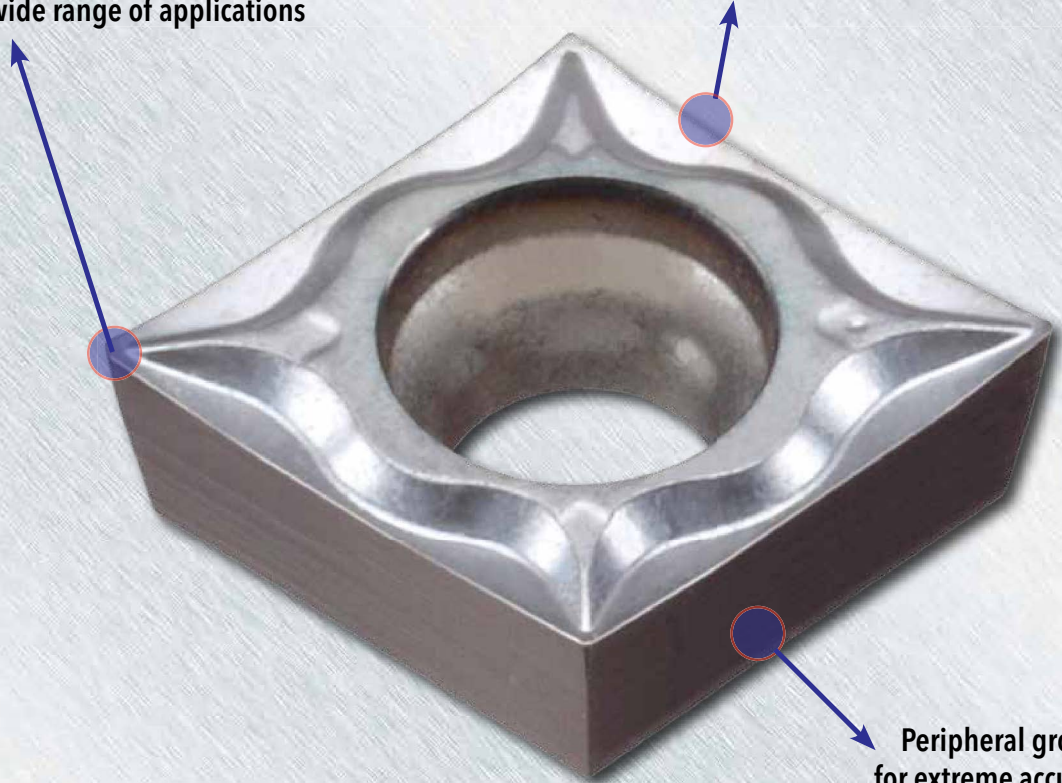
Ingersoll has now launched its new Mini Turn SA chipbreaker for small part turning operations. This new SA chipbreaker has a ground finish to achieve high precision machining on small workpieces. With its optimized corner cutting edge configuration and excellent chip control at low feed rates and depth of cut, exceptional precision is guaranteed. The new SA chipbreaker is available in Ingersoll's TT9020 and TT5030 grades, which employ fine grain carbide substrates with PVD coating. This combination guarantees improved wear resistance to insert fracture and chipping.

Features

- Peripherally ground geometry provides high accuracy
- Low cutting forces due to an inclined, sharp cutting edge and wide groove geometry
- Excellent chip control at low feed rates and depths of cut, due to an optimized chip-breaker design

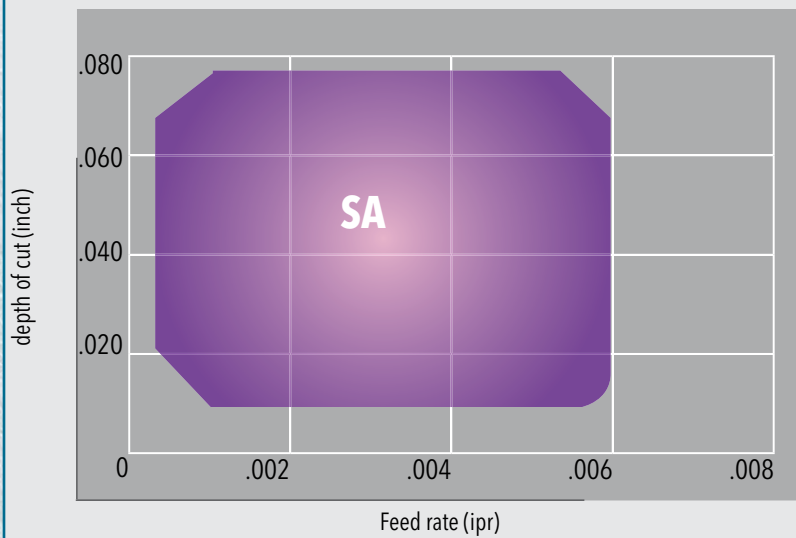
Chip-breaker design suitable for wide range of applications

Waved & sharp cutting edge induces smooth cutting



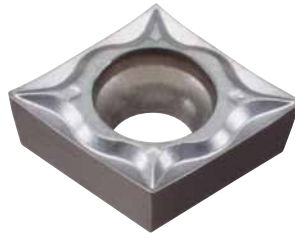
Peripheral ground for extreme accuracy

CHIP CONTROL RANGE



- Insert: CCGT 32.51 SA
- Cutting speed: 650 sfm
- Material: 0.45% Carbon steel

■ CCGT SA - -7° POSITIVE, 80° RHOMBIC GROUND INSERTS WITH SA CHIPBREAKER



ANSI Number	ISO Number	feed (ipr)	DOC (inch)	Grade	TT5030	TT9020
CCGT 21.50 SA	CCGT 060201 SA	.0008 - .0060	.004 - .060	●	●	●
CCGT 21.50.5 SA	CCGT 060202 SA	.0008 - .0060	.004 - .060	●	●	●
CCGT 21.51 SA	CCGT 060204 SA	.0020 - .0080	.004 - .095	●	●	●
CCGT 32.50 SA	CCGT 09T301 SA	.0008 - .0060	.004 - .100	●	●	●
CCGT 32.50.5 SA	CCGT 09T302 SA	.0008 - .0060	.004 - .100	●	●	●
CCGT 32.51 SA	CCGT 09T304 SA	.0020 - .0080	.008 - .100	●	●	●

● = P ● = M ● = K ● = N ● = S ○ = H

■ DCGT SA - -7° POSITIVE, 55° RHOMBIC GROUND INSERTS WITH SA CHIPBREAKER



ANSI Number	ISO Number	feed (ipr)	DOC (inch)	Grade	TT5030	TT9020
DCGT 21.50 SA	DCGT 070201 SA	.0008 - .0060	.004 - .060	●	●	●
DCGT 21.50.5 SA	DCGT 070202 SA	.0008 - .0060	.004 - .060	●	●	●
DCGT 21.51 SA	DCGT 070204 SA	.0010 - .0080	.004 - .060	●	●	●
DCGT 32.50 SA	DCGT 11T301 SA	.0005 - .0040	.004 - .100	●	●	●
DCGT 32.50.5 SA	DCGT 11T302 SA	.0008 - .0060	.004 - .100	●	●	●
DCGT 32.51 SA	DCGT 11T304 SA	.0010 - .0080	.004 - .100	●	●	●

● = P ● = M ● = K ● = N ● = S ○ = H

TCGT SA - -7° POSITIVE, TRIANGULAR GROUND INSERTS WITH SA CHIPBREAKER



ANSI Number	ISO Number	feed (ipr)	DOC (inch)	Grade	TT5030	TT9020
TCGT 21.50 SA	TCGT 110201 SA	.0005 - .0040	.004 - .100	●	●	●
TCGT 21.50.5 SA	TCGT 110202 SA	.0008 - .0060	.008 - .100	●	●	●
TCGT 21.50 SA	TCGT 110204 SA	.0010 - .0080	.008 - .100	●	●	●

● = P ● = M ● = K ● = N ● = S ○ = H

VBGT SA - -7° POSITIVE, 35° RHOMBIC GROUND INSERTS WITH SA CHIPBREAKER



ANSI Number	ISO Number	feed (ipr)	DOC (inch)	Grade	TT5030	TT9020
VBGT 220 SA	VBGT 110301 SA	.0005 - .0030	.004 - .060	●	●	●
VBGT 220.5 SA	VBGT 110302 SA	.0008 - .0030	.008 - .060	●	●	●
VBGT 221 SA	VBGT 110304 SA	.0010 - .0040	.008 - .060	●	●	●

● = P ● = M ● = K ● = N ● = S ○ = H

VC GT SA - -7° POSITIVE, 35° RHOMBIC GROUND INSERTS WITH SA CHIPBREAKER



ANSI Number	ISO Number	feed (ipr)	DOC (inch)	Grade	TT5030	TT9020
VC GT 220 SA	VC GT 110301 SA	.0005 - .0030	.004 - .060	●	●	●
VC GT 220.5 SA	VC GT 110302 SA	.0008 - .0030	.008 - .060	●	●	●
VC GT 221 SA	VC GT 110304 SA	.0010 - .0040	.008 - .060	●	●	●

● = P ● = M ● = K ● = N ● = S ○ = H