



TOTURN™

PC CHIPBREAKER

FOR POSITIVE INSERTS

NEW SINGLE SIDED 'PC' CHIPBREAKER FOR SEMI-FINISH AND MEDIUM MACHINING

Now available from Ingersoll is the new Positive 'PC' Chipbreaker for turning.

This new single sided 'PC' chipbreaker is suited to semi-finish and medium machining similar to the existing double-sided chipbreaker. It has been designed to work under a variety of cutting conditions whilst ensuring the steady and continuous control of swarf. In addition, its distinctive low cutting forces achieve superb surface finish and long tool life. Moreover, the innovative geometry design of the PC Chipbreaker can be applied to general steel, stainless steel and cast iron machining.



Insert Styles:

VBMT PC
CCMT PC
DCMT PC
RCMT PC
SCMT PC
TCMT PC
VCMT PC
CPMT PC
TPMT PC

Grades:

CT3000
TT8115
TT8125
TT9225
TT9080

Feed Rates:

.002~.024 ipr (0.06~0.60 mm/rev)

Cutting Depths:

.020~.177 inches (0.5~4.5 mm)

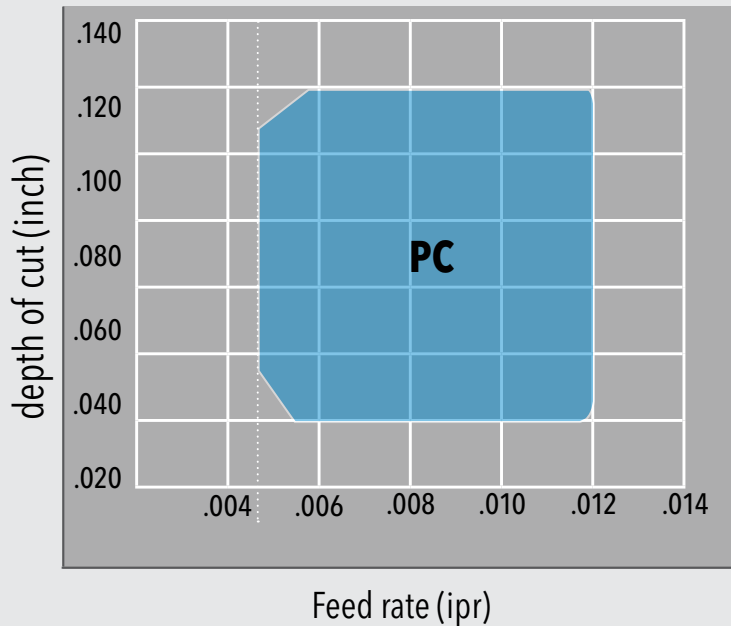
Applications:

- Medium machining operations where lower cutting forces are needed

FEATURES

- Low cutting forces due to its positive rake angle
- Wide chip breaking range
- Suitable for a wide variety of materials
- For semi-finish to medium application
- 5°, 7°, and 11° positive inserts available

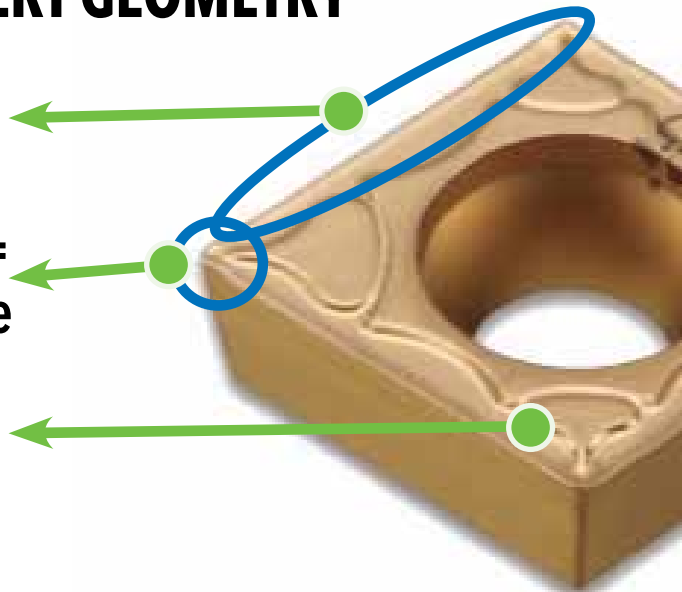
CHIP CONTROL RANGE



- Insert: CCMT 32.52 (09T308)
- Cutting speed: 650 sfm
- Material: 0.45% Carbon steel

POSITIVE PC INSERT GEOMETRY

- Slightly waved cutting edge
- Dimple Design = Low cutting Force
- Wide Groove for Smooth Cutting



VBMT PC - 5° POSITIVE INSERTS WITH PC CHIPBREAKER



ANSI Number	ISO Number	feed (ipr)	DOC (inch)	Grade	PV3010	CT3000	TT8115	TT9225	TT9080
VBMT331PC	VBMT160404PC	0.003 - 0.009	0.020 - 0.110						
VBMT332PC	VBMT160408PC	0.004 - 0.011	0.020 - 0.110						
VBMT333PC	VBMT160412PC	0.004 - 0.011	0.020 - 0.110						

● = P ● = M ● = K ● = N ● = S ○ = H

CCMT PC - 7° POSITIVE, 80° RHOMBIC INSERTS WITH PC CHIPBREAKER



ANSI Number	ISO Number	feed (ipr)	DOC (inch)	Grade	CT3000	TT8115	TT8125	TT9225	TT5100	TT9080
CCMT21.51PC	CCMT060204PC	0.002 - 0.007	0.007 - 0.079							
CCMT21.52PC	CCMT060208PC	0.003 - 0.010	0.010 - 0.079							
CCMT32.51PC	CCMT09T304PC	0.003 - 0.010	0.010 - 0.118							
CCMT32.52PC	CCMT09T308PC	0.004 - 0.011	0.011 - 0.118							
CCMT431PC	CCMT120404PC	0.003 - 0.010	0.010 - 0.157							
CCMT432PC	CCMT120408PC	0.004 - 0.012	0.012 - 0.157							
CCMT433PC	CCMT120412PC	0.005 - 0.014	0.014 - 0.157							

● = P ● = M ● = K ● = N ● = S ○ = H

DCMT PC - 7° POSITIVE, 55° RHOMBIC INSERTS WITH PC CHIPBREAKER



ANSI Number	ISO Number	feed (ipr)	DOC (inch)	Grade	CT3000	TT8115	TT8125	TT9225	TT9080
DCMT21.51PC	DCMT070204PC	0.002 - 0.007	0.012 - 0.079						
DCMT21.52PC	DCMT070208PC	0.003 - 0.010	0.016 - 0.079						
DCMT32.51PC	DCMT11T304PC	0.003 - 0.010	0.014 - 0.118						
DCMT32.52PC	DCMT11T308PC	0.004 - 0.011	0.020 - 0.118						
DCMT32.53PC	DCMT11T312PC	0.005 - 0.013	0.020 - 0.118						

● = P ● = M ● = K ● = N ● = S ○ = H

RCMT PC - 7° POSITIVE ROUND INSERTS WITH PC CHIPBREAKER



ANSI Number	ISO Number	feed (ipr)	DOC (inch)	Grade	TT8115	TT8125	TT9225	TT9235	TT5030
RCMT120400PC	RCMT120400PC	0.008 - 0.024	0.051 - 0.177						

● = P ● = M ● = K ● = N ● = S ○ = H

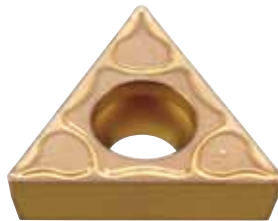
SCMT PC - 7° POSITIVE SQUARE INSERTS WITH PC CHIPBREAKER



ANSI Number	ISO Number	feed (ipr)	DOC (inch)	Grade	CT3000	TT8115	TT8125	TT9225	TT9080
SCMT32.51PC	SCMT09T304PC	0.003 - 0.010	0.014 - 0.118						
SCMT32.52PC	SCMT09T308PC	0.004 - 0.011	0.020 - 0.118						
SCMT431PC	SCMT120404PC	0.003 - 0.010	0.016 - 0.157						
SCMT432PC	SCMT120408PC	0.004 - 0.012	0.028 - 0.157						
SCMT433PC	SCMT120412PC	0.005 - 0.014	0.039 - 0.157						

● = P ● = M ● = K ● = N ● = S ○ = H

TCMT PC - 7° POSITIVE TRIANGULAR INSERTS WITH PC CHIPBREAKER



ANSI Number	ISO Number	feed (ipr)	DOC (inch)	Grade	CT3000	TT8115	TT8125	TT9225	TT9080
TCMT731PC	TCMT090204PC	0.002 - 0.007	0.012 - 0.079						
TCMT732PC	TCMT090208PC	0.003 - 0.010	0.016 - 0.079						
TCMT21.51PC	TCMT110204PC	0.002 - 0.008	0.012 - 0.098						
TCMT21.52PC	TCMT110208PC	0.004 - 0.010	0.017 - 0.098						
TCMT32.51PC	TCMT16T304PC	0.003 - 0.010	0.014 - 0.118						
TCMT32.52PC	TCMT16T308PC	0.004 - 0.011	0.020 - 0.118						
TCMT32.53PC	TCMT16T312PC	0.005 - 0.014	0.024 - 0.118						

● = P ● = M ● = K ● = N ● = S ○ = H

VCMT PC - 7° POSITIVE. 35° RHOMBIC INSERTS WITH PC CHIPBREAKER



VCMT 22x

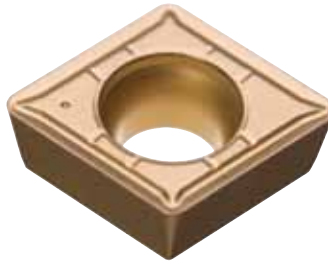


VCMT 33x

ANSI Number	ISO Number	feed (ipr)	DOC (inch)	Grade	CT3000	TT8115	TT8125	TT9225	TT5100
VCMT221PC	VCMT110304PC	0.002 - 0.008	0.004 - 0.067						
VCMT332PC	VCMT160408PC	0.002 - 0.008	0.012 - 0.079						

= P = M = K = N = S = H

CPMT PC - 11° POSITIVE, 80° RHOMBIC INSERTS WITH PC CHIPBREAKER



ANSI Number	ISO Number	feed (ipr)	DOC (inch)	Grade	CT3000	TT8125	TT9225	TT5100	TT5030
CPMT21.51PC	CPMT060204PC	0.002 - 0.007	0.012 - 0.079						
CPMT21.52PC	CPMT060208PC	0.003 - 0.010	0.016 - 0.079						
CPMT32.51PC	CPMT09T304PC	0.003 - 0.010	0.018 - 0.118						
CPMT32.52PC	CPMT09T308PC	0.004 - 0.012	0.024 - 0.118						

= P = M = K = N = S = H

TPMT PC - 11° POSITIVE TRIANGULAR INSERTS WITH PC CHIPBREAKER



ANSI Number	ISO Number	feed (ipr)	DOC (inch)	Grade	CT3000	TT8115	TT8125	TT9225	TT9235
TPMT731PC	TPMT090204PC	0.002 - 0.007	0.012 - 0.079	●●●		●	●	●	●
TPMT21.51PC	TPMT110204PC	0.002 - 0.008	0.016 - 0.098	●●●		●	●	●	●
TPMT21.52PC	TPMT110208PC	0.004 - 0.010	0.020 - 0.098	●●●		●	●	●	●
TPMT221PC	TPMT110304PC	0.002 - 0.008	0.016 - 0.098	●●●		●	●	●	●
TPMT222PC	TPMT110308PC	0.004 - 0.010	0.020 - 0.098	●●●	●	●	●	●	●
TPMT32.51PC	TPMT16T304PC	0.003 - 0.010	0.018 - 0.118	●●●	●	●	●	●	●
TPMT32.52PC	TPMT16T308PC	0.004 - 0.012	0.020 - 0.118	●●●	●	●	●	●	●

● = P ● = M ● = K ● = N ● = S ○ = H