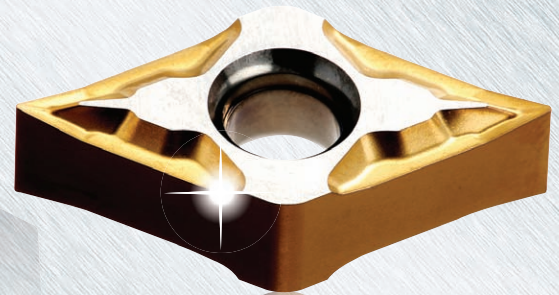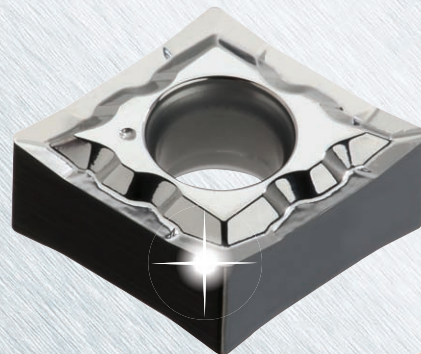# GOLD RHINO™

Insert Shapes
- CNGG
- DNGG

Corner Radii
- .004"
- .008"
- .016"
- .031"

Grades
- TT5080 (Gold-Rush post-coat) for high-temp alloys
- K10 (polished) for non-ferrous materials

NEW PRODUCT ANNOUNCEMENT •2014•

Peripheral Ground ML Chipbreaker Inserts

Ingersoll is pleased to expand the successful Gold-Rhino™ product line by introducing double-sided, peripheral ground inserts. The combination of up-sharp, positive geometry with a ground periphery provides a highly accurate insert with a very sharp cutting edge, making it ideal for machining high-temp alloys and non-ferrous materials.
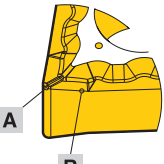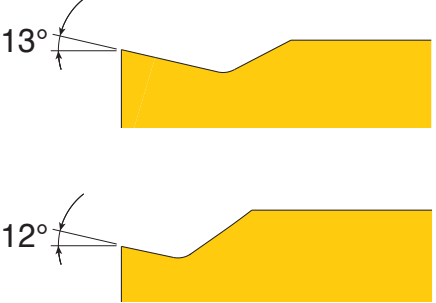
The ML geometry generates less cutting force, minimizes built-up edge during machining and provides an excellent surface finish. Available in 80 degree CNGG and 55 degree DNGG shapes, and with nose radii as small as .004", these inserts are offered in Gold-Rush PVD-coated grade TT5080 and uncoated and polished grade K10.
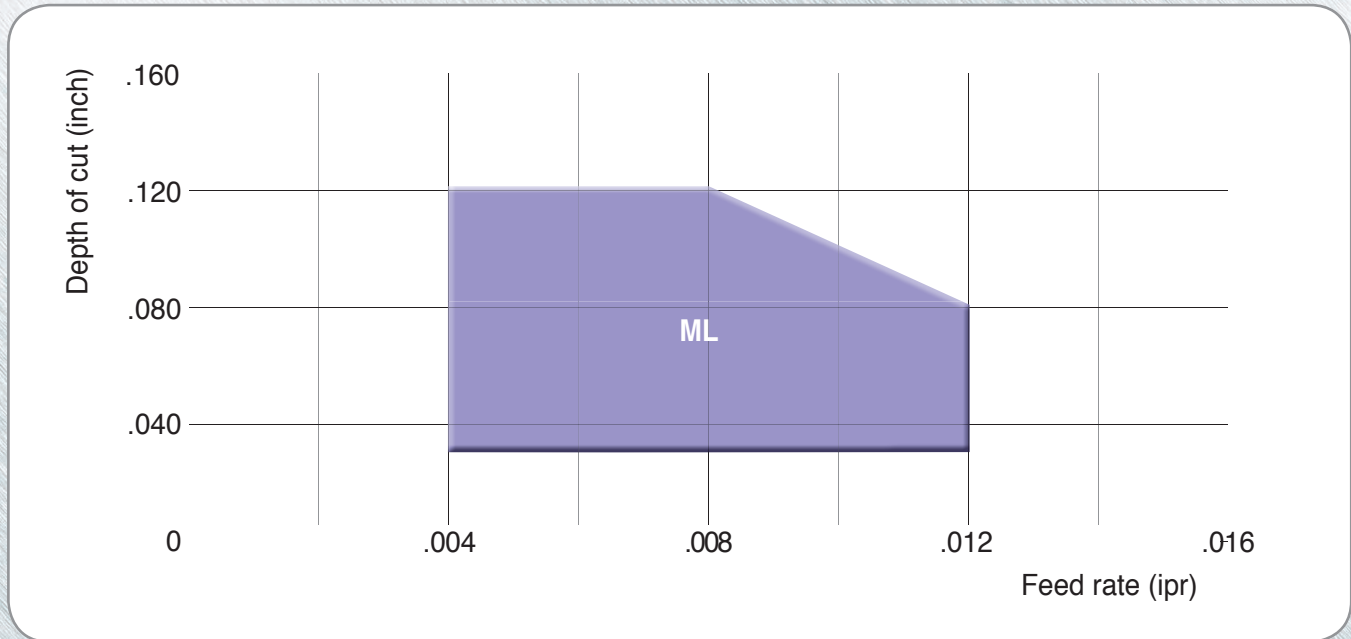
FEATURES
- Double-sided
- Peripheral ground
- High-positive ML chipbreaker with sharp cutting edge
- Fully compatable with all corresponding Gold-Rhino holders and boring bars

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GOLD RHINO™

■ Edge geometry of ML chip breaker
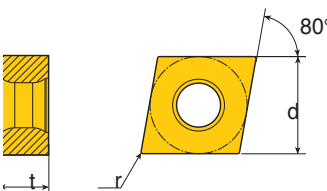
Chip breaker		Edge geometry
CNGG	ML	13° A 12° B

■ Chipbreaker range

Depth of cut (inch) vs Feed rate (ipr)

ML

- Insert: CNGG 331 (090404) ML
- Cutting speed (V): 650 sfm
- Material: 0.45% Carbon Steel (HB200~230)

GOLD RHINO™
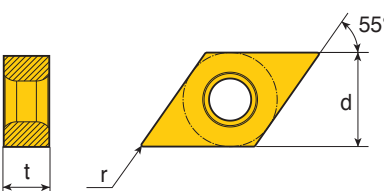
CNGG — Negative 80° rhombic inserts

Size	Dimension (in)		
	d	t	r
330	.375	.187	.004
330.5	.375	.187	.008
331	.375	.187	.016
332	.375	.187	.031

Insert	Designation	Recommended machining conditions		PVD coated	Uncoated
		feed (ipr)	ap (in)	TT5080	K10
CNGG	330 (090401) ML	.001-.004	.004-.040	●	●
	330.5 (090402) ML	.002-.006	.008-.047	●	●
	331 (090404) ML	.004-.012	.031-.118	●	●
	332 (090408) ML	.005-.014	.040-.118	●	●

● : Standard item

DNGG — Negative 55° rhombic inserts

Size	Dimension (mm)		
	d	t	r
3.53.50	.437	.219	.004
3.53.50.5	.437	.219	.008
3.53.51	.437	.219	.016
3.53.52	.437	.219	.031

Insert	Designation	Recommended machining conditions		PVD coated	Uncoated
		feed (ipr)	ap (in)	TT5080	K10
DNGG	3.53.50 (130501) ML	.001-.004	.004-.040	●	●
	3.53.50.5 (130502) ML	.002-.006	.008-.047	●	●
	3.53.51 (130504) ML	.004-.012	.031-.118	●	●
	3.53.52 (130508) ML	.005-.014	.040-.118	●	●

● : Standard item

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845 South Lyford Road, Rockford, IL 61108
Tel: 815.387.6600, Fax: 815.387.6968

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