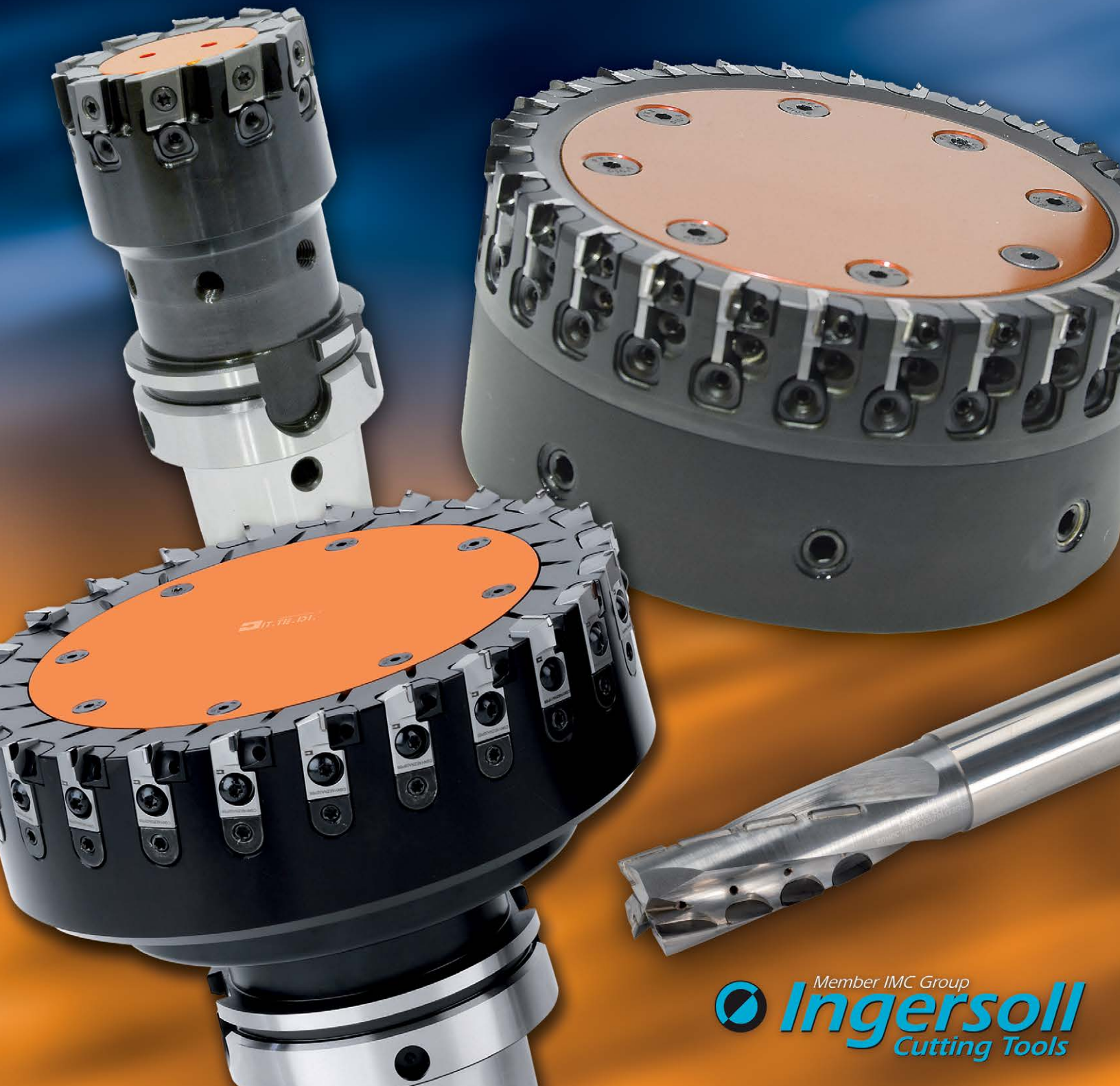
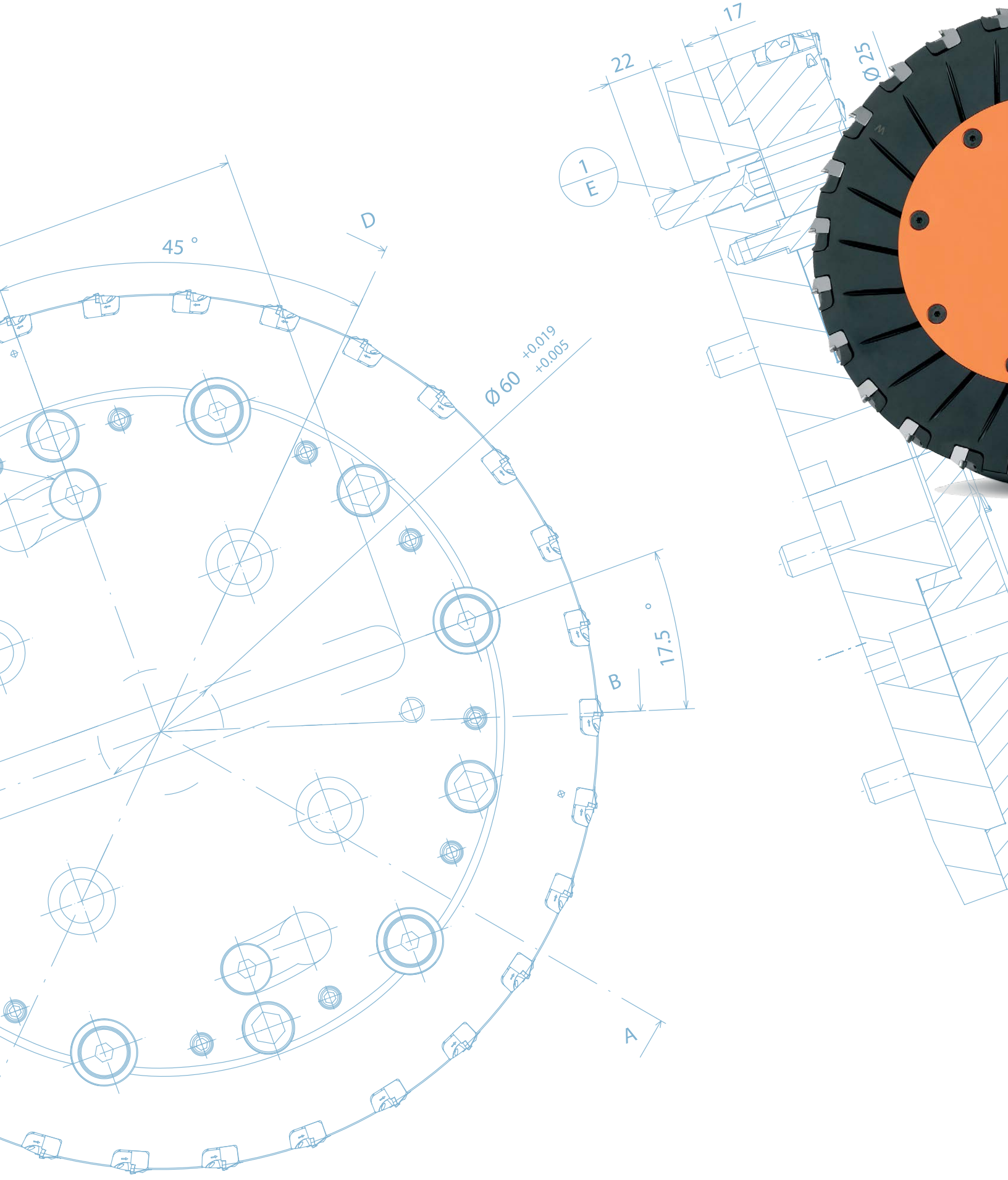
Member IMC Group

IT.TE.DI.

BRAZED & INDEXABLE PCD/CBN MILLING



Member IMC Group
Ingersoll Cutting Tools


17
22
Ø 25
1
E
D
45 °
Ø 60 +0.019 +0.005
B
17.5 °
A

Member IMC Group ®
IT.TE.DI.

CONTENTS

Modern machining operations need to rely on the optimization of the production processes: in this respect the milling operations play a very important role and several factors contribute to its increasing significance. On one side the demand to reduce the machining time and on the other side the constant request for quality improvement as far as surface roughness and flatness are concerned, make it necessary to adopt high performance tools able to guarantee high cutting speeds and long tool life. Moreover, the trend toward stronger, thinner work piece materials in response to the requirement of lighter weight in various industries today highlight the importance of a high quality and versatile cutting edge.

The evolution in the materials to be machined, which may contain carbon, magnesium, composite materials, bimetallic alloys, CGI cast irons, tough cast irons, in addition to the traditional grey cast irons and light alloys, require the most modern cutting materials as well. IT.TE.DI.'s range of milling cutters guarantee the best performance in every machining operation.

A non-superficial approach for every surface

Face milling or contouring: any milling operation can be performed by IT.TE.DI. milling cutters, from the simplest cutter with cylindrical shank to the monolithic cutter with replaceable cartridges. IT.TE.DI. cutters are the best answer to the most difficult challenges and are available exclusively from Ingersoll Cutting Tools throughout North America.

TEDI SFEED

PCD Cutting Edges for Milling

TEDI SFEED™

During CNC machining the cycle time is very important. To improve the productivity, while maintaining a perfect surface finish, IT.TE.DI. is now introducing the TEDI SFEED line with a higher number of cutting edges.

The fundamental characteristic is the high performance, which is due to the high rigidity and stability of the mill and of its components. So, to have those aspects with the high number of cutting edges, we developed a specially designed cutting edge cartridge.

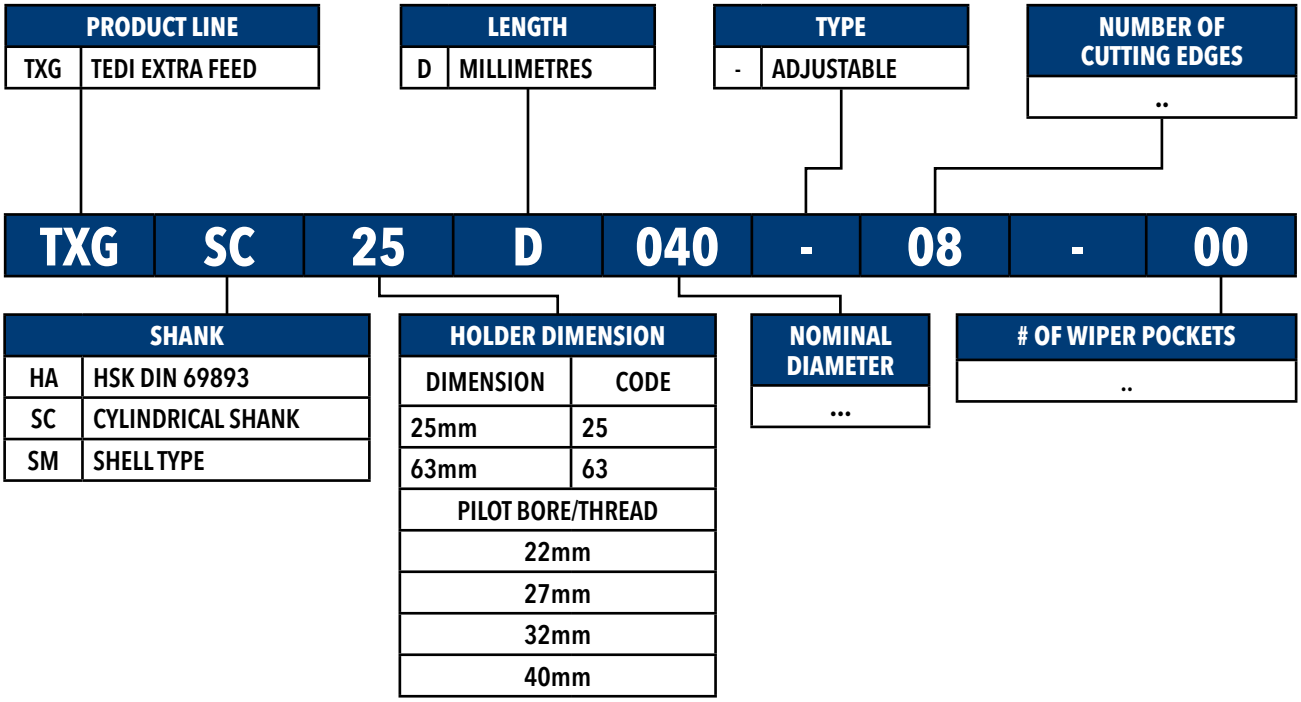
When the screw is clamped, it pushes the cartridge towards the mill's body; once the conical wedge has also been placed in its seat and it has been clamped, it further pushes the cartridge, thus locking it into place and proving better stability.

The precise height is guaranteed from the regulation of the adjusting wedge, that is placed below the cartridges. This product line also offers different cutting edge geometries to satisfy the customers requirements.

FEATURES

- High rigidity double clamping system to support high-feed machining
- Up to .024" (.6mm) total axial adjustment to ensure an excellent surface finish
- Multiple cutting edge geometries to cover any application, including 90°/75° lead angles
- 1.5" (40mm) available in cylindrical shank
- 2.0-5.0" (50mm-125mm) range in shell mill or monoblock bodies
- DOC capability of .157" (4mm)
- Ability to re-tip cartridges

PCD CODIFY



Order examples:

For placing an order of a cutter body shell type ø2" with Z=10 milling, please indicate the code:

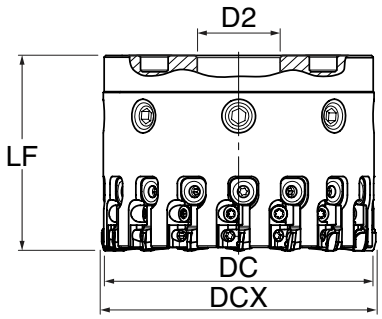
TXGSM22I020-10-10

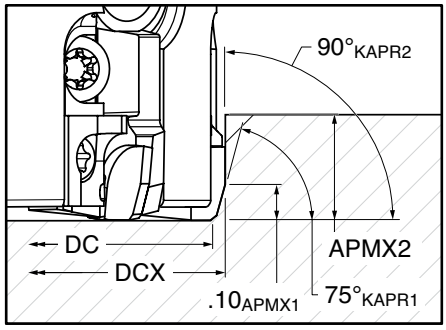
or the ITEM:

2742926

The following codes are referred only to the cutter body not assembled with inserts.

PCD SHELL MILL WITH AXIAL ADJUSTMENT - INCH / METRIC

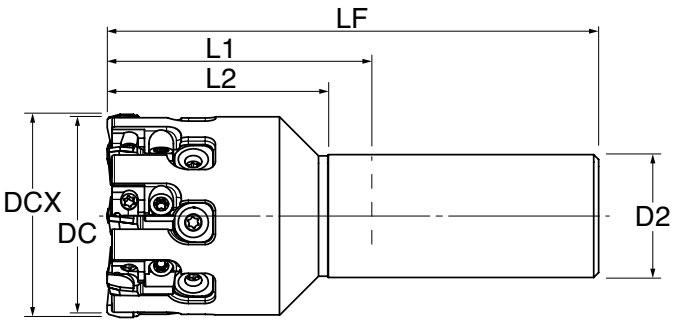


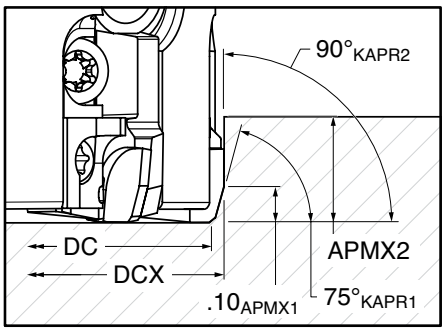


	PRODUCT CODE[1]	D2	DC (90°) DCX (75°)	DC (75°)	HOLDER SHAPE	LF	Z	MATERIAL	ITEM
INCHES	TXGSM22I020-10-00	22mm	2	1.94	A	2.17	10	Steel	2742926
	TXGSM22I025-13-00	22mm	2.5	2.44	B	2.17	13	Steel	2742927
	TXGSM27I030-16-00	27mm	3	2.94	A	2.28	16	Steel	2742928
	TXGSM32I040-22-00	32mm	4	3.94	A	2.28	22	Aluminum + Steel	2742929
	TXGSM40I050-28-00	40mm	5	4.94	A	2.28	28	Aluminum + Steel	2742930
MM	TXGSM22D050U10-00	22mm	50	48.6	B	55	10	Steel	2742926
	TXGSM22D063U13-00	22mm	63	61.6	A	55	13	Steel	2747098
	TXGSM27D080U16-00	27mm	80	78.6	A	58	16	Steel	2747099
	TXGSM32D100U22-00	32mm	100	98.6	A	58	22	Aluminum + Steel	2747100
	TXGSM40D125U28-00	40mm	125	123.6	A	58	28	Aluminum + Steel	2747101

Minimum diameter guaranteed with standard inserts. Refer to related table of available cutting geometry for more detail.
[1] Part number refers to body only, without inserts.

PCD CYLINDRICAL SHANK EM W/ AXIAL ADJUSTMENT - INCH / METRIC

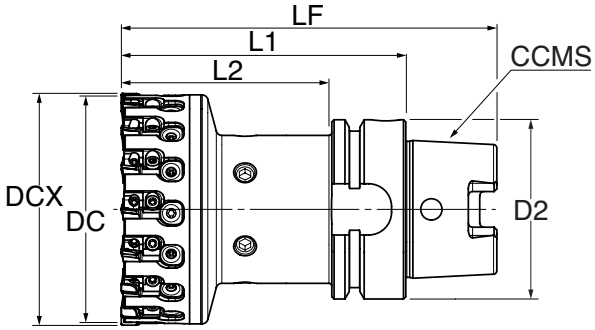


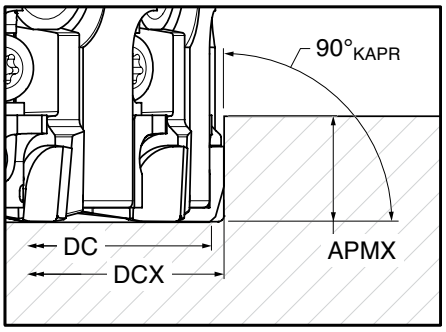


	PRODUCT CODE[1]	D2	DC (90°) DCX (75°)	DC (75°)	HOLDER SHAPE	LF	Z	MATERIAL	ITEM
INCHES	TXGSC01I015-07-00	1.00	1.5	1.44	Cylindrical	3.94	7	Steel	2742931
MM	TXGSC25D040U07-00	25mm	40	38.6	Cylindrical	100	7	Steel	2747102

Minimum diameter guaranteed with standard inserts. Refer to related table of available cutting geometry for more detail.
[1] Part number refers to body only, without inserts.

PCD MONOBLOCK MILL WITH AXIAL ADJUSTMENT - METRIC





	PRODUCT CODE[1]	D2	DC (90°) DCX (75°)	DC (75°)	HOLDER SHAPE	LF	Z	MATERIAL	ITEM
MM	TXGHA63D063-13-00	52	64.4	63	HSK 63 A	100	13	Steel	2748906
	TXGHA63D080-16-00	52	81.4	80	HSK 63 A	100	16	Steel	2748905
	TXGHA63D100-22-00	52	101.4	100	HSK 63 A	100	22	Steel	2748907

Minimum diameter guaranteed with standard inserts. Refer to related table of available cutting geometry for more detail.
[1] Part number refers to body only, without inserts.
Monoblock mills available upon request.

PCD INSERTS

PRODUCT LINE	
TXG	TEDI SFEED

INSERT TYPE	
A	SCRAPER
R	WIPER

ROTATION	
R	RIGHT
L	LEFT

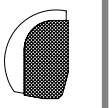
TXG P A 01 R PB

CUTTING MATERIAL	
P	PCD
C	CBN

GEOMETRY
01
02
05
45
07
09

CUTTING EDGE GRADE	
PB*	PCD
CH*	CBN

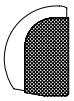
GEOMETRY 01



Recommended for finishing not square shoulder surfaces. Suitable for light roughing too.

Achievable surface:
0.3 ≤ Ra ≤ 0.8

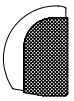
GEOMETRY 02



Recommended for finishing square shoulder surfaces. Suitable for light roughing too.

Achievable surface:
0.3 ≤ Ra ≤ 0.8

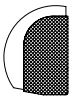
GEOMETRY 05



Suitable for roughing or for cutting material with a high impurity content. (Cubing)

Achievable surface:
0.4 ≤ Ra ≤ 1

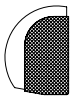
GEOMETRY 45



Suitable for semi-finishing rough surfaces

Achievable surface:
0.4 ≤ Ra < 1

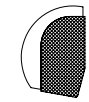
GEOMETRY 07



Suitable for finishing or roughing - general purpose.

Achievable surface:
0.4 ≤ Ra < 1

GEOMETRY 09



Suitable for finishing rough (gasket) surfaces

Achievable surface:
0.8 ≤ Ra ≤ 3.2

PRODUCT CODE	AVAILABILITY	GEOMETRY	ROTATION	GRADE*	ITEM
TXGPA01RPJ	Stock	01	R	PB	2717188
TXGPA02RPJ	Stock	02	R	PB	2717189
TXGPA05RPJ	Stock	05	R	PB	2717190
TXGPA45RPJ	Stock	45	R	PB	2747053
TXGPA07RPJ	Stock	07	R	PB	2717191
TXGPA09RPJ	Stock	09	R	PB	2724019

Alternative grades available. Please contact IT.TE.DI. for assistance with choosing the best grade.


TEDIFEED

TEDI FEED

PCD & CBN
Tangential Milling

TEDI FEED

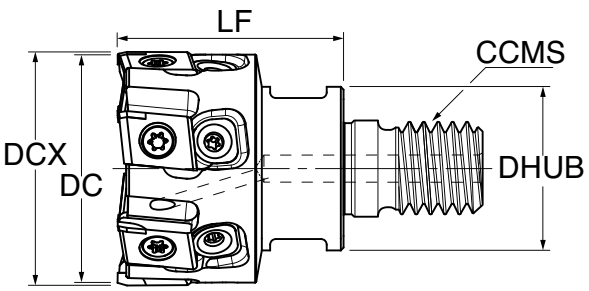
TEDI FEED is the new line of mill with tangential inserts available with PCD and CBN inserts, single, double and full cutting edges. TEDI FEED is studied for machining operations from heavy roughing to super-finishing. Available with all holders, with cylindrical shank, monoblock or shell type configurations. A wide range of diameters, lengths and number of cutting edges guarantee the best results in every applications.

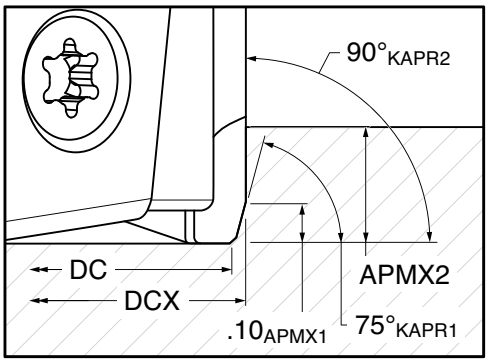
FEATURES

- Suitable for high speed machining
- Low cutting forces
- Insert available with single tip, double tip and full edge
- High number of cutting edges for high productivity

TOP-ON MODULAR CONNECTIONS

PCD / CBN MODULAR END MILL W/ AXIAL ADJUSTMENT - INCH / METRIC

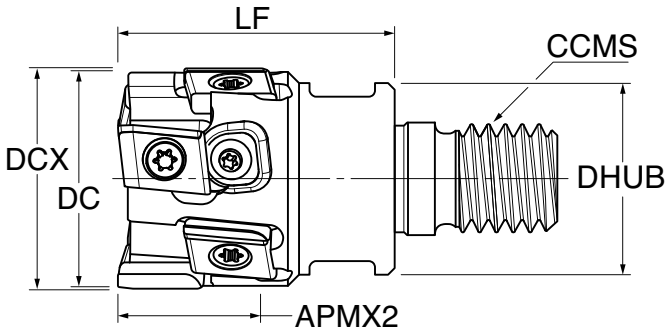


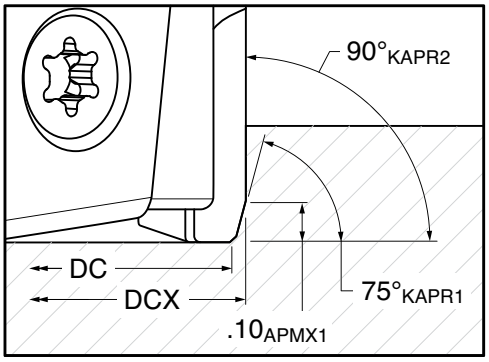


	PRODUCT CODE[1]	DC (90°) DCX (75°)	DC (75°)	CCMS	DHUB	LF	Z	WEIGHT (kg)[2]	ITEM
INCHES	TRGTS12I01Z003-00	1.00	0.95	12.00	21.00	40.00	3	0.14	2743146
	TRGTS16I01205-00	1.25	1.20	16.00	29.00	40.00	5	0.24	2743147
	TRGTS16I01506-00	1.50	1.45	16.00	29.00	40.00	6	0.31	2743148
MM	TUGTS12D02503-00	25.00	23.60	12.00	21.00	40.00	3	0.14	2744559
	TUGTS16D03205-00	32.00	30.60	16.00	29.00	40.00	5	0.24	2744560
	TUGTS16D04006-00	40.00	38.60	16.00	29.00	40.00	6	0.31	2744561

* Minimum diameter guaranteed with standard inserts. Refer to related table of available cutting geometry for more detail.
[1] Item number refers to body only, without inserts.
[2] The weight is referred to the assembled part (cutter body with inserts).

PCD / CBN HELICAL MODULAR END MILL - INCH / METRIC

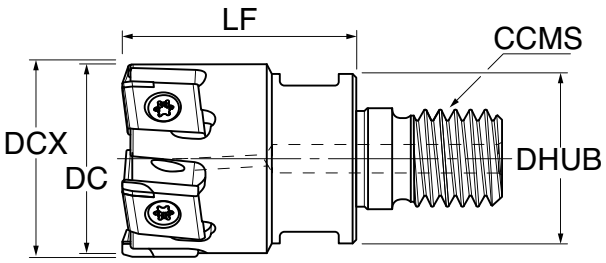


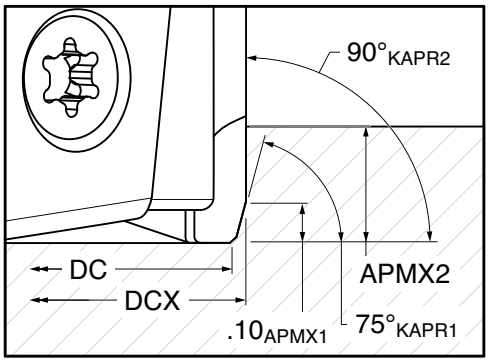


	PRODUCT CODE[1]	DC (90°) DCX (75°)	DC (75°)	CCMS	DHUB	LF	Z	WEIGHT (kg)[2]	ITEM
INCHES	TRGTS16I012H03-00	1.25	1.20	16.00	29.00	42.00	3	0.26	2743159
	TRGTS16I015H04-00	1.50	1.45	16.00	29.00	45.00	4	0.33	2743160
MM	TUGTS16D032H03-00	32.00	30.60	16.00	29.00	42.00	3	0.26	2744570
	TUGTS16D040H04-00	40.00	38.60	16.00	29.00	45.00	4	0.33	2744571

* Minimum diameter guaranteed with standard inserts. Refer to related table of available cutting geometry for more detail.
[1] Item number refers to body only, without inserts.
[2] The weight is referred to the assembled part (cutter body with inserts).

PCD / CBN FIXED POCKET MODULAR END MILL - INCH / METRIC





	PRODUCT CODE[1]	DC (90°) DCX (75°)	DC (75°)	CCMS	DHUB	LF	Z	WEIGHT (kg)[2]	ITEM
INCHES	TRGTS16I012N05-00	1.25	1.20	16.00	29.00	40.00	5	0.24	2743151
	TRGTS16I015N06-00	1.50	1.45	16.00	29.00	40.00	6	0.35	2743152
MM	TUGTS16D032N05-00	32.00	30.60	16.00	29.00	40.00	5	0.24	2744566
	TUGTS16D040N06-00	40.00	38.60	16.00	29.00	40.00	6	0.35	2744567

***** Minimum diameter guaranteed with standard inserts. Refer to related table of available cutting geometry for more detail.
[1] Item number refers to body only, without inserts.
[2] The weight is referred to the assembled part (cutter body with inserts).

PCD / CBN CODIFY

PRODUCT LINE	
TRG	TEDI FEED

LENGTH	
D	MILLIMETRS
I	INCHES

NUMBER OF CUTTING EDGES
..

TRG	HA	63	D	063	-	03	-	00

SHANK	
HA	HSK DIN 69893
IC	ISO A/B DIN 69871
BC	BT A/B MAS 403
CC	CAT HOLDER
SC	CYLINDRICAL SHANK
SM	SHELL TYPE

HOLDER DIMENSION	
DIMENSION	CODE
1"	01
25mm	25
40mm	40
50mm	50
63mm	63
100mm	10
PILOT BORE	
16mm	
22mm	
27mm	
32mm	
40mm	
60mm	

NOMINAL DIAMETER
...

OF WIPER POCKETS
..

Order examples:

For placing an order of a cutter body shell type ø125 with Z=18 milling + 2 wiper, please indicate the code:

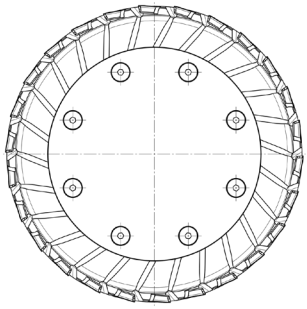
TRGSM40D125-18-02

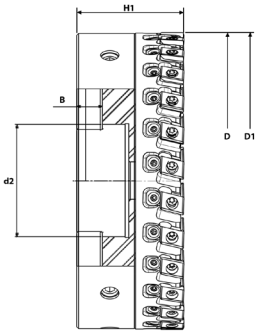
or the ITEM:

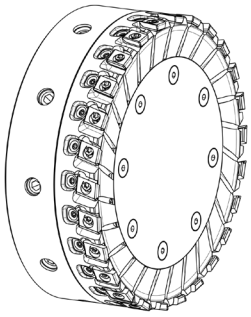
2717435

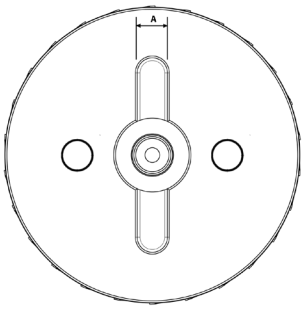
The following codes are referred only to the cutter body not assembled with inserts.

PCD / CBN SHELL TYPE CUTTERS (ADJUSTABLE) - METRIC / INCH







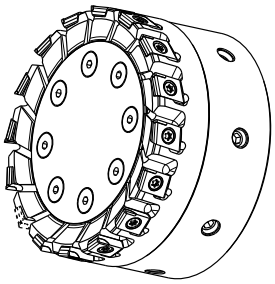


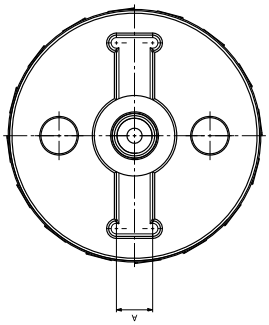
Drive notch measure (A, B) according to ISO 6462-1983

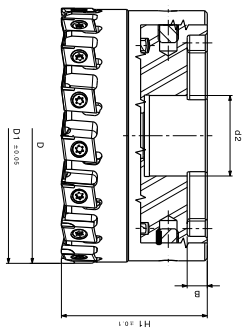
	PRODUCT CODE[1]	d2	HOLDER SHAPE	D * ø nom.	D1	Z	H1	MATERIAL	WEIGHT (kg)[3]	ITEM
MM	TUGSM16D040-06-00[2]	16mm	A	40	38.6	6	48	Steel	0,7	2726291
	TUGSM22D050-08-00	22mm	A	50	48.6	8	55	Steel	0,9	2726292
	TUGSM22D063-10-00	22mm	B	63	61.6	10	55	Steel	1,3	2726293
	TUGSM27D080-12-00	27mm	A	80	78.6	12	58	Steel	2,2	2726294
	TUGSM32D100-16-00	32mm	A	100	98.6	16	58	Aluminum + Steel	1,9	2726295
	TUGSM40D125-20-00	40mm	A	125	123.6	20	58	Aluminum + Steel	2,9	2726296
	TUGSM40D125-18-02	40mm	A	125	123.6	18+2	58	Aluminum + Steel	2,9	2726316
	TUGSM40D160-26-00	40mm	C	160	158.6	26	58	Aluminum + Steel	5,1	2726297
	TUGSM40D160-24-02	40mm	C	160	158.6	24+2	58	Aluminum + Steel	5,1	2726317
	TUGSM60D200-30-00	60mm	C	200	198.6	30	63	Aluminum + Steel	8,2	2726298
	TUGSM60D200-28-02	60mm	C	200	198.6	28+2	63	Aluminum + Steel	8,2	2726318
	TUGSM60D250-34-00	60mm	C	250	248.6	34	63	Aluminum + Steel	13,0	2726299
	TUGSM60D250-32-02	60mm	C	250	248.6	32+2	63	Aluminum + Steel	13,0	2726319
INCHES	TRGSM16I015-06-00[2]	16mm	A	1,5"	1,55"	6	2.165"	Steel	0,7	2718082
	TRGSM22I020-08-00	22mm	A	2"	2,05"	8	2.165"	Steel	0,9	2718081
	TRGSM22I025-10-00	22mm	B	2,5"	2,55"	10	2.165"	Steel	1,3	2718083
	TRGSM27I030-12-00	27mm	A	3"	3,05"	12	2,283"	Steel	2,1	2708084
	TRGSM32I040-16-00	32mm	A	4"	4,05"	16	2,283"	Aluminum + Steel	1,9	2718085
	TRGSM40I050-20-00	40mm	A	5"	5,05"	20	2,283"	Aluminum + Steel	3,0	2718086
	TRGSM40I050-18-02	40mm	A	5"	126,4	18+2	2,283"	Aluminum + Steel	3,0	2718309
	TRGSM40I060-24-00	40mm	C	6"	6,05"	24	2,283"	Aluminum + Steel	4,8	2717864
	TRGSM40I060-22-02	40mm	C	6"	6,05"	22+2	2,283"	Aluminum + Steel	4,8	2718310
	TRGSM60I080-30-00	60mm	C	8"	8,05"	30	2,480"	Aluminum + Steel	8,4	2718087
	TRGSM60I080-28-02	60mm	C	8"	8,05"	28+2	2,480"	Aluminum + Steel	8,4	2718311
	TRGSM60I100-34-00	60mm	C	10"	10,05"	34	2,480"	Aluminum + Steel	13,3	2718088
	TRGSM60I100-32-02	60mm	C	10"	10,05"	32+2	2,480"	Aluminum + Steel	13,3	2718312

* Minimum diameter guaranteed with standard inserts. Refer to related table of available cutting geometry for more detail
[1] Item number refers to body only, without inserts.
[2] Without internal coolant.
[3] The weight is referred to the assembled part (cutter body with inserts).

PCD / CBN SHELL TYPE CUTTERS (FIXED) - INCH



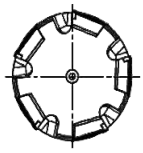


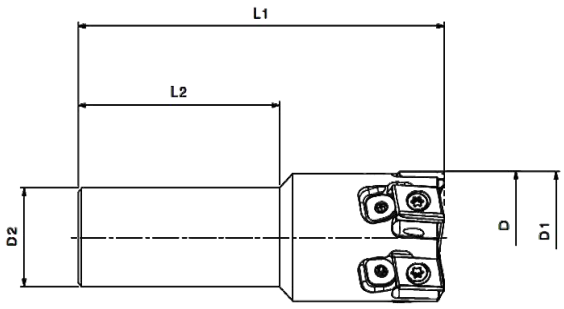


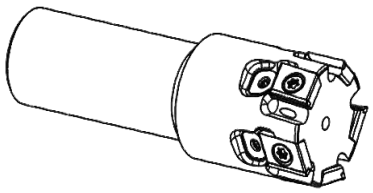
	PRODUCT CODE[1]	d2	HOLDER SHAPE	D * ø nom.	D1***	Z	H1	MATERIAL	WEIGHT (kg)[3]	ITEM
INCHES	TRGSM22I025N10-00	22 mm	B	2.5	2.45	10	2.165	Steel	1.13	2743127
	TRGSM27I030N12-00	27 mm	A	3	2.95	12	2.283	Steel	1.73	2743128
	TRGSM32I040N16-00	32 mm	A	4	3.95	16	2.283	Aluminum + Steel	1.78	2743129
	TRGSM40I050N20-00	40 mm	A	5	4.95	20	2.283	Aluminum + Steel	2.89	2743130

* Minimum diameter guaranteed with standard inserts. Refer to related table of available cutting geometry for more detail
** Without axial adjustment
*** With '01' and '09' cutting edge geometry
[1] Item number refers to body only, without inserts.
[3] The weight is referred to the assembled part (cutter body with inserts).

PCD / CBN CYLINDRICAL TYPE CUTTERS - INCH / METRIC





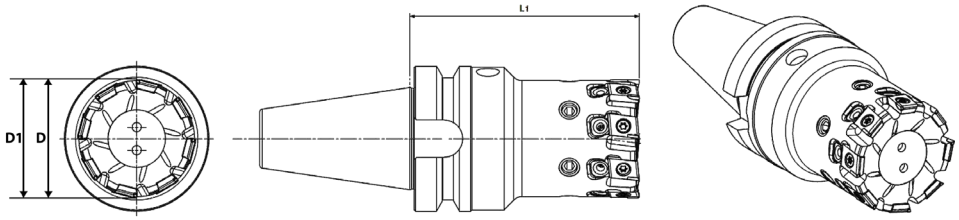


	PRODUCT CODE[1]	d2	D * ø nom.	D1***	Z	L1	L2	WEIGHT (kg)[3]	ITEM
INCHES	TRGSC01I010N03-00**	1	1	0.95	3	4	2	0.4	2718069
	TRGSC01I010-03-00	1	1	0.95	3	4	2	0.4	2718079
	TRGSC01I012-05-00	1	1.25	1.20	5	4	2	0.5	2718080
MM	TUGSC25D025N03-00**	25	25	23.6	3	100	50	0.4	2726332
	TUGSC25D025-03-00	25	25	23.6	3	100	50	0.4	2726335
	TUGSC25D032-05-00	25	32	30.6	5	100	55	0.5	2726333

* Minimum diameter guaranteed with standard inserts. Refer to related table of available cutting geometry for more detail
** Without axial adjustment
*** With '01' and '09' cutting edge geometry
[1] Item number refers to body only, without inserts.
[3] The weight is referred to the assembled part (cutter body with inserts).

PCD / CBN MONOBLOCK TYPE CUTTERS - METRIC

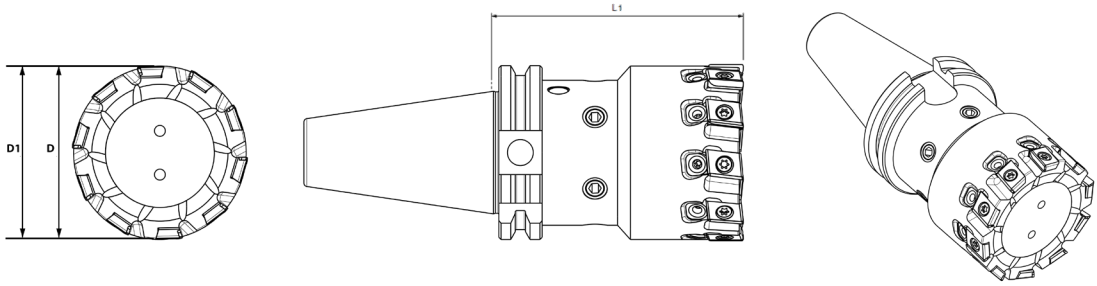
BT A/B
MAS 403



PRODUCT CODE[1]	BT TAPER DIMENSION	D * ø nom.	D1	Z	L1	MATERIAL	WEIGHT (kg)[3]
TRGBC40D040-06-00	40	40	41,4	6	100	Steel	1,8
TRGBC40D050-08-00	40	50	51,4	8	100	Steel	2,1
TRGBC40D063-10-00	40	63	64,4	10	100	Steel	2,7
TRGBC40D080-12-00	40	80	81,4	12	100	Steel	3,3
TRGBC40D100-16-00	40	100	101,4	16	100	Steel	4,2
TRGBC40D125-20-00	40	125	126,4	20	100	Steel	5,6

PCD / CBN MONOBLOCK TYPE CUTTERS - METRIC

ISO A/B
DIN 69871

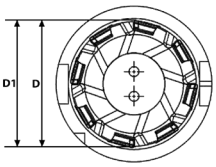


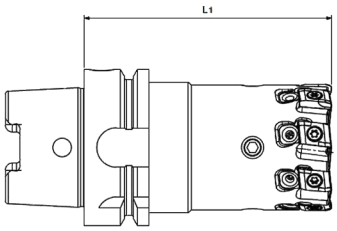
PRODUCT CODE[1]	ISO TAPER DIMENSION	D * ø nom.	D1	Z	L1	MATERIAL	WEIGHT (kg)[3]
TRGIC40D040-06-00	40	40	41,4	6	100	Steel	1,6
TRGIC40D050-08-00	40	50	51,4	8	100	Steel	2,0
TRGIC40D063-10-00	40	63	64,4	10	100	Steel	2,3
TRGIC40D080-12-00	40	80	81,4	12	100	Steel	2,9
TRGIC40D100-16-00	40	100	101,4	16	100	Steel	3,8
TRGIC40D125-20-00	40	125	126,4	20	100	Steel	5,2

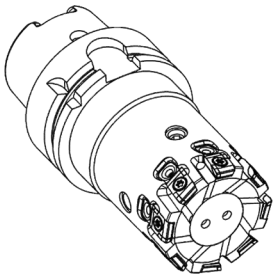
*Minimum diameter guaranteed with standard inserts. Refer to related table of available cutting geometry for more detail.
[1]Item number refers to body only, without inserts.
[3]The weight is referred to the assembled part (cutter body with cutting parts).
Monoblock cutters are non-stock standard - request a quote.

PCD / CBN MONOBLOCK TYPE CUTTERS - METRIC

HSK A
DIN 69893



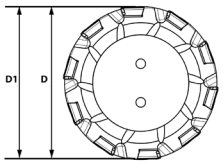


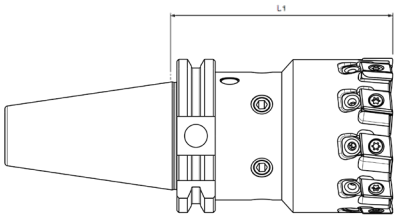


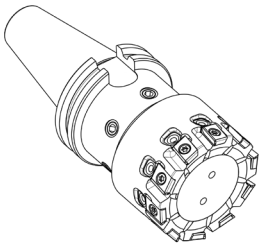
PRODUCT CODE[1]	HSK TAPER DIMENSION	D * ø nom.	D1	Z	L1	MATERIAL	WEIGHT (kg)[3]
TRGHA63D040-06-00	A 63	40	41,4	6	100	Steel	1,5
TRGHA63D050-80-00	A 63	50	51,4	8	100	Steel	1,8
TRGHA63D063-10-00	A 63	63	64,4	10	100	Steel	2,2
TRGHA63D080-12-00	A 63	80	81,4	12	100	Steel	2,8
TRGHA63D100-16-00	A 63	100	101,4	16	100	Steel	3,7
TRGHA63D125-20-00	A 63	125	126,4	20	100	Steel	5,1
TRGHA10D080-12-00	A 100	80	81,4	12	100	Steel	4,9
TRGHA10D100-16-00	A 100	100	101,4	16	100	Steel	5,8
TRGHA10D125-20-00	A 100	125	126,4	20	100	Steel	7,2

PCD / CBN MONOBLOCK TYPE CUTTERS - METRIC

CAT







PRODUCT CODE[1]	CAT TAPER DIMENSION	D * ø nom.	D1	Z	L1	MATERIAL	WEIGHT (kg)[3]
TRGCC40D040-06-00	40	40	41,4	6	100	Steel	1,6
TRGCC40D050-08-00	40	50	51,4	8	100	Steel	2,0
TRGCC40D063-10-00	40	63	64,4	10	100	Steel	2,3
TRGCC40D080-12-00	40	80	81,4	12	100	Steel	2,9
TRGCC40D100-16-00	40	100	101,4	16	100	Steel	3,8
TRGCC40D125-20-00	40	125	126,4	20	100	Steel	5,2

*Minimum diameter guaranteed with standard inserts. Refer to related table of available cutting geometry for more detail.
[1]Item number refers to body only, without inserts.
[3]The weight is referred to the assembled part (cutter body with cutting parts).
Monoblock cutters are non-stock standard - request a quote.

PCD / CBN INSERTS

Inserts are screw clamped in mill body to help assembling process. Several combination of insert are available to cover a wide range of material and applications.

INSERT TYPE	
A	MILLING
R	WIPER
P	MILLING for 2 inch and smaller

CUTTING EDGE GRADE	
PCD	PB*
CBN	CH*

CUTTING EDGE	
M	SINGLE TIP
B	DOUBLE TIP
T	FULL EDGE

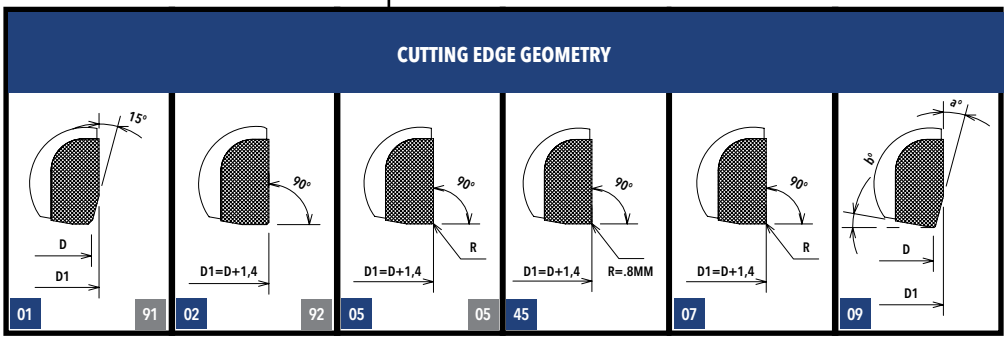
PRODUCT LINE

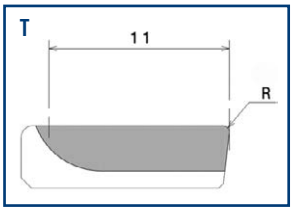
TRG	P	A	02	B	R	PB

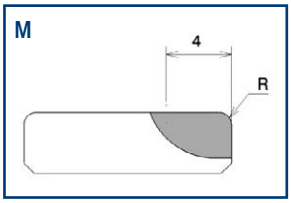
CUTTING MATERIAL	
P	PCD
C	CBN

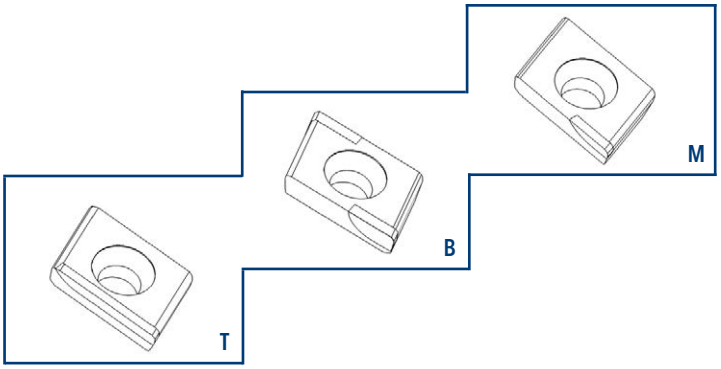
ROTATION	
R	RIGHT
L	LEFT

CUTTING EDGE GEOMETRY







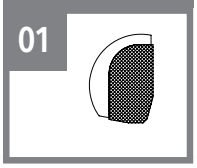


*Alternative grades available, please contact IT.TE.DI. for choosing the best grade.

PCD INSERTS

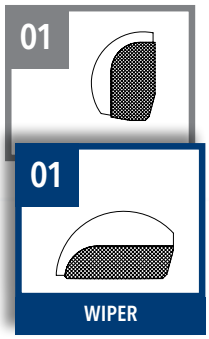
RECOMMENDED GRADE FOR ALUMINUM ALLOYS WITH Si < 12 - 14% AND MAGNESIUM ALLOYS

GEOMETRY 01



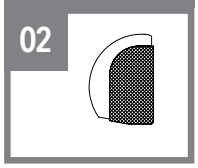
Recommended for finishing not square shoulder surfaces. Suitable for light roughing too.

Achievable surface:
0.3 ≤ Ra ≤ 0.8



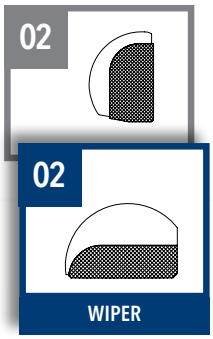
Achievable Surface:
0.1 ≤ Ra ≤ 0.5

GEOMETRY 02



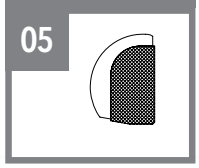
Recommended for finishing square shoulder surfaces. Suitable for light roughing too.

Achievable surface:
0.3 ≤ Ra ≤ 0.8



Achievable Surface:
0.1 ≤ Ra ≤ 0.5

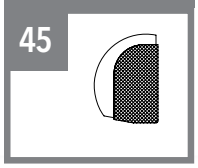
GEOMETRY 05



Suitable for roughing or for cutting material with a high impurity content. (Cubing)

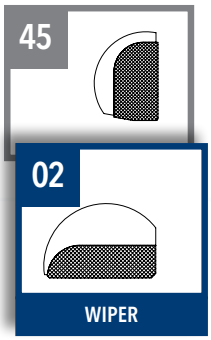
Achievable surface:
0.4 ≤ Ra ≤ 1

GEOMETRY 45



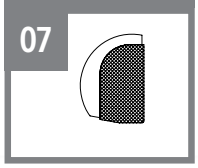
Suitable for finishing to medium roughing

Achievable surface:
0.4 ≤ Ra ≤ 1



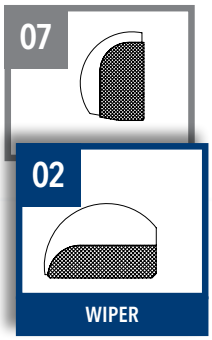
Achievable Surface:
0.1 ≤ Ra ≤ 0.5

GEOMETRY 07



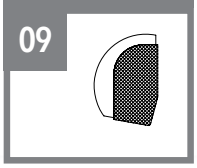
Suitable for finishing or roughing - general purpose.

Achievable surface:
0.4 ≤ Ra < 1



Achievable Surface:
0.1 ≤ Ra ≤ 0.5

GEOMETRY 09



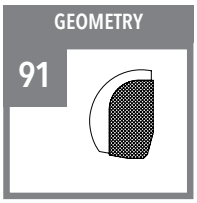
Suitable for finishing rough (gasket) surfaces

Achievable surface:
0.8 ≤ Ra ≤ 3.2

CBN INSERTS

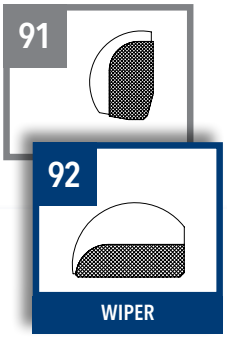
RECOMMENDED GRADE FOR GREY CAST IRONS AND NON FERROUS CAST IRONS

GEOMETRY 91



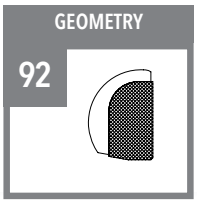
Recommended for finishing not square shoulder surfaces.

Achievable surface:
0.4 ≤ Ra ≤ 0.8



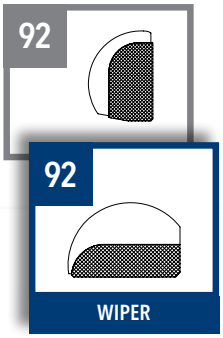
Achievable Surface:
0.2 ≤ Ra ≤ 0.5

GEOMETRY 92



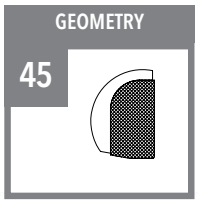
Recommended for finishing square shoulder surfaces.

Achievable surface:
0.4 ≤ Ra ≤ 0.8



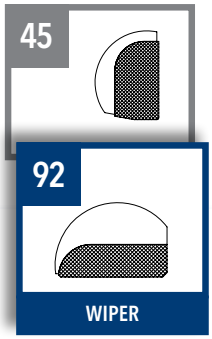
Achievable Surface:
0.2 ≤ Ra ≤ 0.5

GEOMETRY 45



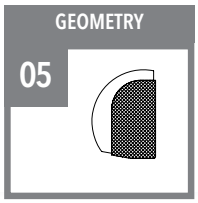
Recommended for finishing square shoulder surfaces.

Achievable surface:
0.4 ≤ Ra ≤ 0.8



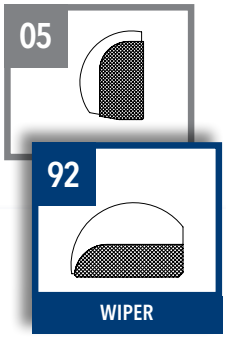
Achievable Surface:
0.2 ≤ Ra ≤ 0.5

GEOMETRY 05



Recommended for roughing square shoulder surfaces.

Achievable surface:
0.4 ≤ Ra ≤ 0.8



Achievable Surface:
0.2 ≤ Ra ≤ 0.5

PCD INSERTS

SINGLE TIP

Sample shown: right hand.

PRODUCT CODE	AVAILABILITY	GEOMETRY	ROTATION	GRADE	ITEM
TRGPA01MRPB	▲	01	R	PB	2717188
TRGPA02MRPB	▲	02	R	PB	2717189
TRGPA05MRPB	▲	05	R	PB	2717190
TRGPA07MRPB	▲	07	R	PB	2717191
TRGPA09MRPB	▲	09	R	PB	2724019
TRGPA45MRPB	▲	45	R	PB	2735937

DOUBLE TIP

Sample shown: right hand.

PRODUCT CODE	AVAILABILITY	GEOMETRY	ROTATION	GRADE	ITEM
TRGPA01BRPB	▲	01	R	PB	2717192
TRGPA02BRPB	▲	02	R	PB	2717193
TRGPA05BRPB	▲	05	R	PB	2717194
TRGPA07BRPB	▲	07	R	PB	2717195
TRGPA45BRPB	▲	45	R	PB	2735939

FULL EDGE

Sample shown: right hand.

PRODUCT CODE	AVAILABILITY	GEOMETRY	ROTATION	GRADE	ITEM
TRGPA01TRPB	▲	01	R	PB	2717196
TRGPA02TRPB	▲	02	R	PB	2717197
TRGPA05TRPB	▲	05	R	PB	2717198
TRGPA07TRPB	▲	07	R	PB	2717199
TRGPA09TRPB	▲	09	R	PB	2723895
TRGPA45TRPB	▲	45	R	PB	2735938

WIPER

Sample shown: right hand.

PRODUCT CODE	AVAILABILITY	GEOMETRY	ROTATION	GRADE	ITEM
TRGPR02TRPB	▲	02	R	PB	2717201

▲ Available in stock

○ Available upon request

CBN INSERTS

SINGLE TIP

Sample shown: right hand.

PRODUCT CODE	AVAILABILITY	GEOMETRY	ROTATION	GRADE	ITEM
TRGCA91MRCH	▲	91	R	CH	2717530
TRGCA92MRCH	▲	92	R	CH	2717531
TRGCA05MRCH	▲	05	R	CH	2717532

DOUBLE TIP

Sample shown: right hand.

PRODUCT CODE	AVAILABILITY	GEOMETRY	ROTATION	GRADE	ITEM
TRGCA91BRCH	▲	91	R	CH	2717533
TRGCA92BRCH	▲	92	R	CH	2717534
TRGCA05BRCH	▲	05	R	CH	2717535

WIPER

Sample shown: right hand.

PRODUCT CODE	AVAILABILITY	GEOMETRY	ROTATION	GRADE	ITEM
TRGCR92TRCH	▲	92	R	CH	2717537

▲ Available in stock

○ Available upon request

PCD INSERTS - FOR CUTTERS Ø≤2.00" / 50mm

SINGLE TIP

Sample shown: right hand.

PRODUCT CODE	AVAILABILITY	GEOMETRY	ROTATION	GRADE	ITEM
TRGPP01MRPB	▲	01	R	PB	2717465
TRGPP02MRPB	▲	02	R	PB	2717466
TRGPP05MRPB	▲	05	R	PB	2717467
TRGPP45MRPB	▲	45	R	PB	2719486
TRGPP07MRPB	▲	07	R	PB	2717468
TRGPP09MRPB	▲	09	R	PB	2730867

DOUBLE TIP

Sample shown: right hand.

PRODUCT CODE	AVAILABILITY	GEOMETRY	ROTATION	GRADE	ITEM
TRGPP01BRPB	▲	01	R	PB	2717469
TRGPP02BRPB	▲	02	R	PB	2717470
TRGPP05BRPB	▲	05	R	PB	2717471
TRGPP45BRPB	▲	45	R	PB	2735940
TRGPP07BRPB	▲	07	R	PB	2717472

FULL EDGE

Sample shown: right hand.

PRODUCT CODE	AVAILABILITY	GEOMETRY	ROTATION	GRADE	ITEM
TRGPP01TRPB	▲	01	R	PB	2717473
TRGPP02TRPB	▲	02	R	PB	2717474
TRGPP05TRPB	▲	05	R	PB	2717475
TRGPP45TRPB	▲	45	R	PB	2719487
TRGPP07TRPB	▲	07	R	PB	2717476
TRGPP09TRPB	▲	09	R	PB	2730865

▲ Available in stock

○ Available upon request

CBN INSERTS - FOR CUTTERS Ø≤2.00" / 50mm

SINGLE TIP

Sample shown: right hand.

PRODUCT CODE	AVAILABILITY	GEOMETRY	ROTATION	GRADE	ITEM
TRGCP91MRCH	▲	91	R	CH	2717541
TRGCP92MRCH	▲	92	R	CH	2717542
TRGCP45MRCH	▲	45	R	CH	2735943
TRGCP05MRCH	▲	05	R	CH	2717543

DOUBLE TIP

Sample shown: right hand.

PRODUCT CODE	AVAILABILITY	GEOMETRY	ROTATION	GRADE	ITEM
TRGCP91BRCH	▲	91	R	CH	2717544
TRGCP92BRCH	▲	92	R	CH	2717545
TRGCP45BRCH	▲	45	R	CH	2735944
TRGCP05BRCH	▲	05	R	CH	2717546

▲ Available in stock

○ Available upon request

TEDI MILL

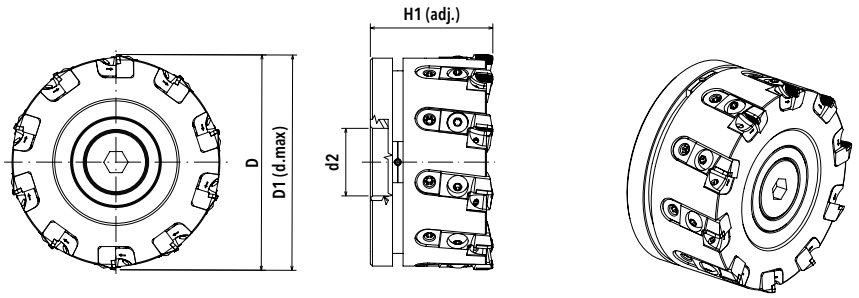
The Perfect Answer

TEDI MILL

TEDI MILL is a family of cutters with replaceable cartridges with brazed PCD and PCBN cutting edges. They have been developed thanks to IT.TE.DI.'s experience and research and are the result of modern solutions and accurate production checks. An important feature of the TEDI MILL is its clamping system: besides the common screw clamping, a clamping wedge is added, thus the rigidity of the cutter is increased and higher cutting speeds, feeds and tool life are attainable. The clamping wedge also prevents erosion of the cutter body from chip wash and it directs coolant directly to the cutting edge which helps prevent material build up and extends tool life. TEDI MILL cutters are very versatile: one cutter body may be equipped with inexpensive "disposable" cartridges or with cartridges that can be re-tipped several times.

There is the additional option to add one or more wiper cartridges to the cutter according to the machining operation. TEDI MILL cutters are provided with a quick and precise micro adjustment system which allows the user to set each individual cartridge, in order to achieve minimal axial run-out and thus ensure a good surface quality and a long life of the cutting edges. Moreover a simple device allows balancing to a G 1.6. The wide range of available cutters includes shell cutters and high productivity integral TEDI MILL cutters featuring a higher number of teeth to meet the demand of machining efficiency. All TEDI MILL cutters are designed to perform in dry machining, with coolant and with MQL. Also, the special adaptors made by IT.TE.DI. can be mounted in high coolant pressure machines. TEDI MILL milling cutters show their best performance in the finishing operations.
Their structural features and stability guarantee machining efficiency in roughing operations too.

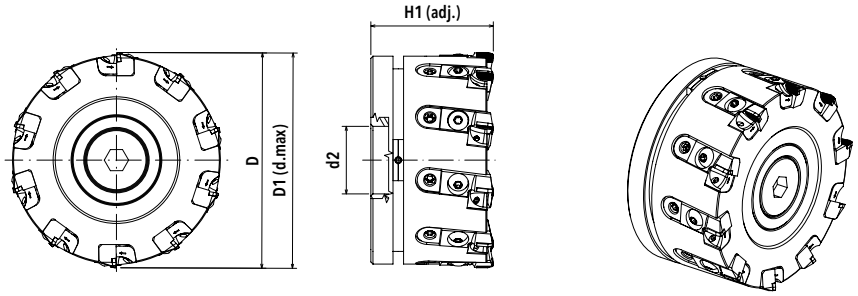
PCD SHELL TYPE CUTTERS - INCH



PART NUMBER	d2 (MM)	HOLDER SHAPE	D (*) Ø NOM. (INCH)	D1 (INCH)	Z	H1	MATERIAL	ROTATION	EDP
FIP020R040A	22	A	2.00	2.055	4	2.165	Aluminum	R	3212461
FIP020R050S	22	A	2.00	2.055	5	2.165	Steel	R	3212462
FIP025R050A	22	B	2.50	2.555	5	2.165	Aluminum	R	3212463
FIP025R060A	22	B	2.50	2.555	6	2.165	Aluminum	R	3212464
FIP030R050A	27	A	3.00	3.055	5	2.283	Aluminum	R	3212465
FIP030R060A	27	A	3.00	3.055	6	2.283	Aluminum	R	3212466
FIP030R080A	27	A	3.00	3.055	8	2.283	Aluminum	R	3212467
FIP040R080A	32	A	4.00	4.055	8	2.283	Aluminum	R	3212468
FIP040R100A	32	A	4.00	4.055	10	2.283	Aluminum	R	2716693
FIP050R100A	40	A	5.00	5.055	10	2.283	Aluminum	R	3212470
FIP050R140A	40	A	5.00	5.055	14	2.283	Aluminum	R	2716694
FIP060R100A	40	C	6.00	6.055	10	2.283	Aluminum	R	3212472
FIP060R180A	40	C	6.00	6.055	18	2.283	Aluminum	R	3212473
FIP070R200A	40	C	7.00	7.055	20	2.283	Aluminum	R	2900558
FIP080R120A	60	C	8.00	8.055	12	2.48	Aluminum	R	3212474
FIP080R240A	60	C	8.00	8.055	24	2.48	Aluminum	R	3212475
FIP100R160A	60	C	10.00	10.055	16	2.48	Aluminum	R	3212476
FIP100R300A	60	C	10.00	10.055	30	2.48	Aluminum	R	3212477

(*) Minimum diameter guaranteed with standard cartridges. Ref. page 31 depending on cartridge geometry.
(1) Item number refers to body only, without cartridges.

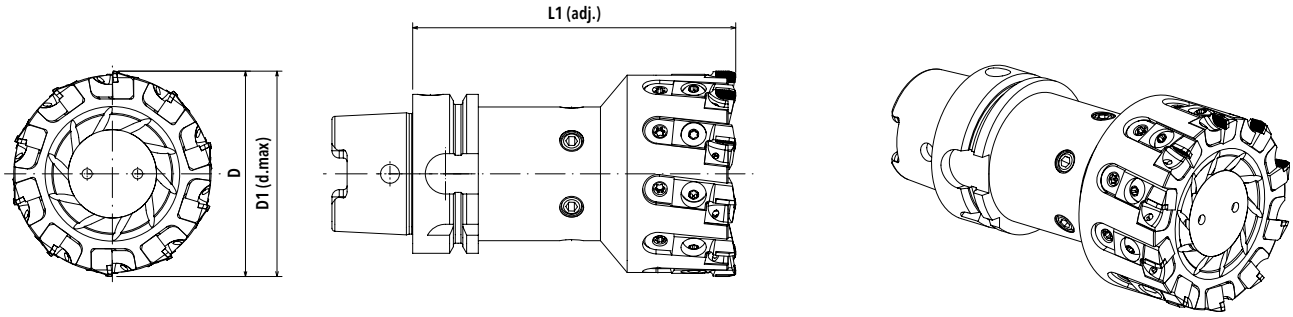
PCD SHELL TYPE CUTTERS - METRIC



PART NUMBER	d2	HOLDER SHAPE	D (*) Ø NOM.	D1	Z	H1	MATERIAL	ROTATION	EDP
FTP040R030S	16	A	40	41,4	3	48	Steel	R	
FTP050R040A	22	A	50	51,4	4	55	Light Alloy	R	
FTP050R050S	22	A	50	51,4	5	55	Steel	R	
FTP063R030A	22	B	63	64,4	3	55	Light Alloy	R	
FTP063R050A	22	B	63	64,4	5	55	Light Alloy	R	
FTP063R060A	22	B	63	64,4	6	55	Light Alloy	R	
FTP080R050A	27	A	80	81,4	5	58	Light Alloy	R	
FTP080R060A	27	A	80	81,4	6	58	Light Alloy	R	
FTP080R080A	27	A	80	81,4	8	58	Light Alloy	R	
FTP080R100T	27	A	80	81,4	10	58	Titanium	R	
FTP100R060A	32	A	100	101,4	6	58	Light Alloy	R	
FTP100R080A	32	A	100	101,4	8	58	Light Alloy	R	
FTP100R100A	32	A	100	101,4	10	58	Light Alloy	R	
FTP100R120T	32	A	100	101,4	12	58	Titanium	R	
FTP125R080A	40	A	125	126,4	8	58	Light Alloy	R	
FTP125R100A	40	A	125	126,4	10	58	Light Alloy	R	
FTP125R120A	40	A	125	126,4	12	58	Light Alloy	R	
FTP125R140A	40	A	125	126,4	14	58	Light Alloy	R	
FTP125R160T	40	A	125	126,4	16	58	Titanium	R	
FTP160R100A	40	C	160	161,4	10	58	Light Alloy	R	
FTP160R140A	40	C	160	161,4	14	58	Light Alloy	R	
FTP160R180A	40	C	160	161,4	18	58	Light Alloy	R	
FTP200R120A	60	C	200	201,4	12	63	Light Alloy	R	
FTP200R160A	60	C	200	201,4	16	63	Light Alloy	R	
FTP200R240A	60	C	200	201,4	24	63	Light Alloy	R	
FTP250R160A	60	C	250	251,4	16	63	Light Alloy	R	
FTP250R200A	60	C	250	251,4	20	63	Light Alloy	R	
FTP250R300A	60	C	250	251,4	30	63	Light Alloy	R	
FTP315R180A	60	D	315	316,4	18	80	Light Alloy	R	
FTP315R240A	60	D	315	316,4	24	80	Light Alloy	R	
FTP315R380A	60	D	315	316,4	38	80	Light Alloy	R	
FTP400R260A	60	D	400	401,4	26	80	Light Alloy	R	
FTP400R500A	60	D	400	401,4	50	80	Light Alloy	R	

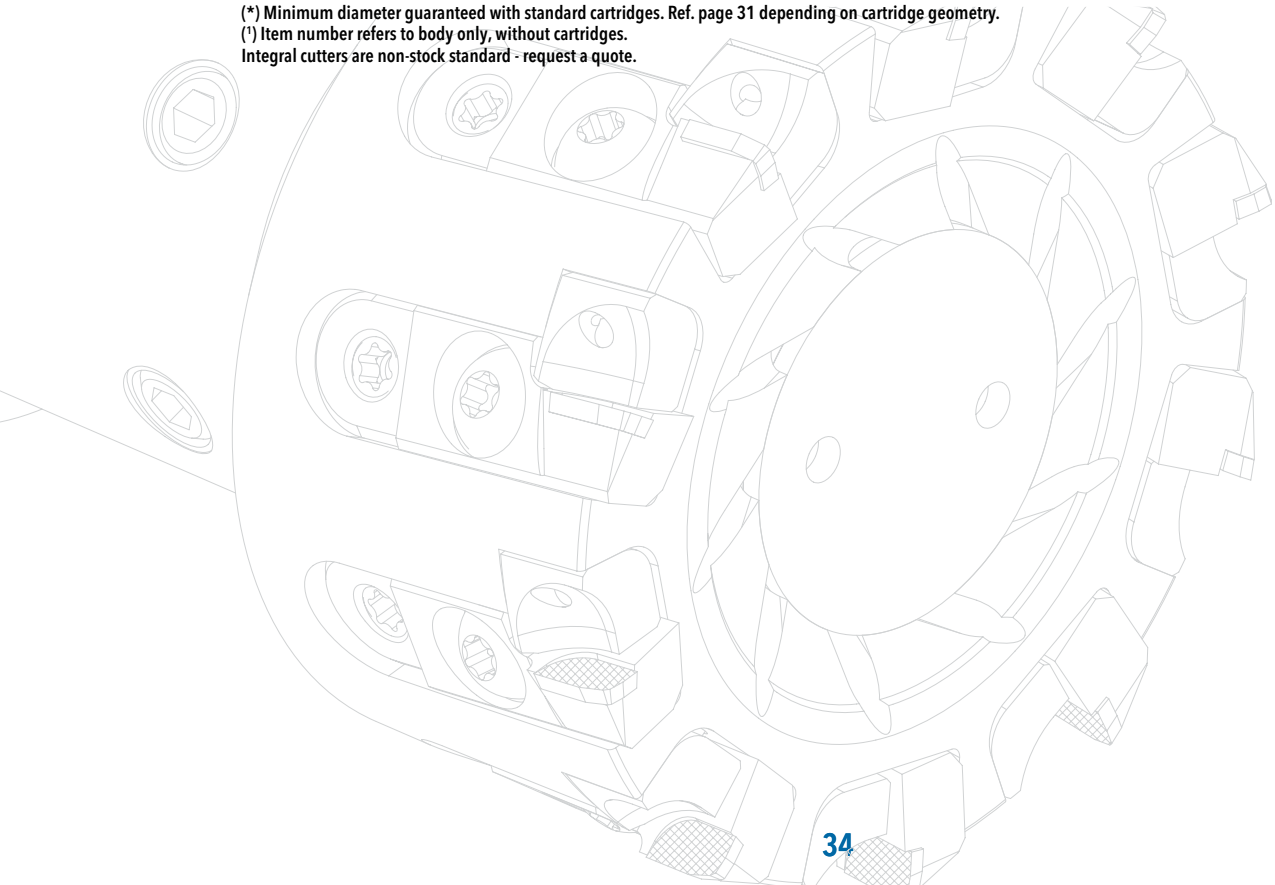
(*) Minimum diameter guaranteed with standard cartridges. Ref. page 31 depending on cartridge geometry.
(¹) Item number refers to body only, without cartridges.
Metric diameters are non-stock standard - request a quote.

PCD INTEGRAL TYPE CUTTERS - METRIC HOLDER HSK A



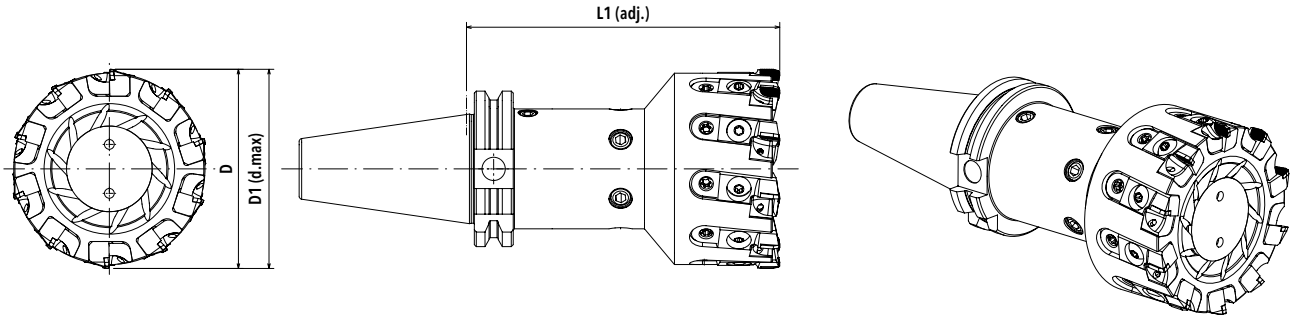
ITEM NUMBER	HSK TAPER DIMENSION	D (*) Ø NOM.	D1	Z	L1	MATERIAL	ROTATION
THA50040125P030	A 50	40	41.4	3	125	Steel	R
THA50050125P050	A 50	50	51.4	5	125	Steel	R
THA50063125P070	A 50	63	51.4	7	125	Steel	R
THA63040125P030	A 63	40	64.4	3	125	Steel	R
THA63050125P050	A 63	50	51.4	5	125	Steel	R
THA63063125P070	A 63	63	64.4	7	125	Steel	R
THA63080125P100	A 63	80	81.4	10	125	Steel	R
THA63100125P120	A 63	100	101.4	12	125	Steel	R
THA10080125P100	A 100	80	81.4	10	125	Steel	R
THA10100125P120	A 100	100	101.4	12	125	Steel	R
THA10125125P160	A 100	125	126.4	16	125	Steel	R

(*) Minimum diameter guaranteed with standard cartridges. Ref. page 31 depending on cartridge geometry.
(¹) Item number refers to body only, without cartridges.
Integral cutters are non-stock standard - request a quote.



PCD INTEGRAL TYPE CUTTERS - INCH

HOLDER CAT A/B



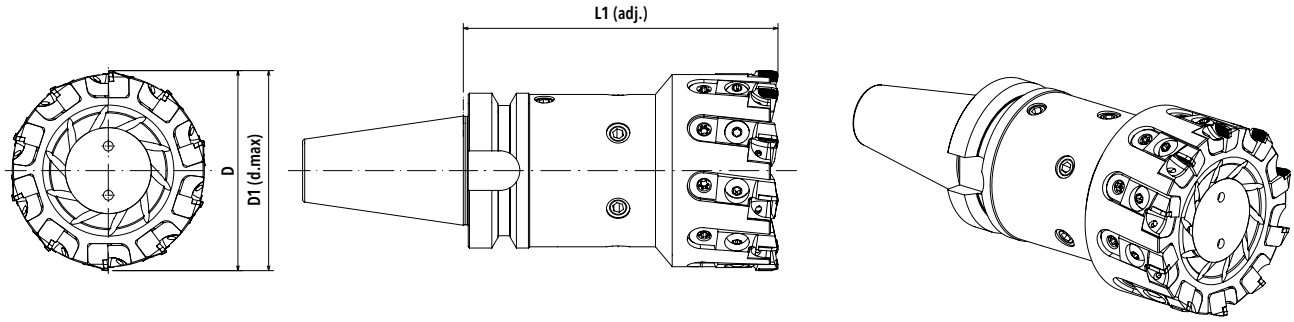
ITEM NUMBER	CAT TAPER DIMENSION	D(*) Ø NOM. (INCH)	D1 (INCH)	Z	L1 (MM)	MATERIAL	ROTATION
TCC40016125P030	40	1.63	1.68	3	125	Steel	R
TCC40020125P050	40	2.00	2.055	5	125	Steel	R
TCC40025125P070	40	2.50	2.555	7	125	Steel	R
TCC40030125P100	40	3.00	3.055	10	125	Steel	R

(*) Minimum diameter guaranteed with standard cartridges. Ref. page 31 depending on cartridge geometry.
(1) Item number refers to body only, without cartridges.

TEDI MILL®

PCD INTEGRAL TYPE CUTTERS - METRIC

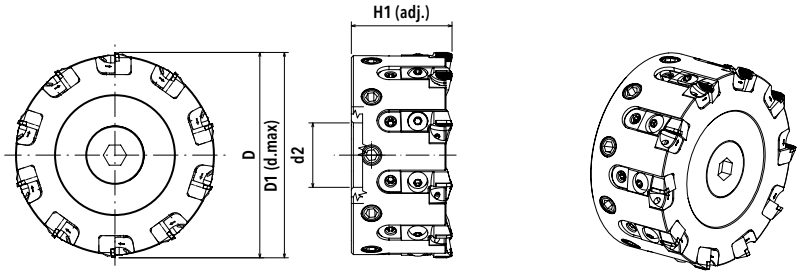
HOLDER BT A/B
MAS 403



ITEM NUMBER	BT TAPER DIMENSION	D (*) Ø NOM.	D1	Z	L1	MATERIAL	ROTATION
TBC40040125P030	40	40	41.4	3	125	Steel	R
TBC40050125P050	40	50	51.4	5	125	Steel	R
TBC40063125P070	40	63	64.4	7	125	Steel	R
TBC40080125P100	40	80	81.4	10	125	Steel	R

(*) Minimum diameter guaranteed with standard cartridges. Ref. page 31 depending on cartridge geometry.
(1) Item number refers to body only, without cartridges.
Integral cutters are non-stock standard - request a quote.

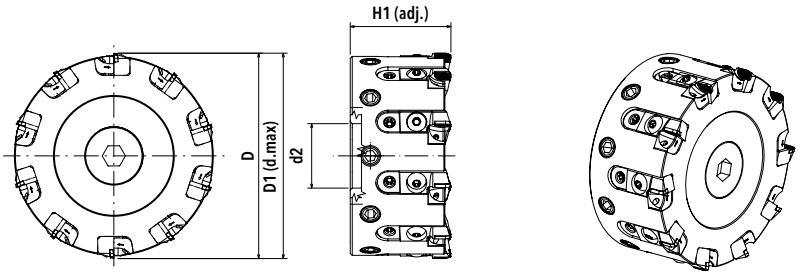
CBN SHELL CUTTERS - INCH



ITEM NUMBER	d2 (MM)	HOLDER SHAPE	D(*) Ø NOM. (INCH)	D1 (INCH)	Z	H1	MATERIAL	ROTATION
FIC020R040S	22	A	2.00	2.055	4	2.165	Steel	R
FIC020R050S	22	A	2.00	2.055	5	2.165	Steel	R
FIC025R050S	22	B	2.50	2.555	5	2.165	Steel	R
FIC025R060S	22	B	2.50	2.555	6	2.165	Steel	R
FIC030R050S	27	A	3.00	3.055	5	2.283	Steel	R
FIC030R060S	27	A	3.00	3.055	6	2.283	Steel	R
FIC030R080S	27	A	3.00	3.055	8	2.283	Steel	R
FIC040R080S	32	A	4.00	4.055	8	2.283	Steel	R
FIC040R120S	32	A	4.00	4.055	12	2.283	Steel	R
FIC050R100S	40	A	5.00	5.055	10	2.283	Steel	R
FIC050R160S	40	A	5.00	5.055	16	2.283	Steel	R
FIC060R100S	40	C	6.00	6.055	10	2.283	Steel	R
FIC060R180S	40	C	6.00	6.055	18	2.283	Steel	R
FIC080R120S	60	C	8.00	8.055	12	2.48	Steel	R
FIC080R240S	60	C	8.00	8.055	24	2.48	Steel	R
FIC100R160S	60	C	10.00	10.055	16	2.48	Steel	R
FIC100R300S	60	C	10.00	10.055	30	2.48	Steel	R

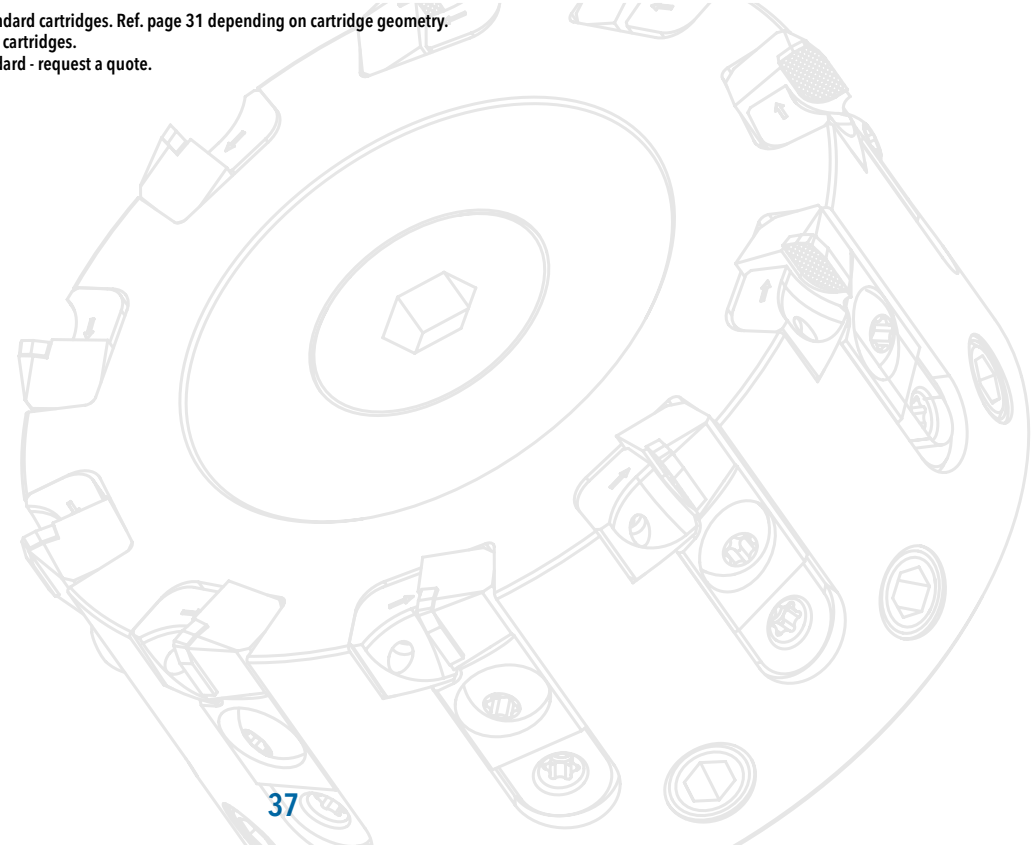
(*) Minimum diameter guaranteed with standard cartridges. Ref. page 31 depending on cartridge geometry.
(1) Item number refers to body only, without cartridges.
CBN cutter bodies are non-stock standard - request a quote.

CBN SHELL CUTTERS - METRIC



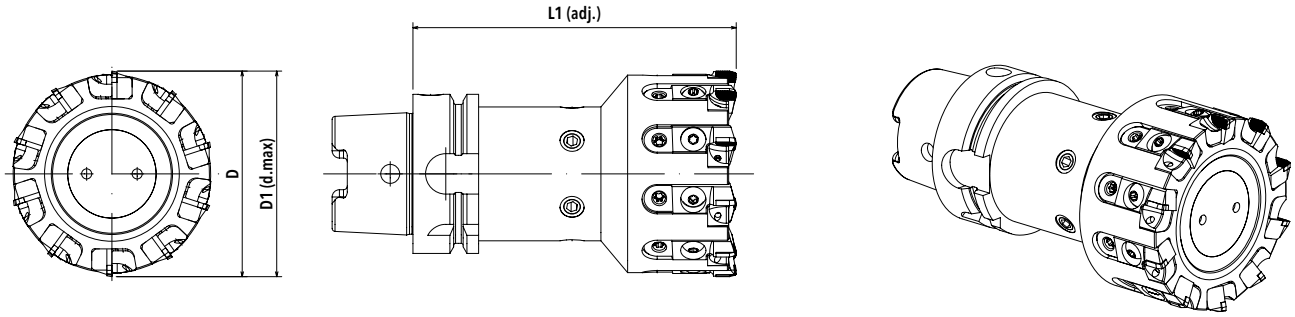
ITEM NUMBER	d2	HOLDER SHAPE	D (*) Ø NOM.	D1	Z	H1	MATERIAL	ROTATION
FTC050R040S	22	A	50	51,4	4	50	Steel	R
FTC063R060S	22	B	63	64,4	6	50	Steel	R
FTC080R080S	27	A	80	81,4	8	50	Steel	R
FTC080R100S	27	A	80	81,4	10	50	Steel	R
FTC100R080S	32	A	100	101,4	8	50	Steel	R
FTC100R120S	32	A	100	101,4	12	50	Steel	R
FTC125R100S	40	A	125	126,4	10	63	Steel	R
FTC125R140S	40	A	125	126,4	14	63	Steel	R
FTC125R160S	40	A	125	126,4	16	63	Steel	R
FTC160R140S	40	C	160	161,4	14	63	Steel	R
FTC160R180S	40	C	160	161,4	18	63	Steel	R
FTC200R160S	60	C	200	201,4	16	63	Steel	R
FTC200R240S	60	C	200	201,4	24	63	Steel	R

(*) Minimum diameter guaranteed with standard cartridges. Ref. page 31 depending on cartridge geometry.
(1) Item number refers to body only, without cartridges.
Metric CBN cutter bodies are non-stock standard - request a quote.



CBN INTEGRAL TYPE CUTTERS - METRIC

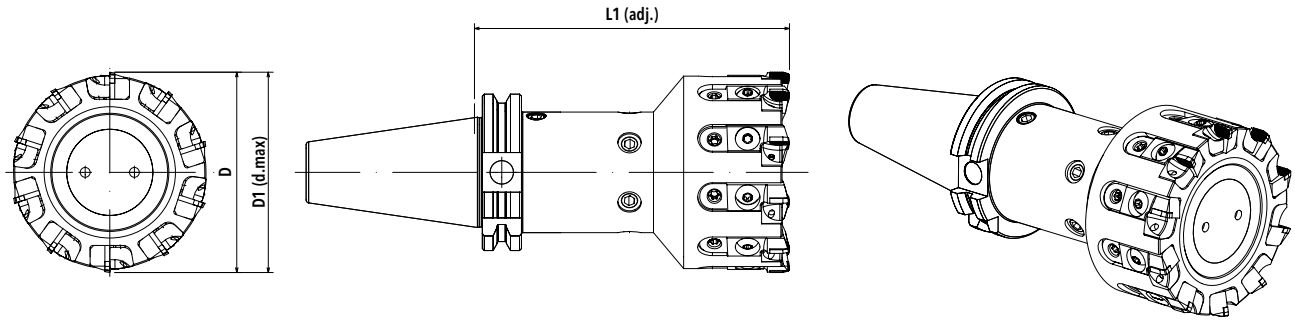
HOLDER HSK A
DIN 69893



ITEM NUMBER	HSK TAPER DIMENSION	D (*) Ø NOM.	D1	Z	L1	MATERIAL	ROTATION
THA63040125C030	A 63	40	41.4	3	125	Steel	R
THA63050125C050	A 63	50	51.4	5	125	Steel	R
THA63063125C070	A 63	63	64.4	7	125	Steel	R
THA63080125C100	A 63	80	81.4	10	125	Steel	R
THA10040125C030	A 100	40	41.4	3	125	Steel	R
THA10050125C050	A 100	50	51.4	5	125	Steel	R
THA10063125C060	A 100	63	64.4	6	125	Steel	R
THA10080125C100	A 100	80	81.4	10	125	Steel	R
THA10100125C120	A 100	100	101.4	12	125	Steel	R
THA10125125C160	A 100	125	126.4	16	125	Steel	R

CBN INTEGRAL TYPE CUTTERS - INCH

HOLDER CAT A/B

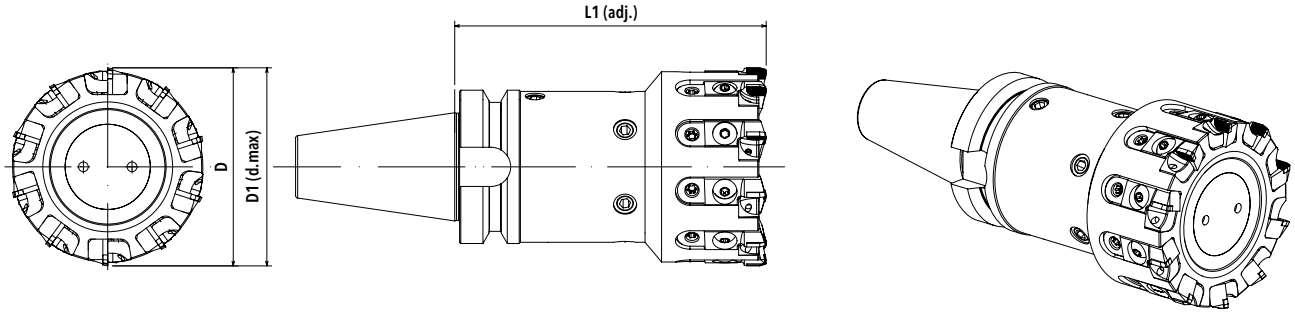


ITEM NUMBER	CAT TAPER DIMENSION	D(*) Ø NOM. (INCH)	D1 (INCH)	Z	L1 (INCH)	MATERIAL	ROTATION
TCC40016125C030	40	1.63	1.68	3	125	Steel	R
TCC40020125C050	40	2.00	2.055	5	125	Steel	R
TCC40025125C070	40	2.50	2.555	7	125	Steel	R
TCC40030125C100	40	3.00	3.055	10	125	Steel	R
TCC50016125C030	50	1.63	1.68	3	125	Steel	R
TCC50020125C050	50	2.00	2.055	5	125	Steel	R
TCC50025125C070	50	2.50	2.555	7	125	Steel	R
TCC50030125C100	50	3.00	3.055	10	125	Steel	R
TCC50040125C120	50	4.00	4.055	12	125	Steel	R
TCC50050125C160	50	5.00	5.055	16	125	Steel	R

(*) Minimum diameter guaranteed with standard cartridges. Ref. page 31 depending on cartridge geometry.
(1) Item number refers to body only, without cartridges.
Integral cutters are non-stock standard - request a quote.

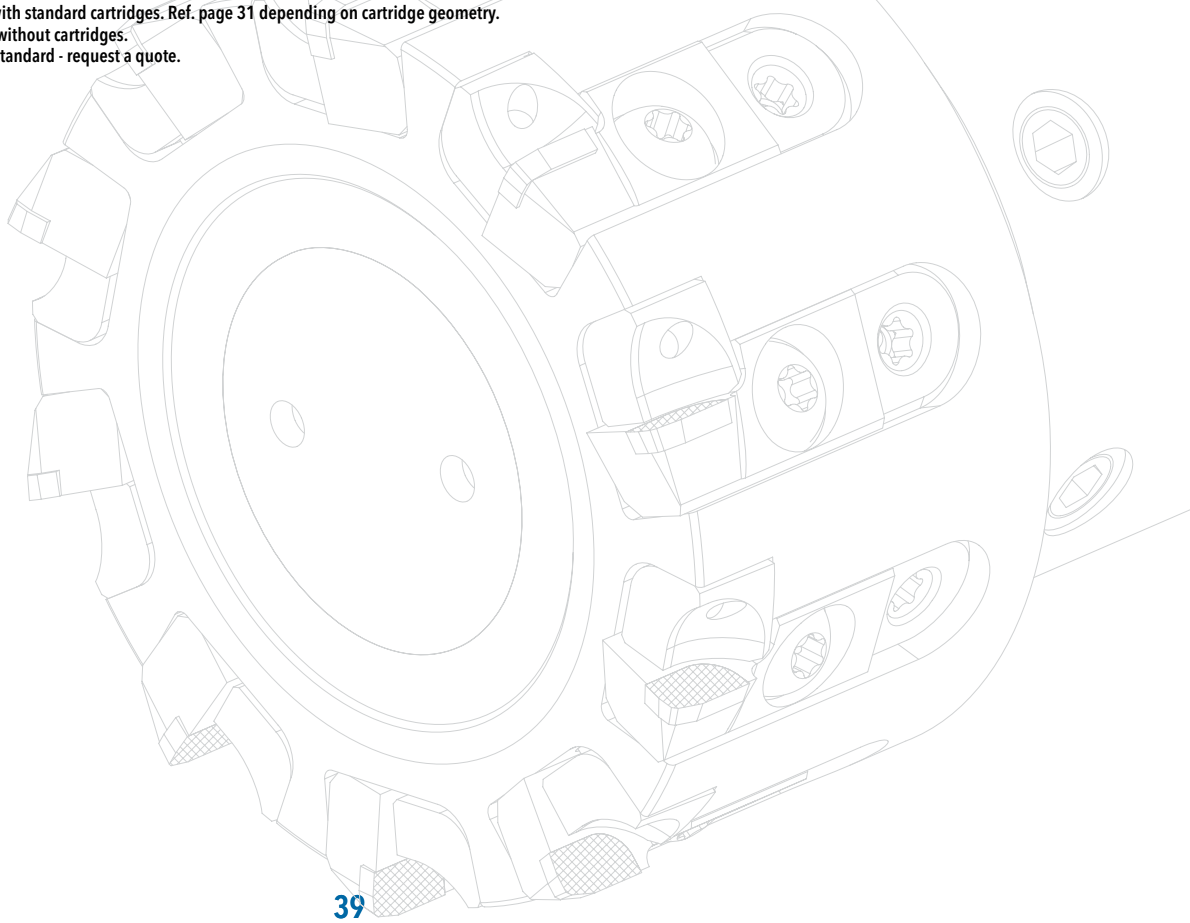
CBN INTEGRAL TYPE CUTTERS - METRIC

HOLDER BT A/B
MAS 403



ITEM NUMBER	BT TAPER DIMENSION	D (*) Ø NOM.	D1	Z	L1	MATERIAL	ROTATION
TBC40040125C030	40	40	41.4	3	125	Steel	R
TBC40050125C050	40	50	51.4	5	125	Steel	R
TBC40063125C070	40	63	64.4	7	125	Steel	R
TBC40080125C100	40	80	81.4	10	125	Steel	R
TBC50040125C030	50	40	41.4	3	125	Steel	R
TBC50050125C050	50	50	51.4	5	125	Steel	R
TBC50063125C060	50	63	64.4	6	125	Steel	R
TBC50080125C100	50	80	81.4	10	125	Steel	R
TBC50100125C120	50	100	101.4	12	125	Steel	R
TBC50125125C160	50	125	126.4	16	125	Steel	R

(*) Minimum diameter guaranteed with standard cartridges. Ref. page 31 depending on cartridge geometry.
(1) Item number refers to body only, without cartridges.
Integral cutter bodies are non-stock standard - request a quote.



TEDI MILL
Cartridges

DESIGNATION SYSTEM FOR CARTRIDGES

PRODUCT LINE

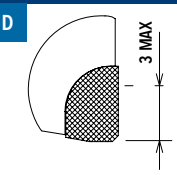
TEDI MILL

TYPE OF CARTRIDGE

- Milling — A
- Wiper — R

CUTTING EDGE

- Disposable — D
- Re-Tippable — R



CUTTING EDGE GRADE

- B5 PCD — PCD – recommended grade for Aluminium alloys with Si < 12-14%, Magnesium alloys.
- 90 CBN — CBN – recommended grade for grey cast irons and non-ferrous cast irons.

T	M	C	P	A	0	1	R	R	B	5

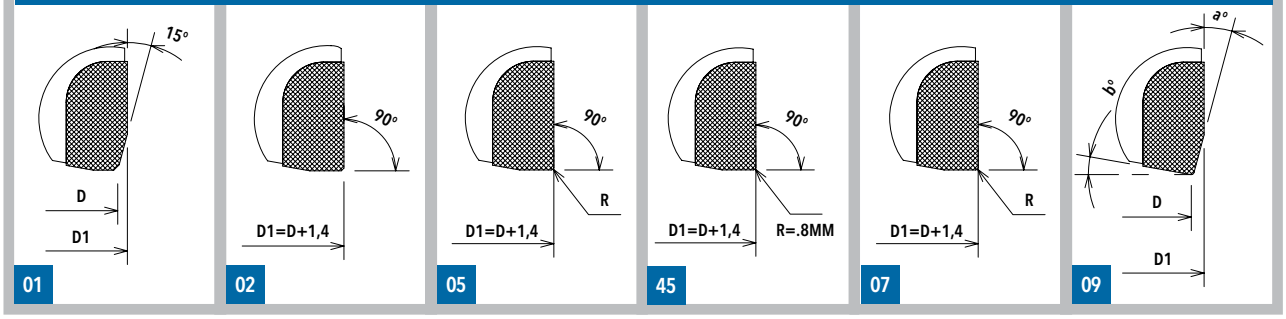
CUTTING EDGE MATERIAL

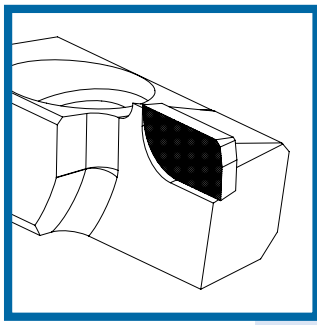
- PCD — P
- CBN — C

ROTATION

- Right — R
- Left — L

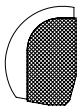
CUTTING EDGE GEOMETRY





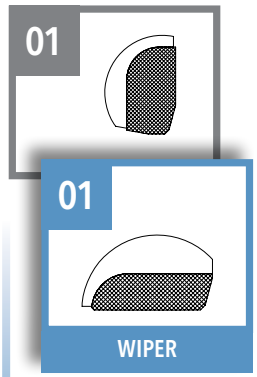
PCD

GEOMETRY 01



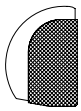
Recommended for finishing not square shoulder surfaces. Suitable for roughing too.

Achievable surface:
0.3 ≤ Ra ≤ 0.8



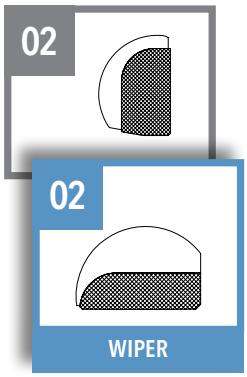
Achievable surface:
0.1 ≤ Ra ≤ 0.5

GEOMETRY 02



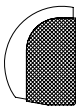
Recommended for finishing square shoulder surfaces. Suitable for roughing too.

Achievable surface:
0.3 ≤ Ra ≤ 0.8



Achievable surface:
0.1 ≤ Ra ≤ 0.5

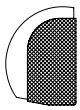
GEOMETRY 05



Suitable for roughing or for cutting material with a high impurity content. (Cubing)

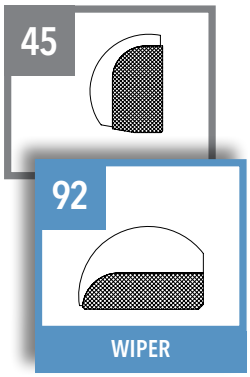
Achievable surface:
0.4 ≤ Ra < 1

GEOMETRY 45



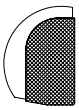
Recommended for finishing square shoulder surfaces.

Achievable surface:
0,4 ≤ Ra ≤ 0,8



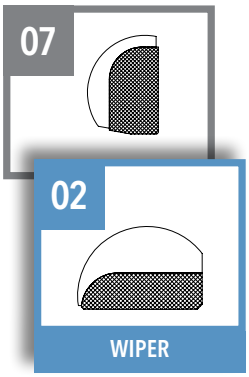
Achievable surface:
0.2 ≤ Ra ≤ 0.5

GEOMETRY 07



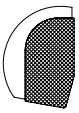
Suitable for finishing or roughing - general purpose.

Achievable surface:
0.4 ≤ Ra < 1



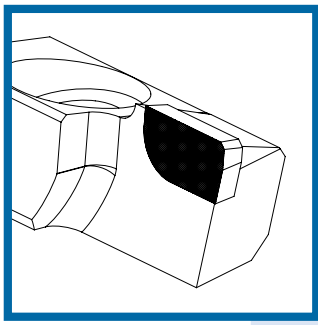
Achievable surface:
0.1 ≤ Ra ≤ 0.5

GEOMETRY 09



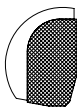
Suitable for finishing surfaces requiring gasket retention.

Achievable surface:
0.8 ≤ Ra ≤ 3.2



CBN

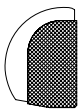
GEOMETRY 01



Recommended for finishing not square shoulder surfaces.

Achievable surface:
0.4 ≤ Ra ≤ 0.8

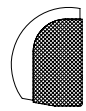
GEOMETRY 02



Recommended for finishing square shoulder surfaces.

Achievable surface:
0.4 ≤ Ra ≤ 0.8

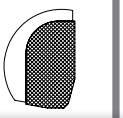
GEOMETRY 05



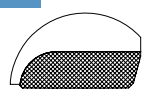
Recommended for roughing square shoulder surfaces.

Achievable surface:
0.4 ≤ Ra ≤ 0.8

01



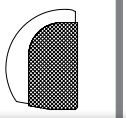
01



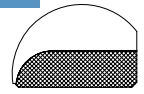
WIPER

Achievable surface:
0.2 ≤ Ra ≤ 0.5

02



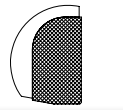
02



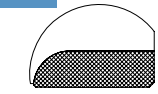
WIPER

Achievable surface:
0.2 ≤ Ra ≤ 0.5

05



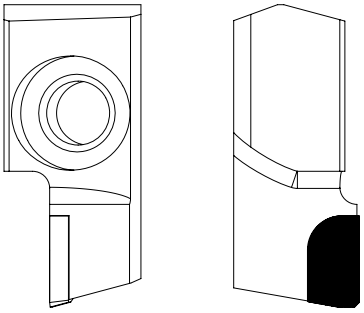
02



WIPER

Achievable surface:
0.2 ≤ Ra ≤ 0.5

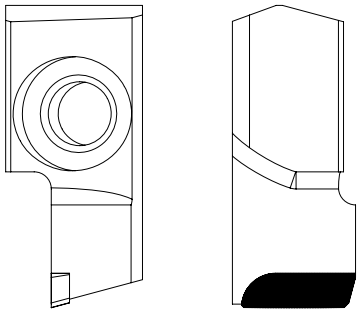
PCD MILLING CARTRIDGES



ITEM NUMBER	PCD GRADE	
	B5	(*)
TMCPA01DRB5	●	
TMCPA01RRB5	●	
TMCPA02DRB5	●	
TMCPA02RRB5	●	
TMCPA05DRB5	●	
TMCPA05RRB5	●	
TMCPA07DRB5	●	
TMCPA07RRB5	●	
TMCPA09DRB5	●	
TMCPA09RRB5	●	
TMCPA45DRB5	●	
TMCPA45RRB5	●	

(*) Contact Ingersoll/IT.TE.DI. for the right choice of CBN grade in case of different applications.

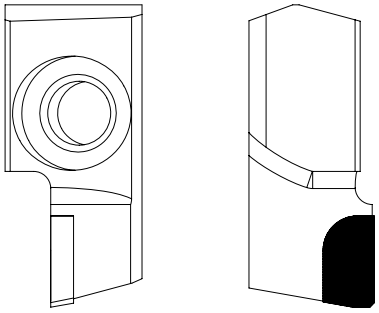
PCD WIPER CARTRIDGES



ITEM NUMBER	PCD GRADE	
	B5	(*)
TMCPR01RRB5	●	
TMCPR02RRB5	●	

(*) Contact Ingersoll/IT.TE.DI. for the right choice of CBN grade in case of different applications.

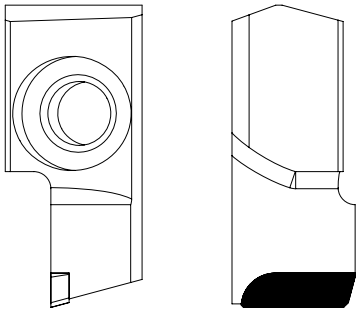
CBN MILLING CARTRIDGES



ITEM NUMBER	CBN GRADE	
	90	(*)
TMCCA01DR90	●	
TMCCA01RR90	●	
TMCCA02DR90	●	
TMCCA02RR90	●	
TMCCA05DR90	●	
TMCCA05RR90	●	

(*) Contact Ingersoll/IT.TE.DI. for the right choice of CBN grade in case of different applications.

CBN WIPER CARTRIDGES



ITEM NUMBER	CBN GRADE	
	90	(*)
TMCCR01RR90	●	
TMCCR02RR90	●	

(*) Contact Ingersoll/IT.TE.DI. for the right choice of CBN grade in case of different applications.

TEDI OCTO CUT

Shell Mill Line With CBN Octagonal Inserts

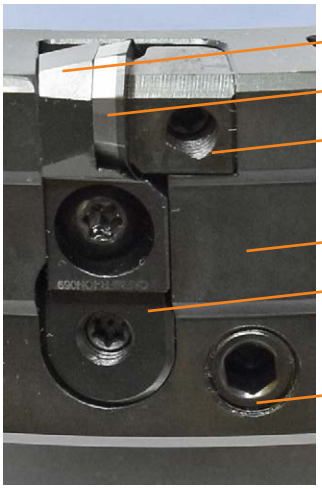
TEDI OCTO CUT

The innovative TEDI OCTO CUT line features CBN inserts for grey cast iron parts in high speed processes with the guarantee of improved cycle times and extended insert usability. When an insert edge is worn, simply rotate the insert to the next edge, and you're ready to get back to work. As the name implies, insert rotation can be performed up to eight times.

TEDI OCTO CUT mills also feature wiper inserts for high quality surface finishing at high feed rates. The seat of the cutting edge pack (wedge, cartridge, and insert) is the same for each pocket, so you can mount wiper or scraper inserts indifferently.

FEATURES

- High speed machining for cast iron applications
- High rigidity
- Simple and precise axial adjustment
- 8 effective corners per insert
- High flexibility so the correct surface finish can be achieved



The adjusting wedge (below the cartridge) axially sets the inserts in order to have consistent height within the mill.

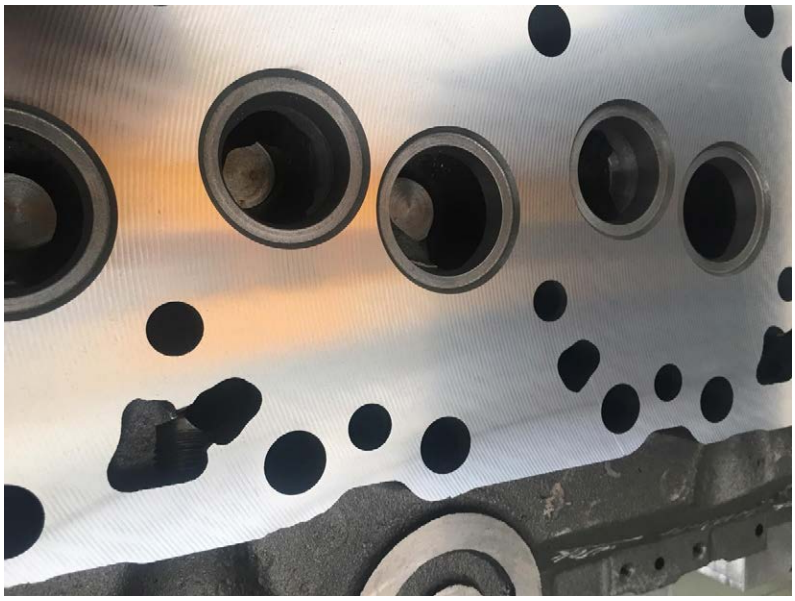
TEDI OCTO CUT can be used indifferently with a standard face milling adaptor or with an IT.TE.DI. adaptor:

TEDI MILL adaptor

Standard IMC adaptor

CBN RESULTS

RESULTS ON CAST IRON CYLINDER HEADS



GG40 grey cast iron

TEDI OCTO CUT Ø315 Z=28+4	
RPM	1012
TABLE FEED	1450 mm
DOC	0,5 mm

RESULTS	
SURFACE FINISH	Rz 3÷5
FLATNESS	14÷18 µm

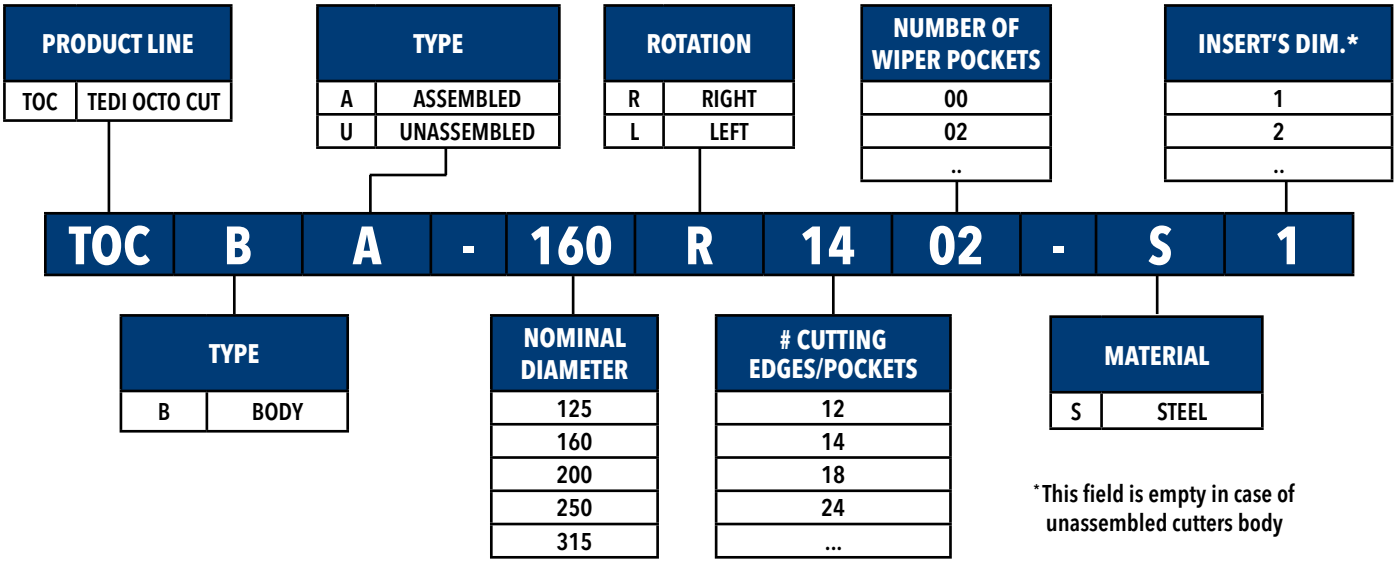
RESULTS ON CAST IRON CYLINDER BLOCKS

GG30 grey cast iron

TEDI OCTO CUT Ø250 Z=22+4	
RPM	1520
TABLE FEED	2400 mm
DOC	0,4 mm

RESULTS	
SURFACE FINISH	Rz 3÷6
FLATNESS	15÷20 µm

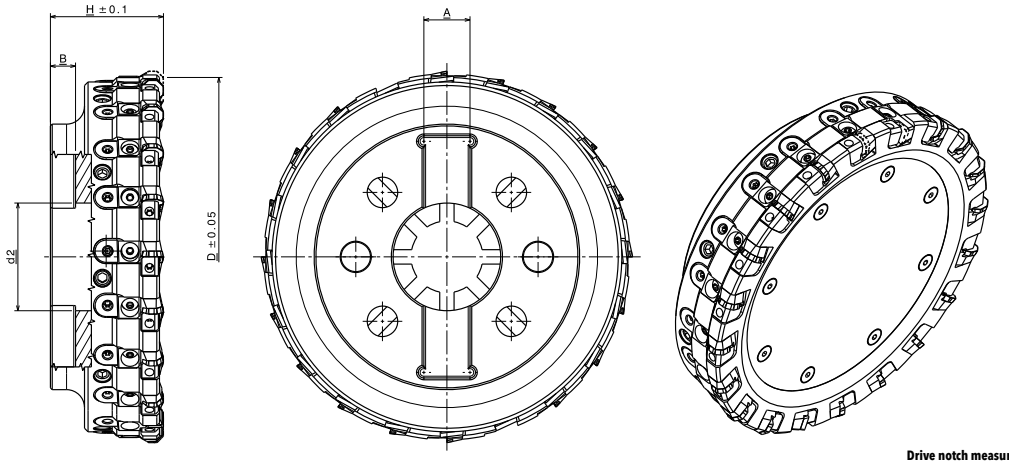
CBN CUTTER BODIES



*This field is empty in case of unassembled cutters body

NOTE:
The assembled bodies don't include inserts
The unassembled bodies don't include inserts and cartridges

CBN ASSEMBLED CUTTERS - METRIC

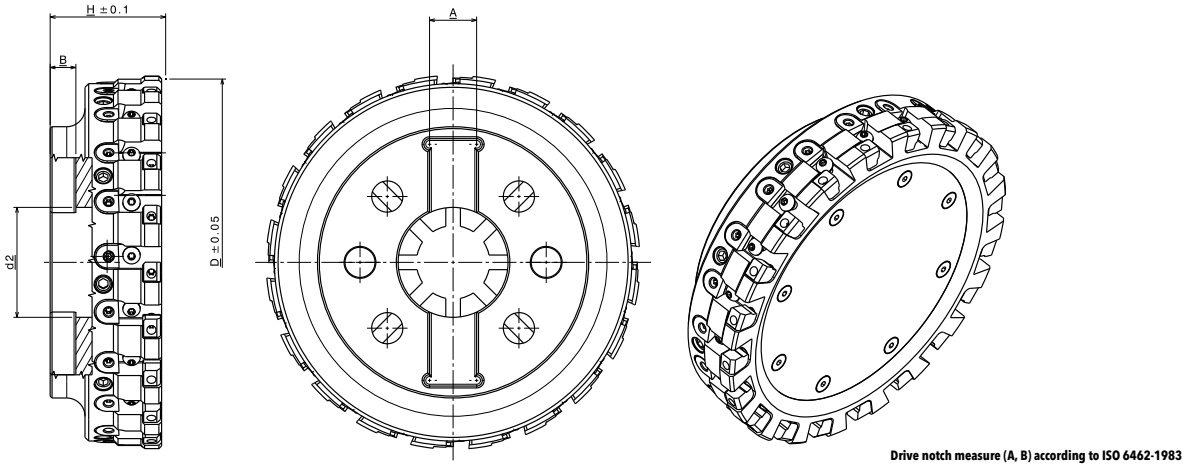


Drive notch measure (A, B) according to ISO 6462-1983

PART NUMBER	d2 (MM)	HOLDER SHAPE	D (*) Ø NOM. (MM)	Z	H	INSERT'S DIM.	MATERIAL	WEIGHT	EDP
TOCBA-100R0800-S1	32	A	100	8	63	1	Steel	2,7	2764834
TOCBA-125R1200-S1	40	A	125	12	63	1	Steel	4,64	2740961
TOCBA-160R1402-S1	40	C	160	14+2	63	1	Steel	6,37	2740962
TOCBA-200R1802-S1	60	C	200	18+2	63	1	Steel	9,23	2740963
TOCBA-250R2402-S1	60	C	250	24+2	63	1	Steel	13,07	2740964
TOCBA-315R2804-S1	60	C	315	28+4	63	1	Steel	19,37	2740965

[1] Part number refers to the body without inserts. (cartridges are included)
[2] The weight is referred to the assembled part (cutter body with cutting parts)

CBN UNASSEMBLED CUTTERS - INCH



Drive notch measure (A, B) according to ISO 6462-1983

PART NUMBER	d2 (MM)	HOLDER SHAPE	D (*) Ø NOM. (INCH)	Z	H	INSERT'S DIM.	MATERIAL	WEIGHT	EDP
TOCBU-160R1600-S	32	A	100	8	63	1	Steel	2,7	2765959
TOCBU-125R1200-S	40	A	125	12	63	1	Steel	4,38	2743281
TOCBU-160R1600-S	40	C	160	16	63	1	Steel	6,03	2743282
TOCBU-200R2000-S	60	C	200	20	63	1	Steel	8,81	2743283
TOCBU-250R2600-S	60	C	250	26	63	1	Steel	12,52	2743284
TOCBA-315R3200-S	60	C	315	32	63	1	Steel	18,72	2743285

[4] Part number refers to the body without inserts and cartridges (scraper and adjustment type wedges are included)

CBN CARTRIDGES

PRODUCT LINE	
TOC	TEDI OCTO CUT

TYPE	
S	SCRAPER
W	WIPER

GEOMETRY
G01
G02
..

TOC C S - 1 G01 - C

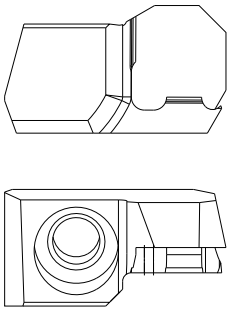
TYPE	
C	CARTRIDGE

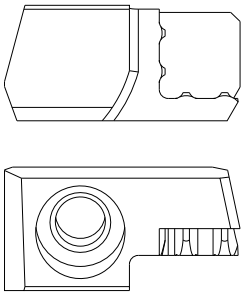
INSERT'S DIM.
1
..

INSERT'S MATERIAL	
C	CBN
..	

CBN CARTRIDGES

SCRAPER CARTRIDGE





WIPER CAR-TRIDGE

PART NUMBER	TYPE	INSERT'S DIM.	ROTATION	GEOMETRY	MATERIAL	WEIGHT (kg)	EDP
TOCCS-1G01-C	SCRAPER	1	R	G01	Steel	0,02	2739218
TOCCW-1G01-C	WIPER	1	R	G01	Steel	0,02	2739231

SCRAPER CARTRIDGE

WIPER CARTRIDGE

CBN INSERTS

PRODUCT LINE	
TOC	TEDI OCTO CUT

TYPE	
S	SCRAPER
W	WIPER

GEOMETRY
A0043
..

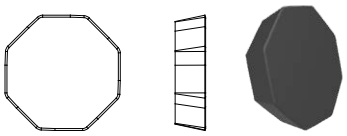
COATING	
NN	NOT COATED

TOC	I	S	-	1	-	A0043	CH	-	NN

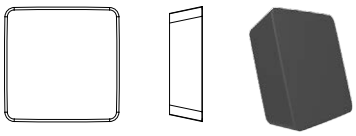
TYPE	
I	INSERT

INSERT'S DIM.
1
..

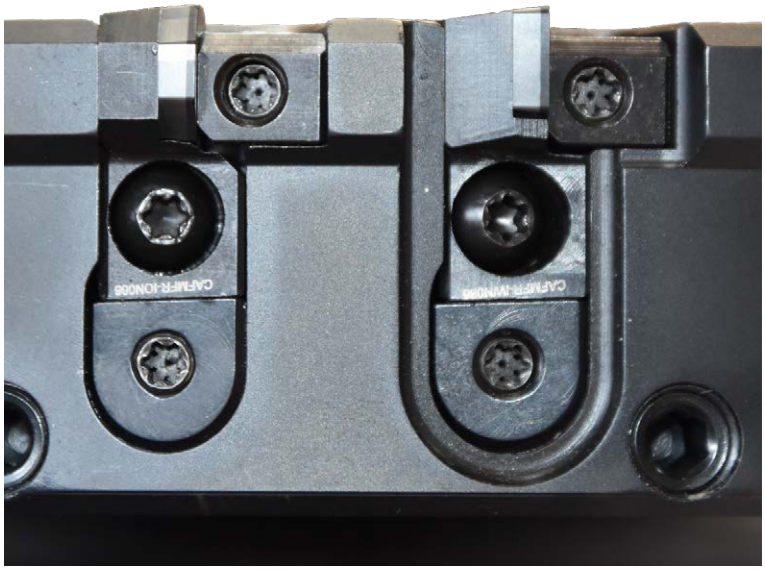
MATERIAL	
H	CBN



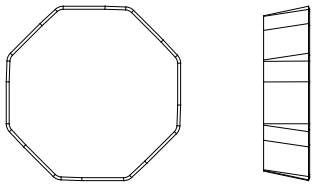
SCRAPER INSERT

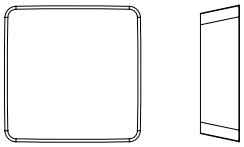


WIPER INSERT



CBN INSERTS





PRODUCT CODE [6]	TYPE	INSERT'S DIM.	GEOMETRY	GRADE	COATING	AVAILABILITY	ITEM
TOCIS-1-A0044CH-NN	Scraper	1	A0043	CH	NN	Stock	2737837
TOCIW-1-A0014CH-NN	Wiper	1	A0043	CH	NN	Stock	2737836
TOCIS-1-A0080CB-NN	Scraper	1	A0043	CB	NN	Stock	2744399
TOCIW-1-A0080CB-NN	Wiper	1	A0043	CB	NN	Stock	2744400

SCRAPER INSERT

WIPER INSERT

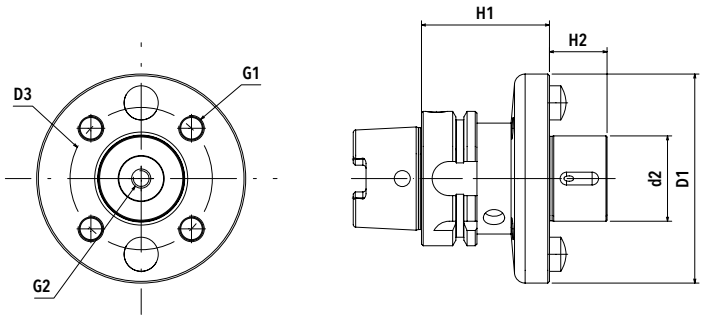
*** Minimum diameter guaranteed with standard inserts. Refer to related table of available cutting geometry for more detail**
[1] Item number refers to body only, without inserts.
[3] The weight is referred to the assembled part (cutter body with cutting parts)

ADAPTORS

The IT.TE.DI. adaptors have been engineered to make the cutter extremely rigid. For this reason, they are designed with oversized flange diameters in combination with larger drive keys which allow the perfect tightness with the cutter body. In this way coolant leakage, which can be harmful to the spindle too, are avoided. The coolant pressure stays stable and a perfect cleaning of the cutting area during the machining is guaranteed. IT.TE.DI. holders undergo careful and meticulous production processes. That's why they are particularly suitable for machining at high cutting speeds, in wet, dry or MQL operations. The holders are all balanced for high cutting speeds.

CUTTER HOLDERS - METRIC

HOLDER HSK A
DIN 69893

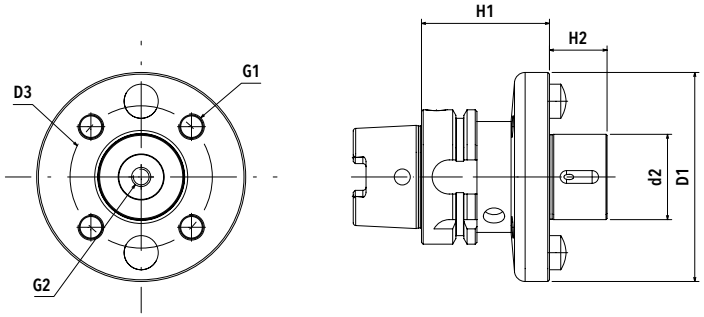


ITEM NUMBER	HSK TAPER DIMENSION	HOLDER SHAPE	d2	H1	D1	D3	H2	G1	G2
APHK40AA16050	A 40	A	16	50	41		13		M6
APHK40BA22050	A 40	B	22	50	58		19		M10
APHK40AA22050	A 40	A	22	50	50		19		M10
APHK50AA16050	A 50	A	16	50	41		13		M6
APHK50AA16100	A 50	A	16	100	41		13		M6
APHK50BA22050	A 50	B	22	50	58		19		M10
APHK50AA22050	A 50	A	22	50	50		19		M10
APHK50BA22100	A 50	B	22	100	58		19		M10
APHK50AA22100	A 50	A	22	100	50		19		M10
APHK50AA27060	A 50	A	27	60	68		21		M12
APHK50AA27100	A 50	A	27	100	68		21		M12
APHK63AA16050	A 63	A	16	50	41		13		M6
APHK63AA16100	A 63	A	16	100	41		13		M6
APHK63BA22050	A 63	B	22	50	58		19		M10
APHK63AA22050	A 63	A	22	50	50		19		M10
APHK63BA22100	A 63	B	22	100	58		19		M10
APHK63AA22100	A 63	A	22	100	50		19		M10
APHK63AA27060	A 63	A	27	60	68		21		M12
APHK63AA27100	A 63	A	27	100	68		21		M12
APHK63AA32060	A 63	A	32	60	88		24		M16
APHK63AA32100	A 63	A	32	100	88		24		M16
APHK63AA40060	A 63	A	40	60	98		27		M20
APHK63AA40100	A 63	A	40	100	98		27		M20
APHK63CA40060	A 63	C	40	60	98	66.7	27	M12	
APHK80AA16060	A 80	A	16	60	41		13		M6

NOTE: Both metric and inch size cutters will fit on metric pilot adapters.

CUTTER HOLDERS - METRIC

HOLDER HSK A
DIN 69893

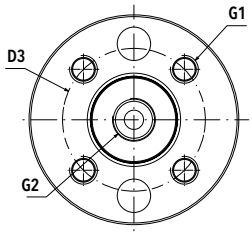


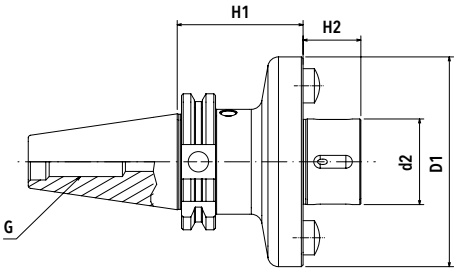
ITEM NUMBER	HSK TAPER DIMENSION	HOLDER SHAPE	d2	H1	D1	D3	H2	G1	G2
APHK80AA16120	A 80	A	16	120	41		13		M6
APHK80BA22060	A 80	B	22	60	58		19		M10
APHK80AA22060	A 80	A	22	60	50		19		M10
APHK80BA22120	A 80	B	22	120	58		19		M10
APHK80AA22120	A 80	A	22	120	50		19		M10
APHK80AA27060	A 80	A	27	60	68		21		M12
APHK80AA27120	A 80	A	27	120	68		21		M12
APHK80AA32060	A 80	A	32	60	88		24		M16
APHK80AA32120	A 80	A	32	120	88		24		M16
APHK80AA40060	A 80	A	40	60	98		27		M20
APHK80AA40120	A 80	A	40	120	98		27		M20
APHK80CA40060	A 80	C	40	60	98	66.7	27	M12	
APHK80CA60060	A 80	C	60	60	140	101.6	40	M16	
APHK10BA22060	A 100	B	22	60	58		19		M10
APHK10AA22060	A 100	A	22	60	50		19		M10
APHK10BA22120	A 100	B	22	120	58		19		M10
APHK10AA22120	A 100	A	22	120	50		19		M10
APHK10AA27060	A 100	A	27	60	68		21		M12
APHK10AA27120	A 100	A	27	120	68		21		M12
APHK10AA32070	A 100	A	32	70	88		24		M16
APHK10AA32120	A 100	A	32	120	88		24		M16
APHK10AA40070	A 100	A	40	70	98		27		M20
APHK10AA40120	A 100	A	40	120	98		27		M20
APHK10CA40070	A 100	C	40	70	98	66.7	27	M12	
APHK10CA60070	A 100	C	60	70	140	101.6	40	M16	

NOTE: Both metric and inch size cutters will fit on metric pilot adapters.

CUTTER HOLDERS - METRIC

HOLDER CAT A/B



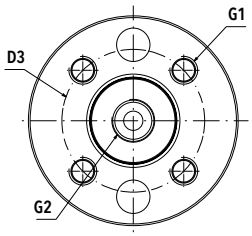


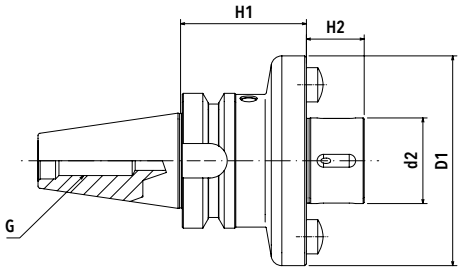
ITEM NUMBER	CAT TAPER DIMENSION	HOLDER SHAPE	d2	H1	D1	D3	H2	G1	G2
API740AC22050	40	A	22	50	50		19		M10
API740AC22100	40	A	22	100	50		19		M10
API740BC22050	40	B	22	50	58		19		M10
API740BC22100	40	B	22	100	58		19		M10
API740AC27060	40	A	27	60	68		21		M12
API740AC27100	40	A	27	100	68		21		M12
API740AC32060	40	A	32	60	88		24		M16
API740AC32100	40	A	32	100	88		24		M16
API740AC40060	40	A	40	60	98		27		M20
API740AC40100	40	A	40	100	98		27		M20
API740CC40060	40	C	40	60	98	66.7	27	M12	
API740CC40100	40	C	40	60	98	66.7	27	M12	
API750AC22060	50	A	22	60	50		19		M10
API750AC22120	50	A	22	120	50		19		M10
API750BC22060	50	B	22	60	58		19		M10
API750BC22120	50	B	22	120	58		19		M10
API750AC27060	50	A	27	60	68		21		M12
API750AC27120	50	A	27	120	68		21		M12
API750AC32070	50	A	32	70	88		24		M16
API750AC32120	50	A	32	120	88		24		M16
API750AC40070	50	A	40	70	98		27		M20
API750AC40120	50	A	40	120	98		27		M20
API750CC40070	50	C	40	70	98	66.7	27	M12	
API750CC40120	50	C	40	120	98	66.7	27	M12	
API750CC60070	50	C	60	70	140	101.6	30	M16	
API750CC60120	50	C	60	120	140	101.6	30	M16	

NOTE: Both metric and inch size cutters will fit on metric pilot adapters.

CUTTER HOLDERS - METRIC

HOLDER BT A/B
MAS 403



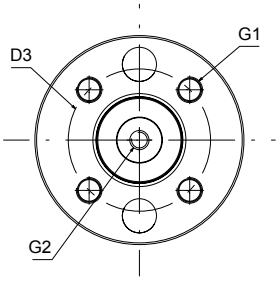


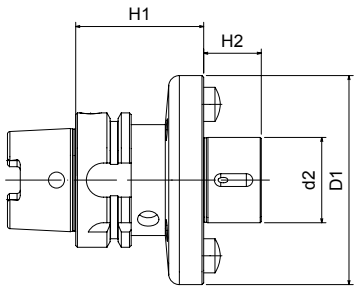
ITEM NUMBER	BT TAPER DIMENSION	HOLDER SHAPE	d2	H1	D1	D3	H2	G1	G2
API430AA16050	30	A	16	50	41	-	13	-	M6
API430BA22050	30	B	22	50	50	-	19	-	M10
API430AA22050	30	A	22	50	50	-	19	-	M10
API430AA27060	30	A	27	60	68	-	21	-	M12
API430AA32060	30	A	32	60	88	-	24	-	M16
API440AC16050	40	A	16	50	41		13		M6
API440AC16100	40	A	16	100	41		13		M6
API440BC22050	40	B	22	50	58		19		M10
API440AC22050	40	A	22	50	50		19		M10
API440BC22100	40	B	22	100	58		19		M10
API440AC22100	40	A	22	100	50		19		M10
API440AC27060	40	A	27	60	68		21		M12
API440AC27100	40	A	27	100	68		21		M12
API440AC32060	40	A	32	60	88		24		M16
API440AC32100	40	A	32	100	88		24		M16
API440AC40060	40	A	40	60	98		27		M20
API440AC40100	40	A	40	100	98		27		M20
API440CC40060	40	C	40	60	98	66.7	27	M12	
API450BC22060	50	B	22	60	58		19		M10
API450AC22060	50	A	22	60	50		19		M10
API450BC22120	50	B	22	120	58		19		M10
API450AC22120	50	A	22	120	50		19		M10
API450AC27060	50	A	27	60	68		21		M12
API450AC27120	50	A	27	120	68		21		M12
API450AC32070	50	A	32	70	88		24		M16
API450AC32120	50	A	32	120	88		24		M16
API450AC40070	50	A	40	70	98		27		M20
API450AC40120	50	A	40	120	98		27		M20
API450CC40070	50	C	40	70	98	66.7	27	M12	
API450CC60070	50	C	60	70	140	101.6	40	M16	

NOTE: Both metric and inch size cutters will fit on metric pilot adapters.

ADAPTORS - METRIC

HSK A DIN 69893





IC

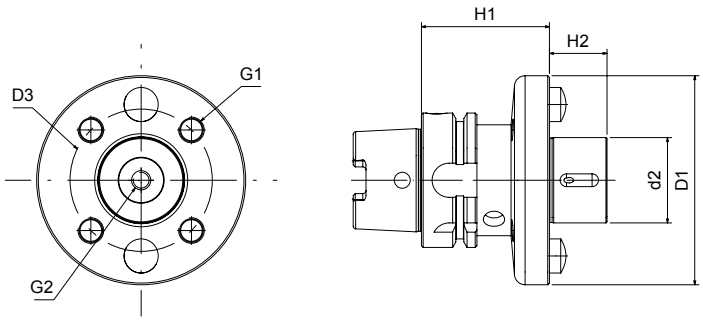
ITEM NUMBER	HSK TAPER DIMENSION	HOLDER SHAPE	d2	H1	D1	D3	H2	G1	G2	ITEM	AVAILABILITY
APHK40AA16050	A 40	A	16	50	41		13		M6	2703351	○
APHK40AA22050	A 40	A	22	50	50		19		M10	2703355	○
APHK40BA22050	A 40	B	22	50	58		19		M10	2703353	○
APHK50AA16050	A 50	A	16	50	41		13		M6	2703357	○
APHK50AA16100	A 50	A	16	100	41		13		M6	2703359	○
APHK50AA22050	A 50	A	22	50	50		19		M10	2708949	○
APHK50BA22050	A 50	B	22	50	58		19		M10	2703361	○
APHK50AA22100	A 50	A	22	100	50		19		M10	2703365	○
APHK50BA22100	A 50	B	22	100	58		19		M10	2703363	○
APHK50AA27060	A 50	A	27	60	68		21		M12	2708987	○
APHK50AA27100	A 50	A	27	100	68		21		M12	2703369	○
APHK63AA16050	A 63	A	16	50	41		13		M6	2708988	▲
APHK63AA16100	A 63	A	16	100	41		13		M6	2708990	○
APHK63AA22050	A 63	A	22	50	50		19		M10	2708993	▲
APHK63BA22050	A 63	B	22	50	58		19		M10	2708991	▲
APHK63AA22100	A 63	A	22	100	50		19		M10	2708995	○
APHK63BA22100	A 63	B	22	100	58		19		M10	2708994	○
APHK63AA27060	A 63	A	27	60	68		21		M12	2708998	▲
APHK63AA27100	A 63	A	27	100	68		21		M12	2709001	○
APHK63AA32060	A 63	A	32	60	88		24		M16	2709002	▲
APHK63AA32100	A 63	A	32	100	88		24		M16	2709004	○
APHK63AA40060	A 63	A	40	60	98		27		M20	2709006	▲
APHK63CA40060	A 63	C	40	60	98	66.7	27	M12		2709007	▲
APHK63AA40100	A 63	A	40	100	98		27		M20	2705499	○

▲ **Available in stock**

○ **Available upon request**

ADAPTORS - METRIC

HSK A DIN 69893



IC

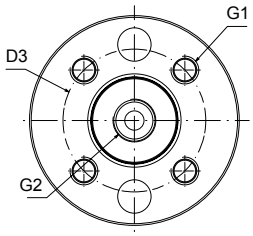
ITEM NUMBER	HSK TAPER DIMENSION	HOLDER SHAPE	d2	H1	D1	D3	H2	G1	G2	ITEM	AVAILABILITY
APHK80AA16060	A80	A	16	60	41		13		M6	2709010	○
APHK80AA16120	A 80	A	16	120	41		13		M6	2709011	○
APHK80AA22060	A 80	A	22	60	50		19		M10	2709012	○
APHK80BA22060	A 80	B	22	60	58		19		M10	2709013	○
APHK80AA22120	A 80	A	22	120	50		19		M10	2709015	○
APHK80BA22120	A 80	B	22	120	58		19		M10	2709014	○
APHK80AA27060	A 80	A	27	60	68		21		M12	2709016	○
APHK80AA27120	A 80	A	27	120	68		21		M12	2709017	○
APHK80AA32060	A 80	A	32	60	88		24		M16	2709019	○
APHK80AA32120	A 80	A	32	120	88		24		M16	2709020	○
APHK80AA40060	A 80	A	40	60	98		27		M20	2709023	○
APHK80CA40060	A 80	C	40	60	98	66.7	27	M12		2709027	○
APHK80AA40120	A 80	A	40	120	98		27		M20	2709026	○
APHK80CA60060	A 80	C	60	60	140	101.6	40	M16		2709028	○
APHK10AA22060	A 100	A	22	60	50		19		M10	2709031	▲
APHK10BA22060	A 100	B	22	60	58		19		M10	2709029	▲
APHK10AA22120	A 100	A	22	120	50		19		M10	2709039	○
APHK10BA22120	A 100	B	22	120	58		19		M10	2709032	○
APHK10AA27060	A 100	A	27	60	68		21		M12	2709043	▲
APHK10AA27120	A 100	A	27	120	68		21		M12	2709046	○
APHK10AA32070	A 100	A	32	70	88		24		M16	2709047	▲
APHK10AA32120	A 100	A	32	120	88		24		M16	2709048	○
APHK10AA40070	A 100	A	40	70	98		27		M20	2709049	▲
APHK10CA40070	A 100	C	40	70	98	66.7	27	M12		2709051	▲
APHK10AA40120	A 100	A	40	120	98		27		M20	2709050	○
APHK10CA60070	A 100	C	60	70	140	101.6	40	M16		2709053	▲

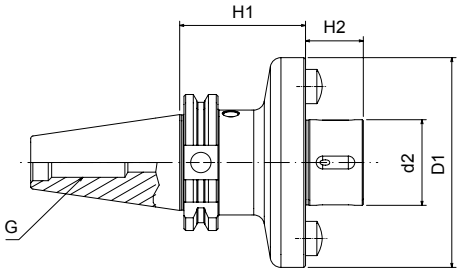
▲ **Available in stock**

○ **Available upon request**

ADAPTORS - METRIC

CAT A/B





IC

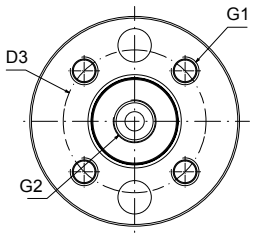
ITEM NUMBER	CAT TAPER DIMENSION	HOLDER SHAPE	d2	H1	D1	D3	H2	G1	G2	ITEM	AVAILABILITY
API740AC22050	40	A	22	50	50		19		M10	2709138	▲
API740BC22050	40	B	22	50	58		19		M10	2709549	▲
API740AC22100	40	A	22	100	50		19		M10	2709548	○
API740BC22100	40	B	22	100	58		19		M10	2709552	○
API740AC27060	40	A	27	60	68		21		M12	2709553	▲
API740AC27100	40	A	27	100	68		21		M12	2709554	○
API740AC32060	40	A	32	60	88		24		M16	4583200	▲
API740AC32100	40	A	32	100	88		24		M16	2709556	○
API740AC40060	40	A	40	60	98		27		M20	2709558	▲
API740CC40060	40	C	40	60	98	66.7	27	M12		2709560	▲
API740AC40100	40	A	40	100	98		27		M20	2708981	○
API740CC40100	40	C	40	100	98	66.7	27	M12		2709561	○
API750AC22060	50	A	22	60	50		19		M10	2709562	○
API750BC22060	50	B	22	60	58		19		M10	2709565	○
API750AC22120	50	A	22	120	50		19		M10	2709563	○
API750BC22120	50	B	22	120	58		19		M10	2709566	○
API750AC27060	50	A	27	60	68		21		M12	2709567	○
API750AC27120	50	A	27	120	68		21		M12	2709570	○
API750AC32070	50	A	32	70	88		24		M16	2709576	▲
API750AC32120	50	A	32	120	88		24		M16	2709577	○
API750AC40070	50	A	40	70	98		27		M20	2709580	○
API750CC40070	50	C	40	70	98	66.7	27	M12		2808977	▲
API750AC40120	50	A	40	120	98		27		M20	2709581	○
API750CC40120	50	C	40	120	98	66.7	27	M12		2709583	○
API750CC60070	50	C	60	70	140	101.6	30	M16		2709584	○
API750CC60120	50	C	60	120	140	101.6	30	M16		2709585	○

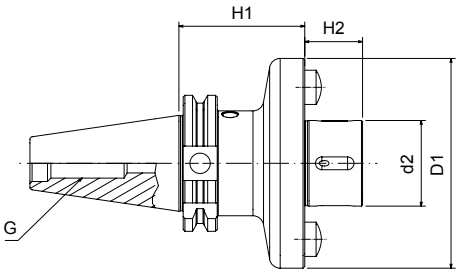
▲ **Available in stock**

○ **Available upon request**

ADAPTORS - METRIC

SK AD/B DIN 69871





IC

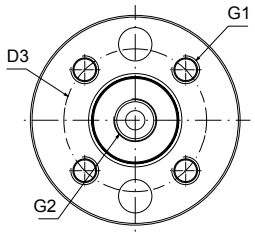
ITEM NUMBER	SK TAPER DIMENSION	HOLDER SHAPE	d2	H1	D1	D3	H2	G1	G2	ITEM	AVAILABILITY
API640AC16050	40	A	16	50	41		13		M6	2709055	▲
API640AC16100	40	A	16	100	41		13		M6	2709057	○
API640AC22050	40	A	22	50	50		19		M10	2709062	▲
API640BC22050	40	B	22	50	58		19		M10	2709059	▲
API640AC22100	40	A	22	100	50		19		M10	2709063	○
API640BC22100	40	B	22	100	58		19		M10	2709066	○
API640AC27060	40	A	27	60	68		21		M12	2709067	▲
API640AC27100	40	A	27	100	68		21		M12	2709068	○
API640AC32060	40	A	32	60	88		24		M16	2709069	▲
API640AC32100	40	A	32	100	88		24		M16	2709070	○
API640AC40060	40	A	40	60	98		27		M20	2709071	▲
API640CC40060	40	C	40	60	98	66.7	27	M12		2709073	▲
API640AC40100	40	A	40	100	98		27		M20	2709072	○
API650AC22060	50	A	22	60	50		19		M10	2709075	○
API650BC22060	50	B	22	60	58		19		M10	2709074	○
API650AC22120	50	A	22	120	50		19		M10	2709079	○
API650BC22120	50	B	22	120	58		19		M10	2709077	○
API650AC27060	50	A	27	60	68		21		M12	2709081	○
API650AC27120	50	A	27	120	68		21		M12	2709082	○
API650AC32070	50	A	32	70	88		24		M16	2709083	○
API650AC32120	50	A	32	120	88		24		M16	2709086	○
API650AC40070	50	A	40	70	98		27		M20	2709088	○
API650CC40070	50	C	40	70	98	66.7	27	M12		2709098	○
API650AC40120	50	A	40	120	98		27		M20	2709089	○
API650CC60070	50	C	60	70	140	101.6	40	M16		2709099	○

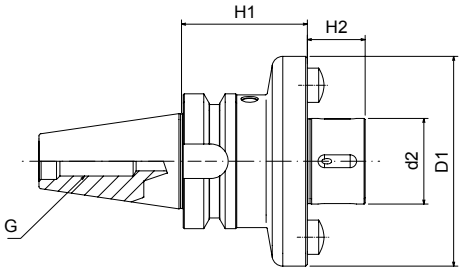
▲ **Available in stock**

○ **Available upon request**

ADAPTORS - METRIC

BT A/B MAS403





ITEM NUMBER	BT TAPER DIMENSION	HOLDER SHAPE	d2	H1	D1	D3	H2	G1	G2	ITEM	AVAILABILITY
API440AC16050	40	A	16	50	41		13		M6	2709100	▲
API440AC16100	40	A	16	100	41		13		M6	2708978	○
API440AC22050	40	A	22	50	50		19		M10	2709106	▲
API440BC22050	40	B	22	50	58		19		M10	2709105	▲
API440AC22100	40	A	22	100	50		19		M10	2709108	○
API440BC22100	40	B	22	100	58		19		M10	2709107	○
API440AC27060	40	A	27	60	68		21		M12	2709114	▲
API440AC27100	40	A	27	100	68		21		M12	2709121	○
API440AC32060	40	A	32	60	88		24		M16	2709126	▲
API440AC32100	40	A	32	100	88		24		M16	2709127	○
API440AC40060	40	A	40	60	98		27		M20	2709128	▲
API440CC40060	40	C	40	60	98	66.7	27	M12		2709133	▲
API440AC40100	40	A	40	100	98		27		M20	2709130	○
API450AC22060	50	A	22	60	50		19		M10	2709135	○
API450BC22060	50	B	22	60	58		19		M10	2709134	○
API450AC22120	50	A	22	120	50		19		M10	2709137	○
API450BC22120	50	B	22	120	58		19		M10	2709136	○
API450AC27060	50	A	27	60	68		21		M12	2709139	○
API450AC27120	50	A	27	120	68		21		M12	2709141	○
API450AC32070	50	A	32	70	88		24		M16	2709143	○
API450AC32120	50	A	32	120	88		24		M16	2709144	○
API450AC40070	50	A	40	70	98		27		M20	2709145	○
API450CC40070	50	C	40	70	98	66.7	27	M12		2709147	○
API450AC40120	50	A	40	120	98		27		M20	2709146	○
API450CC60070	50	C	60	70	140	101.6	40	M16		2709148	○

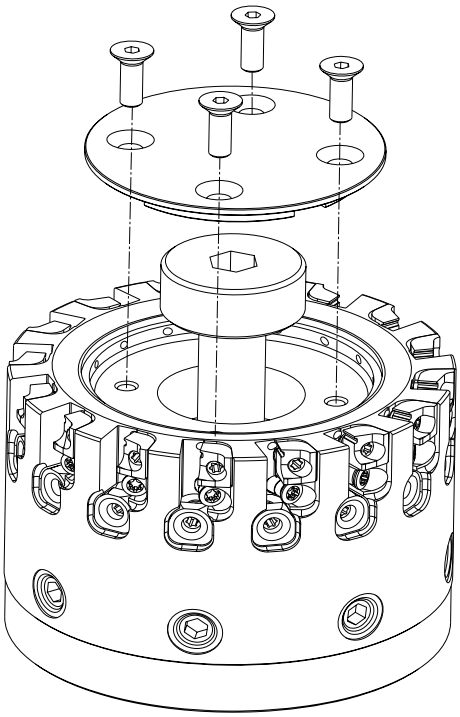
▲ **Available in stock**

○ **Available upon request**

NOTES

TECHNICAL

PCD TEDISFEED - ASSEMBLY PROCEDURE FOR SHELL TYPE



For insert mounting procedures refer to the next page

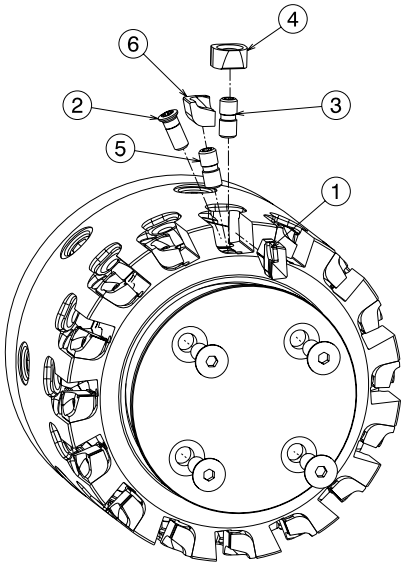
1. Connect the mill holder to the mill body, making sure the holder drivers fit into the cutter's slots.
2. Drive in the screw that comes with the mill. Make sure to use the correct torque value (see table below).
3. Put the cover on its seat and fasten the cover screws.

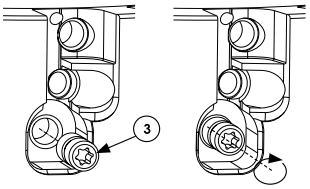
CUTTER DIAMETER	THREAD	TORQUE
ø40	M6	23Nm
ø50÷ø250	M10÷M20	60Nm

To properly use the coolant system on the shell type cutters ø50 and ø63 on TediSFeed's holder, it's necessary to assemble on the cutter the dedicated kit composed of:

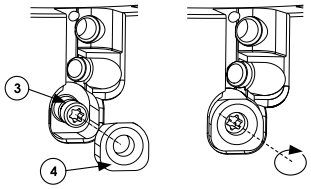
- n°2 pcs. of the item 2717081 (des. RSFTC1012) - included in the box
- n°2 pcs. of the item 4300414 (des. VC01034211015) - included in the box

PCD TEDISFEED - ASSEMBLY PROCEDURE FOR INSERTS

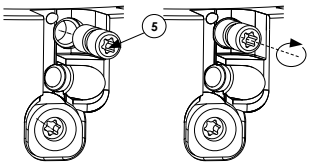




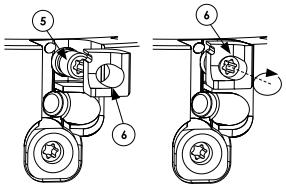
STEP 1 Insert the no. 3 grub screw into its corresponding seat and partially screw it down (1, 2 threads).



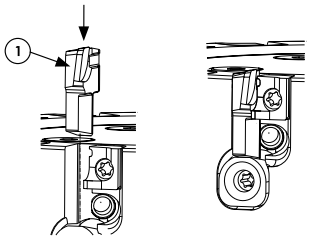
STEP 2 Connect the no. 4 wedge with its corresponding grub screw (no. 3) and screw it until the maximum gap over the cutter body is approximately 1mm.



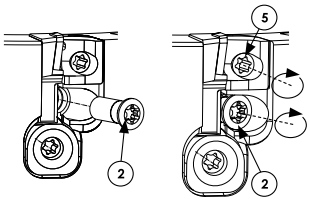
STEP 3 Insert the no. 5 grub screw into its corresponding seat and partially screw it down (1, 2 threads).



STEP 4 Connect the no. 6 wedge with its corresponding grub screw (no. 5) and screw it until the maximum gap over the cutter body is approximately 1mm.



STEP 5 Put the insert no. 1 into its corresponding seat, pushing in the direction of the arrow above the cutter body (see diagram above).
Note: you must enter from the upper portion of the cutter due to the shape of the insert.

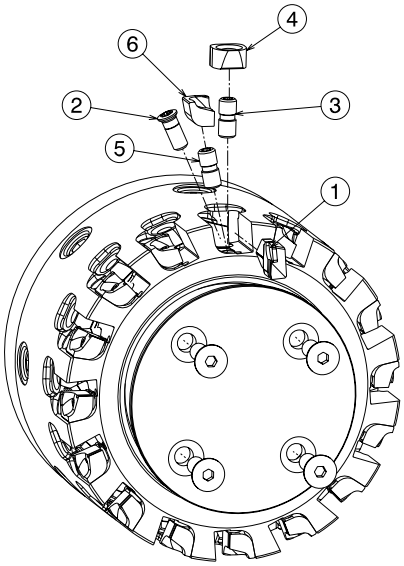


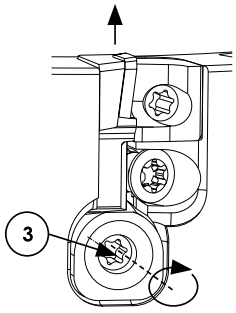
STEP 6 Put the screw no. 2 into its seat and slightly clamp down screw no. 2 and grub screw no. 5.

REPEAT steps 1 through 6 for each cutting edge.

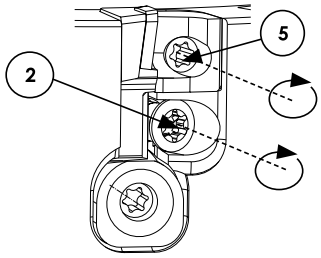
IT.TE.DI. recommends to replace the screw (n°2) every two changes of the insert.

PCD TEDISFEED - SETTING PROCEDURE FOR INSERTS

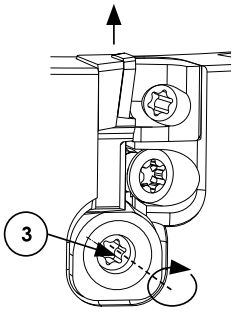




STEP 1 Act on grub screw no. 3, and bring the insert at 0.04÷0.05 from the required axial measurements.



STEP 2 Tighten the clamping screw no. 2 at 1Nm and the grub screw no. 5 at 1.5Nm.

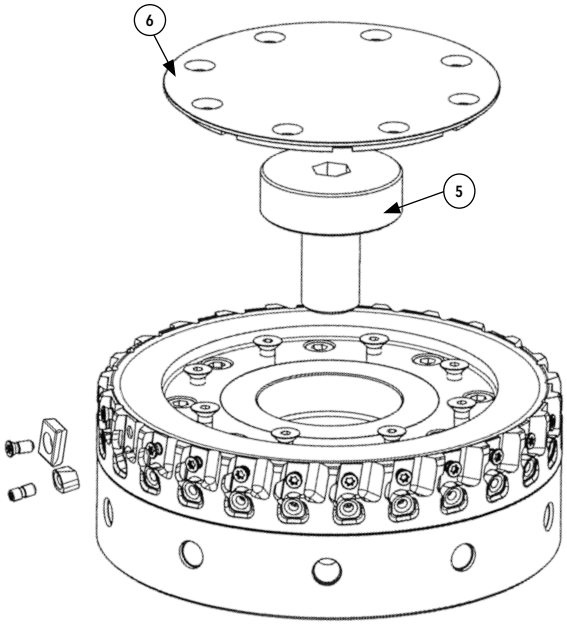


STEP 3 Using the grub screw no. 3, bring the insert to the required axial measurement.

REPEAT the procedure for each insert.

IT.TE.DI. recommends to replace the screw (n°2) every two changes of the insert.

PCD/CBN TEDI FEED - ASSEMBLY PROCEDURE FOR SHELL TYPE



For insert mounting procedures refer to the next page

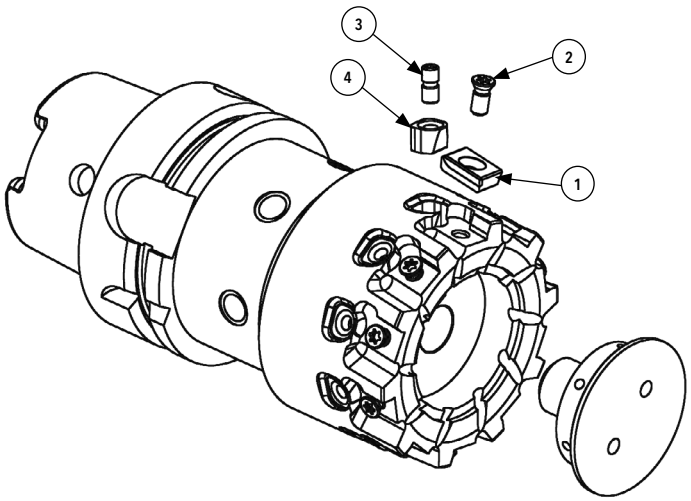
1. Assemble the mill holder with the cutter referring to the drivers;
2. Tighten the clamping screw (5) that you find with the cutter using the right torque (see the label)
3. Put the cover (6) on its seat
4. Tighten the cover's screws

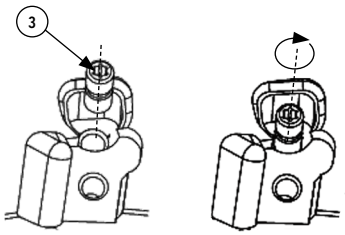
CUTTER DIAMETER	THREAD	TORQUE
ø40	M6	23Nm
ø50÷ø250	M10÷M20	60Nm

To properly use the coolant system on the shell type cutters ø50 and ø63 on TEDIMILL's holder, it's necessary to assemble on the cutter the dedicated kit composed of:

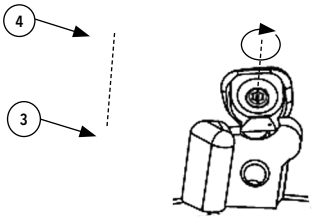
- n°2 pcs. of the item 2717081 (des. RSFTC1012) - included in the box
- n°2 pcs. of the item 4300414 (des. VC01034211015) - included in the box

PCD/CBN TEDI FEED - ASSEMBLY PROCEDURE FOR INSERTS

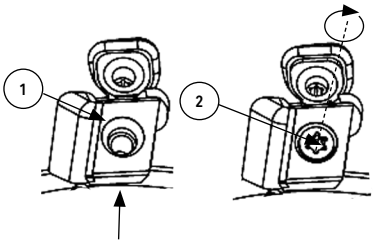




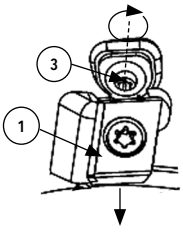
PICTURE A Insert the no. 3 diff screw into its own seat and screw it down partially (1-2 threads).



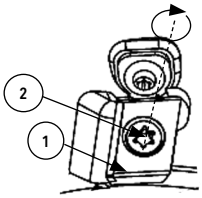
PICTURE B Connect the no. 4 wedge with its own diff screw (no. 3) and screw it until the maximum gap over the cutter body is approximately 1 mm.



PICTURE C Put the insert no. 1 into its own seat pushing as per the arrow in the cutter body. Clamp slightly the clamping screw no. 2.



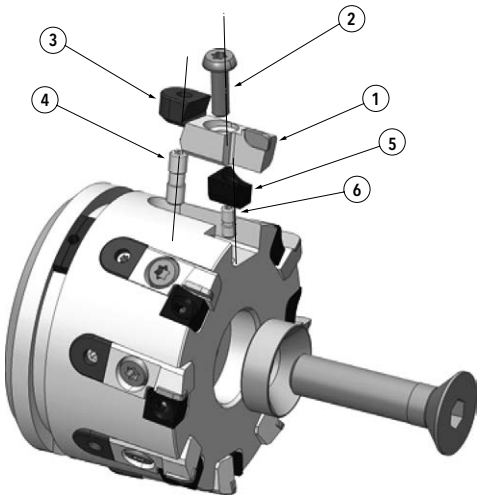
PICTURE D Act on diff screw no. 3 and if needed on clamping screw no. 2 (unscrew little bit) for adjusting axially the height of the insert (no. 1).

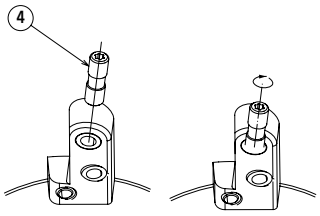


PICTURE E When you reach the axial measure you need, tighten the clamping screw at 4.5Nm (no.2). Repeat the procedure for each insert.

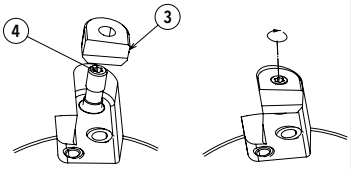
IT.TE.DI. recommends to replace the screw (n°2) every two changes of the insert.

PCD/CBN TEDI MILL - ASSEMBLY PROCEDURE FOR INSERTS

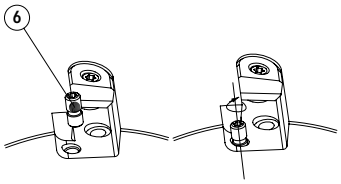




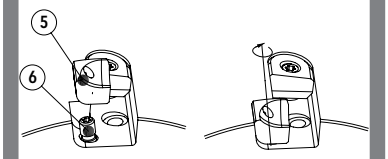
PICTURE A Insert the no. 4 axial adjustment screw into its own seat and screw it down partially (1-2 threads).



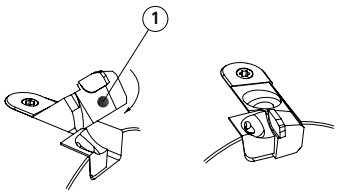
PICTURE B Connect the no. 3 axial adjustment wedge with its own adjustment screw (no. 4) and screw it in until the maximum gap over the cutter body is approximately 1 mm.



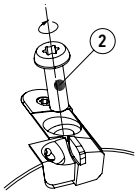
PICTURE C Insert the no. 6 clamp wedge screw into its own seat and screw it down partially (1-2 threads).



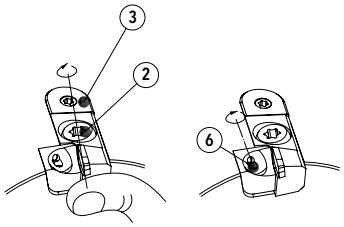
PICTURE D Connect the no. 5 clamp wedge to its own screw (no. 6) and screw it partially.



PICTURE E Insert the cartridge into its own seat.



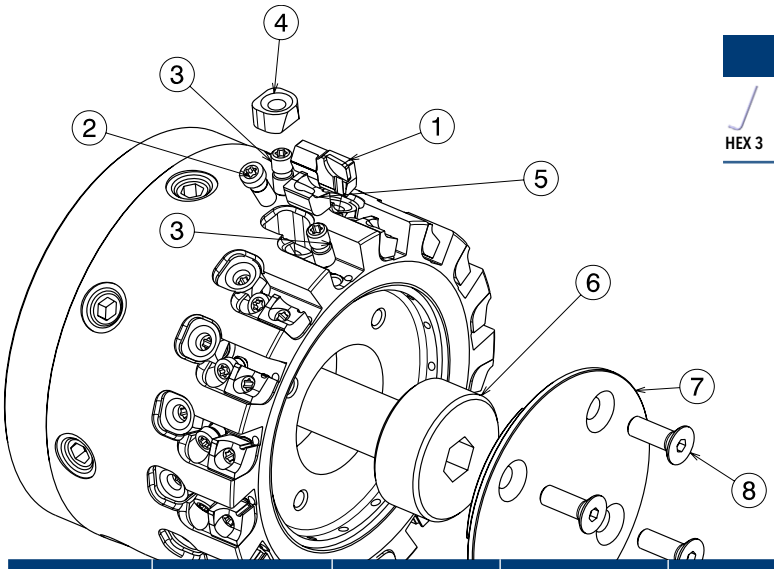
PICTURE F Insert the no. 2 cartridge clamping screw and screw it down partially.



PICTURE G Use your finger to push the cartridge towards the no. 3 wedge and tighten the no. 2 clamping screw. Then you can tighten the no. 6 clamp wedge screw.

IT.TE.DI. recommends to replace the screw (n°2) every two changes of the insert.

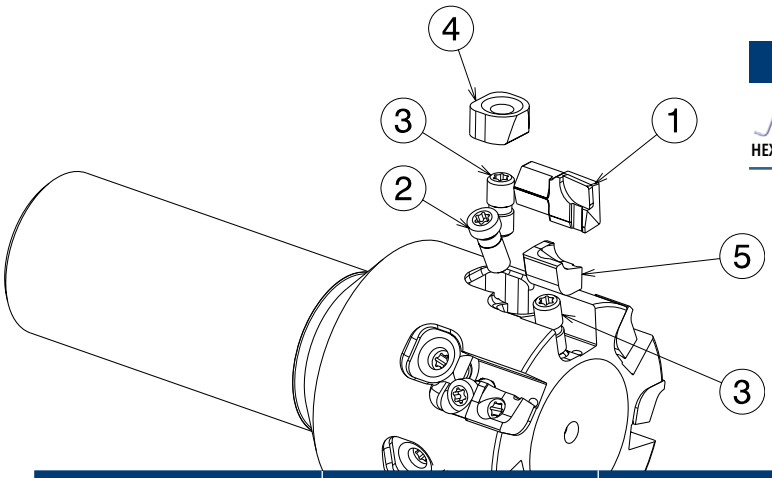
PCD TEDISFEED - SPARE PARTS FOR SHELL TYPE MM



TYPE				ITEM NUMBER	
HEX 3	HEX 2.5	T8	Grease	2750072	Std kit supplied with the cutter

CUTTER DIAMETER	2	3	4	5	6	7	8
50 - Z=10	VX00TEDI35009	RSRGR5M40	RSFTC1009	RSFTA1200	RSFTX-050	-	-
63 - Z=13	VX00TEDI35009	RSRGR5M40	RSFTC1009	RSFTA1200	VC004762I10035F	RSFTS4063M	GC004026I81010
80 - Z=16	VX00TEDI35009	RSRGR5M40	RSFTC1009	RSFTA1200	VC004762I12040	RSFTS4080	GC004026I81010
100 - Z=22	VX00TEDI35009	RSRGR5M40	RSFTC1009	RSFTA1200	VC00TANG16040	RSFTS4100	GC004026I81010
125 - Z=28	VX00TEDI35009	RSRGR5M40	RSFTC1009	RSFTA1200	VC00TEDI20040F	RSFTS4125	GC004026I81010

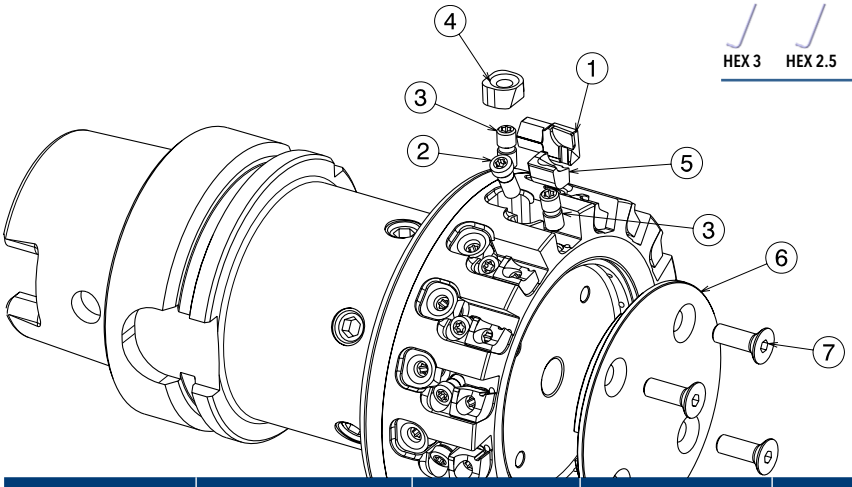
PCD TEDISFEED - SPARE PARTS FOR CYLINDRICAL CUTTERS MM



TYPE				ITEM NUMBER	
HEX 3	HEX 2.5	T8	Grease	2750072	Std kit supplied with the cutter

CUTTER DIAMETER	2	3	4	5
40	VX00TEDI35009	RSRGR5M40	RSFTC1009	RSFTA1200

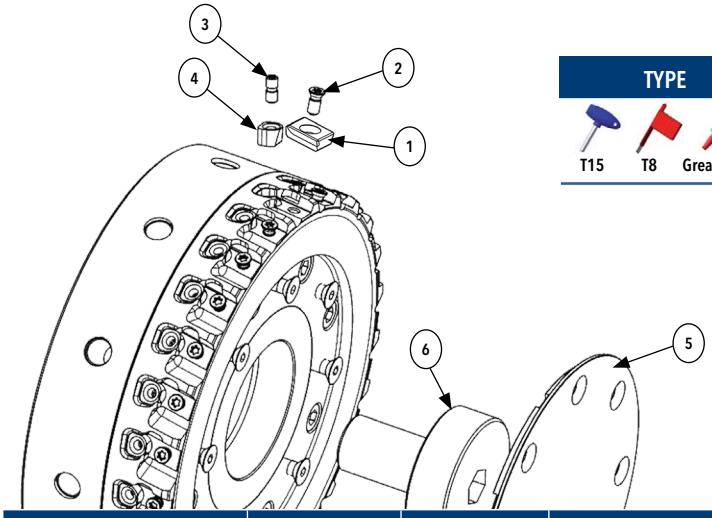
PCD TEDISFEED - SPARE PARTS FOR MONOBLOCK TYPE MM



TYPE	ITEM NUMBER	
HEX 3 · HEX 2.5 · T8 · Grease	2750072	Std kit supplied with the cutter

MILL DIAMETER	2	3	4	5	6	7
63 - Z=13	VX00TEDI35009	RSRGR5M40	RSFTC1009	RSFTA1200	RSFTS4063M	C
80 - Z=16	VX00TEDI35009	RSRGR5M40	RSFTC1009	RSFTA1200	RSFTS4080	GC004026I81010
100 - Z=22	VX00TEDI35009	RSRGR5M40	RSFTC1009	RSFTA1200	RSFTS4100	GC004026I81010

PCD/CBN TEDI FEED - SPARE PARTS - METRIC FOR SHELL CUTTERS

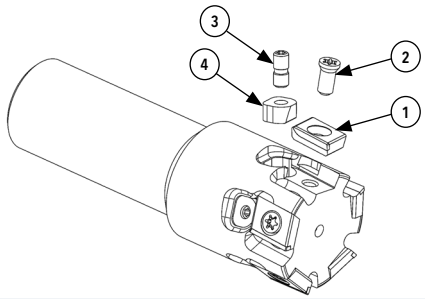


TYPE	ITEM NUMBER	
T15 T8 Grease	2706376	Std keys kit supplied with the cutter

*S=SCRAPER
W=WIPER

PRODUCT CODE	2	3	4*	5	6
TRGSM16D040-06-00	VX040024A	RSRGR5M40	S=RSFTC1009	-	VC004762I06035
TRGSM22D050-08-00	VX040024A	RSRGR5M40	S=RSFTC1008	-	RSFTS4050M
TRGSM22D063-10-00	VX040024A	RSRGR5M40	S=RSFTC1008	RSFTS4063M	VC004762I10035F
TRGSM27D080-12-00	VX040024A	RSRGR5M40	S=RSFTC1008	RSFTS4080	VC00TEDI12040F
TRGSM32D100-16-00	VX040024A	RSRGR5M40	S=RSFTC1008	RSFTS4100	VC00TANG16040F
TRGSM40D125-20-00	VX040024A	RSRGR5M40	S=RSFTC1008	RSFTS4125	VC00TEDI20040F
TRGSM40D125-18-02	VX040024A	RSRGR5M40	S=RSFTC1008 / W=RSFTC1010	RSFTS4125W	VC00TEDI20040F
TRGSM40D160-26-00	VX040024A	RSRGR5M40	S=RSFTC1008	RSFTS4160	4xVC004762I12050
TRGSM40D160-24-02	VX040024A	RSRGR5M40	S=RSFTC1008 / W=RSFTC1010	RSFTS4160W	4xVC004762I12050
TRGSM60D200-30-00	VX040024A	RSRGR5M40	S=RSFTC1008	RSFTS4200	4xVC004762I16060
TRGSM60D200-28-02	VX040024A	RSRGR5M40	S=RSFTC1008 / W=RSFTC1010	RSFTS4200W	4xVC004762I16060
TRGSM60D250-34-00	VX040024A	RSRGR5M40	S=RSFTC1008	RSFTS4250	4xVC004762I16060
TRGSM60D250-32-02	VX040024A	RSRGR5M40	S=RSFTC1008 / W=RSFTC1010	RSFTS4250W	4xVC004762I16060

PCD/CBN TEDI FEED - SPARE PARTS - METRIC FOR CYLINDRICAL CUTTERS

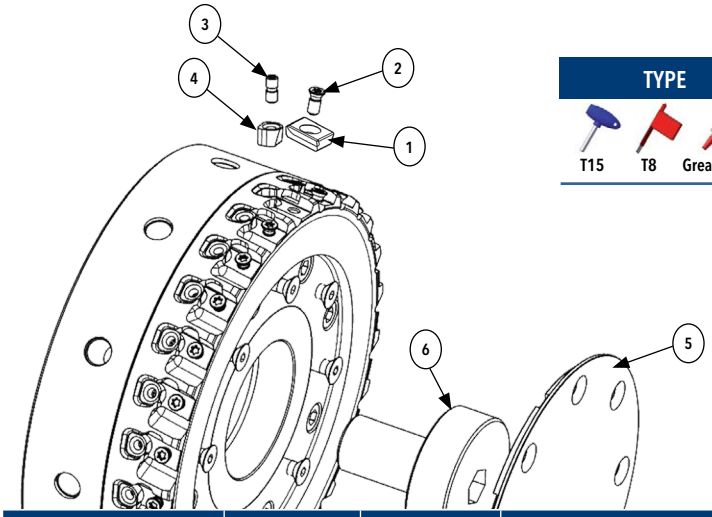


TYPE	ITEM NUMBER	
T15 T8 Grease	2706376	Std keys kit supplied with the cutter

PRODUCT CODE	2	3	4
TRGSC25D025N03-00	VX040024A	-	-
TRGSC25D025-03-00	VX040024A	VX040028A	RSFTC1011
TRGSC25D032-05-00	VX040024A	RSRGR5M40	RSFTC1009

TEDI FEED - SPARE PARTS - INCH

FOR SHELL CUTTERS



TYPE	ITEM NUMBER	
T15 T8 Grease	2706376	Std keys kit supplied with the cutter

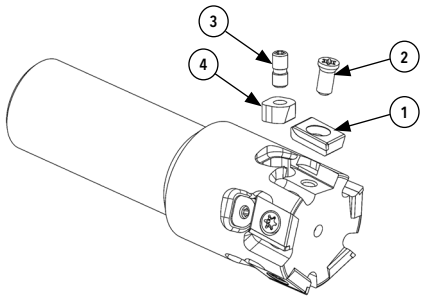
*S=MILLING
W=WIPER

PRODUCT CODE	2	3	4*	5	6
TRGSM16I015-06-00	VX040024A	RSRGR5M40	S=RSFTC1009	-	VC004762I06035
TRGSM22I020-08-00	VX040024A	RSRGR5M40	S=RSFTC1008	-	RSFTS4050M
TRGSM22I025-10-00	VX040024A	RSRGR5M40	S=RSFTC1008	RSFTS4063M	VC004762I10035F
TRGSM27I030-12-00	VX040024A	RSRGR5M40	S=RSFTC1008	RSFTS4080	VC00TEDI12040F
TRGSM32I040-16-00	VX040024A	RSRGR5M40	S=RSFTC1008	RSFTS4100	VC00TANG16040F
TRGSM40I050-20-00	VX040024A	RSRGR5M40	S=RSFTC1008	RSFTS4125	VC00TEDI20040F
TRGSM40I050-18-02	VX040024A	RSRGR5M40	S=RSFTC1008 / W=RSFTC1010	RSFTS4125W	VC00TEDI20040F
TRGSM40I060-24-00	VX040024A	RSRGR5M40	S=RSFTC1008	RSFTS4160	4xVC004762I12050
TRGSM40I060-22-02	VX040024A	RSRGR5M40	S=RSFTC1008 / W=RSFTC1010	RSFTS4160W	4xVC004762I12050
TRGSM60I080-30-00	VX040024A	RSRGR5M40	S=RSFTC1008	RSFTS4200	4xVC004762I16060
TRGSM60I080-28-02	VX040024A	RSRGR5M40	S=RSFTC1008 / W=RSFTC1010	RSFTS4200W	4xVC004762I16060
TRGSM60I100-34-00	VX040024A	RSRGR5M40	S=RSFTC1008	RSFTS4250	4xVC004762I16060
TRGSM60I100-32-02	VX040024A	RSRGR5M40	S=RSFTC1008 / W=RSFTC1010	RSFTS4250W	4xVC004762I16060

PCD/CBN

TEDI FEED - SPARE PARTS - INCH

FOR CYLINDRICAL CUTTERS

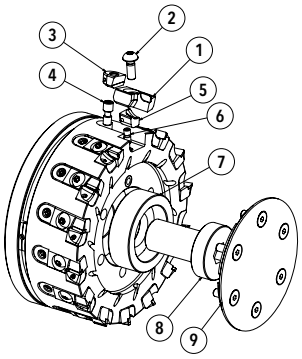


TYPE	ITEM NUMBER	
T15 T8 Grease	2706376	Std keys kit supplied with the cutter

PRODUCT CODE	2	3	4
TRGSC01I010N03-00	VX040024A	-	-
TRGSC01I010-03-00	VX040024A	VX040028A	RSFTC1011
TRGSC01I012-05-00	VX040024A	RSRGR5M40	RSFTC1009

TEDI MILL - SPARE PARTS

FOR SHELL CUTTERS

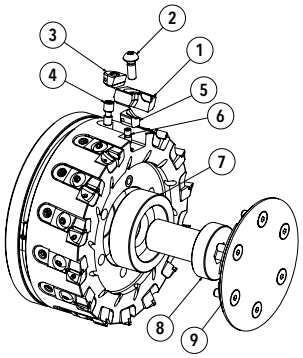


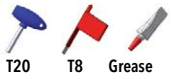
TYPE	ITEM NUMBER	
 T20 T8 Grease	4360818	Std keys kit supplied with the cutter
 T 20	4361287	Torque key upon request

ITEM NUMBER	2	3	4	5	6	7	8	9
FTP040R030S	VX050006A	RSFTC3000	RSRGR6M50	RSFTA1000	RSRGR5M40		VC004762I06035	
FTP050R040A	VX050006A	RSFTC3000	RSRGR6M50	RSFTA1000	RSRGR5M40		VC00TEDI10040	
FTP050R050S	VX050006A	RSFTC3000	RSRGR6M50	RSFTA1000	RSRGR5M40		VC00TEDI10040	
FTP063R030A	VX050006A	RSFTC3000	RSRGR6M50	RSFTA1000	RSRGR5M40		VC004762I10040	
FTP063R050A	VX050006A	RSFTC3000	RSRGR6M50	RSFTA1000	RSRGR5M40		VC004762I10040	
FTP063R060A	VX050006A	RSFTC3000	RSRGR6M50	RSFTA1000	RSRGR5M40		VC004762I10040	
FTP080R050A	VX050006A	RSFTC3000	RSRGR6M50	RSFTA1000	RSRGR5M40	RSBF4080	VC00TEDI12040	
FTP080R060A	VX050006A	RSFTC3000	RSRGR6M50	RSFTA1000	RSRGR5M40	RSBF4080	VC00TEDI12040	
FTP080R080A	VX050006A	RSFTC3000	RSRGR6M50	RSFTA1000	RSRGR5M40	RSBF4080	VC00TEDI12040	
FTP080R100T	VX050006A	RSFTC3000	RSRGR6M50	RSFTA1000	RSRGR5M40	RSBF4080	VC00TEDI12040F	RSFPT3080
FTP100R060A	VX050006A	RSFTC3000	RSRGR6M50	RSFTA1000	RSRGR5M40	RSBF4100	VC00TEDI16040	
FTP100R080A	VX050006A	RSFTC3000	RSRGR6M50	RSFTA1000	RSRGR5M40	RSBF4100	VC00TEDI16040	
FTP100R100A	VX050006A	RSFTC3000	RSRGR6M50	RSFTA1000	RSRGR5M40	RSBF4100	VC00TEDI16040	
FTP100R120T	VX050006A	RSFTC3000	RSRGR6M50	RSFTA1000	RSRGR5M40	RSBF4100	VC00TEDI16040F	RSFPT1100
FTP125R080A	VX050006A	RSFTC3000	RSRGR6M50	RSFTA1000	RSRGR5M40	RSBF4125	VC00TEDI20040F	RSFPT1125
FTP125R100A	VX050006A	RSFTC3000	RSRGR6M50	RSFTA1000	RSRGR5M40	RSBF4125	VC00TEDI20040F	RSFPT1125
FTP125R120A	VX050006A	RSFTC3000	RSRGR6M50	RSFTA1000	RSRGR5M40	RSBF4125	VC00TEDI20040F	RSFPT1125
FTP125R140A	VX050006A	RSFTC3000	RSRGR6M50	RSFTA1000	RSRGR5M40	RSBF4125	VC00TEDI20040F	RSFPT1125
FTP125R160T	VX050006A	RSFTC3000	RSRGR6M50	RSFTA1000	RSRGR5M40	RSBF4125	VC00TEDI20040F	RSFPT1125
FTP160R100A	VX050006A	RSFTC3000	RSRGR6M50	RSFTA1000	RSRGR5M40		VC004762I12050	RSFPT1160
FTP160R140A	VX050006A	RSFTC3000	RSRGR6M50	RSFTA1000	RSRGR5M40		VC004762I12050	RSFPT1160
FTP160R180A	VX050006A	RSFTC3000	RSRGR6M50	RSFTA1000	RSRGR5M40		VC004762I12050	RSFPT1160
FTP200R120A	VX050006A	RSFTC3000	RSRGR6M50	RSFTA1000	RSRGR5M40		VC004762I16050	RSFPT1200
FTP200R160A	VX050006A	RSFTC3000	RSRGR6M50	RSFTA1000	RSRGR5M40		VC004762I16050	RSFPT1200
FTP200R240A	VX050006A	RSFTC3000	RSRGR6M50	RSFTA1000	RSRGR5M40		VC004762I16050	RSFPT1200

TEDI MILL - SPARE PARTS

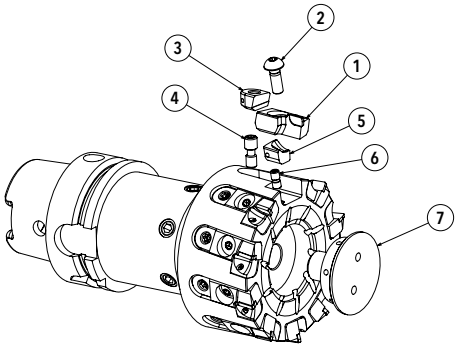
FOR SHELL CUTTERS



TYPE	ITEM NUMBER	
 T20 T8 Grease	4360818	Std keys kit supplied with the cutter
 T20	4361287	Torque key upon request

ITEM NUMBER	2	3	4	5	6	7	8	9
FTP250R160A	VX050006A	RSFTC3000	RSRGR6M50	RSFTA1000	RSRGR5M40		VC004762I16050	RSFPT1200
FTP250R200A	VX050006A	RSFTC3000	RSRGR6M50	RSFTA1000	RSRGR5M40		VC004762I16050	RSFPT1200
FTP250R300A	VX050006A	RSFTC3000	RSRGR6M50	RSFTA1000	RSRGR5M40		VC004762I16050	RSFPT1200
FTP315R180A	VX050006A	RSFTC3000	RSRGR6M50	RSFTA1000	RSRGR5M40		VC004762I20050	RSFPT1315
FTP315R240A	VX050006A	RSFTC3000	RSRGR6M50	RSFTA1000	RSRGR5M40		VC004762I20050	RSFPT1315
FTP315R380A	VX050006A	RSFTC3000	RSRGR6M50	RSFTA1000	RSRGR5M40		VC004762I20050	RSFPT1315
FTP400R260A	VX050006A	RSFTC3000	RSRGR6M50	RSFTA1000	RSRGR5M40		VC004762I20050	RSFPT1315
FTP400R500A	VX050006A	RSFTC3000	RSRGR6M50	RSFTA1000	RSRGR5M40		VC004762I20050	RSFPT1315
FIP020R040A	VX050006A	RSFTC3000	RSRGR6M50	RSFTA1000	RSRGR5M40		VC00TEDI10040	
FIP020R050S	VX050006A	RSFTC3000	RSRGR6M50	RSFTA1000	RSRGR5M40		VC00TEDI10040	
FIP025R050A	VX050006A	RSFTC3000	RSRGR6M50	RSFTA1000	RSRGR5M40		VC004762I10040	
FIP025R060A	VX050006A	RSFTC3000	RSRGR6M50	RSFTA1000	RSRGR5M40		VC004762I10040	
FIP030R050A	VX050006A	RSFTC3000	RSRGR6M50	RSFTA1000	RSRGR5M40	RSBF4080	VC00TEDI12040	
FIP030R060A	VX050006A	RSFTC3000	RSRGR6M50	RSFTA1000	RSRGR5M40	RSBF4080	VC00TEDI12040	
FIP030R080A	VX050006A	RSFTC3000	RSRGR6M50	RSFTA1000	RSRGR5M40	RSBF4080	VC00TEDI12040	
FIP040R080A	VX050006A	RSFTC3000	RSRGR6M50	RSFTA1000	RSRGR5M40	RSBF4100	VC00TEDI16040	
FIP040R120T	VX050006A	RSFTC3000	RSRGR6M50	RSFTA1000	RSRGR5M40	RSBF4100	VC00TEDI16040	RSFPT1100
FIP050R100A	VX050006A	RSFTC3000	RSRGR6M50	RSFTA1000	RSRGR5M40	RSBF4125	VC00TEDI20040F	RSFPT1125
FIP050R160T	VX050006A	RSFTC3000	RSRGR6M50	RSFTA1000	RSRGR5M40	RSBF4125	VC00TEDI20040F	RSFPT1125
FIP060R100A	VX050006A	RSFTC3000	RSRGR6M50	RSFTA1000	RSRGR5M40		VC004762I12050	RSFPT1160
FIP060R180A	VX050006A	RSFTC3000	RSRGR6M50	RSFTA1000	RSRGR5M40		VC004762I12050	RSFPT1160
FIP080R120A	VX050006A	RSFTC3000	RSRGR6M50	RSFTA1000	RSRGR5M40		VC004762I16050	RSFPT1200
FIP080R240A	VX050006A	RSFTC3000	RSRGR6M50	RSFTA1000	RSRGR5M40		VC004762I16050	RSFPT1200
FIP100R160A	VX050006A	RSFTC3000	RSRGR6M50	RSFTA1000	RSRGR5M40		VC004762I16050	RSFPT1200
FIP100R300A	VX050006A	RSFTC3000	RSRGR6M50	RSFTA1000	RSRGR5M40		VC004762I16050	RSFPT1200

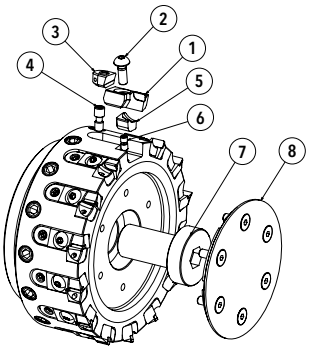
PCD TEDI MILL - SPARE PARTS FOR INTEGRAL TYPE CUTTERS



TYPE	ITEM NUMBER	
 T20 T8 Grease	4360818	Std keys kit supplied with the cutter
 T 20	4361287	Torque key upon request

ITEM NUMBER	TAPER DIMENSION	2	3	4	5	6	7
THA50040125P030	HSK-A 50	VX050006A	RSFTC3000	RSRGR6M50	RSFTA1000	RSRGR5M40	
THA50050125P050	HSK-A 50	VX050006A	RSFTC3000	RSRGR6M50	RSFTA1000	RSRGR5M40	RSFPT1050
THA50063125P070	HSK-A 50	VX050006A	RSFTC3000	RSRGR6M50	RSFTA1000	RSRGR5M40	RSFPT1063
THA63040125P030	HSK-A63	VX050006A	RSFTC3000	RSRGR6M50	RSFTA1000	RSRGR5M40	
THA63050125P050	HSK-A63	VX050006A	RSFTC3000	RSRGR6M50	RSFTA1000	RSRGR5M40	RSFPT1050
THA63063125P070	HSK-A63	VX050006A	RSFTC3000	RSRGR6M50	RSFTA1000	RSRGR5M40	RSFPT1063
THA63080125P100	HSK-A63	VX050006A	RSFTC3000	RSRGR6M50	RSFTA1000	RSRGR5M40	RSFPT1080
THA63100125P120	HSK-A63	VX050006A	RSFTC3000	RSRGR6M50	RSFTA1000	RSRGR5M40	RSFPT1100
THA10080125P100	HSK-A100	VX050006A	RSFTC3000	RSRGR6M50	RSFTA1000	RSRGR5M40	RSFPT1080
THA10100125P120	HSK-A100	VX050006A	RSFTC3000	RSRGR6M50	RSFTA1000	RSRGR5M40	RSFPT1100
THA10125125P160	HSK-A100	VX050006A	RSFTC3000	RSRGR6M50	RSFTA1000	RSRGR5M40	RSFPT1125
TCC40016125P030	CAT 40	VX050006A	RSFTC3000	RSRGR6M50	RSFTA1000	RSRGR5M40	
TCC40020125P050	CAT 40	VX050006A	RSFTC3000	RSRGR6M50	RSFTA1000	RSRGR5M40	RSFPT1050
TCC40025125P070	CAT 40	VX050006A	RSFTC3000	RSRGR6M50	RSFTA1000	RSRGR5M40	RSFPT1063
TCC40030125P100	CAT 40	VX050006A	RSFTC3000	RSRGR6M50	RSFTA1000	RSRGR5M40	RSFPT1080
TBC40040125P030	BT40	VX050006A	RSFTC3000	RSRGR6M50	RSFTA1000	RSRGR5M40	
TBC40050125P050	BT40	VX050006A	RSFTC3000	RSRGR6M50	RSFTA1000	RSRGR5M40	RSFPT1050
TBC40063125P070	BT40	VX050006A	RSFTC3000	RSRGR6M50	RSFTA1000	RSRGR5M40	RSFPT1063
TBC40080125P100	BT40	VX050006A	RSFTC3000	RSRGR6M50	RSFTA1000	RSRGR5M40	RSFPT1080

CBN TEDI MILL - SPARE PARTS FOR SHELL CUTTERS

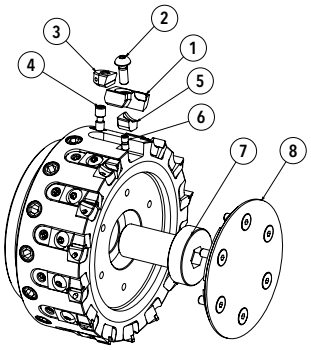


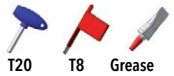
TYPE	ITEM NUMBER	
 T20 T8 Grease	4360818	Std keys kit supplied with the cutter
 T 20	4361287	Torque key upon request

ITEM NUMBER	2	3	4	5	6	7	8
FTC050R040S	VX050006A	RSFTC3000	RSRGR6M50	RSFTA3000	RSRGR5M40	VC00TEDI10035	
FTC063R060S	VX050006A	RSFTC3000	RSRGR6M50	RSFTA3000	RSRGR5M40	VC004762I10035	
FTC080R080S	VX050006A	RSFTC3000	RSRGR6M50	RSFTA3000	RSRGR5M40	VC00TEDI12040	
FTC080R100S	VX050006A	RSFTC3000	RSRGR6M50	RSFTA3000	RSRGR5M40	VC00TEDI12040	
FTC100R080S	VX050006A	RSFTC3000	RSRGR6M50	RSFTA3000	RSRGR5M40	VC00TEDI16040	
FTC100R120S	VX050006A	RSFTC3000	RSRGR6M50	RSFTA3000	RSRGR5M40	VC00TEDI16040	
FTC125R100S	VX050006A	RSFTC3000	RSRGR6M50	RSFTA3000	RSRGR5M40	VC00TEDI20040	RSFPT2125
FTC125R140S	VX050006A	RSFTC3000	RSRGR6M50	RSFTA3000	RSRGR5M40	VC00TEDI20040	RSFPT2125
FTC125R160S	VX050006A	RSFTC3000	RSRGR6M50	RSFTA3000	RSRGR5M40	VC00TEDI20040	RSFPT2125
FTC160R140S	VX050006A	RSFTC3000	RSRGR6M50	RSFTA3000	RSRGR5M40	VC004762I12050	RSFPT2160
FTC160R180S	VX050006A	RSFTC3000	RSRGR6M50	RSFTA3000	RSRGR5M40	VC004762I12050	RSFPT2160
FTC200R160S	VX050006A	RSFTC3000	RSRGR6M50	RSFTA3000	RSRGR5M40	VC004762I16050	RSFPT2200
FTC200R240S	VX050006A	RSFTC3000	RSRGR6M50	RSFTA3000	RSRGR5M40	VC004762I16050	RSFPT2200

CONTINUE ON NEXT PAGE.

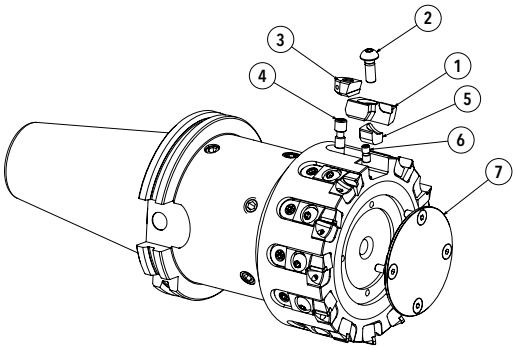
CBN TEDI MILL - SPARE PARTS FOR SHELL CUTTERS



TYPE	ITEM NUMBER	
 T20 T8 Grease	4360818	Std keys kit supplied with the cutter
 T 20	4361287	Torque key upon request

ITEM NUMBER	2	3	4	5	6	7	8
FIC020R040S	VX050006A	RSFTC3000	RSRGR6M50	RSFTA3000	RSRGR5M40	VC00TEDI10035	
FIC020R050S	VX050006A	RSFTC3000	RSRGR6M50	RSFTA3000	RSRGR5M40	VC00TEDI10035	
FIC025R050S	VX050006A	RSFTC3000	RSRGR6M50	RSFTA3000	RSRGR5M40	VC004762I10035	
FIC025R060S	VX050006A	RSFTC3000	RSRGR6M50	RSFTA3000	RSRGR5M40	VC004762I10035	
FIC030R050S	VX050006A	RSFTC3000	RSRGR6M50	RSFTA3000	RSRGR5M40	VC00TEDI12040	
FIC030R060S	VX050006A	RSFTC3000	RSRGR6M50	RSFTA3000	RSRGR5M40	VC00TEDI12040	
FIC030R080S	VX050006A	RSFTC3000	RSRGR6M50	RSFTA3000	RSRGR5M40	VC00TEDI12040	
FIC040R080S	VX050006A	RSFTC3000	RSRGR6M50	RSFTA3000	RSRGR5M40	VC00TEDI16040	
FIC040R120S	VX050006A	RSFTC3000	RSRGR6M50	RSFTA3000	RSRGR5M40	VC00TEDI16040	
FIC050R100S	VX050006A	RSFTC3000	RSRGR6M50	RSFTA3000	RSRGR5M40	VC00TEDI20040	RSFPT2125
FIC050R160S	VX050006A	RSFTC3000	RSRGR6M50	RSFTA3000	RSRGR5M40	VC00TEDI20040	RSFPT2125
FIC060R100S	VX050006A	RSFTC3000	RSRGR6M50	RSFTA3000	RSRGR5M40	VC004762I12050	RSFPT2160
FIC060R180S	VX050006A	RSFTC3000	RSRGR6M50	RSFTA3000	RSRGR5M40	VC004762I12050	RSFPT2160
FIC080R120S	VX050006A	RSFTC3000	RSRGR6M50	RSFTA3000	RSRGR5M40	VC004762I16050	RSFPT2200
FIC080R240S	VX050006A	RSFTC3000	RSRGR6M50	RSFTA3000	RSRGR5M40	VC004762I16050	RSFPT2200
FIC100R160S	VX050006A	RSFTC3000	RSRGR6M50	RSFTA3000	RSRGR5M40	VC004762I16050	RSFPT2200
FIC100R300S	VX050006A	RSFTC3000	RSRGR6M50	RSFTA3000	RSRGR5M40	VC004762I16050	RSFPT2200

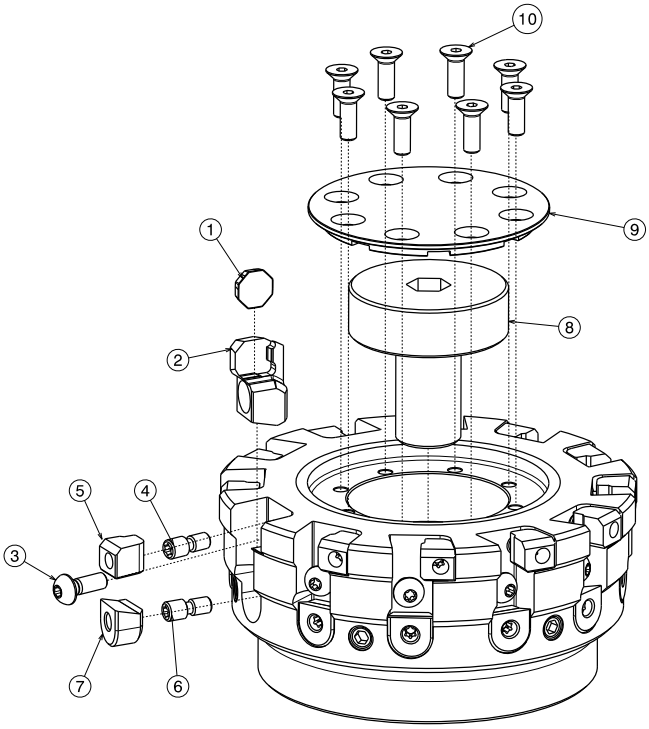
CBN TEDI MILL - SPARE PARTS FOR INTEGRAL TYPE CUTTERS



TYPE	ITEM NUMBER	
 T20 T8 Grease	4360818	Std keys kit supplied with the cutter
 T 20	4361287	Torque key upon request

ITEM NUMBER	TAPER DIMENSION	2	3	4	5	6	7
THA63040125C030	HSK-A 63	VX050006A	RSFTC3000	RSRGR6M50	RSFTA3000	RSRGR5M40	
THA63050125C050	HSK-A 63	VX050006A	RSFTC3000	RSRGR6M50	RSFTA3000	RSRGR5M40	RSFPT2050
THA63063125C070	HSK-A 63	VX050006A	RSFTC3000	RSRGR6M50	RSFTA3000	RSRGR5M40	RSFPT2063
THA63080125C100	HSK-A 63	VX050006A	RSFTC3000	RSRGR6M50	RSFTA3000	RSRGR5M40	RSFPT2080
THA10040125C030	HSK-A 100	VX050006A	RSFTC3000	RSRGR6M50	RSFTA3000	RSRGR5M40	
THA10050125C050	HSK-A 100	VX050006A	RSFTC3000	RSRGR6M50	RSFTA3000	RSRGR5M40	RSFPT2050
THA10063125C060	HSK-A 100	VX050006A	RSFTC3000	RSRGR6M50	RSFTA3000	RSRGR5M40	RSFPT2063
THA10080125C100	HSK-A 100	VX050006A	RSFTC3000	RSRGR6M50	RSFTA3000	RSRGR5M40	RSFPT2080
THA10100125C120	HSK-A 100	VX050006A	RSFTC3000	RSRGR6M50	RSFTA3000	RSRGR5M40	RSFPT2100
THA10125125C160	HSK-A 100	VX050006A	RSFTC3000	RSRGR6M50	RSFTA3000	RSRGR5M40	RSFPT2125
TCC40016125C030	CAT 40	VX050006A	RSFTC3000	RSRGR6M50	RSFTA3000	RSRGR5M40	
TCC40020125C050	CAT 40	VX050006A	RSFTC3000	RSRGR6M50	RSFTA3000	RSRGR5M40	RSFPT2050
TCC40025125C070	CAT 40	VX050006A	RSFTC3000	RSRGR6M50	RSFTA3000	RSRGR5M40	RSFPT2063
TCC40030125C100	CAT 40	VX050006A	RSFTC3000	RSRGR6M50	RSFTA3000	RSRGR5M40	RSFPT2080
TCC50016125C030	CAT 50	VX050006A	RSFTC3000	RSRGR6M50	RSFTA3000	RSRGR5M40	
TCC50020125C050	CAT 50	VX050006A	RSFTC3000	RSRGR6M50	RSFTA3000	RSRGR5M40	RSFPT2050
TCC50025125C070	CAT 50	VX050006A	RSFTC3000	RSRGR6M50	RSFTA3000	RSRGR5M40	RSFPT2063
TCC50030125C100	CAT 50	VX050006A	RSFTC3000	RSRGR6M50	RSFTA3000	RSRGR5M40	RSFPT2080
TCC50040125C120	CAT 50	VX050006A	RSFTC3000	RSRGR6M50	RSFTA3000	RSRGR5M40	RSFPT2100
TCC50050125C160	CAT 50	VX050006A	RSFTC3000	RSRGR6M50	RSFTA3000	RSRGR5M40	RSFPT2125
TBC40040125C030	BT 40	VX050006A	RSFTC3000	RSRGR6M50	RSFTA3000	RSRGR5M40	
TBC40050125C050	BT 40	VX050006A	RSFTC3000	RSRGR6M50	RSFTA3000	RSRGR5M40	RSFPT2050
TBC40063125C070	BT 40	VX050006A	RSFTC3000	RSRGR6M50	RSFTA3000	RSRGR5M40	RSFPT2063
TBC40080125C100	BT 40	VX050006A	RSFTC3000	RSRGR6M50	RSFTA3000	RSRGR5M40	RSFPT2080
TBC50040125C030	BT 50	VX050006A	RSFTC3000	RSRGR6M50	RSFTA3000	RSRGR5M40	
TBC50050125C050	BT 50	VX050006A	RSFTC3000	RSRGR6M50	RSFTA3000	RSRGR5M40	RSFPT2050
TBC50063125C060	BT 50	VX050006A	RSFTC3000	RSRGR6M50	RSFTA3000	RSRGR5M40	RSFPT2063
TBC50080125C100	BT 50	VX050006A	RSFTC3000	RSRGR6M50	RSFTA3000	RSRGR5M40	RSFPT2080
TBC50100125C120	BT 50	VX050006A	RSFTC3000	RSRGR6M50	RSFTA3000	RSRGR5M40	RSFPT2100
TBC50125125C160	BT 50	VX050006A	RSFTC3000	RSRGR6M50	RSFTA3000	RSRGR5M40	RSFPT2125

CBN TEDI OCTO CUT - ASSEMBLY PROCEDURE

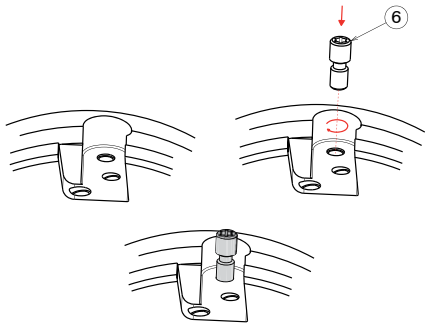


REMARK: see next page for insert and cartridge mounting procedures

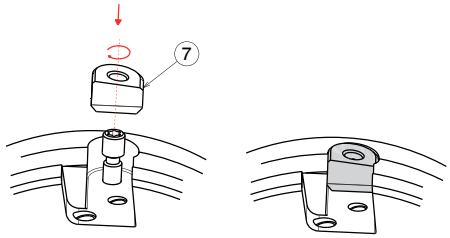
1. **Connect the mill holder to the mill body making sure the drivers of the holder fit into the cutter's slots;**
2. **Drive in the screw (8) that comes with the mill, making sure you use the right torque value (see table);**
3. **Put the cover(9) on its seat;**
4. **Fasten the cover screws (10)**

CUTTER DIAMETER	THREAD	TORQUE
ø125	M20	70Nm
ø160÷ø315	4x M12	60Nm

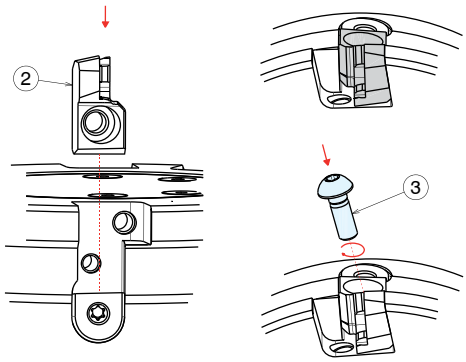
CBN TEDI OCTO CUT - ASSEMBLY PROCEDURE



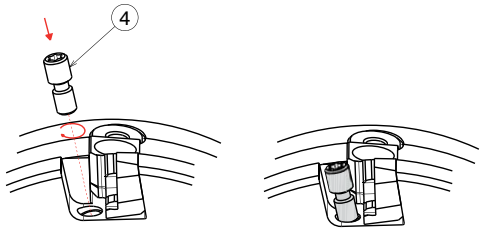
Picture A
Insert the grub screw #6 into its own seat and screw it down partially (1 or 2 threads).



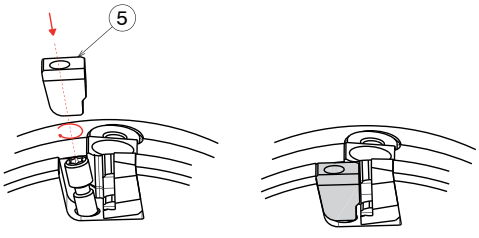
Picture B
Connect the wedge #7 with its own grub screw (#6) and screw it until the maximum gap over the cutter body is approximately 1mm.



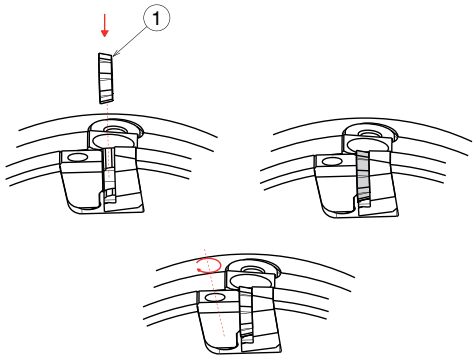
Picture C
Put the cartridge #2 into its own seat from the upper part of the mill pushing as per the arrow. Clamp the screw #3 at 6Nm, remembering to use the grease in the thread.



Picture D
Insert the grub screw #4 into its own seat and screw it down partially (1 or 2 threads).

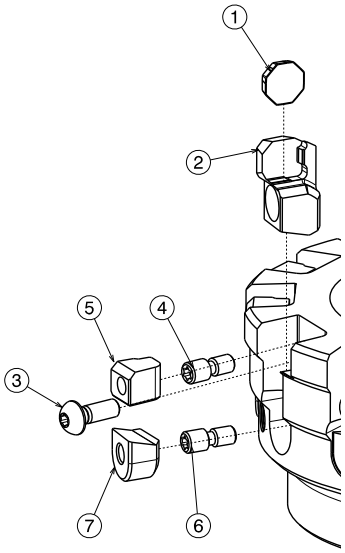


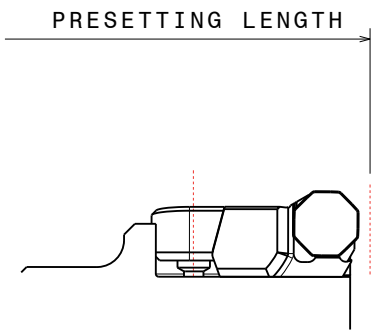
Picture E
Connect the wedge #5 with its own grub screw (#4) and screw it leaving the space for the insert.



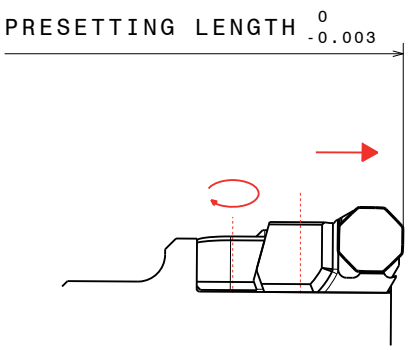
Picture F
Put the insert on its seat and tighten the wedge. Repeat the procedure for each pocket indifferently for scraper or wiper insert.

CBN TEDI OCTO CUT - SETTING PROCEDURE

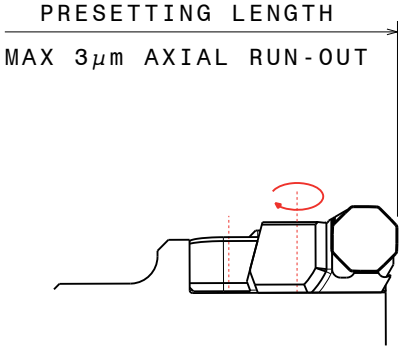




Picture A
Check the height of the cartridges, the insert should stay under the presetting length.

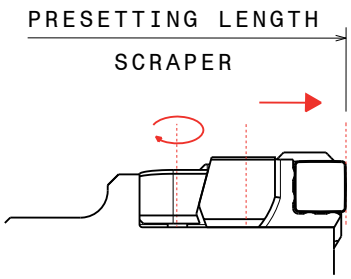


Picture B
Act the grub screw #6 and move the cartridge till the insert is about 3 µm from the final measure.

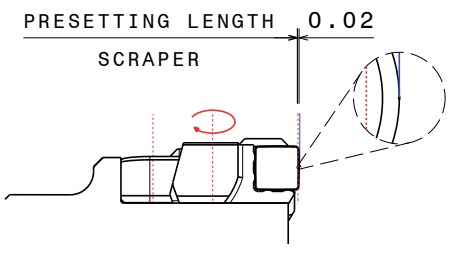


Picture C
Tighten the screw #3 at 12Nm, check again the presetting length; if needed, act on grubscrew #6 to keep the axial run-out in tolerance. Repeat the procedure for all the cartridges.

WIPER INSERTS

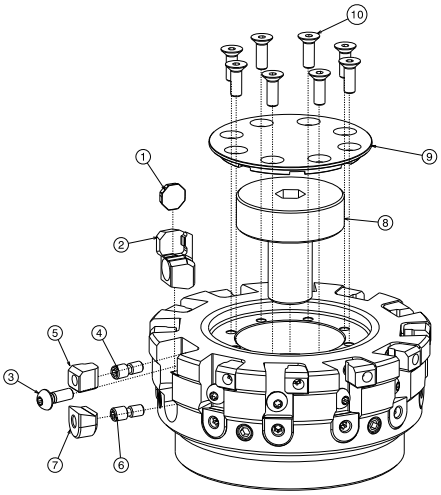


Picture D
Act the grub screw #6 and move the cartridge till the insert is about 3 µm from the final measure (+0.02 mm respect the presetting scraper length).



Picture E
Tighten the screw #3 at 12Nm, check again the height; if needed, act on grubscrew #6 to keep the axial run-out in tolerance.
Repeat the procedure for all the wiper's cartridges.

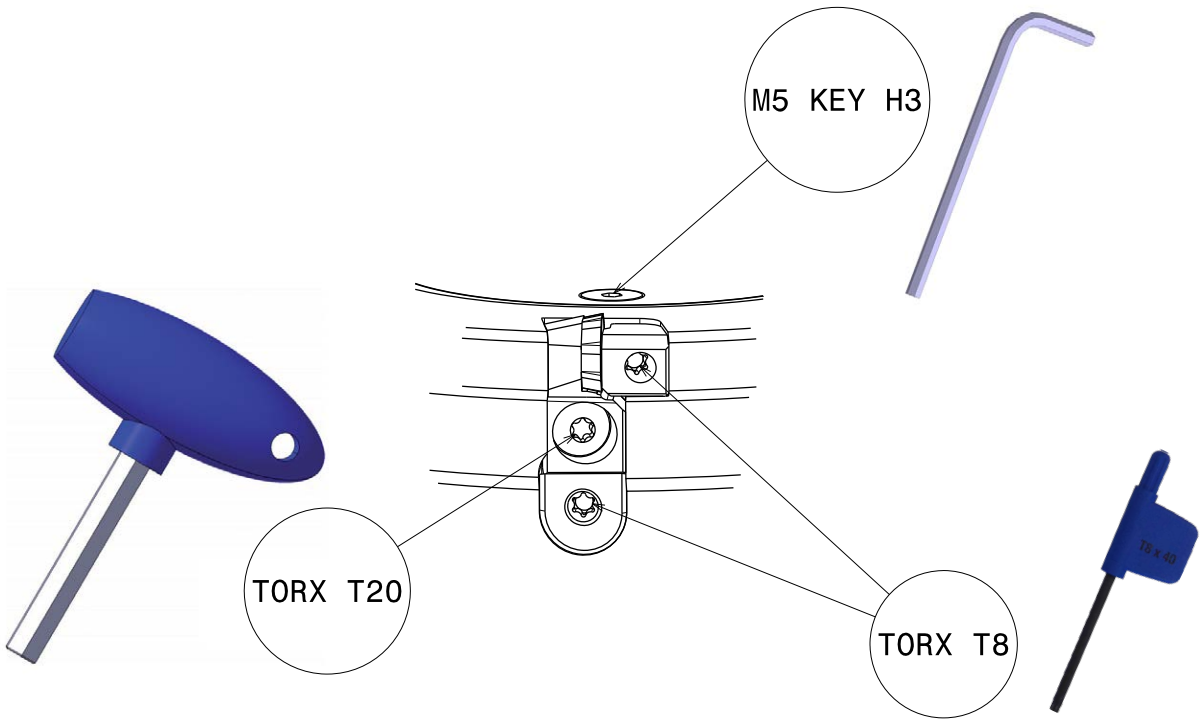
CBN TEDI OCTO CUT - SPARE PARTS



TYPE			ITEM NUMBER	DESCRIPTION
 T20	 T8	 GREASE	4360818	Std kit supplied with the cutter

CODE	DESCRIPTION	5 S= SCRAPER; W=WIPER; P=POCKET
TOCBA	WEDGE FOR SCRAPER WEDGE FOR WIPER	#Sx RSFTC5000 #Wx RSFTA9000
TOCBU	WEDGE FOR SCRAPER	#Px RSFTA9000

CODE	3	4 + 6	7	8	9	10
TOCBA-125R1200-S1	12x VX050006A	24x RSRGR6M50	12x RSFTC5000	1x VC00TEDI20040	1x RSFTS5100	8x VC010642I05015
TOCBA-160R1402-S1	16x VX050006A	32x RSRGR6M50	16x RSFTC5000	4x VC004762I10035	1x RSFPT1160	8x VC010642I05015
TOCBA-200R1802-S1	20x VX050006A	40x RSRGR6M50	20x RSFTC5000	4x VC004762I16050	1x RSFPT1200	8x VC010642I05015
TOCBA-250R2402-S1	26x VX050006A	52x RSRGR6M50	26x RSFTC5000	4x VC004762I16050	1x RSFPT1200	8x VC010642I05015
TOCBA-315R2804-S1	32x VX050006A	64x RSRGR6M50	32x RSFTC5000	4x VC004762I16050	1x RSFPT1315	12x VC010642I05015
TOCBU-125R1200-S	12x VX050006A	24x RSRGR6M50	12x RSFTC5000	1x VC00TEDI20040	1x RSFTS5100	8x VC010642I05015
TOCBA-160R1600-S	16x VX050006A	32x RSRGR6M50	16x RSFTC5000	4x VC004762I10035	1x RSFPT1160	8x VC010642I05015
TOCBU-200R2000-S	20x VX050006A	40x RSRGR6M50	20x RSFTC5000	4x VC004762I16050	1x RSFPT1200	8x VC010642I05015
TOCBU-250R2600-S	26x VX050006A	52x RSRGR6M50	26x RSFTC5000	4x VC004762I16050	1x RSFPT1200	8x VC010642I05015
TOCBU-315R3200-S	32x VX050006A	64x RSRGR6M50	32x RSFTC5000	4x VC004762I16050	1x RSFPT1315	12x VC010642I05015



NOTES

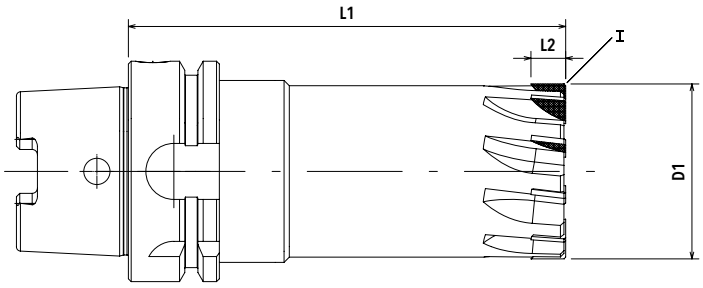
TEDI BRAZED
Brazed Cutters

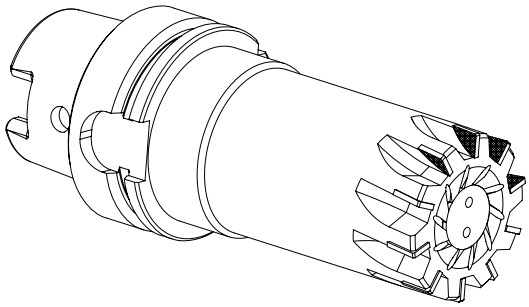
TEDIBRAZED™

The variety of ITTEDI brazed cutters, endmills and integral monoblock, all regrindable, allow a perfect use in a wide range of operations and materials and guarantee excellent performances in terms of quality, consistency and working speed in facing, interpolating and profiling operations. The studies which have been made on the different types of milling operations and the acquired know-how have allowed ITTEDI to make a variety of extremely flexible brazed cutters, which can be employed immediately in any application. Their structural and technical features, together with the accurate quality inspections they go through, make the ITTEDI brazed cutters the ideal tool in both roughing and finishing.

INTEGRAL BRAZED CUTTERS

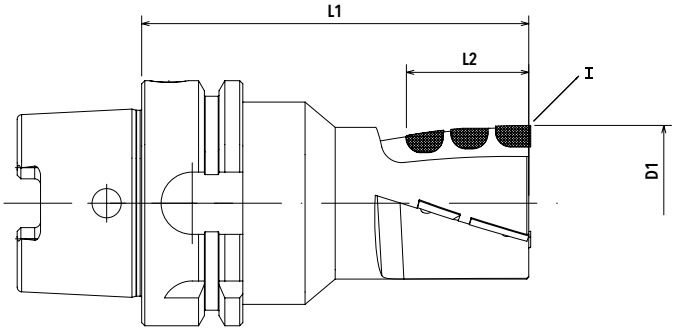
HSK A ADAPTOR
DIN 69893

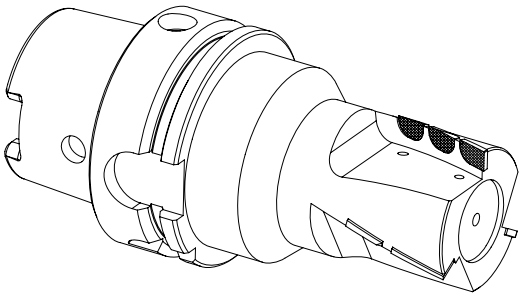




ITEM NUMBER	HSK TAPER DIMENSION	D1	Z	L1	L2	I LEAD ANGLE	ROTATION
FBHA63032125P060	A 63	32	6	125	15	0.2x45°	R
FBHA63040125P080	A 63	40	8	125	15	0.2x45°	R
FBHA63050125P100	A 63	50	10	125	10	0.2x45°	R
FBHA63063125P120	A 63	63	12	125	10	0.2x45°	R
FBHA63080125P140	A 63	80	14	125	10	0.2x45°	R
FBHA63100100P160	A 63	100	16	100	10	0.2x45°	R
FBHA63125100P200	A 63	125	20	100	10	0.2x45°	R
FBHA10080125P140	A 100	80	14	125	10	0.2x45°	R
FBHA10100125P160	A 100	100	16	125	10	0.2x45°	R
FBHA10125125P200	A 100	125	20	125	10	0.2x45°	R

Brazed cutters are non-stock standard - request a quote.



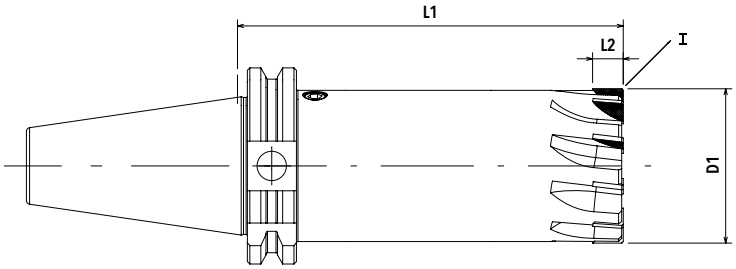


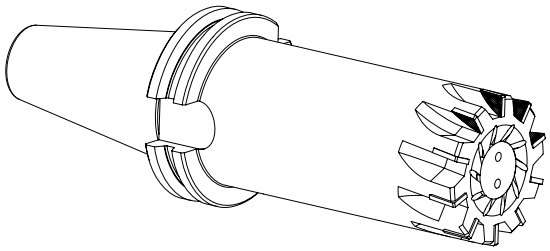
ITEM NUMBER	HSK TAPER DIMENSION	D1	Z	L1	L2	I LEAD ANGLE	ROTATION
EBSED032Z03HA63L30R02	A 63	32	3	100	30	R02	R
EBSED040Z03HA63L40R02	A 63	40	3	100	40	R02	R
EBSED050Z04HA63L40R02	A 63	50	4	100	40	R02	R
EBSED063Z04HA63L40R02	A 63	63	4	100	40	R02	R

Brazed cutters are non-stock standard - request a quote.

INTEGRAL BRAZED CUTTERS

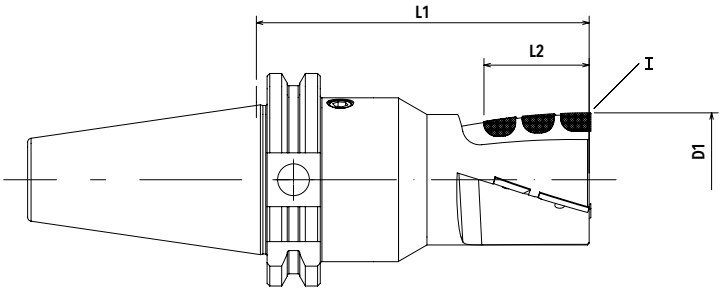
CAT A/B ADAPTOR

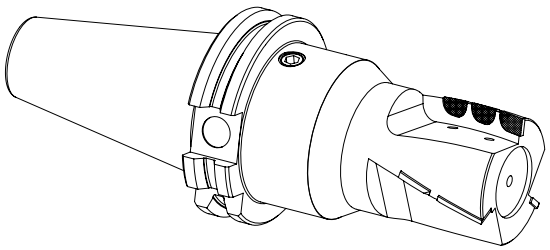




ITEM NUMBER	CAT TAPER DIMENSION	D1	Z	L1	L2	I LEAD ANGLE	ROTATION
FBCC40032125P060	40	32	6	125	15	0.2x45°	R
FBCC40040125P080	40	40	8	125	15	0.2x45°	R
FBCC40050125P100	40	50	10	125	10	0.2x45°	R

Brazed cutters are non-stock standard - request a quote.



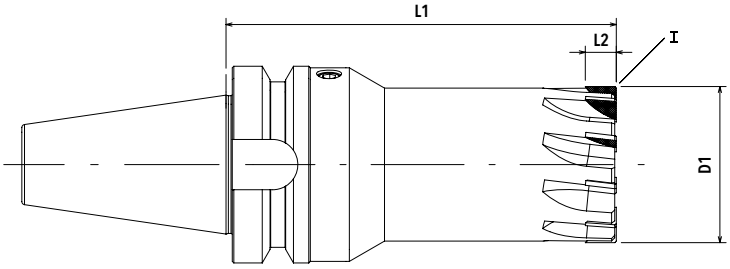


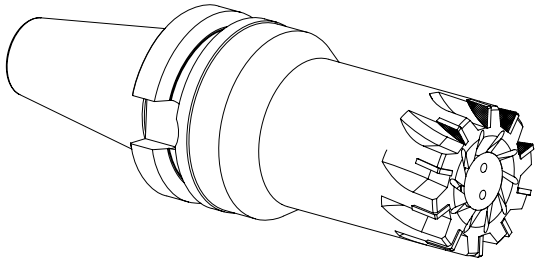
ITEM NUMBER	CAT TAPER DIMENSION	D1	Z	L1	L2	I LEAD ANGLE	ROTATION
EBSED032Z03CC40L30R02	40	32	3	100	30	R02	R
EBSED040Z03CC40L40R02	40	40	3	100	40	R02	R
EBSED050Z04CC40L40R02	40	50	4	100	40	R02	R
EBSED063Z04CC40L40R02	40	63	4	100	40	R02	R

Brazed cutters are non-stock standard - request a quote.

INTEGRAL BRAZED CUTTERS

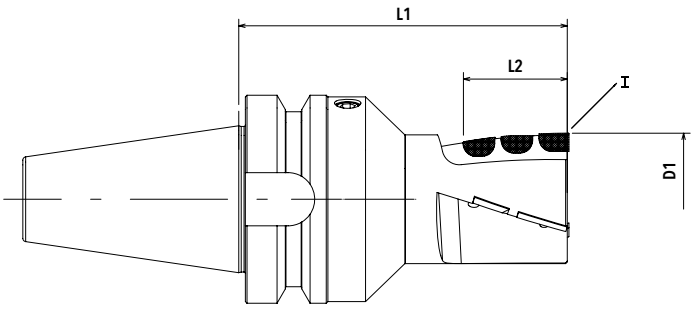
BT A/B ADAPTOR
MAS 403

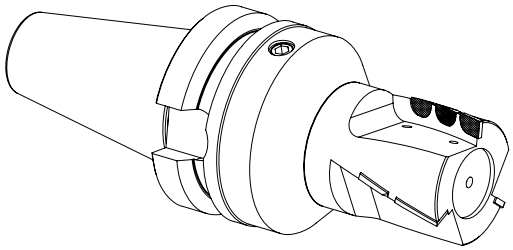




ITEM NUMBER	BT TAPER DIMENSION	D1	Z	L1	L2	I LEAD ANGLE	ROTATION
FBBC40032125P060	40	32	6	125	15	0.2x45°	R
FBBC40040125P080	40	40	8	125	15	0.2x45°	R
FBBC40050125P100	40	50	10	125	10	0.2x45°	R

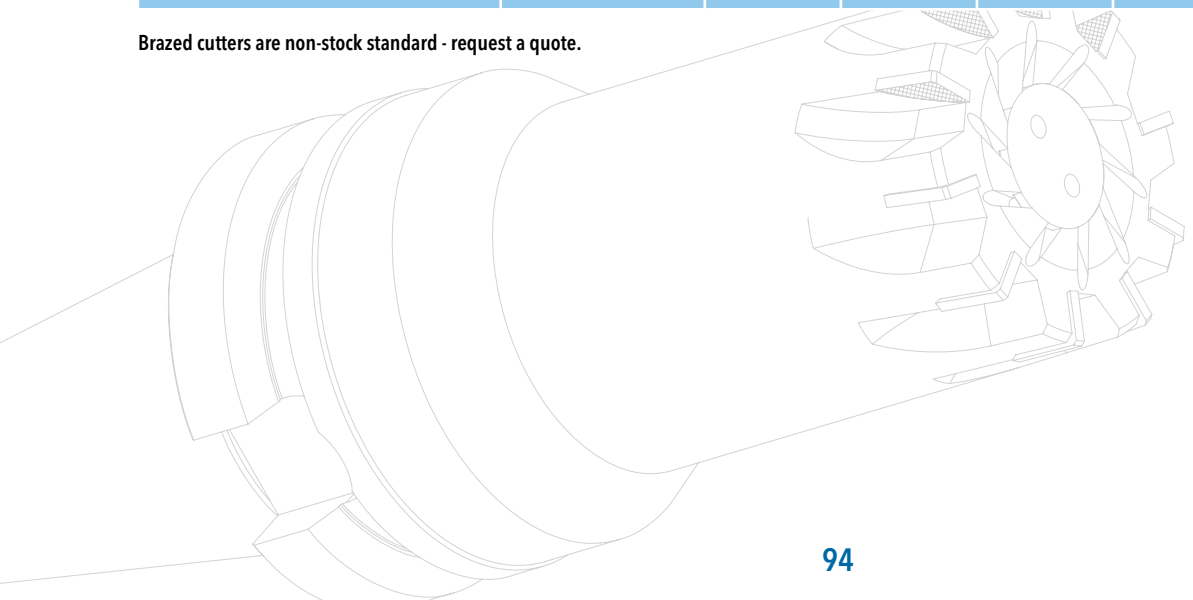
Brazed cutters are non-stock standard - request a quote.





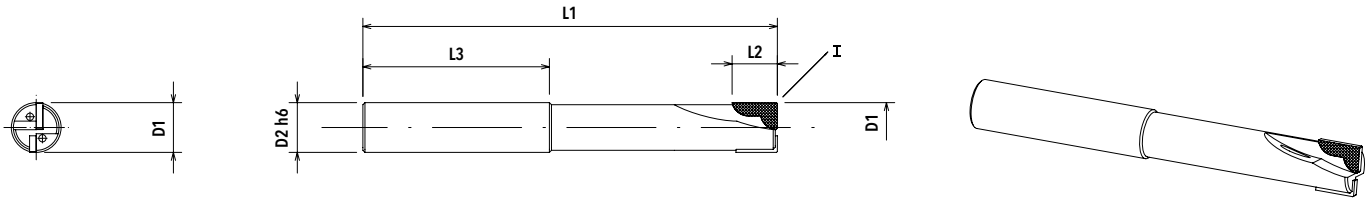
ITEM NUMBER	BT TAPER DIMENSION	D1	Z	L1	L2	I LEAD ANGLE	ROTATION
EBSED032Z03BC40L30R02	40	32	3	100	30	R02	R
EBSED040Z03BC40L40R02	40	40	3	100	40	R02	R
EBSED050Z04BC40L40R02	40	50	4	100	40	R02	R
EBSED063Z04BC40L40R02	40	63	4	100	40	R02	R

Brazed cutters are non-stock standard - request a quote.



INTEGRAL BRAZED CUTTERS

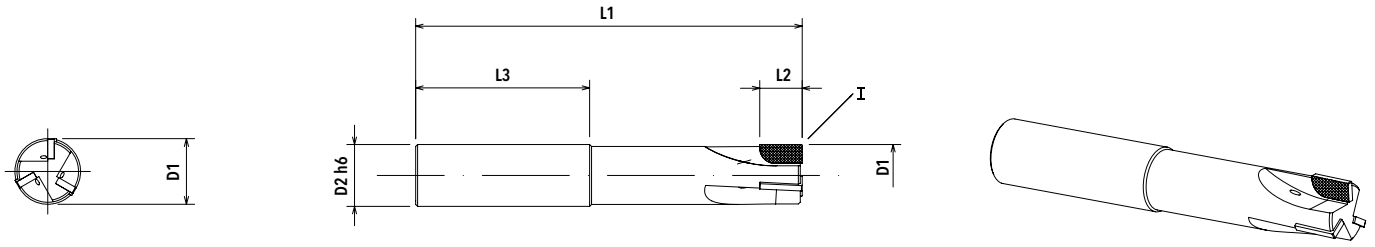
CYLINDRICAL SHANK



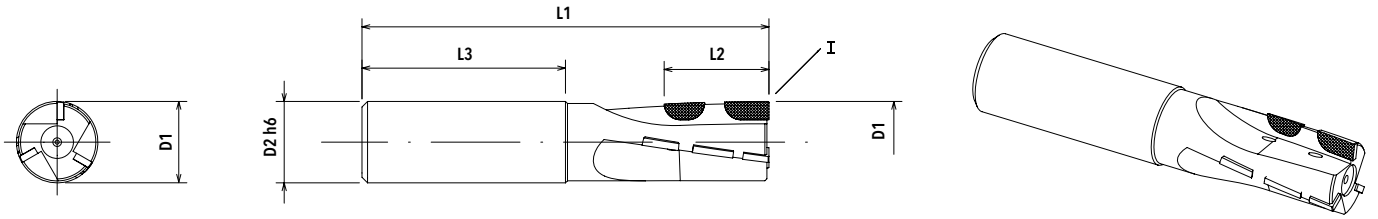
	ITEM NUMBER	D2	D1	Z	L1	L2	L3	I LEAD ANGLE	ROTATION
INCHES	EBSTI15Z01CM05L10C01	5mm	0.156	1	2.64	0.394	1.22	0.004x45°	R
	EBSTI18Z01CM05L10C01	5mm	0.188	1	2.64	0.394	1.22	0.004x45°	R
	EBSTI25Z01CM06L10C01	6mm	0.250	1	2.64	0.394	1.57	0.004x45°	R
	EBSTI25Z02CM06L20C01	6mm	0.250	2	2.64	0.787	1.57	0.004x45°	R
	EBSTI31Z02CM08L10C01	8mm	0.313	2	3.23	0.394	1.57	0.004x45°	R
	EBSTI31Z02CM08L20C01	8mm	0.313	2	3.23	0.787	1.57	0.004x45°	R
	EBSTI37Z02CM10L10C01	10mm	0.375	2	3.23	0.394	1.73	0.008x45°	R
	EBST37Z02CM10L20C02	10mm	0.375	2	3.23	0.787	1.73	0.008x45°	R
	EBSTI50Z02CM12L10C01	12mm	0.500	2	3.66	0.394	2.00	0.008x45°	R
	EBSTI50Z02CM12L20C02	12mm	0.500	2	3.66	0.787	2.00	0.008x45°	R
MM	EBSTD04Z01CM05L10C01	5	4	1	67	10	31	0.1x45°	R
	EBSTD05Z01CM05L10C01	5	5	1	67	10	31	0.1x45°	R
	EBSTD06Z02CM06L10C01	6	6	2	67	10	40	0.1x45°	R
	EBSTD06Z02CM06L20C01	6	6	2	67	20	40	0.1x45°	R
	EBSTD08Z02CM08L10C01	8	8	2	73	10	40	0.1x45°	R
	EBSTD08Z02CM08L20C01	8	8	2	73	20	40	0.1x45°	R
	EBSTD10Z02CM10L10C02	10	10	2	82	10	44	0.2x45°	R
	EBSTD10Z02CM10L20C02	10	10	2	82	20	44	0.2x45°	R
	EBSTD12Z02CM12L10C02	12	12	2	93	10	50	0.2x45°	R
	EBSTD12Z02CM12L20C02	12	12	2	93	20	50	0.2x45°	R

INTEGRAL BRAZED CUTTERS

CYLINDRICAL SHANK



	ITEM NUMBER	D2	D1	Z	L1	L2	L3	I LEAD ANGLE	ROTATION
INCHES	EBSPI37Z03CM10L10R02	0.375	10mm	3	2.84	.375	1.75	R0.008	R
	EBSPI50Z03CM12L10R02	0.500	12mm	3	3.27	.375	2.00	R0.008	R
	EBSPI62Z03CM16L10R02	0.625	14mm	3	3.62	.375	2.00	R0.008	R
	EBSPI75Z03CM20L10R02	0.750	16mm	3	3.98	.375	2.16	R0.008	R
MM	EBSPD10Z03CM10L10R02	10	10	3	72	10	44	R0.2	R
	EBSPD12Z03CM12L10R02	12	12	3	83	10	50	R0.2	R
	EBSPD14Z03CM14L10R02	14	14	3	87	10	50	R0.2	R
	EBSPD16Z03CM16L10R02	16	16	3	92	10	53	R0.2	R
	EBSPD20Z03CM20L10R02	20	20	3	104	10	55	R0.2	R



	ITEM NUMBER	D2	D1	Z	L1	L2	L3	I LEAD ANGLE	ROTATION
INCHES	EBSEI62Z03CM16L30R02	0.625	16mm	3	3.94	1.18	2.00	R0.008	R
	EBSEI75Z03CM20L30R02	0.750	20mm	3	3.94	1.18	2.00	R0.008	R
	EBSEI10Z03CM25L30R02	1.000	25mm	3	3.94	1.18	2.16	R0.008	R
MM	EBSED16Z03CM16L30R02	16	16	3	100	30	50	R0.2	R
	EBSED20Z03CM20L30R02	20	20	3	100	30	50	R0.2	R
	EBSED25Z03CM25L30R02	25	25	3	100	30	55	R0.2	R

NOTES

CUTTING PARAMETERS

CUTTING PARAMETERS

The below cutting data is purely an indication and are calculated assuming optimal working conditions; they can vary depending on stability of the fixture, the machine and the workpiece.
For more detailed information and for choosing the best grade, you should contact IT.TE.DI.'s offices.

MATERIAL	GRADE	Vc (sfm)	fz (in/z)
Aluminum casting alloys (Si <12%)	PCD	≤ 19,000	0.002 - 0.010
Aluminum casting alloys (Si >12%)	PCD	≤ 5,000	0.002 - 0.010
Aluminum forging alloys	PCD	≤ 19,000	0.002 - 0.010
Copper, bronze, brass, zinc and magnesium alloys	PCD	≤ 6,500	0.002 - 0.010
Non metallic materials	PCD	≤ 10,000	0.002 - 0.010
Grey Cast Iron	CBN	3,200 - 6,500	0.002 - 0.010
Nodular Cast Iron (ferritic)	CBN	1,300 - 2,000	0.002 - 0.010
Malleable Cast Iron (ferritic)	CBN	1,600 - 2,600	0.002 - 0.010
Hardened Steel	CBN	500 - 1,000	0.002 - 0.010

FORMULA AND ABBREVIATION:			CALCULATION OF:
ø	Milling cutter - diameter	[in]	$V_c = n \times ø \times .262$
a_p	Axial depth of cut	[in]	
a_e	Width of cut	[in]	$n = (V_c \div ø) \div .262$
V_c	Cutting speed	[sfm]	
n	RPM	[min-1]	$V_f = f_z \times n \times z$
z	Number of teeth		
f_z	Feed rate per tooth	[in]	$f_z = V_f \div (n \times z)$
V_f	Feed rate	[in/min]	

SERVICES

Ingersoll/IT.TE.DI. provides a variety of services aiming at the total satisfaction of those who choose its products. The experience and expertise with special tooling is IT.TE.DI.'s distiguishing feature, proved by its ability to make customized solutions based on the customer's needs; this vocation is also the trademark of IT.TE.DI.'s services.

SPECIAL DIMENSIONS: IT.TE.DI. excels at providing highly personalized solutions, based on specific customer's requirements, thanks to their staff and organization, from engineering to the R & D tests.

REGRINDABLE CARTRIDGES: IT.TE.DI. provides an efficient grinding service, so that new and refurbished cartridges are perfectly indexable.

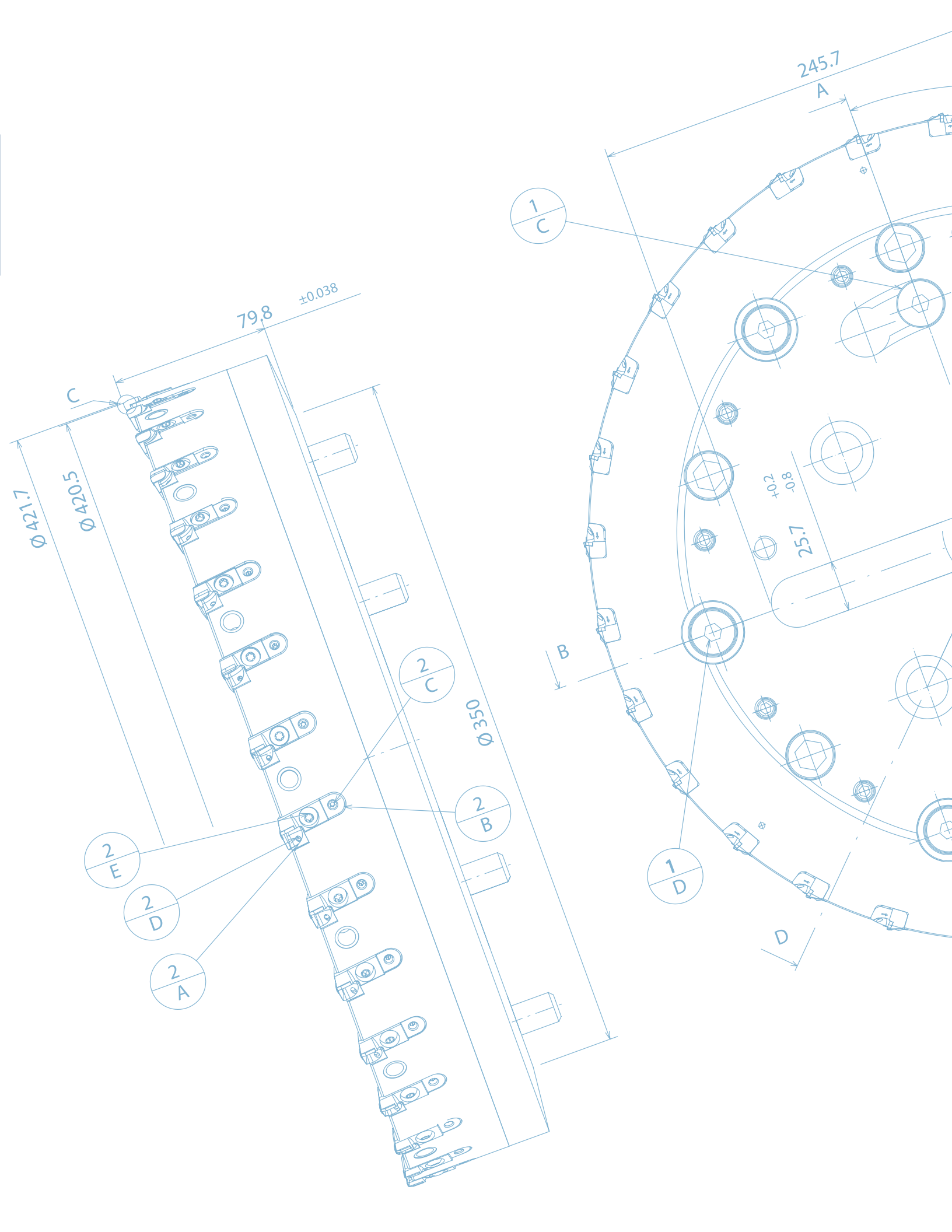
ASSEMBLING AND PRESETTING: these are highly valuable options. They are part of the offer to the customer, aiming at a better personalization and the best performance of the solution which was found during the production process.

BALANCING: The IT.TE.DI. balancing system has been designed to allow the customers to obtain the best performance from its tools.

NOTES

Member IMC Group ®

IT.TE.DI.


245.7
A
1
C
79.8
±0.038
C
Ø421.7
Ø420.5
Ø350
2
C
2
B
2
E
2
D
2
A
B
25.7
+0.2
-0.8
1
D
D

Member IMC Group

IT.TE.DI.

BRAZED & INDEXABLE PCD/CBN MILLING

Ingersoll Cutting Tools for Americas

Marketing & Technology Center
845 S. Lyford Road
Rockford, IL 61108-2749 U.S.A.
Tel: 815.387.6600
Fax: 815.387.6968
Email: info@ingersoll-imc.com
www.ingersoll-imc.com

Ingersoll Mexico
Blvd. Cuauhtemoc Num 2411 Locales 6 y 7
Esquina Calle Manuel Perez Trevino
Fracc. Residencial Los Pinos
CP 25198
Saltillo, Coahuila, Mexico
Tel: 52-844-4-85-32-20
Fax: 52-844-4-85-32-23
Email: info@ingersoll-imc.com

Ingersoll Western Canada
Unit 14 – 1599 Dugald Rd.
Winnipeg, Manitoba
R2E 0B1
Tel: (204) 654-9894
Fax: (204) 654-6080
Toll Free: 1-866-460-4951
info@eagleindustrial.ca

Ingersoll Cutting Tools for Europe

Marketing & Technology Center
Ingersoll Werkzeuge GmbH
Kalteiche-Ring 21-25
35708 Haiger, Germany
Tel: 02773.742 0
Fax: 02773.742 812/814
Email: info@ingersoll-imc.de
www.ingersoll-imc.de

Ingersoll France s.a.r.l.
21, rue Galilée
F-77420 CHAMPS-sur-MARNE
Tel: +33 (0)1 64 68 45 36
Fax: +33 (0)1 64 68 45 24
Email: info@ingersoll-imc.fr

Ingersoll Italien
Via Monte Grappa, 78
20020 Arese (Milano)
Telefon: +39 02 99 76 67 00
Telefax: +39 02 99 76 67 10
Email: crespi@taegutec.it

Ingersoll Cutting Tools for Asia

Ingersoll Japan Ltd.
Senri Asahi Hankyu Bldg. 15F
1-5-3 Shinsenri-Higashimachi
Toyonaka-shi Osaka 560-0082
Tel: 81-6-6835-7731
Fax: 81-6-6835-7732

Ingersoll China
7B21,
Hanwei Plaza,
GuangHua Road,
Chaoyang District,
Beijing, P.R.C.,100004.
Tel:+86 10 656 10261/2/3
Fax:+86 10 656 10264

Member IMC Group
Ingersoll
Cutting Tools

CAT-027-6 2913567 (6/23)