

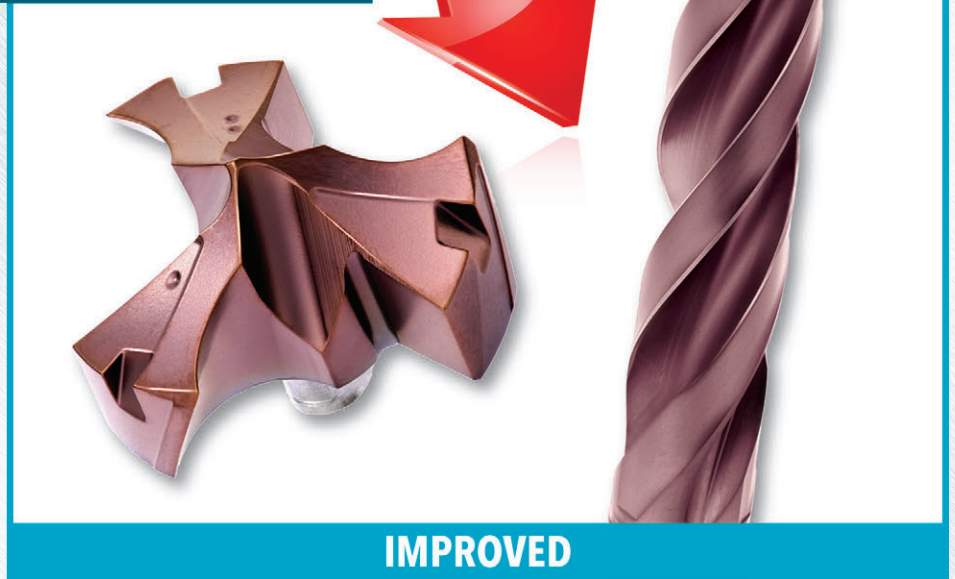


Grade:
IN2205

Series:
SolidDrill FR
TwistSFeed FPC

Diameters:
SolidDrill³:
3.97-12.00mm (.1563"-.4724")

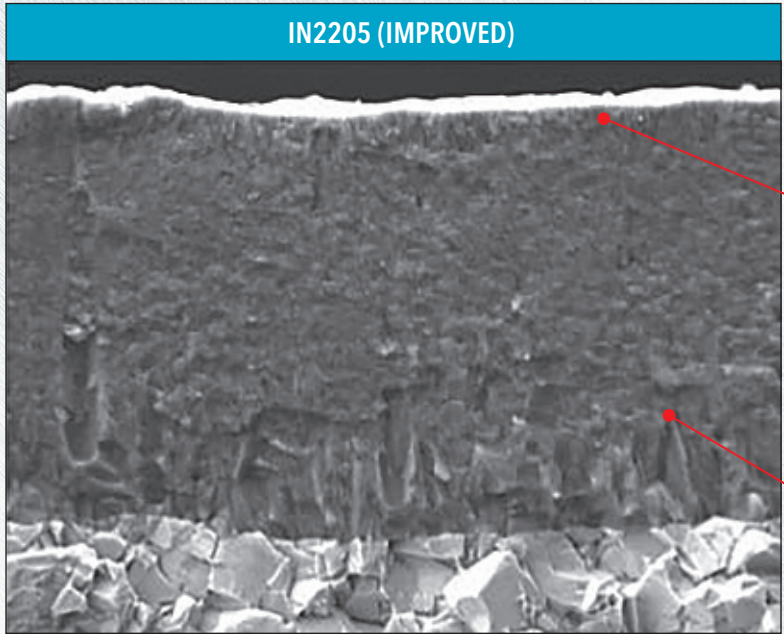
TwistSFeed:
15.0-20.9mm (.5906"-.8228")



Improved IN2205 Grade for Drilling

Ingersoll has introduced an improved version of grade IN2205 for TwistSFeed and SolidDrill³ which will boost productivity and machinability. The new bronze color, PVD coating, features more reliable machining due to its higher hardness over current "blue" grade. This is a running change. Item numbers and descriptions will remain the same. The new coating will be available as existing inventory is depleted for each item.

GRADE IN2205 FEATURES



Improved edge chipping resistant layer

Anti-abrasion and crack resistant layer

- Suitable for high feed and speed machining on cast iron and alloy steel
- Improved PVD coated layer with excellent anti-abrasion and crack resistance
- Sub-micron substrate with high wear resistance and optimum toughness



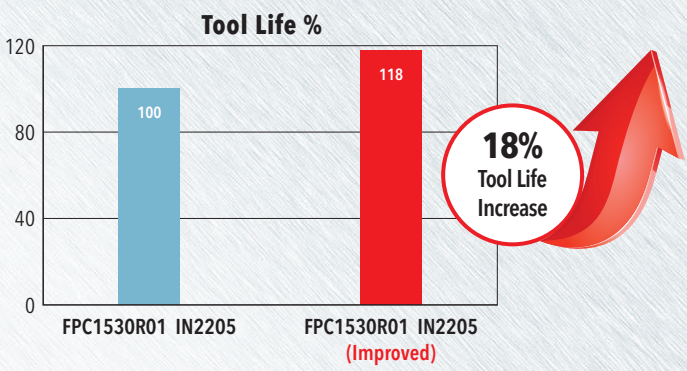


CASE STUDIES

Case Study 1



		Ingersoll
Material		Carbon Steel, AISI 1045
Drill Body		FD150007518R01
Drill Head		FPC1530R01 IN2205 (Improved)
Drilling Depth (in)		2.750"
Cutting Speed	V (sfm)	400
Feed	f (ipr)	.020"
Coolant		Internal (218 PSI)
Tool Life		100% 118%



Case Study 2



		Ingersoll
Material		Carbon Steel, AISI 1045
Drill		FR0400029T7R01 IN2205 FR0400029T7R01 IN2205 (Improved)
Drilling Depth (in)		.787"
Cutting Speed	V (sfm)	330
Feed	f (ipr)	.010"
Coolant		Internal (218 PSI)
Tool Life		100% 120%

