

TURNING INSERTS

Product Lines

ISO Turn
T-Clamp Ultra+

New Designations

Current: TD810
Replacement: TD1010

Current: KP300
Replacement: TD1020

PCD Grade Designation Change Notice

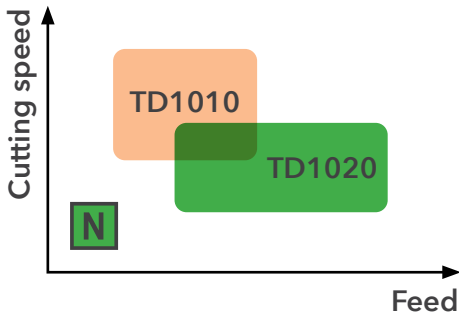
(NON-ROTATING INSERTS ONLY)

Ingersoll's grade designation for PCD turning inserts has changed as part of a new naming convention for inserts made from advanced materials. This change is intended to simplify grade identification.

No structural or physical changes are being made to the inserts - the only change is to the grade designation.

To effectively manage this transition, new item numbers have been assigned to the inserts that use the new grade names. This is summarized in the pages that follow.

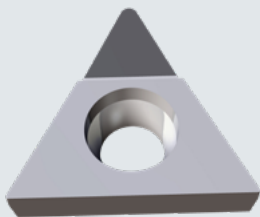
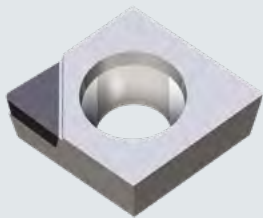
Ingersoll's internal and e-commerce systems have been updated to incorporate these changes and identify the new, alternative items where applicable. The transition to the new item will take place as each old item is depleted from stock.



Updated designation system for advanced material grades (Ceramic, CBN, PCD)

TD 1020

Material	ISO Class	Coating	ISO Range
TD : PCD TC : Ceramic TB : CBN	1 : N 2 : H 3 : S 7 : K 8 : P 9 : M	0 : Uncoated 1-6 : PVD coated 7-9 : CVD coated	05 Hardness 10 • • 45 50 Toughness



Old/New Item Numbers

ISO TURNING INSERTS

TD810 / KP300 Phase Out			➡	TD1010 / TD1020 Phase In		
Item No.	ANSI Part Number	ISO Part Number		Item No.	ANSI Part Number	ISO Part Number
5402895	CCGT21.51CB KP300	CCGT060204CB KP300	➡	6308122	CCGT21.51CB TD1020	CCGT060204CB TD1020
5402917	CCGT32.50.5CB KP300	CCGT09T302CB KP300	➡	6308124	CCGT32.50.5CB TD1020	CCGT09T302CB TD1020
5402802	CCGT32.51CB KP300	CCGT09T304CB KP300	➡	6308125	CCGT32.51CB TD1020	CCGT09T304CB TD1020
5402915	CCGT32.52CB KP300	CCGT09T308CB KP300	➡	6308131	CCGT32.52CB TD1020	CCGT09T308CB TD1020
5402897	CCGT431CB KP300	CCGT120404CB KP300	➡	6308132	CCGT431CB TD1020	CCGT120404CB TD1020
5402918	CCGT432CB KP300	CCGT120408CB KP300	➡	6308133	CCGT432CB TD1020	CCGT120408CB TD1020
5400940	CCGW21.50.5LN-7 KP300	CCGW060202LN-7 KP300	➡	6308134	CCGW21.50.5LN-7 TD1020	CCGW060202LN-7 TD1020
5403615	CCGW21.50.5LN-7 TD810	CCGW060202LN-7 TD810	➡	6264319	CCGW21.50.5LN-7 TD1010	CCGW060202LN-7 TD1010
5400941	CCGW21.51LN-7 KP300	CCGW060204LN-7 KP300	➡	6308135	CCGW21.51LN-7 TD1020	CCGW060204LN-7 TD1020
5403604	CCGW21.51LN-7 TD810	CCGW060204LN-7 TD810	➡	6264321	CCGW21.51LN-7 TD1010	CCGW060204LN-7 TD1010
6342426	CCGW32.51LN-7 KP300	CCGW09T304LN-7 KP300	➡	6308136	CCGW32.51LN-7 TD1020	CCGW09T304LN-7 TD1020
5403602	CCGW32.51LN-7 TD810	CCGW09T304LN-7 TD810	➡	6308137	CCGW32.51LN-7 TD1010	CCGW09T304LN-7 TD1010
5400944	CCGW32.52LN-7 KP300	CCGW09T308LN-7 KP300	➡	6308139	CCGW32.52LN-7 TD1020	CCGW09T308LN-7 TD1020
5403612	CCGW32.52LN-7 TD810	CCGW09T308LN-7 TD810	➡	6308140	CCGW32.52LN-7 TD1010	CCGW09T308LN-7 TD1010
5400945	CCGW431LN-7 KP300	CCGW120404LN-7 KP300	➡	6308141	CCGW431LN-7 TD1020	CCGW120404LN-7 TD1020
NA	NA	NA	➡	6264323	CCGW431LN-7 TD1010	CCGW120404LN-7 TD1010
5400946	CCGW432LN-7 KP300	CCGW120408LN-7 KP300	➡	6308142	CCGW432LN-7 TD1020	CCGW120408LN-7 TD1020
5403608	CCGW432LN-7 TD810	CCGW120408LN-7 TD810	➡	6308143	CCGW432LN-7 TD1010	CCGW120408LN-7 TD1010
5400947	CNGA431LN-10 KP300	CNGA120404LN-10 KP300	➡	6308144	CNGA431LN-10 TD1020	CNGA120404LN-10 TD1020
5400948	CNGA432LN-10 KP300	CNGA120408LN-10 KP300	➡	6308146	CNGA432LN-10 TD1020	CNGA120408LN-10 TD1020
5400949	CNGA433LN-10 KP300	CNGA120412LN-10 KP300	➡	6264356	CNGA433LN-10 TD1020	CNGA120412LN-10 TD1020
NA	NA	NA	➡	6308148	DCGT21.20.5LN-10 TD1020	DCGT070202CB TD1020
NA	NA	NA	➡	6308149	DCGT21.21LN-10 TD1020	DCGT070204CB TD1020
5402909	DCGT32.50.5CB KP300	DCGT11T302CB KP300	➡	6308150	DCGT32.50.5CB TD1020	DCGT11T302CB TD1020
5402801	DCGT32.51CB KP300	DCGT11T304CB KP300	➡	6264363	DCGT32.51CB TD1020	DCGT11T304CB TD1020
5402912	DCGT32.52CB KP300	DCGT11T308CB KP300	➡	6264364	DCGT32.52CB TD1020	DCGT11T308CB TD1020

Old/New Item Numbers (continued)

ISO TURNING INSERTS

TD810 / KP300 Phase Out			➡	TD1010 / TD1020 Phase In		
Item No.	ANSI Part Number	ISO Part Number		Item No.	ANSI Part Number	ISO Part Number
5400950	DCGW21.50.5LN-7 KP300	DCGW070202LN-7 KP300	➡	6264325	DCGW21.50.5LN-7 TD1020	DCGW070202LN-7 TD1020
5403628	DCGW21.50.5LN-7 TD810	DCGW070202LN-7 TD810	➡	6264326	DCGW21.50.5LN-7 TD1010	DCGW070202LN-7 TD1010
5400951	DCGW21.51LN-7 KP300	DCGW070204LN-7 KP300	➡	6264327	DCGW21.51LN-7 TD1020	DCGW070204LN-7 TD1020
5403625	DCGW21.51LN-7 TD810	DCGW070204LN-7 TD810	➡	6264328	DCGW21.51LN-7 TD1010	DCGW070204LN-7 TD1010
5400952	DCGW32.50.5LN-7 KP300	DCGW11T302LN-7 KP300	➡	6264329	DCGW32.50.5LN-7 TD1020	DCGW11T302LN-7 TD1020
5403607	DCGW32.50.5LN-7 TD810	DCGW11T302LN-7 TD810	➡	6264330	DCGW32.50.5LN-7 TD1010	DCGW11T302LN-7 TD1010
5400953	DCGW32.51LN-7 KP300	DCGW11T304LN-7 KP300	➡	6264332	DCGW32.51LN-7 TD1020	DCGW11T304LN-7 TD1020
5403599	DCGW32.51LN-7 TD810	DCGW11T304LN-7 TD810	➡	6264333	DCGW32.51LN-7 TD1010	DCGW11T304LN-7 TD1010
5400954	DCGW32.52LN-7 KP300	DCGW11T308LN-7 KP300	➡	6264335	DCGW32.52LN-7 TD1020	DCGW11T308LN-7 TD1020
5403606	DCGW32.52LN-7 TD810	DCGW11T308LN-7 TD810	➡	6264336	DCGW32.52LN-7 TD1010	DCGW11T308LN-7 TD1010
5400955	DNGA431LN-10 KP300	DNGA150404LN-10 KP300	➡	6264357	DNGA431LN-10 TD1020	DNGA150404LN-10 TD1020
5400956	DNGA432LN-10 KP300	DNGA150408LN-10 KP300	➡	6264358	DNGA432LN-10 TD1020	DNGA150408LN-10 TD1020
6119040	DNGA432LN-10 TD810	DNGA150408LN-10 TD810	➡	6270055	DNGA432LN-10 TD1010	DNGA150408LN-10 TD1010
5401000	DNGA441LN-10 KP300	DNGA150604LN-10 KP300	➡	6264359	DNGA441LN-10 TD1020	DNGA150604LN-10 TD1020
5401004	DNGA442LN-10 KP300	DNGA150608LN-10 KP300	➡	6264360	DNGA442LN-10 TD1020	DNGA150608LN-10 TD1020
5402785	TCGT731CB KP300	TCGT090204CB KP300	➡	6264365	TCGT731CB TD1020	TCGT090204CB TD1020
5402784	TCGT21.51CB KP300	TCGT110204CB KP300	➡	6264366	TCGT21.51CB TD1020	TCGT110204CB TD1020
5402916	TCGT32.52CB KP300	TCGT16T308CB KP300	➡	6264367	TCGT32.52CB TD1020	TCGT16T304CB TD1020
5400962	TCGW731LN-7 KP300	TCGW090204LN-7 KP300	➡	6264338	TCGW731LN-7 TD1020	TCGW090204LN-7 TD1020
5400963	TCGW732LN-7 KP300	TCGW090208LN-7 KP300	➡	6264339	TCGW732LN-7 TD1020	TCGW090208LN-7 TD1020
5400964	TCGW21.51LN-7 KP300	TCGW110204LN-7 KP300	➡	6264340	TCGW21.51LN-7 TD1020	TCGW110204LN-7 TD1020
5403600	TCGW21.51LN-7 TD810	TCGW110204LN-7 TD810	➡	6264341	TCGW21.51LN-7 TD1010	TCGW110204LN-7 TD1010
5400966	TCGW32.51LN-7 KP300	TCGW16T304LN-7 KP300	➡	6264343	TCGW32.51LN-7 TD1020	TCGW16T304LN-7 TD1020
5400967	TCGW32.52LN-7 KP300	TCGW16T308LN-7 KP300	➡	6264344	TCGW32.52LN-7 TD1020	TCGW16T308LN-7 TD1020
5400968	TNGA331LN-10 KP300	TNGA160404LN-10 KP300	➡	6264361	TNGA331LN-10 TD1020	TNGA160404LN-10 TD1020
5400973	TPG320.5LN-7 KP300	TPGN160302LN-7 KP300	➡	6264345	TPG320.5LN-7 TD1020	TPGN 160302LN-7 TD1020

Old/New Item Numbers (continued)

ISO TURNING INSERTS

TD810 / KP300 Phase Out			➡	TD1010 / TD1020 Phase In		
Item No.	ANSI Part Number	ISO Part Number		Item No.	ANSI Part Number	ISO Part Number
6264346	TPG321LN-7 TD1020	TPGN160304LN-7 TD1020	➡	6264346	TPG321LN-7 TD1020	TPGN 160304LN-7 TD1020
5402347	VBGW330.5LN-7 KP300	VBGW160402LN-7 KP300	➡	6264347	VBGW330.5LN-7 TD1020	VBGW160402LN-7 TD1020
5400977	VBGW331LN-7 KP300	VBGW160404LN-7 KP300	➡	6264348	VBGW331LN-7 TD1020	VBGW160404LN-7 TD1020
5400978	VBGW332LN-7 KP300	VBGW160408LN-7 KP300	➡	6264349	VBGW332LN-7 TD1020	VBGW160408LN-7 TD1020
5402913	VCGT220.5CB KP300	VCGT110302CB KP300	➡	6264368	VCGT220.5CB TD1020	VCGT110302CB TD1020
NA	NA	NA	➡	6264369	VCGT221CB TD1020	VCGT110304CB TD1020
5402803	VCGT331CB KP300	VCGT160404CB KP300	➡	6264370	VCGT331CB TD1020	VCGT160404CB TD1020
5402898	VCGT332CB KP300	VCGT160408CB KP300	➡	6264371	VCGT332CB TD1020	VCGT160408CB TD1020
5402914	VCGT333CB KP300	VCGT160412CB KP300	➡	6264372	VCGT333CB TD1020	VCGT160412CB TD1020
5401061	VCGW331LN-7 KP300	VCGW160404LN-7 KP300	➡	6264350	VCGW331LN-7 TD1020	VCGW160404LN-7 TD1020
5403601	VCGW331LN-7 TD810	VCGW160404LN-7 TD810	➡	6264351	VCGW331LN-7 TD1010	VCGW160404LN-7 TD1010
5401085	VCGW332LN-7 KP300	VCGW160408LN-7 KP300	➡	6264353	VCGW332LN-7 TD1020	VCGW160408LN-7 TD1020
5403603	VCGW332LN-7 TD810	VCGW160408LN-7 TD810	➡	6264354	VCGW332LN-7 TD1010	VCGW160408LN-7 TD1010
5400979	VNGA331LN-10 KP300	VNGA160404LN-10 KP300	➡	6264362	VNGA331LN-10 TD1020	VNGA160404LN-10 TD1020

Old/New Part Numbers

T-CLAMP ULTRA+ FULL RADIUS INSERTS

TD810 / KP300 Phase Out		➡	TD1010 / TD1020 Phase In	
Item Number	Part Number		Item Number	Part Number
5400389	TSA6.00-3.00 KP300	➡	5400389	TSA6.00-3.00 TD1020
5400390	TSA8.00-4.00 KP300	➡	5400390	TSA8.00-4.00 TD1020

Operating Guidelines

ISO	Material	Condition	Tensile Strength (N/mm ²)	Hardness HB	Material Group No.	Cutting Speed V _c (SFM)		
						Grade		
						TD1010	TD1020	
N	Aluminum-wrought alloy	Not curable	-	60	21	985-8200	985-7545	
		Cured	-	100	22	985-8200	985-7545	
	Aluminum-cast, alloyed	≤12% Si	Not curable	-	75	23	655-4920	655-4590
			Cured	-	90	24	655-4920	655-4590
		>12% Si	High temperature	-	130	25	260-3280	260-2950
	Copper alloys	>1% Pb	Free cutting	-	110	26	195-1970	195-1805
			Brass	-	90	27	195-1970	195-1805
			Electrolytic copper	-	100	28	100-1310	100-1245
	Non-metallic		Duroplastics, fiber plastics	-	-	29	330-3280	330-2950
			Hard rubber	-	-	30	330-1640	330-1805