



PARTING & GROOVING

Insert Widths

10 mm
15 mm
20 mm

Grooving Depths

Maximum .252"
(dependent on
workpiece diameter)

Grade

UF10 -
Universal substrate, uncoated

Holder

Inch: .750" and 1.000"
Metric: 20 mm and 25 mm
All holders feature
CoolBurst thru-coolant

GOLDFLEX™

Extra Wide Insert Blanks for Special Profile Grooving Applications

- » 4-edge insert blank available in 3 different widths: 10, 15 and 20 mm
- » Clever clamping design provides stable insert mounting
- » Huge cycle time reduction possibilities!
- » Customers can grind special profiles themselves, or Ingersoll can supply tailor-made products complete



See it in
action! »



WINSPEED™
ADVANCED MACHINING

ingersoll-imc.com



Extra Wide Grooving Inserts and Holders for Wide Profile Machining

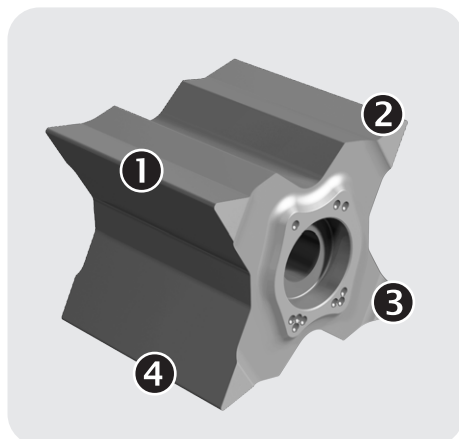
Ingersoll's new **GoldFlex** line now includes standard, semi-finished insert blanks for external wide profile grooving in three widths: 10, 15 and 20mm. These insert blanks are available in uncoated grade UF10, which is ideal for machining a wide range of materials.

These semi-finished insert blanks can be ground to the desired profile by the end-user. Alternatively, Ingersoll offers grinding and coating services to produce these custom profiles according to the end-user specifications.

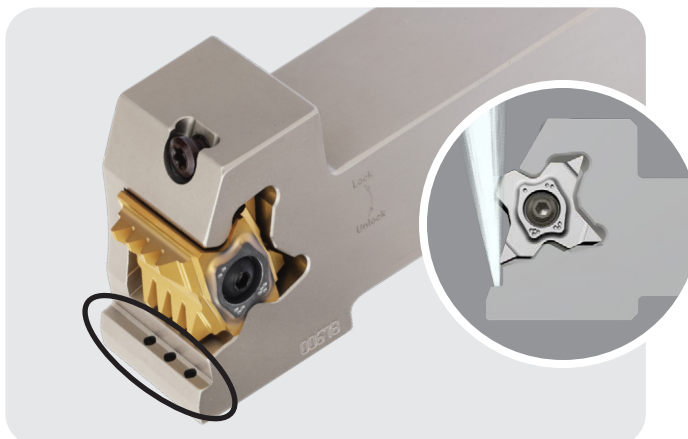
When required, the user can utilize the specific holder as a grinding fixture thanks to its high precision insert positioning and simple yet reliable clamping mechanism. In addition, the COOL-BURST's pinpointed high-pressure coolant supply contributes to longer tool life and improved productivity

Features & Benefits

- Economical, uncoated 4-edge insert blanks
- Insert blanks in 3 different widths: 10, 15 and 20 mm
- Customers can grind special profiles themselves, or Ingersoll can supply tailor-made products
- Smart clamping holder design for stable and robust insert mounting of wide inserts
- High-pressure CoolBurst external holders: 20mm, 25mm, .750" and 1.00"

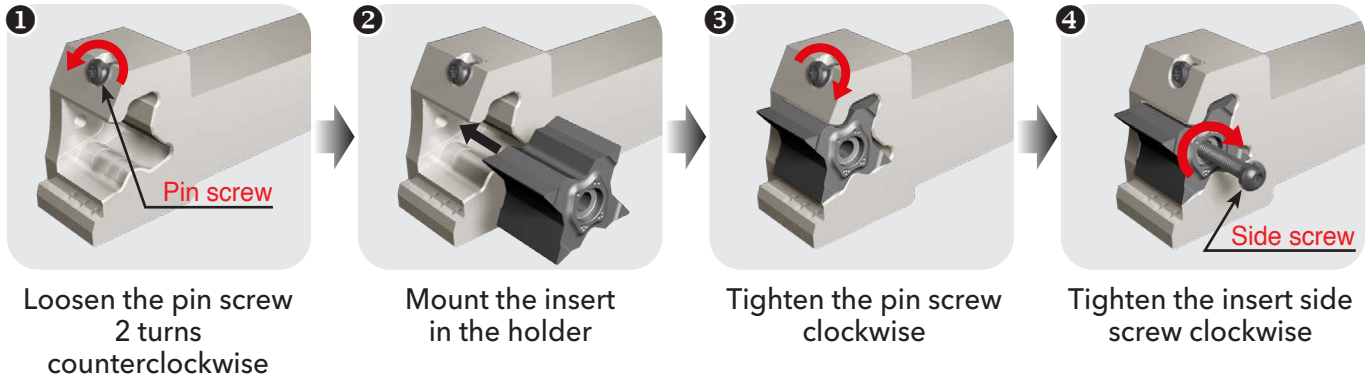


Wide 4-edge insert



Pinpointed high-pressure coolant supply

Insert Mounting Instructions

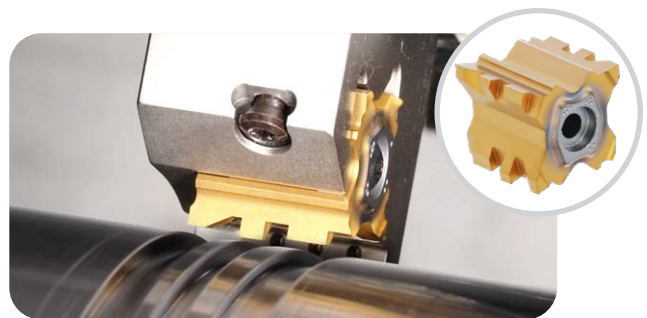


Smart Clamping Mechanism

- ❶ Pin screw clamping (tighten clockwise)
- ❷ As the pin descends, press the insert to secure it in the holder.
- ❸ Stable 4-point contact area (●)



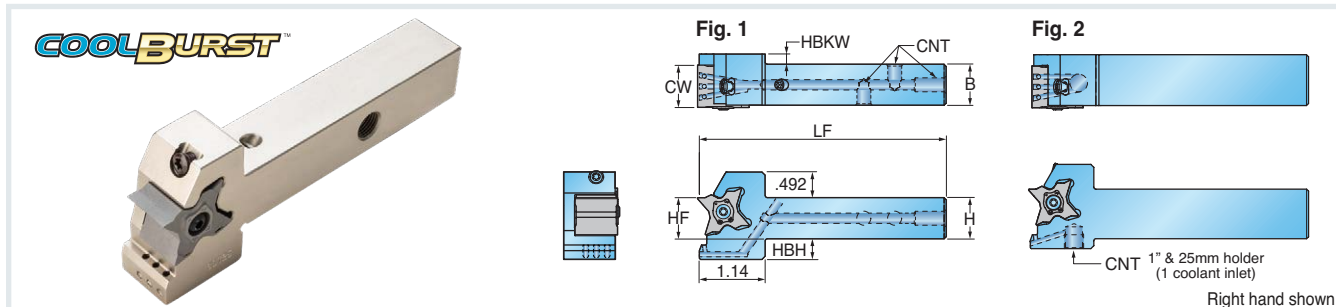
Reference for Profile Machining





Series TQHR/L...EW-TB (Inch)

HOLDERS FOR WIDE SPECIAL FORM GROOVING WITH HIGH PRESSURE COOLANT



Part Number	H Shank Height	HF Functional Height	B Shank Width	LF Functional Length	CW Cutting Width	HBH Head Bottom Offset Height	HBKW Head Back Offset Width	Fig.	CNT Coolant Entry Thread Size	Insert
INCH										
TQHR/L 19-27-10EW-TB	.750	.750	.750	5.0	.413	.512	-	1	1/8-27 NPTF	TQBS 27-10EW
TQHR/L 19-27-15EW-TB	.750	.750	.750	5.0	.610	.512	-	1	1/8-27 NPTF	TQBS 27-15EW
TQHR/L 19-27-20EW-TB	.750	.750	.750	5.0	.807	.512	.197	1	1/8-27 NPTF	TQBS 27-20EW
TQHR/L 25.4-27-10EW-TB	1.000	1.000	1.000	5.5	.413	.315	-	2	1/8-27 NPTF	TQBS 27-10EW
TQHR/L 25.4-27-15EW-TB	1.000	1.000	1.000	5.5	.610	.315	-	2	1/8-27 NPTF	TQBS 27-15EW
TQHR/L 25.4-27-20EW-TB	1.000	1.000	1.000	5.5	.807	.315	-	2	1/8-27 NPTF	TQBS 27-20EW

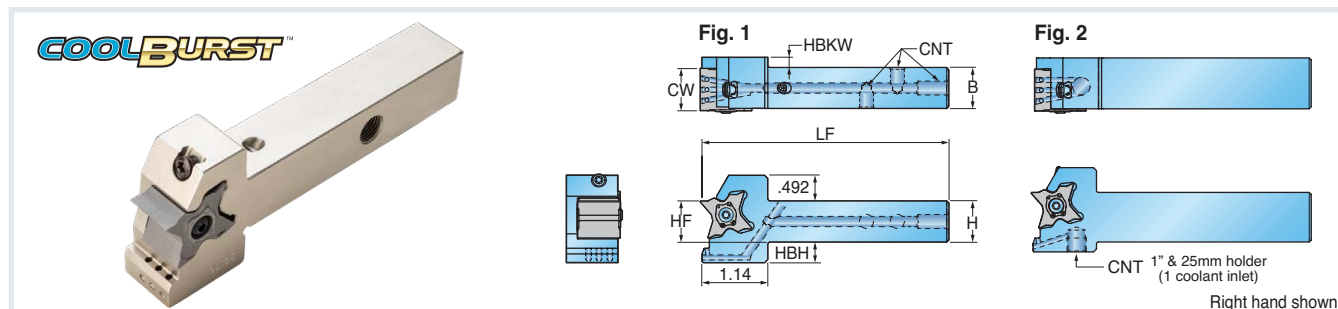
Hardware

Part Number	Clamping Pin	Pin Screw	Side Screw	Plug	Torx Driver	Hex Driver	Hex Driver
TQHR/L 19...10EW-TB	PIN-TQ-W-T	TS 40F120A	BH M4X0.7X16-D7	NPTF 1/8-TQ19	T 15	L-W 2.5	L-W 3/16
TQHR/L 19...15EW-TB	PIN-TQ-W-T	TS 40F120A	BH M4X0.7X20-D7	NPTF 1/8-TQ19	T 15	L-W 2.5	L-W 3/16
TQHR/L 19...20EW-TB	PIN-TQ-W-T	TS 40F120A	BH M4X0.7X23-D7	NPTF 1/8-TQ19	T 15	L-W 2.5	L-W 3/16
TQHR/L 25.4...10EW-TB	PIN-TQ-W-T	TS 40F120A	BH M4X0.7X16-D7	-	T 15	L-W 2.5	-
TQHR/L 25.4...15EW-TB	PIN-TQ-W-T	TS 40F120A	BH M4X0.7X20-D7	-	T 15	L-W 2.5	-
TQHR/L 25.4...20EW-TB	PIN-TQ-W-T	TS 40F120A	BH M4X0.7X23-D7	-	T 15	L-W 2.5	-



Series TQHR/L...EW-TB (Metric)

HOLDERS FOR WIDE SPECIAL FORM GROOVING WITH HIGH PRESSURE COOLANT



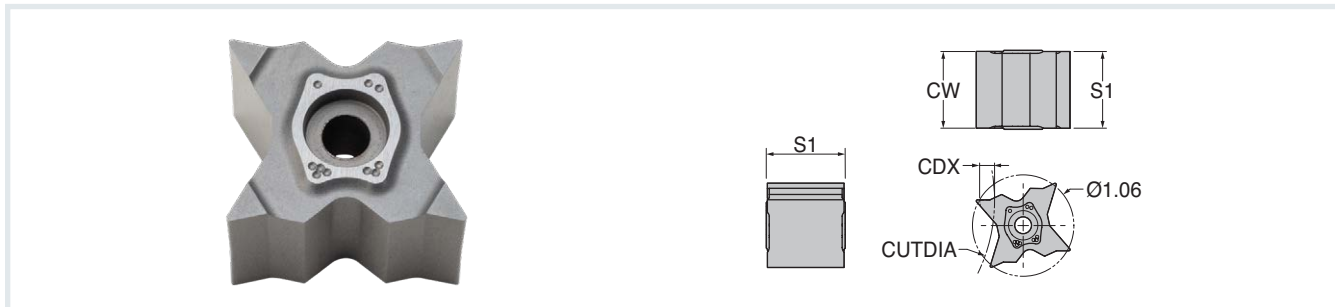
Part Number	H Shank Height	HF Funct. Height	B Shank Width	LF Funct. Length	CW Cutting Width	HBH Head Bottom Offset Height	HBKW Head Back Offset Width	Fig.	CNT Coolant Entry Thread Size	Insert
METRIC										
TQHR/L 20-27-10EW-TB	20 mm	20 mm	20 mm	120 mm	10.5 mm	13 mm	-	1	G 1/8	TQBS 27-10EW
TQHR/L 20-27-15EW-TB	20 mm	20 mm	20 mm	120 mm	15.5 mm	13 mm	-	1	G 1/8	TQBS 27-15EW
TQHR/L 20-27-20EW-TB	20 mm	20 mm	20 mm	120 mm	20.5 mm	13 mm	5 mm	1	G 1/8	TQBS 27-20EW
TQHR/L 25-27-10EW-TB	25 mm	25 mm	25 mm	135 mm	10.5 mm	8 mm	-	2	G 1/8	TQBS 27-10EW
TQHR/L 25-27-15EW-TB	25 mm	25 mm	25 mm	135 mm	15.5 mm	8 mm	-	2	G 1/8	TQBS 27-15EW
TQHR/L 25-27-20EW-TB	25 mm	25 mm	25 mm	135 mm	20.5 mm	8 mm	-	2	G 1/8	TQBS 27-20EW

Hardware

Part Number	Clamping Pin	Pin Screw	Side Screw	Plug	Torx Driver	Hex Driver	Hex Driver
TQHR/L 20...10EW-TB	PIN-TQ-W-T	TS 40F120A	BH M4X0.7X16-D7	PLG G1/8-L6.5	T 15	L-W 2.5	L-W 5
TQHR/L 20...15EW-TB	PIN-TQ-W-T	TS 40F120A	BH M4X0.7X20-D7	PLG G1/8-L6.5	T 15	L-W 2.5	L-W 5
TQHR/L 20...20EW-TB	PIN-TQ-W-T	TS 40F120A	BH M4X0.7X23-D7	PLG G1/8-L6.5	T 15	L-W 2.5	L-W 5
TQHR/L 25...10EW-TB	PIN-TQ-W-T	TS 40F120A	BH M4X0.7X16-D7	-	T 15	L-W 2.5	-
TQHR/L 25...15EW-TB	PIN-TQ-W-T	TS 40F120A	BH M4X0.7X20-D7	-	T 15	L-W 2.5	-
TQHR/L 25...20EW-TB	PIN-TQ-W-T	TS 40F120A	BH M4X0.7X23-D7	-	T 15	L-W 2.5	-

Series TQBS 27-EW

4-EDGE, SEMI-FINISHED INSERT BLANKS FOR WIDE SPECIAL FORM GROOVING



Part Number	Dimension (inch)			CUTDIA Cutting Diameter										Grade
	CW Cutting Width	S1 Thickness (Overall)	CDX Cutting Dia. Max.	CDX ≤ .118	CDX ≤ .138	CDX ≤ .157	CDX ≤ .177	CDX ≤ .197	CDX ≤ .217	CDX ≤ .224	CDX ≤ .236	CDX ≤ .244	CDX ≤ .252	
INCH														
TQBS 27-10EW	.413 (10.5mm)	.437	.252	N.L.	23.62	11.02	7.09	5.31	4.13	3.74	3.35	3.07	2.17	•
TQBS 27-15EW	.610 (15.5mm)	.634	.252	N.L.	23.62	11.02	7.09	5.31	4.13	3.74	3.35	3.07	2.17	•
TQBS 27-20EW	.807 (20.5mm)	.831	.252	N.L.	23.62	11.02	7.09	5.31	4.13	3.74	3.35	3.07	2.17	•

N.L.: No Limit

• = Standard Items