

PARTING & GROOVING

Series

TST-RS

Features

Precision Ground, Single-Ended

Compatible with all T-Clamp Ultra+ Holders

Applications

External Deep Grooving, Turning, & Profiling

Internal Deep Grooving, Turning, & Profiling

Face Grooving & Turning

Insert Widths

3,4,5, 6 mm & .250"

Grades

TT3010 - PVD coated for super alloys

TT9080 - PVD coated for general purpose in variety of materials

K10 - uncoated for aluminum alloys and non-ferrous materials

Materials

-  Steel
-  Stainless Steel
-  Non-Ferrous
-  Super Alloys

TCLAMP™

New TST-RS Insert for Deep Grooving and Turning Applications

- » Precision ground for low cutting forces, even in super alloy machining
- » Single-sided allows for deep grooving & profiling capability
- » Fully compatible with all T-Clamp Ultra+ holders



Ingersoll has introduced the TST-RS precision round type insert for deep turning and grooving applications.

Ingersoll's new single-ended, round-type TST-RS insert is perfect for deep profiling, turning, and grooving. Its sharp cutting edge enables lower cutting loads, resulting in stable machining and an excellent surface finish, even in super alloy machining. This single-ended insert, with the same geometry as the double-ended TDT-RS insert, is capable of deep depth of cut machining where demand has recently grown.

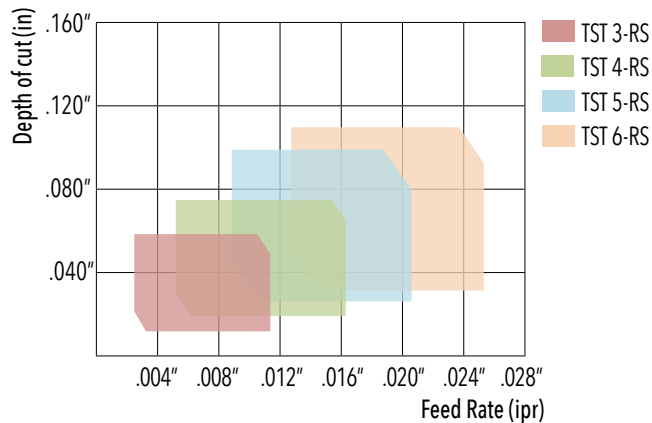
Features & Benefits

- For external and internal profiling, turning, and grooving applications
- Precision machining and excellent repeatability
- Low cutting force and good surface finish due to the insert's sharp cutting edge
- Good chip control over a wide medium-to-finishing machining range
- TT3010 grade provides excellent tool life in super alloy machining

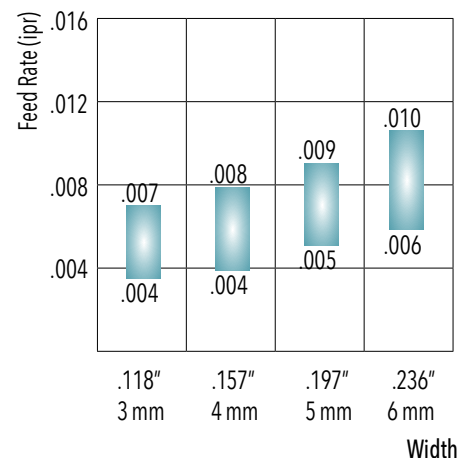


Cutting Conditions

- Turning

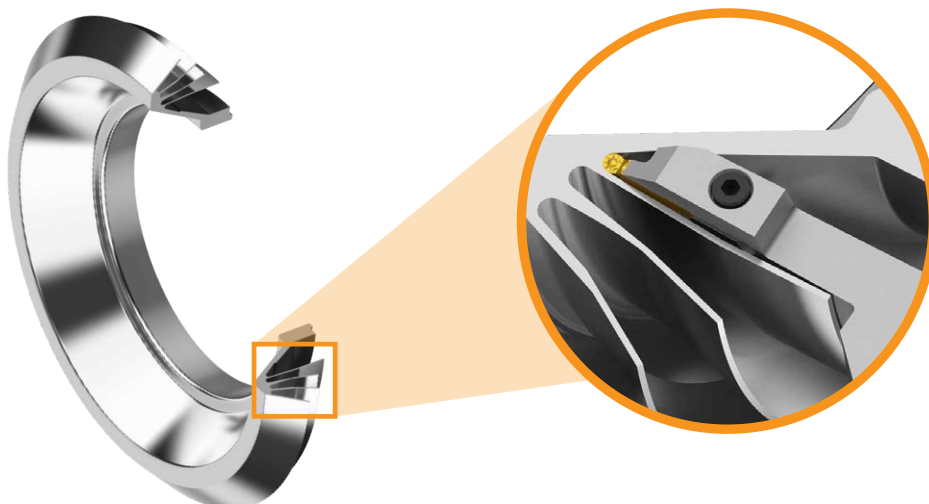
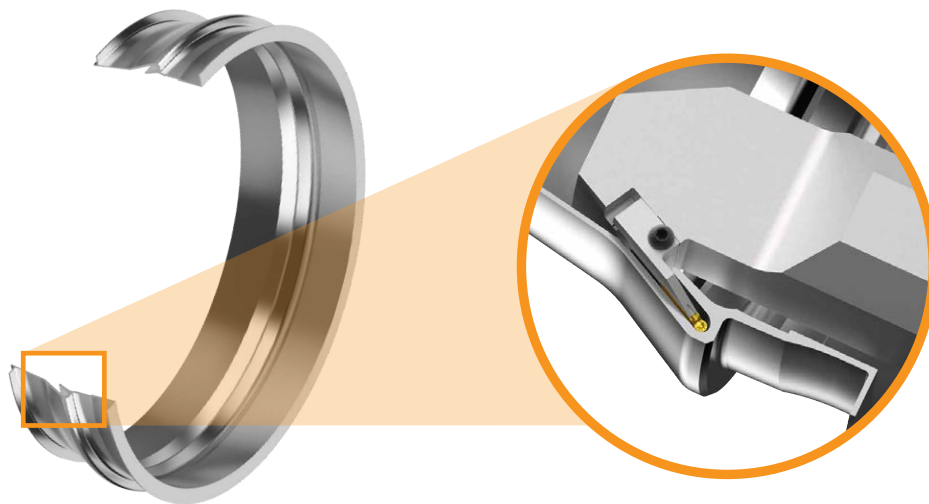


- Grooving



Applications

Capable of deep machining, perfect for tough sectors like aerospace



Face Groove/
Turn



ID FNR
Groove/Turn



ID FNR
Profile



OD FNR
Groove/Turn

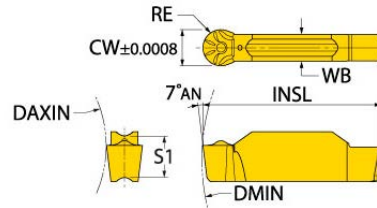


OD FNR
Profile



Series TST-RS

SINGLE-ENDED INSERTS FOR DEEP GROOVING, TURNING, & PROFILING



Size	Dimensions (inch)			
	CW Cutting Width	RE Corner Radius	WB Body Width	INS L Insert Length
3.00E-1.50	.118	.059	.094	.780
4.00E-2.00	.157	.079	.118	.780
5.00E-2.50	.197	.098	.157	.984
6.00E-3.00	.236	.118	.197	.984
6.35E-3.18	.250	.125	.197	.984

Part Number	SSC Insert Seat Size	Turning				Grooving		Grade		
		ap (inch)		fn (ipr)		fn (ipr)		TT3010	TT9080	K10
		Min.	Max.	Feed Min.	Feed Max.	Feed Min.	Feed Max.			
INCH										
TST3.00E-1.50-RS	3	.000	.059	.006	.011	.004	.007	•	•	
TST4.00E-2.00-RS	4	.000	.079	.007	.014	.004	.008	•	•	
TST5.00E-2.50-RS	5	.000	.098	.010	.021	.005	.009	•	•	
TST6.00E-3.00-RS	6	.000	.118	.012	.026	.006	.011	•	•	
TST6.35E-3.18-RS	6	.000	.118	.012	.026	.006	.011	•		•

• = Standard Items



<< Scan the QR code for cutting speed guidelines.