NPA

NEW

New Product Announcement

Member IMC Group Ingersoll Cutting Tools

TURNING

Applications

Super-finishing of non-ferrous materials

Insert Shapes/Sizes

CCGT 32.50.5, 32.51,431,432
DCGT 21.50.5, 21.51, 32.50.5, 32.51,32.52
VCGT 331, 332

Chipbreaker

CF – Finishing applications

Grade

TD1020 – PCD for general turning of non-ferrous materials

Materials

Non-Ferrous

ISOTURN™

PCD Inserts with CF Chipbreaker for Finishing

- Laser etched chipbreaker for light depth of cut applications
- Capable of chip breaking at depths of cut as low as .004"
- PCD allows for maximum speed and wear resistance in non-ferrous machining

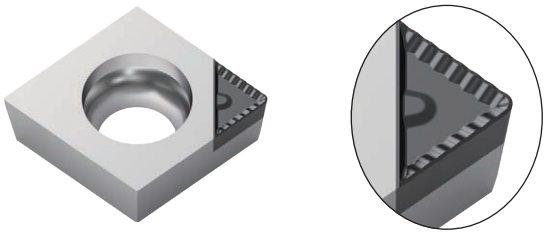
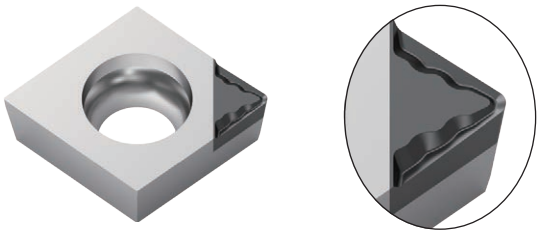
For more information »

ingersoll-imc.com

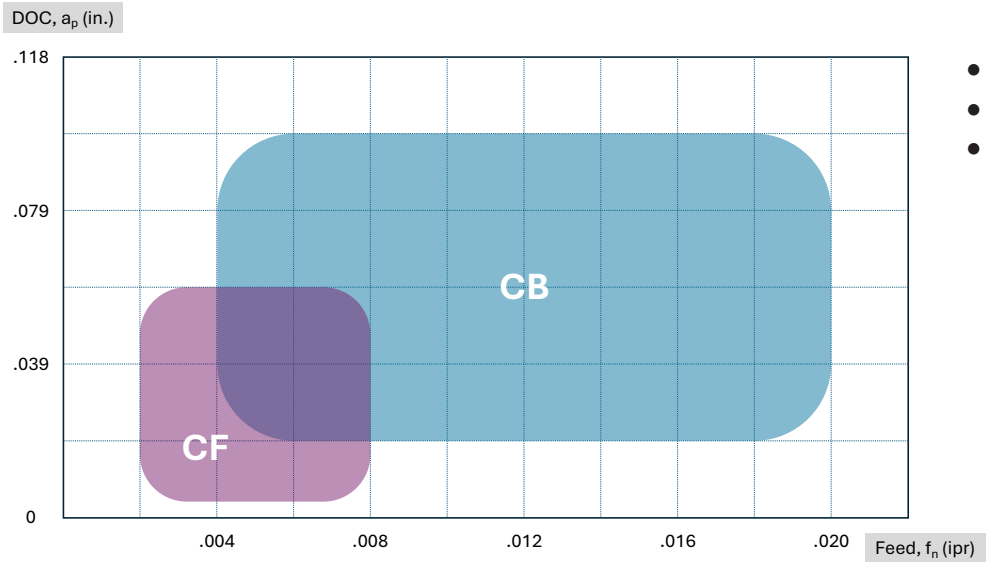
Ingersoll introduces the new CF chipbreaker for finishing of non-ferrous materials

Long, stringy chips are often seen in finish machining of non-ferrous materials. This lack of chip control can lead to machine downtime that decreases productivity. The new CF chipbreaker is capable of breaking chips even in low depth of cut machining of non-ferrous materials. These new inserts are offered in PCD grade TD1020, which allow for a wide range of non-ferrous material machining.

PCD Type Chipbreakers

CB: For roughing to medium	new CF: For finishing
	

Chip Control Range



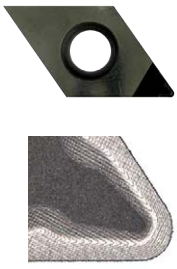
- Insert: DCGT32.51CB/CF TD1020
- Cutting Speed (V_c): 2600 SFM
- Material: 356.0-T6 Aluminum

Chip Comparison Table

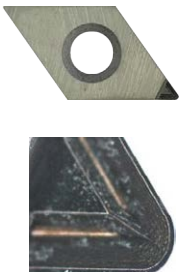
-Excellent chip breaking even in less than .020" depth of cut machining

Material	356.0-T6 Aluminum, Ø5"	Application	External turning	Cutting Speed	2600 SFM

Ingersoll

 DCGT32.51CF	.020"			
	.012"			
	.008"			
	a_p (in.)	.002"	.004"	.008"
		Feed, f_n (ipr)		

Competitor A

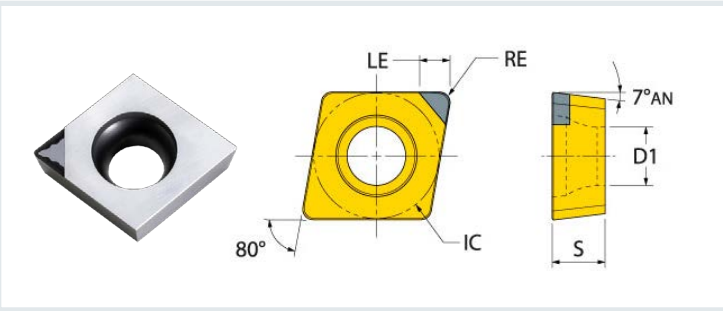
 D-type insert	.020"			
	.012"			
	.008"			
	a_p (in.)	.002"	.004"	.008"
		Feed, f_n (ipr)		

Competitor B

 D-type insert	.020"			
	.012"			
	.008"			
	a_p (in.)	.002"	.004"	.008"
		Feed, f_n (ipr)		

CCGT CF

POSITIVE 80° RHOMBIC INSERTS FOR FINISHING APPLICATIONS



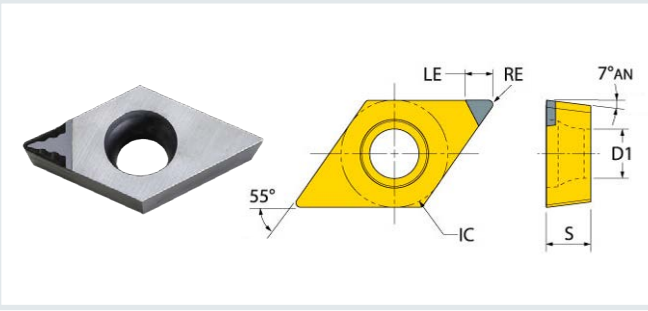
Size	Dimensions (in.)					
	NOI No. of Indexes	IC Inscribed Circle	S Thickness	RE Corner Radius	LE Cutting Edge Eff. Length.	D1 Fixing Hole Dia.
32.50.5	1	.375	.156	.008	.161	.173
32.51	1	.375	.156	.016	.161	.173
431	1	.500	.187	.016	.161	.217
432	1	.500	.187	.031	.157	.217

Part Number		ap (in.)		Feed (ipr)		PCD
Ansi	ISO	Min.	Max.	Min.	Max.	TD1020
CCGT32.50.5CF	CCGT09T302CF	.004	.039	.002	.008	•
CCGT32.51CF	CCGT09T304CF	.004	.039	.002	.008	•
CCGT431CF	CCGT120404CF	.004	.039	.002	.008	•
CCGT432CF	CCGT120408CF	.004	.039	.002	.008	•

• = Standard Items

DCGT CF

POSITIVE 55° RHOMBIC INSERTS FOR FINISHING APPLICATIONS



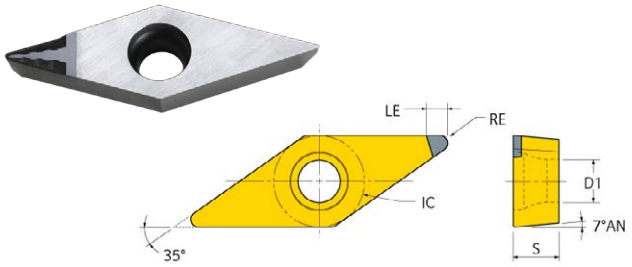
Size	Dimensions (in.)					
	NOI No. of Indexes	IC Inscribed Circle	S Thickness	RE Corner Radius	LE Cutting Edge Eff. Length.	D1 Fixing Hole Dia.
21.50.5	1	.250	.094	.008	.134	.110
21.51	1	.250	.094	.016	.130	.110
32.50.5	1	.375	.156	.008	.193	.173
32.51	1	.375	.156	.016	.185	.173
32.52	1	.375	.156	.031	.181	.173

Part Number		ap (in.)		Feed (ipr)		PCD
Ansi	ISO	Min.	Max.	Min.	Max.	TD1020
DCGT21.50.5CF	DCGT070202CF	.004	.039	.002	.008	•
DCGT21.51CF	DCGT070204CF	.004	.039	.002	.008	•
DCGT32.50.5CF	DCGT11T302CF	.004	.059	.002	.008	•
DCGT32.51F	DCGT11T304CF	.004	.059	.002	.008	•
DCGT32.52CF	DCGT11T308CF	.004	.059	.002	.008	•

• = Standard Items

VCGT CF

POSITIVE 35° RHOMBIC INSERTS FOR FINISHING APPLICATIONS



Size	Dimensions (in.)					
	NOI No. of Indexes	IC Inscribed Circle	S Thickness	RE Corner Radius	LE Cutting Edge Eff. Length.	D1 Fixing Hole Dia.
331	1	.375	.187	.016	.287	.150
332	1	.375	.187	.031	.252	.150

Part Number		ap (in.)		Feed (ipr)		PCD
Ansi	ISO	Min.	Max.	Min.	Max.	TD1020
VCGT331CF	VCGT160404CF	.004	.079	.002	.008	•
VCGT332CF	VCGT160408CF	.004	.079	.002	.008	•

• = Standard Items