

NEW

Member IMC Group
Ingersoll
Cutting Tools

SPEEDUP
HIGH SPEED & FEED

GOLDSFEED

HIGH FEED MILL 15G1B

HIGH FEED MILL 15G1B

- *Very smooth cutting geometry*
- *4-edged insert*
- *2 different insert geometries with 3 different carbide grades each*
- *Screw-in type milling cutter with TopOn and TS-adaption*
- *End mill cylindrical*
- *Tool diameter range: Ø10/12/16/20/25 mm*



Product Overview

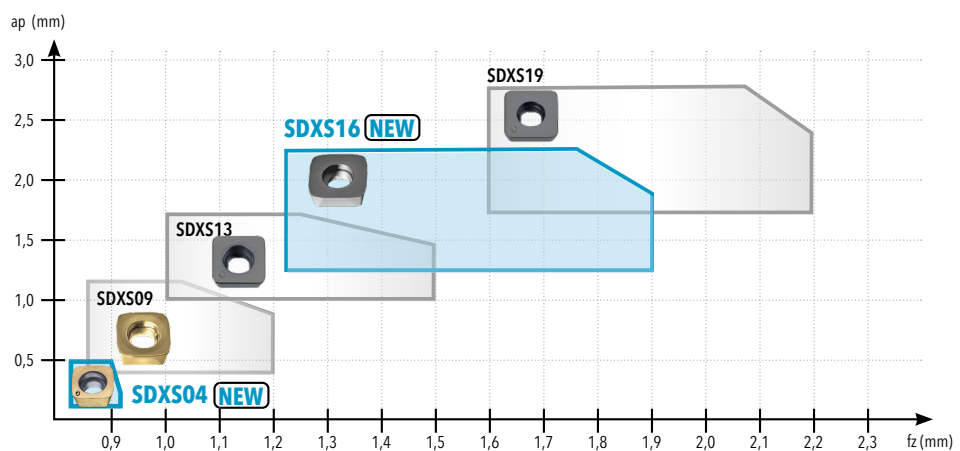
New high feed milling cutter for roughing in diameter range from Ø 10 - 25 mm.

Various insert geometries for machining steel, cast iron and materials of machining group **M** (stainless steel) and material group **S** (heat-resistant alloys and titanium alloys), as well as hard milling up to 48 HRC.

In the course of the **SFeedUp** product presentation, the product description of our entire high feed cutter series of square inserts changes from **GoldQuadF** to **GoldSFeed**. The extension of the **GoldSFeed** high feed tools are offered as end mills, screw-in type milling cutters with metric adaption, as well as in the design of our proven Ts adaption.

Application Range

Face and contour milling in general mechanical engineering, die and mold industry and above all in aerospace industry.



Technical Features

4-edged insert with cutting depths ap up to 0.5 mm. Different geometries for stable and unstable conditions. Neutral and positive geometries in 3 different carbide grades each for a wide variety of applications enable max. cutting volume even with difficult applications. Ø10 with Z = 2 up to Ø25 with Z = 6 as narrow spaced tools for high productive machining.

The machining of 90° shoulders can be carried out without any problems due to the secondary cutting edge on the cutting Ø 90°. In contrast to the series with the 13th and 19th inserts, in this new 04th series the effective Ø is retained even when changing from neutral to positive cutting edge. Thus the nominal Ø is also the effective diameter for programming. The programming radius is R0.9 mm.

Recommended cutting values can be found in the manual for cutting values for milling and drilling tools.

Advantages

- Smooth cutting, axially positive insert seat
- Cutting depth up to 0,5 mm
- 4-edged insert
- 2 different insert geometries with 3 different carbide grades each
- End mill cylindrical / TopOn screw-in type mill / screw-in type mill with Ts-adaption
- Cutting tool diameter Ø10 with Z=2 up to Ø25 with Z=6
- No diameter changes when using different insert geometries
- Protective cutting edge for 90° shoulder milling

SDXS04



Insert:	SDXS0402MPR-MR1	SDXS0402MPR-MM
Recommended cutting depth:	ap = 0,5 mm	ap = 0,5 mm
Machining group:	P / K / H	P / M / S

Recommended cutting data

ISO	material	cutting speed Vc [m/min]				feed per tooth fz [mm]
		1st choice dry machining resp. wear resistant carbide		1st choice wet machining resp. rough carbide		
P	unalloyed steel	IN2505	160 - 220	IN2530	130 - 180	0,4 - 0,9
	alloyed steel 800 N/mm ²	IN2505	140 - 200	IN2530	110 - 160	0,4 - 0,8
	alloyed steel 1100 N/mm ²	IN2505	120 - 180	IN2530	100 - 150	0,4 - 0,7
M	stainless steel	IN2530	90 - 150	IN2530	80 - 130	0,4 - 0,7
K	gray cast iron	IN2505	160 - 250	IN2530	140 - 200	0,4 - 0,9
	nodular cast iron	IN2505	140 - 200	IN2530	120 - 170	0,4 - 0,8
N	aluminum	-	-	-	-	-
S	high temperature alloys	IN2530	50 - 80	IN2530	50 - 70	0,4 - 0,6
	titanium alloys	-	-	IN2530	30 - 40	0,3 - 0,5
H	hard machining < 48 HRC	IN2505	60 - 100	-	-	0,2 - 0,5
	hard machining < 63 HRC	-	-	-	-	-

Tips:

- The worse the material machinability, the smaller the tool engagement should be chosen.
- The smaller the cutting tool diameter, the higher the cutting speed can be.
- Approaching feed rate should be reduced by 30%.
- 4-edged insert
- Programming radius R0,9

Ramping angle and circular interpolation:

tool diameter [mm]	max. ramp. angle [°]	min. bore dia. [mm]	max. ap/rev [mm]	max. bore dia. [mm]
10	9°	13	0,5	20
12	6°	17	0,5	24
16	3,2°	25	0,5	32
20	2,1°	33	0,5	40
25	1,5°	43	0,5	50

General information:

Insert screw:

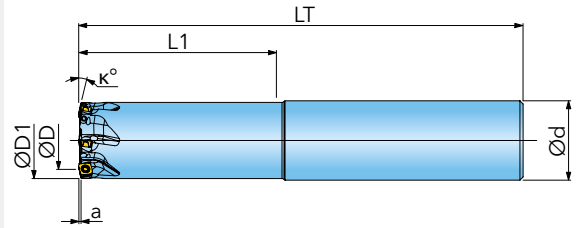
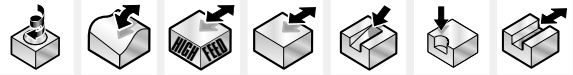
Diameter Ø 10 - 12: **SM18-033-00**
 Diameter Ø 16 - 25: **SM18-041-00**

Torque: **0,5 Nm**
 Torque: **0,5 Nm**

Torque wrench: **DTN005S with bit DS-TP06TB**
 Torque wrench: **DTN005S with bit DS-TP06TB**

GOLDFEED HIGH FEED MILL 15G1B...T

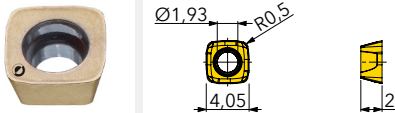
ADAPTION ACC. TO DIN 1835 A



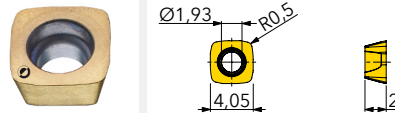
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15G1B010030T1R00	3,6	10	10	80	30	12	0,5	1	2	✓	0,042
15G1B012030T2R00	5,6	12	12	80	30	12	0,5	1	3	✓	0,059
15G1B016040T3R00	9,6	16	16	100	40	12	0,5	1	4	✓	0,134
15G1B020050T4R00	13,6	20	20	130	50	12	0,5	1	5	✓	0,279
15G1B025060T5R00	18,6	25	25	140	60	12	0,5	1	6	✓	0,487

Rp = Programming radius

SDXS0402MPR-MM



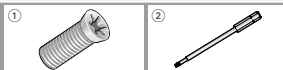
SDXS0402MPR-MR1



Designation	fz(min/max)	Design	Grade	IN2505		IN2530							
SDXS0402MPR-MM	0,50/0,80	positive geometry, convex											
SDXS0402MPR-MR1	0,50/0,80	neutral geometry, convex											

● = P ● = M ● = K ● = N ● = S ○ = H

SPARE PARTS



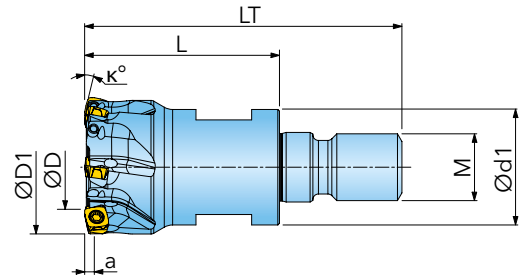
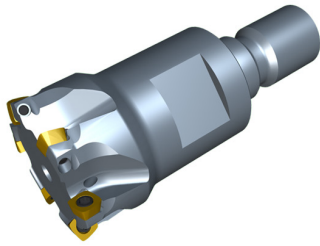
Diameter range

3,6 - 5,6	SM18-033-00 (0,5Nm)	TXPLUS06x90-B
9,6 - 18,6	SM18-041-00 (0,5Nm)	TXPLUS06x90-B

① = Insert screw ② = Torx-bit

GOLDSPEED HIGH FEED MILL 15G1B...X

WITH SCREW-IN TYPE ADAPTION



Designation	D	D1	d1	LT	L	κ	a	Rp	M	Z		
15G1B010017X4R00	3,6	10	9,8	31,5	17	12	0,5	1	M6	2	✓	0,010
15G1B012023X4R00	5,6	12	11,8	37,5	23	12	0,5	1	M6	3	✓	0,017
15G1B016023X5R00	9,6	16	13	40,8	23	12	0,5	1	M8	4	✓	0,026
15G1B020030X6R00	13,6	20	18	49,8	30	12	0,5	1	M10	5	✓	0,060
15G1B025035X7R00	18,6	25	21	57	35	12	0,5	1	M12	6	✓	0,103

Rp = Programming radius

SDXS0402MPR-MM		SDXS0402MPR-MR1									
Designation	fz(min/max)	Design	Grade	IN2505	IN2530						
SDXS0402MPR-MM	0,50/0,80	positive geometry, convex									
SDXS0402MPR-MR1	0,50/0,80	neutral geometry, convex									

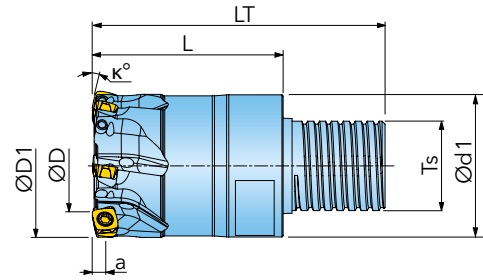
● = P ● = M ● = K ● = N ● = S ○ = H

SPARE PARTS		
Diameter range		
3,6 - 5,6	SM18-033-00 (0,5Nm)	TXPLUS06x90-B
9,6 - 18,6	SM18-041-00 (0,5Nm)	TXPLUS06x90-B

① = Insert screw ② = Torx-bit

GOLDFEED HIGH FEED MILL 15G1B...

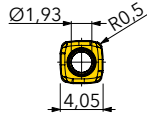
FÜR WECHSELKOPFSYSTEM



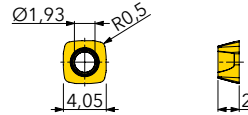
Designation	D	D1	d1	LT	L	κ	a	Rp	Ts	Z		
15G1B010016T6R00	3,6	10	9,7	22,65	16	12	0,5	1	T6	2	✓	0,008
15G1B012017T8R00	5,6	12	11,5	25	17	12	0,5	1	T8	3	✓	0,012
15G1B016019T10R00	9,6	16	15,2	30,8	19	12	0,5	1	T10	4	✓	0,026
15G1B020022T12R00	13,6	20	18,3	35,8	22	12	0,5	1	T12	5	✓	0,048
15G1B025032T15R00	18,6	25	23,9	49,6	32	12	0,5	1	T15	6	✓	0,114

Rp = Programming radius

SDXS0402MPR-MM



SDXS0402MPR-MR1



Designation	fz(min/max)	Design	Grade	IN2505		IN2530							
SDXS0402MPR-MM	0,50/0,80	positive geometry, convex											
SDXS0402MPR-MR1	0,50/0,80	neutral geometry, convex											

● = P ● = M ● = K ● = N ● = S ○ = H

SPARE PARTS



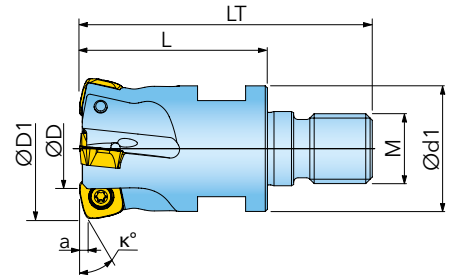
Diameter range

3,6 - 5,6	SM18-033-00 (0,5Nm)	TXPLUS06x90-B
9,6 - 18,6	SM18-041-00 (0,5Nm)	TXPLUS06x90-B

① = Insert screw ② = Torx-bit

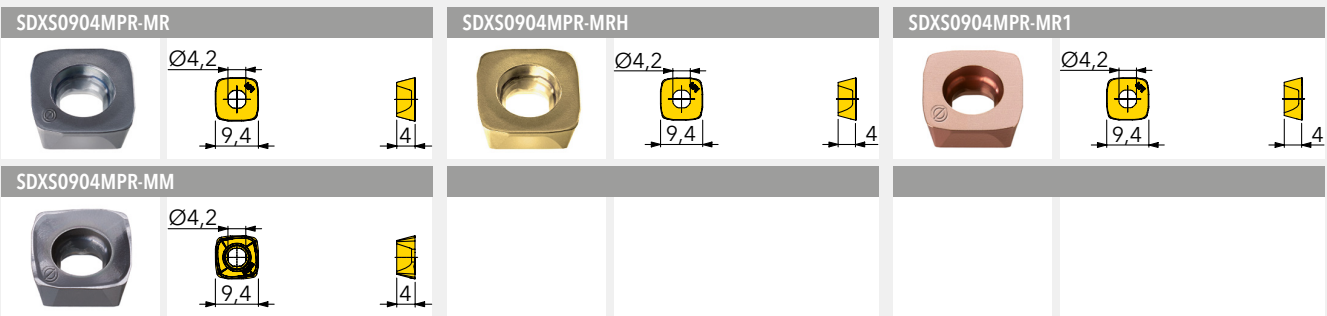
GOLDSPEED HIGH FEED MILL 15G1F...X

SCREW-IN TYPE ADAPTION



Designation	D	D1	d1	LT	L	κ	a	Rp	M	Z			
15G1F025035X7R00	12,9	25	21	57	35	12	1,5	2,5	M12	3	5,5	✓	0,09
15G1F030043X8R00	17,9	30	29	67	43	12	1,5	2,5	M16	3	3,5	✓	0,15
15G1F032043X8R00	19,9	32	29	67	43	12	1,5	2,5	M16	4	3,3	✓	0,20
15G1F035043X8R00	22,9	35	29	67	43	12	1,5	2,5	M16	4	2,6	✓	0,22
15G1F040043X8R00	27,8	40	29	67	43	12	1,5	2,5	M16	5	2,2	✓	0,24
15G1F042043X8R00	29,8	42	29	67	43	12	1,5	2,5	M16	5	2,0	✓	0,26

Rp = Programming radius



Designation	fz(min/max)	Design	Grade	IN2504	IN2505	IN2530	IN4005	IN4030	IN4035	IN7035
SDXS0904MPR-MR	0,50/1,50	neutral geometry, convex, chamfered								
SDXS0904MPR-MRH	0,50/1,50	neutral geometry, convex, chamfered								
SDXS0904MPR-MR1	0,50/1,50	neutral geometry, convex, sharp								
SDXS0904MPR-MM	0,50/1,50	positive geometry, convex, chamfered								

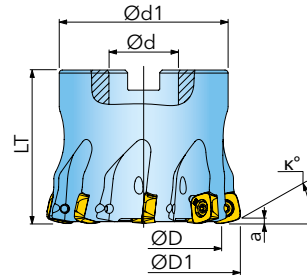
● = P ● = M ● = K ● = N ● = S ○ = H

SPARE PARTS		
	SM30-075-R0 (2,0Nm)	TX09x90-B

① = Insert screw ② = Torx-bit

GOLDFEED HIGH FEED MILL 5G_F

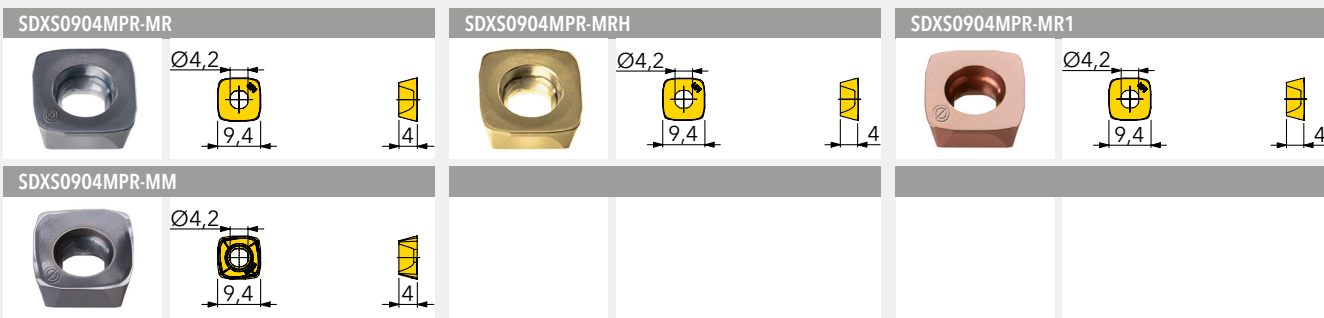
ADAPTION ACC. TO DIN 8030



Designation	D	D1	d	d1	LT	κ	a	Rp	Z			
5G6F040R00	27,8	40	16	38	40	12	1,5	2,5	4	2,2	✓	0,24
5G5F040R00 ¹⁾	27,8	40	16	38	40	12	1,5	2,5	5	2,2	✓	0,24
5G6F042R00	29,8	42	16	38	40	12	1,5	2,5	4	2,0	✓	0,27
5G5F042R00 ¹⁾	29,8	42	16	38	40	12	1,5	2,5	5	2,0	✓	0,27
5G6F050R00	37,8	50	22	45	50	12	1,5	2,5	6	1,5	✓	0,43
5G5F050R00 ¹⁾	37,8	50	22	45	50	12	1,5	2,5	7	1,5	✓	0,43
5G6F052R00	39,8	52	22	40	50	12	1,5	2,5	6	1,3	✓	0,46
5G5F052R00 ¹⁾	39,8	52	22	40	50	12	1,5	2,5	7	1,3	✓	0,46
5G6F063R00	50,8	63	22	55	50	12	1,5	2,5	7	1,1	✓	0,75
5G5F063R00 ¹⁾	50,8	63	22	55	50	12	1,5	2,5	8	1,1	✓	0,75
5G6F066R00	53,8	66	27	50	50	12	1,5	2,5	7	1,0	✓	0,80
5G5F066R00 ¹⁾	53,8	66	27	50	50	12	1,5	2,5	8	1,0	✓	0,80
5G6F080R00	67,8	80	27	70	50	12	1,5	2,5	7	0,6	✓	1,20
5G5F080R00 ¹⁾	67,8	80	27	70	50	12	1,5	2,5	9	0,6	✓	1,20
5G6F085R00	72,8	85	27	70	50	12	1,5	2,5	8	0,4	✓	1,27
5G5F085R00 ¹⁾	72,8	85	27	70	50	12	1,5	2,5	10	0,4	✓	1,27

Rp = Programming radius

¹⁾ narrow pitch



Designation	fz(min/max)	Design	Grade	IN2504	IN2505	IN2530	IN4005	IN4030	IN4035	IN7035
SDXS0904MPR-MR	0,50/1,50	neutral geometry, convex, chamfered								
SDXS0904MPR-MRH	0,50/1,50	neutral geometry, convex, chamfered								
SDXS0904MPR-MR1	0,50/1,50	neutral geometry, convex, sharp								
SDXS0904MPR-MM	0,50/1,50	positive geometry, convex, chamfered								

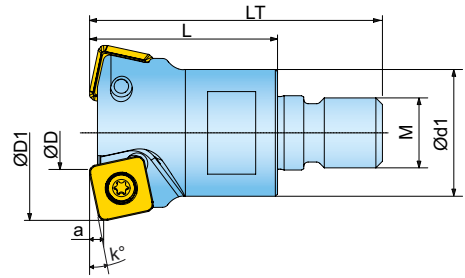
● = P ● = M ● = K ● = N ● = S ○ = H

SPARE PARTS		
	SM30-075-RO (2,0Nm)	TX09x90-B

① = Insert screw ② = Torx-bit

GOLDSPEED HIGH FEED MILL 15M1P...X

SCREW-IN TYPE ADAPTION



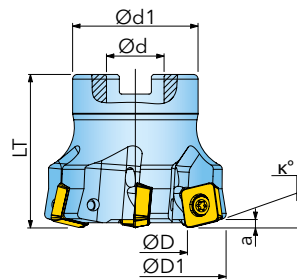
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15M1P032043X8R00	11	32	29	67	43	12	2	M16	2	10	✓	0,17
15M1P035043X8R00	14	35	29	67	43	12	2	M16	2	8	✓	0,17
15M1P040043X8R00	19	40	29	67	43	12	2	M16	3	5	✓	0,19
15M1P042043X8R00	21	42	29	67	43	12	2	M16	3	5	✓	0,20
15M1P032043X8R01 ¹⁾	11	32	29	67	43	12	2	M16	2	10	✓	0,17
15M1P035043X8R01 ¹⁾	14	35	29	67	43	12	2	M16	2	8	✓	0,17
15M1P042043X8R01 ¹⁾	21	42	29	67	43	12	2	M16	3	5	✓	0,20

* fz-values / Programming radii see manual 'Cutting Data for Milling and Boring Tools'

¹⁾for use of *MPR-insert geometry eff. diameter (D1)

GOLDSFEED HIGH FEED MILL 5M_P

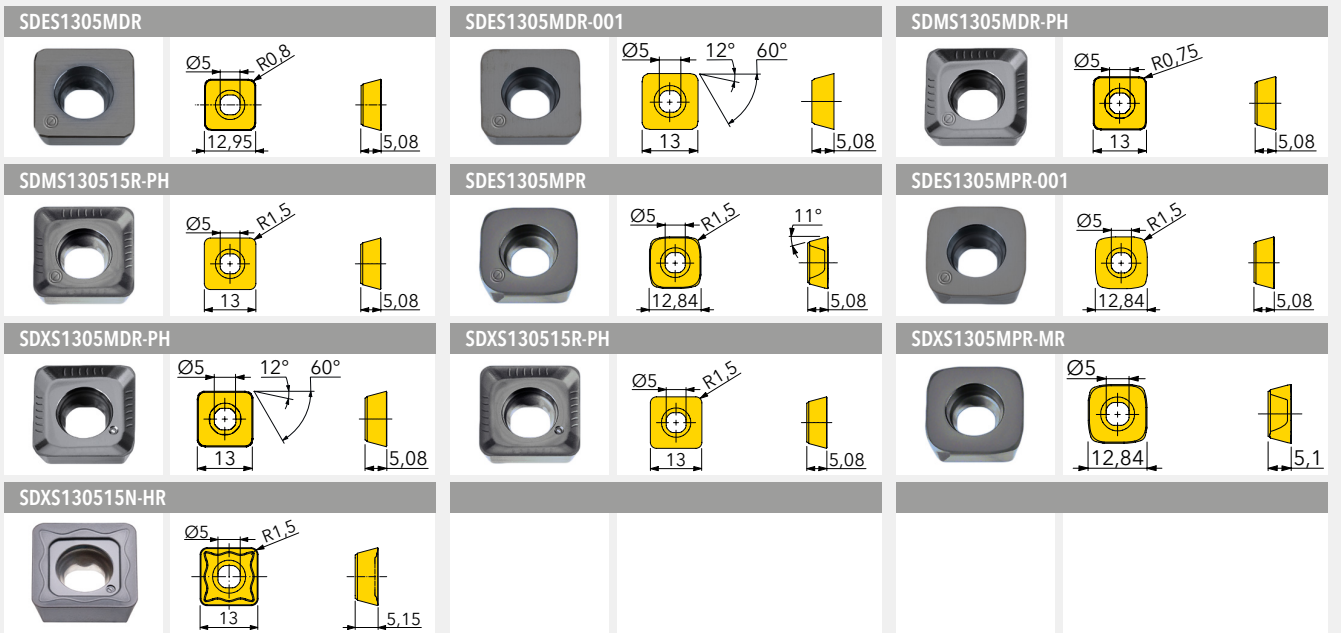
ADAPTION ACC. TO DIN 8030



Designation	D	D1	d	d1	LT	κ	a	Z			
5M6P050R00	29	50	22	45	50	12	2	4	3,5	✓	0,34
5M5P050R00 ¹⁾	29	50	22	45	50	12	2	5	3,5	✓	0,33
5M5P050R01 ¹⁾	29	50	22	45	50	12	2	6	3,5	✓	0,32
5M6P052R00	31	52	22	40	50	12	2	4	3	✓	0,29
5M5P052R00 ¹⁾	31	52	22	40	50	12	2	5	3	✓	0,28
5M6P063R00	42	63	22	55	50	12	2	5	2,5	✓	0,57
5M5P063R00 ¹⁾	42	63	22	55	50	12	2	6	2,5	✓	0,60
5M6P066R00	45	66	27	48	50	12	2	5	2	✓	0,48
5M5P066R00 ¹⁾	45	66	27	48	50	12	2	6	2	✓	0,50
5M6P080R00	59	80	27	70	50	12	2	6	1	✓	0,97
5M5P080R00 ¹⁾	59	80	27	70	50	12	2	8	1	✓	1,01
5M6P100R00	79	100	32	85	55	12	2	7	0,5	✓	1,75
5M5P100R00 ¹⁾	79	100	32	85	55	12	2	9	0,5	✓	1,74
5M5P052R01 ¹⁾²⁾	31	52	22	40	50	12	2	5	3	✓	0,28
5M5P066R01 ¹⁾²⁾	45	66	27	48	50	12	2	6	2	✓	0,50
5M5P080R01 ¹⁾²⁾	59	80	27	70	50	12	2	8	1	✓	1,01
5M5P100R01 ¹⁾²⁾	79	100	32	85	55	12	2	9	0,5	✓	1,74

* fz-values / Programming radii see manual 'Cutting Data for Milling and Boring Tools'

¹⁾narrow pitch; ²⁾for use of *MPR-insert geometry eff. diameter (D1)



Designation	fz(min/max)	Design	Grade	IN2035	IN2504	IN2505	IN4005	IN4030	IN4035		
SDES1305MDR	*/*	neutral geometry, chamfered				●					
SDES1305MDR-001	*/*	neutral geometry, sharp				●					
SDMS1305MDR-PH	*/*	positive geometry, chamfered				●	●	●	●		
SDMS130515R-PH	*/*	positive geometry, chamfered R1,5				●		●	●		
SDES1305MPR	*/*	neutral geometry, convex, chamfered				●	●			●	
SDES1305MPR-001	*/*	neutral geometry, convex, sharp				●	●	●	●		
SDXS1305MDR-PH	*/*	positive geometry, chamfered						●	●		
SDXS130515R-PH	*/*	positive geometry, chamfered R1,5						●	●		
SDXS1305MPR-MR	*/*	neutral geometry, convex, chamfered			●		●	●			
SDXS130515N-HR	*/*	positive titanium geometry, chamfered R1,5		●							

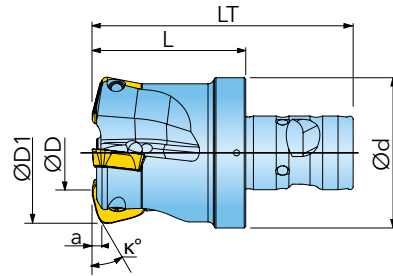
● = P ● = M ● = K ● = N ● = S ○ = H

SPARE PARTS	①	②
	SM40-100-R0 (4,5Nm)	TX15x90-B

① = Insert screw ② = Torx-bit

GOLDFEED HIGH FEED MILL 15G1Q...Z

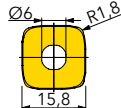
MODULAR INNOFIT ADAPTION



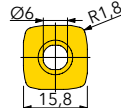
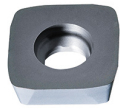
Designation	D	D1	d	LT	L	κ	a	Rp	MOD	Z			
15G1Q050050Z4R00	28,2	50	49	85	50	12	2,5	4,2	40	3	5.2	✓	0,55
15G1Q050050Z4R01	28,2	50	49	85	50	12	2,5	4,2	40	4	5.2	✓	0,54
15G1Q052050Z4R00	30,2	52	49	85	50	12	2,5	4,2	40	3	4.9	✓	0,59
15G1Q052050Z4R01	30,2	52	49	85	50	12	2,5	4,2	40	4	4.9	✓	0,57

Rp = Programming radius

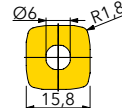
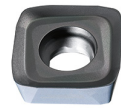
SDXS1605MPR-MR



SDXS1605MPR-MR1



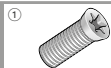
SDXS1605MPR-MM



Designation	fz(min/max)	Design	Grade										
				IN2505	IN2530	IN4035	IN7035						
SDXS1605MPR-MR	0,70/2,00	neutral geometry, convex, chamfered											
SDXS1605MPR-MR1	0,70/2,00	neutral geometry, convex, sharp											
SDXS1605MPR-MM	0,70/2,00	positive geometry, convex, chamfered											

● = P ● = M ● = K ● = N ● = S ○ = H

SPARE PARTS

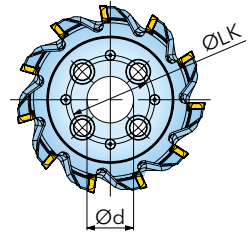
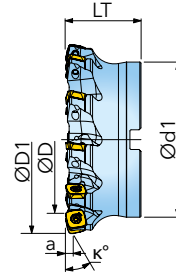


SM50-130-R0 (6,0Nm) TX20x90-B

① = Insert screw ② = Torx-bit

GOLDSPEED HIGH FEED MILL 5G_Q

ADAPTION ACC. TO DIN 8030



Designation	D	D1	d	d1	LT	LK	κ	a	Rp	Z			
5G6Q063R00	41,2	63	22	55	50	-	12	2,5	4,2	4	3.4	✓	0,68
5G5Q063R00	41,2	63	22	55	50	-	12	2,5	4,2	5	3.4	✓	0,69
5G6Q066R00	44,2	66	27	50	50	-	12	2,5	4,2	5	3.1	✓	0,63
5G5Q066R00	44,2	66	27	50	50	-	12	2,5	4,2	6	3.1	✓	0,63
5G6Q080R00	58,2	80	27	70	50	-	12	2,5	4,2	6	2.3	✓	1,17
5G5Q080R00	58,2	80	27	70	50	-	12	2,5	4,2	7	2.3	✓	1,17
5G6Q085R00	63,2	85	27	70	50	-	12	2,5	4,2	7	2.1	✓	1,28
5G5Q085R00	63,2	85	27	70	50	-	12	2,5	4,2	8	2.1	✓	1,28
5G6Q100R00	78,2	100	32	85	55	-	12	2,5	4,2	8	1.65	✓	2,08
5G5Q100R00	78,2	100	32	85	55	-	12	2,5	4,2	9	1.65	✓	2,08
5G6Q125R00	103,2	125	40	100	63	-	12	2,5	4,2	10	1.2	✓	3,50
5G5Q125R00	103,2	125	40	100	63	-	12	2,5	4,2	11	1.2	✓	3,50
5G6Q160R00	138,2	160	40	130	63	66,7	12	2,5	4,2	11	0.7	✓	5,43
5G5Q160R00	138,2	160	40	130	63	66,7	12	2,5	4,2	12	0.7	✓	5,46

Rp = Programming radius

SDXS1605MPR-MR			SDXS1605MPR-MR1			SDXS1605MPR-MM				
Designation	fz(min/max)	Design	Grade	IN2505	IN2530	IN4035	IN7035			
SDXS1605MPR-MR	0,70/2,00	neutral geometry, convex, chamfered								
SDXS1605MPR-MR1	0,70/2,00	neutral geometry, convex, sharp								
SDXS1605MPR-MM	0,70/2,00	positive geometry, convex, chamfered								

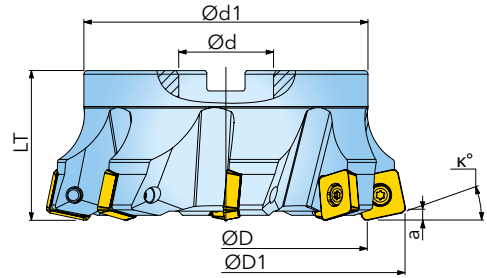
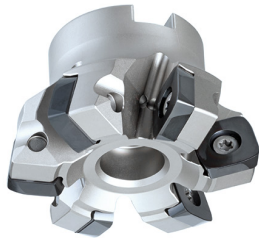
● = P ● = M ● = K ● = N ● = S ○ = H

SPARE PARTS		
	SM50-130-R0 (6,0Nm)	TX20x90-B

① = Insert screw ② = Torx-bit

GOLDFEED HIGH FEED MILL 5G_M

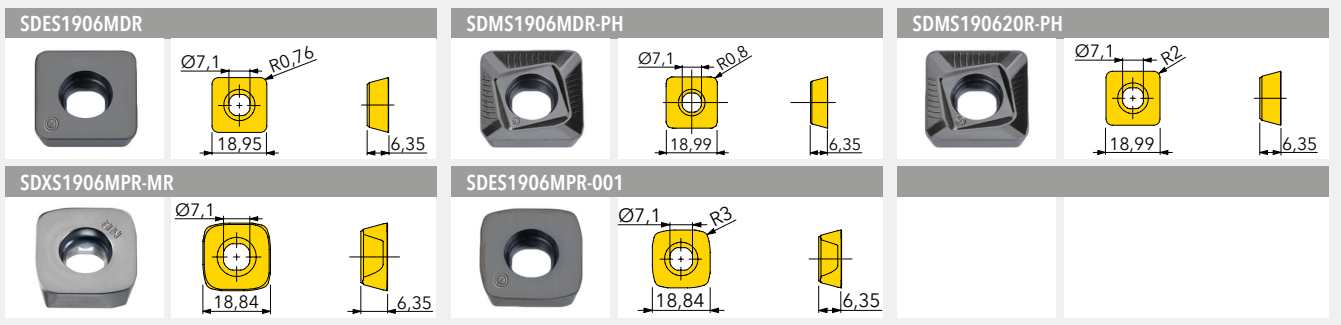
ADAPTION ACC. TO DIN 8030



Designation	D	D1	d	d1	LT	LK	κ	a	Z			
5G6M080R00	48,6	80	27	70	55	-	12	3	5	3,5	✓	1,01
5G5M080R00 ¹⁾	48,6	80	27	70	55	-	12	3	6	3,5	✓	1,02
5G6M100R00	68,6	100	32	85	55	-	12	3	6	2,5	✓	1,63
5G5M100R00 ¹⁾	68,6	100	32	85	55	-	12	3	8	2,5	✓	1,62
5G6M125R00	93,6	125	40	100	63	-	12	3	7	1,5	✓	2,84
5G5M125R00 ¹⁾	93,6	125	40	100	63	-	12	3	9	1,5	✓	2,87
5G6M160R00	128,6	160	40	130	63	66,7	12	3	8	1	✓	4,80
5G5M160R00 ¹⁾	128,6	160	40	130	63	66,7	12	3	10	1	✓	4,82
5G5M080R01 ¹⁾²⁾	48,6	80	27	70	55	-	12	3	6	3,5	✓	1,02
5G5M100R01 ¹⁾²⁾	68,6	100	32	85	55	-	12	3	8	2,5	✓	1,62
5G5M125R01 ¹⁾²⁾	93,6	125	40	100	63	-	12	3	9	1,5	✓	2,87
5G5M160R01 ¹⁾²⁾	128,6	160	40	130	63	66,7	12	3	10	1,0	✓	4,82

* fz-values / Programming radii see manual 'Cutting Data for Milling and Boring Tools'

¹⁾narrow pitch; ²⁾For use of *MPR-insert geometry eff. diameter (D1)



Designation	fz(min/max)	Design	Grade	IN2505	IN4005	IN4030	IN4035				
				SDES1906MDR	*/*	neutral Geometry, chamfered	●				
SDMS1906MDR-PH	*/*	positive Geometry, chamfered	●	●	●	●					
SDMS190620R-PH	*/*	positive Geometry, chamfered R2	●	●	●	●					
SDXS1906MPR-MR	*/*	neutral Geometry, convex, chamfered	●	●	●	●					
SDES1906MPR-001	*/*	neutral Geometry, convex, sharp	●	●	●	●					

● = P ● = M ● = K ● = N ● = S ○ = H

SPARE PARTS	①	②
	SM60-135-R0 (8,0Nm)	DS-T25S

① = Insert screw ② = Screw driver

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