

NEW

Member IMC Group
Ingersoll
Cutting Tools

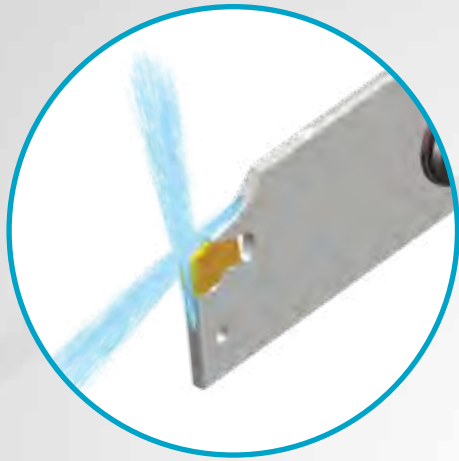
WINSFEED

WINCUT

SINGLE-ENDED RIGID INSERTS
AND HOLDERS SFER/L & SFGB

SINGLE-ENDED RIGID INSERTS AND HOLDERS FOR PARTING AND DEEP GROOVING

- Rigid clamping for excellent durability and repeatability
- User-friendly and rigid insert clamping system
- Improved chip evacuation
- With CoolBurst high pressure coolant system



COOLBURST

No. T348 E / 4-2023

Product Overview

Ingersoll has launched the WINCut, a new line of single-ended rigid inserts and holders for parting and deep grooving

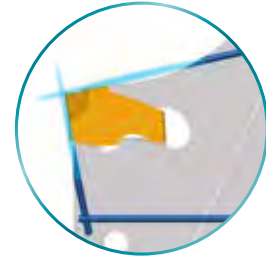
For parting or deep grooving applications, single-ended self-grip inserts are generally used but are susceptible to vibrations due to structural weakness as well as unstable tool life and frequent breakage stemming from bad chip evacuation.

The WINCut line is designed as a thicker height insert and includes a specialized three-area contact with bottom-stopper, which is more robust and stable than the conventional self-grip type. Therefore, it enables improved surface roughness, insert position repeatability and tool life even under tough machining conditions.

The holders are available in two types: a square shank type **SFER/L**, a blade type **SFGB**.

All holders use the **CoolBurst** high pressure coolant system and come as standard products.

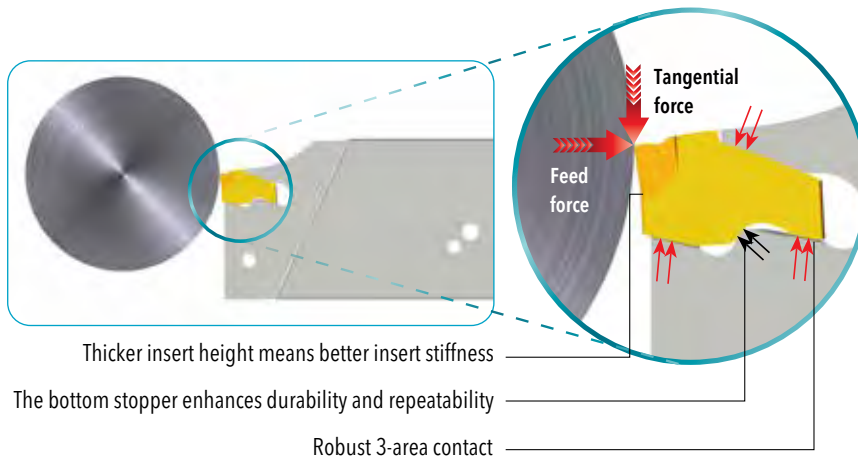
COOLBURST



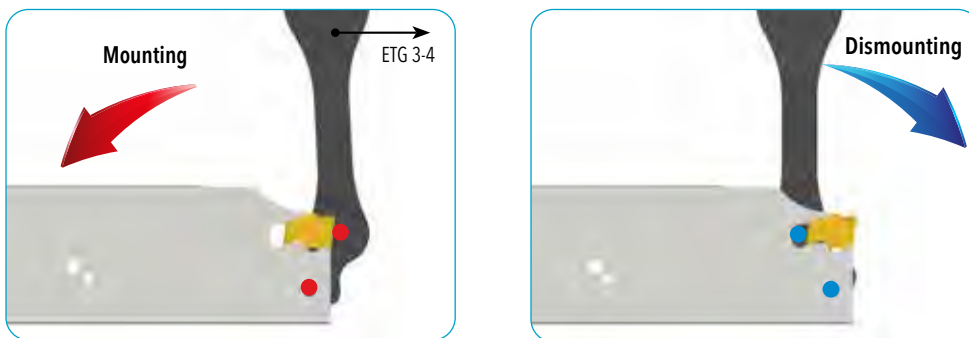
Upper and lower dual high pressure coolant channels

Technical Features

Robust clamping structure and a higher rigidity insert



Self-grip's convenient insert clamping method



Insert Chip Control by Feed Rate

WINCut insert chip control by feed rate

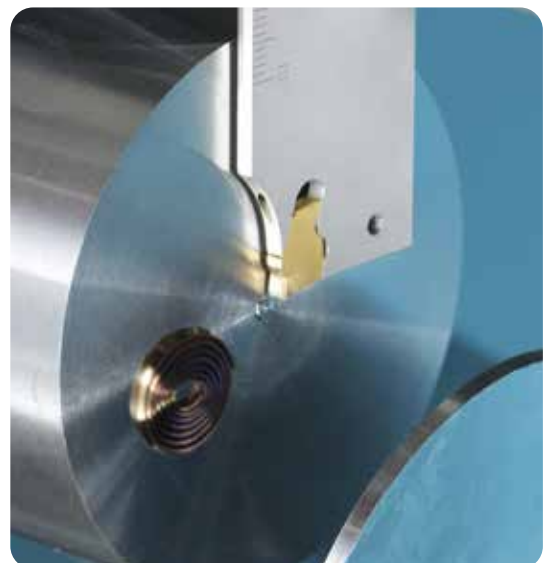
		Ingersoll
Workpiece material		AISI 1045 /C45
Operation		Grooving
Insert		SFC 1.6 TT9080 (Width 1.6mm)
Cutting speed	V (m/min)	140
Feed rate	f (mm/rev)	0.05 / 0.08 / 0.1 / 0.14 / 0.17 / 0.2
Depth of cut	ap (mm)	10
Coolant		wet

Feed f (mm/rev)			
	0.05	0.08	0.1
	0.14	0.17	0.2

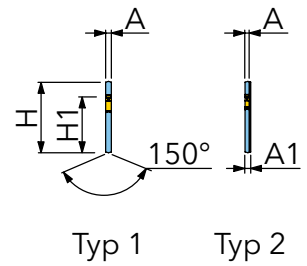
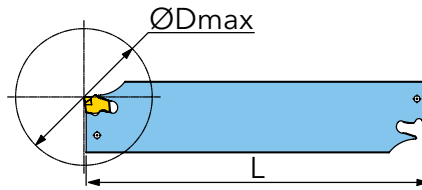
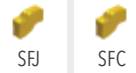
- Excellent chip control in high feed rate conditions


Advantages

- Rigid clamping of the specialized three-area contact design for excellent durability and repeatability
- Insert's increased height enhances rigidity
- User-friendly insert clamping system
- **CoolBurst** holders are available as standard items
 - Stable and improved tool life and improved chip evacuation
- Maximum cutting diameter: Ø100 mm (blade), Ø60 mm (square holder)



BLADES FOR PARTING AND DEEP GROOVING



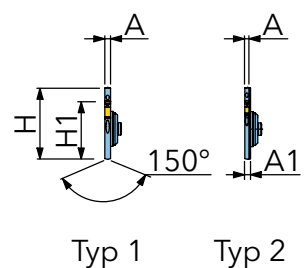
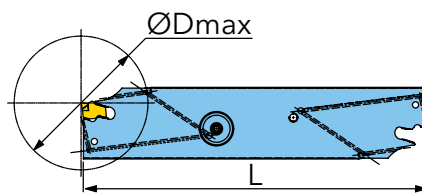
Designation	D max.	L	H	H1	A	A1	Type	Insert-S	kg	
SFGB 32-1.6	38	150	32	24,8	1,3	2,5	2	1	0,25	
SFGB 32-2	50	150	32	24,8	1,8	2,5	2	2	0,25	
SFGB 32-3	100	150	32	24,8	2,5	-	1	3	0,25	




Extractor is not included

1 = Extractor

WINCUT SFGB-TB

BLADES WITH HIGH PRESSURE COOLANT FOR PARTING AND DEEP GROOVING

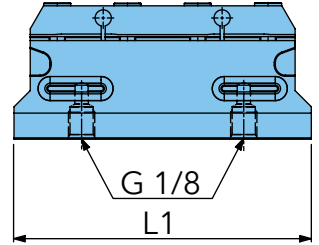
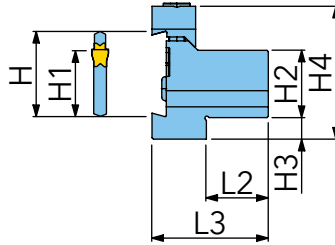


Designation	D max.	L	H	H1	A	A1	Type	Insert-S	kg			
SFGB 32-2-TB	50	150	32	24,8	1,8	2,5	2	2	0,25	✓	ETG 3-4	ETG 3-4
SFGB 32-3-TB	100	150	32	24,8	2,5	-	1	3	0,25	✓	ETG 3-4	ETG 3-4

Extractor is not included

1 = Extractor 2 = Seal screw

BLOCKS WITH COOLANT SUPPLY FOR PARTING AND DEEP GROOVING BLADES

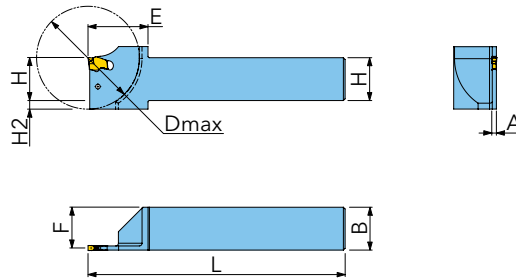



Designation	L1	L2	L3	H	H1	H2	H3	H4	B	kg	IK
TTBU 20-32-TB	100	19	39,2	32	24,8	20	15	36,4	5,3	0,66	✓
TTBU 25-32-TB	110	23	43,2	32	24,8	25	8	41,4	5,3	0,88	✓
TTBU 32-32-TB	110	29	49,2	32	24,8	32	5	48,4	5,3	1,24	✓

Designation	1	2	3	4
TTBU 20-32-TB	SR M6X16 DIN912	BKU 100	O-RING ID14X2.5	LW 5
TTBU 25-32-TB	SR M6X16 DIN912	BKU 110	O-RING ID14X2.5	LW 5
TTBU 32-32-TB	SR M6X16 DIN912	BKU 110	O-RING ID14X2.5	LW 5

1 = Clamp screw 2 = Clamp 3 = O-ring 4 = Wrench

EXTERNAL HOLDER FOR PARTING AND DEEP GROOVING



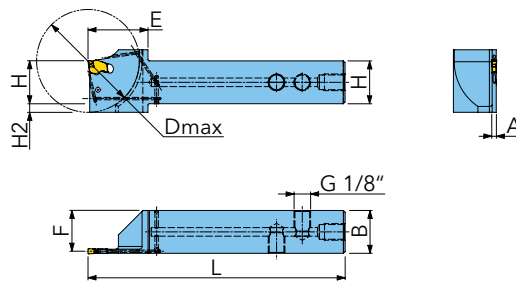
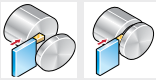
Designation	D max.	L	H	H2	A	B	E	F	Insert-S	kg	
SFEL 2020-1.6T22-D45	45	150	20	2,5	1,3	20	29,5	19,4	1	0,45	
SFEL 2525-2T25-D50	50	150	25	-	1,8	25	32	24,1	2	0,85	
SFEL 2525-3T30-D60	60	150	25	5	2,4	25	35	23,8	3	0,85	
SFER 2020-1.6T22-D45	45	150	20	2,5	1,3	20	29,5	19,4	1	0,45	
SFER 2525-2T25-D50	50	150	25	-	1,8	25	32	24,1	2	0,85	
SFER 2525-3T30-D60	60	150	25	5	2,4	25	35	23,8	3	0,85	

Extractor is not included.




1 = Extractor

WINCUT SFER/L-TB

EXTERNAL HOLDER WITH INTERNAL COOLANT FOR PARTING AND DEEP GROOVING



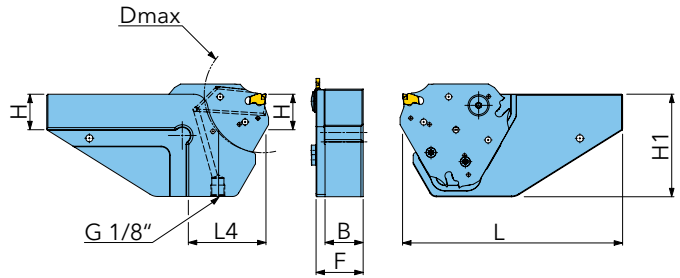
Designation	D max.	L	H	H2	A	B	E	F	Insert-S	kg	
SFEL 2525-2T25-D50-TB	50	150	25	-	1,8	25	32	24,1	2	0,85	✓
SFEL 2525-3T30-D60-TB	60	150	25	5	2,4	25	35	23,8	3	0,85	✓
SFER 2525-2T25-D50-TB	50	150	25	-	1,8	25	32	24,1	2	0,85	✓
SFER 2525-3T30-D60-TB	60	150	25	5	2,4	25	35	23,8	3	0,85	✓

Designation			
SFEL 2525-2T25-D50-TB	PLG G1/8-L6.5	LW 5	ETG 3.4
SFEL 2525-3T30-D60-TB	PLG G1/8-L6.5	LW 5	ETG 3.4
SFER 2525-2T25-D50-TB	PLG G1/8-L6.5	LW 5	ETG 3.4
SFER 2525-3T30-D60-TB	PLG G1/8-L6.5	LW 5	ETG 3.4

Extractor is not included.

1 = Plug 2 = Wrench 3 = Extractor

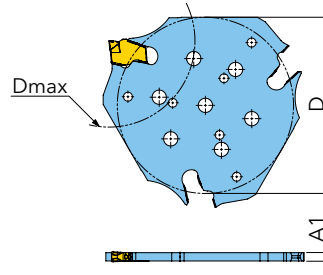
HOLDER FOR TRIANGULAR BLADES



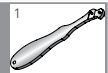
Designation	D max.	L	L4	H	H1	B	F	kg	IK	1	2	3
THTBL 20-D52-TB	52	125	40	20	52	17,5	23,5	0,66	✓	SH M4x0.7X10-TX	O-RING ID10x2	O-RING ID10x2
THTBL 25-D52-TB	52	135	40	25	52	22,5	28,5	0,85	✓	SH M4x0.7X10-TX	O-RING ID10x2	O-RING ID10x2
THTBL 20-D82-TB	82	140	51,5	20	72	17,5	23,5	0,80	✓	SH M4x0.7X10-TX	O-RING ID10x2	O-RING ID10x2
THTBL 25-D82-TB	82	150	51,5	25	72	22,5	28,5	1,10	✓	SH M4x0.7X10-TX	O-RING ID10x2	O-RING ID10x2
THTBL 25-D120-TB	120	165	67	25	95	22,5	28,5	1,29	✓	SH M4x0.7X10-TX	O-RING ID10x2	O-RING ID10x2
THTBL 32-D120-TB	120	165	67	32	95	29,0	35,0	1,79	✓	SH M4x0.7X10-TX	O-RING ID10x2	O-RING ID10x2
THTBR 20-D52-TB	52	125	40	20	52	17,5	23,5	0,66	✓	SH M4x0.7X10-TX	O-RING ID10x2	O-RING ID10x2
THTBR 25-D52-TB	52	135	40	25	52	22,5	28,5	0,85	✓	SH M4x0.7X10-TX	O-RING ID10x2	O-RING ID10x2
THTBR 20-D82-TB	82	140	51,5	20	72	17,5	23,5	0,80	✓	SH M4x0.7X10-TX	O-RING ID10x2	O-RING ID10x2
THTBR 25-D82-TB	82	150	51,5	25	72	22,5	28,5	1,10	✓	SH M4x0.7X10-TX	O-RING ID10x2	O-RING ID10x2
THTBR 25-D120-TB	120	165	67	25	95	22,5	28,5	1,29	✓	SH M4x0.7X10-TX	O-RING ID10x2	O-RING ID10x2
THTBR 32-D120-TB	120	165	67	32	95	29,0	35,0	1,79	✓	SH M4x0.7X10-TX	O-RING ID10x2	O-RING ID10x2

1 = Clamp screw 2 = O-ring 3 = Wrench

TRIANGULAR BLADES FÜR PARTING AND DEEP GROOVING



Designation	D	D max.	A1	Insert-S	kg
SFTB D52-2	53,2	52	1,8	2	0,20
SFTB D52-3	53,2	52	2,5	3	0,20
SFTB D82-2	64,3	82	1,8	2	0,30
SFTB D82-3	64,3	82	2,5	3	0,30
SFTB D120-2	85,5	120	1,8	2	0,40
SFTB D120-3	85,5	120	2,5	3	0,40

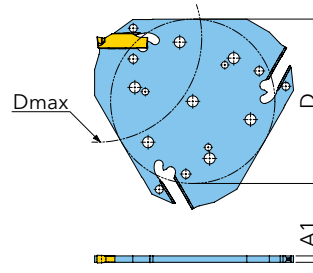


Extractor is not included.

1 = Extractor

TCLAMP^{ULTRA+} TGTB

TRIANGULAR BLADES FÜR PARTING AND DEEP GROOVING



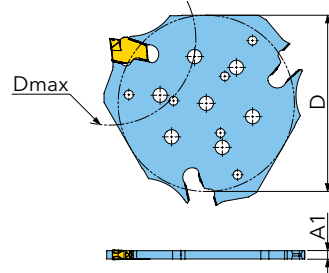
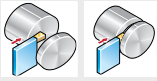
Designation	D	D max.	A1	Insert-S	kg
TGTB D52-2	53,2	52	1,8	2	0,20
TGTB D52-3	53,2	52	2,5	3	0,20
TGTB D82-2	64,3	82	1,8	2	0,30
TGTB D82-3	64,3	82	2,5	3	0,30



Extractor is not included.

1 = Extractor

TRIANGULAR BLADES FÜR PARTING AND DEEP GROOVING WITH INTERNAL COOLING



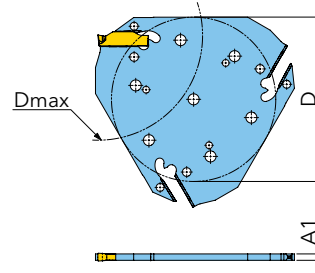
Designation	D	D max.	A1	insert-S	kg	IK	1	2
SFTB D52-2-TB	53,2	52	1,8	2	0,029			
SFTB D52-3-TB	53,2	52	2,5	3	0,039		ETG 3-4	SGC 340-Q
SFTB D82-2-TB	64,3	82	1,8	2	0,050		ETG 3-4	SGC 340-Q
SFTB D82-3-TB	64,3	82	2,5	3	0,068		ETG 3-4	SGC 340-Q
SFTB D120-2-TB	85,5	120	1,8	2	0,103		ETG 3-4	SGC 340-Q
SFTB D120-3-TB	85,5	120	2,5	3	0,141		ETG 3-4	SGC 340-Q

Extractor is not included.

1 = Extractor 2 = Lock screw

TCLAMP^{ULTRA+} TGTB-TB

TRIANGULAR BLADES FÜR PARTING AND DEEP GROOVING WITH INTERNAL COOLING

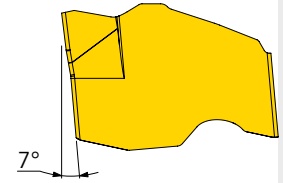
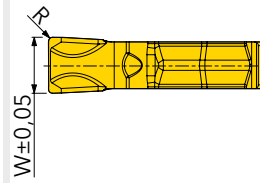
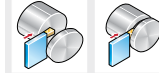


Designation	D	D max.	A1	insert-S	kg	IK	1	2
TGTB D52-2-TB	53,2	52	1,8	2	0,028			
TGTB D52-3-TB	53,2	52	2,5	3	0,039		EDG 33B	SGC 340-Q
TGTB D82-2-TB	64,3	82	1,8	2	0,050		EDG 33B	SGC 340-Q
TGTB D82-3-TB	64,3	82	2,5	3	0,065		EDG 33B	SGC 340-Q

Extractor is not included.

1 = Extractor 2 = Lock screw

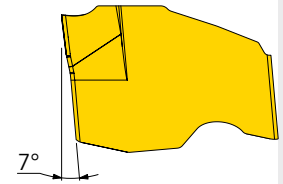
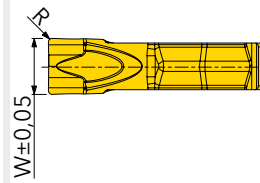
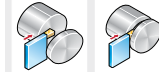
SINGLE-ENDED INSERT FOR PARTING AND GROOVING WITH "C"-TYPE CHIP BREAKER



Designation	R	W ± 0,05	insert-S	Grade	TT9080	TT8020
SFC 1.6	0,2	1,6	1			
SFC 2	0,2	2,0	2			
SFC 3	0,2	3,0	3			

● = P ● = M ● = K ● = N ● = S ○ = H

SINGLE-ENDED INSERT FOR PARTING AND GROOVING WITH "J"-TYPE CHIP BREAKER



Designation	R	W ± 0,05	insert-S	Grade	TT9080	TT8020
SFJ 2	0,2	2,0	2			
SFJ 3	0,2	3,0	3			

● = P ● = M ● = K ● = N ● = S ○ = H