WINSFEED

Member IMC Group Ingersoll Cutting Tools

WINCUT

NEW WINCUT SLOTTING CUTTERS IN MODULAR DESIGN

- Standard tools in diameters Ø80, Ø100, Ø125 and Ø160 mm
- Cutting widths 2 mm and 3 mm
- Strong cutting edges for maximum productivity
- Precisely directed internal coolant supply
- Designed with flat front and free of interfering contours

Nr. 235 E / 02-2024

WINCUT SLOTTING CUTTERS SSC

PRODUCT OVERVIEW

Ingersoll expands its standard program with slotting and disc milling cutters in Ø80, Ø100, Ø125 and Ø160 mm based on our WinCut cutting inserts (SFC / SFJ).

These inserts available in cutting widths of 2 and 3 mm are already used in our parting and grooving tools.

The new product line differs from conventional systems in particular due to the internal coolant supply and the very stable insert seat.

The modular design allows for a certain degree of flexibility and – if necessary – a quick change of the milling cutter.

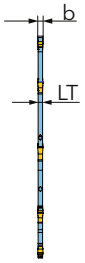
TECHNICAL FEATURES & ADVANTAGES

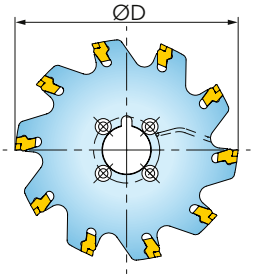
In addition to the pinpointed internal coolant supply and the design with a flat front and no interfering contours, the WinCut insert known from our cut-off blades are a guarantee for excellent productivity and process reliability.

The form-fitting insert seat allows previously unattainable feeds per tooth and can also cope with rough applications. Thanks to the better cooling, higher cutting speeds can also be used - which significantly increases productivity.

- Standard tools in Ø80, Ø100, Ø125 and Ø160 mm
- Cutting widths 2 mm and 3 mm
- Strong cutting edges for highest productivity
- Precisley directed internal coolant supply
- Designed with flat front and free of interfering contours

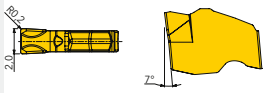
ADAPTION ACC. TO DIN 138



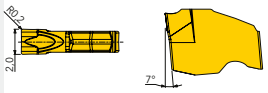


Designation	D	d	LT	a	b	Z	insert-S	IK	kg	inserts
SSC 80 2 22KR00-TB	80	22	1,7	7	2	8	2	✓	0,04	AB
SSC 80 3 22KR00-TB	80	22	2,5	7	3	7	3	✓	0,05	CD
SSC 100 2 22KR00-TB	100	22	1,7	7	2	10	2	✓	0,06	AB
SSC 100 3 22KR00-TB	100	22	2,5	7	3	8	3	✓	0,09	CD
SSC 125 2 27KR00-TB	125	27	1,7	7	2	12	2	✓	1,10	AB
SSC 125 3 27KR00-TB	125	27	2,5	7	3	10	3	✓	1,58	CD
SSC 160 2 32KR00-TB	160	32	1,8	7	2	14	2	✓	1,99	AB
SSC 160 3 32KR00-TB	160	32	2,5	7	3	12	3	✓	2,74	CD

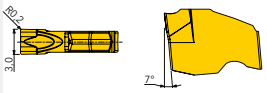
A SFC 2



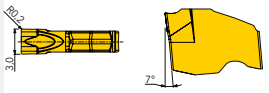
B SFJ 2



C SFC 3



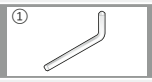
D SFJ 3



Designation	fz(min/max)	Design	Grade TT9080	TT8020
SFC 2	0,08/0,20	1-sided inserts for parting and grooving		
SFJ 2	0,05/0,15	1-sided inserts for parting and grooving		
SFC 3	0,10/0,25	1-sided inserts for parting and grooving		
SFJ 3	0,08/0,20	1-sided inserts for parting and grooving		

P = P M = M K = K N = N S = S H = H

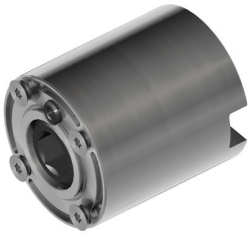
SPARE PARTS



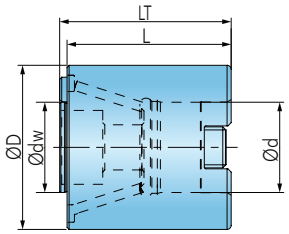
ESG 1

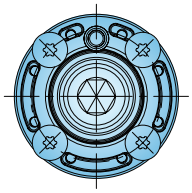
① = ejector

DIN 8030



Modular





Designation	D	d	dw	LT	L	IK	kg
FBD22CP22SA040-TB	40	22	22	41,8	40	✓	0,32
FBD27CP27SA045-TB	45	27	27	46,8	45	✓	0,46
FBD32CP32SA060-TB	55	32	32	61,8	60	✓	0,96

RECOMMENDED CUTTING DATA

WINCUT SF_




Insert type:	SFC 2	SFJ 2	SFC 3	SFJ 3
Cutting width:	2	2	3	3
Average chip thickness:	hm = 0,07 - 0,18 mm	hm = 0,04 - 0,12 mm	hm = 0,08 - 0,25 mm	hm = 0,04 - 0,18 mm

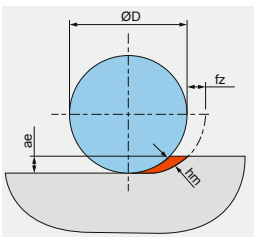
Recommended Cutting Data:

ISO	Material	Cutting speed Vc [m/min]	
		1st choice wet machining resp. tough carbide	1st choice wet machining resp. tough carbide
P	unalloyed steel	250 - 290	200 - 240
	alloyed steel 800 N/mm2	210 - 250	160 - 200
	alloyed steel 1100 N/mm2	160 - 180	110 - 130
M	stainless steel	120 - 180	80 - 130
K	gray cast iron	180 - 250	150 - 200
	nodular cast iron	140 - 210	110 - 160
N	aluminum	800 - 1500	500 - 800
S	high temperature alloys	110 - 125	60 - 80
	titanium alloys	40 - 50	30 - 40
H	hard machining < 54 HRC	30 - 40	–
	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
- Tf tool engagement is less than 1/3 of cutting tool diameter, the feed per tooth should be calculated with the following formula:

$$fz = hm \times \sqrt{\frac{D}{ae}}$$



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