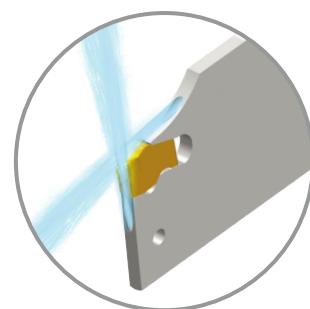
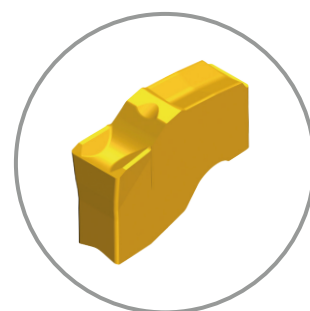


SINGLE-ENDED RIGID INSERTS AND HOLDERS FOR PARTING AND DEEP GROOVING

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



COOLBURST

PRODUCT OVERVIEW

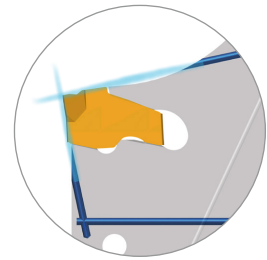
Ingersoll has launched the **WinCut**, a new line of single-ended rigid inserts and holders for parting and deep grooving

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.

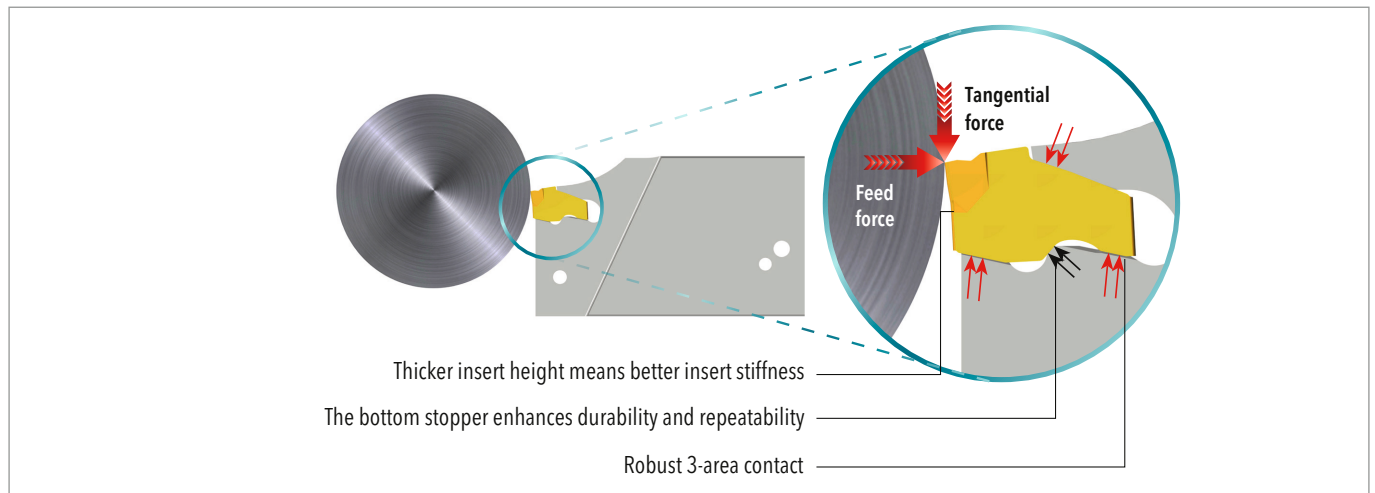
COOLBURST



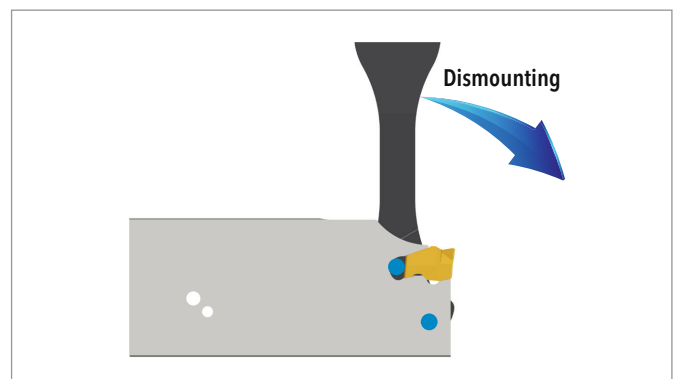
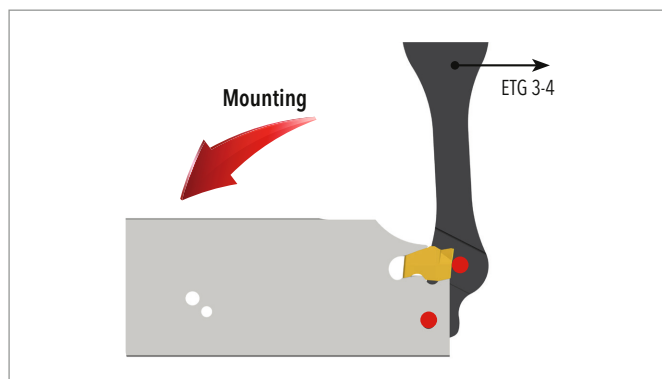
Upper and lower dual high pressure coolant channels

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

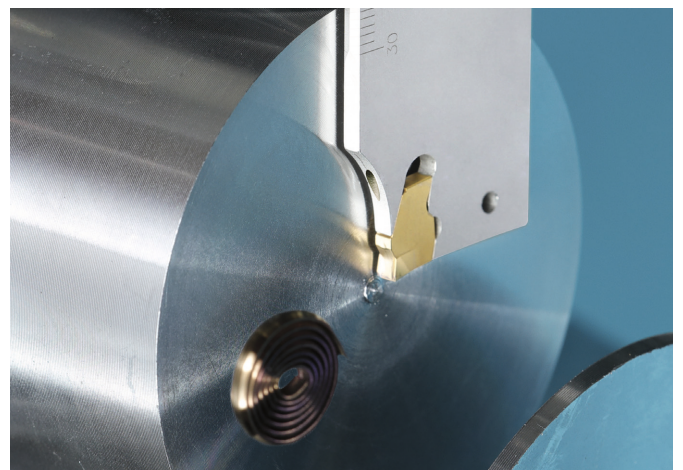
		Ingersoll
Workpiece material		AISI 1045 / C45
Operation		Grooving
Insert		SFC 1.6 TT9080 (Width 1.6mm)
Cutting speed	V (m/min)	140
Feed rate	f (mm/rev)	0.05 / 0.08 / 0.1 / 0.14 / 0.17 / 0.2
Depth of cut	ap (mm)	10
Coolant		wet

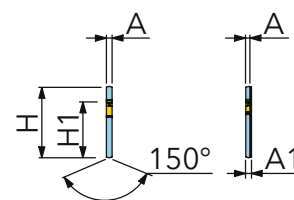
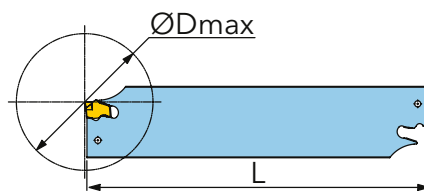
Feed f (mm/rev)			
	0,05	0,08	0,1
			
	0,14	0,17	0,2

- 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


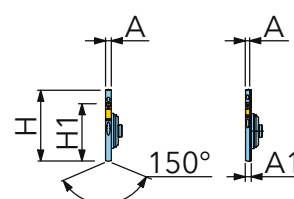
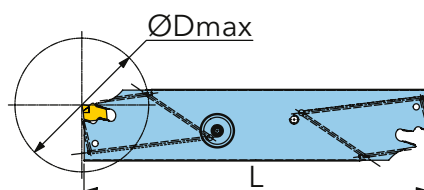
Typ 1

Typ 2

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

BLADES WITH HIGH PRESSURE COOLANT FOR PARTING AND DEEP GROOVING


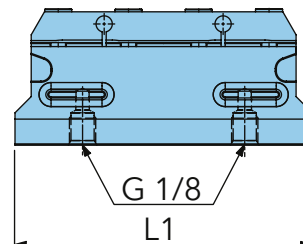
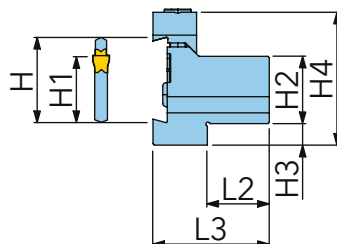
Typ 1

Typ 2

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
SFGB 32-3-TB	100	150	32	24,8	2,5	-	1	3	0,25	✓	ETG 3-4

Extractor is not included

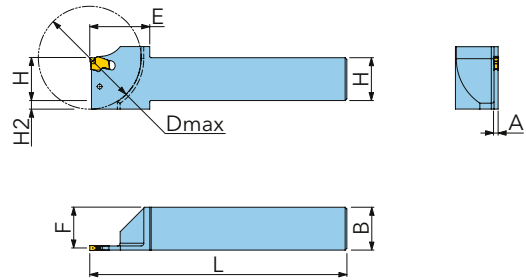
1 = Extractor 2 = Seal screw

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	L-W 5
TTBU 25-32-TB	SR M6X16 DIN912	BKU 110	O-RING ID14X2.5	L-W 5
TTBU 32-32-TB	SR M6X16 DIN912	BKU 110	O-RING ID14X2.5	L-W 5

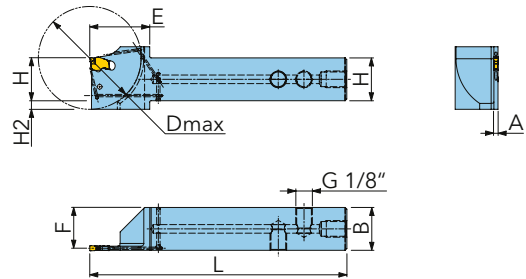
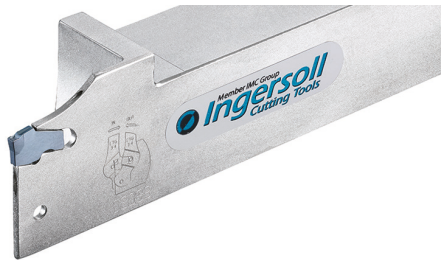
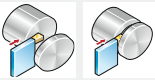
1 = Clamp screw 2 = Clamp 3 = O-ring 4 = Wrench

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

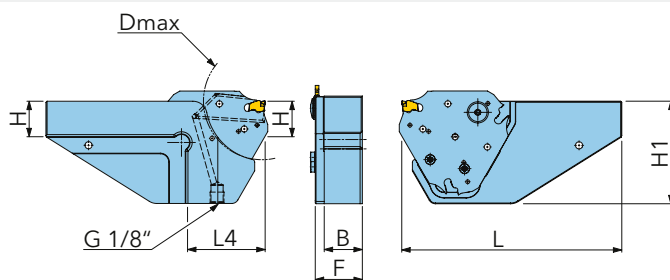
EXTERNAL HOLDER WITH INTERNAL COOLANT FOR PARTING AND DEEP GROOVING


Designation	D max.	L	H	H2	A	B	E	F	Insert-S	kg	IK
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	1	2	3
SFEL 2525-2T25-D50-TB	PLG G1/8-L6.5	L-W 5	ETG 3-4
SFEL 2525-3T30-D60-TB	PLG G1/8-L6.5	L-W 5	ETG 3-4
SFER 2525-2T25-D50-TB	PLG G1/8-L6.5	L-W 5	ETG 3-4
SFER 2525-3T30-D60-TB	PLG G1/8-L6.5	L-W 5	ETG 3-4

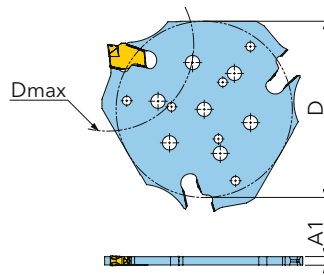
Extractor is not included.

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

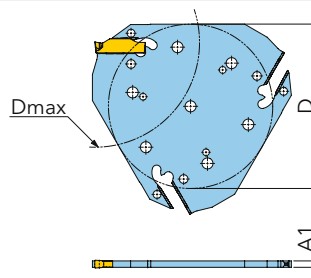
1 = Clamp screw 2 = O-ring 3 = Wrench

TRIANGULAR BLADES FÜR PARTING AND DEEP GROOVING


Designation	D	D max.	A1	Insert-S	kg	1
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.

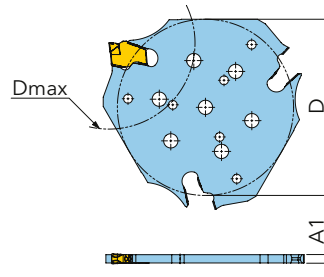
1 = Extractor

TCLAMP^{ULTRA+} TGTB
TRIANGULAR BLADES FÜR PARTING AND DEEP GROOVING


Designation	D	D max.	A1	Insert-S	kg	1
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.

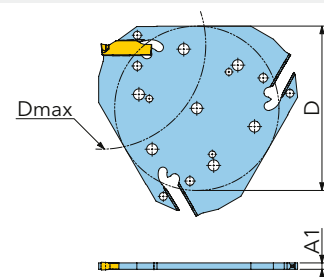
1 = Extractor

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		ETG 3-4	SGC 340-Q
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.

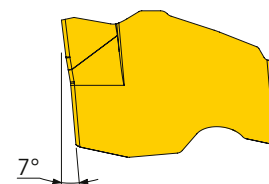
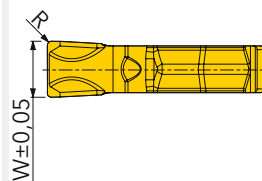
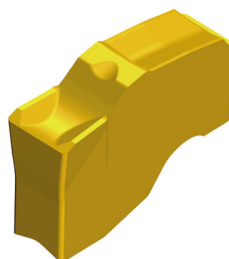
1 = Extractor 2 = Lock screw

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		EDG 33B	SGC 340-Q
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

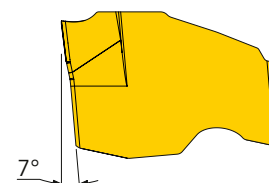
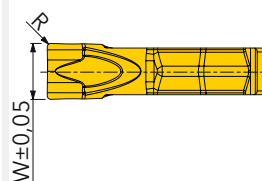
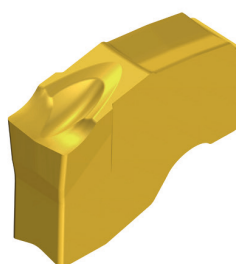
Extractor is not included.

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

WINCUT SFJ
**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

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