



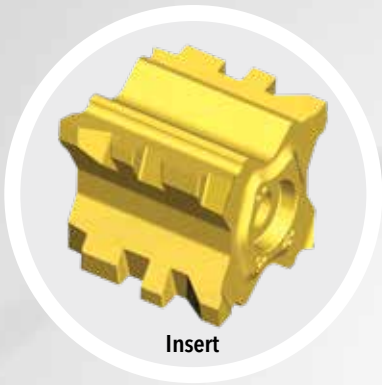
WINSFEED

GOLDFLEX

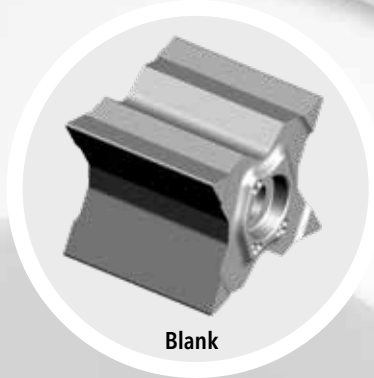
EXTRA WIDE GROOVING INSERTS
AND HOLDERS

EXTRA WIDE INSERT BLANKS FOR SPECIAL PROFILE GROOVING APPLICATIONS

- Economical 4-wide cutting edges insert blank
- Insert blanks in 3 different widths: 10, 15 and 20 mm
- Smart clamping holder design
- Stable and robust insert mounting
- CoolBurst high-pressure coolant



Insert



Blank



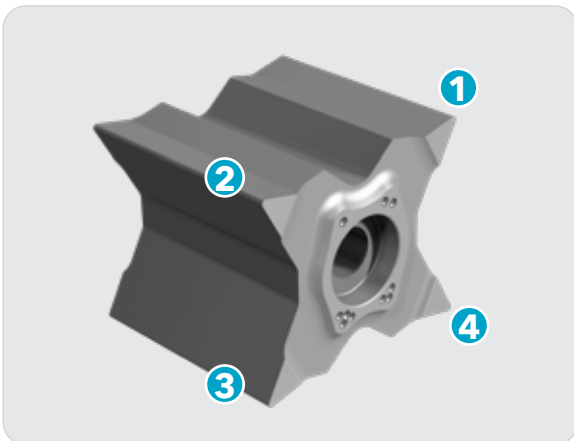
Product Overview

Ingersoll's **GoldFlex** line has introduced extra wide grooving inserts and holders for wide profile machining

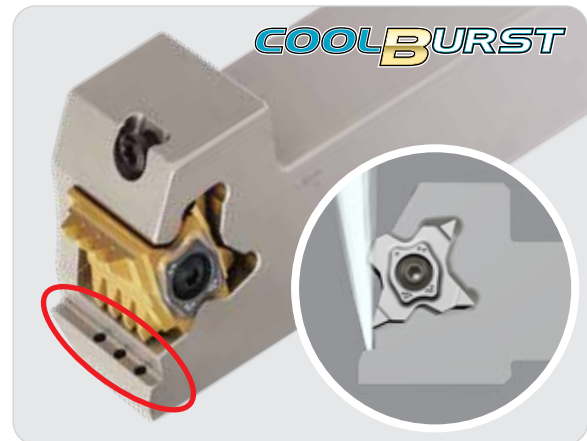
The **GoldFlex** line now includes standard, semi-finished insert blanks for external wide profile grooving in three widths: 10, 15 and 20mm. These insert blanks come in the UF10 uncoated grade, suited for the machining of a wide range of materials and can be used after self-grinding to the desired profile by the end-user.

Additionally, Ingersoll offers grinding profile and coating in accordance with end-user specifications should end-users need custom inserts.

When required, the user can utilize the specific holder as a grinding fixture thanks to its high precision insert positioning and simple yet reliable clamping mechanism. In addition, the **CoolBurst's** pinpointed high-pressure coolant supply contributes to longer tool life and improved productivity



4-corner wide insert

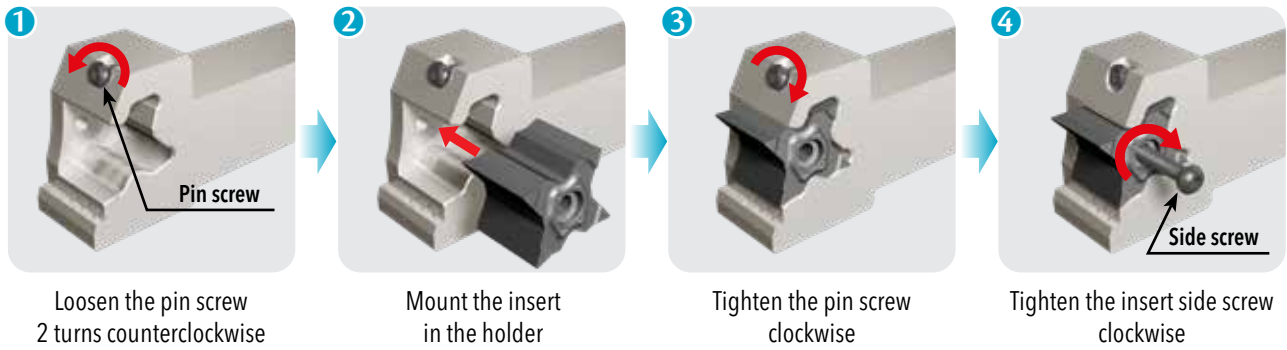


Pinpointed high-pressure coolant supply

Features & Advantages

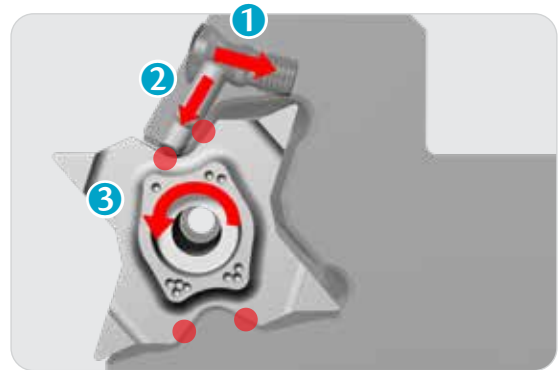
- Economical 4-wide cutting edges insert blank
- Insert blanks in 3 different widths: 10, 15 and 20 mm
- Customers can grind special profiles themselves, or Ingersoll can supply tailor-made products
- Smart clamping holder design for stable and robust insert mounting of wide inserts
- High-pressure coolant (**CoolBurst**) holder: 20x20 mm, 25x25 mm

Insert mounting instructions



Smart clamping mechanism

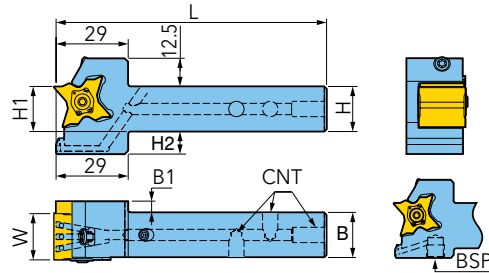
- 1 Pin screw clamping (tighten clockwise)
- 2 As the pin descends, press the insert to secure it in the holder.
- 3 4-point (●) contact clamping of the insert by cutting force



Reference for profile machining



HOLDERS FOR EXTERNAL WIDE AND PROFILE GROOVING WITH HIGH PRESSURE COOLING

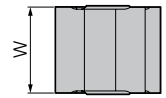
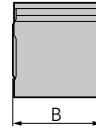
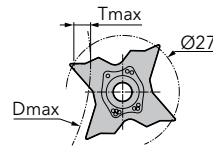
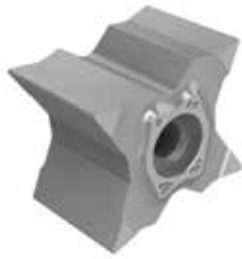


Designation	L	H	H1	H2	B	B1	W	BSP	kg	IK
TQHL 20-27-10EW-TB	120	20	20	13	20	-	10,5	G1/8	0,465	✓
TQHL 20-27-15EW-TB	120	20	20	13	20	-	15,5	G1/8	0,465	✓
TQHL 20-27-20EW-TB	120	20	20	13	20	5	20,5	G1/8	0,465	✓
TQHL 25-27-10EW-TB	135	25	25	8	25	-	10,5	G1/8	0,745	✓
TQHL 25-27-15EW-TB	135	25	25	8	25	-	15,5	G1/8	0,745	✓
TQHL 25-27-20EW-TB	135	25	25	8	25	-	20,5	G1/8	0,745	✓
TQHR 20-27-10EW-TB	120	20	20	13	20	-	10,5	G1/8	0,465	✓
TQHR 20-27-15EW-TB	120	20	20	13	20	-	15,5	G1/8	0,465	✓
TQHR 20-27-20EW-TB	120	20	20	13	20	5	20,5	G1/8	0,465	✓
TQHR 25-27-10EW-TB	135	25	25	8	25	-	10,5	G1/8	0,745	✓
TQHR 25-27-15EW-TB	135	25	25	8	25	-	15,5	G1/8	0,745	✓
TQHR 25-27-20EW-TB	135	25	25	8	25	-	20,5	G1/8	0,745	✓

Designation	①	②	③	④	⑤	⑥	⑦
TQHL 20-27-10EW-TB	PIN-TQ-WT	SM40-106-B1	BH M4X0.7X16-D7	PLG G1/8-L6.5	T15	LW2.5	LW5
TQHL 20-27-15EW-TB	PIN-TQ-WT	SM40-106-B1	BH M4X0.7X20-D7	PLG G1/8-L6.5	T15	LW2.5	LW5
TQHL 20-27-20EW-TB	PIN-TQ-WT	SM40-106-B1	BH M4X0.7X23-D7	PLG G1/8-L6.5	T15	LW2.5	LW5
TQHL 25-27-10EW-TB	PIN-TQ-WT	SM40-106-B1	BH M4X0.7X16-D7	-	T15	LW2.5	-
TQHL 25-27-15EW-TB	PIN-TQ-WT	SM40-106-B1	BH M4X0.7X20-D7	-	T15	LW2.5	-
TQHL 25-27-20EW-TB	PIN-TQ-WT	SM40-106-B1	BH M4X0.7X23-D7	-	T15	LW2.5	-
TQHR 20-27-10EW-TB	PIN-TQ-WT	SM40-106-B1	BH M4X0.7X16-D7	PLG G1/8-L6.5	T15	LW2.5	LW5
TQHR 20-27-15EW-TB	PIN-TQ-WT	SM40-106-B1	BH M4X0.7X20-D7	PLG G1/8-L6.5	T15	LW2.5	LW5
TQHR 20-27-20EW-TB	PIN-TQ-WT	SM40-106-B1	BH M4X0.7X23-D7	PLG G1/8-L6.5	T15	LW2.5	LW5
TQHR 25-27-10EW-TB	PIN-TQ-WT	SM40-106-B1	BH M4X0.7X16-D7	-	T15	LW2.5	-
TQHR 25-27-15EW-TB	PIN-TQ-WT	SM40-106-B1	BH M4X0.7X20-D7	-	T15	LW2.5	-
TQHR 25-27-20EW-TB	PIN-TQ-WT	SM40-106-B1	BH M4X0.7X23-D7	-	T15	LW2.5	-

① = Clamping pin ② = Pin screw ③ = Side screw ④ = Plug ⑤ = Wrench ⑥ = Wrench ⑦ = Wrench

BLANK FOR FURTHER PROCESSING WITHOUT COATING
4-EDGED GROOVING BLANK FOR EXTERNAL WIDE AND PROFILE GROOVING



Designation	B	W ± 0,1	insert-S	Grade	UF10
TQBS 27-10EW	11,1	10,5	27-10		●
TQBS 27-15EW	16,1	15,5	27-15		●
TQBS 27-20EW	21,1	20,5	27-20		●

● = P ● = M ● = K ● = N ● = S ○ = H

Designation	Dimension (mm)		Dmax										Grade
	W	B	Tmax ≤3,0	Tmax ≤3,5	Tmax ≤4,0	Tmax ≤4,5	Tmax ≤5,0	Tmax ≤5,5	Tmax ≤5,7	Tmax ≤6,0	Tmax ≤6,2	Tmax ≤6,4	UF10
TQBS 27-10EW	10,5	11,1	-	600	280	180	135	105	95	85	78	55	●
TQBS 27-15EW	15,5	16,1	-	600	280	180	135	105	95	85	78	55	●
TQBS 27-20EW	20,5	21,1	-	600	280	180	135	105	95	85	78	55	●

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