

Ingersoll **TAEQU** line **INTRODUCES...**

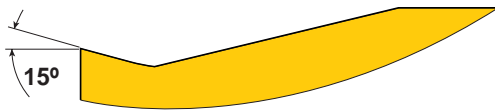
## **CHIPBREAKERS** **for** **EXOTIC** *Materials*



Ingersoll TaeguLine introduces two types of chipbreakers for machining stainless steel and heat resistant alloys.

EA is a chipbreaker for semi-finishing and finishing operations. It controls chips at a very low depth of cut and low to medium feed rates. Its sharp cutting edge has been adopted for smooth cutting which improves surface finishes and increases accuracy.

ET is a chipbreaker for rough machining. Its positive rake angle reduces machining load during roughing applications and minimizes built-up-edges. In addition, the geometry helps to reduce heat generated while machining.





**EA - EXOTIC ACCURATE**

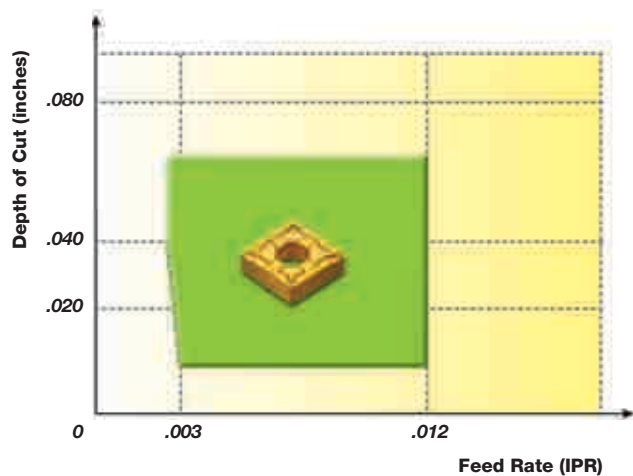
Cutting Edge Geometry



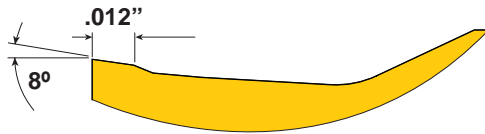
EA is designed with very high positive geometry that minimizes built-up-edge and reduces machining load. Its sharp cutting edge and tight chipbreaker deliver excellent surface finishes.

**FEATURES:**

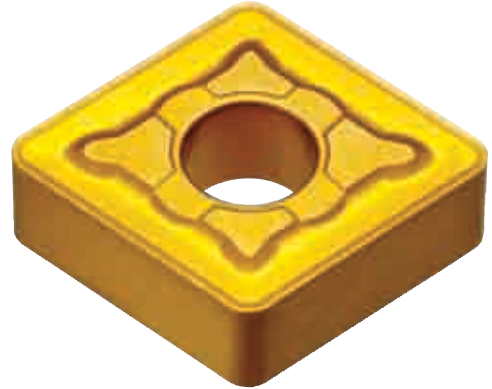
-  Very tight chipbreaker for low depth of cut and low to medium feed rates.
-  Sharp geometry to minimize built-up-edge.
-  High positive rake angle and helix designed to minimize machining loads.
-  Accurate finishing and exceptional surface quality.

**RECOMMENDED CUTTING CONDITIONS:****Recommended Cutting Conditions:**

- CNMG431EA
- $a_p = .016''$  (.008" ~ .060")
- $f = .004''$  (.002" ~ .012") IPR




**ET - EXOTIC TOUGH**

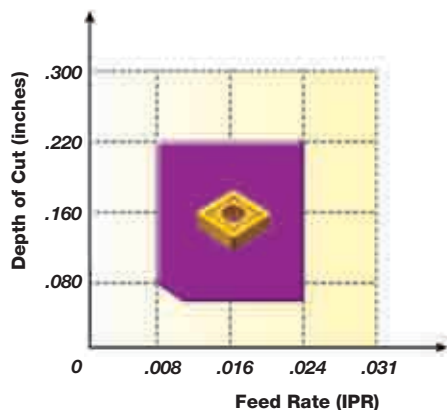
Cutting Edge Geometry



ET is designed with positive geometry to minimize built-up-edges created while machining exotic materials and stainless steel. Its geometry reduces machining load and is ideal for roughing difficult-to-cut materials.

**FEATURES:**

-  Positive, yet strong chipbreaker for high depth of cut and high feed rates.
-  Sharp geometry to minimize built-up-edge.
-  High positive rake angle in order to minimize machining loads and reduce heat.

**RECOMMENDED CUTTING CONDITIONS:****Recommended Cutting Conditions:**

- CNMG433ET
- $a_p = .120''$  (.050" ~ .220")
- $f = .014''$  (.008" ~ .024") IPR

**STOCKED ITEMS:****EA Chipbreaker**

Designation
CNMG431EA TT5100
CNMG431EA TT5030
CNMG431EA TT1500
CNMG431EA TT3500
CNMG431EA TT8020
CNMG431EA CT3000
CNMG432EA TT5100
CNMG432EA TT5030
CNMG432EA TT1500
CNMG432EA TT3500
CNMG432EA TT8020
CNMG432EA CT3000

**ET Chipbreaker**

Designation
CNMG432ET TT5100
CNMG432ET TT5030
CNMG432ET TT3500
CNMG433ET TT5100
CNMG433ET TT3500
CNMG433ET TT5030
CNMG543ET TT5100
CNMG543ET TT3500
CNMG643ET TT5100
CNMG643ET TT5030
CNMG643ET TT3500
CNMG644ET TT5030
CNMG644ET TT5100
CNMG644ET TT3500

\* Other grades are available upon request.

(Subject to minimum order requirements.)