

NEW! Ingersoll **TAEGU** line INTRODUCES...
T-CAST grade **TT7310**



Ingersoll introduces within its TaeguLine of ISO turning inserts a new T-CAST grade, TT7310, specifically designed for cast iron applications. This new generation grade provides exceptional performance in ductile cast iron, and can also be used in gray cast iron at medium to high cutting speeds. TT7310 compliments our existing T-CAST TT1300 grade that is ideal for gray cast iron applications at very high cutting speeds.

TT7310 is a cemented carbide insert consisting of a tough substrate with a thick, CVD coating that is all black in color. This grade has been developed using a new post-coating treatment technology that provides a smooth cutting edge, resulting in excellent surface finish on the work piece and extended tool life. The substrate toughness, thick coating, and post-coating edge treatment provide an excellent combination of wear and chipping resistance that makes this grade ideal for both roughing and finishing applications.

A total of 97 unique inserts will be available from stock immediately!

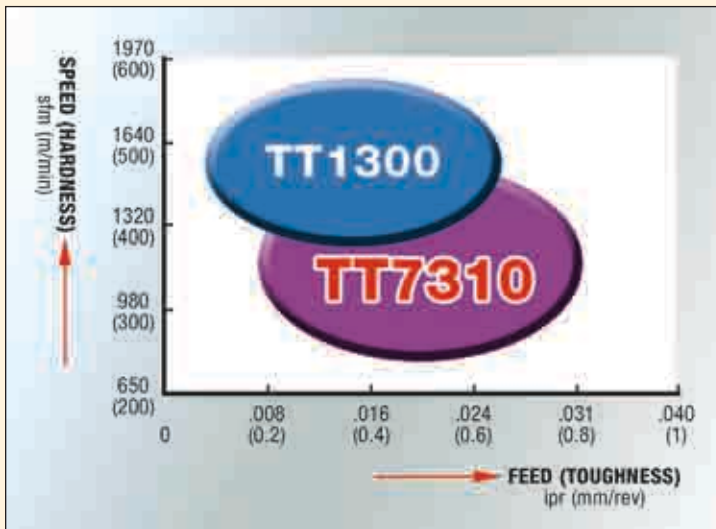
FEATURES

- The first insert designed specifically for ductile cast iron.
- Can also be used for gray cast iron.
- Excellent wear resistance and endurance to chipping.
- Can be applied in roughing and finishing applications.

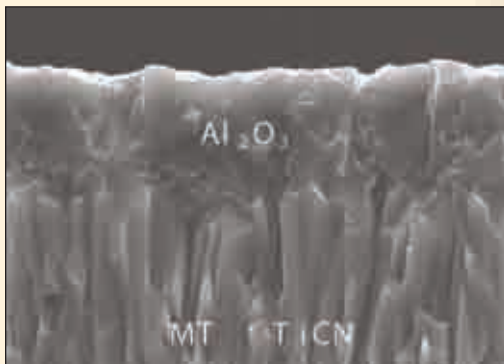


TT7310 packages will be supplied with optimal cutting parameters printed on the label.

APPLICATION RANGE



MICRO STRUCTURE OF TT7310



RECOMMENDED CUTTING SPEEDS

- Ductile cast iron: 490 – 1150 sfm (150-300 m/min)
- Gray cast iron: 490 – 1380 sfm (150-420 m/min)

CASE STUDY

1. Component: Pressure Plate

Material	Vc	f	ap	Operation	Coolant	Insert Designation	Tool life
Ductile cast Iron	906sfm (276m/min)	.008ipr (0.20mm/rev)	.020inch (0.5mm)	Facing(Interrupted)	dry	CNMG 432 (120408) RT TT1300	5pcs/edge
						CNMG 432 (120408) RT TT7310	10pcs/edge

2. Component: Hub

Material	Vc	f	ap	Operation	Coolant	Insert Designation	Tool life
Ductile cast Iron	903sfm (275m/min)	.008ipr (0.20mm/rev)	.050inch (1.5mm)	Ext. Turning & Facing	wet	CNMG 432 (120408) UZ AC300G	20pcs/edge
						CNMG 432 (120408) MT TT7310	70pcs/edge
	1667sfm (508m/min)	.008ipr (0.20mm/rev)	.080inch (2.5mm)	Ext. Turning & Facing	wet	CNMG 433 (120412) NM5 WAK20	300pcs/edge
						CNMG 433 (120412) RT TT7310	400pcs/edge
SG Iron	985sfm (300m/min)	.008ipr (0.20mm/rev)	.079inch (2.0mm)	Ext. Turning & Facing	wet	WNMA 433 (080412) TT1300	140pcs/edge
						WNMG 433 (080412) RT TT7310	470pcs/edge

3. Component: Damper Pulley

Material	Vc	f	ap	Operation	Coolant	Insert Designation	Tool life
Grey Cast Iron	1677sfm (511m/min)	.011ipr (0.28mm/rev)	.050inch (1.5mm)	Int. Turning & Facing	wet	CNMG 432 (120408) CA4115	1100pcs/edge
						CNMG 432 (120408) RT TT7310	1400pcs/edge

4. Component: Pump Cover

Material	Vc	f	ap	Operation	Coolant	Insert Designation	Tool life
Ductile cast Iron	722sfm (220m/min)	.012ipr (0.30mm/rev)	.079inch (2.0mm)	Ext. Turning & Facing	wet	WNMA 432 (080408) T5010	750pcs/edge
						WNMA 432 (080408) TT7310	1500pcs/edge

5. Component: Case

Material	Vc	f	ap	Operation	Coolant	Insert Designation	Tool life
Grey Cast Iron	985sfm (300m/min)	.008ipr (0.20mm/rev)	.079inch (2.0mm)	Ext. Turning & Facing	wet	WNMA 433 (080412) TT1300	430pcs/edge
						WNMG 433 (080412) RT TT7310	770pcs/edge
Grey Cast Iron	985sfm (300m/min)	.008ipr (0.20mm/rev)	.079inch (2.0mm)	Ext. Turning & Facing	wet	WNMA 433 (080412) TT1300	2100pcs/edge
						WNMG 433 (080412) RT TT7310	4200pcs/edge

6. Component: Knuckle

Material	Vc	f	ap	Operation	Coolant	Insert Designation	Tool life
Ductile cast Iron	788sfm (240m/min)	.008ipr (0.20mm/rev)	.079inch (2.0mm)	Int. Turning & Facing	wet	CNMA 432 (120408) UC5115	2000pcs/edge
						CNMA 432 (120408) TT7310	3000pcs/edge
Ductile cast Iron	591sfm (180m/min)	.010ipr (0.25mm/rev)	.079inch (2.0mm)	Ext. Turning & Facing	wet	CNMG 433 (120412) KM GC3015	2500pcs/edge
						CNMG 432 (120408) RT TT7310	4070pcs/edge
SG Iron	591sfm (180m/min)	.010ipr (0.25mm/rev)	.079inch (2.0mm)	Back Boring	wet	CNMG 432 (120408) RT TT1300	3000pcs/edge
						CNMG 432 (120408) RT TT7310	4000pcs/edge

7. Component: Housing

Material	Vc	f	ap	Operation	Coolant	Insert Designation	Tool life
SG Iron	525sfm (160m/min)	.008ipr (0.20mm/rev)	.098inch (2.5mm)	Facing(Interrupted)	wet	CNMG 432 (120408) GH UC5115	10pcs/edge
						CNMG 432 (120408) RT TT7310	10pcs/edge
SG Iron	591sfm (180m/min)	.010ipr (0.25mm/rev)	.089inch (2.3mm)	Boring	wet	CNMG 432 (120408) GH UC5115	18pcs/edge
						CNMG 432 (120408) RT TT7310	20pcs/edge
Ductile cast Iron	847sfm (258m/min)	.010ipr (0.25mm/rev)	.158inch (4.0mm)	Rough Turn	wet	CNMG 432 (120408) NM5 WAK20	10pcs/edge
						CNMA 432 (120408) TT7310	15pcs/edge

8. Component: Clutch Basket

Material	Vc	f	ap	Operation	Coolant	Insert Designation	Tool life
Ductile cast Iron	1198sfm (365m/min)	.012ipr (0.30mm/rev)	.079inch (2.0mm)	Rough Turn	wet	CNMA 433 (120412) GC3205	50pcs/edge
						CNMA 432 (120408) TT7310	60pcs/edge

9. Component: Drive Hub

Material	Vc	f	ap	Operation	Coolant	Insert Designation	Tool life
Ductile cast Iron	850sfm (259m/min)	.011ipr (0.28mm/rev)	.091inch (2.3mm)	Rough Turn	wet	WNMA 433 (080412) KC9315	30pcs/edge
						WNMA 433 (080412) TT7310	41pcs/edge

10. Component: Fly Wheel

Material	Vc	f	ap	Operation	Coolant	Insert Designation	Tool life
Ductile cast Iron	886sfm (270m/min)	.013ipr (0.33mm/rev)	.079inch (2.0mm)	Rough Turn	wet	CNMA 432 (120408) UC5105	8pcs/edge
						CNMA 432 (120408) TT7310	10pcs/edge

11. Component: Coupling

Material	Vc	f	ap	Operation	Coolant	Insert Designation	Tool life
SG Iron	821sfm (250m/min)	.010ipr (0.25mm/rev)	.028inch (0.7mm)	Semi Finish	wet	WNMG 433 (080412) RT TT1500	20pcs/edge
						WNMG 433 (080412) RT TT7310	20pcs/edge

AVAILABLE STOCK ITEMS

Item No	Description	Item No	Description	Item No	Description
• 5518366	CCMT 060204 (21.51) MT	5518389	DNMG 150608 (442) MT	5518418	TNMA 160416 (334)
• 5518367	CCMT 060208 (21.52) MT	5518390	DNMG 150608 (442) RT	• 5518419	TNMA 220408 (432)
• 5518368	CCMT 09T304 (32.51) MT	5518391	DNMG 150612 (443)	• 5518420	TNMA 220412 (433)
• 5518369	CCMT 09T308 (32.52) MT	5518392	DNMG 150612 (443) MT	5518421	TNMG 160404 (331)
• 5518370	CCMT 120404 (431) MT	5518393	DNMG 150612 (443) RT	5518423	TNMG 160404 (331) MT
• 5518371	CCMT 120408 (432) MT	• 5518242	HNMG 050408 (432) GU	5518422	TNMG 160408 (332)
• 5518245	CNMA 120404 (431)	5518394	RCMT 120400 MT	• 5518424	TNMG 160408 (332) MT
• 5518124	CNMA 120408 (432) *	5518280	RCMT 160600 MT	• 5518425	TNMG 160408 (332) RT
• 5518125	CNMA 120412 (433) *	5518395	RCMX 120400	5518426	TNMG 160412 (333) RT
• 5518372	CNMA 160612 (543)	5518396	RCMX 160600	5518427	TPMR 110304 (221)
• 5518373	CNMG 120404 (431)	5518279	RCMX 200600	• 5518428	TPMR 160304 (321)
• 5518276	CNMG 120404 (431) MT	• 5518397	SCMT 09T304 (32.51) MT	• 5518429	TPMR 160308 (322)
• 5518374	CNMG 120408 (432)	• 5518398	SCMT 09T308 (32.52) MT	• 5518430	VBMT 160404 (331) MT
• 5518446	CNMG 120408 (432) MC	• 5518399	SCMT 120408 (432) MT	• 5518431	VBMT 160408 (332) MT
• 5518120	CNMG 120408 (432) MT *	• 5518400	SNMA 120408 (432)	• 5518432	VNMG 160404 (331)
• 5518122	CNMG 120408 (432) RT *	• 5518401	SNMA 120412 (433)	• 5518433	VNMG 160408 (332)
• 5518814	CNMG 120408 (432) WT	5518236	SNMA 120416 (434)	5518434	VNMG 160408 (332) MT
5518445	CNMG 120412 (433)	5518402	SNMG 120404 (431)	5518435	VNMG 160412 (333)
• 5518121	CNMG 120412 (433) MT *	• 5518403	SNMG 120408 (432)	5518436	WNMA 060408 (332)
• 5518123	CNMG 120412 (433) RT *	• 5518404	SNMG 120408 (432) MT	• 5518126	WNMA 080408 (432)
• 5518287	CNMG 160612 (543) RT	• 5518405	SNMG 120408 (432) RT	• 5518127	WNMA 080412 (433)
5518375	CNMG 190608 (642)	5518406	SNMG 120412 (433)	5518437	WNMA 080416 (434)
• 5518376	CNMG 190612 (643) RT	• 5518407	SNMG 120412 (433) RT	5518438	WNMG 080404 (431) MT
• 5518377	DCMT 11T304 (32.51) MT	5518408	SNMG 190608 (642)	• 5518439	WNMG 080408 (432) MT
• 5518378	DCMT 11T308 (32.52) MT	5518409	SNMG 190612 (643)	• 5518128	WNMG 080408 (432) RT
5518379	DCMT 11T312 (32.53) MT	5518410	TCMT 090204 (731) MT	• 5518441	WNMG 080412 (433) MT
• 5518380	DNMA 150408 (432)	5518411	TCMT 090208 (732) MT	• 5518129	WNMG 080412 (433) RT
• 5518381	DNMA 150412 (433)	• 5518412	TCMT 110204 (21.51) MT	• 5518442	WNMG 080412 (433) WT
5518382	DNMA 150608 (442)	• 5518413	TCMT 110208 (21.52) MT		
5518383	DNMA 150612 (443)	• 5518414	TCMT 16T304 (32.51) MT		
5518385	DNMG 150408 (432)	• 5518415	TCMT 16T308 (32.52) MT		
• 5518386	DNMG 150408 (432) RT	5518416	TNMA 160404 (331)		
5518387	DNMG 150604 (441) MT	• 5518417	TNMA 160408 (332)		
5518388	DNMG 150608 (442)	5518234	TNMA 160412 (333)		

- Stocked in USA
- * Woksa paks available

PRICES

- Please refer to "Ask Margaret"