

GOLD•DUTY



FEATURES

- Double-sided inserts
- Lower cutting forces & HP requirement versus CNMG inserts
- Better surface finish than CNMG inserts

INSERTS

- CNMX43.52 (new)
- CNMX43.53 (new)
- CNMX553, CNMG554, SNMX553, SNMX554 (all previously introduced)

GRADES

- TT8115
- TT8125
- TT8135

HOLDERS

- HCLNR/L
- 1" and 1 1/4" Shanks, External
- 1 1/4" and 1 1/2" Shanks, Internal
- Refer to full catalog for 5/8" IC insert holders & bars



Now Available in 1/2" IC Insert!

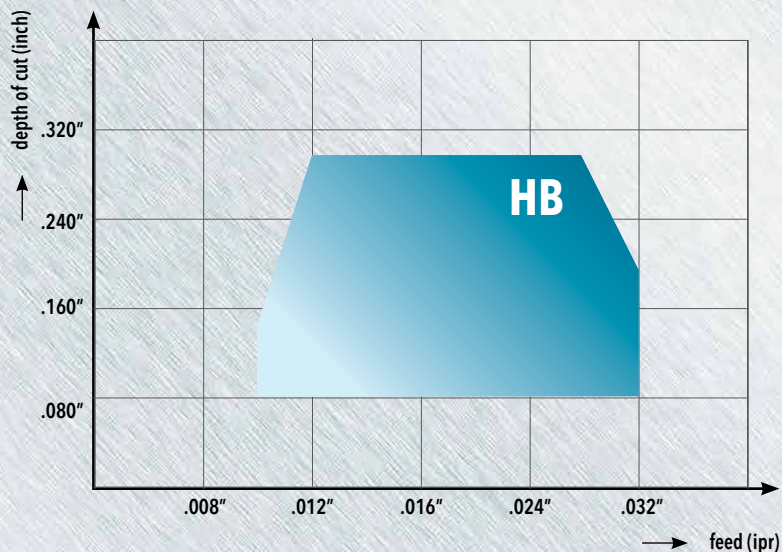
Ingersoll is pleased to announce the expansion of its GOLD•DUTY product line to include .500" IC inserts. With the success of the existing .625" IC inserts, the development of a smaller, economically sized insert and corresponding holders was based on market demand. These new, CNMX43.5x size inserts offer the same excellent performance in medium to medium-roughing applications, but on a smaller scale. Their free-cutting geometry makes them suitable for applications in which maximum material removal rates are desirable, even on machines with limited horsepower.

Both GOLD•DUTY insert sizes are double-sided and feature a positive "HB" chip breaker that enables smooth machining, provides excellent chip control and produces a very good surface finish in medium to high depths-of-cut.

All GOLD•DUTY inserts are available in the latest GoldRush grades that promote stable machining and outstanding tool life.

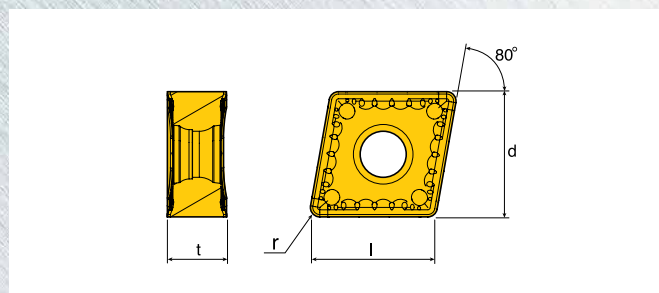
**NEW
PRODUCT
ANNOUNCEMENT
•2014•**

CHIP BREAKING RANGE



- Insert : CNMX 43.52 HB TT8125
- Cutting speed : 650 sfm
- Material : 0.45% Carbon steel (1045)

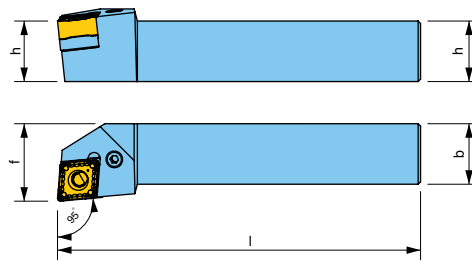
CNMX HB Semi Heavy Turn Insert



Designation	feed (ipr)	ap (inch)	Dimensions (inch)				Grade & Vc(sfm)		
			l	d	t	r	TT8115	TT8125	TT8135
CNMX 43.52 HB	.010-.032	.080-.240	.500	.219	.031	•	•	•	
CNMX 43.53 HB	.010-.032	.080-.240	.500	.219	.047	•	•	•	

• Marked: Standard Items
 * Other grades produced upon request only.

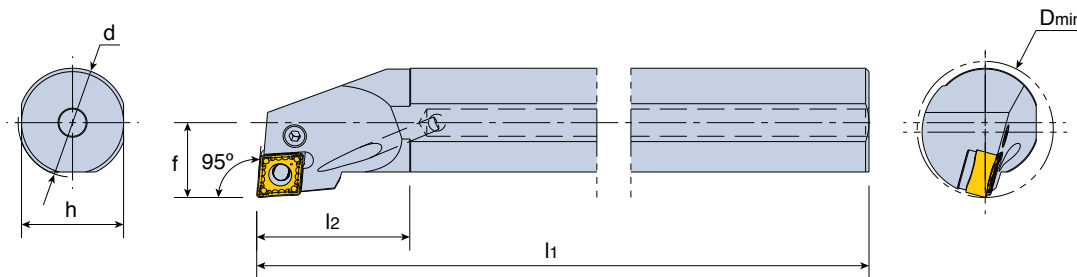
HCLNR/L Holder



Designation	Dimensions (inch)			
	h	b	l	f
HCLNR/L 12-43.5B	.750	.750	4.50	1.000
HCLNR/L 16-43.5D	1.000	1.000	6.00	1.250
HCLNR/L 20-43.5E	1.250	1.250	7.00	1.500

HARDWARE							
	Insert	Lever	Screw	Shim	Shim Pin	Shim Pin Punch	Wrench
HCLNR/L 12-43.5B			LCS 5-L21				
HCLNR/L 16-43.5D	CNMX 43.5 HB	LCL 12-NX	LCS 5	LSC 43-NX	LSP 4	SPP 3-4	L-W 3
HCLNR/L 20-43.5E							

A-HCLNR/L 43.5 Holder



Designation	Dimensions (inch)					
	d	h	l1	l2	f	Dmin
A20U HCLNR/L 43.5	1.25	1.169	14.0	1.77	0.765	1.50
A24U HCLNR/L 43.5	1.50	1.382	14.0	2.17	0.890	1.75

HARDWARE							
	Insert	Lever	Screw	Shim	Shim Pin	Shim Pin Punch	Wrench
A20U HCLNR/L 43.5			LCS 5-L21				
A24U HCLNR/L 43.5	CNMX 43.5 HB	LCL 12-NX	LCS 5	LSC 43-NXS	LSP 4	SPP 3-4	L-W 3