



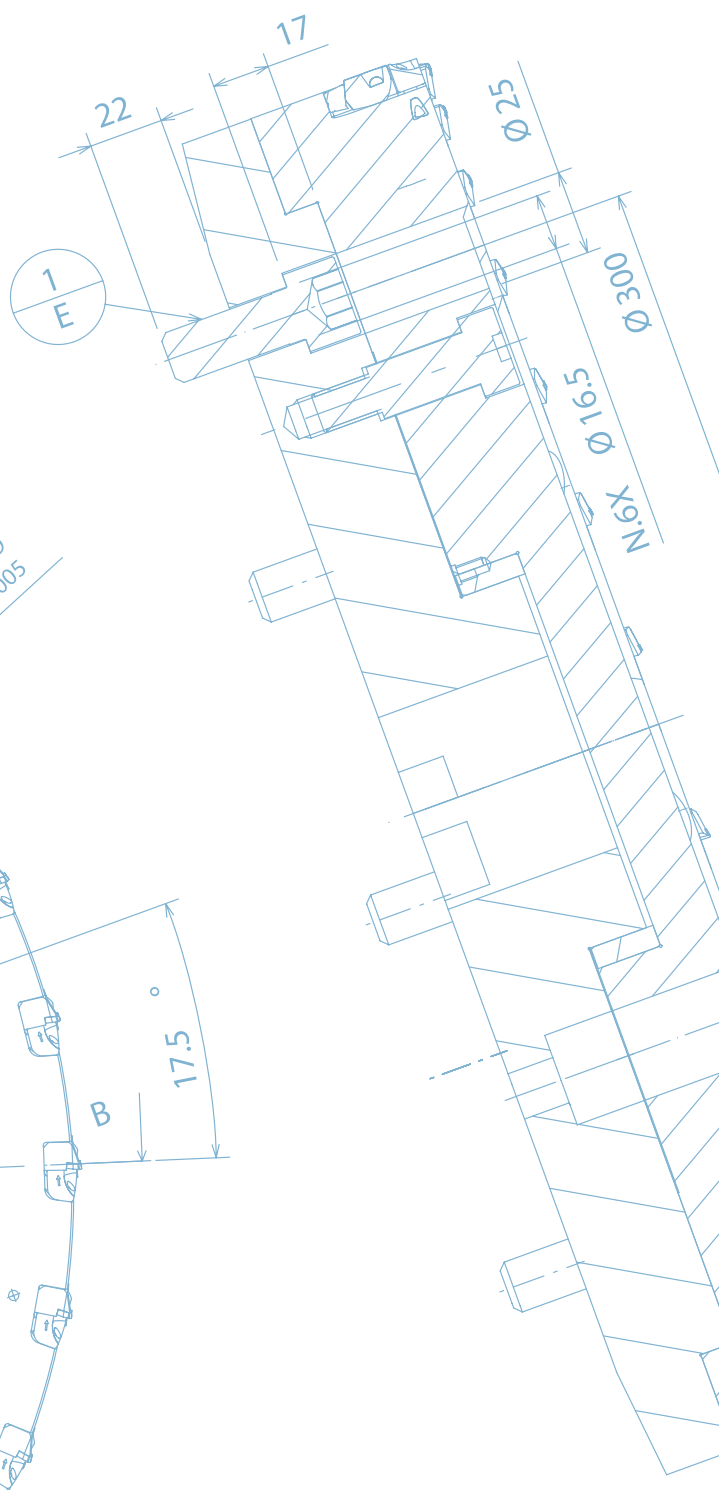
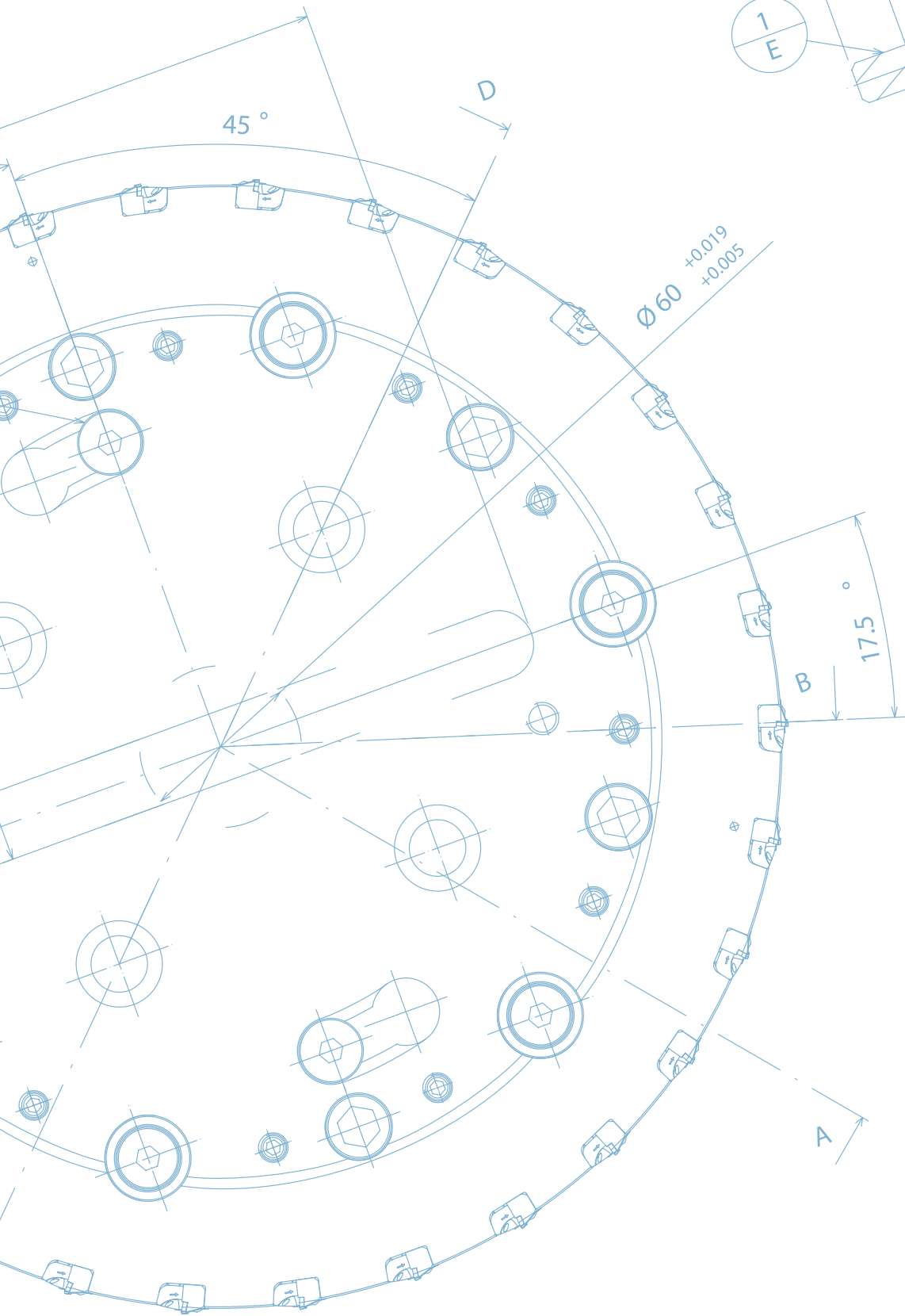
Member IMC Group

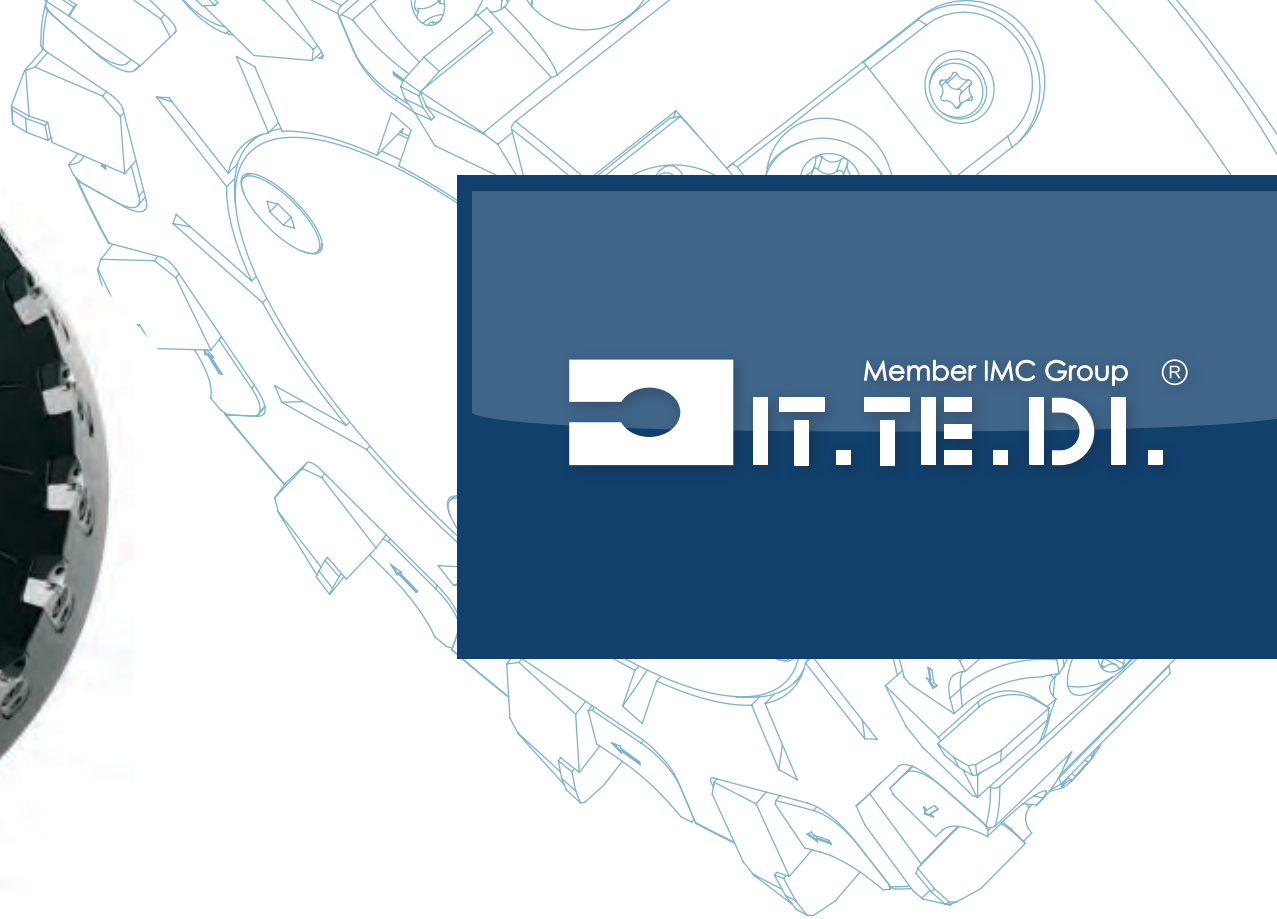
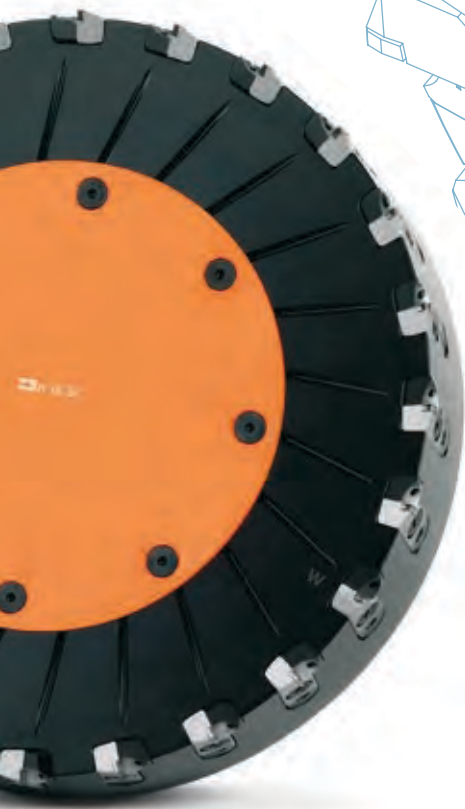
# IT.TE.DI.

## BRAZED & INDEXABLE PCD/CBN MILLING



Member IMC Group  
**Ingersoll**  
Cutting Tools





Member IMC Group <sup>®</sup>

**IT.TE.DI.**

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*Modern machining operations need to rely on the optimization of the production processes: in this respect the milling operations play a very important role and several factors contribute to its increasing significance. On one side the demand to reduce the machining time and on the other side the constant request for quality improvement as far as surface roughness and flatness are concerned, make it necessary to adopt high performance tools able to guarantee high cutting speeds and long tool life. Moreover, the trend towards stronger thinner work piece materials in response to the requirement of lighter weight in various industries today highlight the importance of a high quality and versatile cutting edge.*

*The evolution in the materials to be machined, which may contain carbon, magnesium, composite materials, bimetallic alloys, CGI cast irons, tough cast irons, in addition to the traditional grey cast irons and light alloys, require the most modern cutting materials as well. IT.TE.DI.'s range of milling cutters guarantee the best performance in every machining operation.*



# *For every surface a non superficial approach*

*Face milling or contouring: any milling operation can be performed by IT.TE.DI milling cutters, from the simplest cutter with cylindrical shank to the monolithic cutter with replaceable cartridges. IT.TE.DI cutters are the best answer to the most difficult challenges and are available exclusively from Ingersoll Cutting Tools throughout North America.*





**TEDI FEED**  
**LEDI FEED**



**TEDI FEED<sup>®</sup>**  
**PCD & CBN**  
*Tangential Milling*





The logo for TEDIFEEED, featuring the word in a stylized, bold font with a color gradient from yellow to blue.

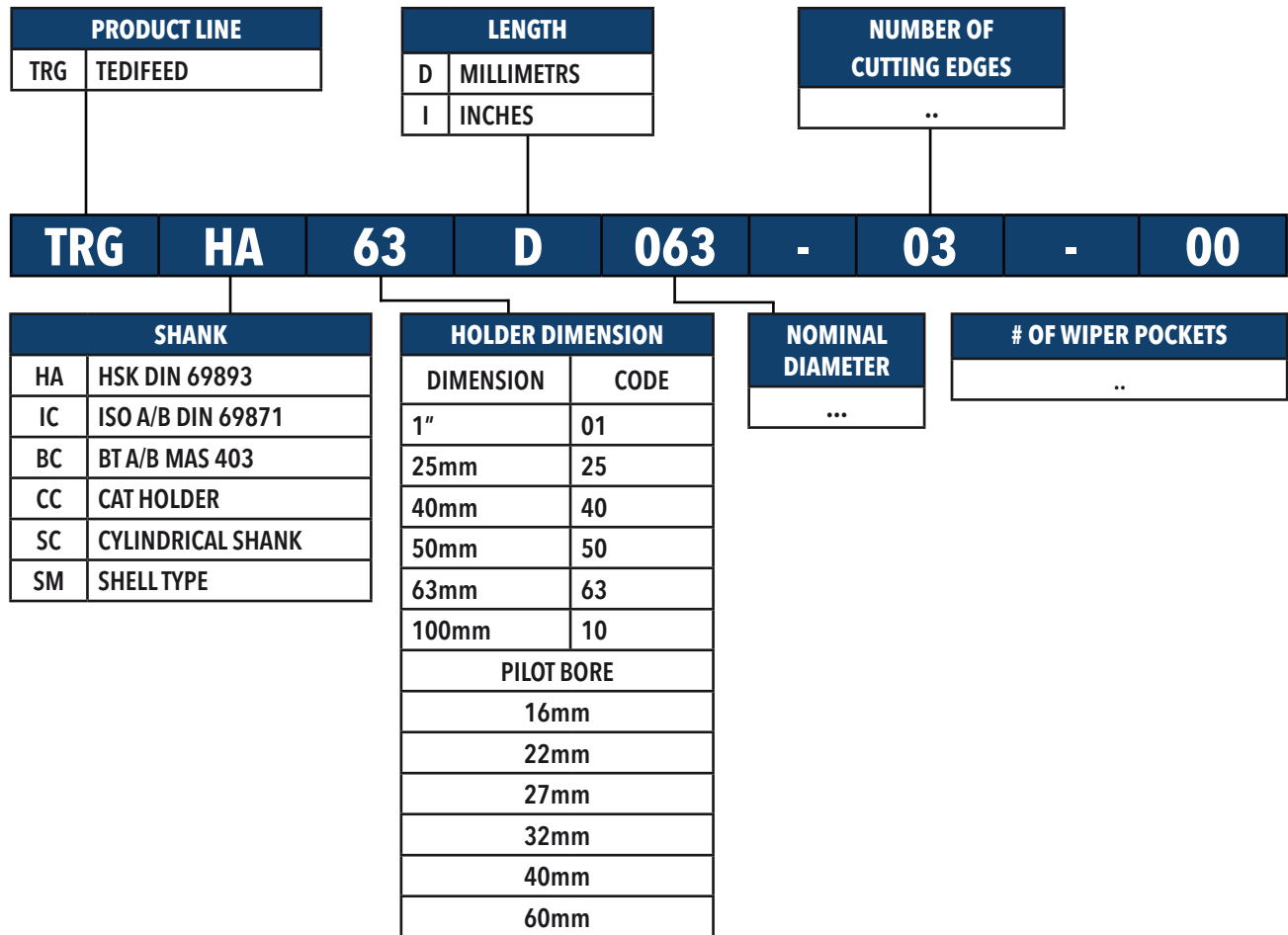
***TEDIFEEED is the new line of mill with tangential inserts available with PCD and CBN inserts, single, double and full cutting edges. TEDIFEEED is studied for machining operations from heavy roughing to superfinishing. Available with all holders, with cylindrical shank, monoblock or shell type configurations. A wide range of diameters, lengths and number of cutting edges guarantee the best results in every applications.***

### ***FEATURES:***

- ◆ *Suitable for high speed machining*
- ◆ *Low cutting forces*
- ◆ *Insert available with single tip, double tip and full edge*
- ◆ *High number of cutting edges for high productivity*



## PCD / CBN CODIFY

**Order examples:**

For placing an order of a cutter body shell type  $\varnothing 125$  with Z=18 milling + 2 wiper, please indicate the code:

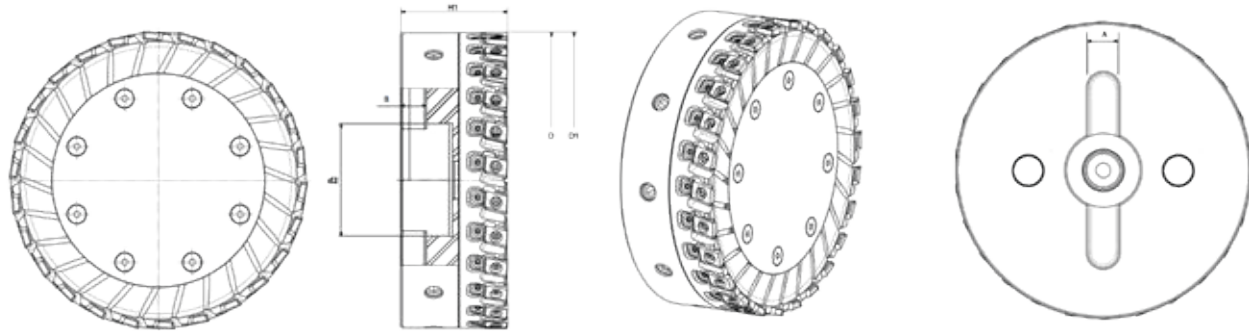
**TRGSM40D125-18-02**

or the ITEM:

**2717435**

**The following codes are referred only to the cutter body not assembled with inserts.**

# PCD / CBN SHELL TYPE CUTTERS - INCH / METRIC



Drive notch measure (A, B) according to ISO 6462-1983

	PRODUCT CODE <sup>1</sup>	d2	HOLDER SHAPE	D * ø nom.	D1**	Z	H1	MATERIAL	WEIGHT (kg) <sup>3</sup>	ITEM
INCHES	TRGSM16I015-06-00 <sup>2</sup>	16mm	A	1,5"	1.45"	6	2.165"	Steel	0,7	2718082
	TRGSM22I020-08-00	22mm	A	2"	1.95"	8	2.165"	Steel	0,9	2718081
	TRGSM22I025-10-00	22mm	B	2,5"	2.45"	10	2.165"	Steel	1,3	2718083
	TRGSM27I030-12-00	27mm	A	3"	2.95"	12	2,283"	Steel	2,1	2718084
	TRGSM32I040-16-00	32mm	A	4"	3.95"	16	2,283"	Aluminum + Steel	1,9	2718085
	TRGSM40I050-20-00	40mm	A	5"	4.95"	20	2,283"	Aluminum + Steel	3,0	2718086
	TRGSM40I050-18-02	40mm	A	5"	4.95"	18+2	2,283"	Aluminum + Steel	3,0	2718309
	TRGSM40I060-24-00	40mm	C	6"	5.95"	24	2,283"	Aluminum + Steel	4,8	2717864
	TRGSM40I060-22-02	40mm	C	6"	5.95"	22+2	2,283"	Aluminum + Steel	4,8	2718310
	TRGSM60I080-30-00	60mm	C	8"	7.95"	30	2,480"	Aluminum + Steel	8,4	2718087
	TRGSM60I080-28-02	60mm	C	8"	7.95"	28+2	2,480"	Aluminum + Steel	8,4	2718311
	TRGSM60I100-34-00	60mm	C	10"	9.95"	34	2,480"	Aluminum + Steel	13,3	2718088
TRGSM60I100-32-02	60mm	C	10"	9.95"	32+2	2,480"	Aluminum + Steel	13,3	2718312	
MM	TUGSM16D040-06-00 <sup>2</sup>	16mm	A	40	38.6	6	48	Steel	0,7	2726291
	TUGSM22D050-08-00	22mm	A	50	48.6	8	55	Steel	0,9	2726292
	TUGSM22D063-10-00	22mm	B	63	61.6	10	55	Steel	1,3	2726293
	TUGSM27D080-12-00	27mm	A	80	78.6	12	58	Steel	2,2	2726294
	TUGSM32D100-16-00	32mm	A	100	98.6	16	58	Aluminum + Steel	1,9	2726295
	TUGSM40D125-20-00	40mm	A	125	123.6	20	58	Aluminum + Steel	2,9	2726296
	TUGSM40D125-18-02	40mm	A	125	123.6	18+2	58	Aluminum + Steel	2,9	2726316
	TUGSM40D160-26-00	40mm	C	160	158.6	26	58	Aluminum + Steel	5,1	2726297
	TUGSM40D160-24-02	40mm	C	160	158.6	24+2	58	Aluminum + Steel	5,1	2726317
	TUGSM60D200-30-00	60mm	C	200	198.6	30	63	Aluminum + Steel	8,2	2726298
	TUGSM60D200-28-02	60mm	C	200	198.6	28+2	63	Aluminum + Steel	8,2	2726318
	TUGSM60D250-34-00	60mm	C	250	248.6	34	63	Aluminum + Steel	13,0	2726299
TUGSM60D250-32-02	60mm	C	250	248.6	32+2	63	Aluminum + Steel	13,0	2726319	

\* Minimum diameter guaranteed with standard inserts. Refer to related table of available cutting geometry for more detail.

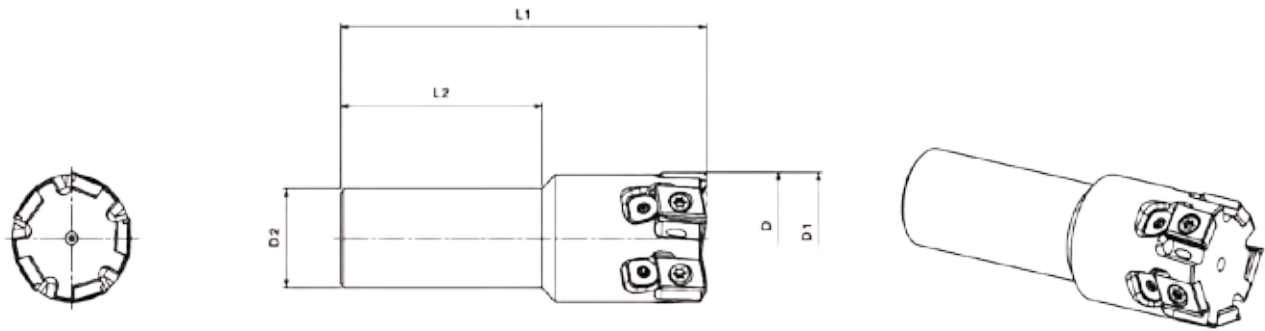
\*\* With '01' and '09' cutting edge geometry.

<sup>1</sup> Item number refers to body only, without inserts.

<sup>2</sup> Without internal coolant.

<sup>3</sup> The weight is referred to the assembled part (cutter body with inserts).

# PCD / CBN CYLINDRICAL TYPE CUTTERS - INCH / METRIC



	PRODUCT CODE <sup>1</sup>	D2	D* ø nom.	D1 <sup>***</sup>	Z	L1	L2	WEIGHT (kg) <sup>3</sup>	ITEM
INCHES	TRGSC01I010N03-00**	1"	1"	0.95"	3	4"	2"	0,4	2718069
	TRGSC01I010-03-00	1"	1"	0.95"	3	4"	2"	0,4	2718079
	TRGSC01I012-05-00	1"	1,25"	1.20"	5	4"	2"	0,5	2718080
MM	TUGSC25D025N03-00**	25	25	23.6	3	100	50	0,4	2726332
	TUGSC25D025-03-00	25	25	23.6	3	100	50	0,4	2726335
	TUGSC25D032-05-00	25	32	30.6	5	100	55	0,5	2726333

\* Minimum diameter guaranteed with standard inserts. Refer to related table of available cutting geometry for more detail

\*\* Without axial adjustment

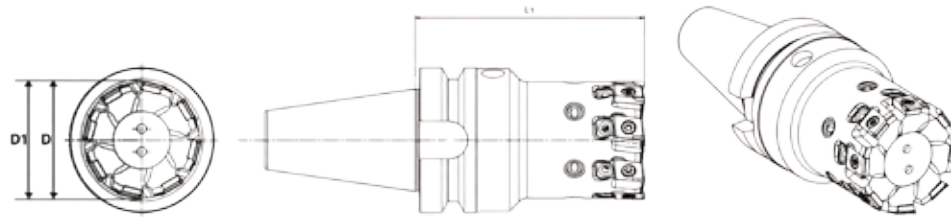
\*\*\* With '01' and '09' cutting edge geometry

<sup>1</sup> Item number refers to body only, without inserts.

<sup>3</sup> The weight is referred to the assembled part (cutter body with inserts).

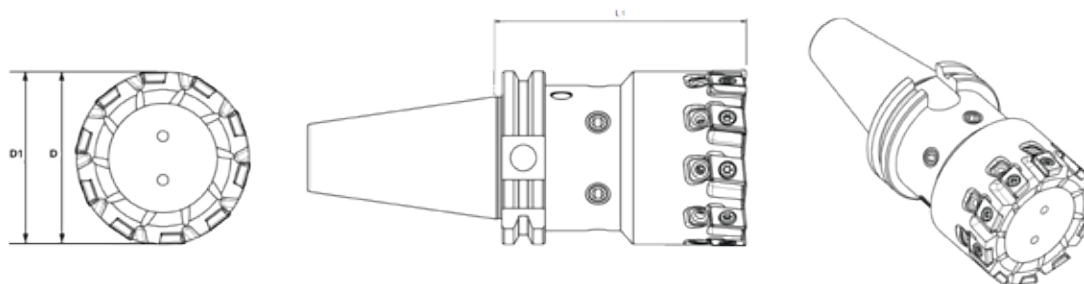


**PCD / CBN MONOBLOCK TYPE CUTTERS - METRIC** BT A/B  
MAS 403



PRODUCT CODE <sup>1</sup>	BTTAPER DIMENSION	D * ø nom.	D1	Z	L1	MATERIAL	WEIGHT (kg) <sup>3</sup>	ITEM
TRGBC40D040-06-00	40	40	41,4	6	100	Steel	1,8	2717374
TRGBC40D050-08-00	40	50	51,4	8	100	Steel	2,1	2717375
TRGBC40D063-10-00	40	63	64,4	10	100	Steel	2,7	2717376
TRGBC40D080-12-00	40	80	81,4	12	100	Steel	3,3	2717377
TRGBC40D100-16-00	40	100	101,4	16	100	Steel	4,2	2717378
TRGBC40D125-20-00	40	125	126,4	20	100	Steel	5,6	2717379

**PCD / CBN MONOBLOCK TYPE CUTTERS - METRIC** ISO A/B  
DIN 69871



PRODUCT CODE <sup>1</sup>	ISO TAPER DIMENSION	D * ø nom.	D1	Z	L1	MATERIAL	WEIGHT (kg) <sup>3</sup>	ITEM
TRGIC40D040-06-00	40	40	41,4	6	100	Steel	1,6	2717380
TRGIC40D050-08-00	40	50	51,4	8	100	Steel	2,0	2717381
TRGIC40D063-10-00	40	63	64,4	10	100	Steel	2,3	2717382
TRGIC40D080-12-00	40	80	81,4	12	100	Steel	2,9	2717383
TRGIC40D100-16-00	40	100	101,4	16	100	Steel	3,8	2717384
TRGIC40D125-20-00	40	125	126,4	20	100	Steel	5,2	2717385

\*Minimum diameter guaranteed with standard inserts. Refer to related table of available cutting geometry for more detail.

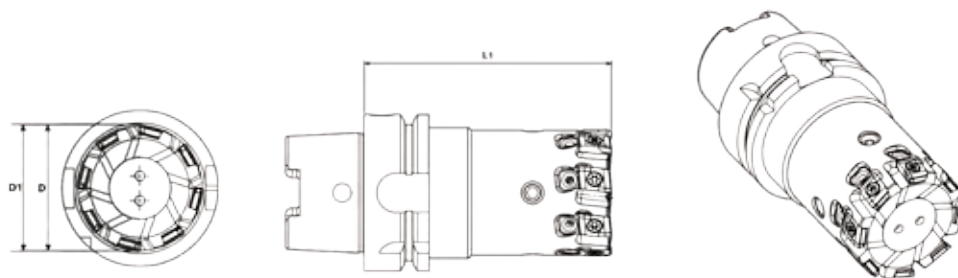
<sup>1</sup>Item number refers to body only, without inserts.

<sup>3</sup>The weight is referred to the assembled part (cutter body with cutting parts).

Monoblock cutters are non-stock standard - request a quote.

TEDI FEED<sup>®</sup>

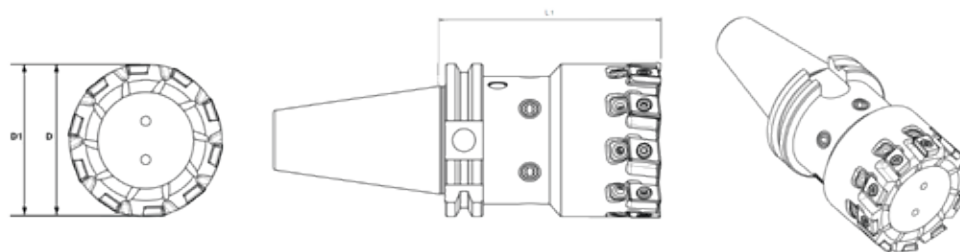
## PCD / CBN MONOBLOCK TYPE CUTTERS - METRIC

HSK A  
DIN 69893

PRODUCT CODE <sup>1</sup>	HSK TAPER DIMENSION	D * ø nom.	D1	Z	L1	MATERIAL	WEIGHT (kg) <sup>3</sup>	ITEM
TRGHA63D040-06-00	A 63	40	41,4	6	100	Steel	1,5	2717359
TRGHA63D050-80-00	A 63	50	51,4	8	100	Steel	1,8	2717360
TRGHA63D063-10-00	A 63	63	64,4	10	100	Steel	2,2	2717361
TRGHA63D080-12-00	A 63	80	81,4	12	100	Steel	2,8	2717362
TRGHA63D100-16-00	A 63	100	101,4	16	100	Steel	3,7	2717363
TRGHA63D125-20-00	A 63	125	126,4	20	100	Steel	5,1	2717364
TRGHA10D080-12-00	A 100	80	81,4	12	100	Steel	4,9	2717365
TRGHA10D100-16-00	A 100	100	101,4	16	100	Steel	5,8	2717366
TRGHA10D125-20-00	A 100	125	126,4	20	100	Steel	7,2	2717367

## PCD / CBN MONOBLOCK TYPE CUTTERS - METRIC

CAT



PRODUCT CODE <sup>1</sup>	CAT TAPER DIMENSION	D * ø nom.	D1	Z	L1	MATERIAL	WEIGHT (kg) <sup>3</sup>	ITEM
TRGCC40D040-06-00	40	40	41,4	6	100	Steel	1,6	2717368
TRGCC40D050-08-00	40	50	51,4	8	100	Steel	2,0	2717369
TRGCC40D063-10-00	40	63	64,4	10	100	Steel	2,3	2717370
TRGCC40D080-12-00	40	80	81,4	12	100	Steel	2,9	2717371
TRGCC40D100-16-00	40	100	101,4	16	100	Steel	3,8	2717372
TRGCC40D125-20-00	40	125	126,4	20	100	Steel	5,2	2717373

\*Minimum diameter guaranteed with standard inserts. Refer to related table of available cutting geometry for more detail.

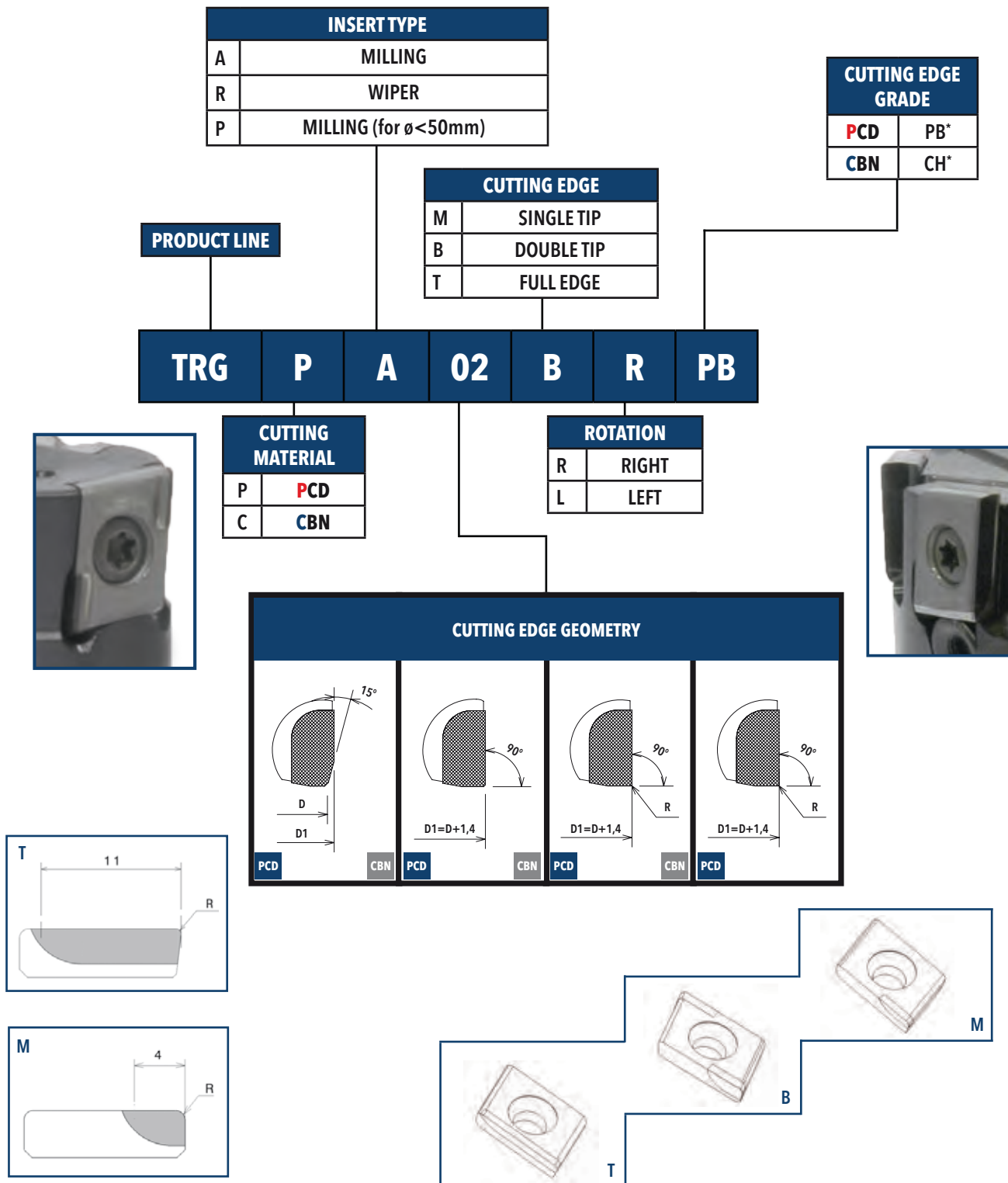
<sup>1</sup>Item number refers to body only, without inserts.

<sup>3</sup>The weight is referred to the assembled part (cutter body with cutting parts).

Monoblock cutters are non-stock standard - request a quote.

# PCD / CBN INSERTS

Inserts are screw clamped in mill body to help assembling process. Several combination of insert are available to cover a wide range of material and applications.




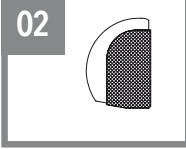
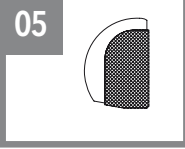
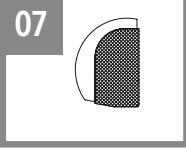
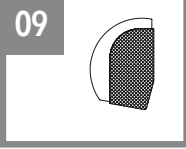

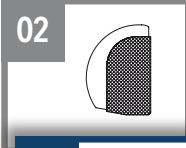

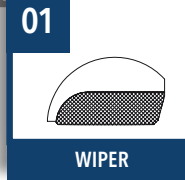

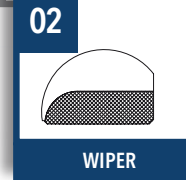
TEDI FEED<sup>®</sup>

\*Alternative grades available, please contact IT.TE.DI. for choosing the best grade.

## PCD

## INSERTS

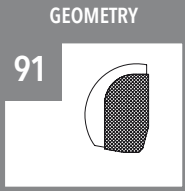
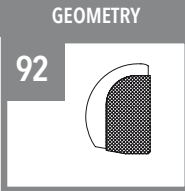
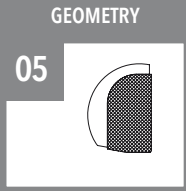

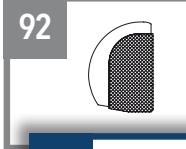
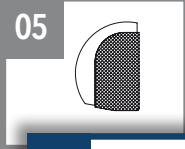
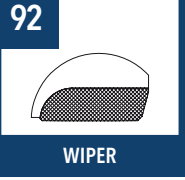
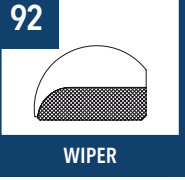
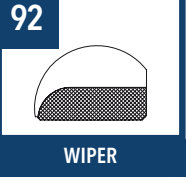
## RECOMMENDED GRADE FOR ALUMINUM ALLOYS WITH SI &lt; 12 - 14% AND MAGNESIUM ALLOYS

<p><b>GEOMETRY</b></p> <p><b>01</b></p>  <p>Recommended for finishing not square shoulder surfaces. Suitable for light roughing too.</p> <p>Achievable surface: <math>0.3 \leq Ra \leq 0.8</math></p>	<p><b>GEOMETRY</b></p> <p><b>02</b></p>  <p>Recommended for finishing square shoulder surfaces. Suitable for light roughing too.</p> <p>Achievable surface: <math>0.3 \leq Ra \leq 0.8</math></p>	<p><b>GEOMETRY</b></p> <p><b>05</b></p>  <p>Suitable for roughing or for cutting material with a high impurity content. (Cubing)</p> <p>Achievable surface: <math>0.4 \leq Ra \leq 1</math></p>	<p><b>GEOMETRY</b></p> <p><b>07</b></p>  <p>Suitable for finishing or roughing - general purpose.</p> <p>Achievable surface: <math>0.4 \leq Ra &lt; 1</math></p>	<p><b>GEOMETRY</b></p> <p><b>09</b></p>  <p>Suitable for finishing rough (gasket) surfaces</p> <p>Achievable surface: <math>0.8 \leq Ra \leq 3.2</math></p>
<p><b>01</b></p> 	<p><b>02</b></p> 		<p><b>07</b></p> 	
<p><b>01</b></p>  <p><b>WIPER</b></p> <p>Achievable Surface: <math>0,1 \leq Ra \leq 0,5</math></p>	<p><b>02</b></p>  <p><b>WIPER</b></p> <p>Achievable Surface: <math>0,1 \leq Ra \leq 0,5</math></p>		<p><b>02</b></p>  <p><b>WIPER</b></p> <p>Achievable Surface: <math>0,1 \leq Ra \leq 0,5</math></p>	

## CBN

## INSERTS

## RECOMMENDED GRADE FOR GREY CAST IRONS AND NON FERROUS CAST IRONS

<p><b>GEOMETRY</b></p> <p><b>91</b></p>  <p>Recommended for finishing not square shoulder surfaces.</p> <p>Achievable surface: <math>0,4 \leq Ra \leq 0,8</math></p>	<p><b>GEOMETRY</b></p> <p><b>92</b></p>  <p>Recommended for finishing square shoulder surfaces.</p> <p>Achievable surface: <math>0,4 \leq Ra \leq 0,8</math></p>	<p><b>GEOMETRY</b></p> <p><b>05</b></p>  <p>Recommended for roughing square shoulder surfaces.</p> <p>Achievable surface: <math>0,4 \leq Ra \leq 0,8</math></p>
<p><b>91</b></p> 	<p><b>92</b></p> 	<p><b>05</b></p> 
<p><b>92</b></p>  <p><b>WIPER</b></p> <p>Achievable Surface: <math>0,2 \leq Ra \leq 0,5</math></p>	<p><b>92</b></p>  <p><b>WIPER</b></p> <p>Achievable Surface: <math>0,2 \leq Ra \leq 0,5</math></p>	<p><b>92</b></p>  <p><b>WIPER</b></p> <p>Achievable Surface: <math>0,2 \leq Ra \leq 0,5</math></p>



# PCD

# INSERTS

## SINGLE TIP



Sample shown: right hand.

PRODUCT CODE	AVAILABILITY	GEOMETRY	ROTATION	GRADE	ITEM
TRGPA01MRPB	▲	01	R	PB	2717188
TRGPA02MRPB	▲	02	R	PB	2717189
TRGPA05MRPB	▲	05	R	PB	2717190
TRGPA07MRPB	▲	07	R	PB	2717191

## DOUBLE TIP



Sample shown: right hand.

PRODUCT CODE	AVAILABILITY	GEOMETRY	ROTATION	GRADE	ITEM
TRGPA01BRPB	▲	01	R	PB	2717192
TRGPA02BRPB	▲	02	R	PB	2717193
TRGPA05BRPB	▲	05	R	PB	2717194
TRGPA07BRPB	▲	07	R	PB	2717195

## FULL EDGE



Sample shown: right hand.

PRODUCT CODE	AVAILABILITY	GEOMETRY	ROTATION	GRADE	ITEM
TRGPA01TRPB	○	01	R	PB	2717196
TRGPA02TRPB	○	02	R	PB	2717197
TRGPA05TRPB	▲	05	R	PB	2717198
TRGPA07TRPB	▲	07	R	PB	2717199

## WIPER



Sample shown: right hand.

PRODUCT CODE	AVAILABILITY	GEOMETRY	ROTATION	GRADE	ITEM
TRGPR02TRPB	▲	02	R	PB	2717201

- ▲ Available in stock
- Available upon request

**CBN**

**INSERTS**



**SINGLE TIP**

Sample shown: right hand.

PRODUCT CODE	AVAILABILITY	GEOMETRY	ROTATION	GRADE	ITEM
TRGCA91MRCH	▲	91	R	CH	2717530
TRGCA92MRCH	▲	92	R	CH	2717531
TRGCA05MRCH	▲	05	R	CH	2717532



**DOUBLE TIP**

Sample shown: right hand.

PRODUCT CODE	AVAILABILITY	GEOMETRY	ROTATION	GRADE	ITEM
TRGCA91BRCH	▲	91	R	CH	2717533
TRGCA92BRCH	▲	92	R	CH	2717534
TRGCA05BRCH	▲	05	R	CH	2717535



**WIPER**

Sample shown: right hand.

PRODUCT CODE	AVAILABILITY	GEOMETRY	ROTATION	GRADE	ITEM
TRGCR92TRCH	▲	92	R	CH	2717537

- ▲ Available in stock
- Available upon request

# PCD

# INSERTS - FOR CUTTERS $\varnothing \leq 50\text{mm}$



## SINGLE TIP

Sample shown: right hand.

PRODUCT CODE	AVAILABILITY	GEOMETRY	ROTATION	GRADE	ITEM
TRGPP01MRPB	▲	01	R	PB	2717465
TRGPP02MRPB	▲	02	R	PB	2717466
TRGPP05MRPB	▲	05	R	PB	2717467
TRGPP07MRPB	▲	07	R	PB	2717468



## DOUBLE TIP

Sample shown: right hand.

PRODUCT CODE	AVAILABILITY	GEOMETRY	ROTATION	GRADE	ITEM
TRGPP01BRPB	▲	01	R	PB	2717469
TRGPP02BRPB	▲	02	R	PB	2717470
TRGPP05BRPB	▲	05	R	PB	2717471
TRGPP07BRPB	▲	07	R	PB	2717472



## FULL EDGE

Sample shown: right hand.

PRODUCT CODE	AVAILABILITY	GEOMETRY	ROTATION	GRADE	ITEM
TRGPP01TRPB	▲	01	R	PB	2717473
TRGPP02TRPB	○	02	R	PB	2717474
TRGPP05TRPB	▲	05	R	PB	2717475
TRGPP07TRPB	▲	07	R	PB	2717476

- ▲ Available in stock
- Available upon request

# CBN

# INSERTS - FOR CUTTERS $\varnothing \leq 50\text{mm}$

## SINGLE TIP



Sample shown: right hand.

PRODUCT CODE	AVAILABILITY	GEOMETRY	ROTATION	GRADE	ITEM
TRGCP91MRCH	▲	91	R	CH	2717541
TRGCP92MRCH	▲	92	R	CH	2717542
TRGCP05MRCH	▲	05	R	CH	2717543

## DOUBLE TIP

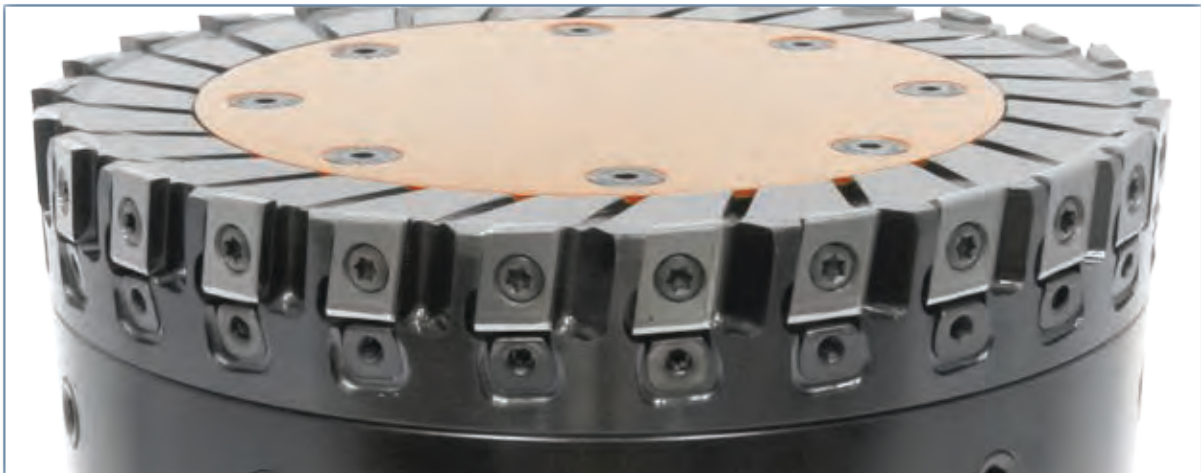


Sample shown: right hand.

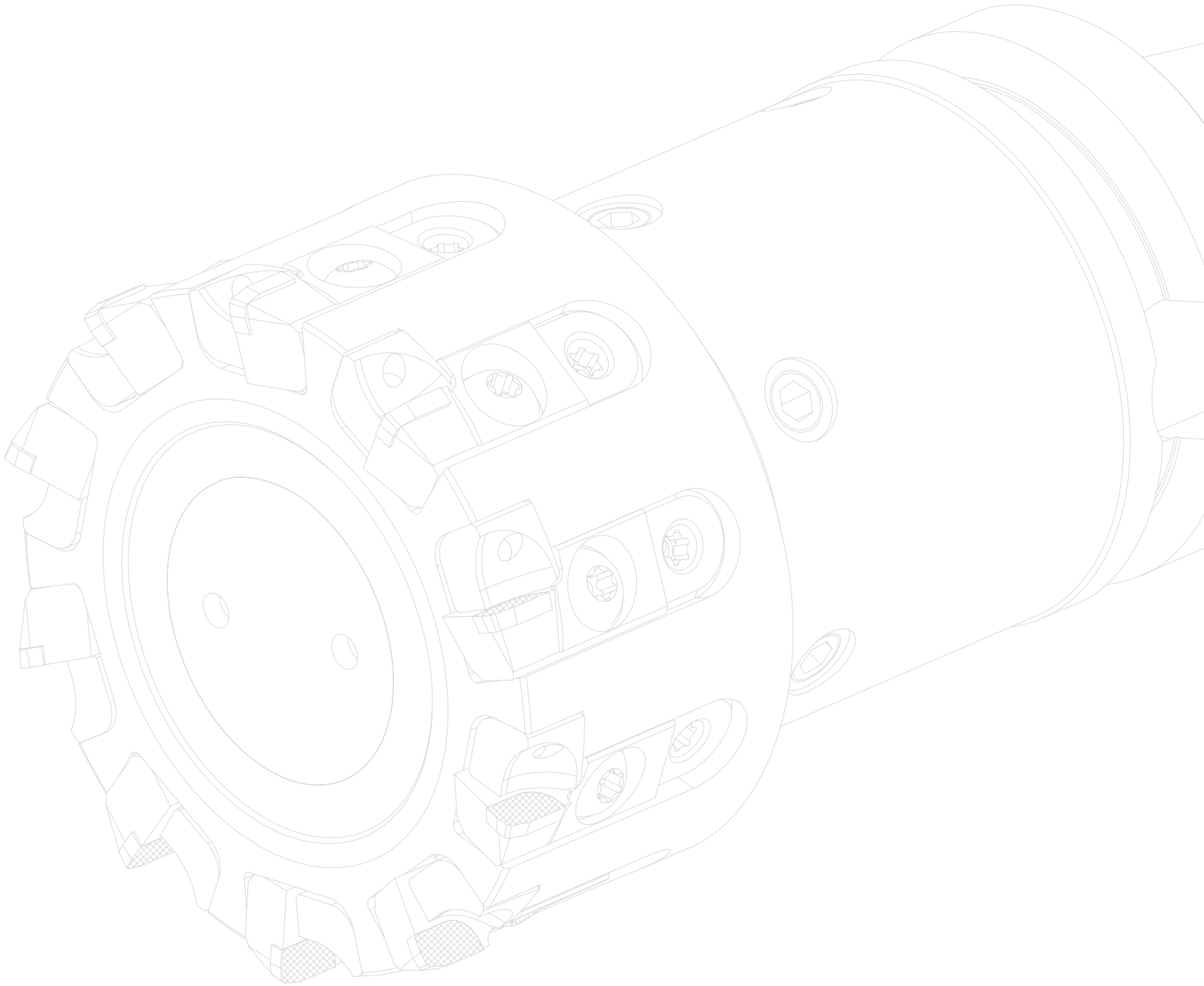
PRODUCT CODE	AVAILABILITY	GEOMETRY	ROTATION	GRADE	ITEM
TRGCP91BRCH	▲	91	R	CH	2717544
TRGCP92BRCH	▲	92	R	CH	2717545
TRGCP05BRCH	▲	05	R	CH	2717546

▲ Available in stock

○ Available upon request



# NOTES



**TEDI MILL<sup>®</sup>**  
*The perfect  
answer*



The logo for TEDI MILL, featuring the words "TEDI MILL" in a bold, blue, sans-serif font. The text is enclosed within a stylized orange and yellow swoosh that forms a partial circle around the letters. The logo is positioned in the upper right quadrant of the page, partially overlapping a light blue background element.

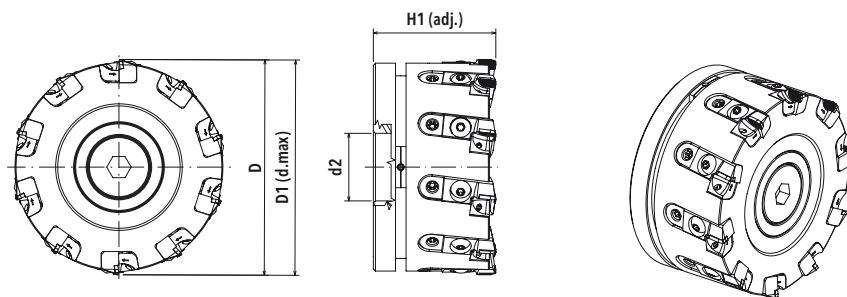
***TEDI MILL is a family of cutters with replaceable cartridges with brazed PCD and PCBN cutting edges. They have been developed thanks to IT.TE.DI's experience and research and are the result of modern solutions and accurate production checks. An important feature of the TEDI MILL is its clamping system: besides the common screw clamping, a clamping wedge is added, thus the rigidity of the cutter is increased and higher cutting speeds, feeds and tool life are attainable. The clamping wedge also prevents erosion of the cutter body from chip wash and it directs coolant directly to the cutting edge which helps prevent material build up and extends tool life. TEDI MILL cutters are very versatile: one cutter body may be equipped with inexpensive "disposable" cartridges or with cartridges that can be re-tipped several times.***

***There is the additional option to add one or more wiper cartridges to the cutter according to the machining operation. TEDI MILL cutters are provided with a quick and precise micro adjustment system which allows the user to set each individual cartridge, in order to achieve minimal axial run-out and thus ensure a good surface quality and a long life of the cutting edges. Moreover a simple device allows balancing to a G 1.6. The wide range of available cutters includes shell cutters and high productivity integral TEDI MILL cutters featuring a higher number of teeth to meet the demand of machining efficiency. All TEDI MILL cutters are designed to perform in dry machining, with coolant and with MQL. Also, the special adaptors made by IT.TE.DI can be mounted in high coolant pressure machines. TEDI MILL milling cutters show their best performance in the finishing operations. Their structural features and stability guarantee machining efficiency in roughing operations too.***



## PCD

## SHELL TYPE CUTTERS - INCH



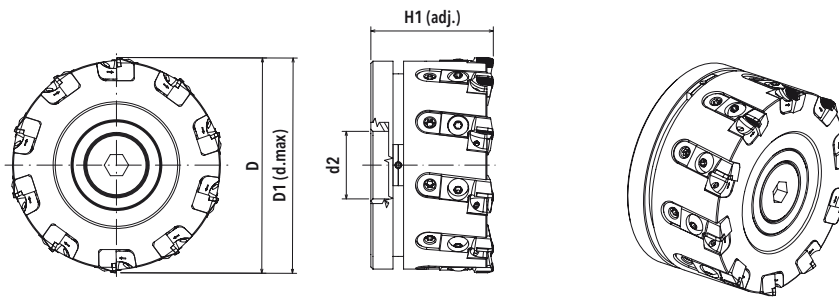
Item Number	d2 (MM)	Holder Shape	D(*) Ø nom. (INCH)	D1 (INCH)	Z	H1	Material	Rotation
FIP020R040A	22	A	2.00	2.055	4	2.165	Aluminum	R
FIP020R050S	22	A	2.00	2.055	5	2.165	Steel	R
FIP025R050A	22	B	2.50	2.555	5	2.165	Aluminum	R
FIP025R060A	22	B	2.50	2.555	6	2.165	Aluminum	R
FIP030R050A	27	A	3.00	3.055	5	2.283	Aluminum	R
FIP030R060A	27	A	3.00	3.055	6	2.283	Aluminum	R
FIP030R080A	27	A	3.00	3.055	8	2.283	Aluminum	R
FIP040R080A	32	A	4.00	4.055	8	2.283	Aluminum	R
FIP050R100A	40	A	5.00	5.055	10	2.283	Aluminum	R
FIP060R100A	40	C	6.00	6.055	10	2.283	Aluminum	R
FIP060R180A	40	C	6.00	6.055	18	2.283	Aluminum	R
<b>NEW!</b> FIP070R200A	<b>40</b>	<b>C</b>	<b>7.00</b>	<b>7.055</b>	<b>20</b>	<b>2.283</b>	<b>Aluminum</b>	<b>R</b>
FIP080R120A	60	C	8.00	8.055	12	2.48	Aluminum	R
FIP080R240A	60	C	8.00	8.055	24	2.48	Aluminum	R
FIP100R160A	60	C	10.00	10.055	16	2.48	Aluminum	R
FIP100R300A	60	C	10.00	10.055	30	2.48	Aluminum	R

(\*) Minimum diameter guaranteed with standard cartridges. Ref. page 31 depending on cartridge geometry.

(!) Item number refers to body only, without cartridges.



# PCD SHELL TYPE CUTTERS - METRIC



Item Number	d2	Holder Shape	D(*) Ø nom.	D1	Z	H1	Material	Rotation
FTP040R030S	16	A	40	41,4	3	48	Steel	R
FTP050R040A	22	A	50	51,4	4	55	Light Alloy	R
FTP050R050S	22	A	50	51,4	5	55	Steel	R
FTP063R030A	22	B	63	64,4	3	55	Light Alloy	R
FTP063R050A	22	B	63	64,4	5	55	Light Alloy	R
FTP063R060A	22	B	63	64,4	6	55	Light Alloy	R
FTP080R050A	27	A	80	81,4	5	58	Light Alloy	R
FTP080R060A	27	A	80	81,4	6	58	Light Alloy	R
FTP080R080A	27	A	80	81,4	8	58	Light Alloy	R
FTP080R100T	27	A	80	81,4	10	58	Titanium	R
FTP100R060A	32	A	100	101,4	6	58	Light Alloy	R
FTP100R080A	32	A	100	101,4	8	58	Light Alloy	R
FTP100R100A	32	A	100	101,4	10	58	Light Alloy	R
FTP100R120T	32	A	100	101,4	12	58	Titanium	R
FTP125R080A	40	A	125	126,4	8	58	Light Alloy	R
FTP125R100A	40	A	125	126,4	10	58	Light Alloy	R
FTP125R120A	40	A	125	126,4	12	58	Light Alloy	R
FTP125R140A	40	A	125	126,4	14	58	Light Alloy	R
FTP125R160T	40	A	125	126,4	16	58	Titanium	R
FTP160R100A	40	C	160	161,4	10	58	Light Alloy	R
FTP160R140A	40	C	160	161,4	14	58	Light Alloy	R
FTP160R180A	40	C	160	161,4	18	58	Light Alloy	R
FTP200R120A	60	C	200	201,4	12	63	Light Alloy	R
FTP200R160A	60	C	200	201,4	16	63	Light Alloy	R
FTP200R240A	60	C	200	201,4	24	63	Light Alloy	R
FTP250R160A	60	C	250	251,4	16	63	Light Alloy	R
FTP250R200A	60	C	250	251,4	20	63	Light Alloy	R
FTP250R300A	60	C	250	251,4	30	63	Light Alloy	R
FTP315R180A	60	D	315	316,4	18	80	Light Alloy	R
FTP315R240A	60	D	315	316,4	24	80	Light Alloy	R
FTP315R380A	60	D	315	316,4	38	80	Light Alloy	R
FTP400R260A	60	D	400	401,4	26	80	Light Alloy	R
FTP400R500A	60	D	400	401,4	50	80	Light Alloy	R

(\*) Minimum diameter guaranteed with standard cartridges. Ref. page 31 depending on cartridge geometry.

(†) Item number refers to body only, without cartridges.

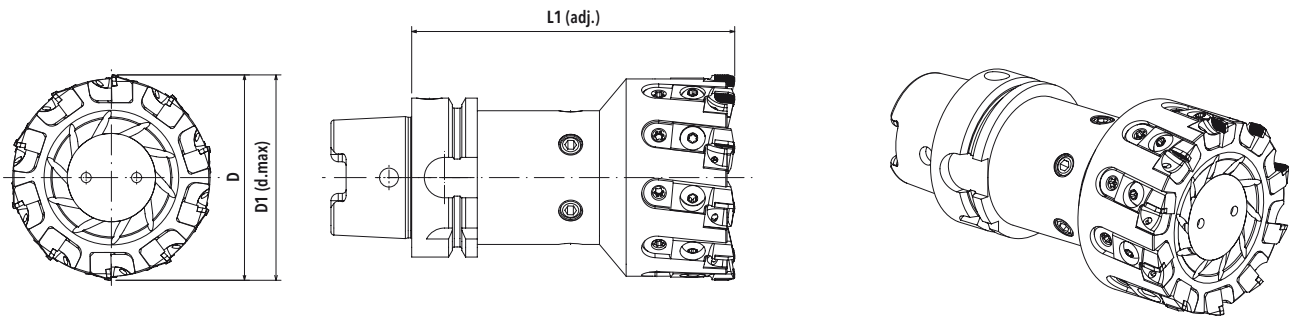
Metric diameters are non-stock standard - request a quote.



PCD

INTEGRAL TYPE CUTTERS - METRIC

HOLDER HSK A



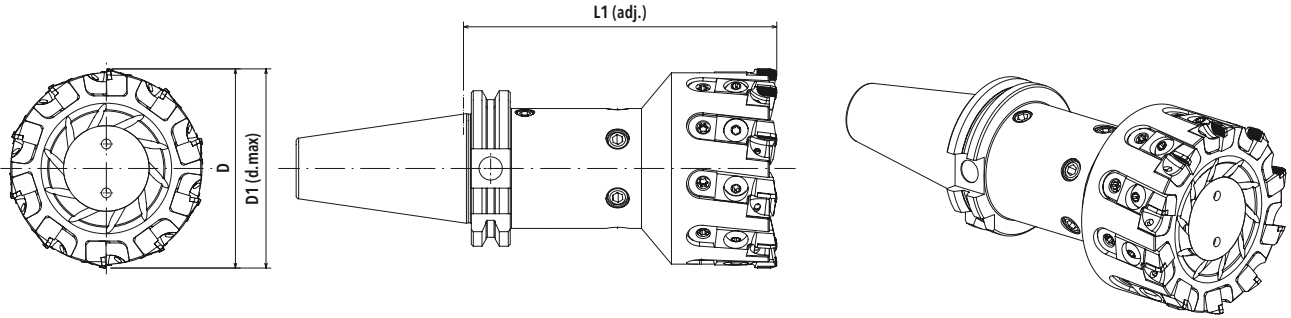
Item Number	HSK Taper Dimension	D(*) Ø nom.	D1	Z	L1	Material	Rotation
THA50040125P030	A 50	40	41.4	3	125	Steel	R
THA50050125P050	A 50	50	51.4	5	125	Steel	R
THA50063125P070	A 50	63	51.4	7	125	Steel	R
THA63040125P030	A 63	40	64.4	3	125	Steel	R
THA63050125P050	A 63	50	51.4	5	125	Steel	R
THA63063125P070	A 63	63	64.4	7	125	Steel	R
THA63080125P100	A 63	80	81.4	10	125	Steel	R
THA63100125P120	A 63	100	101.4	12	125	Steel	R
THA10080125P100	A 100	80	81.4	10	125	Steel	R
THA10100125P120	A 100	100	101.4	12	125	Steel	R
THA10125125P160	A 100	125	126.4	16	125	Steel	R

(\*) Minimum diameter guaranteed with standard cartridges. Ref. page 31 depending on cartridge geometry.

(†) Item number refers to body only, without cartridges.

Integral cutters are non-stock standard - request a quote.

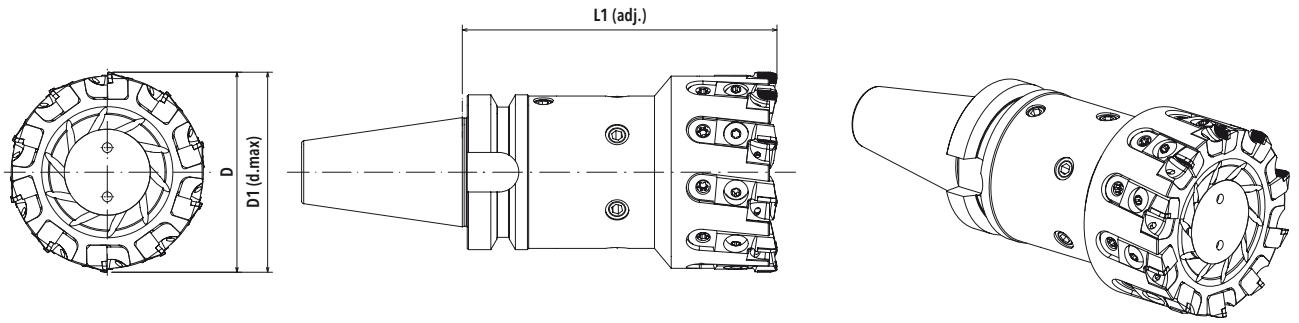
**PCD** **INTEGRAL TYPE CUTTERS - INCH** **HOLDER CAT A/B**



Item Number	CAT Taper Dimension	D(*) Ø nom. (INCH)	D1 (INCH)	Z	L1 (MM)	Material	Rotation
TCC40016125P030	40	1.63	1.68	3	125	Steel	R
TCC40020125P050	40	2.00	2.055	5	125	Steel	R
TCC40025125P070	40	2.50	2.555	7	125	Steel	R
TCC40030125P100	40	3.00	3.055	10	125	Steel	R

(\*) Minimum diameter guaranteed with standard cartridges. Ref. page 31 depending on cartridge geometry.  
 (†) Item number refers to body only, without cartridges.

**PCD** **INTEGRAL TYPE CUTTERS - METRIC** **HOLDER BT A/B MAS 403**



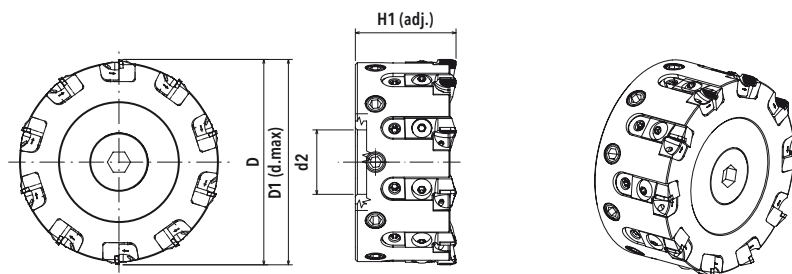
Item Number	BT Taper Dimension	D(*) Ø nom.	D1	Z	L1	Material	Rotation
TBC40040125P030	40	40	41.4	3	125	Steel	R
TBC40050125P050	40	50	51.4	5	125	Steel	R
TBC40063125P070	40	63	64.4	7	125	Steel	R
TBC40080125P100	40	80	81.4	10	125	Steel	R

(\*) Minimum diameter guaranteed with standard cartridges. Ref. page 31 depending on cartridge geometry.  
 (†) Item number refers to body only, without cartridges.  
 Integral cutters are non-stock standard - request a quote.

TEDI MILL <sup>®</sup>

# CBN

# SHELL CUTTERS - INCH



Item Number	d2 (MM)	Holder Shape	D(*) Ø nom. (INCH)	D1 (INCH)	Z	H1	Material	Rotation
FIC020R040S	22	A	2.00	2.055	4	2.165	Steel	R
FIC020R050S	22	A	2.00	2.055	5	2.165	Steel	R
FIC025R050S	22	B	2.50	2.555	5	2.165	Steel	R
FIC025R060S	22	B	2.50	2.555	6	2.165	Steel	R
FIC030R050S	27	A	3.00	3.055	5	2.283	Steel	R
FIC030R060S	27	A	3.00	3.055	6	2.283	Steel	R
FIC030R080S	27	A	3.00	3.055	8	2.283	Steel	R
FIC040R080S	32	A	4.00	4.055	8	2.283	Steel	R
FIC040R120S	32	A	4.00	4.055	12	2.283	Steel	R
FIC050R100S	40	A	5.00	5.055	10	2.283	Steel	R
FIC050R160S	40	A	5.00	5.055	16	2.283	Steel	R
FIC060R100S	40	C	6.00	6.055	10	2.283	Steel	R
FIC060R180S	40	C	6.00	6.055	18	2.283	Steel	R
FIC080R120S	60	C	8.00	8.055	12	2.48	Steel	R
FIC080R240S	60	C	8.00	8.055	24	2.48	Steel	R
FIC100R160S	60	C	10.00	10.055	16	2.48	Steel	R
FIC100R300S	60	C	10.00	10.055	30	2.48	Steel	R

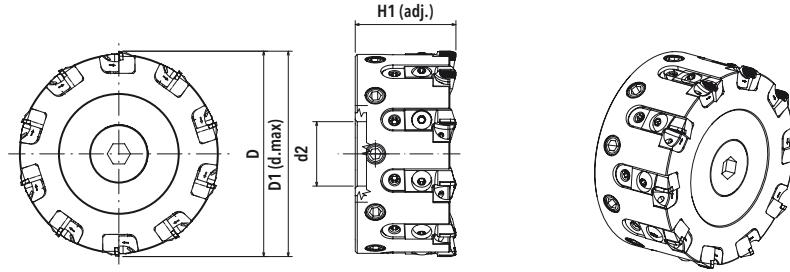
(\*) Minimum diameter guaranteed with standard cartridges. Ref. page 31 depending on cartridge geometry.

(†) Item number refers to body only, without cartridges.

CBN cutter bodies are non-stock standard - request a quote.

**CBN**

**SHELL CUTTERS - METRIC**

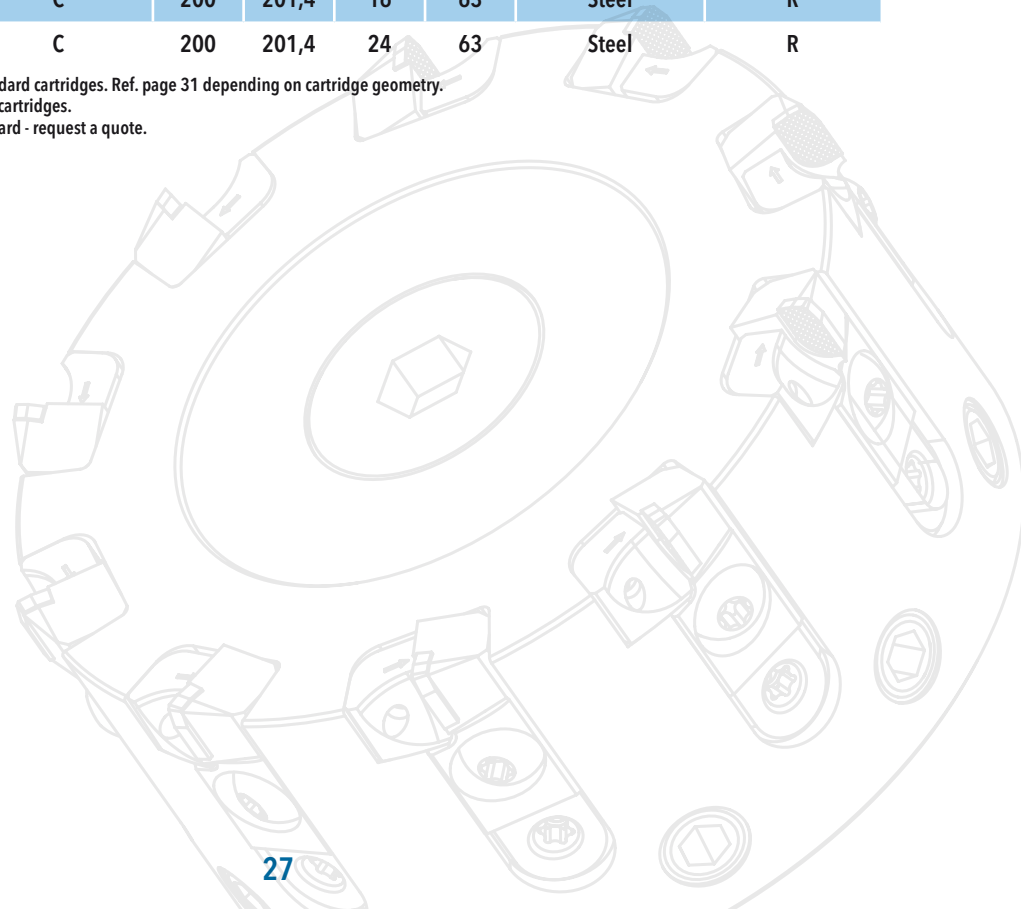


Item Number	d2	Holder Shape	D(*) Ø nom.	D1	Z	H1	Material	Rotation
FTC050R040S	22	A	50	51,4	4	50	Steel	R
FTC063R060S	22	B	63	64,4	6	50	Steel	R
FTC080R080S	27	A	80	81,4	8	50	Steel	R
FTC080R100S	27	A	80	81,4	10	50	Steel	R
FTC100R080S	32	A	100	101,4	8	50	Steel	R
FTC100R120S	32	A	100	101,4	12	50	Steel	R
FTC125R100S	40	A	125	126,4	10	63	Steel	R
FTC125R140S	40	A	125	126,4	14	63	Steel	R
FTC125R160S	40	A	125	126,4	16	63	Steel	R
FTC160R140S	40	C	160	161,4	14	63	Steel	R
FTC160R180S	40	C	160	161,4	18	63	Steel	R
FTC200R160S	60	C	200	201,4	16	63	Steel	R
FTC200R240S	60	C	200	201,4	24	63	Steel	R

(\*) Minimum diameter guaranteed with standard cartridges. Ref. page 31 depending on cartridge geometry.

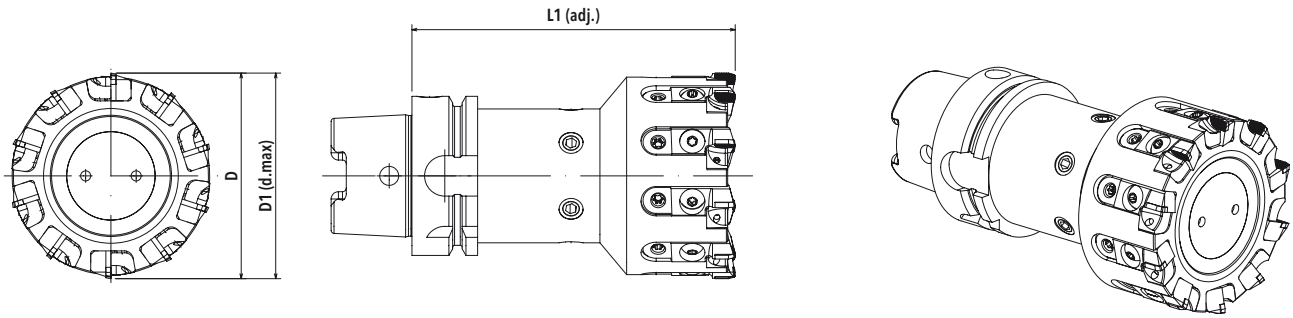
(†) Item number refers to body only, without cartridges.

Metric CBN cutter bodies are non-stock standard - request a quote.



CBN

## INTEGRAL TYPE CUTTERS - METRIC

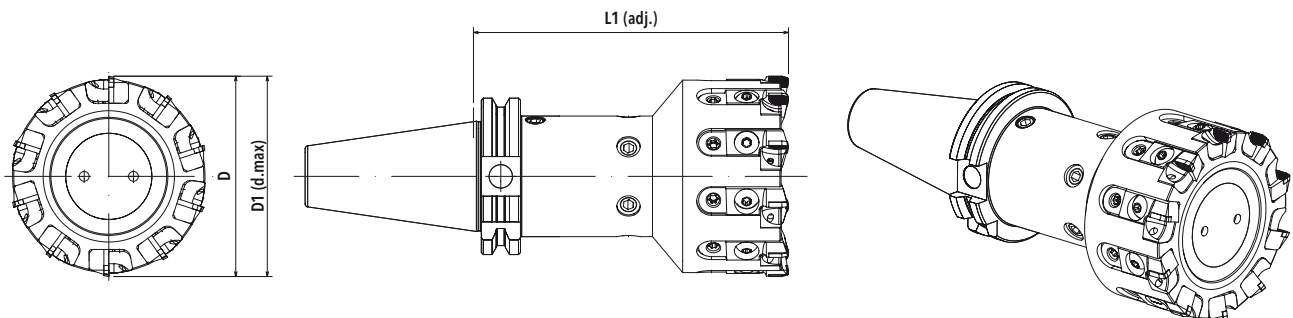
HOLDER HSK A  
DIN 69893

Item Number	HSK Taper Dimension	D(*) Ø nom.	D1	Z	L1	Material	Rotation
THA63040125C030	A 63	40	41.4	3	125	Steel	R
THA63050125C050	A 63	50	51.4	5	125	Steel	R
THA63063125C070	A 63	63	64.4	7	125	Steel	R
THA63080125C100	A 63	80	81.4	10	125	Steel	R
THA10040125C030	A 100	40	41.4	3	125	Steel	R
THA10050125C050	A 100	50	51.4	5	125	Steel	R
THA10063125C060	A 100	63	64.4	6	125	Steel	R
THA10080125C100	A 100	80	81.4	10	125	Steel	R
THA10100125C120	A 100	100	101.4	12	125	Steel	R
THA10125125C160	A 100	125	126.4	16	125	Steel	R

CBN

## INTEGRAL TYPE CUTTERS - INCH

HOLDER CAT A/B



Item Number	CAT Taper Dimension	D(*) Ø nom. (INCH)	D1 (INCH)	Z	L1 (INCH)	Material	Rotation
TCC40016125C030	40	1.63	1.68	3	125	Steel	R
TCC40020125C050	40	2.00	2.055	5	125	Steel	R
TCC40025125C070	40	2.50	2.555	7	125	Steel	R
TCC40030125C100	40	3.00	3.055	10	125	Steel	R
TCC50016125C030	50	1.63	1.68	3	125	Steel	R
TCC50020125C050	50	2.00	2.055	5	125	Steel	R
TCC50025125C070	50	2.50	2.555	7	125	Steel	R
TCC50030125C100	50	3.00	3.055	10	125	Steel	R
TCC50040125C120	50	4.00	4.055	12	125	Steel	R
TCC50050125C160	50	5.00	5.055	16	125	Steel	R

(\*) Minimum diameter guaranteed with standard cartridges. Ref. page 31 depending on cartridge geometry.

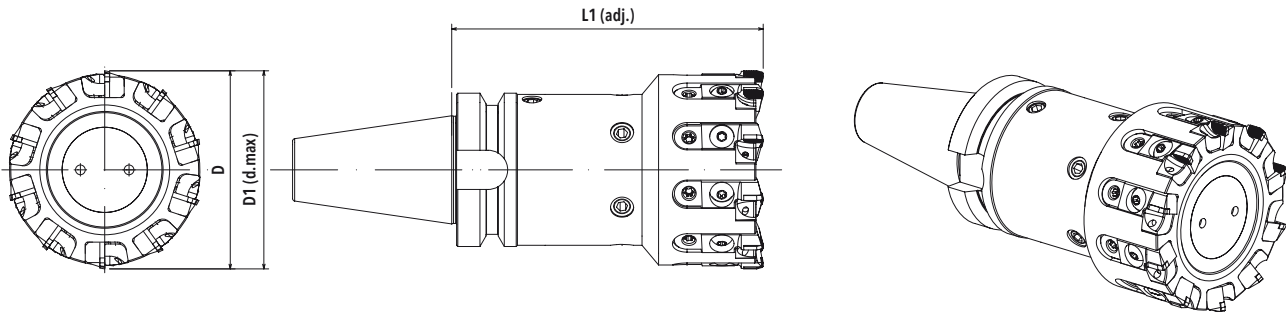
(\*) Item number refers to body only, without cartridges.

Integral cutters are non-stock standard - request a quote.

**CBN**

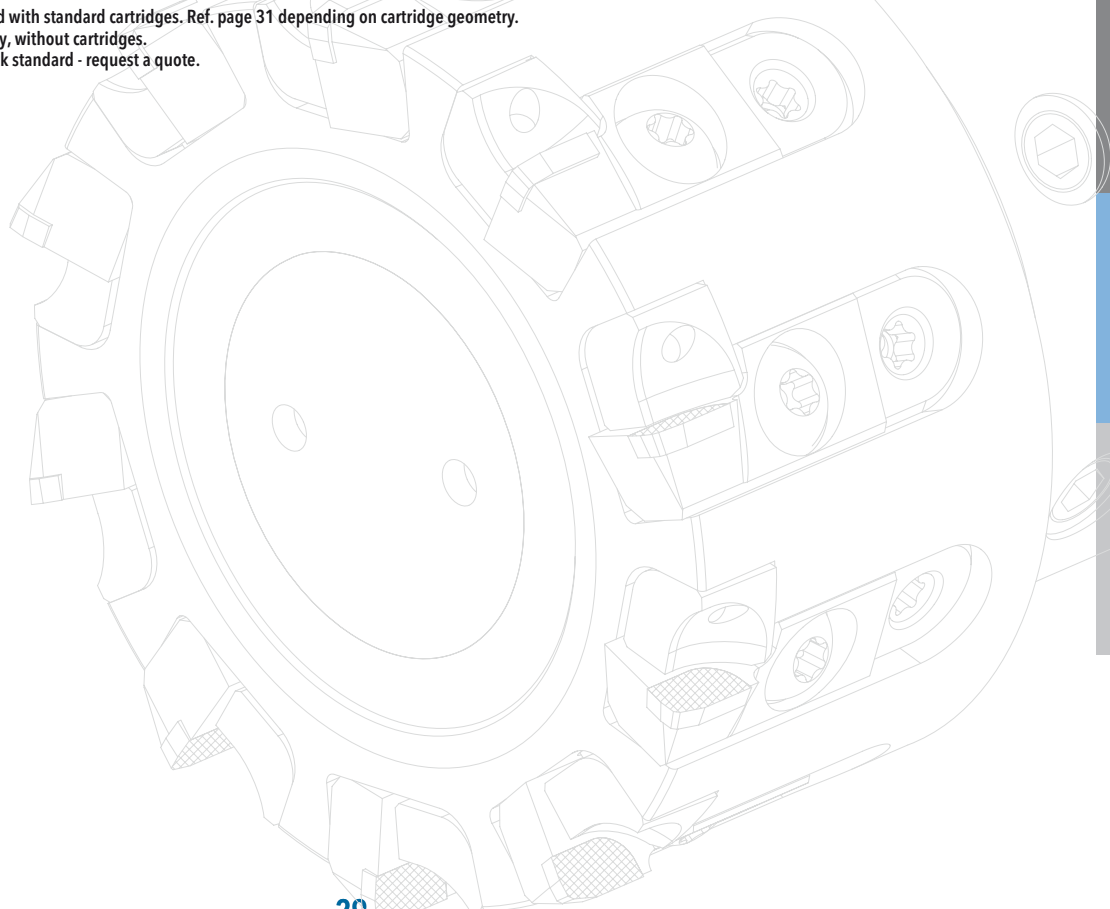
**INTEGRAL TYPE CUTTERS - METRIC**

**HOLDER BT A/B  
 MAS 403**



Item Number	BT Taper Dimension	D(*) Ø nom.	D1	Z	L1	Material	Rotation
TBC40040125C030	40	40	41.4	3	125	Steel	R
TBC40050125C050	40	50	51.4	5	125	Steel	R
TBC40063125C070	40	63	64.4	7	125	Steel	R
TBC40080125C100	40	80	81.4	10	125	Steel	R
TBC50040125C030	50	40	41.4	3	125	Steel	R
TBC50050125C050	50	50	51.4	5	125	Steel	R
TBC50063125C060	50	63	64.4	6	125	Steel	R
TBC50080125C100	50	80	81.4	10	125	Steel	R
TBC50100125C120	50	100	101.4	12	125	Steel	R
TBC50125125C160	50	125	126.4	16	125	Steel	R

(\*) Minimum diameter guaranteed with standard cartridges. Ref. page 31 depending on cartridge geometry.  
 (†) Item number refers to body only, without cartridges.  
 Integral cutter bodies are non-stock standard - request a quote.



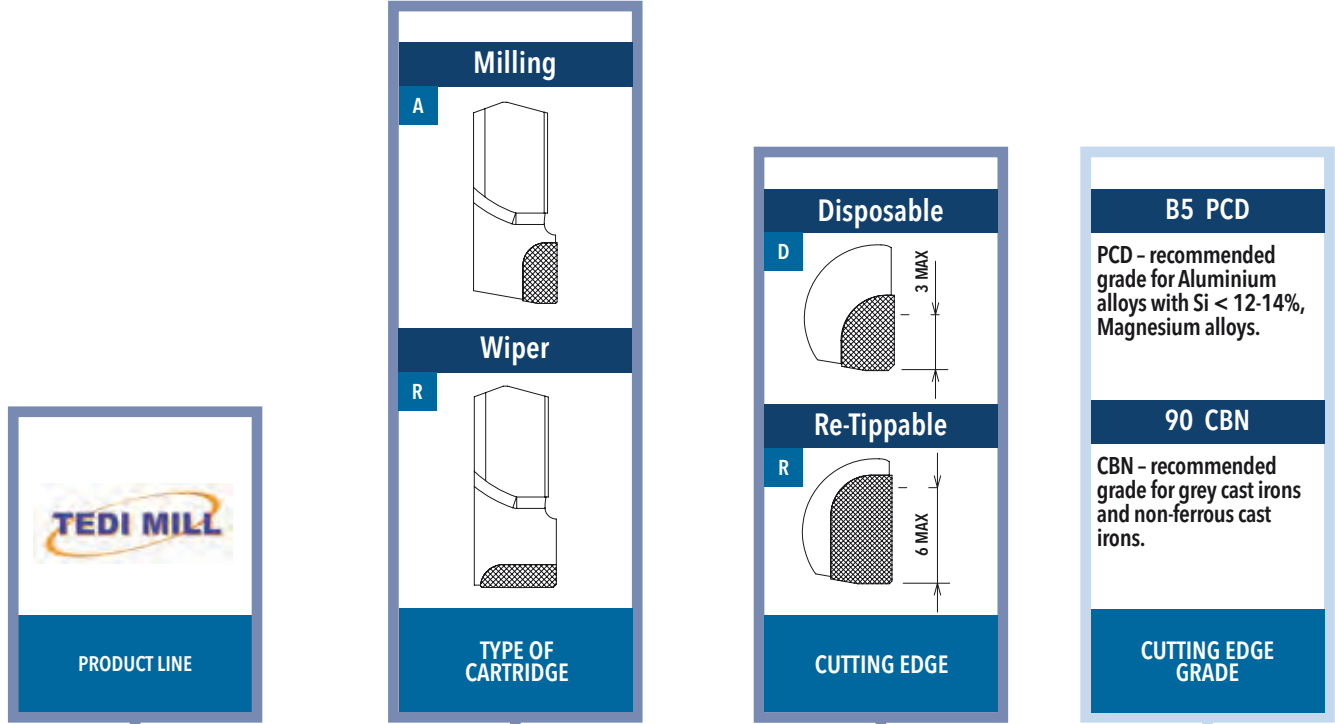
TEDI MILL<sup>®</sup>



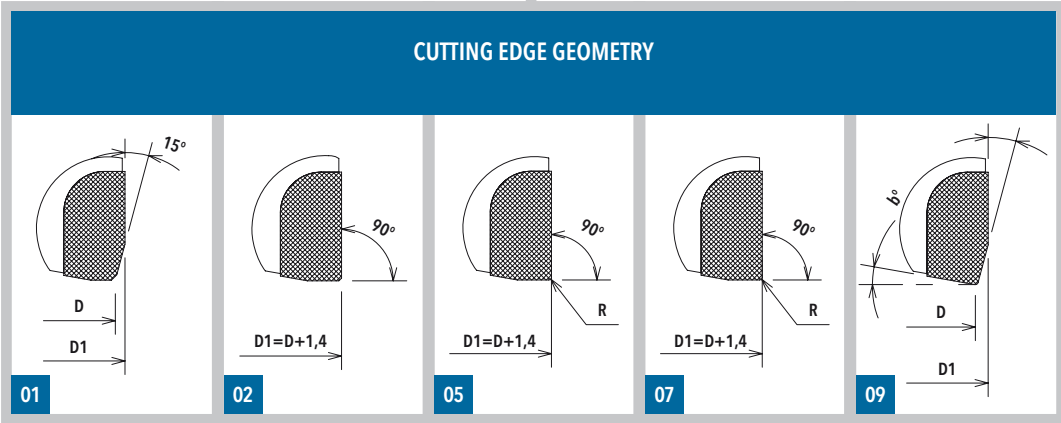
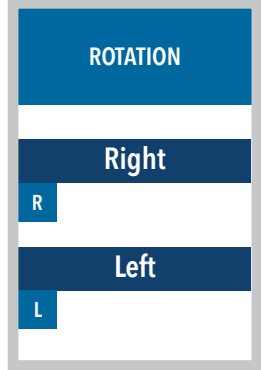
***TEDI MILL<sup>®</sup>***  
***Cartridges***

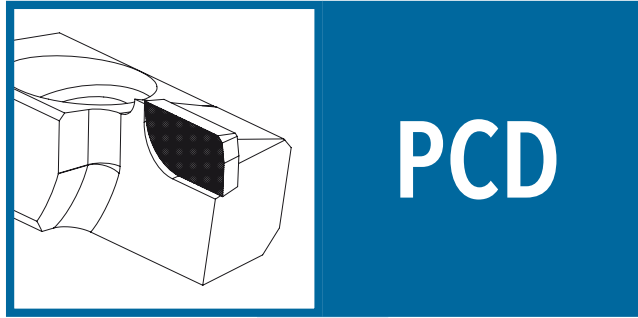


# DESIGNATION SYSTEM FOR CARTRIDGES

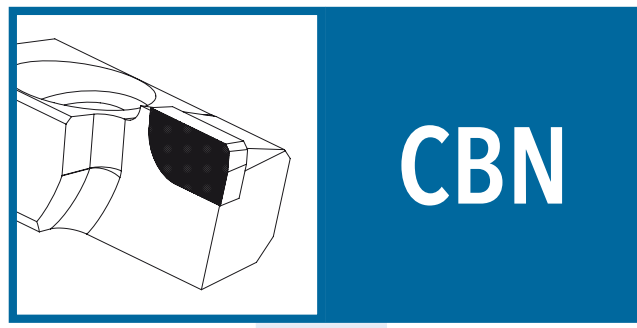


**T M C**   **P**   **A**   **0 1**   **R**   **R**   **B 5**





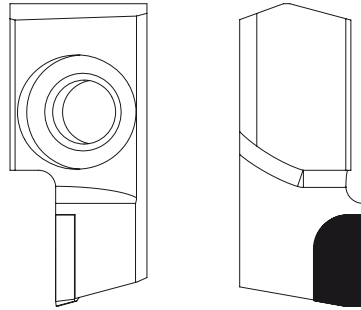
<p><b>GEOMETRY</b></p> <p>01</p>	<p><b>GEOMETRY</b></p> <p>02</p>	<p><b>GEOMETRY</b></p> <p>05</p>	<p><b>GEOMETRY</b></p> <p>07</p>	<p><b>GEOMETRY</b></p> <p>09</p>
<p>Recommended for finishing not square shoulder surfaces. Suitable for roughing too.</p> <p>Achievable surface: <math>0.3 \leq Ra \leq 0.8</math></p>	<p>Recommended for finishing square shoulder surfaces. Suitable for roughing too.</p> <p>Achievable surface: <math>0.3 \leq Ra \leq 0.8</math></p>	<p>Suitable for roughing or for cutting material with a high impurity content. (Cubing)</p> <p>Achievable surface: <math>0.4 \leq Ra &lt; 1</math></p>	<p>Suitable for finishing or roughing - general purpose.</p> <p>Achievable surface: <math>0.4 \leq Ra &lt; 1</math></p>	<p>Suitable for finishing surfaces requiring gasket retention.</p> <p>Achievable surface: <math>0.8 \leq Ra \leq 3.2</math></p>
<p>01</p> <p><b>WIPER</b></p>	<p>02</p> <p><b>WIPER</b></p>		<p>07</p> <p><b>WIPER</b></p>	
<p>Achievable surface: <math>0.1 \leq Ra \leq 0.5</math></p>	<p>Achievable surface: <math>0.1 \leq Ra \leq 0.5</math></p>		<p>Achievable surface: <math>0.1 \leq Ra \leq 0.5</math></p>	



TEDI MILL<sup>®</sup>

<p><b>GEOMETRY</b></p> <p>01</p>	<p><b>GEOMETRY</b></p> <p>02</p>	<p><b>GEOMETRY</b></p> <p>05</p>
<p>Recommended for finishing not square shoulder surfaces.</p> <p>Achievable surface:  <math>0.4 \leq Ra \leq 0.8</math></p>	<p>Recommended for finishing square shoulder surfaces.</p> <p>Achievable surface:  <math>0.4 \leq Ra \leq 0.8</math></p>	<p>Recommended for roughing square shoulder surfaces.</p> <p>Achievable surface:  <math>0.4 \leq Ra \leq 0.8</math></p>
<p>01</p> <p>01</p> <p><b>WIPER</b></p>	<p>02</p> <p>02</p> <p><b>WIPER</b></p>	<p>05</p> <p>02</p> <p><b>WIPER</b></p>
<p>Achievable surface:  <math>0.2 \leq Ra \leq 0.5</math></p>	<p>Achievable surface:  <math>0.2 \leq Ra \leq 0.5</math></p>	<p>Achievable surface:  <math>0.2 \leq Ra \leq 0.5</math></p>

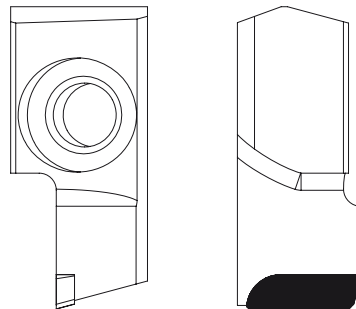
**PCD MILLING CARTRIDGES**



Item Number	PCD Grade	
	B5	(*)
TMCPA01DRB5	●	
TMCPA01RRB5	●	
TMCPA02DRB5	●	
TMCPA02RRB5	●	
TMCPA05DRB5	●	
TMCPA05RRB5	●	
TMCPA07DRB5	●	
TMCPA07RRB5	●	
TMCPA09DRB5	●	
TMCPA09RRB5	●	

(\*) Contact Ingersoll/IT.TE.DI. for the right choice of CBN grade in case of different applications.

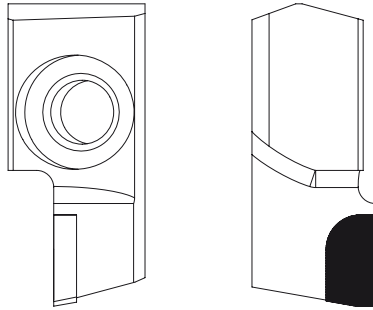
**PCD WIPER CARTRIDGES**



Item Number	PCD Grade	
	B5	(*)
TMCPR01RRB5	●	
TMCPR02RRB5	●	

(\*) Contact Ingersoll/IT.TE.DI. for the right choice of CBN grade in case of different applications.

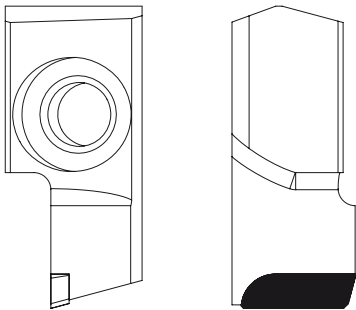
**CBN MILLING CARTRIDGES**



Item Number	CBN Grade	
	90	(*)
TMCCA01DR90	●	
TMCCA01RR90	●	
TMCCA02DR90	●	
TMCCA02RR90	●	
TMCCA05DR90	●	
TMCCA05RR90	●	

(\*) Contact Ingersoll/IT.TE.DI. for the right choice of CBN grade in case of different applications.

**CBN WIPER CARTRIDGES**




Item Number	CBN Grade	
	90	(*)
TMCCR01RR90	●	
TMCCR02RR90	●	

(\*) Contact Ingersoll/IT.TE.DI. for the right choice of CBN grade in case of different applications.

TEDI MILL<sup>®</sup>

# *ADAPTORS*



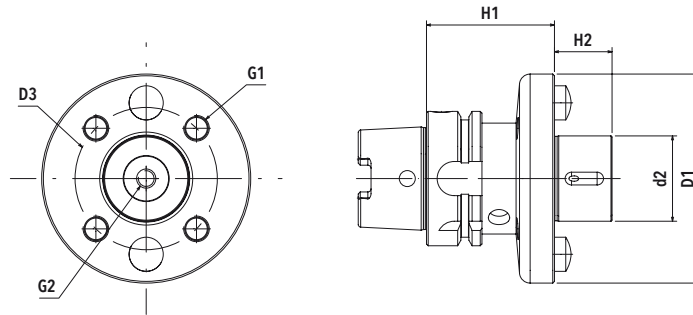


***The IT.TE.DI adaptors have been engineered to make the cutter extremely rigid. For this reason, they are designed with oversized flange diameters in combination with larger drive keys which allow the perfect tightness with the cutter body. In this way coolant leakage, which can be harmful to the spindle too, are avoided. The coolant pressure stays stable and a perfect cleaning of the cutting area during the machining is guaranteed. IT.TE.DI holders undergo careful and meticulous production processes. That's why they are particularly suitable for machining at high cutting speeds, in wet, dry or MQL operations. The holders are all balanced for high cutting speeds.***



# CUTTER HOLDERS

HOLDER HSK A  
DIN 69893



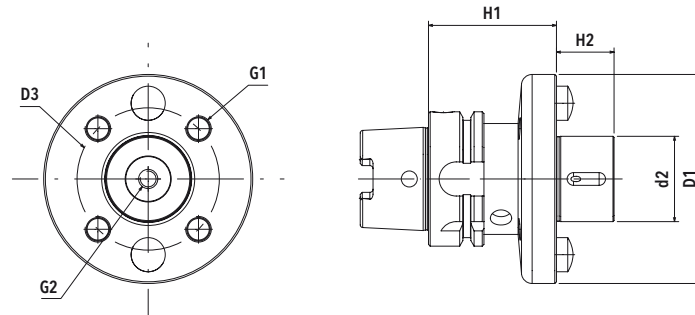
Item Number	HSK Taper Dimension	Holder Shape	d2	H1	D1	D3	H2	G1	G2
APHK40AA16050	A 40	A	16	50	41		13		M6
APHK40BA22050	A 40	B	22	50	58		19		M10
APHK40AA22050	A 40	A	22	50	50		19		M10
APHK50AA16050	A 50	A	16	50	41		13		M6
APHK50AA16100	A 50	A	16	100	41		13		M6
APHK50BA22050	A 50	B	22	50	58		19		M10
APHK50AA22050	A 50	A	22	50	50		19		M10
APHK50BA22100	A 50	B	22	100	58		19		M10
APHK50AA22100	A 50	A	22	100	50		19		M10
APHK50AA27060	A 50	A	27	60	68		21		M12
APHK50AA27100	A 50	A	27	100	68		21		M12
APHK63AA16050	A 63	A	16	50	41		13		M6
APHK63AA16100	A 63	A	16	100	41		13		M6
APHK63BA22050	A 63	B	22	50	58		19		M10
APHK63AA22050	A 63	A	22	50	50		19		M10
APHK63BA22100	A 63	B	22	100	58		19		M10
APHK63AA22100	A 63	A	22	100	50		19		M10
APHK63AA27060	A 63	A	27	60	68		21		M12
APHK63AA27100	A 63	A	27	100	68		21		M12
APHK63AA32060	A 63	A	32	60	88		24		M16
APHK63AA32100	A 63	A	32	100	88		24		M16
APHK63AA40060	A 63	A	40	60	98		27		M20
APHK63AA40100	A 63	A	40	100	98		27		M20
APHK63CA40060	A 63	C	40	60	98	66.7	27	M12	
APHK80AA16060	A 80	A	16	60	41		13		M6

NOTE: Both metric and inch size cutters will fit on metric pilot adapters.



# CUTTER HOLDERS - METRIC

HOLDER HSK A  
 DIN 69893

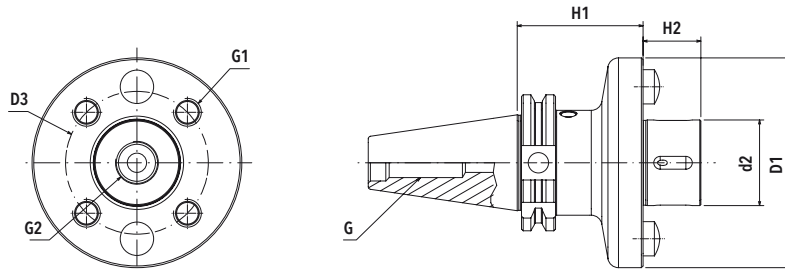


Item Number	HSK Taper Dimension	Holder Shape	d2	H1	D1	D3	H2	G1	G2
APHK80AA16120	A 80	A	16	120	41		13		M6
APHK80BA22060	A 80	B	22	60	58		19		M10
APHK80AA22060	A 80	A	22	60	50		19		M10
APHK80BA22120	A 80	B	22	120	58		19		M10
APHK80AA22120	A 80	A	22	120	50		19		M10
APHK80AA27060	A 80	A	27	60	68		21		M12
APHK80AA27120	A 80	A	27	120	68		21		M12
APHK80AA32060	A 80	A	32	60	88		24		M16
APHK80AA32120	A 80	A	32	120	88		24		M16
APHK80AA40060	A 80	A	40	60	98		27		M20
APHK80AA40120	A 80	A	40	120	98		27		M20
APHK80CA40060	A 80	C	40	60	98	66.7	27	M12	
APHK80CA60060	A 80	C	60	60	140	101.6	40	M16	
APHK10BA22060	A 100	B	22	60	58		19		M10
APHK10AA22060	A 100	A	22	60	50		19		M10
APHK10BA22120	A 100	B	22	120	58		19		M10
APHK10AA22120	A 100	A	22	120	50		19		M10
APHK10AA27060	A 100	A	27	60	68		21		M12
APHK10AA27120	A 100	A	27	120	68		21		M12
APHK10AA32070	A 100	A	32	70	88		24		M16
APHK10AA32120	A 100	A	32	120	88		24		M16
APHK10AA40070	A 100	A	40	70	98		27		M20
APHK10AA40120	A 100	A	40	120	98		27		M20
APHK10CA40070	A 100	C	40	70	98	66.7	27	M12	
APHK10CA60070	A 100	C	60	70	140	101.6	40	M16	

NOTE: Both metric and inch size cutters will fit on metric pilot adapters.

# CUTTER HOLDERS - METRIC

HOLDER CAT A/B

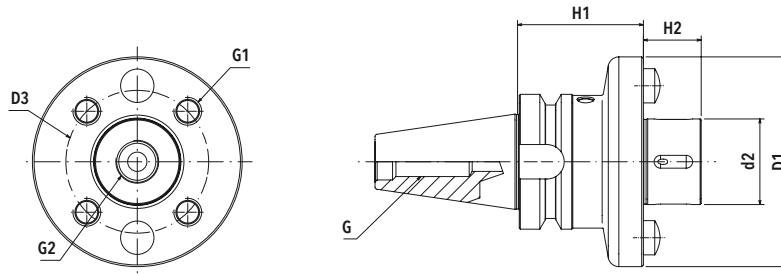


Item Number	CAT Taper Dimension	Holder Shape	d2	H1	D1	D3	H2	G1	G2
API740AC22050	40	A	22	50	50		19		M10
API740AC22100	40	A	22	100	50		19		M10
API740BC22050	40	B	22	50	58		19		M10
API740BC22100	40	B	22	100	58		19		M10
API740AC27060	40	A	27	60	68		21		M12
API740AC27100	40	A	27	100	68		21		M12
API740AC32060	40	A	32	60	88		24		M16
API740AC32100	40	A	32	100	88		24		M16
API740AC40060	40	A	40	60	98		27		M20
API740AC40100	40	A	40	100	98		27		M20
API740CC40060	40	C	40	60	98	66.7	27	M12	
API740CC40100	40	C	40	60	98	66.7	27	M12	
API750AC22060	50	A	22	60	50		19		M10
API750AC22120	50	A	22	120	50		19		M10
API750BC22060	50	B	22	60	58		19		M10
API750BC22120	50	B	22	120	58		19		M10
API750AC27060	50	A	27	60	68		21		M12
API750AC27120	50	A	27	120	68		21		M12
API750AC32070	50	A	32	70	88		24		M16
API750AC32120	50	A	32	120	88		24		M16
API750AC40070	50	A	40	70	98		27		M20
API750AC40120	50	A	40	120	98		27		M20
API750CC40070	50	C	40	70	98	66.7	27	M12	
API750CC40120	50	C	40	120	98	66.7	27	M12	
API750CC60070	50	C	60	70	140	101.6	30	M16	
API750CC60120	50	C	60	120	140	101.6	30	M16	

NOTE: Both metric and inch size cutters will fit on metric pilot adapters.

# ADAPTORS - METRIC

HOLDER BT A/B  
 MAS 403

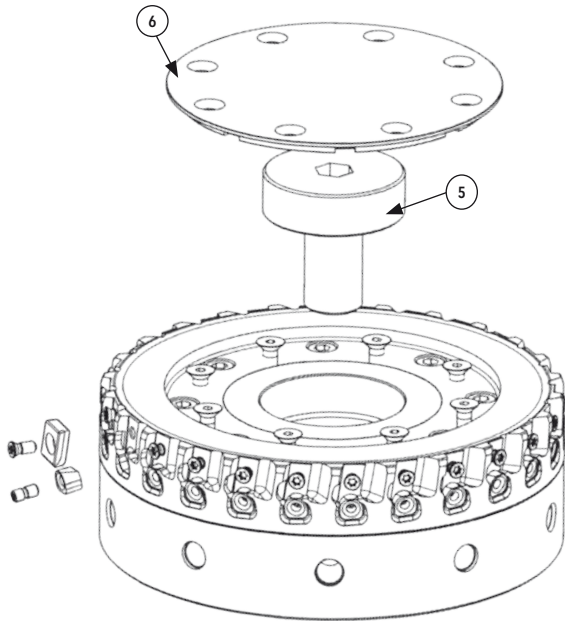


Item Number	BT Taper Dimension	Holder Shape	d2	H1	D1	D3	H2	G1	G2
<b>NEW!</b> API430AA16050	30	A	16	50	41	-	13	-	M6
<b>NEW!</b> API430BA22050	30	B	22	50	50	-	19	-	M10
<b>NEW!</b> API430AA22050	30	A	22	50	50	-	19	-	M10
<b>NEW!</b> API430AA27060	30	A	27	60	68	-	21	-	M12
<b>NEW!</b> API430AA32060	30	A	32	60	88	-	24	-	M16
API440AC16050	40	A	16	50	41		13		M6
API440AC16100	40	A	16	100	41		13		M6
API440BC22050	40	B	22	50	58		19		M10
API440AC22050	40	A	22	50	50		19		M10
API440BC22100	40	B	22	100	58		19		M10
API440AC22100	40	A	22	100	50		19		M10
API440AC27060	40	A	27	60	68		21		M12
API440AC27100	40	A	27	100	68		21		M12
API440AC32060	40	A	32	60	88		24		M16
API440AC32100	40	A	32	100	88		24		M16
API440AC40060	40	A	40	60	98		27		M20
API440AC40100	40	A	40	100	98		27		M20
API440CC40060	40	C	40	60	98	66.7	27	M12	
API450BC22060	50	B	22	60	58		19		M10
API450AC22060	50	A	22	60	50		19		M10
API450BC22120	50	B	22	120	58		19		M10
API450AC22120	50	A	22	120	50		19		M10
API450AC27060	50	A	27	60	68		21		M12
API450AC27120	50	A	27	120	68		21		M12
API450AC32070	50	A	32	70	88		24		M16
API450AC32120	50	A	32	120	88		24		M16
API450AC40070	50	A	40	70	98		27		M20
API450AC40120	50	A	40	120	98		27		M20
API450CC40070	50	C	40	70	98	66.7	27	M12	
API450CC60070	50	C	60	70	140	101.6	40	M16	

NOTE: Both metric and inch size cutters will fit on metric pilot adapters.

*TECHNICAL*





**NB: For insert mounting procedures refer to the next page**

1. Assemble the mill holder with the cutter referring to the drivers;
2. Tighten the clamping screw (5) that you find with the cutter using the right torque (see the label)
3. Put the cover (6) on its seat
4. Tighten the cover's screws

CUTTER DIAMETER	THREAD	TORQUE
ø40	M6	23Nm
ø50÷ø250	M10÷M20	60Nm



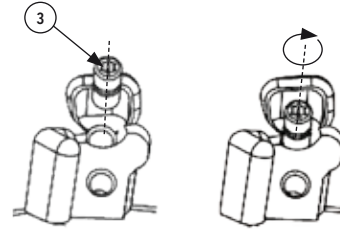
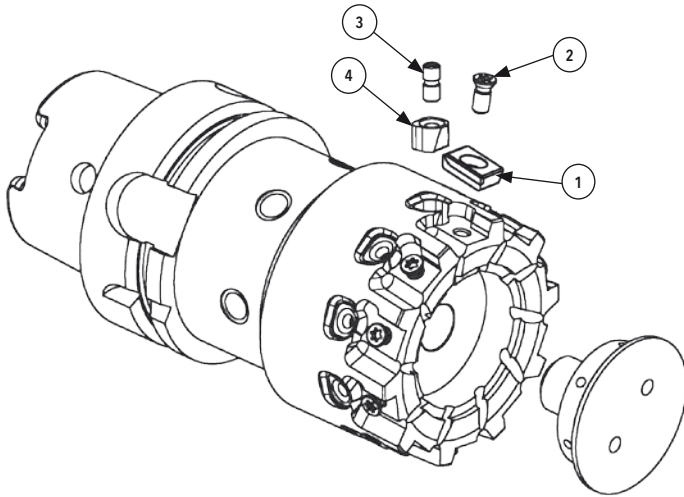
To properly use the coolant system on the shell type cutters ø50 and ø63 on TEDIMILL's holder, it's necessary to assemble on the cutter the dedicated kit composed of:

- n°2 pcs. of the item 2717081 (des. RSFTC1012) - included in the box
- n°2 pcs. of the item 4300414 (des. VC010642104015) - included in the box

PCD/CBN

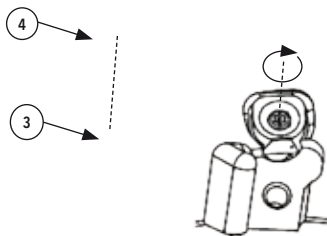
## TEDI FEED - ASSEMBLY PROCEDURE

FOR INSERTS



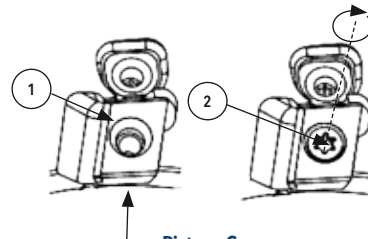
Picture A

Insert the no. 3 diff screw into its own seat and screw it down partially (1-2 threads).



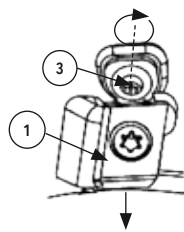
Picture B

Connect the no. 4 wedge with its own diff screw (no. 3) and screw it until the maximum gap over the cutter body is approximately 1mm.



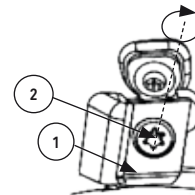
Picture C

Put the insert no. 1 into its own seat pushing as per the arrow in the cutter body. Clamp slightly the clamping screw no. 2.



Picture D

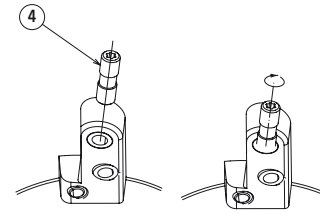
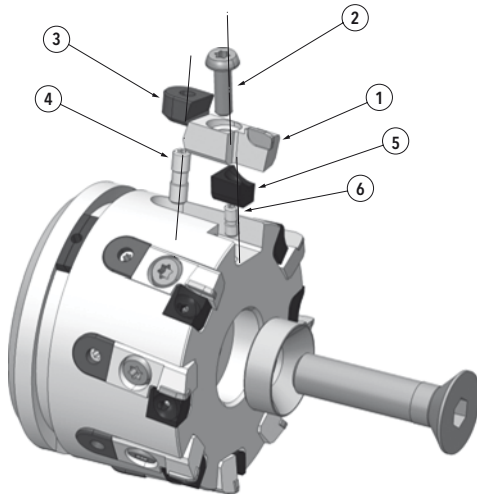
Act on diff screw no. 3 and if needed on clamping screw no. 2 (unscrew little bit) for adjusting axially the height of the insert (no. 1).



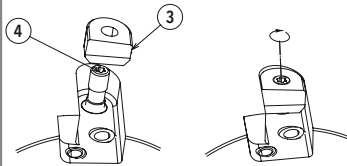
Picture E

When you reach the axial measure you need, tighten the clamping screw at 4.5Nm (no.2). Repeat the procedure for each insert.

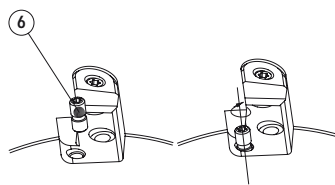
IT.TE.DI. recommends to replace the screw (n°2) every two changes of the insert.



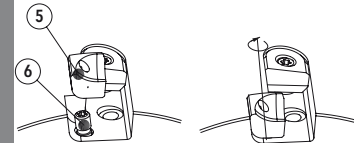
**Picture A**  
 Insert the no. 4 axial adjustment screw into its own seat and screw it down partially (1-2 threads).



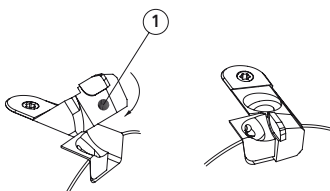
**Picture B**  
 Connect the no. 3 axial adjustment wedge with its own adjustment screw (no. 4) and screw it in until the maximum gap over the cutter body is approximately 1mm.



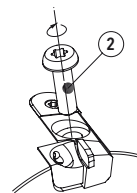
**Picture C**  
 Insert the no. 6 clamp wedge screw into its own seat and screw it down partially (1-2 threads).



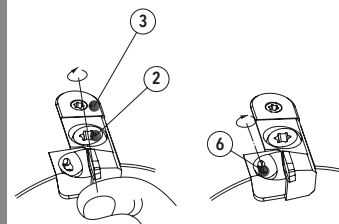
**Picture D**  
 Connect the no. 5 clamp wedge to its own screw (no. 6) and screw it partially.



**Picture E**  
 Insert the cartridge into its own seat.



**Picture F**  
 Insert the no. 2 cartridge clamping screw and screw it down partially.



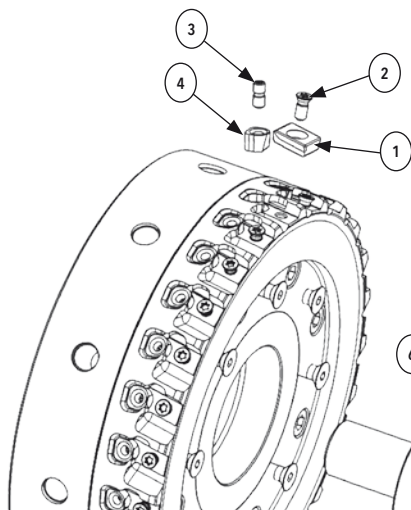
**Picture G**  
 Use your finger to push the cartridge towards the no. 3 wedge and tighten the no. 2 clamping screw. Then you can tighten the no. 6 clamp wedge screw.

IT.TE.DI. recommends to replace the screw (n°2) every two changes of the insert.

PCD/CBN

TEDI FEED - SPARE PARTS - METRIC

FOR SHELL CUTTERS



TYPE	ITEM NUMBER	
T15 T8 Grease	2706376	Std keys kit supplied with the cutter

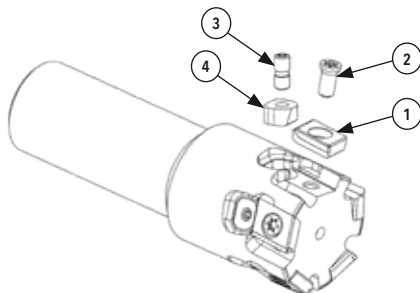
\*S=SCRAPER  
W=WIPER

PRODUCT CODE	2	3	4*	5	6
TRGSM16D040-06-00	VX040024A	RSRGR5M40	S=RSFTC1009	-	VC004762106035
TRGSM22D050-08-00	VX040024A	RSRGR5M40	S=RSFTC1008	-	RSFTS4050M
TRGSM22D063-10-00	VX040024A	RSRGR5M40	S=RSFTC1008	RSFTS4063M	VC004762110035F
TRGSM27D080-12-00	VX040024A	RSRGR5M40	S=RSFTC1008	RSFTS4080	VC00TEDI12040F
TRGSM32D100-16-00	VX040024A	RSRGR5M40	S=RSFTC1008	RSFTS4100	VC00TANG16040F
TRGSM40D125-20-00	VX040024A	RSRGR5M40	S=RSFTC1008	RSFTS4125	VC00TEDI20040F
TRGSM40D125-18-02	VX040024A	RSRGR5M40	S=RSFTC1008 / W=RSFTC1010	RSFTS4125W	VC00TEDI20040F
TRGSM40D160-26-00	VX040024A	RSRGR5M40	S=RSFTC1008	RSFTS4160	4xVC004762112050
TRGSM40D160-24-02	VX040024A	RSRGR5M40	S=RSFTC1008 / W=RSFTC1010	RSFTS4160W	4xVC004762112050
TRGSM60D200-30-00	VX040024A	RSRGR5M40	S=RSFTC1008	RSFTS4200	4xVC004762116060
TRGSM60D200-28-02	VX040024A	RSRGR5M40	S=RSFTC1008 / W=RSFTC1010	RSFTS4200W	4xVC004762116060
TRGSM60D250-34-00	VX040024A	RSRGR5M40	S=RSFTC1008	RSFTS4250	4xVC004762116060
TRGSM60D250-32-02	VX040024A	RSRGR5M40	S=RSFTC1008 / W=RSFTC1010	RSFTS4250W	4xVC004762116060

PCD/CBN

TEDI FEED - SPARE PARTS - METRIC

FOR CYLINDRICAL CUTTERS



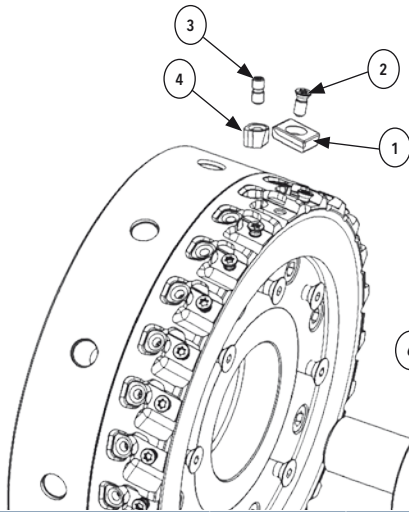
TYPE	ITEM NUMBER	
T15 T8 Grease	2706376	Std keys kit supplied with the cutter

PRODUCT CODE	2	3	4
TRGSC25D025N03-00	VX040024A	-	-
TRGSC25D025-03-00	VX040024A	VX040028A	RSFTC1011
TRGSC25D032-05-00	VX040024A	RSRGR5M40	RSFTC1009



## TEDI MILL - SPARE PARTS - INCH

FOR SHELL CUTTERS



TYPE	ITEM NUMBER	
T15                         T8                         Grease	2706376	Std keys kit supplied with the cutter

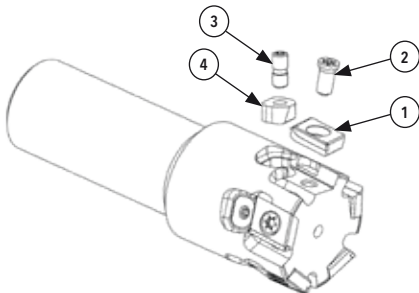
\*S=MILLING  
W=WIPER

PRODUCT CODE	2	3	4*	5	6
TRGSM16I015-06-00	VX040024A	RSRGR5M40	S=RSFTC1009	-	VC004762I06035
TRGSM22I020-08-00	VX040024A	RSRGR5M40	S=RSFTC1008	-	RSFTS4050M
TRGSM22I025-10-00	VX040024A	RSRGR5M40	S=RSFTC1008	RSFTS4063M	VC004762I10035F
TRGSM27I030-12-00	VX040024A	RSRGR5M40	S=RSFTC1008	RSFTS4080	VC00TEDI12040F
TRGSM32I040-16-00	VX040024A	RSRGR5M40	S=RSFTC1008	RSFTS4100	VC00TANG16040F
TRGSM40I050-20-00	VX040024A	RSRGR5M40	S=RSFTC1008	RSFTS4125	VC00TEDI20040F
TRGSM40I050-18-02	VX040024A	RSRGR5M40	S=RSFTC1008 / W=RSFTC1010	RSFTS4125W	VC00TEDI20040F
TRGSM40I060-24-00	VX040024A	RSRGR5M40	S=RSFTC1008	RSFTS4160	4xVC004762I12050
TRGSM40I060-22-02	VX040024A	RSRGR5M40	S=RSFTC1008 / W=RSFTC1010	RSFTS4160W	4xVC004762I12050
TRGSM60I080-30-00	VX040024A	RSRGR5M40	S=RSFTC1008	RSFTS4200	4xVC004762I16060
TRGSM60I080-28-02	VX040024A	RSRGR5M40	S=RSFTC1008 / W=RSFTC1010	RSFTS4200W	4xVC004762I16060
TRGSM60I100-34-00	VX040024A	RSRGR5M40	S=RSFTC1008	RSFTS4250	4xVC004762I16060
TRGSM60I100-32-02	VX040024A	RSRGR5M40	S=RSFTC1008 / W=RSFTC1010	RSFTS4250W	4xVC004762I16060

## PCD/CBN

## TEDI MILL - SPARE PARTS - INCH

FOR CYLINDRICAL CUTTERS

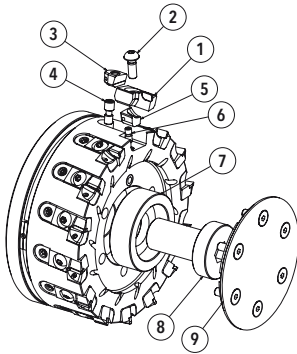






TYPE	ITEM NUMBER	
T15                         T8                         Grease	2706376	Std keys kit supplied with the cutter

PRODUCT CODE	2	3	4
TRGSC01I010N03-00	VX040024A	-	-
TRGSC01I010-03-00	VX040024A	VX040028A	RSFTC1011
TRGSC01I012-05-00	VX040024A	RSRGR5M40	RSFTC1009

# TEDI MILL - SPARE PARTS

FOR SHELL CUTTERS

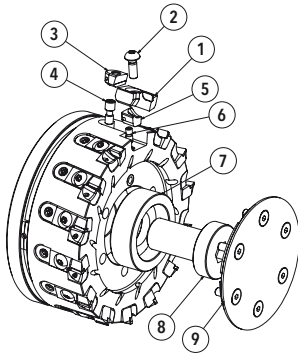


TYPE	ITEM NUMBER	
  	4360818	Std keys kit supplied with the cutter
	4361287	Torque key upon request

Item Number	2	3	4	5	6	7	8	9
FTP040R030S	VX050006A	RSFTC3000	RSRGR6M50	RSFTA1000	RSRGR5M40		VC004762106035	
FTP050R040A	VX050006A	RSFTC3000	RSRGR6M50	RSFTA1000	RSRGR5M40		VC00TEDI10040	
FTP050R050S	VX050006A	RSFTC3000	RSRGR6M50	RSFTA1000	RSRGR5M40		VC00TEDI10040	
FTP063R030A	VX050006A	RSFTC3000	RSRGR6M50	RSFTA1000	RSRGR5M40		VC004762110040	
FTP063R050A	VX050006A	RSFTC3000	RSRGR6M50	RSFTA1000	RSRGR5M40		VC004762110040	
FTP063R060A	VX050006A	RSFTC3000	RSRGR6M50	RSFTA1000	RSRGR5M40		VC004762110040	
FTP080R050A	VX050006A	RSFTC3000	RSRGR6M50	RSFTA1000	RSRGR5M40	RSBF4080	VC00TEDI12040	
FTP080R060A	VX050006A	RSFTC3000	RSRGR6M50	RSFTA1000	RSRGR5M40	RSBF4080	VC00TEDI12040	
FTP080R080A	VX050006A	RSFTC3000	RSRGR6M50	RSFTA1000	RSRGR5M40	RSBF4080	VC00TEDI12040	
FTP080R100T	VX050006A	RSFTC3000	RSRGR6M50	RSFTA1000	RSRGR5M40	RSBF4080	VC00TEDI12040F	RSFPT3080
FTP100R060A	VX050006A	RSFTC3000	RSRGR6M50	RSFTA1000	RSRGR5M40	RSBF4100	VC00TEDI16040	
FTP100R080A	VX050006A	RSFTC3000	RSRGR6M50	RSFTA1000	RSRGR5M40	RSBF4100	VC00TEDI16040	
FTP100R100A	VX050006A	RSFTC3000	RSRGR6M50	RSFTA1000	RSRGR5M40	RSBF4100	VC00TEDI16040	
FTP100R120T	VX050006A	RSFTC3000	RSRGR6M50	RSFTA1000	RSRGR5M40	RSBF4100	VC00TEDI16040F	RSFPT1100
FTP125R080A	VX050006A	RSFTC3000	RSRGR6M50	RSFTA1000	RSRGR5M40	RSBF4125	VC00TEDI20040F	RSFPT1125
FTP125R100A	VX050006A	RSFTC3000	RSRGR6M50	RSFTA1000	RSRGR5M40	RSBF4125	VC00TEDI20040F	RSFPT1125
FTP125R120A	VX050006A	RSFTC3000	RSRGR6M50	RSFTA1000	RSRGR5M40	RSBF4125	VC00TEDI20040F	RSFPT1125
FTP125R140A	VX050006A	RSFTC3000	RSRGR6M50	RSFTA1000	RSRGR5M40	RSBF4125	VC00TEDI20040F	RSFPT1125
FTP125R160T	VX050006A	RSFTC3000	RSRGR6M50	RSFTA1000	RSRGR5M40	RSBF4125	VC00TEDI20040F	RSFPT1125
FTP160R100A	VX050006A	RSFTC3000	RSRGR6M50	RSFTA1000	RSRGR5M40		VC004762112050	RSFPT1160
FTP160R140A	VX050006A	RSFTC3000	RSRGR6M50	RSFTA1000	RSRGR5M40		VC004762112050	RSFPT1160
FTP160R180A	VX050006A	RSFTC3000	RSRGR6M50	RSFTA1000	RSRGR5M40		VC004762112050	RSFPT1160
FTP200R120A	VX050006A	RSFTC3000	RSRGR6M50	RSFTA1000	RSRGR5M40		VC004762116050	RSFPT1200
FTP200R160A	VX050006A	RSFTC3000	RSRGR6M50	RSFTA1000	RSRGR5M40		VC004762116050	RSFPT1200
FTP200R240A	VX050006A	RSFTC3000	RSRGR6M50	RSFTA1000	RSRGR5M40		VC004762116050	RSFPT1200

# TEDI MILL - SPARE PARTS

FOR SHELL CUTTERS



TYPE	ITEM NUMBER	
T20 T8 Grease	4360818	Std keys kit supplied with the cutter
T 20	4361287	Torque key upon request

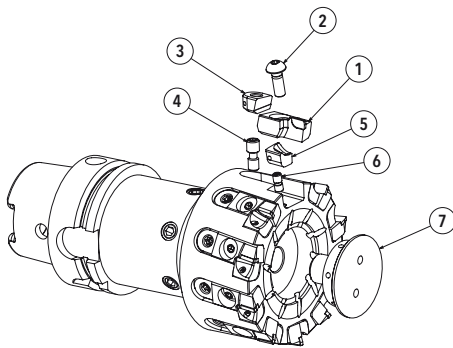
Item Number	2	3	4	5	6	7	8	9
FTP250R160A	VX050006A	RSFTC3000	RSRGR6M50	RSFTA1000	RSRGR5M40		VC004762116050	RSFPT1200
FTP250R200A	VX050006A	RSFTC3000	RSRGR6M50	RSFTA1000	RSRGR5M40		VC004762116050	RSFPT1200
FTP250R300A	VX050006A	RSFTC3000	RSRGR6M50	RSFTA1000	RSRGR5M40		VC004762116050	RSFPT1200
FTP315R180A	VX050006A	RSFTC3000	RSRGR6M50	RSFTA1000	RSRGR5M40		VC004762120050	RSFPT1315
FTP315R240A	VX050006A	RSFTC3000	RSRGR6M50	RSFTA1000	RSRGR5M40		VC004762120050	RSFPT1315
FTP315R380A	VX050006A	RSFTC3000	RSRGR6M50	RSFTA1000	RSRGR5M40		VC004762120050	RSFPT1315
FTP400R260A	VX050006A	RSFTC3000	RSRGR6M50	RSFTA1000	RSRGR5M40		VC004762120050	RSFPT1315
FTP400R500A	VX050006A	RSFTC3000	RSRGR6M50	RSFTA1000	RSRGR5M40		VC004762120050	RSFPT1315
FIP020R040A	VX050006A	RSFTC3000	RSRGR6M50	RSFTA1000	RSRGR5M40		VC00TEDI10040	
FIP020R050S	VX050006A	RSFTC3000	RSRGR6M50	RSFTA1000	RSRGR5M40		VC00TEDI10040	
FIP025R050A	VX050006A	RSFTC3000	RSRGR6M50	RSFTA1000	RSRGR5M40		VC004762110040	
FIP025R060A	VX050006A	RSFTC3000	RSRGR6M50	RSFTA1000	RSRGR5M40		VC004762110040	
FIP030R050A	VX050006A	RSFTC3000	RSRGR6M50	RSFTA1000	RSRGR5M40	RSBF4080	VC00TEDI12040	
FIP030R060A	VX050006A	RSFTC3000	RSRGR6M50	RSFTA1000	RSRGR5M40	RSBF4080	VC00TEDI12040	
FIP030R080A	VX050006A	RSFTC3000	RSRGR6M50	RSFTA1000	RSRGR5M40	RSBF4080	VC00TEDI12040	
FIP040R080A	VX050006A	RSFTC3000	RSRGR6M50	RSFTA1000	RSRGR5M40	RSBF4100	VC00TEDI16040	
FIP040R120T	VX050006A	RSFTC3000	RSRGR6M50	RSFTA1000	RSRGR5M40	RSBF4100	VC00TEDI16040	RSFPT1100
FIP050R100A	VX050006A	RSFTC3000	RSRGR6M50	RSFTA1000	RSRGR5M40	RSBF4125	VC00TEDI20040F	RSFPT1125
FIP050R160T	VX050006A	RSFTC3000	RSRGR6M50	RSFTA1000	RSRGR5M40	RSBF4125	VC00TEDI20040F	RSFPT1125
FIP060R100A	VX050006A	RSFTC3000	RSRGR6M50	RSFTA1000	RSRGR5M40		VC004762112050	RSFPT1160
FIP060R180A	VX050006A	RSFTC3000	RSRGR6M50	RSFTA1000	RSRGR5M40		VC004762112050	RSFPT1160
FIP080R120A	VX050006A	RSFTC3000	RSRGR6M50	RSFTA1000	RSRGR5M40		VC004762116050	RSFPT1200
FIP080R240A	VX050006A	RSFTC3000	RSRGR6M50	RSFTA1000	RSRGR5M40		VC004762116050	RSFPT1200
FIP100R160A	VX050006A	RSFTC3000	RSRGR6M50	RSFTA1000	RSRGR5M40		VC004762116050	RSFPT1200
FIP100R300A	VX050006A	RSFTC3000	RSRGR6M50	RSFTA1000	RSRGR5M40		VC004762116050	RSFPT1200




TECHNICAL

PCD

## TEDI MILL - SPARE PARTS

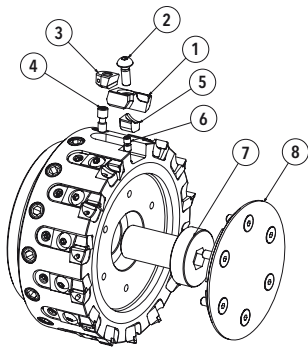
FOR INTEGRAL TYPE CUTTERS



TYPE	ITEM NUMBER	
  	4360818	Std keys kit supplied with the cutter
	4361287	Torque key upon request

Item Number	Taper Dimension	2	3	4	5	6	7
THA50040125P030	HSK-A 50	VX050006A	RSFTC3000	RSRGR6M50	RSFTA1000	RSRGR5M40	
THA50050125P050	HSK-A 50	VX050006A	RSFTC3000	RSRGR6M50	RSFTA1000	RSRGR5M40	RSFPT1050
THA50063125P070	HSK-A 50	VX050006A	RSFTC3000	RSRGR6M50	RSFTA1000	RSRGR5M40	RSFPT1063
THA63040125P030	HSK-A63	VX050006A	RSFTC3000	RSRGR6M50	RSFTA1000	RSRGR5M40	
THA63050125P050	HSK-A63	VX050006A	RSFTC3000	RSRGR6M50	RSFTA1000	RSRGR5M40	RSFPT1050
THA63063125P070	HSK-A63	VX050006A	RSFTC3000	RSRGR6M50	RSFTA1000	RSRGR5M40	RSFPT1063
THA63080125P100	HSK-A63	VX050006A	RSFTC3000	RSRGR6M50	RSFTA1000	RSRGR5M40	RSFPT1080
THA63100125P120	HSK-A63	VX050006A	RSFTC3000	RSRGR6M50	RSFTA1000	RSRGR5M40	RSFPT1100
THA10080125P100	HSK-A100	VX050006A	RSFTC3000	RSRGR6M50	RSFTA1000	RSRGR5M40	RSFPT1080
THA10100125P120	HSK-A100	VX050006A	RSFTC3000	RSRGR6M50	RSFTA1000	RSRGR5M40	RSFPT1100
THA10125125P160	HSK-A100	VX050006A	RSFTC3000	RSRGR6M50	RSFTA1000	RSRGR5M40	RSFPT1125
TCC40016125P030	CAT 40	VX050006A	RSFTC3000	RSRGR6M50	RSFTA1000	RSRGR5M40	
TCC40020125P050	CAT 40	VX050006A	RSFTC3000	RSRGR6M50	RSFTA1000	RSRGR5M40	RSFPT1050
TCC40025125P070	CAT 40	VX050006A	RSFTC3000	RSRGR6M50	RSFTA1000	RSRGR5M40	RSFPT1063
TCC40030125P100	CAT 40	VX050006A	RSFTC3000	RSRGR6M50	RSFTA1000	RSRGR5M40	RSFPT1080
TBC40040125P030	BT40	VX050006A	RSFTC3000	RSRGR6M50	RSFTA1000	RSRGR5M40	
TBC40050125P050	BT40	VX050006A	RSFTC3000	RSRGR6M50	RSFTA1000	RSRGR5M40	RSFPT1050
TBC40063125P070	BT40	VX050006A	RSFTC3000	RSRGR6M50	RSFTA1000	RSRGR5M40	RSFPT1063
TBC40080125P100	BT40	VX050006A	RSFTC3000	RSRGR6M50	RSFTA1000	RSRGR5M40	RSFPT1080

**CBN** **TEDI MILL - SPARE PARTS** FOR SHELL CUTTERS



TYPE	ITEM NUMBER	
T20 T8 Grease	4360818	Std keys kit supplied with the cutter
T20	4361287	Torque key upon request

Item Number	2	3	4	5	6	7	8
FTC050R040S	VX050006A	RSFTC3000	RSRGR6M50	RSFTA3000	RSRGR5M40	VC00TEDI10035	
FTC063R060S	VX050006A	RSFTC3000	RSRGR6M50	RSFTA3000	RSRGR5M40	VC004762I10035	
FTC080R080S	VX050006A	RSFTC3000	RSRGR6M50	RSFTA3000	RSRGR5M40	VC00TEDI12040	
FTC080R100S	VX050006A	RSFTC3000	RSRGR6M50	RSFTA3000	RSRGR5M40	VC00TEDI12040	
FTC100R080S	VX050006A	RSFTC3000	RSRGR6M50	RSFTA3000	RSRGR5M40	VC00TEDI16040	
FTC100R120S	VX050006A	RSFTC3000	RSRGR6M50	RSFTA3000	RSRGR5M40	VC00TEDI16040	
FTC125R100S	VX050006A	RSFTC3000	RSRGR6M50	RSFTA3000	RSRGR5M40	VC00TEDI20040	RSFPT2125
FTC125R140S	VX050006A	RSFTC3000	RSRGR6M50	RSFTA3000	RSRGR5M40	VC00TEDI20040	RSFPT2125
FTC125R160S	VX050006A	RSFTC3000	RSRGR6M50	RSFTA3000	RSRGR5M40	VC00TEDI20040	RSFPT2125
FTC160R140S	VX050006A	RSFTC3000	RSRGR6M50	RSFTA3000	RSRGR5M40	VC004762I12050	RSFPT2160
FTC160R180S	VX050006A	RSFTC3000	RSRGR6M50	RSFTA3000	RSRGR5M40	VC004762I12050	RSFPT2160
FTC200R160S	VX050006A	RSFTC3000	RSRGR6M50	RSFTA3000	RSRGR5M40	VC004762I16050	RSFPT2200
FTC200R240S	VX050006A	RSFTC3000	RSRGR6M50	RSFTA3000	RSRGR5M40	VC004762I16050	RSFPT2200

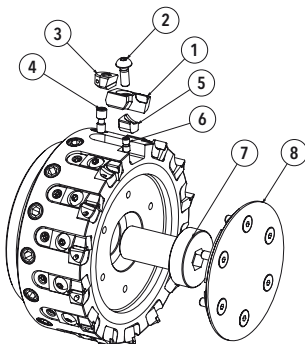
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TECHNICAL

## CBN

## TEDI MILL - SPARE PARTS

FOR SHELL CUTTERS



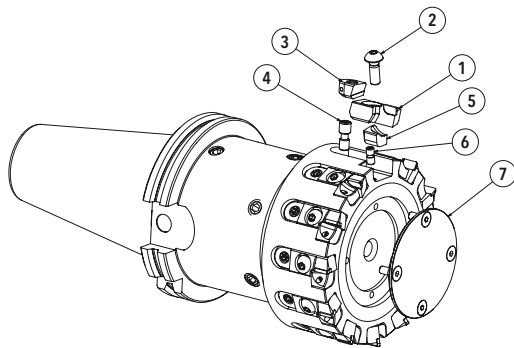
TYPE	ITEM NUMBER	
   T20 T8 Grease	4360818	Std keys kit supplied with the cutter
 T20	4361287	Torque key upon request





Item Number	2	3	4	5	6	7	8
FIC020R040S	VX050006A	RSFTC3000	RSRGR6M50	RSFTA3000	RSRGR5M40	VC00TEDI10035	
FIC020R050S	VX050006A	RSFTC3000	RSRGR6M50	RSFTA3000	RSRGR5M40	VC00TEDI10035	
FIC025R050S	VX050006A	RSFTC3000	RSRGR6M50	RSFTA3000	RSRGR5M40	VC004762I10035	
FIC025R060S	VX050006A	RSFTC3000	RSRGR6M50	RSFTA3000	RSRGR5M40	VC004762I10035	
FIC030R050S	VX050006A	RSFTC3000	RSRGR6M50	RSFTA3000	RSRGR5M40	VC00TEDI12040	
FIC030R060S	VX050006A	RSFTC3000	RSRGR6M50	RSFTA3000	RSRGR5M40	VC00TEDI12040	
FIC030R080S	VX050006A	RSFTC3000	RSRGR6M50	RSFTA3000	RSRGR5M40	VC00TEDI12040	
FIC040R080S	VX050006A	RSFTC3000	RSRGR6M50	RSFTA3000	RSRGR5M40	VC00TEDI16040	
FIC040R120S	VX050006A	RSFTC3000	RSRGR6M50	RSFTA3000	RSRGR5M40	VC00TEDI16040	
FIC050R100S	VX050006A	RSFTC3000	RSRGR6M50	RSFTA3000	RSRGR5M40	VC00TEDI20040	RSFPT2125
FIC050R160S	VX050006A	RSFTC3000	RSRGR6M50	RSFTA3000	RSRGR5M40	VC00TEDI20040	RSFPT2125
FIC060R100S	VX050006A	RSFTC3000	RSRGR6M50	RSFTA3000	RSRGR5M40	VC004762I12050	RSFPT2160
FIC060R180S	VX050006A	RSFTC3000	RSRGR6M50	RSFTA3000	RSRGR5M40	VC004762I12050	RSFPT2160
FIC080R120S	VX050006A	RSFTC3000	RSRGR6M50	RSFTA3000	RSRGR5M40	VC004762I16050	RSFPT2200
FIC080R240S	VX050006A	RSFTC3000	RSRGR6M50	RSFTA3000	RSRGR5M40	VC004762I16050	RSFPT2200
FIC100R160S	VX050006A	RSFTC3000	RSRGR6M50	RSFTA3000	RSRGR5M40	VC004762I16050	RSFPT2200
FIC100R300S	VX050006A	RSFTC3000	RSRGR6M50	RSFTA3000	RSRGR5M40	VC004762I16050	RSFPT2200

**CBN**

**TEDI MILL - SPARE PARTS**

FOR INTEGRAL TYPE CUTTERS



TYPE	ITEM NUMBER	
 T20  T8  Grease	4360818	Std keys kit supplied with the cutter
 T20	4361287	Torque key upon request

Item Number	Taper Dimension	2	3	4	5	6	7
THA63040125C030	HSK-A 63	VX050006A	RSFTC3000	RSRGR6M50	RSFTA3000	RSRGR5M40	
THA63050125C050	HSK-A 63	VX050006A	RSFTC3000	RSRGR6M50	RSFTA3000	RSRGR5M40	RSFPT2050
THA63063125C070	HSK-A 63	VX050006A	RSFTC3000	RSRGR6M50	RSFTA3000	RSRGR5M40	RSFPT2063
THA63080125C100	HSK-A 63	VX050006A	RSFTC3000	RSRGR6M50	RSFTA3000	RSRGR5M40	RSFPT2080
THA10040125C030	HSK-A 100	VX050006A	RSFTC3000	RSRGR6M50	RSFTA3000	RSRGR5M40	
THA10050125C050	HSK-A 100	VX050006A	RSFTC3000	RSRGR6M50	RSFTA3000	RSRGR5M40	RSFPT2050
THA10063125C060	HSK-A 100	VX050006A	RSFTC3000	RSRGR6M50	RSFTA3000	RSRGR5M40	RSFPT2063
THA10080125C100	HSK-A 100	VX050006A	RSFTC3000	RSRGR6M50	RSFTA3000	RSRGR5M40	RSFPT2080
THA10100125C120	HSK-A 100	VX050006A	RSFTC3000	RSRGR6M50	RSFTA3000	RSRGR5M40	RSFPT2100
THA10125125C160	HSK-A 100	VX050006A	RSFTC3000	RSRGR6M50	RSFTA3000	RSRGR5M40	RSFPT2125
TCC40016125C030	CAT 40	VX050006A	RSFTC3000	RSRGR6M50	RSFTA3000	RSRGR5M40	
TCC40020125C050	CAT 40	VX050006A	RSFTC3000	RSRGR6M50	RSFTA3000	RSRGR5M40	RSFPT2050
TCC40025125C070	CAT 40	VX050006A	RSFTC3000	RSRGR6M50	RSFTA3000	RSRGR5M40	RSFPT2063
TCC40030125C100	CAT 40	VX050006A	RSFTC3000	RSRGR6M50	RSFTA3000	RSRGR5M40	RSFPT2080
TCC50016125C030	CAT 50	VX050006A	RSFTC3000	RSRGR6M50	RSFTA3000	RSRGR5M40	
TCC50020125C050	CAT 50	VX050006A	RSFTC3000	RSRGR6M50	RSFTA3000	RSRGR5M40	RSFPT2050
TCC50025125C070	CAT 50	VX050006A	RSFTC3000	RSRGR6M50	RSFTA3000	RSRGR5M40	RSFPT2063
TCC50030125C100	CAT 50	VX050006A	RSFTC3000	RSRGR6M50	RSFTA3000	RSRGR5M40	RSFPT2080
TCC50040125C120	CAT 50	VX050006A	RSFTC3000	RSRGR6M50	RSFTA3000	RSRGR5M40	RSFPT2100
TCC50050125C160	CAT 50	VX050006A	RSFTC3000	RSRGR6M50	RSFTA3000	RSRGR5M40	RSFPT2125
TBC40040125C030	BT 40	VX050006A	RSFTC3000	RSRGR6M50	RSFTA3000	RSRGR5M40	
TBC40050125C050	BT 40	VX050006A	RSFTC3000	RSRGR6M50	RSFTA3000	RSRGR5M40	RSFPT2050
TBC40063125C070	BT 40	VX050006A	RSFTC3000	RSRGR6M50	RSFTA3000	RSRGR5M40	RSFPT2063
TBC40080125C100	BT 40	VX050006A	RSFTC3000	RSRGR6M50	RSFTA3000	RSRGR5M40	RSFPT2080
TBC50040125C030	BT 50	VX050006A	RSFTC3000	RSRGR6M50	RSFTA3000	RSRGR5M40	
TBC50050125C050	BT 50	VX050006A	RSFTC3000	RSRGR6M50	RSFTA3000	RSRGR5M40	RSFPT2050
TBC50063125C060	BT 50	VX050006A	RSFTC3000	RSRGR6M50	RSFTA3000	RSRGR5M40	RSFPT2063
TBC50080125C100	BT 50	VX050006A	RSFTC3000	RSRGR6M50	RSFTA3000	RSRGR5M40	RSFPT2080
TBC50100125C120	BT 50	VX050006A	RSFTC3000	RSRGR6M50	RSFTA3000	RSRGR5M40	RSFPT2100
TBC50125125C160	BT 50	VX050006A	RSFTC3000	RSRGR6M50	RSFTA3000	RSRGR5M40	RSFPT2125

TECHNICAL



# *BRAZED CUTTERS*



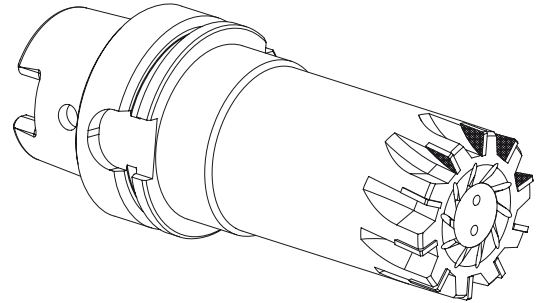
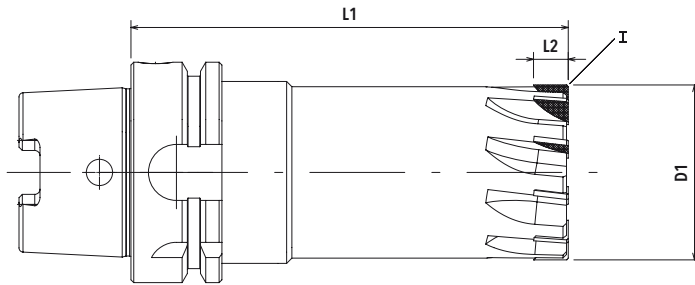


*The variety of ITTEDI brazed cutters, endmills and integral monoblock, all regrindable, allow a perfect use in a wide range of operations and materials and guarantee excellent performances in terms of quality, consistency and working speed in facing, interpolating and profiling operations. The studies which have been made on the different types of milling operations and the acquired know-how have allowed ITTEDI to make a variety of extremely flexible brazed cutters, which can be employed immediately in any application. Their structural and technical features, together with the accurate quality inspections they go through, make the ITTEDI brazed cutters the ideal tool in both roughing and finishing.*



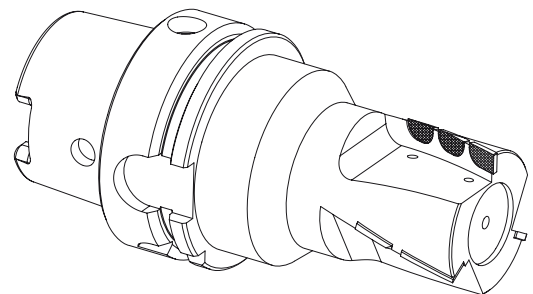
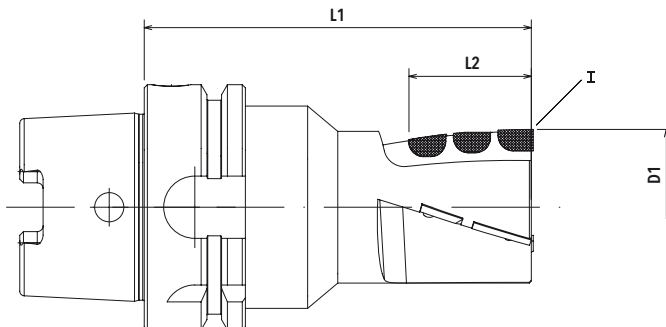
# INTEGRAL BRAZED CUTTERS

HSK A ADAPTOR  
DIN 69893



Item Number	HSK Taper Dimension	D1	Z	L1	L2	I Lead Angle	Rotation
FBHA63032125P060	A 63	32	6	125	15	0.2x45°	R
FBHA63040125P080	A 63	40	8	125	15	0.2x45°	R
FBHA63050125P100	A 63	50	10	125	10	0.2x45°	R
FBHA63063125P120	A 63	63	12	125	10	0.2x45°	R
FBHA63080125P140	A 63	80	14	125	10	0.2x45°	R
FBHA63100100P160	A 63	100	16	100	10	0.2x45°	R
FBHA63125100P200	A 63	125	20	100	10	0.2x45°	R
FBHA10080125P140	A 100	80	14	125	10	0.2x45°	R
FBHA10100125P160	A 100	100	16	125	10	0.2x45°	R
FBHA10125125P200	A 100	125	20	125	10	0.2x45°	R

Brazed cutters are non-stock standard - request a quote.

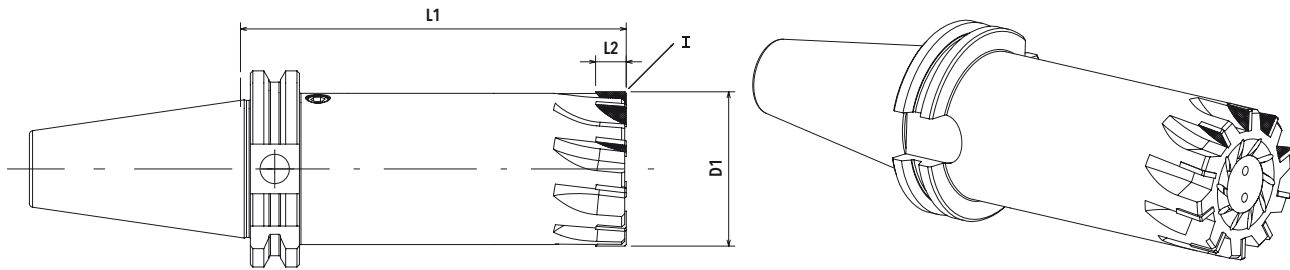


Item Number	HSK Taper Dimension	D1	Z	L1	L2	I Lead Angle	Rotation
EBSED032Z03HA63L30R02	A 63	32	3	100	30	R02	R
EBSED040Z03HA63L40R02	A 63	40	3	100	40	R02	R
EBSED050Z04HA63L40R02	A 63	50	4	100	40	R02	R
EBSED063Z04HA63L40R02	A 63	63	4	100	40	R02	R

Brazed cutters are non-stock standard - request a quote.

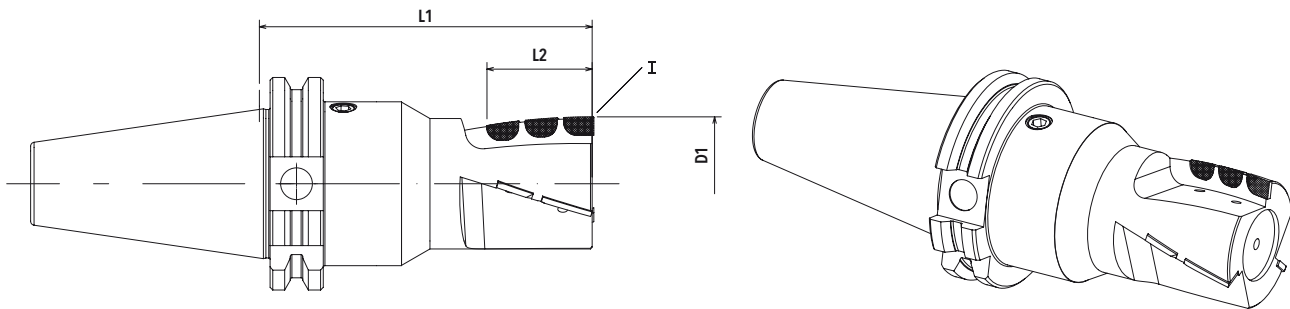
# INTEGRAL BRAZED CUTTERS

CAT A/B ADAPTOR



Item Number	CAT Taper Dimension	D1	Z	L1	L2	I Lead Angle	Rotation
FBCC40032125P060	40	32	6	125	15	0.2x45°	R
FBCC40040125P080	40	40	8	125	15	0.2x45°	R
FBCC40050125P100	40	50	10	125	10	0.2x45°	R

Brazed cutters are non-stock standard - request a quote.



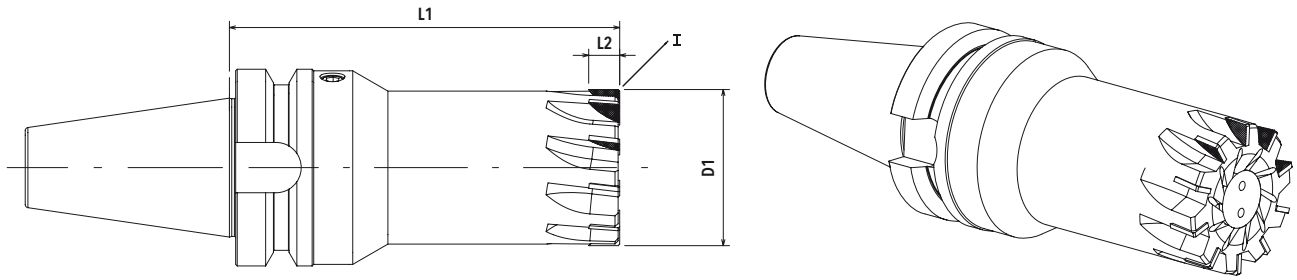
Item Number	CAT Taper Dimension	D1	Z	L1	L2	I Lead Angle	Rotation
EBSED032Z03CC40L30R02	40	32	3	100	30	R02	R
EBSED040Z03CC40L40R02	40	40	3	100	40	R02	R
EBSED050Z04CC40L40R02	40	50	4	100	40	R02	R
EBSED063Z04CC40L40R02	40	63	4	100	40	R02	R

Brazed cutters are non-stock standard - request a quote.

BRAZED CUTTERS

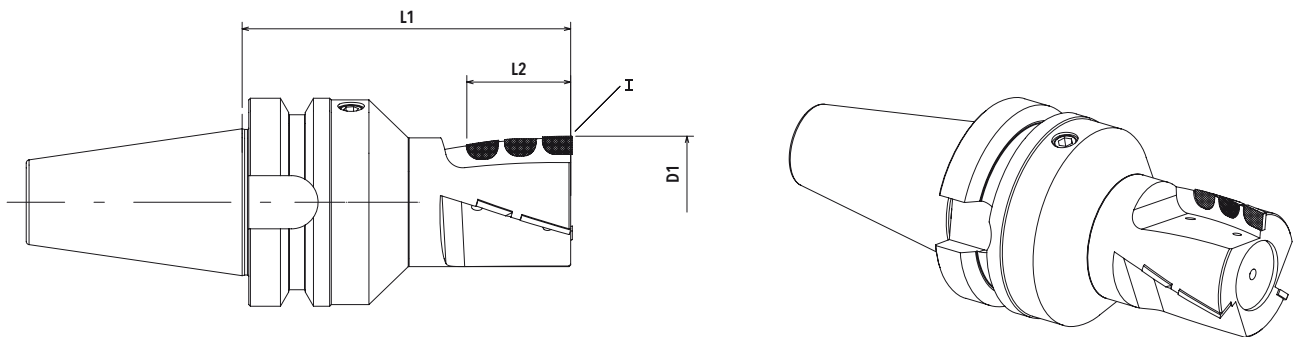
# INTEGRAL BRAZED CUTTERS

BT A/B ADAPTOR  
MAS 403



Item Number	BT Taper Dimension	D1	Z	L1	L2	I Lead Angle	Rotation
FBBC40032125P060	40	32	6	125	15	0.2x45°	R
FBBC40040125P080	40	40	8	125	15	0.2x45°	R
FBBC40050125P100	40	50	10	125	10	0.2x45°	R

Brazed cutters are non-stock standard - request a quote.

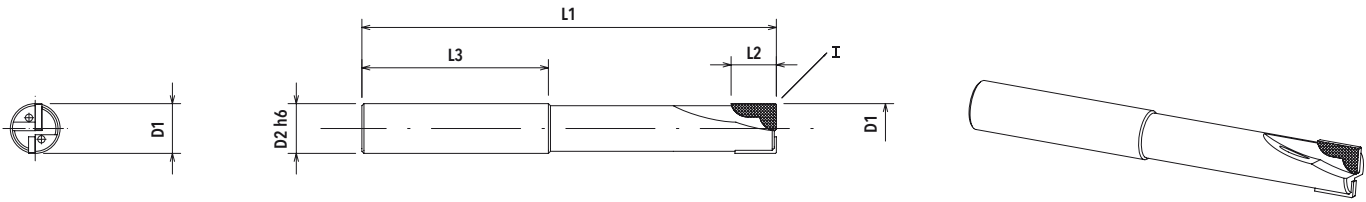


Item Number	BT Taper Dimension	D1	Z	L1	L2	I Lead Angle	Rotation
EBSED032Z03BC40L30R02	40	32	3	100	30	R02	R
EBSED040Z03BC40L40R02	40	40	3	100	40	R02	R
EBSED050Z04BC40L40R02	40	50	4	100	40	R02	R
EBSED063Z04BC40L40R02	40	63	4	100	40	R02	R

Brazed cutters are non-stock standard - request a quote.

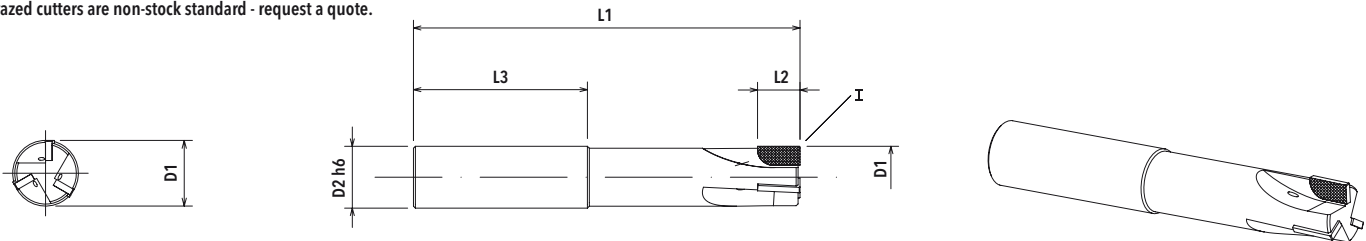
# INTEGRAL BRAZED CUTTERS

CYLINDRICAL SHANK



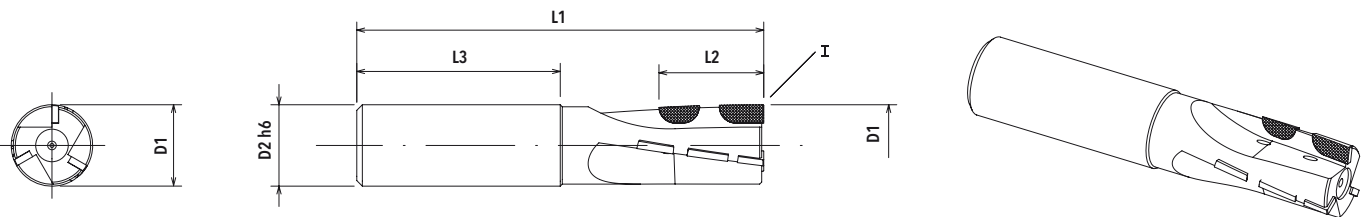
Item Number	D2	D1	Z	L1	L2	L3	I Lead Angle	Rotation
EBSTD04Z01CM05L10C01	5	4	1	67	10	31	0.1x45°	R
EBSTD05Z01CM05L10C01	5	5	1	67	10	31	0.1x45°	R
EBSTD06Z02CM06L10C01	6	6	2	67	10	40	0.1x45°	R
EBSTD06Z02CM06L20C01	6	6	2	67	20	40	0.1x45°	R
EBSTD08Z02CM08L10C01	8	8	2	73	10	40	0.1x45°	R
EBSTD08Z02CM08L20C01	8	8	2	73	20	40	0.1x45°	R
EBSTD10Z02CM10L10C02	10	10	2	82	10	44	0.2x45°	R
EBSTD10Z02CM10L20C02	10	10	2	82	20	44	0.2x45°	R
EBSTD12Z02CM12L10C02	12	12	2	93	10	50	0.2x45°	R
EBSTD12Z02CM12L20C02	12	12	2	93	20	50	0.2x45°	R

Brazed cutters are non-stock standard - request a quote.



Item Number	D2	D1	Z	L1	L2	L3	I Lead Angle	Rotation
EBSPD10Z03CM10L10R02	10	10	3	72	10	44	R0.2	R
EBSPD12Z03CM12L10R02	12	12	3	83	10	50	R0.2	R
EBSPD14Z03CM14L10R02	14	14	3	87	10	50	R0.2	R
EBSPD16Z03CM16L10R02	16	16	3	92	10	53	R0.2	R
EBSPD20Z03CM20L10R02	20	20	3	104	10	55	R0.2	R

Brazed cutters are non-stock standard - request a quote.



Item Number	D2	D1	Z	L1	L2	L3	I Lead Angle	Rotation
EBSED16Z03CM16L30R02	16	16	3	100	30	50	R02	R
EBSED20Z03CM20L30R02	20	20	3	100	30	50	R02	R
EBSED25Z03CM25L30R02	25	25	3	100	30	55	R02	R

Brazed cutters are non-stock standard - request a quote.

A close-up, low-angle shot of a tracked vehicle's track system. The tracks are primarily grey with a prominent orange section in the foreground. The orange section features several circular fasteners and a faint, embossed logo. The grey tracks are equipped with numerous sharp, pointed teeth. The background is dark, making the tracks stand out. A white rectangular box is overlaid in the upper right corner, containing the text 'CUTTING PARAMETERS' in a white, serif, italicized font.

*CUTTING  
PARAMETERS*

## CUTTING PARAMETERS

The below cutting data is purely an indication and are calculated assuming optimal working conditions; they can vary depending on stability of the fixture, the machine and the workpiece.

For more detailed information and for choosing the best grade, you should contact IT.TE.DI.'s offices.

MATERIAL	GRADE	Vc (sfm)	fz (in/z)
Aluminum casting alloys (Si <12%)	<b>PCD</b>	≤ 19,000	0.05 - 0.25
Aluminum casting alloys (Si >12%)	<b>PCD</b>	≤ 5,000	0.05 - 0.25
Aluminum forging alloys	<b>PCD</b>	≤ 19,000	0.05 - 0.25
Copper, bronze, brass, zinc and magnesium alloys	<b>PCD</b>	≤ 6,500	0.05 - 0.25
Non metallic materials	<b>PCD</b>	≤ 10,000	0.05 - 0.25
Grey Cast Iron	<b>CBN</b>	3,200 - 6,500	0.05 - 0.25
Nodular Cast Iron (ferritic)	<b>CBN</b>	1,300 - 2,000	0.05 - 0.25
Malleable Cast Iron (ferritic)	<b>CBN</b>	1,600 - 2,600	0.05 - 0.25
Hardened Steel	<b>CBN</b>	500 - 1,000	0.05 - 0.25

FORMULA AND ABBREVIATION:			CALCULATION OF:
$\varnothing$	Milling cutter - diameter	[in]	$Vc = (n \div \varnothing) \div .262$
$a_p$	Axial depth of cut	[in]	
$a_e$	Width of cut	[in]	$n = Vc \times \varnothing \times .262$
<b>Vc</b>	Cutting speed	[sfm]	
<b>n</b>	RPM	[min-1]	
<b>z</b>	Number of teeth		$Vf = fz \times n \times z$
$f_z$	Feed rate per tooth	[in]	$fz = Vf \div (n \times z)$
<b>vf</b>	Feed rate	[in/min]	

## SERVICES



*Ingersoll/IT.TE.DI. provides a variety of services aiming at the total satisfaction of those who choose its products. The experience and expertise with special tooling is IT.TE.DI.'s distinguishing feature, proved by its ability to make customized solutions based on the customer's needs; this vocation is also the trademark of IT.TE.DI.'s services.*

**SPECIAL DIMENSIONS:** *IT.TE.DI. can make highly personalized solutions, based on specific customer's requirements, thanks to their staff and organization, from engineering to the R & D tests.*

**REGRINDABLE CARTRIDGES:** *IT.TE.DI. provides an efficient grinding service, so that new and refurbished cartridges are perfectly indexable.*

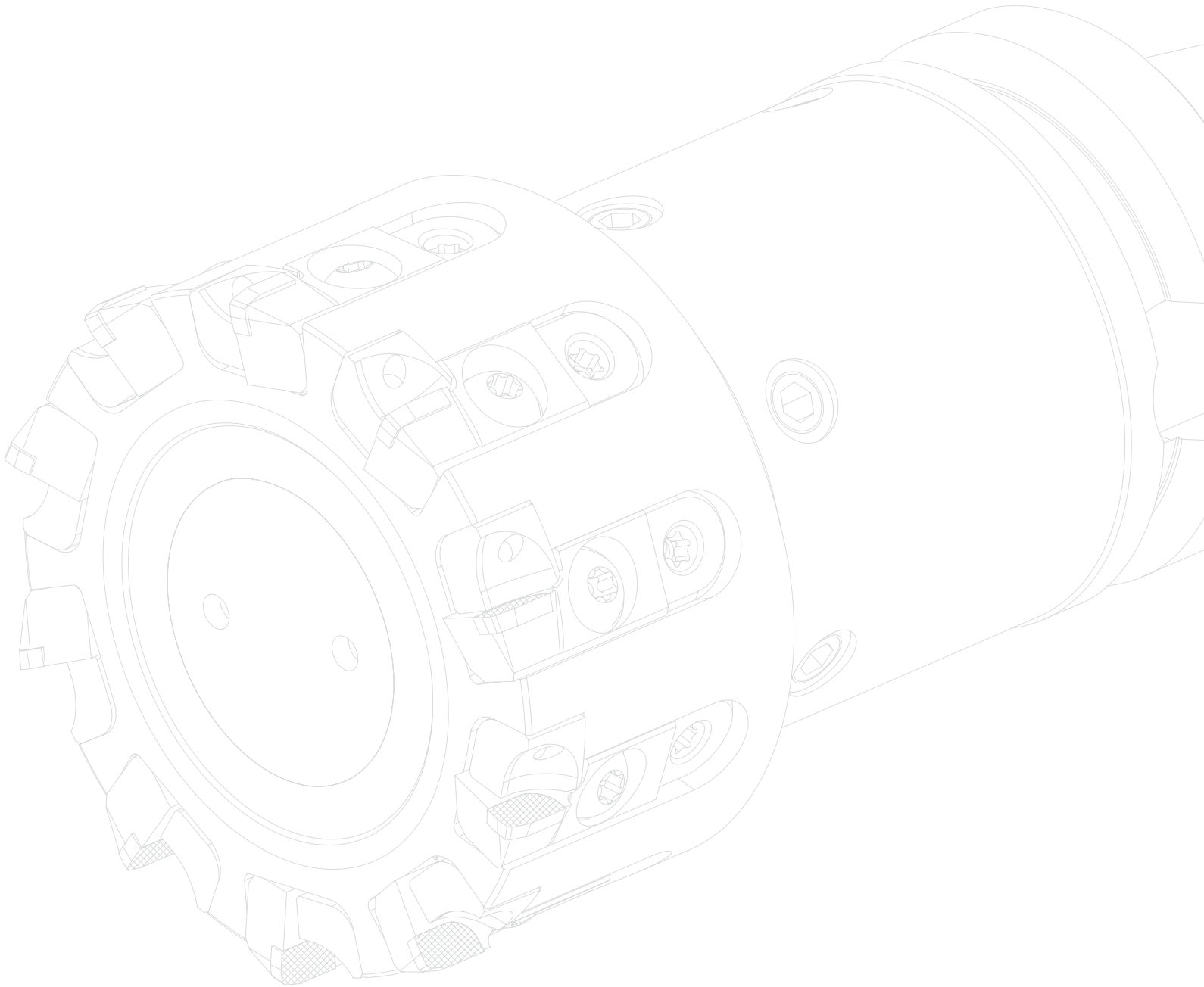
**ASSEMBLING AND PRESETTING:** *these are highly valuable options. They are part of the offer to the customer, aiming at a better personalization and the best performance of the solution which was found during the production process.*

**BALANCING:** *The IT.TE.DI. balancing system has been designed to allow the customers to obtain the best performance from its tools.*





# NOTES

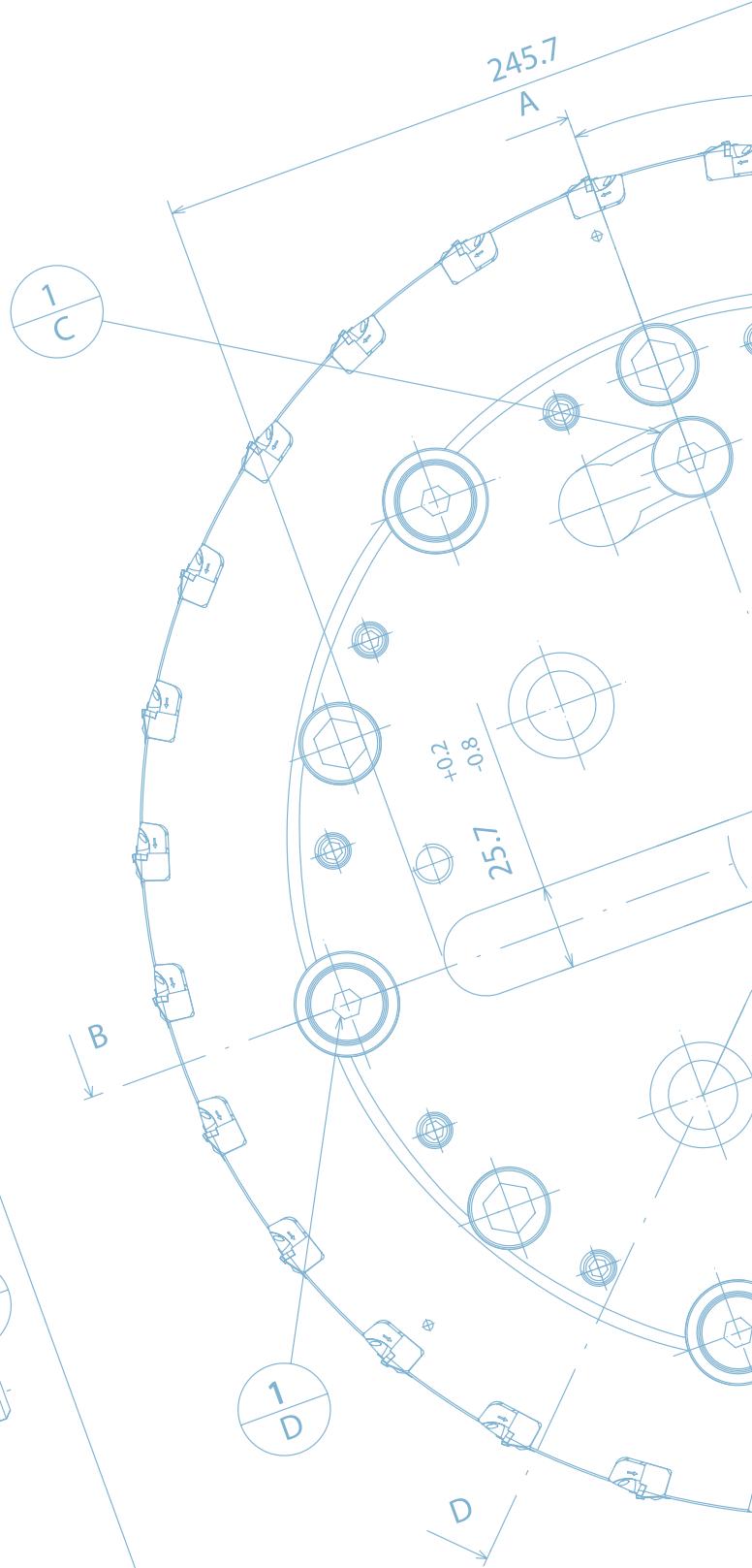
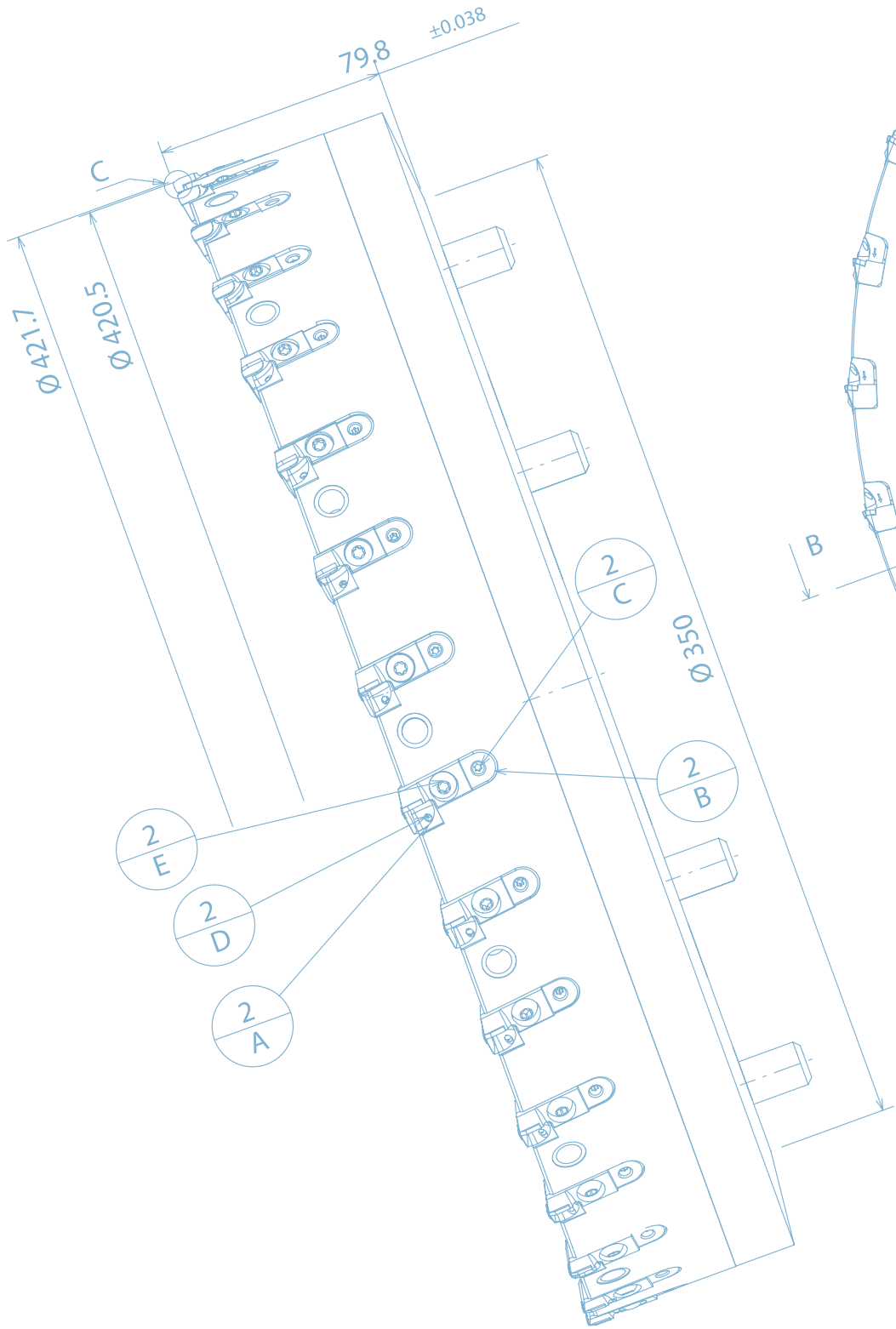




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