



New **TIP** Threading Inserts with **Flat Top** Rake for Short Chipping Materials

ISCAR is introducing two new CUT-GRIP TIP inserts with a flat top rake (without chipbreaker). The inserts are precision ground for a 60° (MT) thread profile. Flat top inserts for 55° (WT) thread profile will be supplied on request.

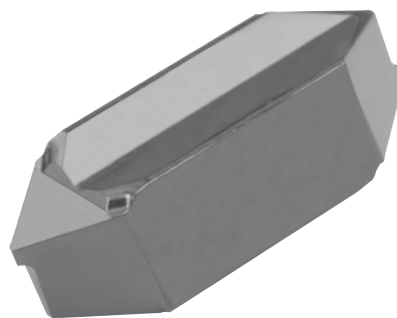
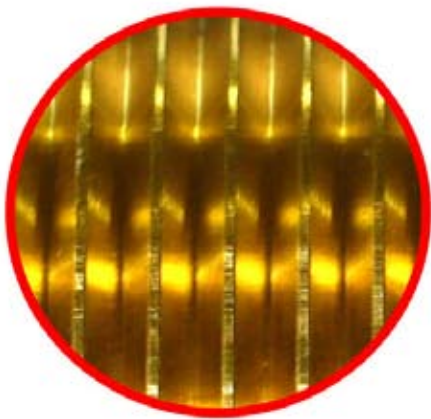
Marketing and Applications:

The inserts were designed for machining threads on short chipping materials such as brass and cast iron.

The use of the flat top rake inserts on these materials results in improved surface quality and less chatter, compared to the inserts with chipbreakers.

As a result, cutting speeds can be increased.

The following picture shows the excellent surface quality obtained by using TIP...A type insert on a brass workpiece.



TIP ...A-MT...





Toolholders:

The new inserts are used on the standard toolholders, as the existing TIP inserts.

Availability:

6403905	TIP 2A-MT-0.05	IC908	- In stock
6403904	TIP 4A-MT-0.15	IC908	- In stock

Sincerely,

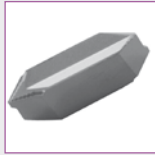
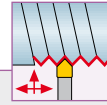
David Zola
Chief Technical Officer
Iscar Headquarters

Sincerely,

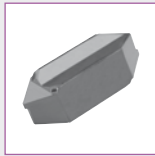
Robi Nudelman
Product Manager,
Turn-Groove, Grip Systems
Iscar Headquarters



TIP-MT

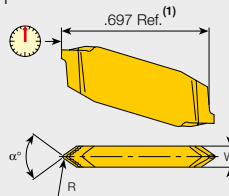


TIP MT



TIP A-MT

Repeatability ±.001



- Metric 60°
- Precision ground
- Double-ended
- TIP MT with chipformer
- TIP A-MT without chipformer for short chipping materials

TIP...MT

Partial Profile 60° - External

Machining Data

W	Designation	R ±.0012	α°	Pitch min	Pitch max	Vc (SFM)		
						Material	IC08	IC908
.094	TIP 2MT-0.05	.0020	60°	56				
NEW .094	TIP 2A-MT-0.05⁽³⁾	.0020	60°	56				
.094	TIP 2MT-0.14	.0055	60°	23				
.157	TIP 4MT-0.15	.0060	60°	20				
NEW .157	TIP 4A-MT-0.15⁽³⁾	.0060	60°	20				
.157	TIP 4MT-0.20	.0080	60°	16				
.217	TIP 5MT-0.25	.0100	60°	13				

⁽¹⁾ TIP inserts are .063" longer than GIP in the same pocket.

⁽²⁾ D - diameter of thread.

⁽³⁾ Without chipformer (flat rake).