

Member IMC Group
Ingersoll
Cutting Tools

FORM MASTER CERA

- Secure, reliable and unique clamping system for ceramic inserts

- AS20 provides excellent heat resistance and optimum toughness

- AS20 grade inserts for high speed machining of cast iron, nickel base plus Inconel, Waspaloy and Titanium super alloys

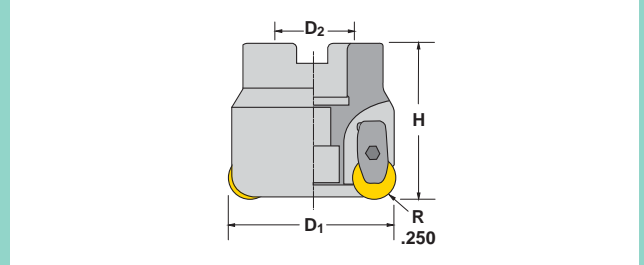
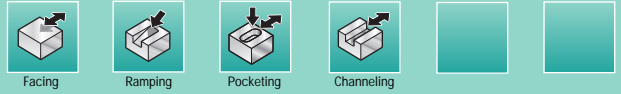


Part of the
Ingersoll
D&M line

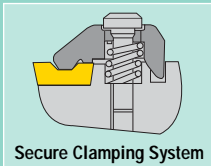
FORMMASTER CERA BUTTON CUTTER

Diameters
2.000"

Ramp Angle
3° Max.



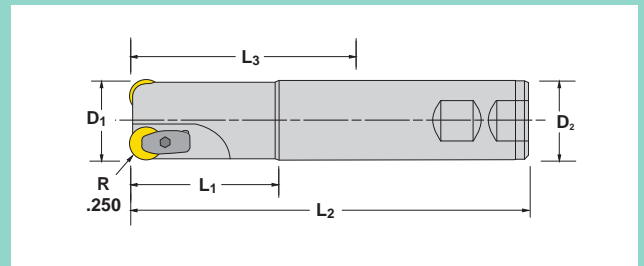
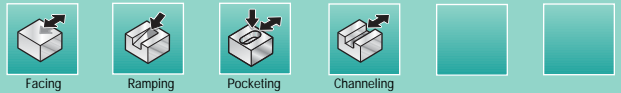
D ₁ Effective Diameter	Cutter Number	D ₂ Bore Size/Style	H Height	Number of Inserts	Keyway Dimensions	Retention Bolt
2.000	TFMRND2.00-12CH	.750	1.570	3	0.32	SD06-46
2.000	TFMRND2.00-12CH-F	.750	1.570	4	0.32	SD06-46



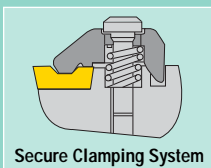
FORMMASTER CERA INTEGRAL SHANK

Diameters
1.250" to 1.500"

Ramp Angle
3° Max.

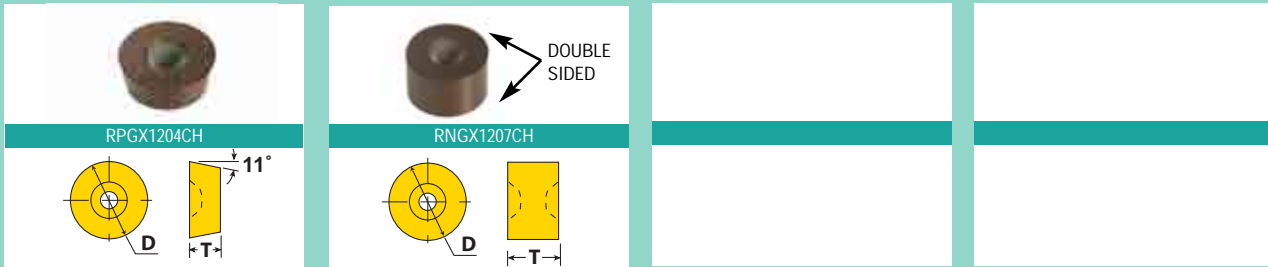


D ₁ Effective Diameter	Cutter Number	L ₁ Extension	L ₂ Overall Length	L ₃ Projection	D ₂ Shank Size/ Style	Number of Inserts
1.250	TERPD1.25-W1.25-12CH	3.150	5.512	3.373	1.250 Weldon	3
1.500	TERPD1.50-W1.25-12CH	1.484	3.940	1.484	1.250 Weldon	3



FORMMASTER CERA INSERTS AND HARDWARE

INSERTS



Insert Number	D Insert Diameter	Corner	T Thickness	Grade
				AS20
RPGX1204CH	.500	.250	.187	■
RNGX1207CH	.500	.250	.312	■

HARDWARE

Cutter	Clamp	Clamp Screw	Clamp Spring	Driver
Part No.	Part No.	Part No.	Part No.	L-W3
TFMRND2.00-12CH	CCL5M	DLS4	DSP4	L-W3 (3 mm hex)
TFMRND2.00-12CH-F				
TERPD1.50-W1.25-12CH	CCL5M	DLS4-18L	DSP4	L-W3 (3 mm hex)
TERPD1.25-W1.25-12CH				

TECHNICAL INFORMATION

OPERATING GUIDELINES

Material	SFM	Feed per Insert	Depth of Cut	Grade	
				AS20	Coolant
Inconel	985 - 2600	.002 - .004	.040 - .120	X	No
Ductile Cast Iron	1970 - 2600	.004 - .012	.040 - .157	X	No



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