

## **T-CLAMP ULTRA+™**

### ***Blades For Face Grooving Operations***



**USES STANDARD TOOL BLOCK**

Ingersoll has extended its T-Clamp Ultra Plus blade program to include products for face grooving operations. The new blades have been designed to produce deeper grooves with a wider range of diameters compared to integral holders, providing many advantages and additional options when conducting face-grooving operations.

These blades will fit into any standard block that accepts 32mm (1.26") blades, and provide two cutting ends. The blades will also accept double-end inserts for maximum economy, or single-end inserts for groove depths that exceed the length of the insert.

- **FEATURES**
- Deeper face grooving compared to integral holders
  - Wider range of diameters in facing operations.
  - Double ended pocket.
  - Uses standard tool blocks & extractors
  - Uses TDC/TDJ/TDFT & TDXU inserts. Single-end inserts are also available when customers need grooves deeper than the length of the insert.

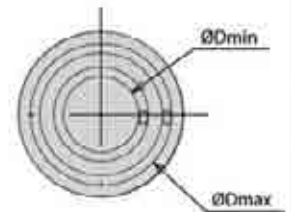
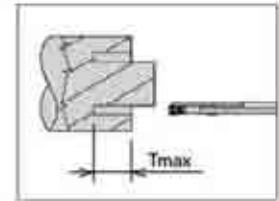
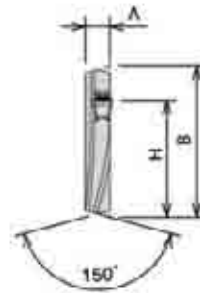
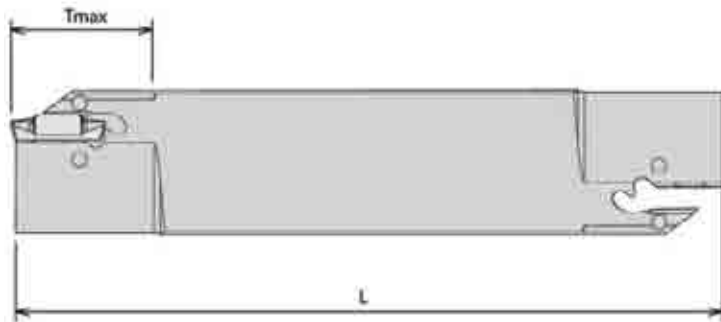
**Minimum diameter of initial face operation for TDC/TDJ/TDT inserts**

Using insert	Insert Width inch(mm)	Dmin inch(mm)	Remark
TDC TDJ TDT	.118 (3)	1.73 (44)	Use TDFT, TDXU type if machining diameter is smaller than Dmin
	.157 (4)	1.65 (42)	
	.197 (5)	1.97 (50)	
	.236 (6)	1.89 (48)	



**USES STANDARD TOOL BLOCK**

**SPECIFICATION FOR BLADES**



RIGHT HAND SHOWN

Designation	Insert seat size	inches (mm)							Insert
		B	L	H	A	Tmax	Dmin	Dmax	
TGBFR/L 32T20-40-60-3	3	1.26 (32)	5.90 (150)	.98 (24.8)	.205 (5.2)	.787(20)	1.57(40)	2.36(60)	TDC, TDJ, TDT, TDFT, TDXU
TGBFR/L 32T20-54-80-3						.787(20)	2.13(54)	3.15(80)	
TGBFR/L 32T25-74-120-3						.984(25)	2.91(74)	4.72(120)	
TGBFR/L 32T25-114-180-3						.984(25)	4.49(74)	7.09(180)	
TGBFR/L 32T25-40-60-4	4	1.26 (32)	5.90 (150)	.98 (24.8)	.205 (5.2)	.984(25)	1.57(40)	2.36(60)	
TGBFR/L 32T25-50-80-4						.984(25)	1.97(50)	3.15(80)	
TGBFR/L 32T30-70-130-4						1.181(30)	2.76(70)	5.12(130)	
TGBFR/L 32T30-120-200-4						1.181(30)	4.72(120)	7.87(200)	
TGBFR/L 32T32-60-95-5	5	1.26 (32)	5.90 (150)	.98 (24.8)	.205 (5.2)	1.260(32)	2.36(60)	3.74(95)	
TGBFR/L 32T35-85-140-5						1.380(35)	3.35(85)	5.51(140)	
TGBFR/L 32T35-130-250-5						1.380(35)	5.12(130)	9.84(250)	
TGBFR/L 32T32-80-180-6	6	1.26 (32)	5.90 (150)	.98 (24.8)	.205 (5.2)	1.260(32)	3.15(80)	7.09(180)	
TGBFR/L 32T38-168-300-6						1.496(38)	6.61(168)	11.81(300)	

\*Uses extractor: EDG-33B (sold separately)

**AVAILABILITY**

All blades are in overseas stock.



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