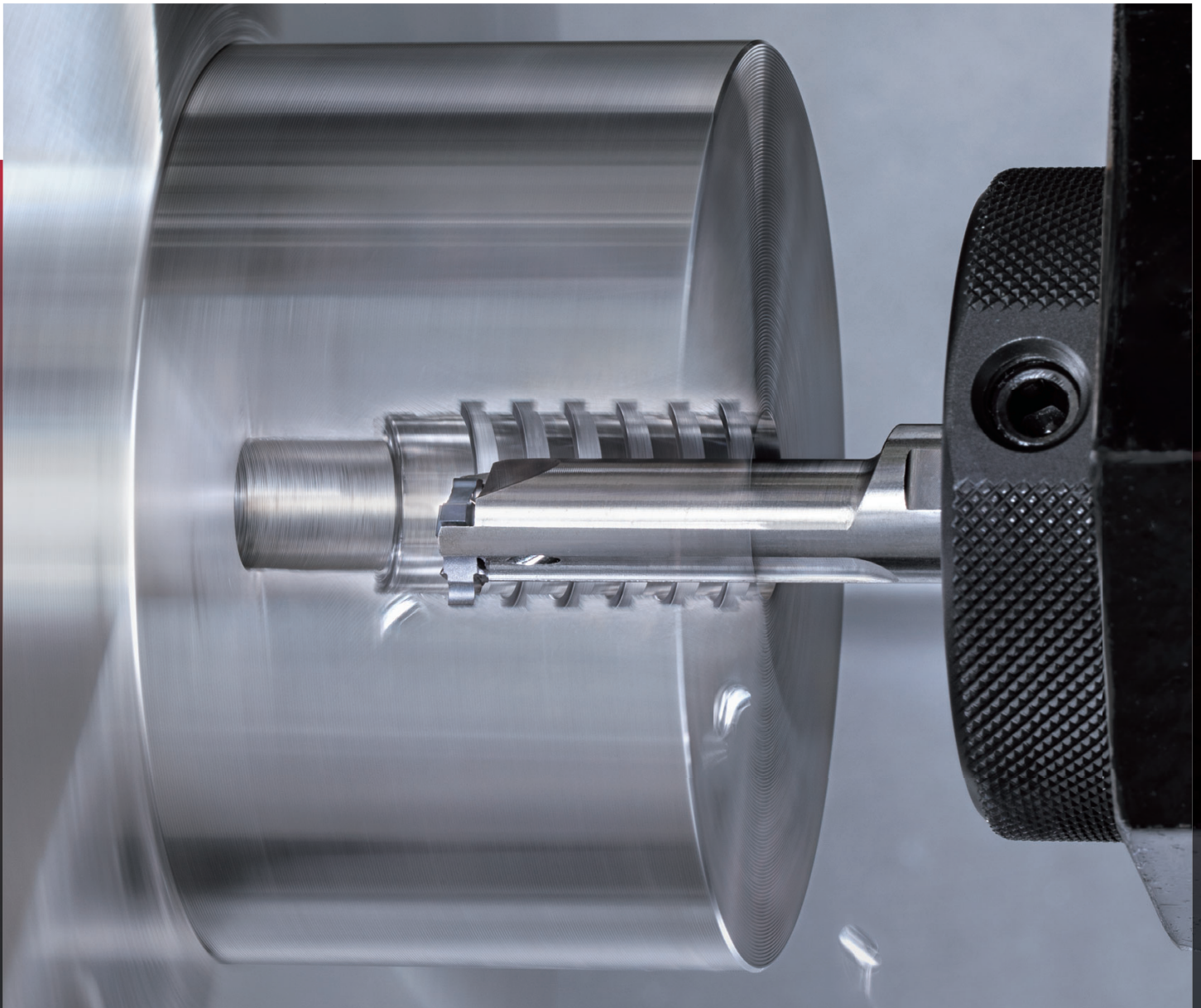


Internal grooving tool

ADDINTERNAL
CUT

Tungaloy Report No. 544S2-US

Industry-standard grooving inserts for **internal grooves of retaining rings**





■ New industry-standard grooving inserts for internal grooves of retaining rings



- Extended groove width options
- From as thin as as 0.02" groove width
- In case of an edge rupture, the holder is designed to protect the remaining unused edges of the insert

For standard sizes of retaining rings

According to JIS B2804

Unit: mm

Groove width	Tolerance	Insert
1.15 (0.045")	+0.14 0 (+0.006" / 0)	TCIG10-122-008
1.35 (0.053")		TCIG10-142-008
1.65 (0.065")		TCIG10-172-008
1.9 (0.075")		TCIG12-197-008
2.2 (0.087")		TCIG12-224-008
2.7 (0.106")		TCIG12-277-015



Tapered section retaining ring

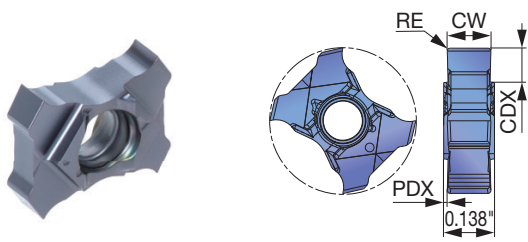
According to ANSI B27.7/27.8 (US), BS 3673 (UK),
DIN 471/472 (DE), NF E 22 163 (FR), UNI 7435/7438 (IT)

Unit: inch

Groove width	Tolerance	Insert
0.043"	+0.006" 0	TCIG10-122-008
0.051"		TCIG10-142-008
0.063"		TCIG10-172-008
0.073"		TCIG12-197-008
0.085"		TCIG12-224-008
0.104"		TCIG12-277-015

INSERT

TCIG



P	Steel	★							
M	Stainless	★							
K	Cast iron	★							
N	Non-ferrous								
S	Superalloys	★							
H	Hard materials								★ : First choice

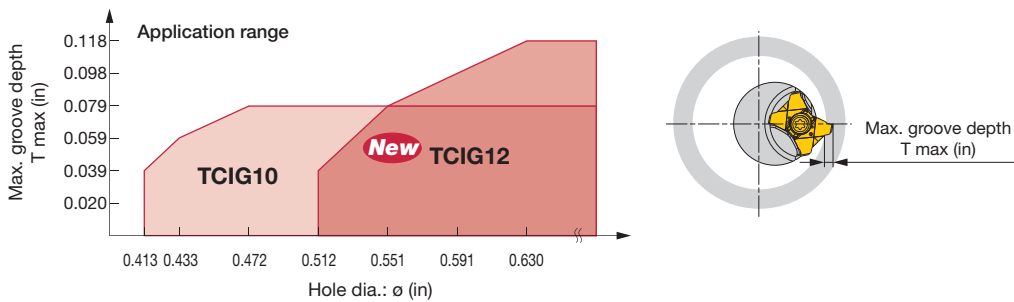
Designation	CW±0.001	RE	Coated							CDX	PDX
			AH725								
New TCIG10-050-005	0.020	0.0020	●							0.039	0.059
New TCIG10-122-008	0.048	0.0031	●							0.079	0.045
New TCIG10-142-008	0.056	0.0031	●							0.079	0.041
TCIG10-150-010	0.059	0.0039	●							0.079	0.039
New TCIG10-172-008	0.068	0.0031	●							0.079	0.035
TCIG10-200-010	0.079	0.0039	●							0.079	0.030
TCIG10-250-020	0.098	0.0079	●							0.079	0.020
TCIG10-300-020	0.118	0.0079	●							0.079	0.010
New TCIG12-100-010	0.039	0.0039	●							0.098	0.049
TCIG12-150-010	0.059	0.0039	●							0.118	0.039
New TCIG12-197-008	0.078	0.0031	●							0.118	0.030
TCIG12-200-020	0.079	0.0079	●							0.118	0.030
New TCIG12-224-008	0.088	0.0031	●							0.118	0.025
TCIG12-250-020	0.098	0.0079	●							0.118	0.020
New TCIG12-277-015	0.109	0.0059	●							0.118	0.015
TCIG12-300-020	0.118	0.0079	●							0.118	0.010

● : New product
● : Line up

Shallower groove depths (T max) for smaller bores

Maximum groove depths (T max) for TCIG10 inserts are smaller than the CDX value shown above when the grooving bore diameter is < 0.472" ; and for TCIG12, when the bore diameter is < 0.63".

See the chart below for T max values in relation to the given bore diameter.



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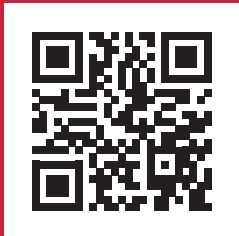
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