



HiPos+™ 09,13,17

MILLING PRODUCTS



Cutter Series:

12J1P, 2J1P: 90° Mill (.35" DOC)
12J1R, 2J1R: 90° Mill (.47" DOC)
12J1G, 2J1G: 90° Mill (.63" DOC)
22J3P, 22J3R, 22J3G: 90° Long Edge
12_1R: Chamfer End Mill
22_3R: Chamfer Long Edge Mill
12L, 2L: 70° Mill

Diameters:

.500" - 8.00" (12mm - 160mm)

Cutting Edge Angles:

15°, 30°, 45°, 60°, 70°, 75° & 90°

Insert Series:

BOMT09, BOCT09, BODT09, ZOMT09
BOMT13, BOCT13, ZOMT13
AOMT17, BOMT17, BOCT17, ZOMT17

Insert Corners:

.015", .031", .039", .047", .062",
.078", .093", .120", .125", .156",
.187" & .250" R

Materials:

Aluminum, Iron, Steel,
Stainless Steel, High-Temps,
Titanium & Hard Steel

Our Highest Positive Milling Geometry!

Designed with diversity and efficiency in mind, Ingersoll's HiPos+ Milling line features three popular insert sizes (9mm, 13mm & 17mm) that are common to several cutter body styles. Having the largest cutter diameter/length/adaption selection and the largest insert corner offering of any Ingersoll milling line, HiPos+ is an ideal multi-purpose mill that excels on low horsepower machines and long chipping materials.

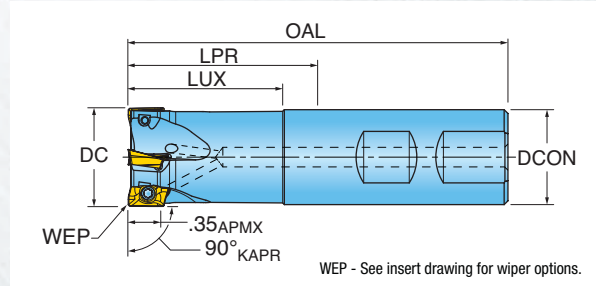
Features & Benefits:

- BOMT inserts offer 2X positive rake and 2X face clearance when compared to APKT; resulting in higher efficiency, less heat and more aggressive ramping capability
- Diverse range of insert grade/geometry additions to accommodate a wide variety of materials
- Inserts with integrated wiper flats typically produce surface finishes between 32-63 Ra
- Carbide inserts equipped with 2 indexes; PCD with 1 index; Add series 12L/2L cutter to get 4 indexes
- Cutters ported with coolant to accommodate non-ferrous, stainless steel, titanium and hi-temp alloy materials



HIPOST⁺ SERIES: 12J1P (WELDON SHANK)

90° END MILL (9MM INSERT)



Part Number	DC Cutting Diameter	LUX Usable Length Max.	LPR Protruding Length	OAL Overall Length	ZEFF Effective Teeth	DCON Shank Diameter	CSP Coolant	RMPX Ramp Angle Max.
12J1P-0501379R01	0.500	1.18	1.34	3.25	1	0.625	Yes	1.5
12J1P-0601379R01	0.625	1.18	1.34	3.25	2	0.625	Yes	10.0
12J1P-0701784R01	0.750	1.18	1.75	3.75	2	0.750	Yes	7.0
12J1P-0701784R02	0.750	1.18	1.75	3.75	3	0.750	Yes	7.0
12J1P-0702784R01	0.750	2.75	2.75	4.75	2	0.750	Yes	7.0
12J1P-0704084R01	0.750	2.75	4.00	6.00	2	0.750	Yes	Not Recomm.
12J1P-0801784R01	0.875	1.18	1.75	3.75	3	0.750	Yes	5.5
12J1P-1001784R01	1.000	1.75	1.75	3.75	3	0.750	Yes	4.4
12J1P-1001784R02	1.000	1.75	1.75	3.75	4	0.750	Yes	4.4
12J1P-1201584R01	1.250	1.50	1.50	3.75	5	0.750	Yes	2.8
12J1P-1501780R01	1.500	1.75	1.75	4.00	6	1.000	Yes	2.4

NOTE: Cutter body must be relieved when using insert corner radii larger than R.031: Body R" = Insert R" - .02"

METRIC

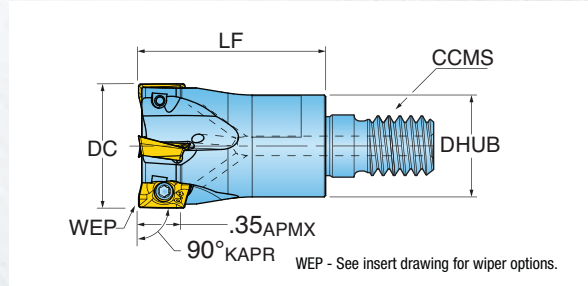
Part Number	DC Cutting Diameter	LUX Usable Length Max.	LPR Protruding Length	OAL Overall Length	ZEFF Effective Teeth	DCON Shank Diameter	CSP Coolant	RMPX Ramp Angle Max.
12J1P012020W3R00	12.00 mm	20.0 mm	32.0 mm	80.0 mm	1	16.00 mm	Yes	1.5
12J1P016026W3R00	16.00 mm	26.0 mm	37.0 mm	85.0 mm	2	16.00 mm	Yes	10.0
12J1P020030W4R00	20.00 mm	30.0 mm	40.0 mm	90.0 mm	3	20.00 mm	Yes	7.0
12J1P020075W4R00	20.00 mm	75.0 mm	75.0 mm	125.0 mm	2	20.00 mm	Yes	7.0
12J1P025040W5R00	25.00 mm	40.0 mm	44.0 mm	100.0 mm	4	25.00 mm	Yes	4.4
12J1P025085W5R00	25.00 mm	85.0 mm	89.0 mm	145.0 mm	3	25.00 mm	Yes	4.4
12J1P025085W5R01	25.00 mm	85.0 mm	89.0 mm	145.0 mm	4	25.00 mm	Yes	4.4

NOTE: Cutter body must be relieved when using insert corner radii larger than R0.8mm: Body R = Insert R - 0.5mm



HIPOST⁺ SERIES: 12J1P (TOPON M-ADAPTION)

90° MODULAR END MILL (9MM INSERT)



Part Number	DC Cutting Diameter	LF Functional Length	ZEFF Effective Teeth	CCMS Connection Code	DHUB Hub Diameter	CSP Coolant	RMPX Ramp Angle Max.
12J1P-06015X5R01	0.625	1.50	2	TopOn M08	0.50	Yes	10.0
12J1P-07015X6R01	0.750	1.50	3	TopOn M10	0.69	Yes	7.0
12J1P-10015X7R01	1.000	1.50	4	TopOn M12	0.81	Yes	4.4
12J1P-12017X8R01	1.250	1.75	5	TopOn M16	1.13	Yes	2.8

NOTE: Cutter body must be relieved when using insert corner radii larger than R.031: Body R" = Insert R" - .02"

METRIC

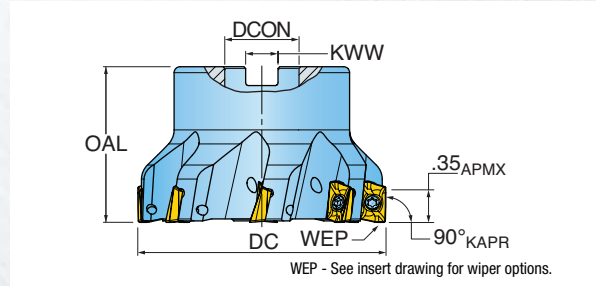
Part Number	DC Cutting Diameter	LF Functional Length	ZEFF Effective Teeth	CCMS Connection Code	DHUB Hub Diameter	CSP Coolant	RMPX Ramp Angle Max.
12J1P012030X4R00	12.00 mm	30.0 mm	1	TopOn M06	11.8 mm	Yes	1.5
12J1P015030X5R00	15.00 mm	30.0 mm	2	TopOn M08	13.0 mm	Yes	12.0
12J1P016035X5R00	16.00 mm	35.0 mm	2	TopOn M08	13.0 mm	Yes	10.0
12J1P020035X6R00	20.00 mm	35.0 mm	3	TopOn M10	18.0 mm	Yes	7.0
12J1P025035X7R00	25.00 mm	35.0 mm	4	TopOn M12	21.0 mm	Yes	4.4
12J1P032043X8R00	32.00 mm	43.0 mm	5	TopOn M16	29.0 mm	Yes	2.8
12J1P035043X8R00	35.00 mm	43.0 mm	5	TopOn M16	29.0 mm	Yes	2.5

NOTE: Cutter body must be relieved when using insert corner radii larger than R 0.8: Body R = Insert R - 0.5mm



HIPOST⁺ SERIES: 2J1P

90° FACE MILL (9MM INSERT)



Part Number	DC Cutting Diameter	OAL Overall Length	ZEFF Effective Teeth	DCON Bore Diameter	KWW Keyway	CSP Coolant	RMPX Ramp Angle Max.
2J1P-15R01	1.500	1.57	6	0.500	0.250	Yes	2.4
2J1P-20R01	2.000	1.57	7	0.750	0.312	Yes	1.3
2J1P-25R01	2.500	1.57	8	0.750	0.312	Yes	1.0
2J1P-30R01	3.000	1.75	9	1.000	0.375	Yes	0.7

NOTE: Cutter body must be relieved when using insert corner radii larger than R.031: Body R" = Insert R" - .02"

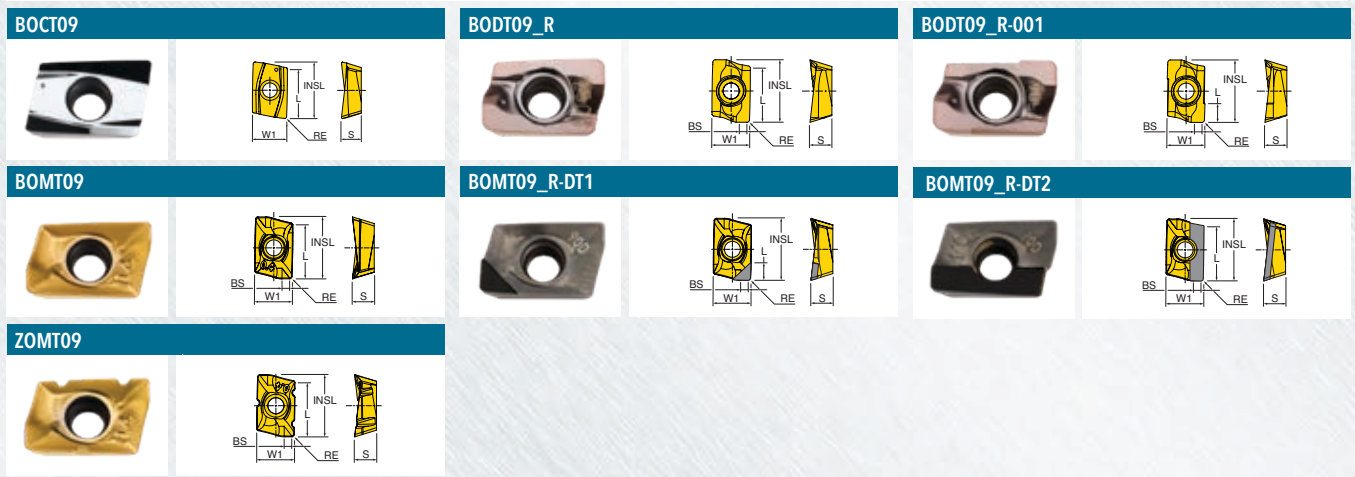
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Part Number	DC Cutting Diameter	OAL Overall Length	ZEFF Effective Teeth	DCON Bore Diameter	KWW Keyway	CSP Coolant	RMPX Ramp Angle Max.
2J1P032R00	32.00 mm	32.00 mm	5	16.00 mm	8.40 mm	Yes	2.8
2J1P032R01	32.00 mm	32.00 mm	4	16.00 mm	8.40 mm	Yes	2.8
2J1P035R00	35.00 mm	32.00 mm	6	16.00 mm	8.40 mm	Yes	2.5
2J1P040R00	40.00 mm	40.00 mm	6	16.00 mm	8.40 mm	Yes	2.4
2J1P040R01	40.00 mm	40.00 mm	4	16.00 mm	8.40 mm	Yes	2.4
2J1P050R00	50.00 mm	40.00 mm	7	22.00 mm	10.40 mm	Yes	1.3
2J1P050R01	50.00 mm	40.00 mm	4	22.00 mm	10.40 mm	Yes	1.3
2J1P063R00	63.00 mm	40.00 mm	8	22.00 mm	10.40 mm	Yes	1.0
2J1P063R01	63.00 mm	40.00 mm	6	22.00 mm	10.40 mm	Yes	1.0
2J1P080R00	80.00 mm	50.00 mm	10	27.00 mm	12.40 mm	Yes	0.6
2J1P100R00	100.00 mm	50.00 mm	12	32.00 mm	14.40 mm	Yes	0.5

NOTE: Cutter body must be relieved when using insert corner radii larger than R0.8mm: Body R = Insert R - 0.5mm











HIPOST[™] 12J1P, 2J1P INSERTS



Part Number	Application	RE Corner Radius	BS Wiper Length	L Cutting Edge Length	INSL Length	W1 Width	S Thickness	Grade	IN10K	IN2010	IN2035	IN2504	IN2505	IN2530	IN4030	IN90D
BOCT09T304FR-P	Grd/Pol for Al	0.015 R	-	0.350	0.417	0.260	0.146	•								
BOCT09T308FR-P	Grd/Pol for Al	0.031 R	-	0.350	0.414	0.260	0.144	•								
BODT09T308R	Finishing	0.031 R	0.057	0.330	0.421	0.258	0.148					•				
BODT09T308R-001	Finishing	0.031 R	0.057	0.120	0.421	0.254	0.148					•				
BOMT09T304R	Multi-Purpose	0.015 R	0.050	0.350	0.421	0.258	0.148		•			•	•	•	•	
BOMT09T308R	Multi-Purpose	0.031 R	0.034	0.350	0.421	0.259	0.148				•	•	•	•	•	
BOMT09T316R	Multi-Purpose	0.062 R	-	0.350	0.421	0.259	0.148				•		•	•		
BOMT09T320R	Multi-Purpose	0.078 R	-	0.350	0.421	0.259	0.148						•			
BOMT09T331R	Multi-Purpose	0.120 R	-	0.350	0.421	0.259	0.148				•		•	•		
BOMT09T304R-DT1	PCD Tipped	0.015 R	0.060	0.120	0.421	0.260	0.147									•
BOMT09T304R-DT2	PCD Tipped	0.015 R	0.060	0.370	0.421	0.260	0.147									•
ZOMT09T304R	Positive-Splitters	0.015 R	0.050	0.350	0.421	0.259	0.148				•		•	•	•	



HIPOST[™] 12J1P, 2J1P HARDWARE

								
	Insert Screw	Screw Driver	Retention Bolt	Retention Bolt w/Coolant	Wrench	**OPTIONAL**	**OPTIONAL**	**OPTIONAL**
12J1P-0501379R01	SM25-054-00	DS-T08W	-	-	-	DS-A00-.25-S	DT-11-.25	DS-T08B
12J1P-0601379R01	SM25-054-00	DS-T08W	-	-	-	DS-A00-.25-S	DT-11-.25	DS-T08B
12J1P-0701784R01	SM25-064-00	DS-T08W	-	-	-	DS-A00-.25-S	DT-11-.25	DS-T08B
12J1P-0701784R02	SM25-064-00	DS-T08W	-	-	-	DS-A00-.25-S	DT-11-.25	DS-T08B
12J1P-0702784R01	SM25-064-00	DS-T08W	-	-	-	DS-A00-.25-S	DT-11-.25	DS-T08B
12J1P-0704084R01	SM25-064-00	DS-T08W	-	-	-	DS-A00-.25-S	DT-11-.25	DS-T08B
12J1P-0801784R01	SM25-064-00	DS-T08W	-	-	-	DS-A00-.25-S	DT-11-.25	DS-T08B
12J1P-1001784R01	SM25-064-00	DS-T08W	-	-	-	DS-A00-.25-S	DT-11-.25	DS-T08B
12J1P-1001784R02	SM25-064-00	DS-T08W	-	-	-	DS-A00-.25-S	DT-11-.25	DS-T08B
12J1P-1201584R01	SM25-064-00	DS-T08W	-	-	-	DS-A00-.25-S	DT-11-.25	DS-T08B
12J1P-1501780R01	SM25-064-00	DS-T08W	-	-	-	DS-A00-.25-S	DT-11-.25	DS-T08B
12J1P-06015X5R01	SM25-054-00	DS-T08W	-	-	610MM	DS-A00-.25-S	DT-11-.25	DS-T08B
12J1P-07015X6R01	SM25-064-00	DS-T08W	-	-	615MM	DS-A00-.25-S	DT-11-.25	DS-T08B
12J1P-10015X7R01	SM25-064-00	DS-T08W	-	-	617MM	DS-A00-.25-S	DT-11-.25	DS-T08B
12J1P-12017X8R01	SM25-064-00	DS-T08W	-	-	622MM	DS-A00-.25-S	DT-11-.25	DS-T08B
2J1P-15R01	SM25-064-00	DS-T08W	SD-04-85	-	-	DS-A00-.25-S	DT-11-.25	DS-T08B
2J1P-20R01	SM25-064-00	DS-T08W	SD-06-46	SD-06-89	-	DS-A00-.25-S	DT-11-.25	DS-T08B
2J1P-25R01	SM25-064-00	DS-T08W	SD-06-46	SD-06-89	-	DS-A00-.25-S	DT-11-.25	DS-T08B
2J1P-30R01	SM25-064-00	DS-T08W	SD-08-48	SD-08-C9	-	DS-A00-.25-S	DT-11-.25	DS-T08B
12J1P012020W3R00	SM25-054-00	DS-T08W	-	-	-	DS-A00-.25-S	DT-11-.25	DS-T08B
12J1P016026W3R00	SM25-054-00	DS-T08W	-	-	-	DS-A00-.25-S	DT-11-.25	DS-T08B
12J1P020030W4R00	SM25-064-00	DS-T08W	-	-	-	DS-A00-.25-S	DT-11-.25	DS-T08B
12J1P020075W4R00	SM25-064-00	DS-T08W	-	-	-	DS-A00-.25-S	DT-11-.25	DS-T08B
12J1P025040W5R00	SM25-064-00	DS-T08W	-	-	-	DS-A00-.25-S	DT-11-.25	DS-T08B
12J1P025085W5R00	SM25-064-00	DS-T08W	-	-	-	DS-A00-.25-S	DT-11-.25	DS-T08B
12J1P025085W5R01	SM25-064-00	DS-T08W	-	-	-	DS-A00-.25-S	DT-11-.25	DS-T08B
12J1P012030X4R00	SM25-054-00	DS-T08W	-	-	-	DS-A00-.25-S	DT-11-.25	DS-T08B
12J1P015030X5R00	SM25-054-00	DS-T08W	-	-	610mm	DS-A00-.25-S	DT-11-.25	DS-T08B
12J1P016035X5R00	SM25-054-00	DS-T08W	-	-	610mm	DS-A00-.25-S	DT-11-.25	DS-T08B
12J1P020035X6R00	SM25-064-00	DS-T08W	-	-	615mm	DS-A00-.25-S	DT-11-.25	DS-T08B
12J1P025035X7R00	SM25-064-00	DS-T08W	-	-	617mm	DS-A00-.25-S	DT-11-.25	DS-T08B
12J1P032043X8R00	SM25-064-00	DS-T08W	-	-	622mm	DS-A00-.25-S	DT-11-.25	DS-T08B
12J1P035043X8R00	SM25-064-00	DS-T08W	-	-	622mm	DS-A00-.25-S	DT-11-.25	DS-T08B
2J1P032R00	SM25-064-00	DS-T08W	ISO4762M8X20-12.9	-	-	DS-A00-.25-S	DT-11-.25	DS-T08B
2J1P032R01	SM25-064-00	DS-T08W	ISO4762M8X20-12.9	-	-	DS-A00-.25-S	DT-11-.25	DS-T08B
2J1P035R00	SM25-064-00	DS-T08W	ISO4762M8X20-12.9	-	-	DS-A00-.25-S	DT-11-.25	DS-T08B
2J1P040R00	SM25-064-00	DS-T08W	ISO4762M8X30-12.9	-	-	DS-A00-.25-S	DT-11-.25	DS-T08B
2J1P040R01	SM25-064-00	DS-T08W	ISO4762M8X30-12.9	-	-	DS-A00-.25-S	DT-11-.25	DS-T08B
2J1P050R00	SM25-064-00	DS-T08W	ISO4762M10X25-12.9	-	-	DS-A00-.25-S	DT-11-.25	DS-T08B
2J1P050R01	SM25-064-00	DS-T08W	ISO4762M10X25-12.9	-	-	DS-A00-.25-S	DT-11-.25	DS-T08B
2J1P063R00	SM25-064-00	DS-T08W	ISO4762M10X25-12.9	-	-	DS-A00-.25-S	DT-11-.25	DS-T08B
2J1P063R01	SM25-064-00	DS-T08W	ISO4762M10X25-12.9	-	-	DS-A00-.25-S	DT-11-.25	DS-T08B
2J1P080R00	SM25-064-00	DS-T08W	ISO4762M12X35-12.9	-	-	DS-A00-.25-S	DT-11-.25	DS-T08B
2J1P100R00	SM25-064-00	DS-T08W	ISO4762M16X30-12.9	-	-	DS-A00-.25-S	DT-11-.25	DS-T08B