

ISO PLUS

Quad 85° & 90° - The Power of 8!

Cutter Series:

90° - DJ5T/DJ6T

85° - DL5T/DL6T

Diameters:

2.00" - 8.00"

Depth of Cut:

.24" DOC & 90° shoulder

.50" max DOC with slight taper

Insert Series:

SNGU13 (Radius Only)

SNGU13_TN (With Wiper)

Corner:

.015, .031, .047, .062R

.031 x 45 chamfer

Materials:

Iron

Steel

Stainless Steel

Hi-temp Alloys



SIN
ROUGHING



CARBIDE
ROUGHING



CARBIDE
ROUGH & FINISH



CARBIDE
ROUGH & FINISH



Two-Sided Technology is incorporated to the ISO Quad inserts for an Ingersoll Exclusive product named ISO Plus. Users benefit by doubling their cutting edges from 4 to 8 while also taking advantage of clean shearing pressed rake face performance for ideal machining efficiency.

Features & Benefits include:

- 90° face mill for roughing and finishing; Ra 32-63
- 85° face mill for roughing with less face pressure; Ra 63-125
- 8 positive and easy-to-manage cutting edges
- .50" max depth of cut, .24" depth of cut along shoulder
- Medium and high density cutter offerings
- Carbide and SiN insert options

PRODUCT
ANNOUNCEMENT

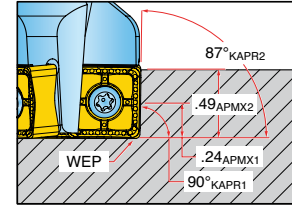
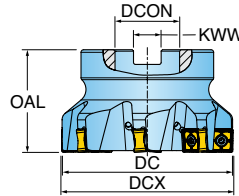
UPDATE

2018



SERIES DJ6T/DJ5T

90° QUAD ROUGHING & FINISHING FACE MILL



WEP - See insert drawing for wiper options.

Part Number	DC Cutting Dia.	DCX Cutting Dia. Max.	OAL Overall Length	ZEFF Effective Teeth	DCON Bore Dia.	KWW Keyway	DBC Bolt Circle	CSP Coolant
DJ6T-20R01	2.000	2.025	1.57	5	0.750	0.312	NA	Yes
DJ6T-25R01	2.500	2.523	1.57	6	0.750	0.312	NA	Yes
DJ5T-30R01	3.000	3.021	1.75	8	1.000	0.375	NA	Yes
DJ6T-30R01	3.000	3.021	1.75	7	1.000	0.375	NA	Yes
DJ5T-40R01	4.000	4.020	2.38	10	1.500	0.625	NA	Yes
DJ6T-40R01	4.000	4.020	2.38	8	1.500	0.625	NA	Yes
DJ6T-50R01	5.000	5.018	2.38	10	1.500	0.625	NA	Yes
DJ5T-60R01	6.000	6.016	2.38	17	1.500	0.625	NA	No
DJ6T-60R01	6.000	6.016	2.38	12	1.500	0.625	NA	No
DJ5T-80R01	8.000	8.016	2.38	21	2.500	1.000	4.00	No
DJ6T-80R01	8.000	8.016	2.38	14	2.500	1.000	4.00	No

NOTE: Carbide insert screw torque is 30-35 in lbs. SiN insert screw torque is 28 in lbs.

INSERTS

SNGU (Only Corner)



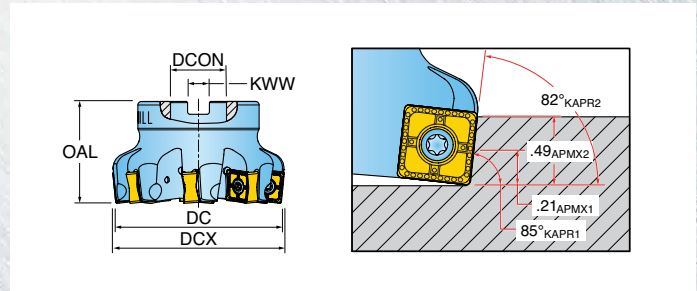
SNGU...TN (With Wiper)



Part Number	RE/BCH Corner Radius/ Chamfer	BS Wiper Length	IC Inscribed Circle Dia.	S Thickness (To Cutting Edge)	NOI Number of Indexes	IH Insert Hand	Grade								
							IN2510	IN2530	IN2505	IN2540	IN6515	IN4030	IN4015	IN7TN	
SNGU130604N	0.015 R	-	0.530	0.268	8	Neutral	•	•	•						•
SNGU130608N	0.031 R	-	0.530	0.268	8	Neutral	•	•							•
SNGU130612N	0.047 R	-	0.530	0.268	8	Neutral	•	•							•
SNGU130616N	0.062 R	-	0.530	0.268	8	Neutral		•	•	•				•	•
SNGU130608TN	0.031 R	0.047	0.530	0.268	8	Neutral	•	•	•	•			•	•	•
SNGU1306ANTN	0.031 Chamfer	0.047	0.530	0.268	8	Neutral	•	•	•	•			•	•	•

SERIES DL6T/DL5T

85° QUAD ROUGHING FACE MILL

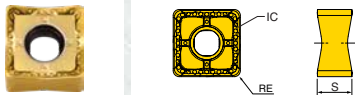


Part Number	DC Cutting Dia.	DCX Cutting Dia. Max.	OAL Overall Length	ZEFF Effective Teeth	DCON Bore Dia.	KWW Keyway	CSP Coolant
DL6T-20R01	2.000	2.11	1.570	5	0.750	0.312	No
DL6T-25R01	2.500	2.61	1.570	6	0.750	0.312	No
DL5T-30R01	3.000	3.11	1.750	8	1.000	0.375	No
DL5T-40R01	4.000	4.11	2.375	10	1.500	0.625	No
DL5T-50R01	5.000	5.11	2.375	13	1.500	0.625	No
DL5T-60R01	6.000	6.11	2.375	17	1.500	0.625	No

NOTE: Carbide insert screw torque is 30-35 in lbs. SiN insert screw torque is 28 in lbs.

INSERTS

SNGU



Part Number	RE/BCH Corner Radius/ Chamfer	IC Inscribed Circle Dia.	S Thickness (To Cutting Edge)	NOI Number of Indexes	IH Insert Hand	Grade							
						IN2510	IN2530	IN2505	IN2540	IN6515	IN4030	IN4015	IN7T1N
SNGU130604N	0.015 R	0.530	0.268	8	Neutral	•	•	•					•
SNGU130608N	0.031 R	0.530	0.268	8	Neutral	•		•					•
SNGU130612N	0.047 R	0.530	0.268	8	Neutral	•		•					•
SNGU130616N	0.062 R	0.530	0.268	8	Neutral		•	•	•				•

HARDWARE

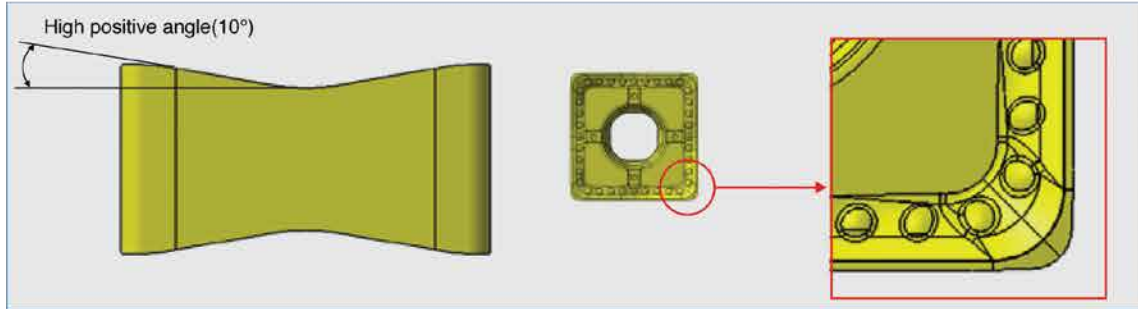
Description	Insert Material	Recommended Torque	 Insert Screw	 Driver Handle	 Torx Driver Blade
85° and 90° Face Mills	Carbide	30-35 in/lbs.	SM40-100-R0	DS-A00T	DS-T156B
	SiNi	28 in/lbs.	SM40-100-R0	DS-A00T	DS-T156B

OPERATING GUIDELINES

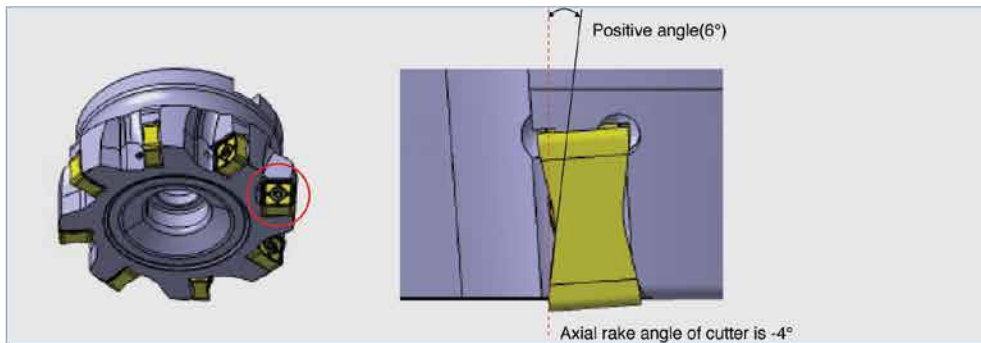
Material	Brinell Hardness	SFM	Feed per Insert (inch)	Grade								Coolant	
				IN2505	IN2510	IN2530	IN2540	IN4030	IN4015	IN6515	IN71N		
Aluminum	7075-T6, 6061-T6, 2024	-	1,500 - 10,000	.006 - .012	1								Yes
Cast Iron	Gray	150 - 250	500 - 1,000	.008 - .010	1				2	3			No
			1,800+	.005 - .008							1		
	Nodular		400 - 800	.007 - .009	3				1	2			
			1,500+	.004 - .007							1		
Steel	Low Carbon 1018, 8620	100 - 250	400 - 1,000	.006 - .018	3	2	4	1					No
	High Carbon F-6180	250 - 400	400 - 800										
	Alloyed Steel 4140, 4340	150 - 300	300 - 700										
	Tool Steel A-6, D-1, D-2	Up to 300	300 - 500										
Stainless Steel	300 Series, 304, 316	-	300 - 550	.005 - .008	3	2		1		1			May not be required at high speeds
	400 Series 15-5 PH	Up to 320	350 - 600										Yes
	13-8 PH	-	200 - 400										Yes
Nickel Alloys	Inconel, Hastelloy, Waspalloy	-	75-120	.003 - .006	1	3	2					Yes	
Titanium	6AL-4V	-	100 - 150	.004 - .007	3	2	1					Yes	

FEATURES AND BENEFITS

High positive insert geometry and dimple chip breaker lower the cutting forces



Low power requirement and smooth cutting possible due to 6 degrees positive rake angle



Unique angle screws gives secure insert clamping and option for high density pitch

