



DIPOS FINISH[™]

MILLING PRODUCTS

Cutter Series
TA3Q

Insert Series:
ANED12_ML: Multi-Purpose
ANED12_AL: Aluminum
ANED12_CBN: CBN
ANED12_PCD: PCD

Diameter Range:
.200" - 6.00"

Depth of Cut Range:
.012" - .020"

Corner:
.03"R & .03" Chamfer

Materials:
Cast Iron, Steel, Stainless Steel,
High-Temp Alloys, Titanium,
Aluminum & Hard Steel



Fixed Pocket (non-adjusting) Super Finish Mills

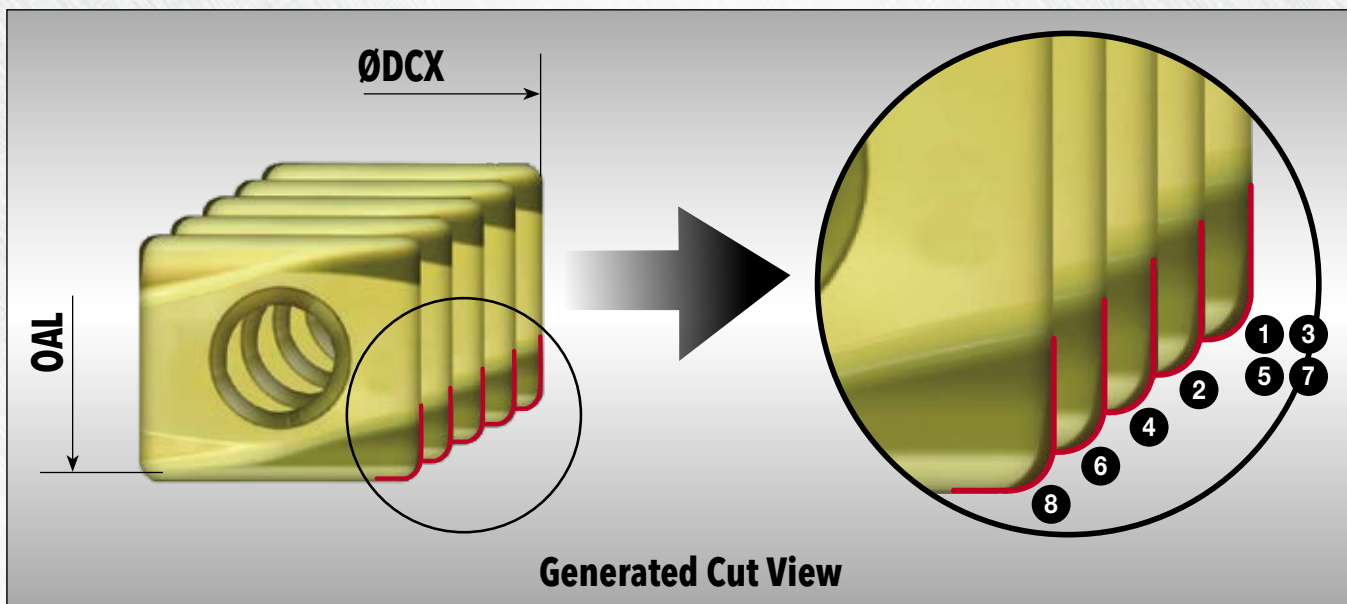
The unique "stepped" design of this fixed pocket finish face mill eliminates the hassle of set up that is typical with adjustable finish mills. That's because there is only one proud wiper station....so there is No Runout! The remainder of the stations are to balance radial load.

Features & Benefits:

- Long crowned wiper produces 3-15 Ra surface finish
- Non-adjusting design reduces set up time
- Stepped insert orientation alleviates axial & radial forces; only one proud wiper insert
- Can mill up to 90° shoulder
- 12 mm Insert with up to 4 indexes
- High positive axial rake promotes chip evacuation and improves tool life
- Carbide, CBN & PCD insert offering for a wide variety of materials!



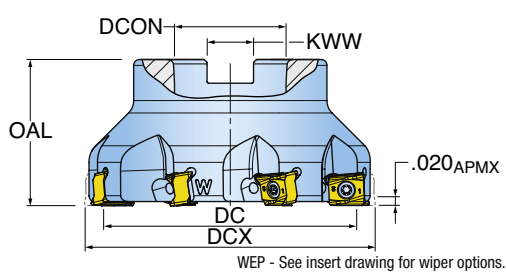
DIPOSFINISH™ "STEPPED" INSERTS



The stepped insert arrangement eliminates runout by making one proud axial wiper station...with the remaining inserts balancing the radial load.

DIPOSFINISH™ SERIES TA3Q

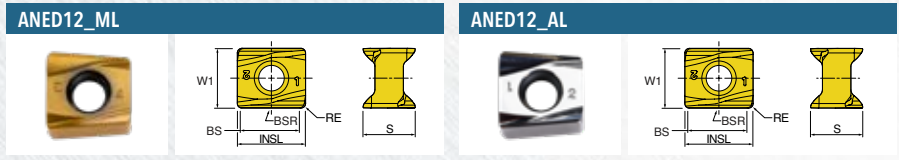
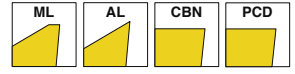
FIXED POCKET (NON-ADJUSTING) FINISH FACE MILL



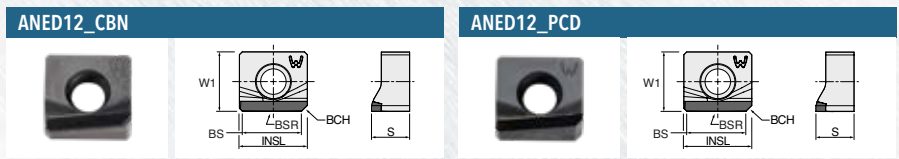
Part Number	DC Cutting Dia.	DCX Cutting Dia. Max.	OAL Overall Length	ZEFF Eff. Teeth	DCON Shank Dia.	KWW Keyway	CSP Coolant	RPM RPM Max.
TA3Q-20R01	1.563	2.000	1.570	5	0.750	0.312	Yes	11800
TA3Q-25R01	2.024	2.500	1.570	6	0.750	0.312	Yes	10500
TA3Q-30R01	2.484	3.000	1.750	8	1.000	0.375	Yes	9300
TA3Q-40R01	3.484	4.000	2.375	8	1.500	0.625	Yes	8300
TA3Q-50R01	4.444	5.000	2.375	10	1.500	0.625	Yes	7450
TA3Q-60R01	5.444	6.000	2.375	10	1.500	0.625	No	6600



DIPOSFINISH™ INSERTS



Part Number	Application	RE Corner Radius	BS Wiper Length	BSR Wiper Radius	LE Cutting Edge Eff. Length	INSL Insert Length	W1 Insert Width	S Thickness	NOI Number of Indexes	IH Insert Hand	Grade	IN2505	IN2510	IN10K
ANED1207-ML	Finishing	0.031	0.412	39.400	0.020	0.472	0.413	0.358	4	Right		•	•	
ANED1207-AL	Finishing, Sharp	0.031	0.412	39.400	0.020	0.472	0.413	0.358	4	Right				•



Part Number	Application	BCH Corner Chamfer Length	BS Wiper Length	BSR Wiper Radius	LE Cutting Edge Eff. Length	INSL Insert Length	W1 Insert Width	S Thickness	NOI Number of Indexes	IH Insert Hand	Grade	IN80B	IN93D
ANED1207-CBN	Finishing	0.030	0.412	39.400	0.020	0.472	0.413	0.264	1	Right		•	
ANED1207-PCD	Finishing	0.030	0.412	39.400	0.020	0.472	0.413	0.264	1	Right			•

DIPOSFINISH™ HARDWARE

	Screw	Driver Handle	Torque Driver Bit	Retention Bolt	Coolant Retention Bolt	Torque Driver Handle	Preset Torque Bit	Torque Driver Bit
TA3Q-20R01	SM40-115-00	DS-A00T	DS-T156B1	SD-06-46	SD-06-89	DS-A00-.25-T	DT-35-25	DS-T15B1
TA3Q-25R01	SM40-115-00	DS-A00T	DS-T156B1	SD-06-46	SD-06-89	DS-A00-.25-T	DT-35-25	DS-T15B1
TA3Q-30R01	SM40-115-00	DS-A00T	DS-T156B1	SD-08-46	SD-08-92	DS-A00-.25-T	DT-35-25	DS-T15B1
TA3Q-40R01	SM40-115-00	DS-A00T	DS-T156B1	SD-12-82	SD-12-99	DS-A00-.25-T	DT-35-25	DS-T15B1
TA3Q-50R01	SM40-115-00	DS-A00T	DS-T156B1	SD-12-82	SD-12-99	DS-A00-.25-T	DT-35-25	DS-T15B1
TA3Q-60R01	SM40-115-00	DS-A00T	DS-T156B1	-	-	DS-A00-.25-T	DT-35-25	DS-T15B1



DIPOSFINISH™ OPERATING GUIDELINES

ISO	Materials			Vc Cutting Speed SFM	fz* Feed/Tooth (inch)	ap Axial Cut Depth (inch)	Harder.....Tougher					Coolant
	Mat'l Group #VDI 3323	Type	Examples				IN93D	IN80B	IN10K	IN2510	IN2505	
P	1 thru 5	Non-alloy Steel	1018, A36, 1045, A572, 1070	400-1,000	.004-.010	.010-.020						No
	6 thru 9	Low-alloy Steel	4140, 4340, P20, 8620, 300M	350-700							1	
	10, 11	High-alloy Steel	H13, A2, D2, M2, T1	300-600								
M	12 thru 13	Stainless Steel (Fer- ritic & Martensitic)	410, 416, 440	350-600	.004-.010	.010-.020					1	Yes May not be required at high speeds
	14	Stainless Steel (Austenitic)	303, 304, 316, 15-5, 17-4	300-550								
K	15 thru 16	Gray Cast Iron	CLS. 20, 30, 45	500-1,000	.004-.010	.010-.020				1	2	No
	17 thru 20	Nodular Cast Iron	60-40-18, 100-70-03	1,800-3,000			.002-.008	.010-.020		1		
	17 thru 20	Nodular Cast Iron	60-40-18, 100-70-03	400-800	.004-.010	.010-.020				1	2	
N	21 - 30	Aluminum	7075, 6061	1,000-10,000	.004-.010	.010-.020	1		1			Yes
S	31 thru 35	High-Temp Alloys	Inconel, Hastelloy, Nimonic, Monel	65-120	.004-.010	.010-.020					1	Yes
		Co Based > 35 HRC	Stellite, Haynes	250-500	.002-.005	.010-.020		1				
		Ni Based > 35 HRC	Inconel, Hasteloy	200-450	.002-.005	.010-.020		1				
		Fe Based > 35 HRC	Nitronic, Ferralium	150-350	.002-.005	.010-.020		1				
	36 thru 37	Titanium Alloys	6Al-4V, 5Al-5Mo-5V-3Cr	85-130	.004-.010	.010-.020					1	
H	38 thru 39	Hardened Steel >48	A2, O1, D2	130-250	.004-.010	.010-.020		1				No

Note: Feed and speed recommendations are starting operating parameters. They are only guidelines from which further optimization should take place. Operating parameters are influenced by many machining variables. These variables may cause for reductions in feeds and speed or dramatic increases. Additionally, DOC and WOC may need to be revised to optimize the tools performance.



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