

Two-Sided Technology



Double your cutting edges from 2 to 4!

- Two Sided Insert Adds Value by Doubling You Cutting Edges!
- Thick and Robust Insert Adds Durability to Demanding Cutting Conditions
- Double Positive Geometry Benefits Machining Efficiency and Slices Super Alloy Materials
- Integrated Wiper Flat Produces Exceptional Surface Finishes
- Coolant Through the Tool Offered
- Various Corner Radii Offered



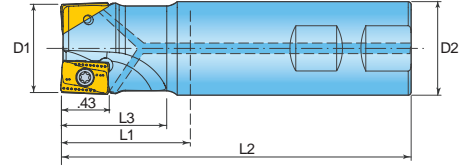
Diameters:
1.00" - 8.00"

Insert Series:
ANHU
ZNHU

Materials:
Cast Iron, Steel, Stainless Steel,
Hardened Steel, High-Temp Alloys

DIPOSOTETRA™ SERIES 1TJ1Q (12MM)

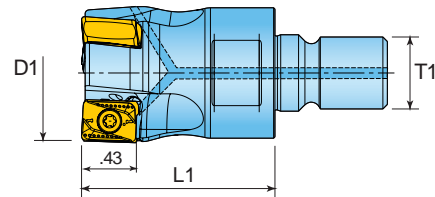
0 DEGREE LEAD ENDMILL WITH 4 INDEXES



Cutter Number	D1 Effective Diameter	L1 Extension Length	L2 Overall Length	L3 Projection Length	D2 Shank Size/Style	# of Inserts	Ramp Angle
1TJ1Q-1001784R01	1.000	1.75	3.75	1.75	.750 W	2	1.09
1TJ1Q-1001780R01	1.000	1.75	4.00	1.55	1.00 W	2	1.09
1TJ1Q-1003780R01	1.000	3.75	6.00	3.55	1.00 W	2	1.09
1TJ1Q-1201784R01	1.250	1.75	3.75	1.75	.750 W	3	.73
1TJ1Q-1202281R01	1.250	2.25	4.50	2.22	1.25 W	3	.73
1TJ1Q-1204281R01	1.250	4.25	6.50	4.22	1.25 W	3	.73
1TJ1Q-1502281R01	1.500	2.25	4.50	2.25	1.25 W	4	.58
1TJ1Q-2002281R01	2.000	2.25	4.50	2.22	1.25 W	5	.40

DIPOSOTETRA™ SERIES 1TJ1Q (TOP•ON STYLE) (12MM)

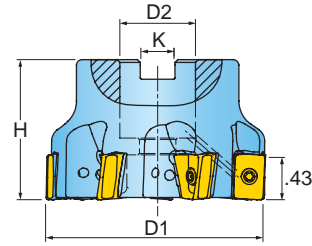
0 DEGREE LEAD ENDMILL WITH 4 INDEXES



Cutter Number	D1 Effective Diameter	T1 Adaption	L1 Extension Length	Number of Inserts	Wrench Size	Ramp Angle
1TJ1Q-10015X7R01	1.000	M12	1.50	2	17mm	1.09
1TJ1Q-12017X8R01	1.250	M16	1.75	3	22mm	.73
1TJ1Q-15017X8R01	1.500	M16	1.75	4	22mm	.58

DIPOSOTETRA™ SERIES TJ5Q, TJ6Q (12MM)

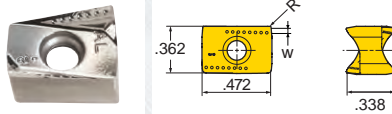
0 DEGREE LEAD FACEMILL WITH 4 INDEXES



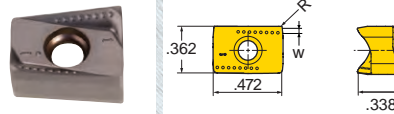
Cutter Number	D1 Effective Diameter	# of Inserts	H Height	D2 Bore Diameter	Retention Bolt	Optional Coolant Bolt	K Keyway	Ramp Angle
TJ5Q-20R01	2.000	6	1.570	0.75	SD-06-46	SD-06-89	0.31	.40
TJ6Q-20R01	2.000	3	1.570	0.75	SD-06-46	SD-06-89	0.31	.40
TJ6Q-25R01	2.500	6	1.570	0.75	SD-06-46	SD-06-89	0.31	.30
TJ5Q-30R01	3.000	9	1.750	1.00	SD-08-46	SD-08-92	0.38	.25
TJ6Q-30R01	3.000	7	1.750	1.00	SD-08-46	SD-08-92	0.38	.25
TJ5Q-40R01	4.000	11	2.375	1.50	SD-12-82	SD-12-99	0.62	.18
TJ6Q-40R01	4.000	7	2.375	1.50	SD-12-82	SD-12-99	0.62	.18

DIPOSOTETRA™ INSERTS (12MM)

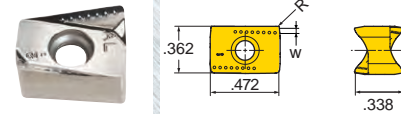
ANHU120604FR-P



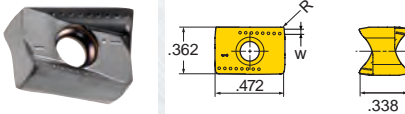
ANHU120604R



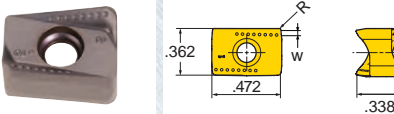
ANHU120608FR-P



ANHU120608R



ANHU120616R



Part Number	Application	R Corner	w Wiper	Grade	IN10K	IN2505	IN2510	IN2530	IN2540	IN4035
ANHU120604R	Multi-Purpose	.015" R	0.060			•				
ANHU120608R	Multi-Purpose	.031" R	0.043			•	•	•	•	
ANHU120616R	Multi-Purpose	.062" R	0.028			•		•		
ANHU120604FR-P	Ground/Polished for Alum.	.015" R	0.060		•					
ANHU120608FR-P	Ground/Polished for Alum.	.031" R	0.047		•					
ANHU120608FR	Hi Temp/Ti	.031" R	0.043							•

DIPOSOTETRA™ HARDWARE



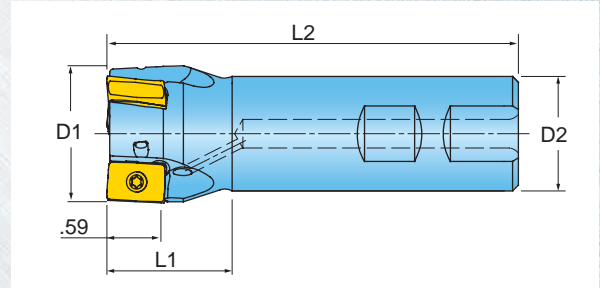
Screw



ANHU12	SM35-088-10	DS-T10T
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DIPOSOTETRA™ SERIES 1TJ1N (16MM)

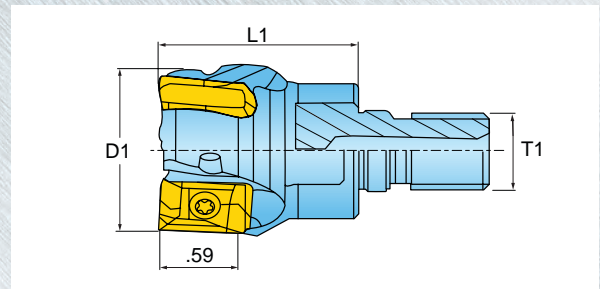
0 DEGREE LEAD ENDMILL WITH 4 INDEXES



Cutter Number	D1 Nominal Diameter	L1 Extension Length	L2 Overall Length	D2 Shank Size/Style	Number of Inserts	Ramp Angle
1TJ1N-1202281R01	1.250	2.25	4.50	1.250" Weldon	2	1.2
1TJ1N-1204281R01	1.250	4.25	6.50	1.250" Weldon	2	1.2
1TJ1N-1206281R01	1.250	6.25	8.50	1.250" Weldon	2	1.2
1TJ1N-1502281R01	1.500	2.25	4.50	1.250" Weldon	3	1.1
1TJ1N-1504281R01	1.500	4.25	6.50	1.250" Weldon	3	1.1
1TJ1N-2002281R01	2.000	2.25	4.50	1.250" Weldon	4	1.0

DIPOSOTETRA™ SERIES 1TJ1N (TOP-ON STYLE) (16MM)

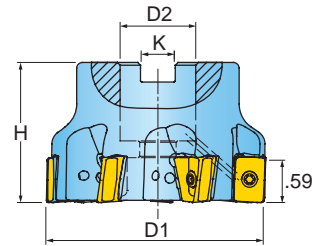
0 DEGREE LEAD ENDMILL WITH 4 INDEXES



Cutter Number	D1 Nom. Dia.	T1 Adaption	L1 Extension Length	Number of Inserts	Wrench Size	Ramp Angle
1TJ1N-12015X8R01	1.250	M16	1.50	2	22mm	1.2
1TJ1N-15015X8R01	1.500	M16	1.50	3	22mm	1.1

DIPOSOTETRA™ SERIES TJ5N, TJ6N (16MM)
4D 90

0 DEGREE LEAD FACEMILL WITH 4 INDEXES







Cutter Number	D1 Nominal Diameter	Number of Inserts	H Height	D2 Bore Dia.	K Keyway	Bolt Circle Diameter	Ramp Angle
TJ5N-20R01	2.000	4	1.570	0.750	0.312	NA	1.0
TJ6N-20R01	2.000	3	1.570	0.750	0.312	NA	1.0
TJ5N-25R01	2.500	5	1.750	1.000	0.375	NA	.60
TJ5N-30R01	3.000	7	1.750	1.000	0.375	NA	.50
TJ6N-30R01	3.000	5	1.750	1.000	0.375	NA	.50
TJ5N-40R01	4.000	8	2.000	1.500	0.625	NA	.35
TJ6N-40R01	4.000	5	2.000	1.500	0.625	NA	.35
TJ5N-50R01	5.000	10	2.000	1.500	0.625	NA	.25
TJ6N-50R01	5.000	7	2.000	1.500	0.625	NA	.25
TJ5N-60R01	6.000	11	2.480	1.500	0.625	NA	.15
TJ6N-60R01	6.000	8	2.480	1.500	0.625	NA	.15
TJ5N-80R01	8.000	14	2.480	2.500	1.000	4.00	.05

DIPOSOTETRA™ INSERTS (16MM)



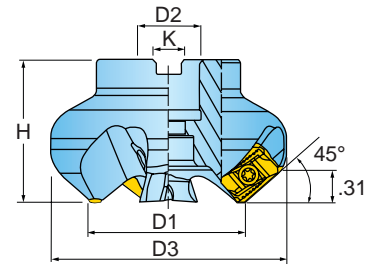
Part Number	Applications	Corner	Grade	IN10K	IN2510	IN2530	IN2505	IN2540	IN6515	IN4035
ANHU160704FR-P	Ground/Polished for Alum.	0.015" R		•						
ANHU160704R	Multi-Purpose	0.015" R				•				
ANHU160708FR	Hi-Temp/Ti	0.031" R				•				•
ANHU160708FR-P	Ground/Polished for Alum.	0.031" R		•						
ANHU160708R	Multi-Purpose	0.031" R			•	•	•	•	•	
ANHU160716R	Multi-Purpose	0.062" R			•	•	•	•		
ZNHU160708R	Chip Splitters	0.031" R				•	•			

DIPOSOTETRA™ HARDWARE

				
	Screw	Retention Bolt	Retention Bolt	(Optional) Coolant Bolt
1TJ1N	SM40-120-20	DS-T15T	-	-
TJ5N-20R01	SM40-120-20	DS-T15T	SD-06-46	SD-06-89
TJ6N-20R01	SM40-120-20	DS-T15T	SD-06-46	SD-06-89
TJ5N-25R01	SM40-120-20	DS-T15T	SD-08-46	SD-08-92
TJ5N-30R01	SM40-120-20	DS-T15T	-	-
TJ6N-30R01	SM40-120-20	DS-T15T	-	-
TJ5N-40R01	SM40-120-20	DS-T15T	-	-
TJ6N-40R01	SM40-120-20	DS-T15T	-	-
TJ5N-50R01	SM40-120-20	DS-T15T	-	-
TJ6N-50R01	SM40-120-20	DS-T15T	-	-
TJ5N-60R01	SM40-120-20	DS-T15T	-	-
TJ6N-60R01	SM40-120-20	DS-T15T	-	-
TJ5N-80R01	SM40-120-20	DS-T15T	-	-

DIPOSOTETRA™ SERIES TN1N (16MM)

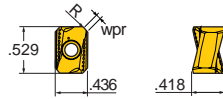
45 DEGREE LEAD FACEMILL WITH 4 INDEXES



Cutter Number	D1 Nominal Diameter	D3 Overall Diameter	Number of Inserts	D2 Bore Dia.	H Height	K Keyway
TN1N-20R01	2.000	2.68	4	0.750	1.750	0.312
TN1N-30R01	3.000	3.68	5	1.000	1.750	0.375
TN1N-30R02	3.000	3.68	7	1.000	1.750	0.375
TN1N-40R01	4.000	4.67	6	1.500	2.375	0.625
TN1N-40R02	4.000	4.67	8	1.500	2.375	0.625
TN1N-60R01	6.000	6.67	10	1.500	2.375	0.625

DIPOSOTETRA™ INSERTS (16MM)

ANHU1607ANR



Part Number	Applications	Wiper	R Corner	Grade	IN2510	IN2530	IN2540
ANHU1607ANR	Multi-Purpose	.062	0.015" R		•	•	•

DIPOSOTETRA™ HARDWARE



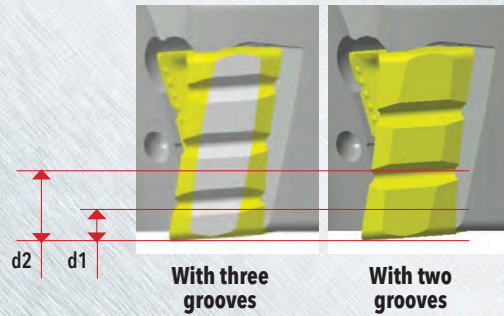
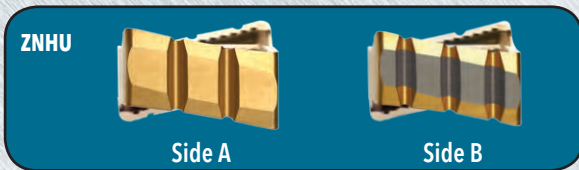
Screw

SM40-120-20

DS-T15T

CHIPSPLITTER INFORMATION

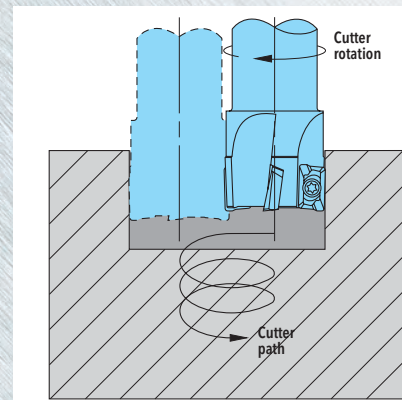
- Reduces vibration and noise
- Improves chip evacuation (Chips split into small pieces)
- Reduces heat generation
- Suitable for long overhang machining (weak machining and fixture applications)
- Mountable on all standard cutter lines without any modification



Depth of Cut	ANHU 16
d1	.10"
d2	.23"

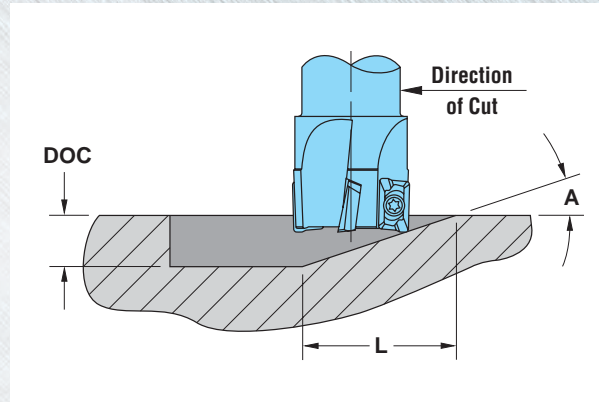
CORKSCREW MILLING

Cutter Diameter	Min. Dia. Milled Hole	Min. Advance Per Cutter Path Rev. (APCPR)	Max. Dia. Milled Hole	Max. Advance Per Cutter Path Rev. (APCPR)
1.25	1.75	0.024	2.44	0.071
1.50	2.40	0.039	2.94	0.079
2.00	3.25	0.055	3.94	0.091
2.50	4.25	0.047	4.94	0.071
3.00	5.50	0.055	5.94	0.075
4.00	7.25	0.051	7.94	0.063
5.00	9.10	0.047	9.94	0.059
6.00	11.85	0.039	11.94	0.043
8.00	15.00	0.016	15.94	0.020



RAMPING

Cutter Diameter	A Ramping Angle	L Length	Depth of Cut
1.25	1.20	28	0.59
1.50	1.10	31	0.59
2.00	1.00	34	0.59
2.50	0.60	56	0.59
3.00	0.50	68	0.59
4.00	0.35	97	0.59
5.00	0.25	135	0.59
6.00	0.15	226	0.59
8.00	0.05	677	0.59





DiPos TETRA - Series 1TJ10, TJ50, TJ60, 1TJ1N, TJ5N, TJ6N, TN1N					IN10K	IN2505	IN2510	IN2530	IN2540	IN6515	Coolant
Material	Brinnell Hardness	SFM	Feed per Insert								
Aluminum	6061-T6, 7075-T6, 2024	-	1500 - 8000	.004 - .018	1						Yes
Cast Iron	Gray	150 - 250	300 - 1000	.004 - .009		3	1			2	No
	Nodular		300 - 600			3	2			1	
Steel	Low Carbon 1018, 8620	150 - 250	400 - 1000	.004 - .009							No
	High Carbon F-6180, Nitralloy 52100	250 - 400	350 - 500	.004 - .007		2		1	3		
	Alloyed Steel 4140, 4340, 6150	150 - 300	300 - 700	.004 - .009							
	Tool Steel A-6, D-1, D-2, P20	Up to 300									
Stainless Steel	300 Series, 304, 316	-	300 - 550	.004 - .009							May not be required at high speeds
	400 Series 15-5 PH, 17-4 PH	Up to 320	350 - 600			2		1	3		
	13-8 PH	-	200 - 400								Yes
Nickel Alloys	Inconel 600, 706, 718, 903, Hastelloy, Waspalloy	-	75-120	.003 - .006		2		1			Yes
Titanium	6AL-4V	-	100 - 150	.005 - .008		2		1			Yes