

GOLD TRIO 10

90° MILL FAMILY OFFERING 3 HI-POSITIVE EDGES FOR THE PRICE OF 2!

Multi-Purpose



Polished for Aluminum



SS/Hi-Temp/Ti



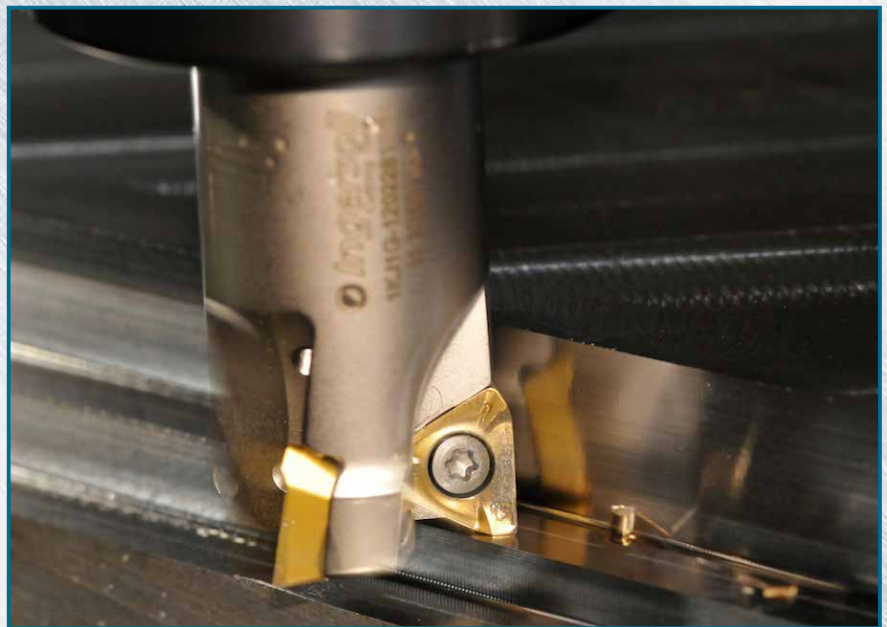
Diameters:
Ø1.250" - Ø 5.000"

Depth of Cut:
.41"

Insert Series:
TH_S10
THS10_P
THLS10_HR

Materials:
Aluminum, Iron, Steel, Stainless
Steel, Hi-Temps, Titanium

AHB Tooling & Machinery, Inc.
ISO Certified
(800) 991-4225
www.ahbinc.com
customerservice@ahbinc.com
Complete Metalworking Solutions
Roseville Saginaw & Jackson, MI

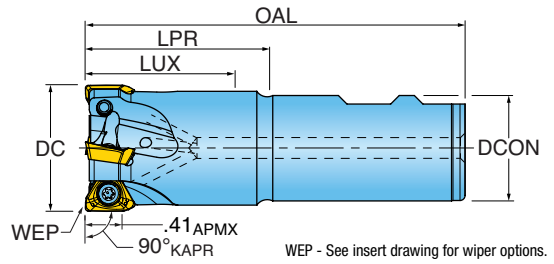


General Features:

- Hi-Positive geometry with 3 cutting edges for performance and economy
- Diverse range of insert corner and grade options for a broad range of materials
- Inserts equipped with integrated wipers for surface finishes between 32-63 Ra
- Cutters offered with coolant through
- Ramping capability for versatility

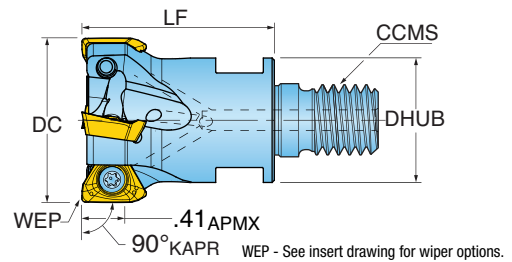
**UPDATED
PRODUCT
ANNOUNCEMENT
2017**

90° END MILL



| 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. |
|------------------|---------------------|------------------------|-----------------------|--------------------|----------------------|---------------------|-------------|----------------------|
| 1KJ1G-1201784R01 | 1.250 | 1.75 | 1.75 | 3.75 | 3 | 0.750 | Yes | 2.3 |
| 1KJ1G-1202281R01 | 1.250 | 2.05 | 2.25 | 4.50 | 2 | 1.250 | Yes | 2.3 |
| 1KJ1G-1202281R02 | 1.250 | 2.05 | 2.25 | 4.50 | 3 | 1.250 | Yes | 2.3 |
| 1KJ1G-1204281R01 | 1.250 | 4.05 | 4.25 | 6.50 | 3 | 1.250 | Yes | 0 |
| 1KJ1G-1502281R01 | 1.500 | 2.20 | 2.25 | 4.50 | 3 | 1.250 | Yes | 1.8 |
| 1KJ1G-1502281R02 | 1.500 | 2.20 | 2.25 | 4.50 | 4 | 1.250 | Yes | 1.8 |
| 1KJ1G-1504281R01 | 1.500 | 4.25 | 4.25 | 6.50 | 3 | 1.250 | Yes | 0 |
| 1KJ1G-2002281R01 | 2.000 | 2.25 | 2.25 | 4.50 | 5 | 1.250 | Yes | 1.5 |

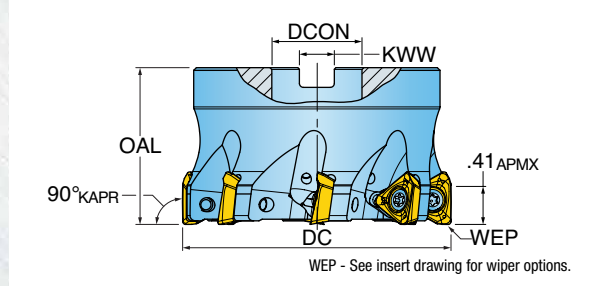
90° MODULAR END MILL



| Part Number | DC Cutting Diameter | LF Functional Length | ZEFF Effective Teeth | CCMS Connection Code | DHUB Hub Diameter | CSP Coolant | RMPX Ramp Angle Max. |
|------------------|---------------------|----------------------|----------------------|----------------------|-------------------|-------------|----------------------|
| 1KJ1G-12017X8R01 | 1.250 | 1.50 | 3 | TopOn M16 | | Yes | 2.3 |
| 1KJ1G-15017X8R01 | 1.500 | 1.75 | 4 | TopOn M16 | | Yes | 1.8 |

GOLD[®]TRIO SERIES: KJ5G, KJ6G

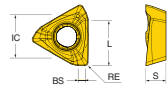
90° FACE MILL



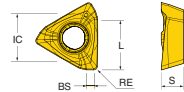
| Part Number | DC Cutting Diameter | OAL Overall Length | ZEFF Effective Teeth | DCON Bore Diameter | KWW Keyway | CSP Coolant | RMPX Ramp Angle Max. |
|-----------------------|---------------------|--------------------|----------------------|--------------------|------------|-------------|----------------------|
| NEW KJ6G-15R01 | 1.500 | 1.38 | 4 | 0.500 | 0.250 | Yes | 1.4 |
| KJ5G-20R01 | 2.000 | 1.57 | 5 | 0.750 | 0.312 | Yes | 1.5 |
| KJ6G-20R01 | 2.000 | 1.57 | 3 | 0.750 | 0.312 | Yes | .8 |
| KJ5G-25R01 | 2.500 | 1.57 | 6 | 0.750 | 0.312 | Yes | 1.1 |
| KJ5G-30R01 | 3.000 | 1.75 | 8 | 1.000 | 0.375 | Yes | .8 |
| KJ6G-30R01 | 3.000 | 1.75 | 5 | 1.000 | 0.375 | Yes | .8 |
| KJ6G-30R02 | 3.000 | 1.75 | 3 | 1.000 | 0.375 | Yes | .8 |
| KJ5G-40R01 | 4.000 | 2.00 | 10 | 1.500 | 0.625 | No | .6 |
| KJ6G-40R01 | 4.000 | 2.00 | 8 | 1.500 | 0.625 | No | .6 |
| KJ6G-50R01 | 5.000 | 2.00 | 11 | 1.500 | 0.625 | No | .5 |

GOLD[®]TRIO INSERTS

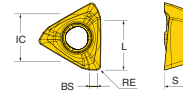
THES10



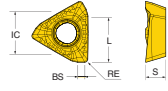
THES10_P



THLS10



THLS10_HR



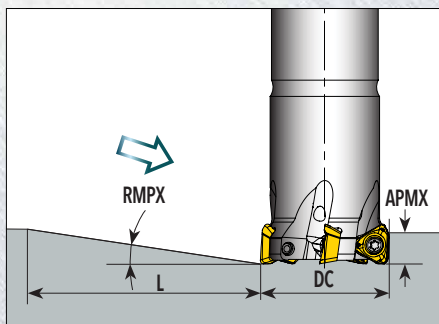
| Part Number | Application | RE Corner Radius | BS Wiper Length | L Cutting Edge Length | IC Inscribed Circle Diameter | S Thickness | Grade | NEW | | | | | | | |
|--------------------|---------------------------------|------------------|-----------------|-----------------------|------------------------------|-------------|-------|-------|--------|--------|--------|--------|--------|--------|--|
| | | | | | | | | IN10K | IN2035 | IN2505 | IN2510 | IN2530 | IN2540 | IN4030 | |
| THES100504R | Multi-Purpose; Ground Periphery | 0.015 R | 0.078 | 0.430 | 0.421 | 0.197 | | | | • | | | | | |
| THES100508R | Multi-Purpose; Ground Periphery | 0.031 R | 0.062 | 0.430 | 0.421 | 0.197 | | | | • | | | | | |
| THES100516R | Multi-Purpose; Ground Periphery | 0.062 R | 0.031 | 0.430 | 0.421 | 0.197 | | | | • | | | | | |
| THES100504FR-P | Grd/Pol for Al | 0.015 R | 0.078 | 0.430 | 0.421 | 0.197 | • | | | | | | | | |
| THES100508FR-P | Grd/Pol for Al | 0.031 R | 0.062 | 0.430 | 0.421 | 0.197 | • | | | | | | | | |
| THLS100508R | Multi-Purpose | 0.031 R | 0.062 | 0.430 | 0.421 | 0.197 | | | • | • | • | • | • | • | |
| THLS100516R | Multi-Purpose | 0.062 R | 0.031 | 0.430 | 0.421 | 0.197 | | | • | | | | | | |
| THLS100524R | Multi-Purpose | 0.094 R | 0.020 | 0.430 | 0.421 | 0.197 | | | • | | | | | | |
| NEW THLS100508R-HR | SS/Hi-Temp/Ti | 0.031 R | 0.062 | 0.430 | 0.421 | 0.197 | | | • | • | | • | | | |

GOLD[®]TRIO HARDWARE

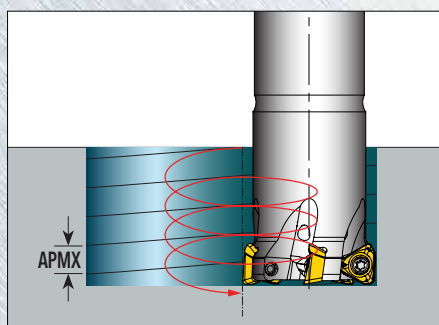


| | Insert Screw | Driver Handle | Torx Driver Blade | Retention Bolt | Retention Bolt w/Coolant | Wrench |
|------------------|--------------|---------------|-------------------|----------------|--------------------------|--------|
| 1KJ1G-1201784R01 | SM40-100-R0 | DS-A00T | DS-T156B | - | - | - |
| 1KJ1G-1202281R01 | SM40-100-R0 | DS-A00T | DS-T156B | - | - | - |
| 1KJ1G-1202281R02 | SM40-100-R0 | DS-A00T | DS-T156B | - | - | - |
| 1KJ1G-1204281R01 | SM40-100-R0 | DS-A00T | DS-T156B | - | - | - |
| 1KJ1G-1502281R01 | SM40-100-R0 | DS-A00T | DS-T156B | - | - | - |
| 1KJ1G-1502281R02 | SM40-100-R0 | DS-A00T | DS-T156B | - | - | - |
| 1KJ1G-1504281R01 | SM40-100-R0 | DS-A00T | DS-T156B | - | - | - |
| 1KJ1G-2002281R01 | SM40-100-R0 | DS-A00T | DS-T156B | - | - | - |
| 1KJ1G-12017X8R01 | SM40-100-R0 | DS-A00T | DS-T156B | - | - | 622MM |
| 1KJ1G-15017X8R01 | SM40-100-R0 | DS-A00T | DS-T156B | - | - | 622MM |
| KJ6G-15R01 | SM40-100-R0 | DS-A00T | DS-T156B | SE04-15 | - | - |
| KJ5G-20R01 | SM40-100-R0 | DS-A00T | DS-T156B | SD-06-46 | SD-06-89 | - |
| KJ6G-20R01 | SM40-100-R0 | DS-A00T | DS-T156B | SD-06-46 | SD-06-89 | - |
| KJ5G-25R01 | SM40-100-R0 | DS-A00T | DS-T156B | SD-06-46 | SD-06-89 | - |
| KJ5G-30R01 | SM40-100-R0 | DS-A00T | DS-T156B | SD-08-46 | SD-08-92 | - |
| KJ6G-30R01 | SM40-100-R0 | DS-A00T | DS-T156B | SD-08-46 | SD-08-92 | - |
| KJ6G-30R02 | SM40-100-R0 | DS-A00T | DS-T156B | SD-08-46 | SD-08-92 | - |
| KJ5G-40R01 | SM40-100-R0 | DS-A00T | DS-T156B | - | - | - |
| KJ6G-40R01 | SM40-100-R0 | DS-A00T | DS-T156B | - | - | - |
| KJ6G-50R01 | SM40-100-R0 | DS-A00T | DS-T156B | - | - | - |

| Series 1KJ1D, KJ_D | | | | | IN10K | IN2035 | IN2505 | IN2510 | IN2530 | IN2540 | IN4030 | Coolant |
|--------------------|-------------------------------|-----------|-----------------|-----------|-------|--------|--------|--------|--------|--------|--------|------------------------------------|
| Material | Brinnell Hardness | SFM | Feed per Insert | | | | | | | | | |
| Aluminum | 6061-T6, 7075-T6, 2024 | - | 1500 - 5000 | .004-.010 | 1 | | | | | | | Yes |
| Cast Iron | Gray | 150 - 250 | 300 - 1000 | .004-.008 | | | 3 | 1 | | | 4 | No |
| | Nodular | | 300 - 600 | | | | 3 | 1 | | | 4 | |
| Steel | Low Carbon 1018, 8620 | 100 - 250 | 400 - 1000 | .004-.007 | | | | | | | | No |
| | High Carbon F-6180 | 250 - 400 | 350 - 500 | | | | | | | | | |
| | Alloyed Steel 4140, 4340 | 150 - 300 | 300 - 700 | | 3 | | 2 | 4 | 1 | | | |
| | Tool Steel A-6, D-1, D-2 | Up to 300 | | | | | | | | | | |
| Stainless Steel | 300 Series, 304, 316 | - | 300 - 550 | .004-.006 | | | | | | | | May not be required at high speeds |
| | 400 Series 15-5 PH | Up to 320 | 350 - 600 | | 1 | 4 | | 3 | 5 | 2 | Yes | |
| | 13-8 PH | - | 200 - 400 | | | | | | | | | |
| Nickel Alloys | Inconel, Hastelloy, Waspalloy | - | 65-120 | .003-.005 | | 1 | 2 | | 4 | | 3 | Yes |
| Titanium | 6AL-4V | - | 100 - 150 | .003-.005 | | 1 | 4 | | 3 | | 2 | Yes |

Straight ramping


| DC Cutter Diameter | RMPX Ramp Angle Max. | APMX Depth of Cut Max. | L |
|-----------------------|-------------------------|---------------------------|------|
| 1.250 | 2.7 | 0.41 | 8.6 |
| 1.500 | 1.7 | 0.41 | 13.8 |
| 2.000 | 1.2 | 0.41 | 19.5 |
| 2.500 | 1.0 | 0.41 | 23.4 |
| 3.000 | 0.7 | 0.41 | 33.5 |
| 4.000 | 0.6 | 0.41 | 39.1 |
| 5.000 | 0.4 | 0.41 | 58.7 |

Helical ramping


| DC Cutter Diameter (Using R.031 Insert) | Min. Dia. Milled Hole (Bottom with Cusp) | APMX / Rev. | Max. Dia. Milled Hole (Flat Bottom) | APMX / Rev. |
|---|---|-------------|--|-------------|
| 1.250 | 2.04 | 0.12 | 2.42 | 0.18 |
| 1.500 | 2.57 | 0.10 | 2.92 | 0.13 |
| 2.000 | 3.58 | 0.10 | 3.92 | 0.12 |
| 2.500 | 4.57 | 0.11 | 4.92 | 0.12 |
| 3.000 | 5.57 | 0.11 | 5.92 | 0.12 |
| 4.000 | 7.57 | 0.11 | 7.92 | 0.12 |
| 5.000 | 9.57 | 0.11 | 9.92 | 0.11 |