

ISO PLUS

Quad 90° - The Power of 8!

Diameters:

- 2.00" - 8.00"

Depth of Cut:

- .24" DOC & 90° shoulder
- .47" max DOC with slight taper

Insert Styles:

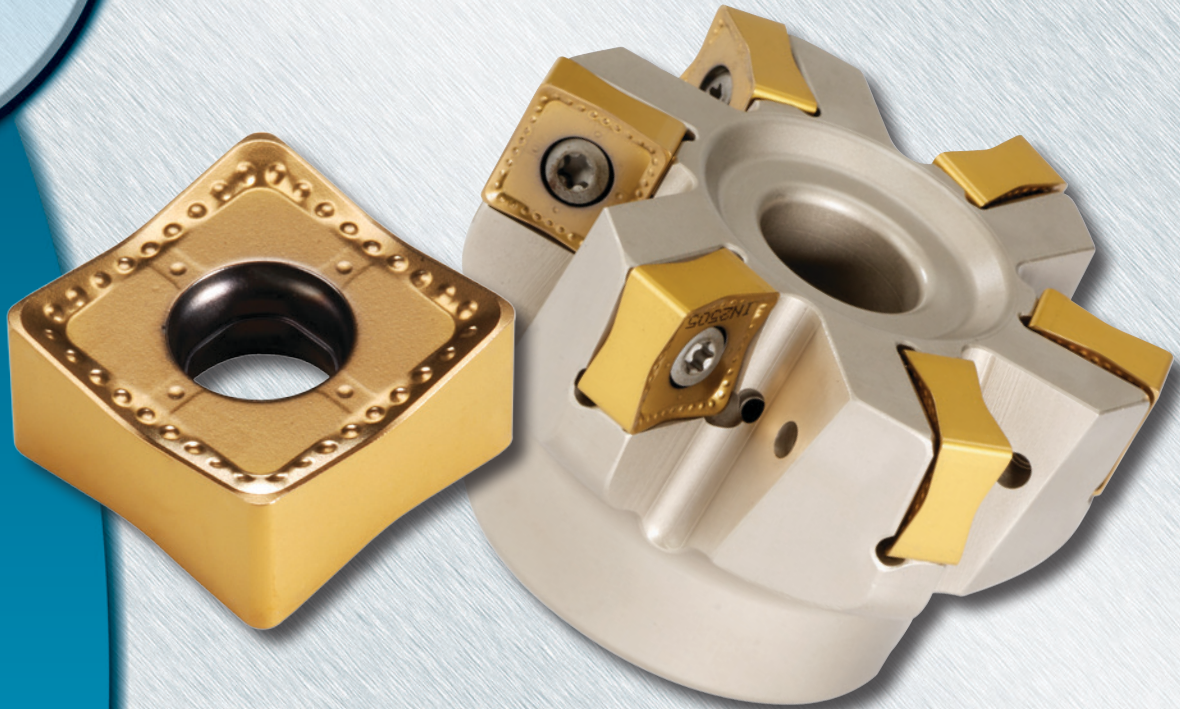
- SNGU13

Insert Grades:

- IN2505
- IN2510
- IN2530
- IN2540
- IN4030
- IN6515
- IN71N
- IN4015

Materials:

- Stainless Steel
- Hi-temp Alloys
- Iron
- Steel



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.

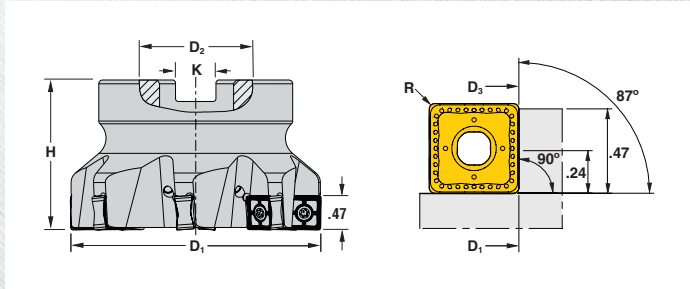
Features & Benefits include:

- 8 positive cutting edges with 90° shoulder
- .50" max depth of cut
- .24" depth of cut along 90° shoulder
- Medium and high density cutter offerings
- 2.00 - 8.00" diameter range
- Cutters equipped with coolant through

**NEW
PRODUCT
ANNOUNCEMENT
2014**

ISOPLUS SERIES DJ6T/DJ5T

90° QUAD FACE MILL

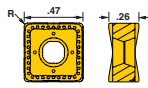


Cutter Number	D1 Nominal Diameter	D3 Overall Diameter	D2 Bore Size	K Keyway	H Height	No. of Inserts	Coolant Thru	Bolt Circle	SHCS	SHCS w/Coolant Thru*
Medium Density										
DJ6T-20R01	2.000	2.025	0.75	0.31	1.570	5	Yes	-	SD-06-46	SD-06-89
DJ6T-25R01	2.500	2.523	0.75	0.31	1.570	6	Yes	-	SD-06-46	SD-06-89
DJ6T-30R01	3.000	3.021	1.00	0.37	1.750	7	Yes	-	SD-08-46	SD-08-92
DJ6T-40R01	4.000	4.020	1.50	0.62	2.375	8	Yes	-	SD-12-82	SD-12-99
DJ6T-50R01	5.000	5.018	1.50	0.62	2.375	10	Yes	-	SD-12-82	SD-12-99
DJ6T-60R01	6.500	6.018	1.50	0.62	2.375	12	No	-	-	-
DJ6T-80R01	8.000	8.016	2.50	1.00	2.375	14	No	4.00	-	-
High Density										
DJ5T-30R01	3.000	3.021	1.00	0.37	1.750	8	Yes	-	SD-08-46	SD-06-89
DJ5T-40R01	4.000	4.020	1.50	0.62	2.375	10	Yes	-	SD-12-82	SD-12-99
DJ5T-50R01	5.000	5.018	1.50	0.62	2.375	13	Yes	-	SD-12-82	SD-12-99
DJ5T-60R01	6.000	6.018	1.50	0.62	2.375	17	No	-	-	-
DJ5T-80R01	8.000	8.016	2.50	1.00	2.375	21	No	4.00	-	-

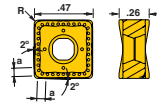
* Order separately.

ISOPLUS SERIES DJ6T/DJ5T INSERTS & HARDWARE

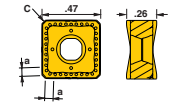
SNGU...N (Only corner)



SNGU...TN (Wiper w/R)



SNGU...ANTN (Wiper w/chamfer)



Inserts

Insert Number	Application	Corner	a	Grade								
				IN2510	IN2530	IN2505	IN2540	IN6515	IN7IN	IN4030	IN4015	
SNGU130604N	Positive Geometry	.015R	-	•								
SNGU130608N	SINI	.031R	-							•		
SNGU130608TN	Positive Geometry	.031R w/wiper	.047	•	•	•	•	•			•	
SNGU130616N	Positive Geometry	.062R	-		•	•	•	•				
SNGU1306ANTN	Positive Geometry	45 x .031 w/wiper	.047	•		•	•	•				•

Hardware



Insert Screw

SM40-100-R0



Driver Handle

DS-T15T



Insert Driver Blade

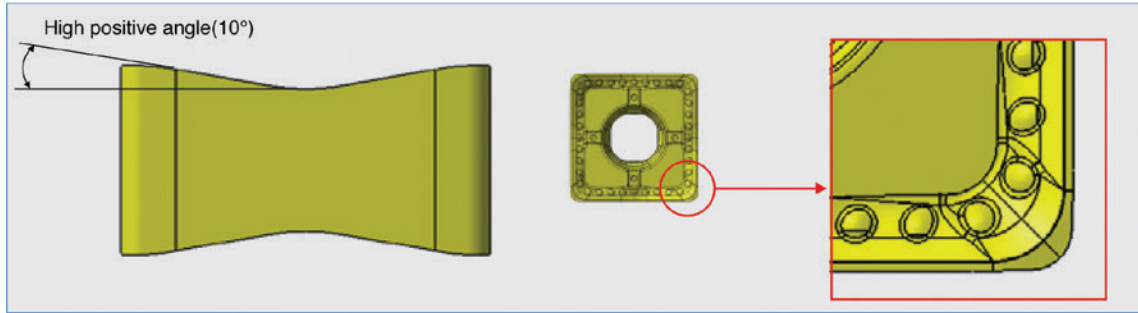
DS-T15B1



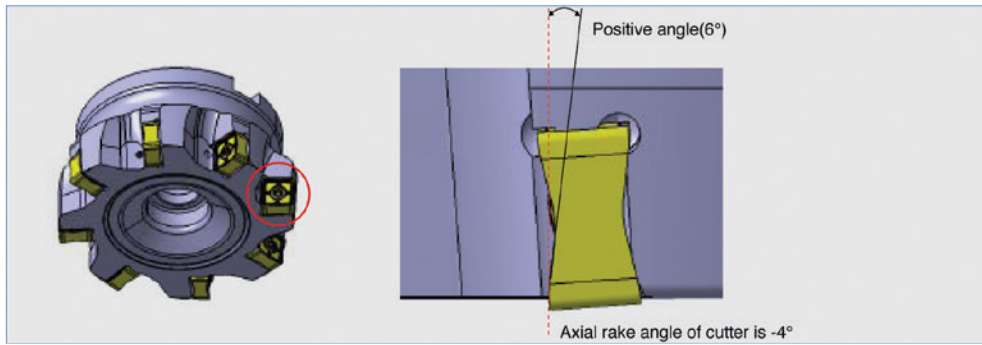
Optional Torque Wrench

DT-35-02

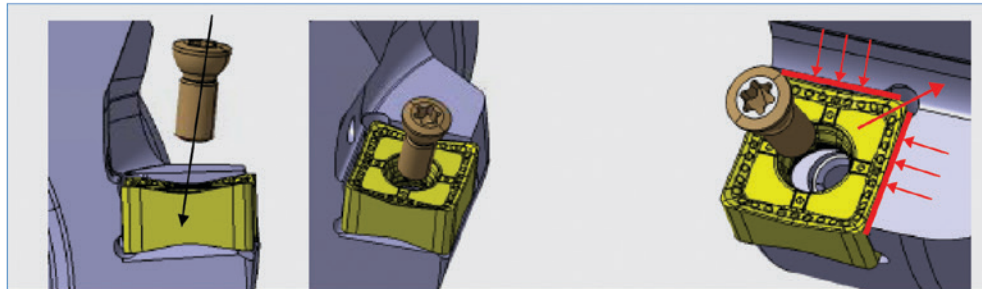
High positive insert geometry and dimple chip breaker lower the cutting forces



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



ISOPLUS 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 - 700	.005 - .008	3	2		1		1		May not be required at high speeds	
	400 Series 15-5 PH	Up to 320	400 - 700									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	