

**Slotters:**

- 3VJ5V

**Inserts:**

- IEE
- IXE

**Grades:**

- IN2505
- IN2515
- IN2530
- IN4005
- IN4015
- IN4030

**Applications:**

- Slotting
- Cut Off
- Back Face

## SUPER-MAX PERFORMANCE IN A THIN SLOTTER DESIGN

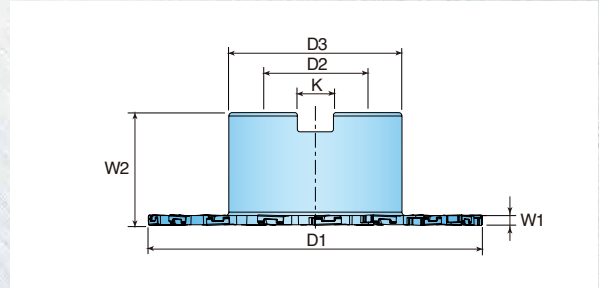
*Ingersoll is pleased to announce the release of our new ThinMax slotter series. Available in both Axial drive and Radial drive, these high performance thin slotters offer a robust insert geometry with 4 cutting edges (2 RH and 2 LH) in a wide variety of carbide grades, suitable for all material types.*

- Diameters ranging from Ø2.500" thru Ø8.00"
- Cutting widths ranging from .125" thru .375"
- 4 insert indexes, creates 90° sidewall
- Multiple corner radii
- Wide variety of carbide grades for all material types
- Same insert used in both RH and LH stations
- Available in both axial and radial drive



**THINOMAX™**  
TANGENTIAL**SERIES 3VJ5V****RADIAL SLOTTER**

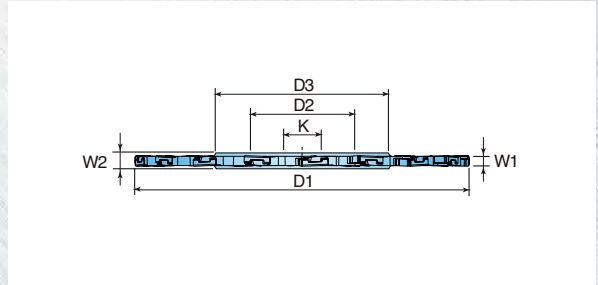
Slotting



Cutter Number	W1 Cutter Width	D1 Nom. Diameter	D2 Bore Diameter	W2 Hub Width	D3 Hub Diameter	K Keyway	Total # of Inserts	# of Effective Inserts	Insert Series
3VJ5V-02012D1R01	0.125	2.500	0.750	1.375	1.180	0.312	8	4	IEE211-001
3VJ5V-03012D1R01	0.125	3.000	0.750	1.500	1.500	0.312	10	5	IEE211-001
3VJ5V-04012D3R01	0.125	4.000	1.000	1.500	1.750	0.375	14	7	IEE211-001
3VJ5V-02015D1R01	0.156	2.500	0.750	1.375	1.180	0.312	8	4	IEE311-001
3VJ5V-03015D1R01	0.156	3.000	0.750	1.500	1.500	0.312	10	5	IEE311-001
3VJ5V-04015D3R01	0.156	4.000	1.000	1.500	1.750	0.375	12	6	IEE311-001
3VJ5V-0601558R01	0.156	6.000	1.500	2.000	3.070	0.625	18	9	IEE311-001
3VJ5V-02018D1R01	0.187	2.500	0.750	1.375	1.180	0.312	8	4	IEE312-001
3VJ5V-03018D1R01	0.187	3.000	0.750	1.500	1.500	0.312	10	5	IEE312-001
3VJ5V-04018D3R01	0.187	4.000	1.000	1.500	1.750	0.375	12	6	IEE312-001
3VJ5V-05018D3R01	0.187	5.000	1.000	1.500	2.250	0.375	14	7	IEE312-001
3VJ5V-0601858R01	0.187	6.000	1.500	2.000	3.070	0.625	18	9	IEE312-001
3VJ5V-02025D1R01	0.250	2.500	0.750	1.500	1.500	0.312	6	3	IXE412-001
3VJ5V-03025D1R01	0.250	3.000	0.750	1.500	1.500	0.312	8	4	IXE412-001
3VJ5V-04025D3R01	0.250	4.000	1.000	1.500	1.750	0.312	10	5	IXE412-001
3VJ5V-05025D3R01	0.250	5.000	1.000	1.500	2.250	0.375	12	6	IXE412-001
3VJ5V-0602558R01	0.250	6.000	1.500	2.000	3.070	0.625	14	7	IXE412-001
3VJ5V-04031D3R01	0.312	4.000	1.000	1.500	1.750	0.375	10	5	IXE413-001
3VJ5V-0603158R01	0.312	6.000	1.500	2.000	3.070	0.625	14	7	IXE413-001
3VJ5V-0803158R01	0.312	8.000	1.500	2.000	3.800	0.625	18	9	IXE413-001
3VJ5V-04037D3R01	0.375	4.000	1.000	1.500	1.750	0.375	10	5	IXE414-001
3VJ5V-05037D3R01	0.375	5.000	1.000	1.500	2.250	0.375	12	6	IXE414-001
3VJ5V-0603758R01	0.375	6.000	1.500	2.000	3.070	0.625	14	7	IXE414-001
3VJ5V-0803758R01	0.375	8.000	1.500	2.000	3.800	0.625	18	9	IXE414-001

**THINOMAX™**  
TANGENTIAL**SERIES 3VJ5V****AXIAL SLOTTER**

Slotting



Cutter Number	W1 Cutter Width	D1 Nom. Diameter	D2 Bore Diameter	W2 Hub Width	D3 Hub Diameter	K Keyway	Total # of Inserts	# of Effective Inserts	Insert Series
3VJ5V-03012AF-01	0.125	3.000	1.000	0.375	1.560	0.250	10	5	IEE211-001
3VJ5V-04012AF-01	0.125	4.000	1.000	0.375	1.750	0.250	14	7	IEE211-001
3VJ5V-03015AF-01	0.156	3.000	1.000	0.375	1.560	0.250	10	5	IEE311-001
3VJ5V-04015AF-01	0.156	4.000	1.000	0.375	1.750	0.250	12	6	IEE311-001
3VJ5V-06015AG-01	0.156	6.000	1.250	0.375	1.870	0.312	18	9	IEE311-001
3VJ5V-03018AF-01	0.187	3.000	1.000	0.375	1.560	0.250	10	5	IEE312-001
3VJ5V-04018AF-01	0.187	4.000	1.000	0.375	1.750	0.250	12	6	IEE312-001
3VJ5V-05018AG-01	0.187	5.000	1.250	0.375	1.870	0.312	14	7	IEE312-001
3VJ5V-06018AG-01	0.187	6.000	1.250	0.375	1.870	0.312	18	9	IEE312-001
3VJ5V-04025AF-01	0.250	4.000	1.000	0.375	1.750	0.250	10	5	IXE412-001
3VJ5V-05025AF-01	0.250	5.000	1.000	0.375	1.870	0.250	12	6	IXE412-001
3VJ5V-06025AG-01	0.250	6.000	1.250	0.375	1.870	0.312	14	7	IXE412-001
3VJ5V-08025AH-01	0.250	8.000	1.500	0.375	2.750	0.375	18	9	IXE412-001
3VJ5V-04031AG-01	0.312	4.000	1.250	0.375	1.870	0.312	10	5	IXE413-001
3VJ5V-05031AG-01	0.312	5.000	1.250	0.375	1.870	0.312	12	6	IXE413-001
3VJ5V-06031AG-01	0.312	6.000	1.250	0.375	1.870	0.312	14	7	IXE413-001
3VJ5V-08031AH-01	0.312	8.000	1.500	0.375	2.750	0.375	18	9	IXE413-001
3VJ5V-04037AG-01	0.375	4.000	1.250	0.345	1.870	0.312	10	5	IXE414-001
3VJ5V-06037AG-01	0.375	6.000	1.250	0.345	1.870	0.312	14	7	IXE414-001
3VJ5V-08037AH-01	0.375	8.000	1.500	0.345	2.750	0.375	18	9	IXE414-001

# THINoMAX™ INSERTS



Insert Number	Corner Configuration	Application	Grade	IN2505	IN2515	IN2530	IN4005	IN4030	IN4035	IN05S
IEE211-001	4 X .015" R	Multi-Purpose		X		X	X	X		X
IEE311-001	4 X .015" R	Multi-Purpose		X	X	X	X	X	X	X
IEE311-002	4 X .031" R	Multi-Purpose		X	X	X	X	X	X	X
IEE312-001	4 X .015" R	Multi-Purpose		X	X	X	X	X	X	X
IEE312-002	4 X .031" R	Multi-Purpose		X	X	X	X	X	X	X
IXE412-001	4 X .015" R	Multi-Purpose		X	X	X	X	X	X	X
IXE412-002	4 X .031" R	Multi-Purpose		X	X	X	X	X	X	X
IXE412-003	4 X .062" R	Multi-Purpose		X	X	X	X	X		
IXE413-001	4 X .015" R	Multi-Purpose		X	X	X	X	X	X	X
IXE413-002	4 X .031" R	Multi-Purpose		X	X	X	X	X	X	X
IXE413-003	4 X .062" R	Multi-Purpose		X	X	X	X	X		
IXE414-001	4 X .015" R	Multi-Purpose		X	X	X	X	X	X	X
IXE414-002	4 X .031" R	Multi-Purpose		X	X	X	X	X	X	X
IXE414-003	4 X .062" R	Multi-Purpose		X	X	X	X	X		

# THINoMAX™ HARDWARE

			
	Screw	Driver	
IEE211	SM25-025-80	DS-T06F	M2.5 X 6MM X 2.5MM
IEE311	SM35-034-50	DS-T09W	M3.5 X 6MM X 3.4MM
IEE312	SM35-042-50	DS-T09W	M3.5 X 6MM X 4.2MM
IXE412	SM40-055-50	DS-T15T	M4.0 X .7MM X 5.5MM
IXE413	SM40-070-50	DS-T15T	M4.0 X .7MM X 7.0MM
IXE414	SM40-080-50	DS-T15T	M4.0 X .7MM X 8.0MM



Material	Material Grade	Brinell Hardness	SFM	Feed per Insert WOC		IN2505	IN2515	IN2530	IN4005	IN055	IN4030	IN4035	Coolant
				.125"-.156"	.187"-.375"								
Aluminum	6062 T-6, 70705 T6	-	1500-1800	.004 - .008	.006 - .015					1			Yes
Cast Iron	Gray	150 - 250	400 - 750	.002 - .006	.004 - .010		1						No
	Nodular		300 - 650										
Steel	Low Carbon 1018, 8620	100 - 250	250 - 500	.002 - .006	.004 - .010	2			1		3		No
	High Carbon F-6180, Nitralloy 52100	250 - 400	250 - 350										
	Alloyed Steel 4140, 4340, 6150	150 - 300	250 - 400										
	Tool Steel A-6, D-1, D-2, P20	Up to 300	250 - 400										
Stainless Steel	300 Series, 304, 316	-	250 - 400	.002 - .006	.004 - .010			3			1	2	Yes
	400 Series 15-5 PH, 17-4 PH	Up to 320	300 - 600										
	13-8 PH	-	200 - 250										
Nickel Alloys	Inconel 600, 706, 718, 903, Hastelloy, Waspalloy	-	75-120	.002 - .006	.004 - .010			3			2	1	Yes
Titanium	6AL-4V	-	100 - 150	.002 - .006	.004 - .010			2	3		1		Yes

