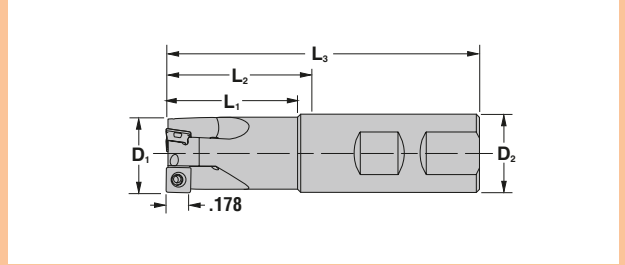


HIPOPOSQUAD[®] 90° LEAD END MILL SERIES 15J1C

Diameters .500" to 1.250"
Max. Depth of Cut .178"
Insert Corner .015"R



D_1 Effective Diameter	Cutter Number	L_1 Projection Length	L_2 Extension Length	L_3 Overall Length	D_2 Flange Diameter	Number of Inserts	Max Ramp Angle
.500	15J1C-05012S4R01	1.12	1.25	3.00	.500 Cyl	2	.5
.625	15J1C-06015S6R01	1.37	1.50	3.50	.625 Cyl	3	.5
.750	15J1C-0701784R01	1.62	1.75	3.75	.750 Weldon	4	3
.750	15J1C-07040S7R01	3.88	4.00	6.00	.750 Cyl	4	3
1.000	15J1C-1001780R01	1.56	1.75	4.00	1.00 Weldon	5	2
1.000	15J1C-1001784R01	1.75	1.75	3.75	.750 Weldon	5	2
1.000	15J1C-1002284R01	2.25	2.25	4.25	.750 Weldon	3	2
1.250	15J1C-1201780R01	1.75	1.75	4.00	1.00 Weldon	6	1.4
1.250	15J1C-1201784R01	1.75	1.75	3.75	.750 Weldon	6	1.4

HIPOPOSQUAD™ 90° LEAD TOPON END MILL SERIES 15J1C

Diameters
.500" to 1.250"

Max. Depth of Cut
.178"

Insert Corner
.015"R



Shoulder



Channeling



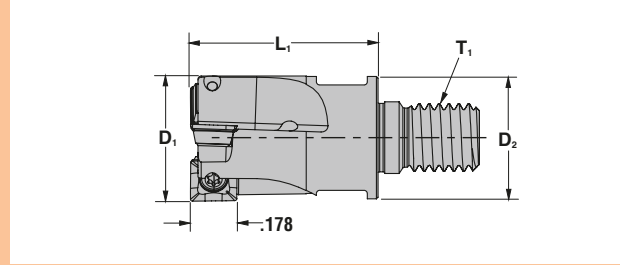
Facing



Ramping



Coolant Thru



D ₁ Nominal Diameter	Cutter Number	L ₁ Extension Length	D ₂ Neck Diameter	T ₁ Shank Size/Style	Number of Inserts	Wrench Size	Max Ramp Angle
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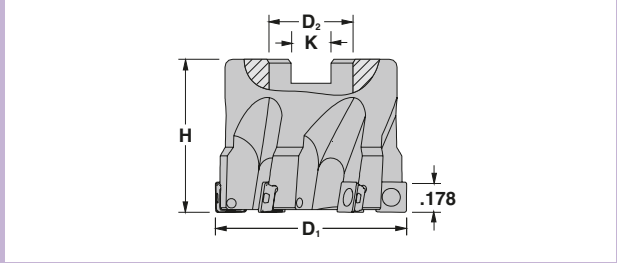
.500	15J1C-05010X4R01	1.00	0.46	M6	2	7mm	.5
.625	15J1C-06010X5R01	1.00	0.51	M8	3	10mm	.5
.750	15J1C-07015X6R01	1.50	0.71	M10	3	15mm	3
.750	15J1C-07015X6R02	1.50	0.71	M10	4	15mm	3
1.000	15J1C-10015X7R01	1.50	0.82	M12	5	17mm	2
1.250	15J1C-12017X8R01	1.75	1.14	M16	6	22mm	1.4

HI-POSQUAD™ 90° LEAD FACE MILL SERIES 5J5C

Diameters
1.500" to 2.000"

Max. Depth of Cut
.178"

Insert Corner
.015"R



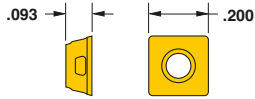
D ₁ Effective Diameter	Cutter Number	Number of Inserts	H Height	D ₂ Bore Diameter	Retention Bolt	K Keyway
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1.500	5J5C-15R01	8	1.57	0.75	SD06-46	0.31
2.000	5J5C-20R01	10	1.57	0.75	SD06-46	0.31

INSERTS



SHMT050204N



Insert
Number

Application

Corner

Grades

IN 2005 2030

SHMT050204N

Multi-Purpose

.015R

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HARDWARE

Insert Screw	Driver	Preset Torque Driver	Torx Bit
Part No.	Torque	Part No.	Part No.
SM20-043-00	5 in. lbs.	DS-TP06S (TxPlus-06)	DTN005S
			DS-TP06TB

OPERATING GUIDELINES

Series 15J1C, 5J5C		Brinell Hardness	SFM	Feed per Insert	Grades		Coolant
Material					IN2005	IN2030	
Aluminum	6061 T-6, 7075 T-6, 2024	-	1000-8000	.003-.008	1		Yes
Cast Iron	Gray	150-250	500-1200	.002-.004	1	2	No
	Nodular		400-800				
Steel	Low Carbon 1018-8620	150-250	600-1200	.002-.004	2	1	No
	High Carbon F-6180, Nitr alloy 52100	250-400	400-600				
	Alloyed Steel 4140, 4340, 6150	150-300	400-800				
	Tool Steel A-6, D-1, D-2, P-20	Up to 300					
Stainless Steel	300 Series, 304, 316	-	400-800	.002-.004	2	1	May not be required at high speeds
	400 Series 15-5 PH, 17-4 PH	Up to 320	500-1000				Yes
	13-8 PH	-	200-400				
Nickel Alloys	Inconel, Hastelloy, Waspalloy	-	75-120	.002-.003	2	1	Yes
Titanium	6AL-4V	-	80-150	.002-.003	1	2	Yes