

# TOP•ON™

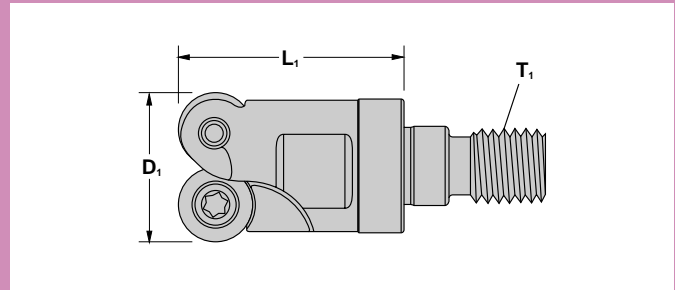
## NEW

## INCH CUTTER BODIES NOW AVAILABLE!!



**FORM•MASTER+** SERIES 15B1 (TOP•ON STYLE)

<b>Diameters</b> .750-1.500	<b>Cutting Edge Radius</b> 4, 5, 6, and 8mm	<b>Button I.C.</b> 8, 10, 12, and 16mm
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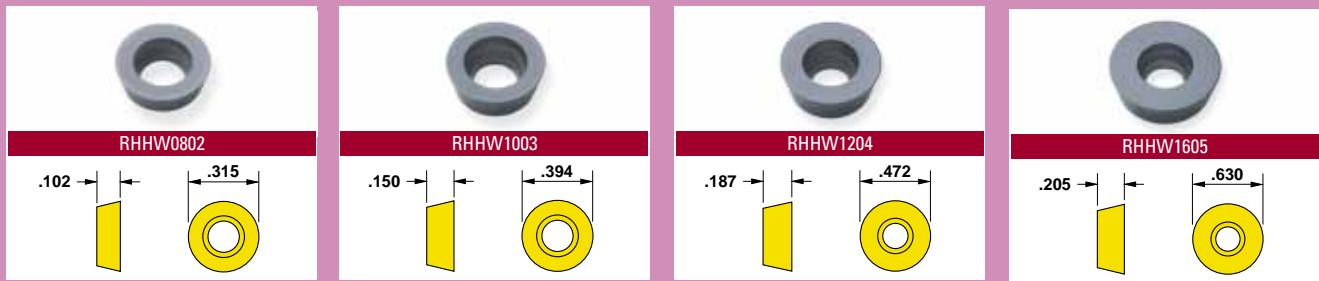


D <sub>1</sub> Nominal Diameter	T <sub>1</sub> Adaption	Cutter Number	Insert Inscribed Circle	L <sub>1</sub> Extension from Holder	Number of Inserts	Wrench Size
.750	M10	<b>15B1E-07512X6R01</b>	8mm	1.25	2	15mm
1.000	M12	<b>15B1H-10015X7R01</b>	12mm	1.50	2	17mm
1.000	M12	<b>15B1G-10012X7R01</b>	10mm	1.25	3	17mm
1.250	M16	<b>15B1K-12015X8R01</b>	16mm	1.50	2	22mm
1.250	M16	<b>15B1H-12015X8R01</b>	12mm	1.50	3	22mm
1.500	M16	<b>15B1G-15012X8R01</b>	10mm	1.25	5	22mm
1.500	M16	<b>15B1H-15015X8R01</b>	12mm	1.50	3	22mm

**Recommended Depth of Cut**

Insert Series	Recommended Depth of Cut
RHHW0802	.010-.040
RHHW1003	.010-.060
RHHW1204	.010-.080
RHHW1605	.010-.100

## INSERTS



Insert Number	Insert Inscribed Circle	Grades		
		IN	2004	2015
RHHW0802MOTN	8mm	■	■	■
RHHW1003MOTN	10mm	■	■	■
RHHW1204MOTN	12mm	■	■	■
RHHW1605MOTN	16mm	■	■	■

## HARDWARE

Insert Inscribed Circle	Insert Screw		Driver
	Part No.	Torque	
8mm	SM30-053-00	13-18 in. lbs.	DS-T09W (Tx-09)
10mm	SM40-080-10	30-35 in. lbs.	DS-T15T (Tx-15)
12mm	SM40-080-10	30-35 in. lbs.	DS-T15T (Tx-15)
16mm	SM50-100-10	35-40 in. lbs.	DS-T20T (Tx-20)

## TOP•ON Series 15B (15B)

Material	Brinell Hardness	SFM	Feed per Insert**	Grades*					Coolant		
				IN40P (235)	IN1530 (581)	IN1540 (588)	IN8330 (708)	IN2030 (831)		IN2040 (835)	
Aluminum	6061 T-6, 7075 T-6	-	1300-1950	.030-.047	1	2	3	4	Yes		
Cast Iron	Gray	150-250	590-720	.020-.039	1	2	3		No		
	Nodular		520-720								
Steel	Low Carbon 1018-8620	100-250	490-650	.020-.039	6	5	4	1	3	2	No
	High Carbon F-6180, Nitralloy 52100	250-400									
	Alloyed Steel 4140, 4340, 6150	150-300									
	Tool Steel A-6, D-1, D-2, P-20	Up to 300									
Stainless Steel	300 Series, 304, 316	-	490-590	.020-.039	2		3	1	4	May not be required at high speeds	
	400 Series 15-5 PH, 17-4 PH	Up to 320	200-600								
	13-8 PH	-	300-800								Yes
Nickel Alloys	Inconel 600, 706, 718, 903, Hastelloy, Waspalloy	-	75-120	.010-.015	1	3	4	2	Yes		
Titanium	6AL-4V	-	100-150	.010-.015	2	3	1		Yes		

\*In order of preference. \*\*Chip thinning factor applied to feed recommendation.