

QUAD PLUS FINISH



Ingersoll introduces...

The perfect blend of "performance and value" with a new product for Finish Milling iron at .040" or less. Performance is obtained with an engineered wedge adjustment system that precisely adjusts inserts within .0002". Further performance benefits come from new screw hole technology that allows conventionally mounted screw-held inserts in high density cutters. Value is afforded with inserts that boast 8 positive cutting edges!

FEATURES & BENEFITS

- FINE ADJUSTMENT TO MINIMIZE FACE RUNOUT AND HOLD TOLERANCE OF .0002"
- HIGH DENSITY CUTTER DESIGNS THAT ACCELERATE METAL REMOVAL RATES
- SCREW HELD INSERTS FOR SECURE MOUNTING
- QUAD INSERT ALLOWS FINISH MILLING UP TO 90 DEGREE SHOULDERS
- 8 CUTTING EDGES AFFORD GREAT VALUE
- SURFACE FINISHES AS GOOD AS 5 RA

■ QUAD⁺PLUS^{FINISH} 90° LEAD FACE MILL SERIES DJ1H

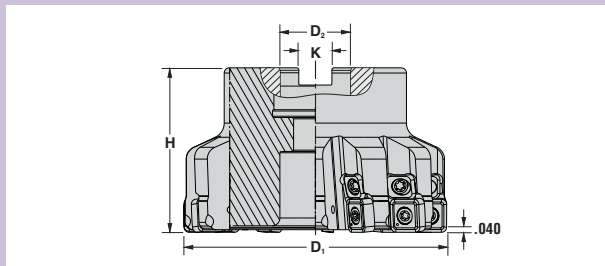
Diameters
4.000" to 8.000"
100mm to 125mm

Max. Depth of Cut
.040"

Insert Corner
.08"R
.04" x 45

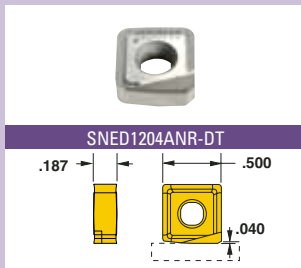
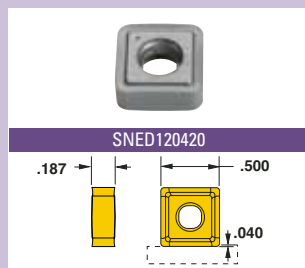


Facing



D ₁ Effective Diameter	Cutter Number	Number of Inserts	D ₂ Bore Diameter	K Keyway	H Height	Retention Bolt	Bolt Circle
4.000	DJ1H-40R01	12	1.250	0.50	2.482	SD10-47	-
6.000	DJ1H-60R01	20	1.500	0.62	2.482	-	-
8.000	DJ1H-80R01	24	2.500	1.00	2.482	-	4.00
Metric							
100 mm	DJ1H100R00	12	32 mm	14 mm	63 mm	SD10-89	-
125 mm	DJ1H125R00	16	40 mm	16 mm	63 mm	-	-

INSERTS



Insert Number	Application	Depth of Cut	Corner	Grades		
				IN	2010	80B
SNED120420	MultiPurpose	.040	0.080		■	
SNED1204ANR-DT	CBN	.040	.04 x 45			■

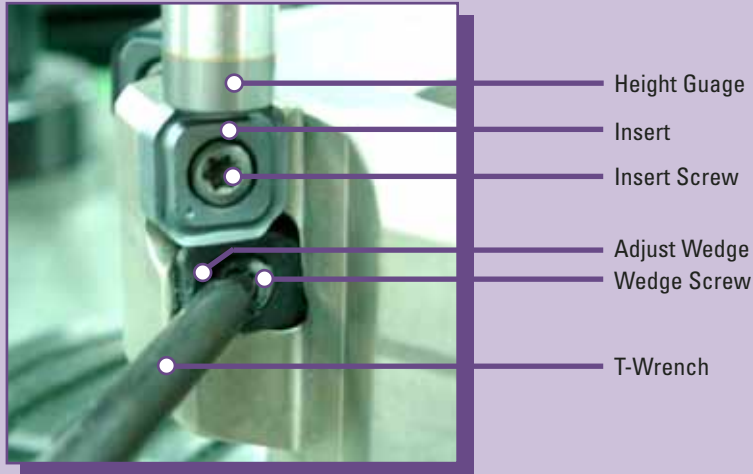
HARDWARE

Insert Screw	Wrench	Adjusting Wedge	Adjusting Screw
Part No.	Part No.	Part No.	Part No.
SM35-110-R0	DS-T15T (Tx-15)	2E-831-01	SB060-03

Optional Torque Driver	Bit for Optional Driver
Part No.	Part No.
DT-35-02	DS-T15B1

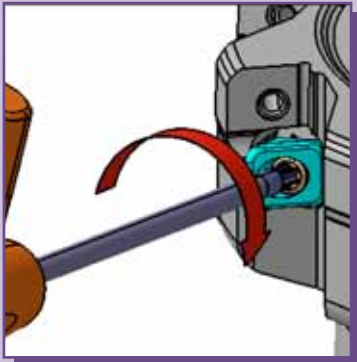
■ QUAD•PLUS^{FINISH} TERMS & SETUP

Terms for each part of the Quad•PlusFinish Facemill:



Setting up the Quad•PlusFinish Facemill:

1 Rotating the wedge screw clockwise, tighten the wedge to the utmost.



*Please note that you should tighten the wedge until it reaches the bottom of the pocket. Avoid using too much force.

2 Mount the insert.



*Tighten the insert screw completely (35in. lbs.)

3 Upon tightening of inserts, measure the cutter run-out, select the highest insert as a datum.



*Do not damage the insert edge on gauge setting.

Setting up the Quad•PlusFinish Facemill CONT.:

4 Set up the cutter height, raising one insert by turning the wedge screw counter-clockwise.



*Adjust 0.01mm (.0004") at least.

5 Adjust AXIAL RUNOUT of the remaining inserts the same way as the original insert.



*Note: The adjustable amount should not be over 0.1mm (.004").

*GAUGE user guide.



5.1 Adjust AXIAL RUNOUT by rotating the wrench gradually until it meets the 0.005mm (.0002") range.



5.2 When beyond the acceptable range. Please reset it with steps (1), (2), and (5).



6 RUNOUT adjustment is completed. (Do not clamp the insert screw any further once it is fixed.)

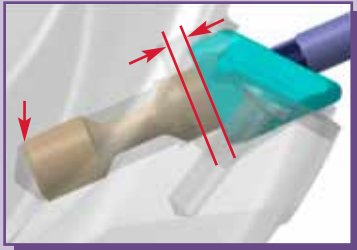


■ QUAD⁺PLUS^{FINISH} TERMS & SETUP CONT.

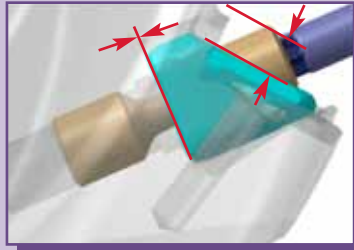
Note on Setting:

- When you change the insert corner, please start over from 1st step.
- You must remove dirt & debris on the surface of inserts or pockets before mounting inserts as this product requires high accuracy.
- When you reassemble the wedge after completely separating it, please put it together as in picture (3).

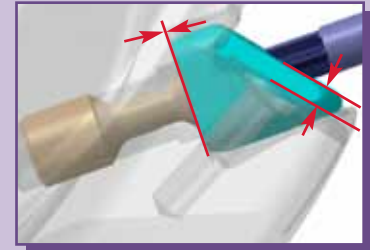
1 NO
Gap between wedge and pocket bottom with screw bottomed out.



2 NO
Wedge bottomed out with screw excessively sticking out of top of wedge.



3 YES
Wedge bottomed out and screw is below wedge.



■ OPERATING GUIDELINES

Series DJ1H		Brinell Hardness	SFM	Feed per Insert	Grades		Coolant
Material					IN2010	IN800B	
Cast Iron	Gray	150-250	300-1000	.006-.012	1		No
			1800 +	.005-.008		1	No
	Nodular	150-250	300-600	.005-.011	1		No
			1500 +	.004-.007		1	No