



Diameters:
1.00" - 8.00"

Cutter Series:
1TJ1Q, TJ*Q,
1TJ1N, TJ*N, TN1N

Insert Series:
ANHU12
ANHU16
ZNHU16

Materials:
Aluminum, Iron, Steel, Stainless
Steel, High-Temp Alloys

Depth of Cut:
ANHU12: .43
ANHU16: .59



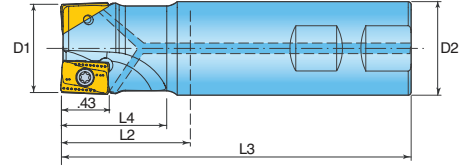
Double your APKT style geometry from 2 to 4 cutting edges!

- Two Sided Insert Adds Value by Doubling You Cutting Edges!
- Thick and Robust Insert Adds Durability to Demanding Cutting Conditions
- Double Positive Geometry Benefits Machining Efficiency and Slices Super Alloy Materials
- Integrated Wiper Flat Produces Surface Finishes As Good As 32Ra
- Coolant Through the Tool Offered
- R.015, .031 and .062 Corner Radii Offered



DIPOSOTETRA™ SERIES 1TJ1Q (12MM)

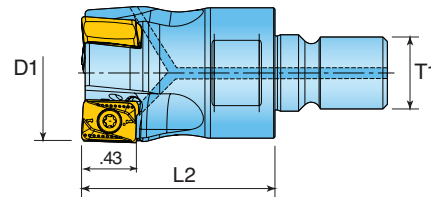
90 DEGREE LEAD ENDMILL WITH 4 INDEXES



Cutter Number	D1 Effective Diameter	L2 Extension Length	L3 Overall Length	L4 Projection Length	D2 Shank Size/Style	# of Inserts	Ramp Angle
1TJ1Q-1001784R01	1.000	1.75	3.75	1.75	.750 W	2	1.4
1TJ1Q-1001780R01	1.000	1.75	4.00	1.55	1.00 W	2	1.4
1TJ1Q-1003780R01	1.000	3.75	6.00	3.55	1.00 W	2	1.4
1TJ1Q-1201784R01	1.250	1.75	3.75	1.75	.750 W	3	1.0
1TJ1Q-1202281R01	1.250	2.25	4.50	2.22	1.25 W	3	1.0
1TJ1Q-1204281R01	1.250	4.25	6.50	4.22	1.25 W	3	1.0
1TJ1Q-1502281R01	1.500	2.25	4.50	2.25	1.25 W	4	0.7
1TJ1Q-2002281R01	2.000	2.25	4.50	2.22	1.25 W	5	0.6

DIPOSOTETRA™ SERIES 1TJ1Q (TOP•ON STYLE) (12MM)

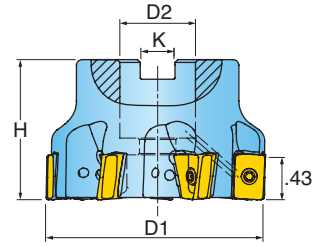
90 DEGREE LEAD ENDMILL WITH 4 INDEXES



Cutter Number	D1 Effective Diameter	T1 Adaption	L2 Extension Length	Number of Inserts	Wrench Size	Ramp Angle
1TJ1Q-10015X7R01	1.000	M12	1.50	2	17mm	1.4
1TJ1Q-12017X8R01	1.250	M16	1.75	3	22mm	1.0
1TJ1Q-15017X8R01	1.500	M16	1.75	4	22mm	0.7

DIPOSOTETRA™ SERIES TJ5Q, TJ6Q (12MM)

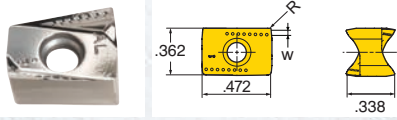
90 DEGREE LEAD FACEMILL WITH 4 INDEXES



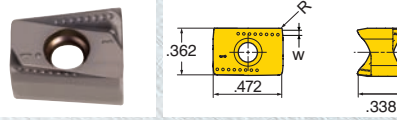
Cutter Number	D1 Effective Diameter	# of Inserts	H Height	D2 Bore Diameter	K Keyway	Ramp Angle
TJ5Q-20R01	2.000	6	1.570	0.75	0.31	0.6
TJ6Q-20R01	2.000	3	1.570	0.75	0.31	0.6
TJ6Q-25R01	2.500	6	1.570	0.75	0.31	0.4
TJ5Q-30R01	3.000	9	1.750	1.00	0.38	0.3
TJ6Q-30R01	3.000	7	1.750	1.00	0.38	0.3
TJ5Q-40R01	4.000	11	2.375	1.50	0.62	0.2
TJ6Q-40R01	4.000	7	2.375	1.50	0.62	0.2

DIPOSOTETRA™ INSERTS (12MM)

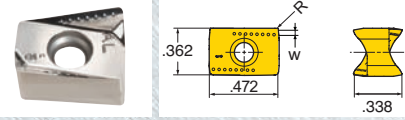
ANHU120604FR-P



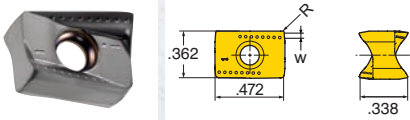
ANHU120604R



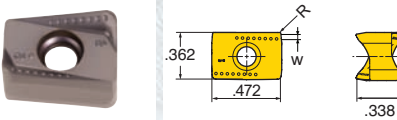
ANHU120608FR-P



ANHU120608R










ANHU120616R



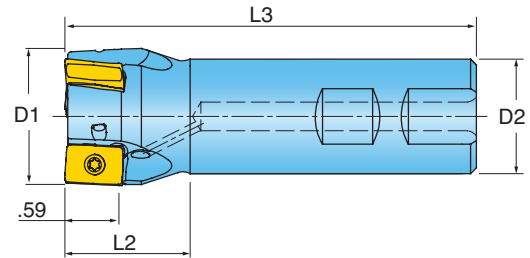
Part Number	Application	R Corner	w Wiper	Grade	IN10K	IN2505	IN2510	IN2530	IN2540	IN4030	IN4035
ANHU120604R	Multi-Purpose	.015" R	0.060			•					
ANHU120608R	Multi-Purpose	.031" R	0.043			•	•	•	•	•	
ANHU120616R	Multi-Purpose	.062" R	0.028			•	•				
ANHU120604FR-P	Ground/Polished for Alum.	.015" R	0.060		•						
ANHU120608FR-P	Ground/Polished for Alum.	.031" R	0.047		•						
ANHU120608FR	Hi Temp/Ti	.031" R	0.043								•

DIPOSOTETRA™ HARDWARE (12MM)

Cutter Number							
	Insert Screw	Driver Handle	Driver Blade	Retention Bolt	Optional Torque Driver Handle	Optional Torque Driver Bit	Optional Coolant Bolt
TJ5Q-20R01	SM35-088-10	DS-A00T	DS-T106B	SD-06-46	DT-28-01	DS-T10B	SD-06-89
TJ6Q-20R01	SM35-088-10	DS-A00T	DS-T106B	SD-06-46	DT-28-01	DS-T10B	SD-06-89
TJ6Q-25R01	SM35-088-10	DS-A00T	DS-T106B	SD-06-46	DT-28-01	DS-T10B	SD-06-89
TJ5Q-30R01	SM35-088-10	DS-A00T	DS-T106B	SD-08-46	DT-28-01	DS-T10B	SD-08-92
TJ6Q-30R01	SM35-088-10	DS-A00T	DS-T106B	SD-08-46	DT-28-01	DS-T10B	SD-08-92
TJ5Q-40R01	SM35-088-10	DS-A00T	DS-T106B	SD-12-82	DT-28-01	DS-T10B	SD-12-99
TJ6Q-40R01	SM35-088-10	DS-A00T	DS-T106B	SD-12-82	DT-28-01	DS-T10B	SD-12-99

DIPOSOTETRA™ SERIES 1TJ1N (16MM)

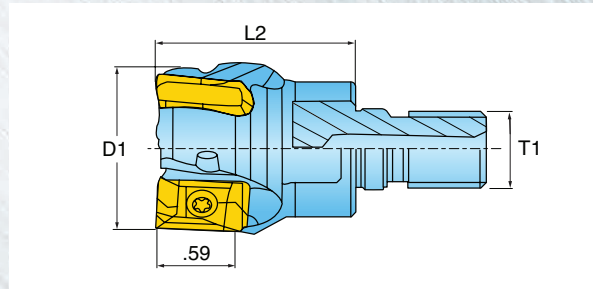
90 DEGREE LEAD ENDMILL WITH 4 INDEXES



Cutter Number	D1 Nominal Diameter	L2 Extension Length	L3 Overall Length	D2 Shank Size/Style	Number of Inserts	Ramp Angle
1TJ1N-1202281R01	1.250	2.25	4.50	1.250" Weldon	2	1.2
1TJ1N-1204281R01	1.250	4.25	6.50	1.250" Weldon	2	1.2
1TJ1N-1206281R01	1.250	6.25	8.50	1.250" Weldon	2	1.2
1TJ1N-1502281R01	1.500	2.25	4.50	1.250" Weldon	3	1.1
1TJ1N-1504281R01	1.500	4.25	6.50	1.250" Weldon	3	1.1
1TJ1N-2002281R01	2.000	2.25	4.50	1.250" Weldon	4	1.0

DIPOSOTETRA™ SERIES 1TJ1N (TOP-ON STYLE) (16MM)

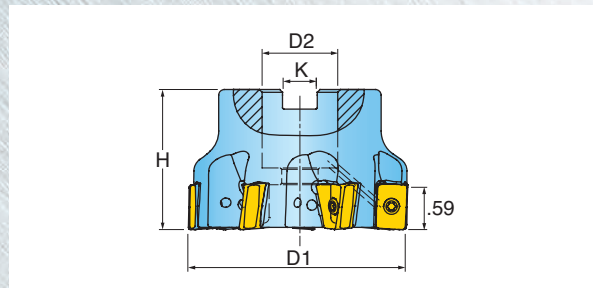
90 DEGREE LEAD ENDMILL WITH 4 INDEXES



Cutter Number	D1 Nom. Dia.	T1 Adaption	L2 Extension Length	Number of Inserts	Wrench Size	Ramp Angle
1TJ1N-12015X8R01	1.250	M16	1.50	2	22mm	1.2
1TJ1N-15015X8R01	1.500	M16	1.50	3	22mm	1.1

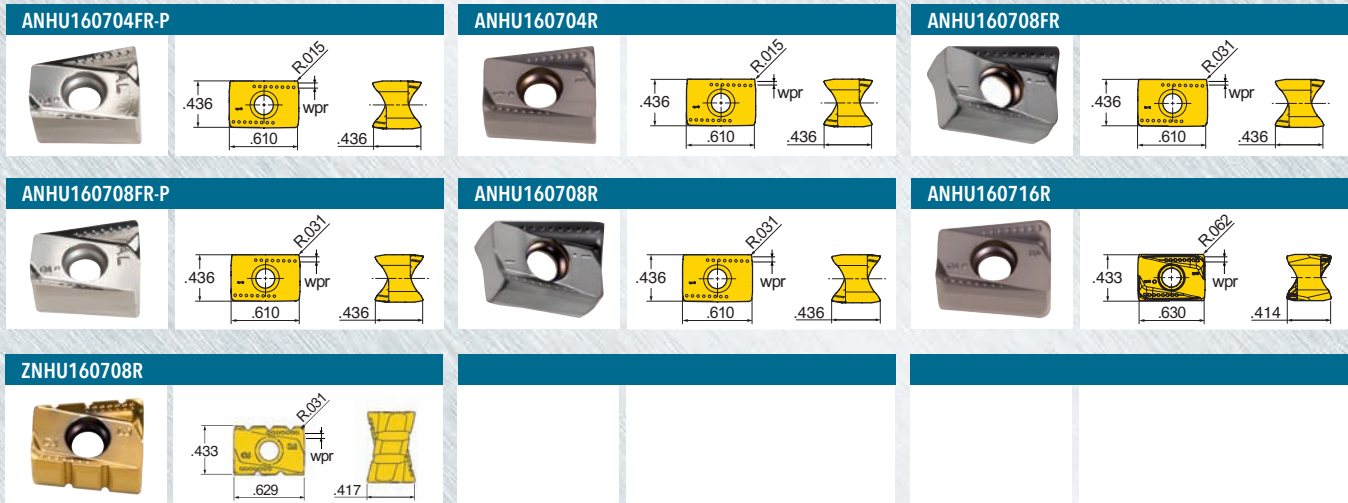
DIPOSOTETRA™ SERIES TJ5N, TJ6N (16MM)

90 DEGREE LEAD FACEMILL WITH 4 INDEXES



Cutter Number	D1 Nominal Diameter	Number of Inserts	H Height	D2 Bore Dia.	K Keyway	Bolt Circle Diameter	Coolant	Ramp Angle
TJ5N-20R01	2.000	4	1.570	0.750	0.312	NA	Yes	1.0
TJ6N-20R01	2.000	3	1.570	0.750	0.312	NA	Yes	1.0
TJ5N-25R01	2.500	5	1.750	1.000	0.375	NA	Yes	.60
TJ5N-30R01	3.000	7	1.750	1.000	0.375	NA	Yes	.50
TJ6N-30R01	3.000	5	1.750	1.000	0.375	NA	Yes	.50
TJ5N-40R01	4.000	8	2.375	1.500	0.625	NA	Yes	.35
TJ6N-40R01	4.000	5	2.375	1.500	0.625	NA	Yes	.35
TJ5N-50R01	5.000	10	2.375	1.500	0.625	NA	Yes	.25
TJ6N-50R01	5.000	7	2.375	1.500	0.625	NA	Yes	.25
TJ5N-60R01	6.000	11	2.480	1.500	0.625	NA	Yes	.15
TJ6N-60R01	6.000	8	2.480	1.500	0.625	NA	Yes	.15
TJ5N-80R01	8.000	14	2.480	2.500	1.000	4.00	-	.05

DIPOSOTETRA™ INSERTS (16MM)



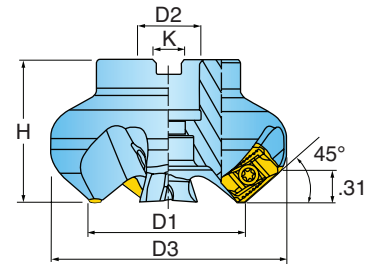
Part Number	Applications	Corner	Grade	IN10K	IN2505	IN2510	IN2530	IN2540	IN6515	IN4035	IN4030
ANHU160704FR-P	Ground/Polished for Alum.	0.015" R		•							
ANHU160704R	Multi-Purpose	0.015" R					•				
ANHU160708FR	Hi-Temp/Ti	0.031" R					•			•	
ANHU160708FR-P	Ground/Polished for Alum.	0.031" R		•							
ANHU160708R	Multi-Purpose	0.031" R			•	•	•	•	•		•
ANHU160716R	Multi-Purpose	0.062" R			•	•	•	•			
ZNHU160708R	Chip Splitters	0.031" R			•		•				

DIPOSOTETRA™ HARDWARE (16MM)

Cutter Number	Insert Screw	Driver Handle	Driver Blade	Retention Bolt	Optional Torque Driver Handle	Optional Torque Driver Bit	Optional Coolant Bolt
1TJ1N	SM40-120-20	DS-A00T	DS-T156B	-	DT-35-02	DS-T15B1	-
TJ5N-20R01	SM40-120-20	DS-A00T	DS-T156B	SD-06-46	DT-35-02	DS-T15B1	SD-06-89
TJ6N-20R01	SM40-120-20	DS-A00T	DS-T156B	SD-06-46	DT-35-02	DS-T15B1	SD-06-89
TJ5N-25R01	SM40-120-20	DS-A00T	DS-T156B	SD-08-46	DT-35-02	DS-T15B1	SD-08-92
TJ5N-30R01	SM40-120-20	DS-A00T	DS-T156B	SD-08-46	DT-35-02	DS-T15B1	SD-08-92
TJ6N-30R01	SM40-120-20	DS-A00T	DS-T156B	SD-08-46	DT-35-02	DS-T15B1	SD-08-92
TJ5N-40R01	SM40-120-20	DS-A00T	DS-T156B	SD-12-82	DT-35-02	DS-T15B1	SD-12-99
TJ6N-40R01	SM40-120-20	DS-A00T	DS-T156B	SD-12-82	DT-35-02	DS-T15B1	SD-12-99
TJ5N-50R01	SM40-120-20	DS-A00T	DS-T156B	SD-12-82	DT-35-02	DS-T15B1	SD-12-99
TJ6N-50R01	SM40-120-20	DS-A00T	DS-T156B	SD-12-82	DT-35-02	DS-T15B1	SD-12-99
TJ5N-60R01	SM40-120-20	DS-A00T	DS-T156B	SD-12-82	DT-35-02	DS-T15B1	SD-12-99
TJ6N-60R01	SM40-120-20	DS-A00T	DS-T156B	SD-12-82	DT-35-02	DS-T15B1	SD-12-99
TJ5N-80R01	SM40-120-20	DS-A00T	DS-T156B	-	DT-35-02	DS-T15B1	-

DIPOSOTETRA™ SERIES TN1N (16MM)

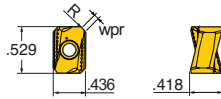
45 DEGREE LEAD FACEMILL WITH 4 INDEXES



Cutter Number	D1 Nominal Diameter	D3 Overall Diameter	Number of Inserts	D2 Bore Dia.	H Height	K Keyway
TN1N-20R01	2.000	2.68	4	0.750	1.750	0.312
TN1N-30R01	3.000	3.68	5	1.000	1.750	0.375
TN1N-30R02	3.000	3.68	7	1.000	1.750	0.375
TN1N-40R01	4.000	4.67	6	1.500	2.375	0.625
TN1N-40R02	4.000	4.67	8	1.500	2.375	0.625

DIPOSOTETRA™ INSERTS (16MM)

ANHU1607ANR



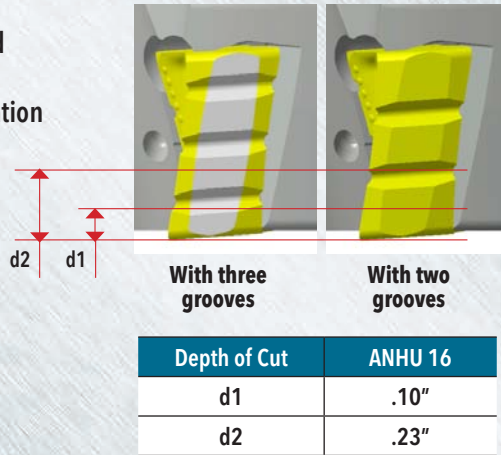
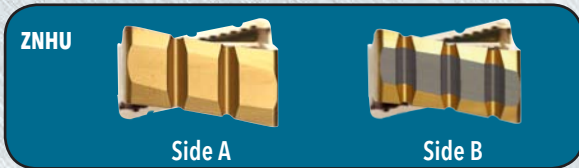
Part Number	Applications	Wiper	R Corner	Grade	IN2510	IN2530	IN2540
ANHU1607ANR	Multi-Purpose	.062	0.015" R		•	•	•

DIPOSOTETRA™ HARDWARE

Cutter Number	Insert Screw	Driver Handle	Driver Blade	Retention Bolt	Optional Torque Driver Handle	Optional Torque Driver Bit	Optional Coolant Bolt
TN1N-20R01	SM40-120-20	DS-A00T	DS-T156B	SD-06-46	DT-35-02	DS-T15B1	SD-06-89
TN1N-30R01	SM40-120-20	DS-A00T	DS-T156B	SD-08-46	DT-35-02	DS-T15B1	SD-08-92
TN1N-30R02	SM40-120-20	DS-A00T	DS-T156B	SD-08-46	DT-35-02	DS-T15B1	SD-08-92
TN1N-40R01	SM40-120-20	DS-A00T	DS-T156B	SD-12-82	DT-35-02	DS-T15B1	SD-12-99
TN1N-40R02	SM40-120-20	DS-A00T	DS-T156B	SD-12-82	DT-35-02	DS-T15B1	SD-12-99

CHIPSPLITTER INFORMATION

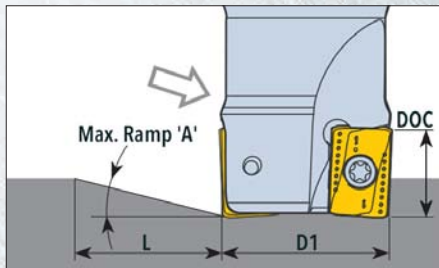
- Reduces vibration and noise
- Improves chip evacuation (Chips split into small pieces)
- Reduces heat generation
- Suitable for long overhang machining (weak machining and fixture applications)
- Mountable on all standard cutter lines without any modification



Depth of Cut	ANHU 16
d1	.10"
d2	.23"

STRAIGHT RAMPING DATA - 1TJ1N, TJ5N, TJ6N (16MM)

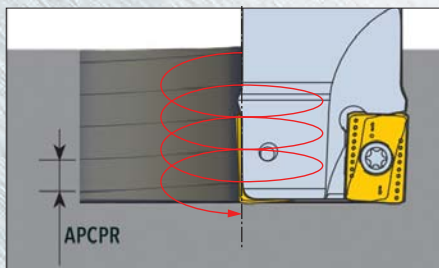
Straight ramping



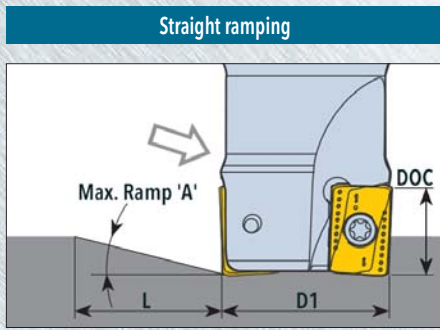
Cutter Diameter	A Ramping Angle	L	DOC
1.25	1.20	28	0.59
1.50	1.10	31	0.59
2.00	1.00	34	0.59
2.50	0.60	56	0.59
3.00	0.50	68	0.59
4.00	0.35	97	0.59
5.00	0.25	135	0.59
6.00	0.15	226	0.59
8.00	0.05	677	0.59

HELICAL RAMPING DATA - 1TJ1N, TJ5N, TJ6N (16MM)

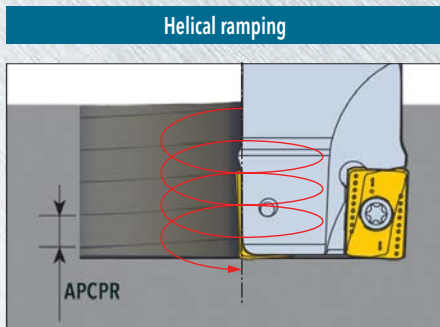
Helical ramping



Cutter Dia. (D1) Using R.031 Insert	MIN. Diameter Milled Hole	MIN. Advance Per Cutter Path Rev. (APCPR)	MAX. Diameter Milled Hole	MAX. Advance Per Cutter Path Rev. (APCPR)
1.25	1.75	0.024	2.44	0.071
1.50	2.40	0.039	2.94	0.079
2.00	3.25	0.055	3.94	0.091
2.50	4.25	0.047	4.94	0.071
3.00	5.50	0.055	5.94	0.075
4.00	7.25	0.051	7.94	0.063
5.00	9.10	0.047	9.94	0.059
6.00	11.85	0.039	11.94	0.043
8.00	15.00	0.016	15.94	0.020



Cutter Diameter	A Ramping Angle	L	DOC
1.00	1.4	17	0.43
1.25	1.0	25	0.43
1.50	0.7	31	0.43
2.00	0.6	41	0.43
2.50	0.4	62	0.43
3.00	0.3	82	0.43
4.00	0.2	124	0.43



Cutter Dia. (D1) Using R.031 Insert	MIN. Diameter Milled Hole	MIN. Advance Per Cutter Path Rev. (APCPR)	MAX. Diameter Milled Hole	MAX. Advance Per Cutter Path Rev. (APCPR)
1.00	1.25	0.01	2.00	0.06
1.25	1.75	0.02	2.50	0.06
1.50	2.25	0.02	3.00	0.06
2.00	3.25	0.03	4.00	0.05
2.50	4.25	0.03	5.00	0.04
3.00	5.25	0.03	6.00	0.04
4.00	7.25	0.03	8.00	0.04

DiPos TETRA - Series 1TJ1Q, TJ5Q, TJ6Q, 1TJ1N, TJ5N, TJ6N, TN1N					IN10K	IN2505	IN2510	IN2530/IN4030	IN2540	IN4035	IN6515	Coolant
Material	Brinnell Hardness	SFM	Feed per Insert									
Aluminum	6061-T6, 7075-T6, 2024	-	1500 - 8000	.004 - .010	1							Yes
Cast Iron	Gray	150 - 250	300 - 1000	.004 - .009		3	1				2	No
	Nodular		300 - 600			3	2			1		
Steel	Low Carbon 1018, 8620	150 - 250	400 - 1000	.004 - .009	2			1	3			No
	High Carbon F-6180, NitrAlloy 52100	250 - 400	350 - 500	.004 - .007								
	Alloyed Steel 4140, 4340, 6150	150 - 300	300 - 700	.004 - .009								
Tool Steel A-6, D-1, D-2, P20	Up to 300											
Stainless Steel	300 Series, 304, 316	-	300 - 550	.004 - .009		3		2	4	1		May not be required at high speeds
	400 Series 15-5 PH, 17-4 PH	Up to 320	350 - 600									Yes
	13-8 PH	-	200 - 400									
Nickel Alloys	Inconel 600, 706, 718, 903, Hastelloy, Waspalloy	-	75-120	.003 - .006	2		3		1		Yes	
Titanium	6AL-4V	-	100 - 150	.004 - .008	3		2		1		Yes	