



Diameters:
2.00" - 6.00"

Depth of Cut:
.235" - .355"

Insert Style:
SNGU12
SNGQ12

Insert Grades:

IN2035
IN2505
IN2510
IN2530
IN2540
IN4015
IN4030
IN10K
IN71N

NEW

Materials:

Stainless Steel, Hi-temp Alloys,
Aluminum, Iron, Steel



45° & 75° Lead Face Mills with 8 Positive Cutting Edges

Two-Sided Technology is incorporated into ISO Quad inserts for an Ingersoll Exclusive product named ISO-Plus. Users benefit by doubling their cutting edges from 4 to 8 while also taking advantage of clean shearing pressed rake face performance for ideal machining efficiency.

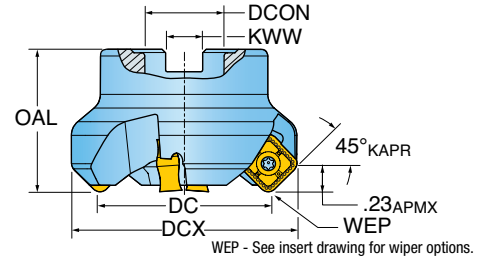
Features & Benefits

- New IN71N (SiNi) grade added for high-speed iron applications
- Thick and robust insert adds durability to demanding cutting conditions
- Strong corner configuration for heavy duty roughing
- .050" wiper flat for 32-63 Ra surface finishes
- Add 1 wiper in 1 station for finish as good as 8 Ra
- Same insert fits both 45° & 75° lead cutter

**PRODUCT
ANNOUNCEMENT
• UPDATE •
2018**

SERIES DN6H/DN5H

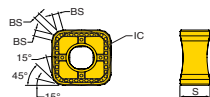
45° FACE MILL WITH 8 CUTTING EDGES



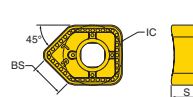
Part Number	DC Cutting Diameter	DCX Cutting Dia. Max.	OAL Overall Length	ZEFF Effective Teeth	DCON Bore Diameter	KWW Keyway	CSP Coolant
DN6H-20R01	2.000	2.57	1.750	4	.750	.312	Yes
DN5H-20R01	2.000	2.57	1.750	6	.750	.312	Yes
DN6H-25R01	2.500	3.07	1.750	6	1.000	.375	Yes
DN6H-30R01	3.000	3.57	1.750	7	1.000	.375	Yes
DN5H-30R01	3.000	3.57	1.750	10	1.000	.375	Yes
DN6H-40R01	4.000	4.57	2.375	8	1.500	.625	Yes
DN5H-40R01	4.000	4.57	2.375	12	1.500	.625	Yes
DN6H-50R01	5.000	5.57	2.375	9	1.500	.625	Yes
DN6H-60R01	6.000	6.57	2.000	12	1.500	.625	No
DN5H-60R01	6.000	6.57	2.000	20	1.500	.625	No

SERIES DN6H/DN5H INSERTS

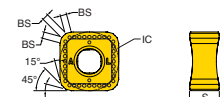
SNGU12



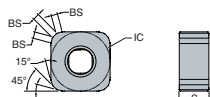
SNGS12-W



SNGU12-P



SNGQ12



Part Number	Application	BS Wiper Length	IC Inscribed Cir. Dia.	S Thickness	NOI Number of Indexes	IH Insert Hand	Grade	IN2035	IN2505	IN2510	IN2530	IN2540	IN4030	IN4015	IN10K	IN71N
SNGU1205ENN	Multi-Purpose	0.040	0.500	0.250	8	Neutral		•	•	•	•	•	•	•		
SNGS1205ANN-W	Wiper	0.275	0.500	0.250	2	Neutral			•	•						
SNGU1205EFN-P	Grd/Pol for Al	0.040	0.500	0.250	8	Neutral									•	
SNGQ1205ENN	Multi-Purpose	0.040	0.500	0.251	8	Neutral										•

** Faceted corner simulates R.093.

SERIES DN6H/DN5H CUTTER BODY HARDWARE

Part Number		
	SHCS	Coolant Through SHCS (opt)
DN6H-20R01	SD-06-46	SD-06-89
DN5H-20R01	SD-06-46	SD-06-89
DN6H-25R01	SD-08-46	SD-08-92
DN6H-30R01	SD-08-46	SD-08-92
DN5H-30R01	SD-08-46	SD-08-92
DN6H-40R01	SD-12-82	SD-12-99
DN5H-40R01	SD-12-82	SD-12-99
DN6H-50R01	SD-12-82	SD-12-99

SERIES DN6H/DN5H INSERT HARDWARE

Part Number	Substrate				Recommended Torque
		Insert Screw	Driver Handle	Insert Driver Blade	
SNGU1205ENN	Carbide	SM40-100-R0	DS-A00T	DS-T156B	30-35 in. lbs.
SNGS1205ANN-W	Carbide	SM40-100-R0	DS-A00T	DS-T156B	30-35 in. lbs.
SNGU1205EFN-P	Carbide	SM40-100-R0	DS-A00T	DS-T156B	30-35 in. lbs.
SNGQ1205ENN	SiNi	SM40-100-R0	DS-A00T	DS-T156B	28 in. lbs.

SERIES DL6H CUTTER BODY HARDWARE

Part Number		
	SHCS	Coolant Through SHCS (opt)
DL6H-20R01	SD-06-46	SD-06-89
DL6H-25R01	SD-08-46	SD-08-92

SERIES DL6H INSERT HARDWARE

Part Number	Substrate				Recommended Torque
		Insert Screw	Driver Handle	Insert Driver Blade	
SNGU1205ENN	Carbide	SM40-100-R0	DS-A00T	DS-T156B	30-35 in. lbs.
SNGU1205EFN-P	Carbide	SM40-100-R0	DS-A00T	DS-T156B	30-35 in. lbs.
SNGQ1205ENN	SiNi	SM40-100-R0	DS-A00T	DS-T156B	28 in. lbs.

OPERATING GUIDELINES

Material	Brinell Hardness	SFM	Feed per Insert (inch)	Grade									Coolant
				IN10K	IN2035	IN2505	IN2510	IN2530	IN2540	IN4015	IN4030	IN71N	
Aluminum	7075-T6, 6061-T6, 2024	-	1,000 - 8,000	.004 - .015	1								Yes
Cast Iron	Gray	150 - 250	400 - 1,000	.006 - .015			3	1			2	4	No
			1800 - 3000	.005 - .008								1	
	Nodular	150 - 250	400 - 800	.005 - .012			3	2			1	4	
			1500 - 2500	.004 - .007								1	
Steel	Low Carbon 1018, 8620	100 - 250	400 - 1000	.006 - .015									No
	High Carbon F-6180	250 - 400	350 - 650										
	Alloyed Steel 4140, 4340	150 - 300	300 - 700				3		2	4		1	
	Tool Steel A-6, D-1, D-2	Up to 300	300 - 600										
Stainless Steel	300 Series, 304, 316	-	300 - 700	.005 - .010									May not be required at high speeds
	400 Series 15-5 PH	Up to 320	400 - 700		1	4		3	5		2		
	13-8 PH	-	200 - 400										Yes
Nickel Alloys	Inconel, Hastelloy, Waspalloy	-	75-120	.003 - .006	1	3		4			2		Yes
Titanium	6AL-4V	-	100 - 150	.004 - .008	1	4		3			2		Yes