ISO PLUS

Quad 85° & 90° – The Power of 8!

Diameters:
- 2.00" – 8.00"

Depth of Cut:
- .24" DOC & 90° shoulder
- .50" max DOC with slight taper

Insert Styles:
- SNGU13

Insert Grades:
- IN2505
- IN2510
- IN2530
- IN2540
- IN4030
- IN6515
- IN71N
- IN4015

Materials:
- Stainless Steel
- Hi-temp Alloys
- Iron
- Steel

UPDATE •2015•

Two-Sided Technology is incorporated to the 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 include:

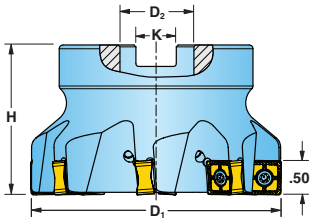
- *90° face mill for roughing and finishing*
- *85° face mill for roughing with less face contact*
- *8 positive cutting edges*
- *.50" max depth of cut, .24" depth of cut along shoulder*
- *Medium and high density cutter offerings*
- *2.00 – 8.00" diameter range*
- *Cutters equipped with coolant through*

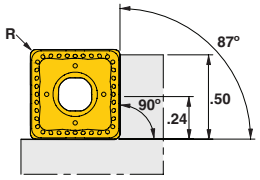
Member IMC Group
Ingersoll Cutting Tools

ISOPLUS SERIES DJ6T/DJ5T

90° QUAD ROUGHING & FINISHING FACE MILL

Facing | Shoulder | Channeling | Coolant



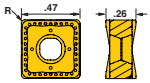


Cutter Number	D1 Nominal Diameter	D3 Overall Diameter	D2 Bore Size	K Keyway	H Height	No. of Inserts	Coolant Thru	Bolt Circle	SHCS	SHCS w/Coolant Thru*
Medium Density										
DJ6T-20R01	2.000	2.025	0.75	0.31	1.570	5	Yes	–	SD-06-46	SD-06-89
DJ6T-25R01	2.500	2.523	0.75	0.31	1.570	6	Yes	–	SD-06-46	SD-06-89
DJ6T-30R01	3.000	3.021	1.00	0.37	1.750	7	Yes	–	SD-08-46	SD-08-92
DJ6T-40R01	4.000	4.020	1.50	0.62	2.375	8	Yes	–	SD-12-82	SD-12-99
DJ6T-50R01	5.000	5.018	1.50	0.62	2.375	10	Yes	–	SD-12-82	SD-12-99
DJ6T-60R01	6.500	6.018	1.50	0.62	2.375	12	No	–	–	–
DJ6T-80R01	8.000	8.016	2.50	1.00	2.375	14	No	4.00	–	–
High Density										
DJ5T-30R01	3.000	3.021	1.00	0.37	1.750	8	Yes	–	SD-08-46	SD-06-89
DJ5T-40R01	4.000	4.020	1.50	0.62	2.375	10	Yes	–	SD-12-82	SD-12-99
DJ5T-50R01	5.000	5.018	1.50	0.62	2.375	13	Yes	–	SD-12-82	SD-12-99
DJ5T-60R01	6.000	6.018	1.50	0.62	2.375	17	No	–	–	–
DJ5T-80R01	8.000	8.016	2.50	1.00	2.375	21	No	4.00	–	–

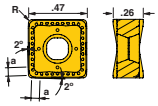
* Order separately.
Insert screw torque for carbide inserts: 30-35 in/lbs. Insert screw torque for SiNi (IN71N): 28 in/lbs.

ISOPLUS SERIES DJ6T/DJ5T INSERTS

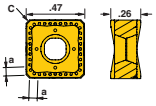
SNGU...N (Only corner)



SNGU...TN (Wiper w/R)



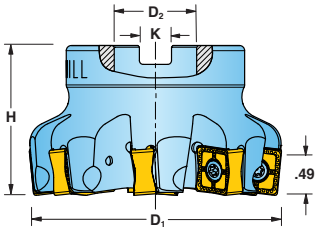
SNGU...ANTN (Wiper w/chamfer)

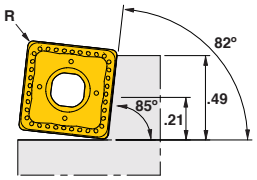


Insert Number	Application	Corner	a	Grade							
				IN2510	IN2530	IN2505	IN2540	IN6515	IN7IN (SiNi)	IN4030	IN4015
SNGU130604N	Positive Geometry	.015R	–	•	•	•			•		
SNGU130608N	Positive Geometry	.031R	–	•		•		•	•		
SNGU130608TN	Positive Geometry	.031R w/wiper	.047	•	•	•	•	•		•	•
SNGU130612N	Positive Geometry	.047R	-	•							
SNGU130616N	Positive Geometry	.062R	–		•	•	•	•	•		
SNGU1306ANTN	Positive Geometry	45 x .031 w/wiper	.047	•		•		•			•

ISOPLUS SERIES DL6T/DL5T

85° QUAD ROUGHING FACE MILL



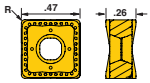


Cutter Number	D1 Nominal Diameter	D3 Overall Diameter	D2 Bore Size	K Keyway	H Height	No. of Inserts	SHCS
DL6T-20R01	2.000	2.025	0.750	0.312	1.570	5	SD-06-46
DL6T-25R01	2.500	2.523	0.750	0.312	1.570	6	SD-06-46
DL5T-30R01	3.000	3.021	1.000	0.375	1.750	8	SD-08-46
DL5T-40R01	4.000	4.020	1.500	0.625	2.375	10	SD-12-82
DL5T-50R01	5.000	5.018	1.500	0.625	2.375	13	SD-12-82
DL5T-60R01	6.000	6.018	1.500	0.625	2.375	17	–

* Order separately.
Insert screw torque for carbide inserts: 30-35 in/lbs. Insert screw torque for SiNi (IN71N): 28 in/lbs.

ISOPLUS SERIES DL6T/DL5T INSERTS

SNGU...N (Only corner)



Insert Number	Application	Corner	Grade						
			IN2510	IN2530	IN2505	IN2540	IN6515	IN7IN (SiNi)	IN4015
SNGU130604N	Positive Geometry	.015R	•	•	•			•	
SNGU130608N	Positive Geometry	.031R	•		•		•	•	
SNGU130612N	Positive Geometry	.047R	•						
SNGU130616N	Positive Geometry	.062R		•	•	•	•	•	•

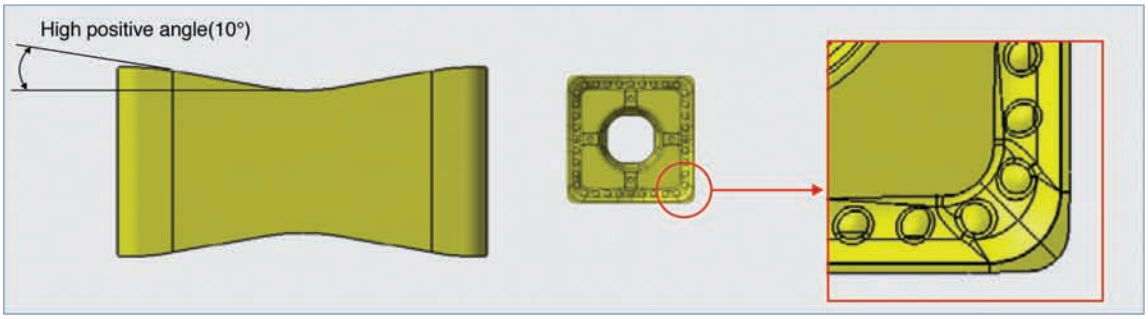
ISOPLUS 85° AND 90° FACE MILL HARDWARE

Description	Insert Material	Recommended Torque	 Insert Screw	 Driver Handle	 Torx Driver Blade	 Optional Torque Driver Blade	 Optional Torque Wrench
85° and 90° Face Mills	Carbide	30-35 in/lbs.	SM40-100-R0	DS-A00T	DS-T156B	DS-T15B1	DT-35-02
	SiNi	28 in/lbs.	SM40-100-R0	DS-A00T	DS-T156B	DS-T15B1	DT-28-01

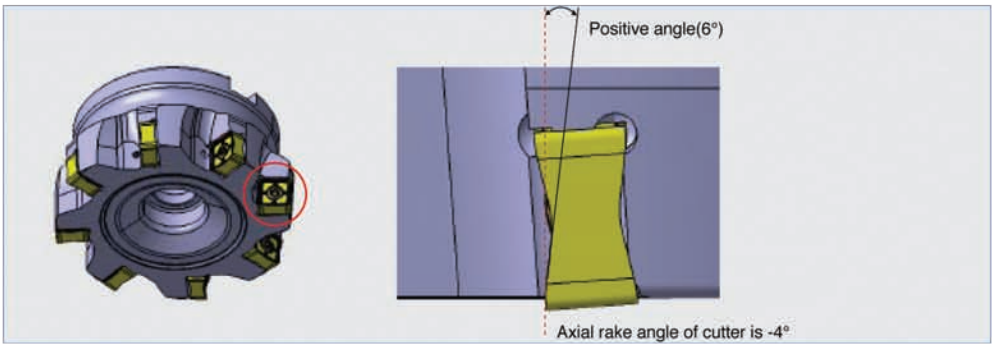
ISOPLUS OPERATING GUIDELINES

Material		Brinell Hardness	SFM	Feed per Insert (inch)	Grade								Coolant
					IN2505	IN2510	IN2530	IN2540	IN4030	IN4015	IN6515	IN71N (SiNi)	
Aluminum	7075-T6, 6061-T6, 2024	–	1,500 - 10,000	.006 - .012		1							Yes
Cast Iron	Gray	150 - 250	500 - 1,000	.008 - .010		1				2	3		No
			1,800+	.005 - .008								1	
	Nodular		400 - 800	.007 - .009		3				1	2		
			1,500+	.004 - .007								1	
Steel	Low Carbon 1018, 8620	100 - 250	400 - 1,000	.006 - .018	3		2	4	1				No
	High Carbon F-6180	250 - 400	400 - 800										
	Alloyed Steel 4140, 4340	150 - 300	300 - 700										
	Tool Steel A-6, D-1, D-2	Up to 300	300 - 500										
Stainless Steel	300 Series, 304, 316	–	300 - 700	.005 - .008	3		2		1		1		May not be required at high speeds
	400 Series 15-5 PH	Up to 320	400 - 700										
	13-8 PH	–	200 - 400										Yes
Nickel Alloys	Inconel, Hastelloy, Waspalloy	–	75-120	.003 - .006	1		3		2				Yes
Titanium	6AL-4V	–	100 - 150	.004 - .007	3		2		1				Yes

High positive insert geometry and dimple chip breaker lower the cutting forces



Low power requirement and smooth cutting possible due to 6 degrees positive rake angle



Unique angle screws gives secure insert clamping and option for high density pitch