

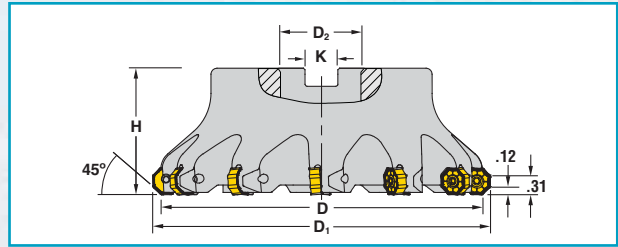
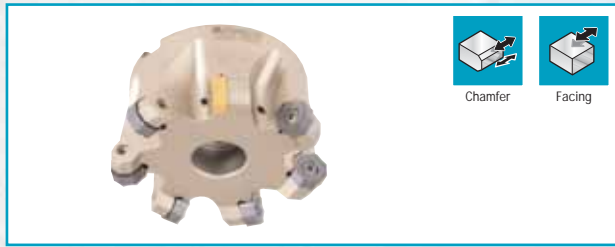
INGERSOLL'S *Sweet 16*



OCTO PLUS™

Series ON5H and ON6H face mills – 5mm

Two-sided tech, 16 edged inserts with aggressive cutting performance provide remarkable low cost productivity!

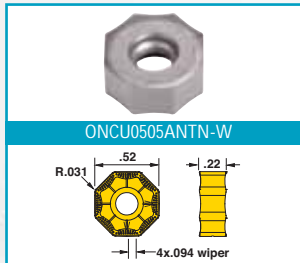
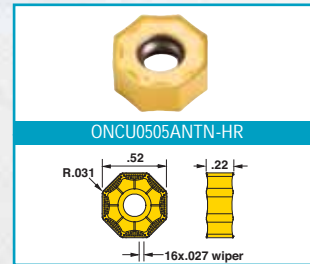
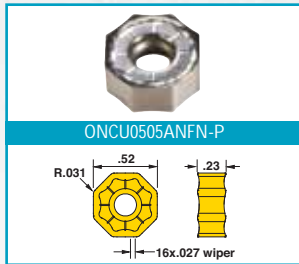
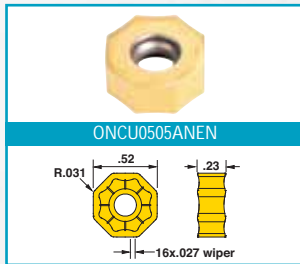


OCTOPLUS™ 90 FACE MILL SERIES ON5H, ON6H

D Nominal Diameter	Cutter Number	D ₁ Overall Diameter	D ₂ Bore Size	K Keyway	H Height	# of Inserts	Coolant Thru	SHCS	SHCS w/ Coolant Thru*
1.500	ON6H-15R01	1.827	0.50	0.25	1.570	4	y	SD-04-86	-
2.000	ON6H-20R01	2.327	0.75	0.31	1.570	4	y	SD-06-46	SD-06-89
2.000	ON5H-20R01	2.327	0.75	0.31	1.570	6	y	SD-06-46	SD-06-89
2.500	ON6H-25R01	2.827	0.75	0.31	1.570	6	y	SD-06-46	SD-06-89
3.000	ON6H-30R01	3.327	1.00	0.38	1.750	7	y	SD-08-46	SD-08-92
3.000	ON5H-30R01	3.327	1.00	0.38	1.750	10	y	SD-08-46	SD-08-92
4.000	ON6H-40R01	4.327	1.50	0.62	2.375	8	y	SD-12-82	SD-12-99
4.000	ON5H-40R01	4.327	1.50	0.62	2.375	12	y	SD-12-82	SD-12-99
5.000	ON6H-50R01	5.327	1.50	0.62	2.375	10	y	SD-12-82	SD-12-99
6.000	ON6H-60R01	6.327	1.50	0.62	2.375	12	-	-	-
6.000	ON5H-60R01	6.327	1.50	0.62	2.375	18	-	-	-

*Order Separately

OCTOPLUS™ INSERTS



Insert Number	Application	Grades						
		IN	10K	2005	2010	2030	2505	70N
ONCU0505ANEN	High Positive Geometry				•			
ONCU0505ANFN-P	Polished for Aluminum		•					
NEW! ONCU0505ANN	SiNi							•
ONCU0505ANTN-HR	Positive Geometry			•		•	•	
ONCU0505ANTN-W	Wiper							•

• **OCTOPLUS™** HARDWARE

Insert Screw		Driver		Optional Torque Wrench	Bit for Torque Driver	
Part No.	Part No.	Torque	1/4" Hex Drive Magnetic		Part No.	Torque
SM40-100-10	DS-T15T	40 in. lbs.	DT-40-01		DS-T15B1	40 in. lbs.

• **OCTOPLUS™** OPERATING GUIDELINES

Material	Brinell Hardness	SFM	Feed per Insert	Grades*						Coolant	
				IN10K	IN2005	IN2010	IN2030	IN2305	IN70N		
Aluminum	6061 T-6, 7075 T-6, 2024	-	1500-10000	.006-.012	1	2					Yes
Cast Iron	Gray	150-250	500-1000	.008-.016		1					No
	Nodular		1800+	.005-.008					1		
			400-800	.007-.014		1					
Steel	Low Carbon 1018, 8620	100-250	400-1000	.006-.015	3	1	2			No	
	High Carbon F-6180,	250-400	400-800	.006-.012							
	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-.009	3	1	2			May not be required at high speeds	
	400 Series 15-5 PH,	Up to 320	400-700							Yes	
	13-8 PH	-	200-400								
Nickel Alloys	Inconel, Hastelloy, Waspalloy	-	75-120	.003-.006			2	1		Yes	
Titanium	6AL-4V	-	100-150	.004-.007			1	2		Yes	

*Preferred for higher SFM.