

1 INSERT, 3 GEOMETRIES!



Diameters:
.625" - 6.00"

Insert Sizes:
6mm IC
10mm IC
13mm IC

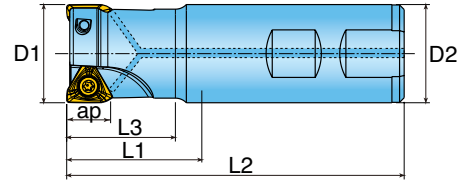
Available Corner Radii:
.015"R, .031"R, .062"R,
NEW! .093"R and **NEW!** .125"R

Materials:
Aluminum, Cast Iron, Steel,
Stainless Steel, Nickel Based Alloys,
Titanium and Other High-Temp Alloys

FEATURES & BENEFITS:

- 0° Lead End Mills and Face Mills
- Hi-Positive Geometry With 3 Cutting Edges for Performance and Economy
- Ramping Capability for Cutting Versatility
- 3 Insert Sizes for Complete Diameter coverage
- Full Range of Insert Radii with Ingersoll Premium Grades
- Coolant Thru Tools up to 3.00" Diameter

0 DEGREE LEAD ENDMILL



Cutter Number	D1 Effective Diameter	Number of Inserts	L1 Extension Length	L2 Overall Length	L3 Projection Length	D2 Shank Size/Style	Ramp Angle Using .031" R Insert	Insert Series	ap Cut Depth
1KJ1D-0601279R01	0.625	1	1.25	3.25	1.22	.625 W	4	TH_S06	.275
1KJ1D-0702084R01	0.725	2	2.00	4.00	1.80	.750 W	3.1	TH_S06	.275
1KJ1D-0701184R01	0.750	2	1.25	3.25	1.05	.750 W	3.1	TH_S06	.275
1KJ1D-0701784R01	0.750	2	1.75	3.75	1.55	.750 W	3.1	TH_S06	.275
1KJ1D-0703084R01	0.750	2	3.00	5.00	2.80	.750 W	3.1	TH_S06	.275
1KJ1D-0801784R01	0.875	2	1.75	3.75	1.75	.750 W	2.5	TH_S06	.275
1KJ1D-1001784R01	1.000	3	1.75	3.75	1.75	.750 W	2.15	TH_S06	.275
1KJ1D-1001780R01	1.000	3	1.75	4.00	1.55	1.00 W	2.15	TH_S06	.275
NEW! 1KJ1D-1003780R01	1.000	3	3.75	6.00	3.375	1.00 W	N/A	TH_S06	.275
1KJ1D-1003784R01	1.000	3	3.75	6.00	3.55	.75 W	N/A	TH_S06	.275
1KJ1D-1201784R01	1.250	4	1.75	3.75	1.75	.750 W	1.5	TH_S06	.275
1KJ1D-1201780R01	1.250	5	1.75	4.00	1.75	1.00 W	1.5	TH_S06	.275
1KJ1D-1501784R01	1.500	5	1.75	3.75	1.75	.750 W	1.3	TH_S06	.275
1KJ1D-1501780R01	1.500	6	1.75	4.00	1.75	1.00 W	1.3	TH_S06	.275
1KJ1D-1502281R01	1.500	6	2.25	4.50	2.25	1.25 W	1.3	TH_S06	.275
1KJ1G-1201784R01	1.250	3	1.75	3.75	1.75	.750 W	2.3	TH_S10	.433
1KJ1G-1202281R01	1.250	2	2.25	4.50	2.05	1.25 W	2.3	TH_S10	.433
1KJ1G-1202281R02	1.250	3	2.25	4.50	2.05	1.25 W	2.3	TH_S10	.433
1KJ1G-1204281R01	1.250	3	4.25	6.50	4.05	1.25 W	N/A	TH_S10	.433
1KJ1G-1502281R01	1.500	3	2.25	4.50	2.20	1.25 W	1.8	TH_S10	.433
1KJ1G-1502281R02	1.500	4	2.25	4.50	2.20	1.25 W	1.8	TH_S10	.433
1KJ1G-1504281R01	1.500	3	4.25	6.50	4.25	1.25 W	N/A	TH_S10	.433
1KJ1G-2002281R01	2.000	5	2.25	4.50	2.25	1.25 W	1.5	TH_S10	.433
1KJ1P-2002281R01	2.000	4	2.25	4.50	2.25	1.25 W	1.5	TH_S13	.590

HIPOSOTRIO™ SERIES 1KJ1_X (TOP•ON STYLE)

0 DEGREE LEAD ENDMILL



Shoulder



Channel



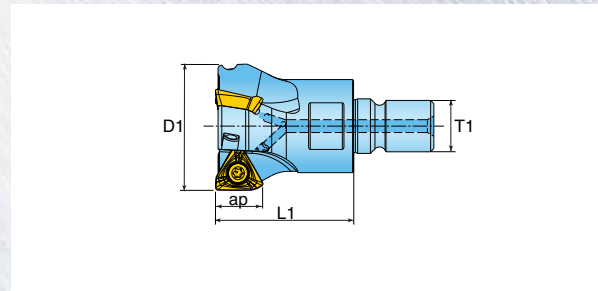
Ramp



Corkscrew



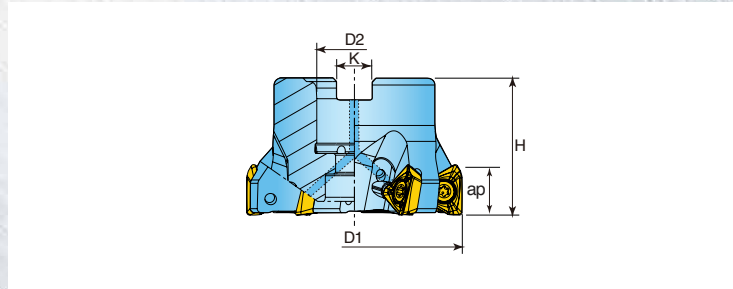
Coolant



Cutter Number	D1 Nominal Diameter	Number of Inserts	L1 Extension Length	T1 Adaption	Wrench Size	Ramp Angle Using .031" R Insert	Insert Series	ap Cut Depth
1KJ1D-07015X6R01	0.750	2	1.50	M10	15mm	3.1	TH_S06	.275
1KJ1D-10015X7R01	1.000	2	1.50	M12	17mm	2.1	TH_S06	.275
1KJ1D-10015X7R02	1.000	3	1.50	M12	17mm	2.1	TH_S06	.275
1KJ1D-12017X8R01	1.250	3	1.75	M16	22mm	2.1	TH_S06	.275
1KJ1D-12017X8R02	1.250	5	1.75	M16	22mm	1.5	TH_S06	.275
1KJ1D-15017X8R01	1.500	5	1.75	M16	22mm	1.3	TH_S06	.275
*1KV1D-10015X7R01	1.000	3	1.50	M12	17mm	NA	TH_S06	.275
*1KV1D-12017X8R01	1.250	5	1.75	M16	22mm	NA	TH_S06	.275
1KJ1G-12017X8R01	1.250	3	1.50	M16	22mm	2.3	TH_S10	.433
1KJ1G-15017X8R01	1.500	4	1.75	M16	22mm	1.8	TH_S10	.433

* 3° Dovetail Endmill

0 DEGREE LEAD FACEMILL



Cutter Number	D1 Effective Diameter	Number of Inserts	H Height	D2 Bore Diameter	Retention Bolt	Optional Coolant Bolt	K Keyway	Coolant	Ramp Angle Using .031" R Insert	Insert Series	ap Cut Depth
KJ5D-15R01	1.500	6	1.57	0.50	SD-04-85	-	0.25	Y	1	TH_S06	.275
KJ5D-20R01	2.000	7	1.57	0.75	SD-06-46	SD-06-89	0.31	Y	1	TH_S06	.275
KJ6D-30R01	3.000	9	1.75	1.00	SD-08-46	SD-08-92	0.38	Y	0.4	TH_S06	.275
KJ5G-20R01	2.000	5	1.57	0.75	SD-06-46	SD-06-89	0.31	Y	1.5	TH_S10	.433
KJ5G-25R01	2.500	6	1.57	0.75	SD-06-46	SD-06-89	0.31	Y	1.1	TH_S10	.433
KJ6G-30R01	3.000	5	1.75	1.00	SD-08-46	SD-08-92	0.38	Y	0.8	TH_S10	.433
KJ5G-30R01	3.000	8	1.75	1.00	SD-08-46	SD-08-92	0.38	Y	0.8	TH_S10	.433
KJ6G-40R01	4.000	8	1.75	1.50	-	-	0.62	N	0.6	TH_S10	.433
KJ5G-40R01	4.000	10	1.75	1.50	-	-	0.62	N	0.6	TH_S10	.433
KJ6G-50R01	5.000	11	2.00	1.50	-	-	0.62	N	0.5	TH_S10	.433
KJ6P-30R01	3.000	6	1.75	1.00	SD-08-46	SD-08-92	0.38	Y	1.3	TH_S13	.590
KJ6P-40R01	4.000	6	1.75	1.50	-	-	0.62	N	1	TH_S13	.590
KJ5P-40R01	4.000	8	1.75	1.50	-	-	0.62	N	1	TH_S13	.590
KJ6P-50R01	5.000	9	2.00	1.50	-	-	0.62	N	0.8	TH_S13	.590
KJ6P-60R01	6.000	8	2.00	1.50	-	-	0.62	N	0.6	TH_S13	.590
KJ5P-60R01	6.000	12	2.00	1.50	-	-	0.62	N	0.6	TH_S13	.590

INSERTS

TH_S



TH_S_FR



TH_S_FR-P



Part Number	Application	R Corner	a Wiper	t Thick.	ap Cut Depth	Grade	IN10K	IN2505	IN2510	IN2530	IN2540
THLS060404R	Multi-Purpose	.015"R	.051	.157	.275			X			
THLS060408R	Multi-Purpose	.031"R	.035	.157	.275		X	X	X	X	
NEW! THLS060416R	Multi-Purpose	.062"R	.022	.157	.275		X				
THLS060408FR	Hi-Temp	.031"R	.035	.157	.275		X			X	
THES060408R	Multi-Purpose, Ground Periphery	.031"R	.035	.157	.275		X				
THES060404FR-P	Ground/Polished for Aluminum	.015"R	.051	.157	.275		X				
THES060408FR-P	Ground/Polished for Aluminum	.031"R	.035	.157	.275		X				
THLS100508R	Multi-Purpose	.031"R	.063	.197	.433			X	X	X	X
NEW! THLS100516R	Multi-Purpose	.062"R	.032	.197	.433		X				
NEW! THLS100524R	Multi-Purpose	.093"R	.020	.197	.433		X				
THLS100508FR	Hi-Temp	.031"R	.063	.197	.433		X			X	
THES100508R	Multi-Purpose, Ground Periphery	.031"R	.063	.197	.433		X				
THES100516R	Multi-Purpose, Ground Periphery	.062"R	.031	.197	.433		X				
THES100508FR-P	Ground/Polished for Aluminum	.031"R	.063	.197	.433		X				
THLS130608R	Multi-Purpose	.031"R	.078	.236	.590			X	X	X	X
THLS130608FR	Hi-Temp	.031"R	.078	.236	.590		X			X	
THLS130616R	Multi-Purpose	.062"R	.047	.236	.590		X			X	
NEW! THLS130624R	Multi-Purpose	.093"R	.024	.236	.590		X				
NEW! THLS130632R	Multi-Purpose	.125"R	.020	.236	.590		X				
THES130608FR-P	Ground/Polished for Aluminum	.031"R	.078	.236	.590		X				

HARDWARE



Insert Screw



Driver

KJ_D	SM25-065-R0	DS-T08W
KJ_G	SM40-100-R0	DS-T15T
KJ_P	SM45-120-R0	DS-T20T



HiPos Trio - 6mm I.C. - Series 1KJ1D, 1KV1D, KJ5D, KJ6D					IN10K	IN2505	IN2510	IN2530	IN2540	Coolant
Material	Brinnell Hardness	SFM	Feed per Insert							
Aluminum	6061 T6, 7075 T6, 2024	-	1500 - 8000	.003 - .006	1					Yes
Cast Iron	Gray	150 - 250	500 - 1200	.002 - .006		2	1			No
	Nodular		400 - 800							
Steel	Low Carbon 1018, 8620	150 - 250	600 - 1200	.002 - .006		2		1	3	No
	High Carbon F-6180, Nitralloy 52100	250 - 400	400 - 600	.002 - .005						
	Alloyed Steel 4140, 4340, 6150	150 - 300	400 - 800							
	Tool Steel A-6, D-1, D-2, P20	Up to 300								
Stainless Steel	300 Series, 304, 316	-	400 - 800	.002 - .005		2		1	3	May not be required at high speeds
	400 Series 15-5 PH, 17-4 PH	Up to 320	500 - 1000							
	13-8 PH	-	200 - 400							Yes
Nickel Alloys	Inconel 600, 706, 718, 903, Hastelloy, Waspalloy	-	75-120	.002 - .004		2	3	1		Yes
Titanium	6AL-4V	-	100 - 150	.002 - .005		2		1		Yes

HiPos Trio - 10mm I.C. - Series 1KJ1G, KJ5G, KJ6G					IN10K	IN2505	IN2510	IN2530	IN2540	Coolant
Material	Brinnell Hardness	SFM	Feed per Insert							
Aluminum	6061 T6, 7075 T6, 2024	-	1500 - 8000	.004 - .010	1					
Cast Iron	Gray	150 - 250	300 - 1000	.004 - .008		2	1			No
	Nodular		300 - 600							
Steel	Low Carbon 1018, 8620	150 - 250	400 - 1000	.004 - .008		2		1	3	No
	High Carbon F-6180, Nitralloy 52100	250 - 400	350 - 500	.004 - .006						
	Alloyed Steel 4140, 4340, 6150	150 - 300	300 - 700	.004 - .008						
	Tool Steel A-6, D-1, D-2, P20	Up to 300								
Stainless Steel	300 Series, 304, 316	-	300 - 700	.004 - .006		2		1	3	May not be required at high speeds
	400 Series 15-5 PH, 17-4 PH	Up to 320	400 - 900							
	13-8 PH	-	200 - 400							Yes
Nickel Alloys	Inconel 600, 706, 718, 903, Hastelloy, Waspalloy	-	75-120	.003 - .005		2	3	1		Yes
Titanium	6AL-4V	-	100 - 150	.005 - .005		2		1		Yes

HiPos Trio - 13mm I.C. - Series 1KJ1P, KJ5P, KJ6P						IN10K	IN2505	IN2510	IN2530	IN2540	Coolant
Material	Brinnell Hardness	SFM	Feed per Insert								
Aluminum	6061 T6, 7075 T6, 2024	-	1500 - 8000	.004 - .010	1						
Cast Iron	Gray	150 - 250	300 - 1000	.004 - .010		2	1				No
	Nodular		300 - 600								
Steel	Low Carbon 1018, 8620	150 - 250	400 - 1000	.004 - .010		2		1	3		No
	High Carbon F-6180, Nitralloy 52100	250 - 400	350 - 500	.004 - .008							
	Alloyed Steel 4140, 4340, 6150	150 - 300	300 - 700	.004 - .010							
	Tool Steel A-6, D-1, D-2, P20	Up to 300									
Stainless Steel	300 Series, 304, 316	-	300 - 700	.004 - .008		2		1			May not be required at high speeds
	400 Series 15-5 PH, 17-4 PH	Up to 320	400 - 900								
	13-8 PH	-	200 - 400							Yes	
Nickel Alloys	Inconel 600, 706, 718, 903, Hastelloy, Waspalloy	-	75-120	.003 - .006		2	3	1			Yes
Titanium	6AL-4V	-	100 - 150	.005 - .006		2		1			Yes