

DOUBLE SIDED POSITIVE INSERT WITH 6 CUTTING EDGES!

NEW!



Diameters:
1.00" - 6.00"

Cutting Edge Length:
WNGU09 - .244
WNGU13 - .362

Geometry:
HiPos

Corner Configurations:
.015", .020", .031", .039", .062"R

Nominal Lead Angle:
0°

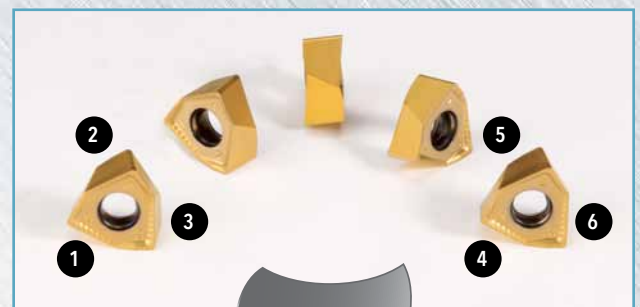
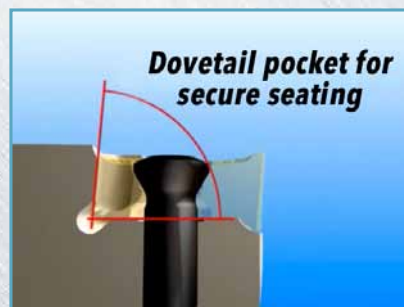
Applications:
Roughing, finishing, one-cuts,
profiling, channel milling and
cutting 90° shoulders

Materials:
Cast iron, steel, stainless steels,
titanium and other high
temperature or
nickel-based alloys

Ingersoll introduces its new DiPosHexa with 6 corner double-sided cutting edge insert, making it first choice for shoulder milling.

Features and Benefits:

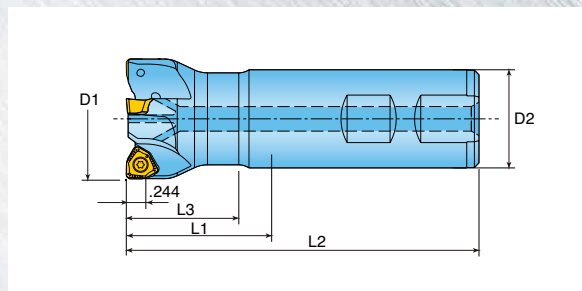
- Six 0 degree cutting edges
- Positive and efficient helical cutting edge action
- Dovetail pocket for secure seating
- Integrated wiper flats for surface finishes as good as 25 Ra
- Coolant through the tool
- Thick insert for durable applications



21SIDE
TECH

DIPOS[®]HEXA[™] SERIES 1DJ1F

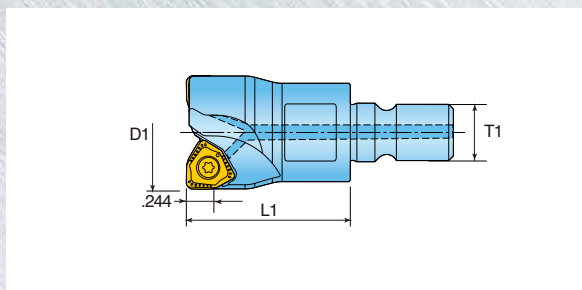
0 DEGREE LEAD ENDMILL WITH 6 INDEXES



Cutter Number	D1 Effective Diameter	L3 Projection Length	L1 Extension Length	L2	Overall Length	D2 Shank Size/Style	Number of Inserts
1DJ1F-1001584R01	1.000	1.50	1.50	3.50		.750 W	2
1DJ1F-1001780R01	1.000	1.55	1.75	4.00		1.00 W	2
1DJ1F-1003780R01	1.000	3.55	3.75	6.00		1.00 W	2
1DJ1F-1201584R01	1.250	1.50	1.50	3.50		.750 W	3
1DJ1F-1202281R01	1.250	2.22	2.25	4.50		1.25 W	3
1DJ1F-1204281R01	1.250	4.22	4.25	6.50		1.25 W	3
1DJ1F-1502281R01	1.500	2.25	2.25	4.50		1.25 W	4

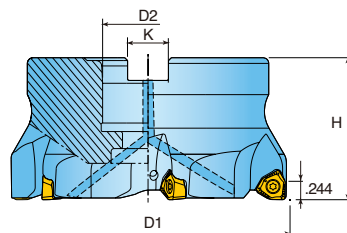
DIPOS[®]HEXA[™] SERIES 1DJ1F (TOP•ON STYLE)

0 DEGREE LEAD ENDMILL WITH 6 INDEXES



Cutter Number	D1 Effective Diameter	T1 Adaption	L1 Extension Length	Wrench Size	Number of Inserts
1DJ1F-10015X7R01	1.000	M12	1.50	17mm	2
1DJ1F-12017X8R01	1.250	M16	1.75	22mm	3
1DJ1F-15017X8R01	1.500	M16	1.75	22mm	4

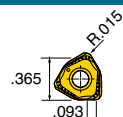
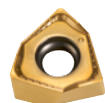
0 DEGREE LEAD FACEMILL WITH 6 INDEXES



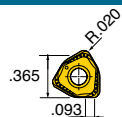
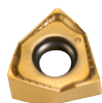
Cutter Number	D1 Effective Diameter	Number of Inserts	H Height	D2 Bore Diameter	K Keyway	Retention Bolt	Optional Coolant Bolt	Coolant
DJ5F-20R01	2.000	5	1.570	0.750	0.312	SD-06-46	SD-06-89	Y
NEW DJ5F-20R02	2.000	6	1.570	0.750	0.312	SD-06-46	SD-06-89	Y
DJ5F-25R01	2.500	6	1.570	0.750	0.312	SD-06-46	SD-06-89	Y
DJ5F-30R01	3.000	7	1.750	1.000	0.375	SD-08-46	SD-08-92	Y
NEW DJ5F-30R02	3.000	9	1.750	1.000	0.375	SD-08-46	SD-08-92	Y
NEW DJ5F-40R01	4.000	11	2.375	1.500	0.625	SD-12-82	SD-12-99	Y
NEW DJ6F-40R01	4.000	8	2.375	1.500	0.625	SD-12-82	SD-12-99	Y

INSERTS

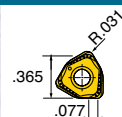
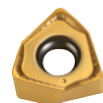
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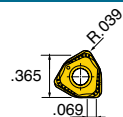
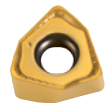
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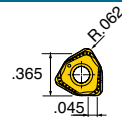
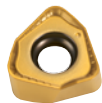
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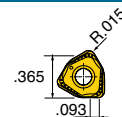
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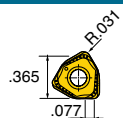
WNGU090416R



WNGU090404FR-P



WNGU090408FR-P



Part Number	Application	Grade	IN2505	IN2510	IN2530	IN2540	IN10K		
WNGU090404R	Multi-Purpose - .015" R		•						
WNGU090405R	Multi-Purpose - .020" R (.5mm R)		•						
WNGU090408R	Multi-Purpose - .031" R		•	•	•	•			
WNGU090410R	Multi-Purpose - .039" R (1.0mm R)		•						
WNGU090416R	Multi-Purpose - .062" R		•	•	•				
NEW WNGU090404FR-P	Grd/Pol for Aluminum - .015" R						•		
NEW WNGU090408FR-P	Grd/Pol for Aluminum - .031" R						•		

HARDWARE



Insert Screw



Driver

WNGU09

SM30-085-10

DS-T09W

SERIES 1DJ1P

0 DEGREE LEAD ENDMILL WITH 6 INDEXES



Shoulder



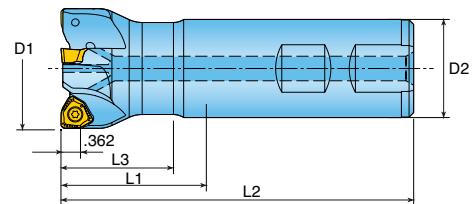
Channel



Facing



Coolant



Cutter Number	D1 Effective Diameter	L3 Projection Length	L1 Extension Length	L2 Overall Length	D2 Shank Size/Style	Number of Inserts
1DJ1P-1202281R01	1.250	2.22	2.25	4.50	1.25 W	2
1DJ1P-1204281R01	1.250	4.22	4.25	6.50	1.25 W	2
1DJ1P-1502281R01	1.500	2.22	2.25	4.50	1.25 W	3
1DJ1P-1504281R01	1.500	4.22	4.25	6.50	1.25 W	3
1DJ1P-2002281R01	2.000	2.22	2.25	4.50	1.25 W	5

SERIES 1DJ1P (TOP•ON STYLE)

0 DEGREE LEAD ENDMILL WITH 6 INDEXES



Shoulder



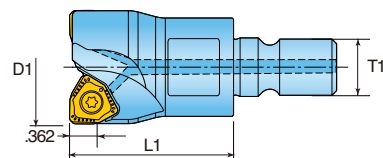
Channel



Facing



Coolant



Cutter Number	D1 Effective Diameter	T1 Adaption	L1 Extension Length	Wrench Size	Number of Inserts
1DJ1P-12017X8R01	1.250	M16	1.75	22mm	2
1DJ1P-15017X8R01	1.500	M16	1.75	22mm	3
1DJ1P-15017X8R02	1.500	M16	1.75	22mm	4

DIPOS[®]HEXA[™] SERIES DJ_P

0 DEGREE LEAD FACEMILL WITH 6 INDEXES

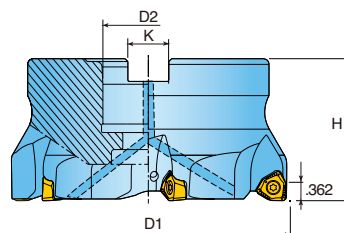


Shoulder

Channel

Facing

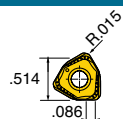
Coolant



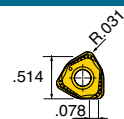
Cutter Number	D1 Effective Diameter	Number of Inserts	H Height	D2 Bore Diameter	K Keyway	Retention Bolt	Optional Coolant Bolt	Coolant
NEW DJ5P-20R01	2.000	5	1.570	0.750	0.312	SD-06-46	SD-06-89	Y
DJ6P-20R01	2.000	4	1.570	0.750	0.312	SD-06-46	SD-06-89	Y
DJ5P-25R01	2.500	6	1.570	0.750	0.312	SD-06-46	SD-06-89	Y
DJ5P-30R01	3.000	7	1.750	1.000	0.375	SD-08-46	SD-08-92	Y
NEW DJ5P-30R02	3.000	9	1.750	1.000	0.375	SD-08-46	SD-08-92	Y
DJ5P-40R01	4.000	8	2.375	1.500	0.625	SD-12-82	SD-12-99	Y
NEW DJ5P-40R02	4.000	11	2.375	1.500	0.625	SD-12-82	SD-12-99	Y
DJ6P-60R01	6.000	12	2.000	1.500	0.625	-	-	N

INSERTS

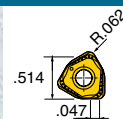
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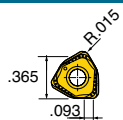
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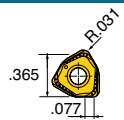
WNGU130616R



WNGU130604FR-P



WNGU130608FR-P



Part Number	Application	Grade	IN2505	IN2510	IN2530	IN2540	IN10K		
WNGU130604R	Multi-Purpose - .015" R		•						
WNGU130608R	Multi-Purpose - .031" R		•	•	•	•			
WNGU130616R	Multi-Purpose - .062" R		•	•	•	•			
NEW WNGU130604FR-P	Grd/Pol for Aluminum - .015" R						•		
NEW WNGU130608FR-P	Grd/Pol for Aluminum - .031" R						•		

HARDWARE



Insert Screw



Driver

WNGU13

SM40-100-R0

DS-T15T

OPERATING GUIDELINES

DiPos Hexa - Series 1DJ1F, DJ5F, 1DJ1P, DJ5P, DJ6P					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 - .010		2		1		May not be required at high speeds
	400 Series 15-5 PH, 17-4 PH	Up to 320	400 - 900							Yes
	13-8 PH	-	200 - 400							
Nickel Alloys	Inconel 600, 706, 718, 903, Hastelloy, Waspalloy	-	75-120	.003 - .006		2		1		Yes
Titanium	6AL-4V	-	100 - 150	.005 - .008		2		1		Yes