

ISOPLUS

Hi-Feed Mill With 8 Indexes

Diameters:
1.50" - 6.00"

Depth of Cut:
.065"

Insert Style:
SNGU1205ENN

Materials:
Cast Iron, Steel, Stainless Steel,
Hardened Steel, High-Temp Alloys



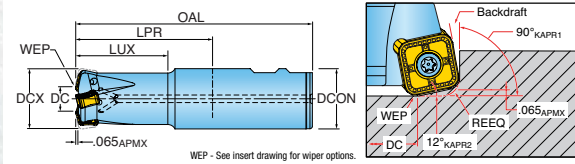
Equipped with our popular SNGU12 Quad style inserts that incorporate 2 Side Technology, this cutter boasts:

- Value with 8 strong cutting edges (4 + 4).
- Near net shape flexibility with .065" axial depth of cut capability.
- Chip evacuation via coolant through the tool capability.
- Deck surface finish capability with .050" integrated wiper flat.
- Clearance angles for corkscrew and ramping applications.
- Utilizes the same insert used on our 45° lead (series DN6H) and 15° lead (series DL6H) cutters.

**PRODUCT
ANNOUNCEMENT
• UPDATE •
2018**

SERIES 1DD1H

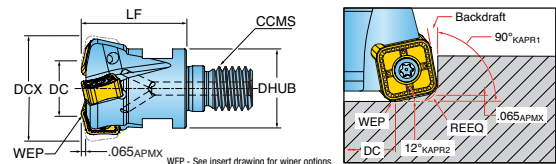
HI-FEED END MILL WITH 8 INDEXES



Part Number	DCX Cutting Dia. Max	DC Cutting Diameter	LUX Usable Length Max.	LPR Protruding Length	OAL Overall Length	ZEPP Effective Teeth	REEQ Program Radius Equivalent	DCON Shank Diameter	CSP Coolant
1DD1H-1502586R01	1.500	0.773	2.50	3.75	6.00	3	0.155	1.500	Yes

SERIES 1DD1H

HI-FEED MODULAR END MILL WITH 8 INDEXES



Part Number	DCX Cutting Dia. Max	DC Cutting Diameter	LF Functional Length	ZEPP Effective Teeth	REEQ Program Radius Equivalent	DHUB Hub Diameter	CCMS Connection Code	CSP Coolant
1DD1H-15015X8R01	1.500	0.773	2.45	3	0.155	1.13	TopOn M16	Yes

SERIES DD6H

HI-FEED FACE MILL WITH 8 INDEXES



Facing

Channeling

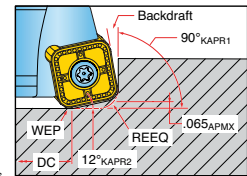
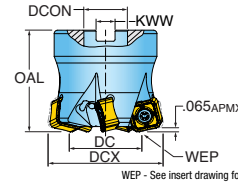
Ramping

Pocketing

Helical/Corkscrew

Contouring

Coolant

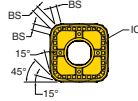


WEP - See insert drawing for wiper options.

Part Number	DCX Cutting Dia. Max	DC Cutting Diameter	OAL Overall Length	ZEFF Effective Teeth	REEQ Program Radius Equivalent	DCON Bore Diameter	KWW Keyway	CSP Coolant	RMPX Ramp Angle Max.
DD6H-20R01	2.000	1.252	1.65	5	0.155	0.750	0.31	Yes	1.14
DD6H-25R01	2.500	1.749	1.65	6	0.155	0.750	0.31	Yes	.86
DD6H-30R01	3.000	2.252	1.75	7	0.155	1.000	0.38	Yes	.66
DD6H-40R01	4.000	3.252	2.38	9	0.155	1.500	0.63	Yes	.45
DD6H-50R01	5.000	4.254	2.38	11	0.155	1.500	0.63	Yes	.34
DD6H-60R01	6.000	5.253	2.38	13	0.155	1.500	0.63	No	.27

INSERT

SNGU12



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	IN6515	IN4030
SNGU1205ENN	Multi-Purpose	0.040	0.500	0.250	8	Neutral		•	•	•	•	•	•	•

HARDWARE



Insert Screw



Driver Handle



Insert Driver Blade



Retention Bolt

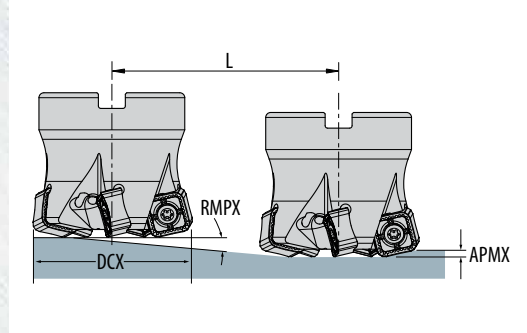


Coolant Bolt (Optional)

	Insert Screw	Driver Handle	Insert Driver Blade	Retention Bolt	Coolant Bolt (Optional)
1DD1H-15...	SM40-100-R0	DS-A00T	DS-T156B	-	-
DD6H-20R01	SM40-100-R0	DS-A00T	DS-T156B	SD-06-47	SD-06-A6
DD6H-25R01	SM40-100-R0	DS-A00T	DS-T156B	SD-06-47	SD-06-A6
DD6H-30R01	SM40-100-R0	DS-A00T	DS-T156B	SD-08-46	SD-08-92
DD6H-40R01	SM40-100-R0	DS-A00T	DS-T156B	SD-12-82	SD-12-99
DD6H-50R01	SM40-100-R0	DS-A00T	DS-T156B	SD-12-82	SD-12-99
DD6H-60R01	SM40-100-R0	DS-A00T	DS-T156B	-	-

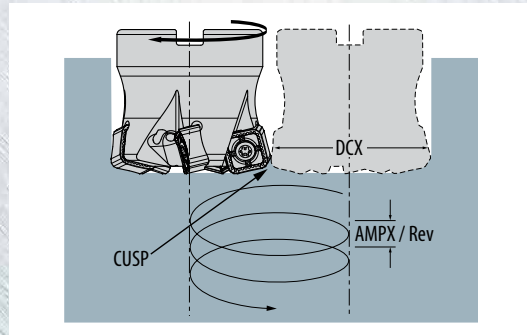
STRAIGHT RAMP DATA

DCX Cutting Dia. Max	RMPX Max Ramp Angle	APMX Max DOC	L
1.500	-	-	-
2.000	1.14	0.065	3.2
2.500	0.86	0.065	4.3
3.000	0.66	0.065	5.6
4.000	0.45	0.065	8.2
5.000	0.34	0.065	10.9
6.000	0.27	0.065	13.7



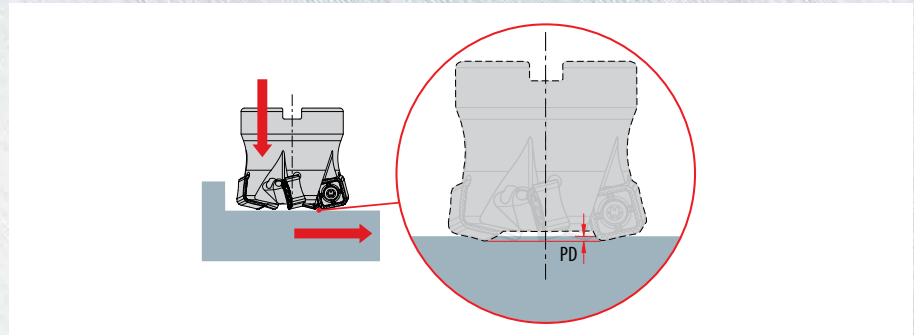
HELICAL RAMP DATA

DCX Cutting Dia. Max	AMPX / Rev.	Max. Dia Milled Hole (Bottom w/ Cusp)	Max. Dia Milled Hole (Flat Bottom)	Min. Dia Milled Hole (Bottom w/ Cusp)	Min. Dia Milled Hole (Flat Bottom)
1.500	-	-	-	-	-
2.000	0.024	4.00	3.25	3.10	3.17
2.500	0.024	5.00	4.25	4.10	4.17
3.000	0.024	6.00	5.25	5.10	5.17
4.000	0.024	8.00	7.25	7.10	7.17
5.000	0.024	10.00	9.25	9.10	9.17
6.000	0.024	12.00	11.25	11.10	11.17



DRILL MILL POCKETING

DCX Cutting Dia. Max	PD Plunge Depth
1.500	-
2.000	0.024
2.500	0.024
3.000	0.024
4.000	0.024
5.000	0.024
6.000	0.024



OPERATING GUIDELINES

Material				Brinnell Hardness	SFM	Feed per Insert	IN2035	IN2530/IN4030	IN2505	IN2540	IN2510	IN6515	Coolant
Cast Iron	Gray	150 - 250	600 - 1000	.030 - .060						1	2	No	
	Nodular		500 - 900						2	1			
Steel	Mild 1018, 1045	125 - 425	300 - 650	.025 - .060		1	2	3			No		
	Low Alloy 4140, 4340, 8620	150 - 425											
	Med Alloy P20, S7, H13, A2		300 - 700										
Stainless Steel	300 Series, 304, 316	Up to 320	200 - 550	.025 - .050	1	2	3	4			May not be required at high speeds		
	400 Series, 15-5 PH, 17-4 PH												
	13-8 PH												
Hardened Steel	ALL	-	150 - 350	.020 - .040		2	1				No		
Nickel Alloys	Inconel, Hastelloy, Waspalloy	-	75 - 120	.025 - .050	1	2	3				Yes		
Titanium	6AL-4V	-	100 - 150	.025 - .050	1	3	2				Yes		