DIPOS TETRA™

Diameters:
.500" - 2.00"

Cutter Series:
1TJ1C, TJ1C

Insert Series:
ENHU05 (5mm I.C.)

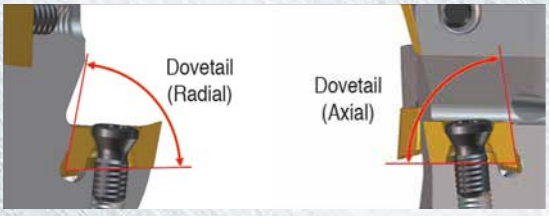
Materials:
Cast Iron, Steel, Stainless Steel, Hardened Steel, High-Temp Alloys

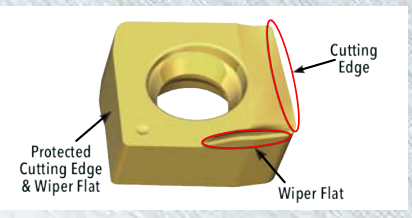
Depth of Cut:
.18"

2 SIDE TECH

Easy-Loading 5mm I.C. Micro Insert That Runs At Maximum Feed Rates

- *Double dovetail pockets allow for easy insert indexing – Insert clamps in pocket while affixing the screw.*
- *Double dovetail pocket along with strong M2.0 insert screw promotes ultra stable insert mounting – To be run at high feed rates!*
- *Double positive insert geometry offers .18" axial depth of cut capability with 2 indexes*
- *.03" integrated wiper flats produce surface finishes as good as Ra 32*
- *.50" – 2.00 cutter diameter range*
- *Equipped with fine pitched densities for high productivity machining*
- *This multi-functional tool does everything – Ramps, Plunges, Interpolates – and does them aggressively!*



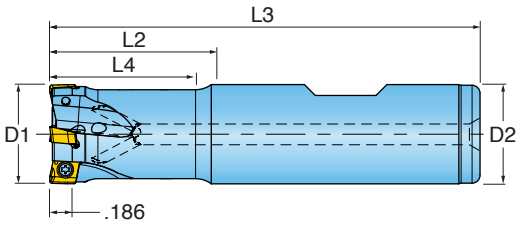


NEW PRODUCT ANNOUNCEMENT *2015*

Member IMC Group
Ingersoll Cutting Tools

DIPOS•TETRA 4D 90 SERIES 1TJ1C (5MM)

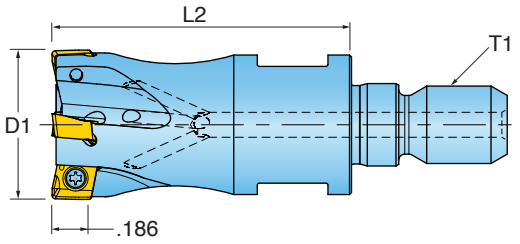
90° END MILL WITH 2 INDEXES



Cutter Number	D1 Effective Diameter	L2 Extension Length	L3 Overall Length	L4 Projection Length	D2 Shank Size/Style	# of Inserts	Ramp Angle
1TJ1C-05012S4R01	0.500	1.22	3.00	0.75	.500" Cyl	2	6.9
1TJ1C-0600779R01	0.625	0.75	2.66	0.72	.625" W	3	4.4
1TJ1C-06020S6R01	0.625	2.09	4.00	1.25	.625" Cyl	3	4.4
1TJ1C-0701284R01	0.750	1.25	3.25	1.22	.750" W	4	3.3
1TJ1C-07030S7R01	0.750	3.00	5.00	1.25	.750" Cyl	4	3.3
1TJ1C-1001780R01	1.000	1.75	4.00	1.72	1.000" W	6	2.2
1TJ1C-1001784R01	1.000	1.75	3.75	1.75	.750" W	5	2.2
1TJ1C-10037S1R01	1.000	3.75	6.00	1.25	1.000" Cyl	5	2.2

DIPOS•TETRA 4D 90 SERIES 1TJ1C (TOP•ON STYLE) (5MM)

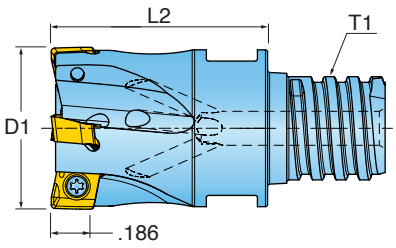
90° MODULAR END MILL WITH 2 INDEXES



Cutter Number	D1 Effective Diameter	T1 Adaption	L2 Extension Length	Number of Inserts	Wrench Size	Ramp Angle
1TJ1C-06010X5R01	0.750	M8	1.00	3	10mm	4.4
1TJ1C-07015X6R01	0.750	M10	1.50	4	15mm	3.3
1TJ1C-10015X7R01	1.000	M12	1.50	5	17mm	2.1

DIPOS•TETRA 4D 90 SERIES 1TJ1C (CHIP•SURFER STYLE) (5MM)

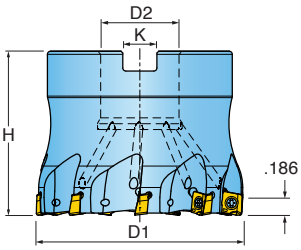
90° MODULAR END MILL WITH 2 INDEXES



Cutter Number	D1 Effective Diameter	T1 Adaption	Number of Inserts	L2 Extension Length	Ramp Angle
1TJ1C-05006T8R01	0.500	T08	2	0.65	6.9
1TJ1C-06008TRR01	0.625	T10	3	0.80	4.4
1TJ1C-07010TSR01	0.750	T12	4	1.00	3.3
1TJ1C-10012TUR01	1.000	T15	5	1.25	2.2

DIPOS•TETRA 4D 90 SERIES TJ1C (5MM)

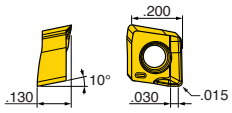
90° FACE MILL WITH 2 INDEXES



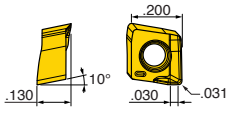
Cutter Number	D1 Effective Diameter	# of Inserts	H Height	D2 Bore Diameter	K Keyway	Ramp Angle
TJ1C-15R01	1.500	8	1.570	0.500	0.250	1.3
TJ1C-20R01	2.000	9	1.570	0.750	0.312	.9

DIPOS TETRA 4D 90 INSERTS (5MM)

ENHU050304R



ENHU050308R



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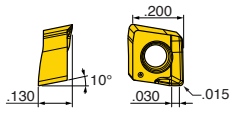

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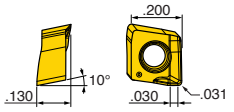


Part Number	Application	R Corner	Grade	IN2504	IN2505	IN2510	IN2530	IN6515	IN7035
ENHU050304R	Multi-Purpose	0.015 R		●	●	●	●	●	
ENHU050308R	Multi-Purpose	0.031 R		●	●	●	●	●	
ENHU050304R-PH	SS/Hi-Temp/Ti	0.015 R					●		●
ENHU050308R-PH	SS/Hi-Temp/Ti	0.031 R			●		●		●

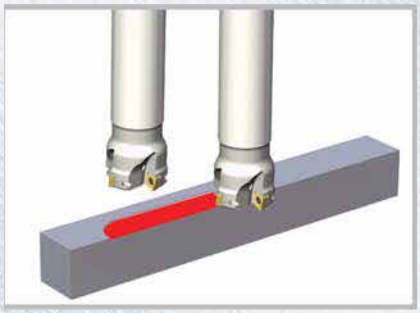
DIPOS TETRA 4D 90 HARDWARE

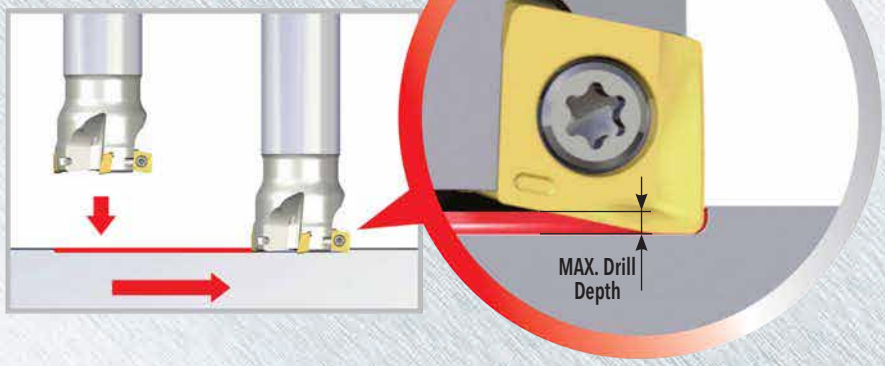
	 Screw	 Driver	 Retention Bolt	 Optional Torque Driver Handle	 Optional Bit
1TJ1C	SM20-043-00	DS-TP06S-NEU	-	DTN005S	DS-TP06TB
TJ1C-15R01	SM20-043-00	DS-TP06S-NEU	SD-04-46	DTN005S	DS-TP06TB
TJ1C-20R01	SM20-043-00	DS-TP06S-NEU	SD-06-46	DTN005S	DS-TP06TB

DIPOS TETRA 4D 90 OPERATING GUIDELINES

DiPos TETRA - Series 1TJ1C, TJ1C											
Material		Brinnell Hardness	SFM	Feed per Insert	IN7035	IN2504	IN2505	IN2510	IN2530	IN6515	Coolant
Cast Iron	Gray	150 - 250	300 - 1000	.003 - .007				1		2	No
	Nodular		300 - 600					2		1	
Steel	Low Carbon 1018, 8620	100 - 250	400 - 1000	.003 - .007			2		1		No
	High Carbon F-6180	250 - 400	350 - 500								
	Alloyed Steel 4140, 4340	150 - 300	300 - 700								
	Tool Steel A-6, D-1, D-2	Up to 300									
Stainless Steel	300 Series, 304, 316	-	300 - 550	.002 - .005	1		3		2		May not be required at high speeds
	400 Series 15-5 PH	Up to 320	350 - 600								
	13-8 PH	-	200 - 400								Yes
Nickel Alloys	Inconel, Hastelloy, Waspalloy	-	75-120	.002 - .005	1		3		2		Yes
Titanium	6AL-4V	-	100 - 150	.002 - .005	1		3		2		Yes
Hardened Steel	All	-	165 - 360	.002 - .005		1	2				Yes

DIPOS TETRA 4D 90 DRILL MILL POCKETING

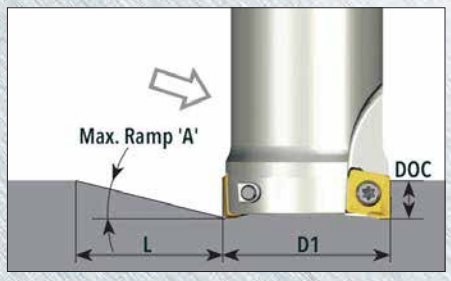




Cutter Dia.	MAX. Drill Depth
0.50	0.027
0.62	0.027
0.75	0.027
1.00	0.027
1.50	0.027
2.00	0.027

DIPOS TETRA 4D 90 STRAIGHT RAMPING DATA

Straight ramping



Cutter Diameter	A Ramping Angle	L	DOC
0.50	6.9	1.48	0.18
0.62	4.4	2.34	0.18
0.75	3.3	3.12	0.18
1.00	2.2	4.68	0.18
1.50	1.3	7.93	0.18
2.00	0.9	11.45	0.18

DIPOS TETRA 4D 90 HELICAL RAMPING DATA

Helical ramping

Cutter Dia. (D1) Using R.031 Insert	MIN. Diameter Milled Hole	MIN. Advance Per Cutter Path Rev. (APCPR)	MAX. Diameter Milled Hole	MAX. Advance Per Cutter Path Rev. (APCPR)
0.50	0.61	0.041	1.00	0.180
0.62	0.86	0.057	1.25	0.150
0.75	1.11	0.065	1.50	0.135
1.00	1.60	0.072	2.00	0.120
1.50	2.60	0.078	3.00	0.180
2.00	3.60	0.078	4.00	0.098