

GOLD[®]TRIO 10

90° MILL FAMILY OFFERING 3 HI-POSITIVE EDGES FOR THE PRICE OF 2!

Diameters:
Ø1.250" - Ø 5.000"

Depth of Cut:
.41"

Insert Series:
TH_S10
THS10_P
THLS10_HR

Materials:
Aluminum, Iron, Steel, Stainless
Steel, Hi-Temps, Titanium

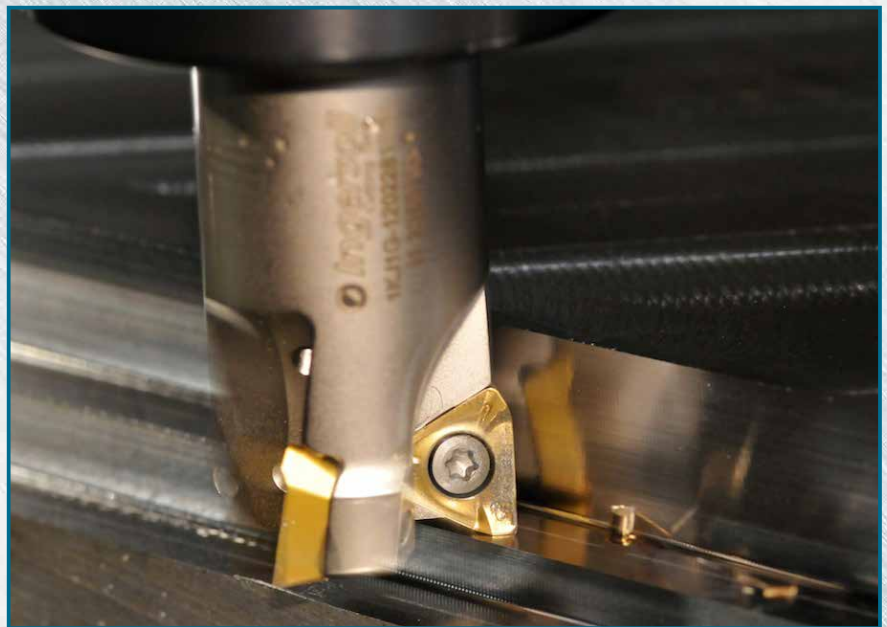
Multi-Purpose



Polished for Aluminum



SS/Hi-Temp/Ti



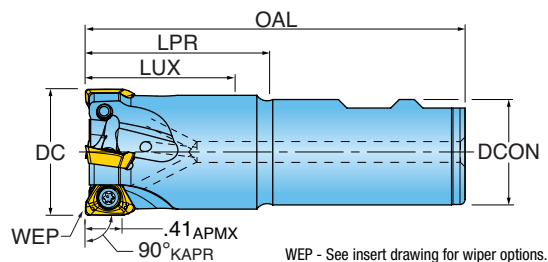
General Features:

- Hi-Positive geometry with 3 cutting edges for performance and economy
- Diverse range of insert corner and grade options for a broad range of materials
- Inserts equipped with integrated wipers for surface finishes between 32-63 Ra
- Cutters offered with coolant through
- Ramping capability for versatility

**UPDATED
PRODUCT
ANNOUNCEMENT
2017**

GOLDOTRIO SERIES: 1KJ1G (WELDON SHANK)

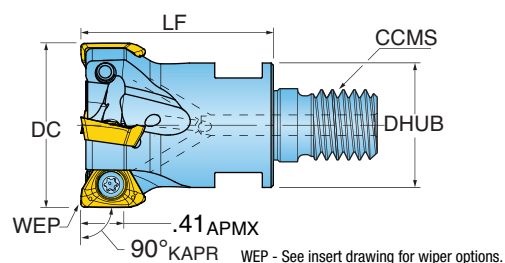
90° END MILL



Part Number	DC Cutting Diameter	LUX Usable Length Max.	LPR Protruding Length	OAL Overall Length	ZEFF Effective Teeth	DCON Shank Diameter	CSP Coolant	RMPX Ramp Angle Max.
1KJ1G-1201784R01	1.250	1.75	1.75	3.75	3	0.750	Yes	2.3
1KJ1G-1202281R01	1.250	2.05	2.25	4.50	2	1.250	Yes	2.3
1KJ1G-1202281R02	1.250	2.05	2.25	4.50	3	1.250	Yes	2.3
1KJ1G-1204281R01	1.250	4.05	4.25	6.50	3	1.250	Yes	0
1KJ1G-1502281R01	1.500	2.20	2.25	4.50	3	1.250	Yes	1.8
1KJ1G-1502281R02	1.500	2.20	2.25	4.50	4	1.250	Yes	1.8
1KJ1G-1504281R01	1.500	4.25	4.25	6.50	3	1.250	Yes	0
1KJ1G-2002281R01	2.000	2.25	2.25	4.50	5	1.250	Yes	1.5

GOLDOTRIO SERIES: 1KJ1G (TOPON M-ADAPTION)

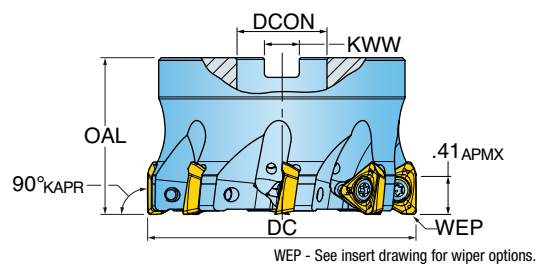
90° MODULAR END MILL



Part Number	DC Cutting Diameter	LF Functional Length	ZEFF Effective Teeth	CCMS Connection Code	DHUB Hub Diameter	CSP Coolant	RMPX Ramp Angle Max.
1KJ1G-12017X8R01	1.250	1.50	3	TopOn M16		Yes	2.3
1KJ1G-15017X8R01	1.500	1.75	4	TopOn M16		Yes	1.8

GOLDOTRIO SERIES: KJ5G, KJ6G

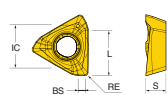
90° FACE MILL



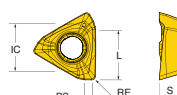
Part Number	DC Cutting Diameter	OAL Overall Length	ZEFF Effective Teeth	DCON Bore Diameter	KWW Keyway	CSP Coolant	RMPX Ramp Angle Max.
NEW KJ6G-15R01	1.500	1.38	4	0.500	0.250	Yes	1.4
KJ5G-20R01	2.000	1.57	5	0.750	0.312	Yes	1.5
KJ6G-20R01	2.000	1.57	3	0.750	0.312	Yes	.8
KJ5G-25R01	2.500	1.57	6	0.750	0.312	Yes	1.1
KJ5G-30R01	3.000	1.75	8	1.000	0.375	Yes	.8
KJ6G-30R01	3.000	1.75	5	1.000	0.375	Yes	.8
KJ6G-30R02	3.000	1.75	3	1.000	0.375	Yes	.8
KJ5G-40R01	4.000	2.00	10	1.500	0.625	No	.6
KJ6G-40R01	4.000	2.00	8	1.500	0.625	No	.6
KJ6G-50R01	5.000	2.00	11	1.500	0.625	No	.5

GOLD[®]TRIO INSERTS

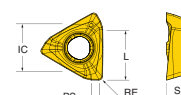
THES10



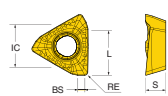
THES10_P



THLS10



THLS10_HR



Part Number	Application	RE Corner Radius	BS Wiper Length	L Cutting Edge Length	IC Inscribed Circle Diameter	S Thickness	Grade	IN10K	NEW IN2035	IN2505	IN2510	IN2530	IN2540	NEW IN4030
THES100504R	Multi-Purpose; Ground Periphery	0.015 R	0.078	0.430	0.421	0.197				•				
THES100508R	Multi-Purpose; Ground Periphery	0.031 R	0.062	0.430	0.421	0.197				•				
THES100516R	Multi-Purpose; Ground Periphery	0.062 R	0.031	0.430	0.421	0.197				•				
THES100504FR-P	Grd/Pol for Al	0.015 R	0.078	0.430	0.421	0.197		•						
THES100508FR-P	Grd/Pol for Al	0.031 R	0.062	0.430	0.421	0.197		•						
THLS100508R	Multi-Purpose	0.031 R	0.062	0.430	0.421	0.197				•	•	•	•	•
THLS100516R	Multi-Purpose	0.062 R	0.031	0.430	0.421	0.197				•				
THLS100524R	Multi-Purpose	0.094 R	0.020	0.430	0.421	0.197				•				
NEW THLS100508R-HR	SS/Hi-Temp/Ti	0.031 R	0.062	0.430	0.421	0.197			•	•		•		

GOLD[®]TRIO HARDWARE

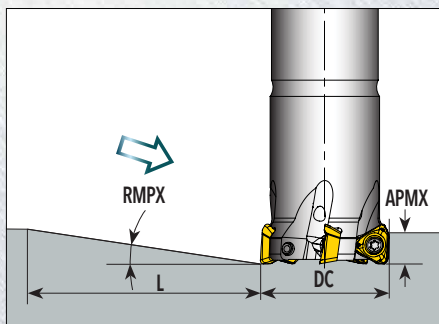
	Insert Screw	Driver Handle	Torx Driver Blade	Retention Bolt	Retention Bolt w/Coolant	Wrench
1KJ1G-1201784R01	SM40-100-R0	DS-A00T	DS-T156B	-	-	-
1KJ1G-1202281R01	SM40-100-R0	DS-A00T	DS-T156B	-	-	-
1KJ1G-1202281R02	SM40-100-R0	DS-A00T	DS-T156B	-	-	-
1KJ1G-1204281R01	SM40-100-R0	DS-A00T	DS-T156B	-	-	-
1KJ1G-1502281R01	SM40-100-R0	DS-A00T	DS-T156B	-	-	-
1KJ1G-1502281R02	SM40-100-R0	DS-A00T	DS-T156B	-	-	-
1KJ1G-1504281R01	SM40-100-R0	DS-A00T	DS-T156B	-	-	-
1KJ1G-2002281R01	SM40-100-R0	DS-A00T	DS-T156B	-	-	-
1KJ1G-12017X8R01	SM40-100-R0	DS-A00T	DS-T156B	-	-	622MM
1KJ1G-15017X8R01	SM40-100-R0	DS-A00T	DS-T156B	-	-	622MM
KJ6G-15R01	SM40-100-R0	DS-A00T	DS-T156B	SE04-15	-	-
KJ5G-20R01	SM40-100-R0	DS-A00T	DS-T156B	SD-06-46	SD-06-89	-
KJ6G-20R01	SM40-100-R0	DS-A00T	DS-T156B	SD-06-46	SD-06-89	-
KJ5G-25R01	SM40-100-R0	DS-A00T	DS-T156B	SD-06-46	SD-06-89	-
KJ5G-30R01	SM40-100-R0	DS-A00T	DS-T156B	SD-08-46	SD-08-92	-
KJ6G-30R01	SM40-100-R0	DS-A00T	DS-T156B	SD-08-46	SD-08-92	-
KJ6G-30R02	SM40-100-R0	DS-A00T	DS-T156B	SD-08-46	SD-08-92	-
KJ5G-40R01	SM40-100-R0	DS-A00T	DS-T156B	-	-	-
KJ6G-40R01	SM40-100-R0	DS-A00T	DS-T156B	-	-	-
KJ6G-50R01	SM40-100-R0	DS-A00T	DS-T156B	-	-	-

GOLD[®]TRIO OPERATING GUIDELINES - SERIES 1KJ1G, KJ_G

Series 1KJ1D, KJ_D					IN10K	IN2035	IN2505	IN2510	IN2530	IN2540	IN4030	
Material		Brinnell Hardness	SFM	Feed per Insert								Coolant
Aluminum	6061-T6, 7075-T6, 2024	-	1500 - 5000	.004-.010	1							Yes
Cast Iron	Gray	150 - 250	300 - 1000	.004-.008			3	1			4	No
	Nodular		300 - 600				3	1			4	
Steel	Low Carbon 1018, 8620	100 - 250	400 - 1000	.004-.007			3		2	4	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	.004-.006		1	4		3	5	2	May not be required at high speeds
	400 Series 15-5 PH	Up to 320	350 - 600									Yes
	13-8 PH	-	200 - 400									
Nickel Alloys	Inconel, Hastelloy, Waspalloy	-	65-120	.003-.005		1	2		4		3	Yes
Titanium	6AL-4V	-	100 - 150	.003-.005		1	4		3		2	Yes

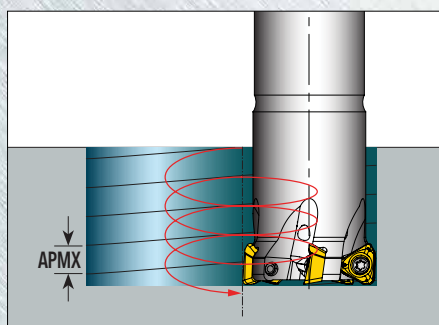
GOLD[®]TRIO RAMPING DATA

Straight ramping



DC Cutter Diameter	RMPX Ramp Angle Max.	APMX Depth of Cut Max.	L
1.250	2.7	0.41	8.6
1.500	1.7	0.41	13.8
2.000	1.2	0.41	19.5
2.500	1.0	0.41	23.4
3.000	0.7	0.41	33.5
4.000	0.6	0.41	39.1
5.000	0.4	0.41	58.7

Helical ramping



DC Cutter Diameter (Using R.031 Insert)	Min. Dia. Milled Hole (Bottom with Cusp)	APMX / Rev.	Max. Dia. Milled Hole (Flat Bottom)	APMX / Rev.
1.250	2.04	0.12	2.42	0.18
1.500	2.57	0.10	2.92	0.13
2.000	3.58	0.10	3.92	0.12
2.500	4.57	0.11	4.92	0.12
3.000	5.57	0.11	5.92	0.12
4.000	7.57	0.11	7.92	0.12
5.000	9.57	0.11	9.92	0.11