

MILLING PRODUCTS

Product Line Affected

FormMasterSpeed

Alternative Product Lines

HiPosWinV
(top recommendation)

DiFeedWinV

DiPosFeed

DiPosTetra

GoldSFeed

PowerFeed13+

FORMMASTER[™]SPEED

Phase Out Notice

EFFECTIVE JANUARY 1, 2025

For many years, Ingersoll has indicated on its e-catalog pages that **FormMasterSpeed** is an “obsolete product line”. The time has come for it to be officially phased out, so effective January 2025, the FormMasterSpeed hi-feed product will no longer be produced.

Remaining Stock

FormMasterSpeed cutter bodies and inserts will remain available until stock levels are depleted, at which time you will need to upgrade your tooling to an alternative Ingersoll product. Several recommendations are available.

Alternative Solutions

Ingersoll experts recommend **HiPosWinV** as the first choice alternative, followed by **DiFeedWinV**, **DiPosTetra 05**, **DiPosFeed**, **GoldSFeed**, and **PowerFeed13+**. The popular IN2505 grade is available for these product lines and ideal chip breakers with sharp, positive geometry, as well as a host of newer grades and additional benefits.

Don't wait for stock to be depleted. Test our newer product offerings today. **See more recommendation information on the following pages:**

- ▶ **Page 2:** Alternative Products' Advantages
- ▶ **Page 3:** Alternative Products Specifications Comparison
- ▶ **Page 4:** Alternative Products Grades Comparison



HIPOSWIN[™]V

Diameters: .625-3.000" | Materials: **P M K N S**

Advantages Over FormMasterSpeed:

- Larger cutter diameter, density and adaption offering
- Higher ramp down angle with secure 'V' clamping for improved productivity
- Advanced grade IN2036 for tool life improvement when cutting SS/Hi-Temp/Ti
- 90° insert fits the same pocket

Product Page



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DIFEEDWIN[™]V

Diameters: .625-3.000" | Materials: **P M K S H**

Advantages Over FormMasterSpeed:

- Higher ramp down angle with secure 'V' clamping for improved productivity
- 4 cutting edges per insert offer great economy
- Excellent hi-feed performance and economy

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DIPOSTETRA[™]

Diameters: .500-2.000" | Materials: **P M K S H**

Advantages Over FormMasterSpeed:

- Similar double-dovetail pocket design for secure mounting/accelerated feed rates
- Smaller IC insert accommodates higher density cutters for accelerated feed rates
- Advanced grade IN7035 for tool life improvement when cutting SS/Hi-Temp/Ti
- 90° inserts fit the same pocket

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DIPOSFEED[™]

Diameters: .312-4.000" | Materials: **P M K S H**

Advantages Over FormMasterSpeed:

- 4 cutting edges per insert offer great economy
- Higher insert density bodies offer great productivity
- Several hi-feed insert sizes provide performance and economy

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GOLDSPEED[™]

Diameters: .375-7.000" | Materials: **P M K S H**

Advantages Over FormMasterSpeed:

- Variety of insert sizes with 4 cutting edges
- 13 mm insert provide similar capability as FormMasterSpeed 13 mm insert
- Excellent hi-feed performance and economy

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POWERFEED13[™]+

Diameters: 1.250-6.000" | Materials: **P M K S H**

Advantages Over FormMasterSpeed:

- 6 cutting edges per insert offer great economy
- Unique insert seating design provides excellent stability in the cut
- Excellent hi-feed performance and economy

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Alternative Products Specifications Comparison

Product Line	Series (End Mill / Face Mill)	Insert Size	Number of Cutting Edges/Indexes	Ap Depth of Cut	Diameter Range	Materials	Axial Rake
FormMasterSpeed	15V1E / 5V6E	8 mm	2	.060"	.750-2.000"	P M H	Positive
	15V1H / 5V6H	13 mm	2	.080"	1.250-4.000"		Positive
HiPosWinV	1VX1F / VX_F	10 mm	2	.039"	.625-3.000"	P M K N S	Positive
DiFeedWinV	TG1V / 1TG1V	6 mm	4	.039"	.625-3.000"	P M K S H	Negative
DiPosTetra 05	1TJ1C / TJ1C	5 mm	2	.019"	.500-2.000"	P M K S H	Positive
DiPosFeed	1TG1B	4 mm	4	.020"	.312-1.250"	P M K S H	Negative
	1TG1F / TG1F	6 mm	4	.028-.043"	.625-2.000"		Negative
	1TG1G / TG1G / TG2G	9 mm	4	.060"	1.000-3.000"		Negative
	1TG1J / TG1J / TG2J	11 mm	4	.078"	1.250-4.000"		Negative
GoldSFeed	15G1B	4 mm	4	.024"	.375-.750"	P M K S H	Positive
	15G1D / 5G1D	6 mm	4	.040"	.625-2.000"		Positive
	15G1F / 5G5F / 5G6F	9 mm	4	.060"	1.000-3.000"		Positive
	15M1P / 5M5P / 5M6P	13 mm	4	.088"	1.250-5.000"		Positive
	5G5Q / 5G6Q	16 mm	4	.107"	2.500-6.000"		Positive
	5G5M / 5G6M	19 mm	4	.145"	3.000-7.000"		Positive
PowerFeed13+	1DG1P (end mill)	7 mm	6	.078"	1.250-1.500"	P M K S H	Negative
	DG5P / DG6P (face mills)	7 mm	6	.078"	2.000-4.000"		Negative

Alternative Products Grades Comparison

Category	Grade	FormMasterSpeed	HiPosWinV	DiFeedWinV	DiPosTetra 05	DiPosFeed	GoldSFeed	PowerFeed13+
PVD TiAlN	IN2005	•						
	IN2030	•						
	IN2035					•		•
	IN2036		•	•				
	IN2040	•						
TiAlN / TiN	IN2504			•	•	•	•	•
	IN2505	•	•	•	•	•	•	•
	IN2510		•		•	•	•	
	IN2515						•	
	IN2530		•	•	•	•	•	•
	IN2535						•	
	IN2537						•	
PVD TiAlN (AlCr) ₂ O ₃	IN4005						•	
	IN4015						•	
	IN4030						•	
	IN4035						•	
CVD	IN6515				•			
	IN6530					•		
	IN6537			•		•	•	
	IN7035				•	•	•	•
	IN7036			•				