



Diameters:
.500" - 2.00"

Cutter Series:
1TJ1C, TJ1C

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

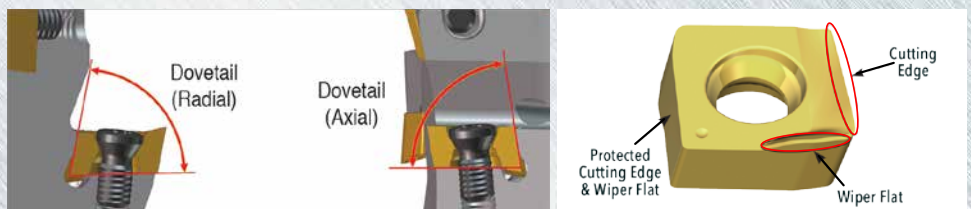
Materials:
Cast Iron, Steel, Stainless Steel,
Hardened Steel, High-Temp Alloys

Depth of Cut:
.18"



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

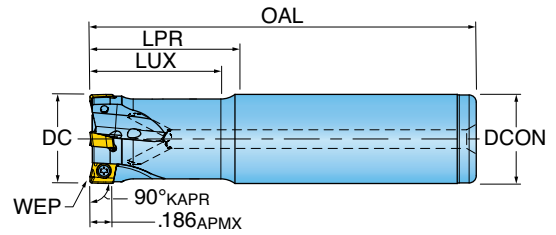
- Double dovetail pockets allow for easy insert indexing - Insert clamps in pocket while affixing the screw.
- Double dovetail pocket along with strong M2.0 insert screw promotes ultra stable insert mounting - To be run at high feed rates!
- Double positive insert geometry offers .18" axial depth of 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!



**PRODUCT
ANNOUNCEMENT
UPDATE
2018**

SERIES 1TJ1C (CYLINDRICAL STYLE) (5MM)

90° END MILL WITH 2 INDEXES

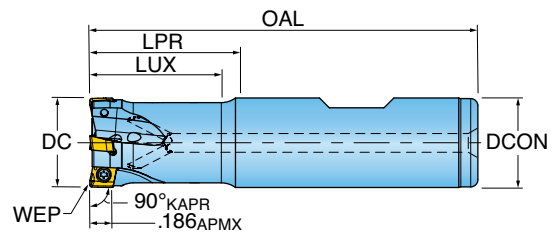


WEP - See insert drawing for wiper options.

Part Number	DC Cutting Dia.	LUX Usable Length Max.	LPR Protruding Length	OAL Overall Length	ZEFF Effective Teeth	DCON Shank Dia.	RMPX Ramp Angle Max.
1TJ1C-05012S4R01	0.500	0.75	1.22	3.00	2	0.500	6.9
1TJ1C-06020S6R01	0.625	1.25	2.09	4.00	3	0.625	4.4
1TJ1C-07030S7R01	0.750	1.25	3.00	5.00	4	0.750	3.3
1TJ1C-10037S1R01	1.000	1.25	3.75	6.00	5	1.000	2.2

SERIES 1TJ1C (WELDON STYLE) (5MM)

90° END MILL WITH 2 INDEXES

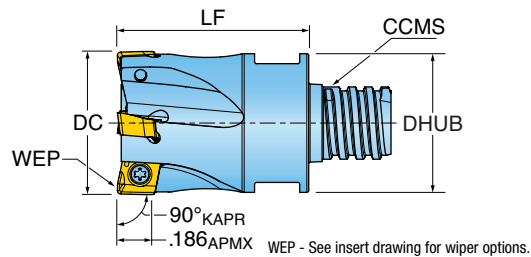


WEP - See insert drawing for wiper options.

Part Number	DC Cutting Dia.	LUX Usable Length Max.	LPR Protruding Length	OAL Overall Length	ZEFF Effective Teeth	DCON Shank Dia.	RMPX Ramp Angle Max.
1TJ1C-0600779R01	0.625	0.72	0.75	2.66	3	0.625	4.4
1TJ1C-0701284R01	0.750	1.22	1.25	3.25	4	0.750	3.3
1TJ1C-1001780R01	1.000	1.72	1.75	4.00	6	1.000	2.2
1TJ1C-1001784R01	1.000	1.75	1.75	3.75	5	0.750	2.2

SERIES 1TJ1C (T-ADAPTION STYLE) (5MM)

90° MODULAR END MILL WITH 2 INDEXES

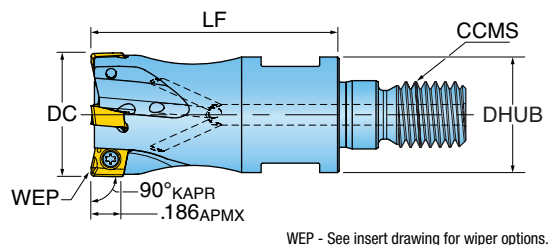


Part Number	DC Cutting Dia.	LF Functional Length	ZEFF Effective Teeth	CCMS Connection Code	DHUB Hub Dia.	CSP Coolant	RMPX Ramp Angle Max.
1TJ1C-05006T8R01	0.500	0.65	2	Chip Surfer T08	.48	Yes	6.9
1TJ1C-06008TRR01	0.625	0.80	3	Chip Surfer T10	.60	Yes	4.4
1TJ1C-07007T8R01*	0.750	0.75	4	Chip Surfer T08	.48	No	3.3
1TJ1C-07010TSR01	0.750	1.00	4	Chip Surfer T12	.72	Yes	3.3
1TJ1C-10007T8R01*	1.000	0.75	5	Chip Surfer T08	.48	No	2.2
1TJ1C-10012TUR01	1.000	1.25	5	Chip Surfer T15	.94	Yes	2.2

* Ideal for Swiss Machines. Recommend with SERIES ER16T08SA shanks.

SERIES 1TJ1C (M-ADAPTION STYLE) (5MM)

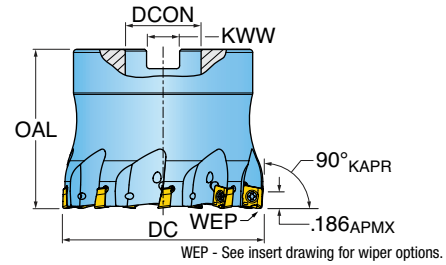
90° MODULAR END MILL WITH 2 INDEXES



Part Number	DC Cutting Dia.	LF Functional Length	ZEFF Effective Teeth	CCMS Connection Code	DHUB Hub Dia.	RMPX Ramp Angle Max.
1TJ1C-06010X5R01	0.625	1.00	3	TopOn M08	0.50	4.4
1TJ1C-07015X6R01	0.750	1.50	4	TopOn M10	0.69	3.3
1TJ1C-10015X7R01	1.000	1.50	5	TopOn M12	0.81	2.1

SERIES TJ1C (5MM)

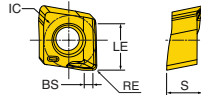
90° FACE MILL WITH 2 INDEXES



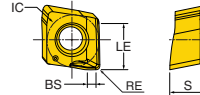
Part Number	DC Cutting Dia.	OAL Overall Length	ZEFF Effective Teeth	DCON Shank Dia.	KWW Keyway	RMPX Ramp Angle Max.
TJ1C-15R01	1.500	1.57	8	0.500	0.250	1.3
TJ1C-20R01	2.000	1.57	9	0.750	0.312	.9

INSERTS & HARDWARE (5MM)


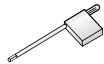



ENHU05R



ENHU05R-PH



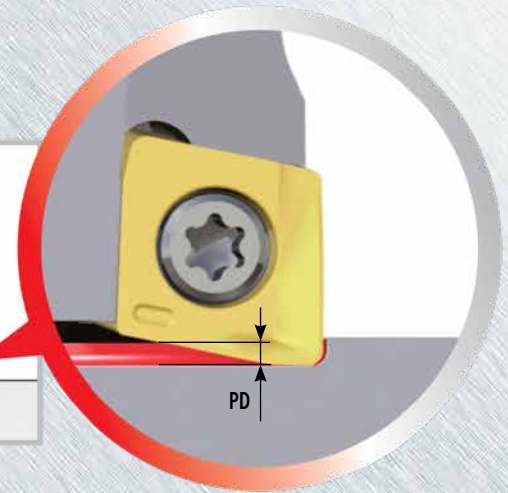
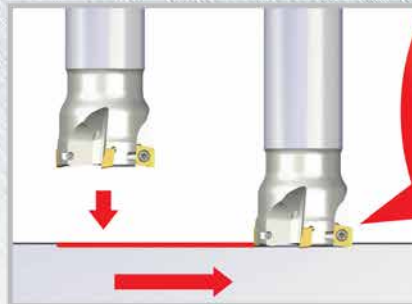
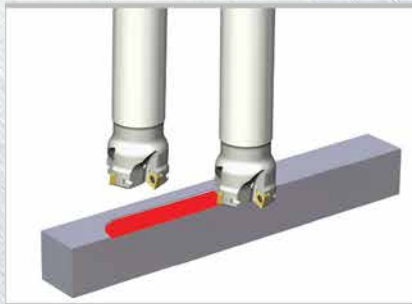
Part Number	RE/BCH Corner Radius/ Chamfer	BS Wiper Length	LE Cutting Edge Length	IC Inscribed Circle Dia.	S Thickness (To Cutting Edge)	NOI Number of Indexes	IH Insert Hand	Grade	IN2504	IN2505	IN2510	IN2530	IN6515	IN7035
ENHU050302R	0.008 R	0.030	0.180	0.203	0.133	2	Right		•		•			
ENHU050304R	0.015 R	0.030	0.180	0.203	0.133	2	Right	•	•	•	•	•	•	
ENHU050308R	0.031 R	0.015	0.180	0.203	0.133	2	Right	•	•	•	•	•	•	
ENHU050304R-PH	0.015 R	0.030	0.180	0.203	0.133	2	Right					•		•
ENHU050308R-PH	0.031 R	0.015	0.180	0.203	0.133	2	Right			•		•		•

	 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

OPERATING GUIDELINES

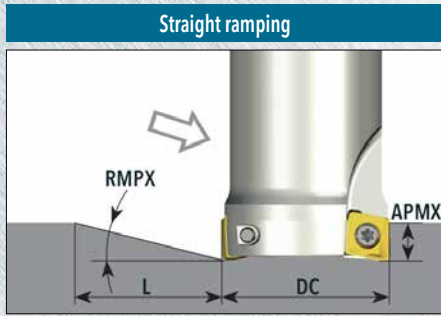
DiPos TETRA - Series 1TJ1C, TJ1C					IN7035	IN2504	IN2505	IN2510	IN2530	IN6515	Coolant
Material	Brinnell Hardness	SFM	Feed per Insert								
Cast Iron	Gray	150 - 250	300 - 1000	.003 - .007				1		2	No
	Nodular		300 - 600					2		1	
Steel	Low Carbon 1018, 8620	100 - 250	400 - 1000	.003 - .007							No
	High Carbon F-6180	250 - 400	350 - 500				2		1		
	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								Yes
	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

DRILL MILL POCKETING



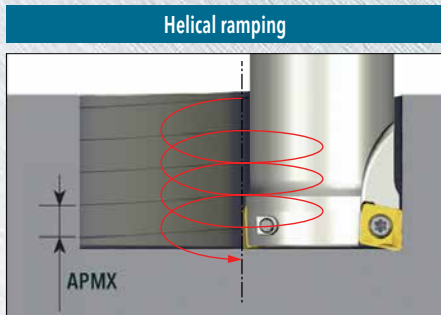
DC Cutting Dia.	PD Plunge Depth
0.500	0.027
0.650	0.027
0.750	0.027
1.000	0.027
1.500	0.027
2.000	0.027

STRAIGHT RAMPING DATA



DC Cutting Dia.	RMPX Ramping Angle	L	APMX
0.500	6.9	1.48	0.18
0.650	4.4	2.34	0.18
0.750	3.3	3.12	0.18
1.000	2.2	4.68	0.18
1.500	1.3	7.93	0.18
2.000	0.9	11.45	0.18

HELICAL RAMPING DATA



DC Cutting Dia.	MIN. Diameter Milled Hole	MIN. Advance Per Cutter Path Rev. (APCPR)	MAX. Diameter Milled Hole	APMX/Rev.
0.500	0.61	0.041	1.00	0.180
0.650	0.86	0.057	1.25	0.150
0.750	1.11	0.065	1.50	0.135
1.000	1.60	0.072	2.00	0.120
1.500	2.60	0.078	3.00	0.180
2.000	3.60	0.078	4.00	0.098