

GOLD SLOT



Slotters:

- 3VJ4V

Inserts:

- IXH

Grades:

- IN2535
- IN4005
- IN4015
- IN4030
- IN4035
- IN055

Applications:

- Slotting
- Back Facing



NEW THIN SLOTTERS WITH RIGID, SECURE INSERT SEATING

Gold-Slot™ offers unique seating surfaces for maximum protection for both the insert and the cutter body. Available in Top-On, Radial Drive and Axial Drive style bodies, this new addition to Ingersoll's slotter family will accommodate the most challenging of applications. New Gold-Slot inserts are offered in a variety of grades and also include 4 edges! (2 LH and 2 RH)

Features & Benefits:

- Significant advances in durability, accuracy and rigidity
- Diameters ranging from 1.50" thru 8.00"
- Cutting widths of .125" thru .500"
- Latest PVD oxide and nano scale multi-layer coatings
- Same insert used in RH and LH stations

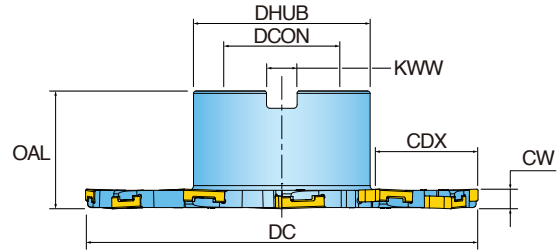
**PRODUCT
ANNOUNCEMENT**

UPDATE

2018

SERIES 3VJ4V

RADIAL SLOTTER

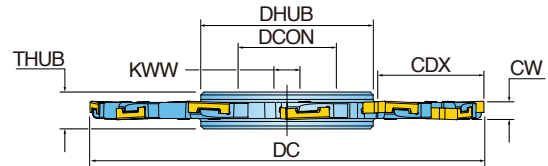


| Part Number | DC Cutting Dia. | CW Cutting Width | CDX Cutting Depth Max. | OAL Overall Length | ZEFP Effective Teeth | ZNP Insert Count | DHUB Hub Dia. | DCON Bore Dia. | KWW Keyway | Insert Series |
|------------------|-----------------------|------------------------|------------------------------|--------------------------|----------------------------|------------------------|---------------------|----------------------|---------------|------------------|
| 3VJ4V-02012D1R01 | 2.500 | 0.125 | 0.58 | 1.38 | 4 | 8 | 1.18 | 0.750 | 0.312 | IXH211 |
| 3VJ4V-02015D1R01 | 2.500 | 0.156 | 0.55 | 1.38 | 4 | 8 | 1.18 | 0.750 | 0.312 | IXH311 |
| 3VJ4V-02018D1R01 | 2.500 | 0.187 | 0.55 | 1.38 | 4 | 8 | 1.18 | 0.750 | 0.312 | IXH312 |
| 3VJ4V-02025D1R01 | 2.500 | 0.250 | 0.58 | 1.50 | 3 | 6 | 1.18 | 0.750 | 0.312 | IXH412 |
| 3VJ4V-03012D1R01 | 3.000 | 0.125 | 0.67 | 1.50 | 5 | 10 | 1.50 | 0.750 | 0.312 | IXH211 |
| 3VJ4V-03015D1R01 | 3.000 | 0.156 | 0.67 | 1.50 | 5 | 10 | 1.50 | 0.750 | 0.312 | IXH311 |
| 3VJ4V-03018D1R01 | 3.000 | 0.187 | 0.67 | 1.50 | 5 | 10 | 1.50 | 0.750 | 0.312 | IXH312 |
| 3VJ4V-03025D1R01 | 3.000 | 0.250 | 0.67 | 1.50 | 4 | 8 | 1.50 | 0.750 | 0.312 | IXH412 |
| 3VJ4V-04012D3R01 | 4.000 | 0.125 | 1.04 | 1.50 | 7 | 14 | 1.75 | 1.000 | 0.375 | IXH211 |
| 3VJ4V-04015D3R01 | 4.000 | 0.156 | 1.04 | 1.50 | 6 | 12 | 1.75 | 1.000 | 0.375 | IXH311 |
| 3VJ4V-04018D3R01 | 4.000 | 0.187 | 1.04 | 1.50 | 6 | 12 | 1.75 | 1.000 | 0.375 | IXH312 |
| 3VJ4V-04025D3R01 | 4.000 | 0.250 | 1.04 | 1.50 | 5 | 10 | 1.75 | 1.000 | 0.375 | IXH412 |
| 3VJ4V-04031D3R01 | 4.000 | 0.312 | 1.04 | 1.50 | 5 | 10 | 1.75 | 1.000 | 0.375 | IXH413 |
| 3VJ4V-04037D3R01 | 4.000 | 0.375 | 1.04 | 1.50 | 5 | 10 | 1.75 | 1.000 | 0.375 | IXH414 |
| 3VJ4V-04050D3R01 | 4.000 | 0.500 | 0.92 | 1.50 | 5 | 10 | 1.75 | 1.000 | 0.375 | IXH415 |
| 3VJ4V-05018D3R01 | 5.000 | 0.187 | 1.29 | 1.50 | 7 | 14 | 2.25 | 1.000 | 0.375 | IXH312 |
| 3VJ4V-05025D3R01 | 5.000 | 0.250 | 1.29 | 1.50 | 6 | 12 | 2.25 | 1.000 | 0.375 | IXH412 |
| 3VJ4V-05037D3R01 | 5.000 | 0.375 | 1.29 | 1.50 | 6 | 12 | 2.25 | 1.000 | 0.375 | IXH414 |
| 3VJ4V-05050D3R01 | 5.000 | 0.500 | 1.04 | 1.50 | 6 | 12 | 2.25 | 1.000 | 0.375 | IXH415 |
| 3VJ4V-0601558R01 | 6.000 | 0.156 | 1.38 | 2.00 | 9 | 18 | 3.07 | 1.500 | 0.625 | IXH311 |
| 3VJ4V-0601858R01 | 6.000 | 0.187 | 1.38 | 2.00 | 9 | 18 | 3.07 | 1.500 | 0.625 | IXH312 |
| 3VJ4V-0602558R01 | 6.000 | 0.250 | 1.38 | 2.00 | 7 | 14 | 3.07 | 1.500 | 0.625 | IXH412 |
| 3VJ4V-0603158R01 | 6.000 | 0.312 | 1.38 | 2.00 | 7 | 14 | 3.07 | 1.500 | 0.625 | IXH413 |
| 3VJ4V-0603758R01 | 6.000 | 0.375 | 1.38 | 2.00 | 7 | 14 | 3.07 | 1.500 | 0.625 | IXH414 |
| 3VJ4V-0605058R01 | 6.000 | 0.500 | 1.01 | 2.00 | 7 | 14 | 3.07 | 1.500 | 0.625 | IXH415 |
| 3VJ4V-0803158R01 | 8.000 | 0.312 | 2.02 | 2.00 | 9 | 18 | 3.80 | 1.500 | 0.625 | IXH413 |
| 3VJ4V-0803758R01 | 8.000 | 0.375 | 2.02 | 2.00 | 9 | 18 | 3.80 | 1.500 | 0.625 | IXH414 |
| 3VJ4V-0805058R01 | 8.000 | 0.500 | 2.01 | 2.00 | 9 | 18 | 3.80 | 1.500 | 0.625 | IXH415 |

GOLD SLOT

SERIES 3VJ4V

AXIAL SLOTTER



| Part Number | DC Cutting Dia. | CW Cutting Width | CDX Cutting Depth Max. | THUB Hub Thickness | ZEPF Effective Teeth | ZNP Insert Count | DHUB Hub Dia. | DCON Bore Dia. | KWW Keyway | Insert Series |
|------------------|-----------------------|------------------------|------------------------------|--------------------------|----------------------------|------------------------|---------------------|----------------------|---------------|------------------|
| 3VJ4V-03012AF-01 | 3.000 | 0.125 | 0.66 | 0.375 | 5 | 10 | 1.56 | 1.000 | 0.250 | IXH211 |
| 3VJ4V-03015AF-01 | 3.000 | 0.156 | 0.66 | 0.375 | 5 | 10 | 1.56 | 1.000 | 0.250 | IXH311 |
| 3VJ4V-03018AF-01 | 3.000 | 0.187 | 0.66 | 0.375 | 5 | 10 | 1.56 | 1.000 | 0.250 | IXH312 |
| 3VJ4V-04012AF-01 | 4.000 | 0.125 | 1.07 | 0.375 | 7 | 14 | 1.75 | 1.000 | 0.250 | IXH211 |
| 3VJ4V-04015AF-01 | 4.000 | 0.156 | 1.07 | 0.375 | 6 | 12 | 1.75 | 1.000 | 0.250 | IXH311 |
| 3VJ4V-04018AF-01 | 4.000 | 0.187 | 1.07 | 0.375 | 6 | 12 | 1.75 | 1.000 | 0.250 | IXH312 |
| 3VJ4V-04025AF-01 | 4.000 | 0.250 | 1.07 | 0.375 | 5 | 10 | 1.75 | 1.000 | 0.250 | IXH412 |
| 3VJ4V-04031AG-01 | 4.000 | 0.312 | 1.02 | 0.375 | 5 | 10 | 1.87 | 1.250 | 0.312 | IXH413 |
| 3VJ4V-04037AG-01 | 4.000 | 0.375 | 1.02 | 0.375 | 5 | 10 | 1.87 | 1.250 | 0.312 | IXH414 |
| 3VJ4V-04050AG-01 | 4.000 | 0.500 | 0.83 | 0.375 | 5 | 10 | 1.75 | 1.250 | 0.312 | IXH415 |
| 3VJ4V-05018AG-01 | 5.000 | 0.187 | 1.51 | 0.375 | 7 | 14 | 1.87 | 1.250 | 0.312 | IXH312 |
| 3VJ4V-05025AF-01 | 5.000 | 0.250 | 1.51 | 0.375 | 6 | 12 | 1.87 | 1.000 | 0.250 | IXH412 |
| 3VJ4V-05050AH-01 | 5.000 | 0.500 | 1.08 | 0.500 | 6 | 12 | 2.25 | 1.500 | 0.375 | IXH415 |
| 3VJ4V-06015AG-01 | 6.000 | 0.156 | 2.01 | 0.375 | 9 | 18 | 1.87 | 1.250 | 0.312 | IXH311 |
| 3VJ4V-06018AG-01 | 6.000 | 0.187 | 2.01 | 0.375 | 9 | 18 | 1.87 | 1.250 | 0.312 | IXH312 |
| 3VJ4V-06025AG-01 | 6.000 | 0.250 | 2.01 | 0.375 | 7 | 14 | 1.87 | 1.250 | 0.312 | IXH412 |
| 3VJ4V-06031AG-01 | 6.000 | 0.312 | 2.02 | 0.375 | 7 | 14 | 1.87 | 1.250 | 0.312 | IXH413 |
| 3VJ4V-06037AG-01 | 6.000 | 0.375 | 2.02 | 0.375 | 7 | 14 | 1.87 | 1.250 | 0.312 | IXH414 |
| 3VJ4V-06050AH-01 | 6.000 | 0.500 | 1.58 | 0.500 | 7 | 14 | 1.87 | 1.500 | 0.375 | IXH415 |
| 3VJ4V-08025AH-01 | 8.000 | 0.250 | 2.57 | 0.375 | 9 | 18 | 2.75 | 1.500 | 0.375 | IXH412 |
| 3VJ4V-08031AH-01 | 8.000 | 0.312 | 2.58 | 0.375 | 9 | 18 | 2.75 | 1.500 | 0.375 | IXH413 |
| 3VJ4V-08037AH-01 | 8.000 | 0.375 | 2.58 | 0.375 | 9 | 18 | 2.75 | 1.500 | 0.375 | IXH414 |
| 3VJ4V-08050AK-01 | 8.000 | 0.500 | 2.20 | 0.500 | 7 | 14 | 3.07 | 2.000 | 0.500 | IXH415 |

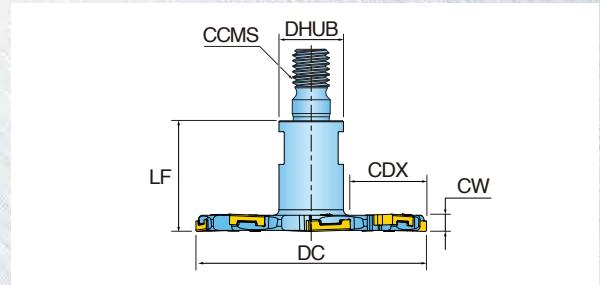
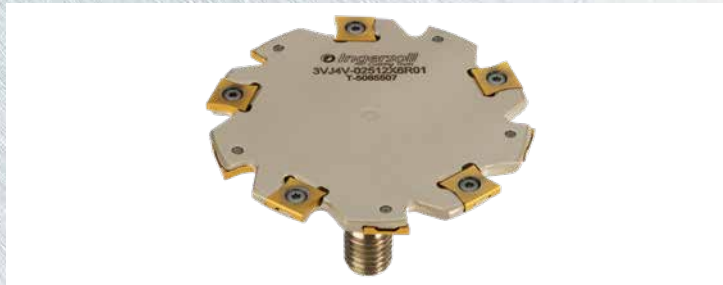
GOLD SLOT

SERIES 3VJ4V

TOP-ON STYLE SLOTTOR



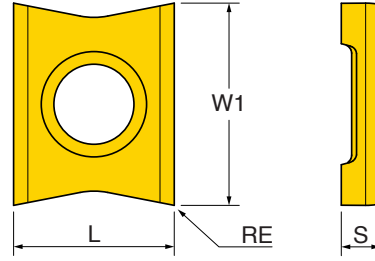
Slotting



| Part Number | DC Cutting Dia. | CW Cutting Width | CDX Cutting Depth Max. | LF Functional Length | ZEFP Effective Teeth | ZNP Insert Count | CCMS Connection Code | DHUB Hub Dia. | Insert Series |
|------------------|-----------------------|------------------------|------------------------------|----------------------------|----------------------------|------------------------|----------------------------|---------------------|------------------|
| 3VJ4V-01512X5R01 | 1.500 | 0.125 | 0.41 | 0.80 | 3 | 6 | M8 | 0.50 | IXH211 |
| 3VJ4V-02012X6R01 | 2.000 | 0.125 | 0.57 | 0.80 | 4 | 8 | M10 | 0.70 | IXH211 |
| 3VJ4V-02015X6R01 | 2.000 | 0.156 | 0.56 | 1.00 | 3 | 6 | M10 | 0.70 | IXH311 |
| 3VJ4V-02018X6R01 | 2.000 | 0.187 | 0.56 | 1.20 | 3 | 6 | M10 | 0.70 | IXH312 |
| 3VJ4V-02512X6R01 | 2.500 | 0.125 | 0.82 | 0.80 | 5 | 10 | M10 | 0.70 | IXH211 |
| 3VJ4V-02515X6R01 | 2.500 | 0.156 | 0.82 | 1.00 | 4 | 8 | M10 | 0.70 | IXH311 |
| 3VJ4V-02518X6R01 | 2.500 | 0.187 | 0.82 | 1.20 | 4 | 8 | M10 | 0.70 | IXH312 |
| 3VJ4V-02525X6R01 | 2.500 | 0.250 | 0.82 | 1.40 | 5 | 10 | M10 | 0.70 | IXH412 |
| 3VJ4V-03518X8R01 | 3.500 | 0.187 | 1.10 | 1.00 | 5 | 10 | M16 | 1.13 | IXH312 |

GOLD SLOT





INSERTS



| Part Number | Application | L Length | W1 Width | S Thickness | RE Corner Radius | Grade | | | | | |
|--------------|---------------|-------------|-------------|----------------|------------------------|-------|--------|--------|--------|--------|--------|
| | | | | | | IN05S | IN2535 | IN4005 | IN4015 | IN4030 | IN4035 |
| IXH211-G01 | Multi-Purpose | 0.310 | 0.330 | 0.070 | 0.015 | | ● | | | | ● |
| IXH211-G01-P | Aluminum | 0.310 | 0.330 | 0.070 | 0.015 | ● | | | | | |
| IXH311-G01 | Multi-Purpose | 0.350 | 0.440 | 0.085 | 0.015 | | ● | ● | ● | ● | ● |
| IXH311-G01-P | Aluminum | 0.350 | 0.440 | 0.085 | 0.015 | ● | | | | | |
| IXH311-G02 | Multi-Purpose | 0.350 | 0.440 | 0.085 | 0.031 | | ● | ● | ● | | ● |
| IXH311-G02-P | Aluminum | 0.350 | 0.440 | 0.085 | 0.031 | ● | | | | | |
| IXH312-G01 | Multi-Purpose | 0.350 | 0.440 | 0.113 | 0.015 | | ● | ● | ● | ● | ● |
| IXH312-G01-P | Aluminum | 0.350 | 0.440 | 0.113 | 0.015 | ● | | | | | |
| IXH312-G02 | Multi-Purpose | 0.350 | 0.440 | 0.113 | 0.031 | | ● | ● | ● | | ● |
| IXH312-G02-P | Aluminum | 0.350 | 0.440 | 0.113 | 0.031 | ● | | | | | |
| IXH412-G01 | Multi-Purpose | 0.420 | 0.553 | 0.153 | 0.015 | | ● | ● | ● | ● | ● |
| IXH412-G01-P | Aluminum | 0.420 | 0.553 | 0.153 | 0.015 | ● | | | | | |
| IXH412-G02 | Multi-Purpose | 0.419 | 0.553 | 0.153 | 0.031 | | ● | ● | ● | ● | ● |
| IXH412-G02-P | Aluminum | 0.419 | 0.553 | 0.153 | 0.031 | ● | | | | | |
| IXH412-G03 | Multi-Purpose | 0.417 | 0.552 | 0.153 | 0.062 | | | ● | | | ● |
| IXH413-G01 | Multi-Purpose | 0.423 | 0.554 | 0.191 | 0.015 | | ● | ● | | | ● |
| IXH413-G01-P | Aluminum | 0.423 | 0.554 | 0.191 | 0.015 | ● | | | | | |
| IXH413-G02 | Multi-Purpose | 0.421 | 0.553 | 0.191 | 0.031 | | ● | ● | | | ● |
| IXH413-G02-P | Aluminum | 0.421 | 0.553 | 0.191 | 0.031 | ● | | | | | |
| IXH414-G01 | Multi-Purpose | 0.424 | 0.554 | 0.231 | 0.015 | | ● | ● | | | ● |
| IXH414-G01-P | Aluminum | 0.424 | 0.554 | 0.231 | 0.015 | ● | | | | | |
| IXH414-G02 | Multi-Purpose | 0.423 | 0.554 | 0.231 | 0.031 | | ● | ● | | | ● |
| IXH414-G02-P | Aluminum | 0.423 | 0.554 | 0.231 | 0.031 | ● | | | | | |
| IXH414-G03 | Multi-Purpose | 0.421 | 0.553 | 0.231 | 0.062 | | ● | ● | | ● | ● |
| IXH415-G01 | Multi-Purpose | 0.428 | 0.555 | 0.298 | 0.015 | | ● | ● | ● | ● | ● |
| IXH415-G01-P | Aluminum | 0.428 | 0.555 | 0.298 | 0.015 | ● | | | | | |
| IXH415-G02 | Multi-Purpose | 0.427 | 0.554 | 0.298 | 0.031 | | ● | ● | ● | ● | ● |
| IXH415-G02-P | Aluminum | 0.427 | 0.554 | 0.298 | 0.031 | ● | | | | | |
| IXH415-G03 | Multi-Purpose | 0.425 | 0.554 | 0.298 | 0.062 | | ● | ● | ● | ● | ● |
| IXH415-G03-P | Aluminum | 0.425 | 0.554 | 0.298 | 0.062 | ● | | | | | |
| IXH415-G04 | Multi-Purpose | 0.425 | 0.554 | 0.298 | 0.125 | | ● | ● | ● | ● | ● |
| IXH415-G04-P | Aluminum | 0.425 | 0.554 | 0.298 | 0.125 | ● | | | | | |

● = P ● = M ● = K ● = N ● = S ○ = H

HARDWARE

| Slotter Width | Insert Series |  |  |  |  | Recommended Torque (in. lbs.) |
|---------------|---------------|---|---|---|---|-------------------------------|
| | | Screw | Driver | Driver Handle | Driver Bit | |
| .125" | IXH211 | SM25-025-80 | DS-T06F | - | - | 4-7 |
| .156" | IXH311 | SM35-034-50 | DS-T09W | - | - | 10-13 |
| .187" | IXH312 | SM35-042-50 | DS-T09W | - | - | 10-13 |
| .250" | IXH412 | SM40-055-50 | - | DS-A00T | DS-T156B | 21-24 |
| .312" | IXH413 | SM40-070-50 | - | DS-A00T | DS-T156B | 21-24 |
| .375" | IXH414 | SM40-080-50 | - | DS-A00T | DS-T156B | 21-24 |
| .500" | IXH415 | SM40-110-00 | - | DS-A00T | DS-T156B | 25-30 |

OPERATING GUIDELINES

| Material | | Brinnell Hardness | SFM | Feed per Insert WOC | | IN2535 | IN4005 | IN4015 | IN4030 | IN4035 | IN055 | Coolant |
|-----------------|--|-------------------|-----------|---------------------|-------------|--------|--------|--------|--------|--------|-------|---------|
| | | | | ≤ .187" | ≥ .250" | | | | | | | |
| Aluminum | 6061, 7075 | - | 1000+ | .004 - .008 | .006 - .015 | | | | | | 1 | Yes |
| Cast Iron | Gray | 100 - 300 | 400 - 750 | .002 - .006 | .004 - .010 | | 2 | 1 | | | | No |
| | Nodular | | 300 - 650 | | | | | | | | | |
| Steel | Low Carbon 1018, 8620 | 100 - 250 | 350 - 600 | .002 - .006 | .004 - .010 | 3 | 1 | | 2 | | | No |
| | High Carbon F-6180, Nitralloy 52100 | 250 - 400 | 250 - 500 | | | | | | 1 | | | |
| | Alloyed Steel 4140, 4340, 6150 | 150 - 350 | 250 - 400 | | | | 2 | 1 | | | | |
| | Tool Steel A-6, D-1, D-2, P20 | 300 - 500 | 250 - 400 | | | | | | | | | |
| Stainless Steel | 300 Series, 304, 316 | - | 250 - 400 | .002 - .006 | .004 - .010 | 1 | | | 3 | 2 | | Yes |
| | 400 Series 15-5 PH, 17-4 PH | Up to 420 | 300 - 600 | | | | | | | | | |
| | 13-8 PH | - | 200 - 250 | | | | | | | | | |
| Nickel Alloys | Inconel 600, 706, 718, 903, Hastelloy, Waspalloy | - | 75-120 | .002 - .006 | .004 - .010 | 1 | | | 3 | 2 | | Yes |
| Titanium | 6AL-4V | - | 100 - 150 | .002 - .006 | .004 - .010 | 1 | | | 3 | 2 | | Yes |