

GOLD-SLOT



Slotters:

- 3VJ4V

Inserts:

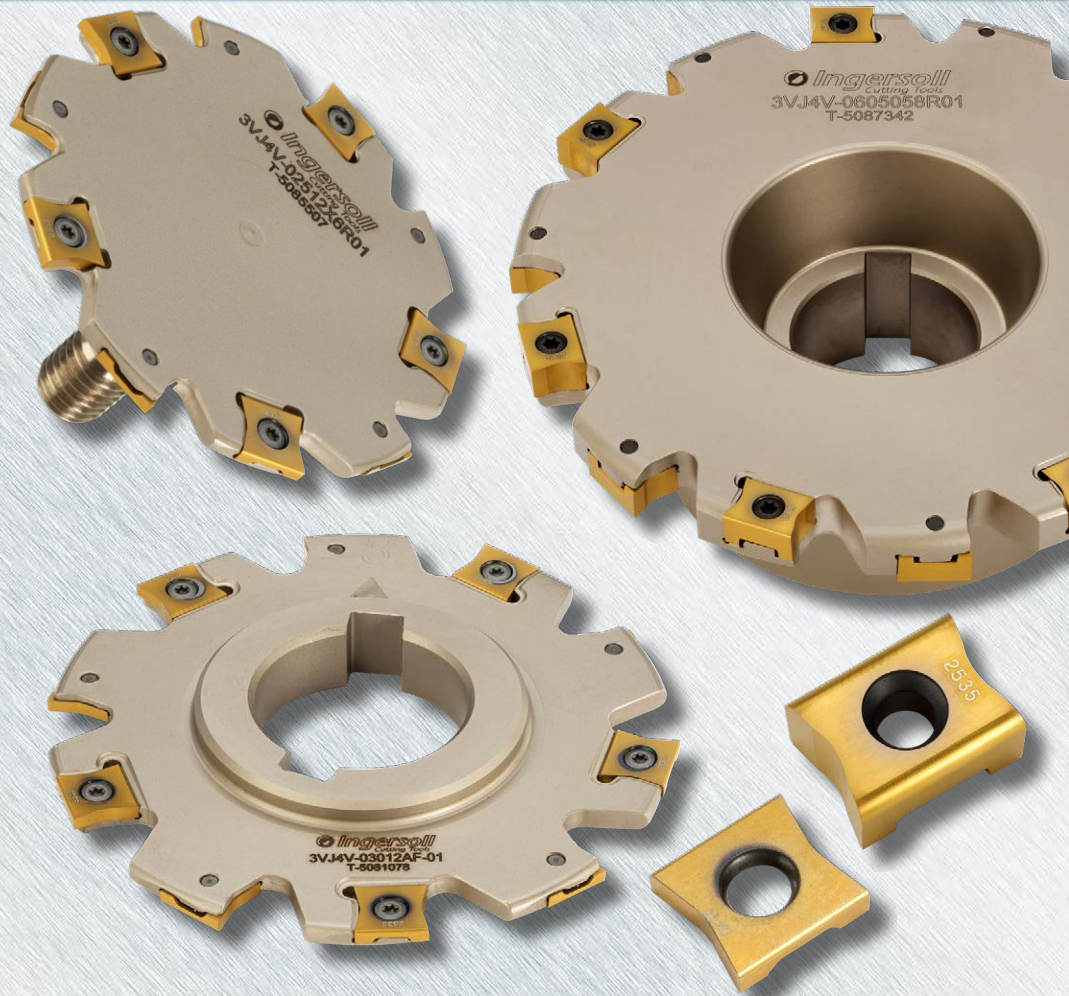
- IXH

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

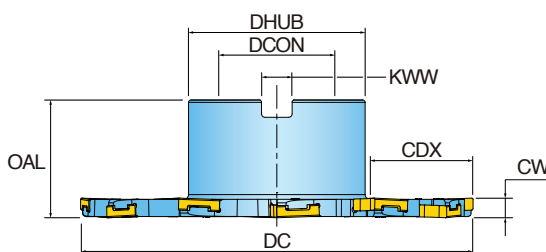
**PRODUCT
ANNOUNCEMENT**
• UPDATE •
2021

SERIES 3VJ4V

RADIAL SLOTTER



Slotting



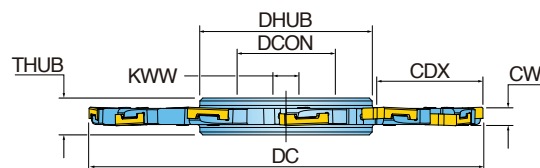
Part Number	DC Cutting Dia.	CW Cutting Width	CDX Cutting Depth Max.	OAL Overall Length	ZEFP Effective Teeth	ZNP Insert Count	DHUB Hub Dia.	DCON Bore Dia.	KWW Keyway	Insert Series
3VJ4V-02012D1R01	2.500	0.125	0.58	1.38	4	8	1.18	0.750	0.312	IXH211
3VJ4V-02015D1R01	2.500	0.156	0.55	1.38	4	8	1.18	0.750	0.312	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

SERIES 3VJ4V

AXIAL SLOTTER



Slotting



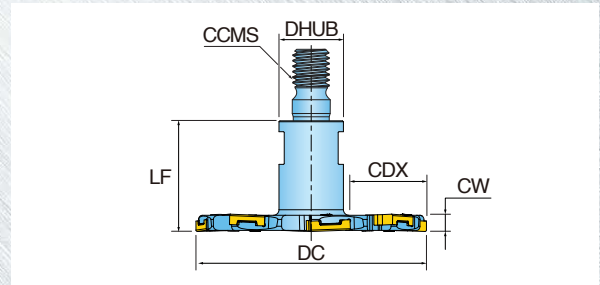
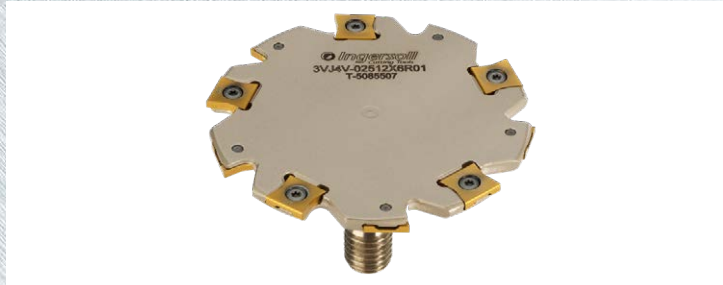
Part Number	DC Cutting Dia.	CW Cutting Width	CDX Cutting Depth Max.	THUB Hub Thickness	ZEFP Effective Teeth	ZNP Insert Count	DHUB Hub Dia.	DCON Bore Dia.	KWW Keyway	Insert Series
3VJ4V-03012AF-01	3.000	0.125	0.66	0.375	5	10	1.56	1.000	0.250	IXH211
3VJ4V-03015AF-01	3.000	0.156	0.66	0.375	5	10	1.56	1.000	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

SERIES 3VJ4V

TOP-ON STYLE SLOTTOR

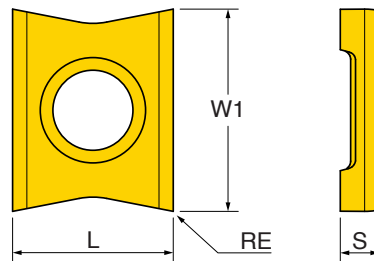


Slotting



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	3	6	M10	0.70	IXH412
3VJ4V-03518X8R01	3.500	0.187	1.10	1.00	5	10	M16	1.13	IXH312

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									
	Alloyed Steel 4140, 4340, 6150	150 - 350	250 - 400				2	1				
	Tool Steel A-6, D-1, D-2, P20	300 - 500										
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