

GOLDOTRIO 13

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

Diameters:
Ø2.000" - Ø 6.500"

Depth of Cut:
.57"

Insert Series:
TH_S13
THS13_P
THLS13_HR

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

Multi-Purpose



R.031



R.062



R.094



R.125

Polished for Aluminum



R.015

SS/Hi-Temp/Ti



R.031



R.062



R.094



R.125



R.031



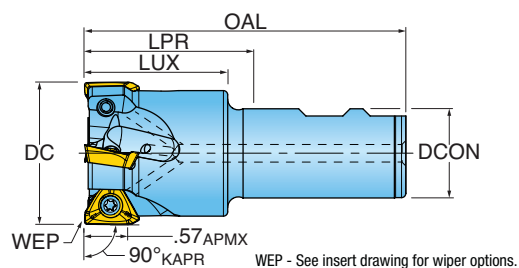
General Features:

- 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 and milling methods
- Inserts equipped with integrated wipers for surface finishes between 32-63 Ra
- Cutters offered with coolant through
- Ramping capability for versatility
- 6.500 diameter cutter ideal for use on boring mills with 6.0" quill.

**PRODUCT
ANNOUNCEMENT
• UPDATE •
2019**

GOLDOTRIO SERIES: 1KJ1P (WELDON SHANK)

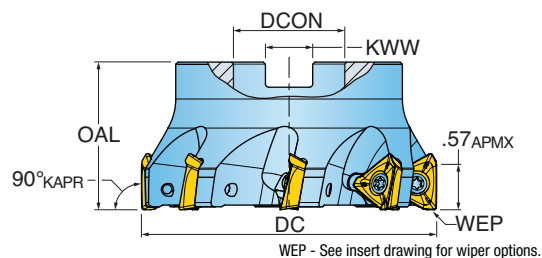
90° END MILL



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.
1KJ1P-2002281R01	2.000	2.25	2.25	4.50	4	1.250	Yes	1.5

GOLDOTRIO SERIES: KJ5P, KJ6P

90° FACE MILL

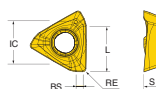


Part Number	DC Cutting Diameter	OAL Overall Length	ZEFF Effective Teeth	DCON Bore Diameter	KWW Keyway	CSP Coolant	RMPX Ramp Angle Max.
KJ6P-30R01	3.000	1.75	6	1.000	0.375	Yes	1.3
KJ5P-40R01	4.000	1.75	8	1.500	0.625	No	1
KJ6P-40R01	4.000	1.75	6	1.500	0.625	No	1
KJ6P-50R01	5.000	2.00	9	1.500	0.625	No	.8
KJ5P-60R01	6.000	2.00	12	1.500	0.625	No	.6
KJ6P-60R01	6.000	2.00	8	1.500	0.625	No	.6
NEW KJ6P-65R01*	6.500	2.00	10	1.500	0.625	No	.4

* Ideal for use on Boring Mills with 6.0" quill.

GOLD[®]TRIO INSERTS

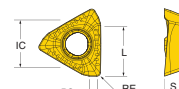
THES13_P



THLS13



THLS13_HR



Part Number	Application	RE Corner Radius	BS Wiper Length	L Cutting Edge Length	IC Inscribed Circle Diameter	S Thickness	Grade	IN10K	IN2035	IN2505	IN2510	IN2530	IN2540	IN4030
THES130604FR-P	Grd/Pol for Al	0.015 R	0.078	0.590	0.531	0.236	•							
THES130608FR-P	Grd/Pol for Al	0.031 R	0.078	0.590	0.531	0.236	•							
THLS130608R	Multi-Purpose	0.031 R	0.078	0.590	0.531	0.236				•	•	•	•	•
THLS130616R	Multi-Purpose	0.062 R	0.047	0.590	0.531	0.236				•		•		
THLS130624R	Multi-Purpose	0.094 R	0.024	0.590	0.531	0.236				•				
THLS130632R	Multi-Purpose	0.125 R	0.020	0.590	0.531	0.236				•				
THLS130608R-HR	SS/Hi-Temp/Ti	0.031 R	0.078	0.590	0.531	0.236			•	•		•		
THLS130616R-HR	SS/Hi-Temp/Ti	0.062 R	0.047	0.590	0.531	0.236			•					
THLS130624R-HR	SS/Hi-Temp/Ti	0.094 R	0.024	0.590	0.531	0.236			•					
THLS130632R-HR	SS/Hi-Temp/Ti	0.125 R	0.020	0.590	0.531	0.236			•					

GOLD[®]TRIO HARDWARE



Insert Screw



Driver Handle



Torx Driver Blade



Retention Bolt

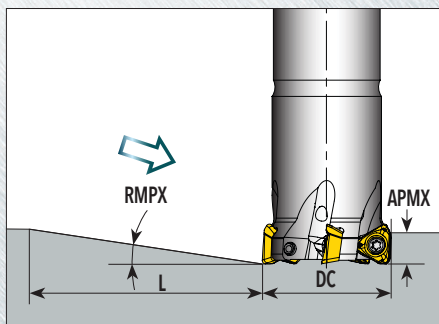
1KJ1P-2002281R01	SM45-120-R0	DS-A00T	DS-T206B	-
KJ6P-30R01	SM45-120-R0	DS-A00T	DS-T206B	SD-08-46
KJ5P-40R01	SM45-120-R0	DS-A00T	DS-T206B	-
KJ6P-40R01	SM45-120-R0	DS-A00T	DS-T206B	-
KJ6P-50R01	SM45-120-R0	DS-A00T	DS-T206B	-
KJ5P-60R01	SM45-120-R0	DS-A00T	DS-T206B	-
KJ6P-60R01	SM45-120-R0	DS-A00T	DS-T206B	-
KJ6P-65R01	SM45-120-R0	DS-A00T	DS-T206B	-

GOLD[®]TRIO OPERATING GUIDELINES - SERIES 1KJ1P, KJ_P

Series 1KJ1P, KJ_P					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-.010			3	1			4	No
	Nodular		300 - 600				3	1			4	
Steel	Low Carbon 1018, 8620	100 - 250	400 - 1000	.004-.009			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-.008		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-.006		1	2		4		3	Yes
Titanium	6AL-4V	-	100 - 150	.004-.006		1	4		3		2	Yes

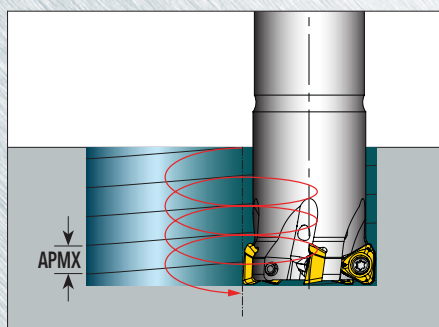
GOLD[®]TRIO RAMPING DATA

Straight ramping



DC Cutter Diameter	RMPX Ramp Angle Max.	APMX Depth of Cut Max.	L
2.000	1.5	0.57	21.7
3.000	0.8	0.57	40.8
4.000	0.6	0.57	54.4
5.000	0.5	0.57	65.3
6.000	0.4	0.57	81.6
6.500	0.2	0.57	163

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.
2.000	3.49	0.14	3.92	0.16
3.000	5.51	0.13	5.92	0.14
4.000	7.51	0.12	7.92	0.14
5.000	9.53	0.12	9.92	0.13
6.000	11.53	0.12	11.92	0.13
6.500	12.53	0.12	12.92	0.13