FORM MASTER SHEAR™

Insert Style:
RJLT (MOTN, MON, MONLL)
RJLW (MOTN)
RJET (MOFN)

Radial Drive:
35B6E (8 mm IC insert)
35B6G (10 mm IC insert)
35B6H (12 mm IC insert)

Axial Drive:
35B6E / AZ (8 mm IC insert)
35B6E / AF (8 mm IC insert)
35B6G / AZ (10 mm IC insert)
35B6G / AF (10 mm IC insert)
35B6H / AF (12 mm IC insert)

Modular:
15T8E (8 mm IC insert)
15T1G (10 mm IC insert)

Grades:
IN2035, IN7035, IN2530, IN2540, IN2505, IN2504, IN10K

Applications:
Power Generation, General Machining

Multi-Purpose

SS/Hi-Temp/Ti

Polished for Aluminum

Contouring Disc Slotters

Features and Benefits:

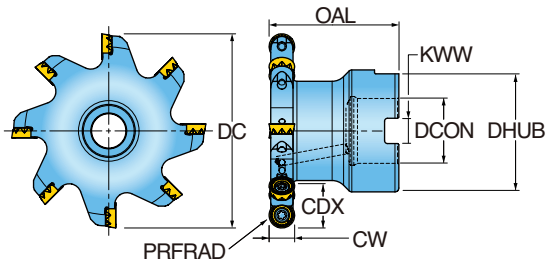
- Radial drive, axial drive and modular (M20 connection) cutter bodies
- Coarse and fine-pitch cutters
- 8 mm, 10 mm, 12 mm IC button sizes
- Well-designed insert geometries promote longer tool life
- Wide range of insert edge preparations to address all applications
- Premium milling grades to cut all materials
- Strong clamping screw for secure and stable insert seating
- Anti-rotating insert clamping
- Robust thick inserts for added strength
- Available Integral (M20) CAT 40, CAT50 and cylindrical shanks
- Ultra-reliable machining performance!
- Excellent internal and external contour milling performance!!

INDUSTRY 4.0 UPDATE PRODUCT ANNOUNCEMENT 2022

Member IMC Group
Ingersoll Cutting Tools

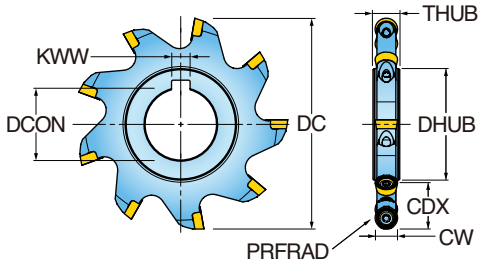
SERIES 35B6E, 35B6G, 35B6H

RADIAL DRIVE CONTOURING DISC SLOTTER



Part Number	DC Cutting Diameter	OAL Overall Length	CW Width of Cut	DHUB Hub Diameter	CDX Max. Radial DOC	DCON Bore Diameter	KWW Keyway	PRFRAD Profile Radius	ZNP Total No. of Inserts	CSP Coolant	Insert Inscribed Circle
35B6E-25031D1R01	2.500	2.00	0.315	1.58	0.54	0.750	0.31	4mm (0.157)	8	Yes	8mm (.315)
35B6E-25031D1R02	2.500	2.00	0.315	1.58	0.54	0.750	0.31	4mm (0.157)	9	Yes	8mm (.315)
35B6E-30031D3R01	3.000	2.00	0.315	1.88	0.68	1.000	0.38	4mm (0.157)	9	Yes	8mm (.315)
35B6G-25039D1R02	2.500	2.00	0.394	1.58	0.54	0.750	0.31	5mm (0.197)	6	Yes	10mm (.394)
35B6G-25039D1R01	2.500	2.00	0.394	1.58	0.54	0.750	0.31	5mm (0.197)	8	Yes	10mm (.394)
35B6G-30039D3R01	3.000	2.00	0.394	1.88	0.68	1.000	0.38	5mm (0.197)	8	Yes	10mm (.394)
35B6H-32047D3R01	3.250	2.50	0.472	2.13	0.78	1.000	0.38	6mm (0.236)	6	Yes	12mm (.472)
35B6H-40047D3R01	4.000	2.50	0.472	2.13	1.02	1.000	0.38	6mm (0.236)	8	Yes	12mm (.472)
35B6H-50047D3R01	5.000	2.50	0.472	2.13	1.52	1.000	0.38	6mm (0.236)	10	Yes	12mm (.472)

AXIAL DRIVE CONTOURING DISC SLOTTER

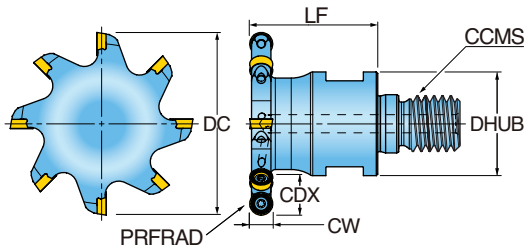


Part Number	DC Cutting Diameter	CW Width of Cut	DHUB Hub Diameter	CDX Max. Radial DOC	DCON Bore Diameter	KWW Keyway	THUB Hub Width	PRFRAD Profile Radius	ZNP Total No. of Inserts	CSP Coolant	Insert Inscribed Circle
35B6E-02031AZ-01	2.500	0.32	1.250	0.60	0.75	0.250	0.375	4mm (0.157)	8	No	8mm (.315)
35B6E-03031AF-01	3.000	0.32	1.560	0.69	1.00	0.250	0.375	4mm (0.157)	9	No	8mm (.315)
35B6G-02039AZ-02	2.500	0.39	1.250	0.60	0.75	0.250	0.500	5mm (0.197)	6	No	10mm (.394)
35B6G-02039AZ-01	2.500	0.39	1.250	0.60	0.75	0.250	0.500	5mm (0.197)	8	No	10mm (.394)
35B6G-03039AF-01	3.000	0.39	1.560	0.69	1.00	0.250	0.500	5mm (0.197)	8	No	10mm (.394)
35B6H-03047AF-02	3.250	0.47	1.560	0.82	1.00	0.250	0.500	6mm (0.236)	6	No	12mm (.472)
35B6H-03047AF-01	3.500	0.47	1.560	0.94	1.00	0.250	0.500	6mm (0.236)	5	No	12mm (.472)
35B6H-04047AF-01	4.000	0.47	1.560	1.19	1.00	0.250	0.500	6mm (0.236)	8	No	12mm (.472)
35B6H-05047AF-01	5.000	0.47	1.560	1.69	1.00	0.250	0.500	6mm (0.236)	10	No	12mm (.472)

SERIES 15T8E, 15T1G

TOPON MODULAR CONTOURING DISC SLOTTER

Slotting | Contour | Coolant



Part Number	DC Cutting Dia.	LF Functional Length	CW Width of Cut	DHUB Hub Dia.	CCMS Connection Code	CDX Max. Radial DOC	PRFRAD Profile Radius	ZNP No. of Eff. Inserts	CSP Coolant	Insert Inscribed Circle
15T8E-25031X9R01	2.500	1.75	0.315	1.42	M20	0.51	4mm (0.157)	8	Yes	8mm (.315)
15T8E-30031X9R01	3.000	1.75	0.315	1.42	M20	0.76	4mm (0.157)	9	Yes	8mm (.315)
15T1G-25039X9R01	2.500	1.75	0.394	1.42	M20	0.51	5mm (0.197)	6	Yes	10mm (.394)
15T1G-25039X9R02	2.500	1.75	0.394	1.42	M20	0.51	5mm (0.197)	8	Yes	10mm (.394)
15T1G-30039X9R01	3.000	1.75	0.394	1.42	M20	0.76	5mm (0.197)	8	Yes	10mm (.394)

INSERTS

Part Number	Description	IC Inscribed Circle Diameter	S Thickness (To Cutting Edge)	Grade	IN2505	IN2504	IN2540	IN2530	IN2035	IN7035	IN10K
RJET0803MOFN	Grd/Pol for Al - 4mm R	8mm	0.126								•
RJLT0803MON	Precision, Pos - 4 mm R	8 mm	0.126		•			•	•	•	
RJLT0803MOTN	Standard, Pos - 4 mm R	8 mm	0.126		•	•				•	
RJLW0803MOTN	Heavy Duty, Flt - 4 mm R	8 mm	0.126		•	•					
RJLT1004MON	Precision, Pos - 5mm R	10 mm	0.157		•			•	•	•	
RJLT1004MONLL	Precision, Pos - 5mm R	10 mm	0.157							•	
RJLT1004MOTN	Standard, Pos - 5mm R	10 mm	0.157		•	•		•	•	•	
RJLW1004MOTN	Heavy Duty, Flt - 5mm R	10 mm	0.157		•	•		•			
RJET1004MOFN	Grd/Pol for Al - 5mm R	10 mm	0.157								•
RJLT1204MON	Precision, Pos - 6mm R	12 mm	0.189		•			•	•	•	
RJLT1204MONLL	Precision, Pos - 6mm R	12 mm	0.189						•	•	
RJLT1204MOTN	Standard, Pos - 6mm R	12 mm	0.189		•	•	•	•	•	•	
RJLW1204MOTN	Heavy Duty, Flt - 6mm R	12 mm	0.189		•		•	•			
RJET1204MOFN	Grd/Pol for Al - 6mm R	12 mm	0.189								•

HARDWARE

Cutter Number	Insert Series	Screw	Driver	Driver Bit	Retention Bolt	(Optional) Coolant Bolt	Drive Ring
35B6E-25031D1R01	RJLT08	SM30-065-00	DS-T09W	n/a	SD06-48	SD-06-89	
35B6E-25031D1R02	RJLT08	SM30-065-00	DS-T09W	n/a	SD06-48	SD-06-89	
35B6E-30031D3R01	RJLT08	SM30-065-00	DS-T09W	n/a	SD08-48	SD-08-92	
35B6G-25039D1R02	RJLT10	SM35-087-70	DS-A00T	BLD T15/S7	SD06-48	SD-06-89	
35B6G-25039D1R01	RJLT10	SM35-087-70	DS-A00T	BLD T15/S7	SD06-48	SD-06-89	
35B6G-30039D3R01	RJLT10	SM35-087-70	DS-A00T	BLD T15/S7	SD08-48	SD-08-92	
35B6H-32047D3R01	RJLT12	SM40-093-20	DS-A00T	BLD T15/S7	SD08-50	SD-08-D7	
35B6H-40047D3R01	RJLT12	SM40-093-20	DS-A00T	BLD T15/S7	SD08-50	SD-08-D7	
35B6H-50047D3R01	RJLT12	SM40-093-20	DS-A00T	BLD T15/S7	SD08-50	SD-08-D7	
35B6E-02031AZ-01	RJLT08	SM30-065-00	DS-T09W	n/a	n/a	n/a	TE-0023
35B6E-03031AF-01	RJLT08	SM30-065-00	DS-T09W	n/a	n/a	n/a	
35B6G-02039AZ-02	RJLT10	SM35-087-70	DS-A00T	BLD T15/S7	n/a	n/a	TE-0023
35B6G-02039AZ-01	RJLT10	SM35-087-70	DS-A00T	BLD T15/S7	n/a	n/a	TE-0023
35B6G-03039AF-01	RJLT10	SM35-087-70	DS-A00T	BLD T15/S7	n/a	n/a	
35B6H-03047AF-02	RJLT12	SM40-093-20	DS-A00T	BLD T15/S7	n/a	n/a	
35B6H-03047AF-01	RJLT12	SM40-093-20	DS-A00T	BLD T15/S7	n/a	n/a	
35B6H-04047AF-01	RJLT12	SM40-093-20	DS-A00T	BLD T15/S7	n/a	n/a	
35B6H-05047AF-01	RJLT12	SM40-093-20	DS-A00T	BLD T15/S7	n/a	n/a	
15T8E-25031X9R01	RJLT08	SM30-065-00	DS-T09W	n/a	n/a	n/a	
15T8E-30031X9R01	RJLT08	SM30-065-00	DS-T09W	n/a	n/a	n/a	
15T1G-25039X9R01	RJLT10	SM35-087-70	DS-A00T	BLD T15/S7	n/a	n/a	
15T1G-25039X9R02	RJLT10	SM35-087-70	DS-A00T	BLD T15/S7	n/a	n/a	
15T1G-30039X9R01	RJLT10	SM35-087-70	DS-A00T	BLD T15/S7	n/a	n/a	

TECHNICAL INFORMATION

Material		Brinnell Hardness	SFM	Feed per Tooth	Grade	IN2505	IN2504	IN2540	IN2530	IN2035	IN7035	IN10K	Coolant
Aluminum	6061-T6, 7075-T6		1300-1650	.0075 - .047								1	Yes
Cast Iron	Gray	190-220	360 - 690	.005 - .022		1			2				No
	Nodular	140-200	390 - 690			1			2				
Steel	Low Carbon 1018-8620	85-175	721 - 985	.005 - .024		1			2				No
	High Carbon F-6180	175 - 225	490 - 820	.005 - .024		1			2				
	Alloyed Steel 4140	275-325	325 - 590	.005 - .022		1		3	2				
	Tool Steel P20-H13	200-320	275 - 775	.005 - .040		1		3	2				
	Hardened Tool Steels	320-630	250 - 450	.005 - .030		2	1	3					
Stainless Steel	300 Series, 304, 316	-	360 - 600	.005 - .025		4			3	2	1		Optional
	400 Series 15-5 PH, 17-4 PH	-	360 - 720	.003 - .025		4			3	2	1		
	13-8 PH	-	200 - 600	.003 - .020					3	2	1		
Nickel Alloys	Inconel 600, 706, 718	-	80 - 150	.003 - .012					3	2	1		YES
Titanium	903, Hastelloy	-	115 - 195	.003 - .015					3	2	1		YES

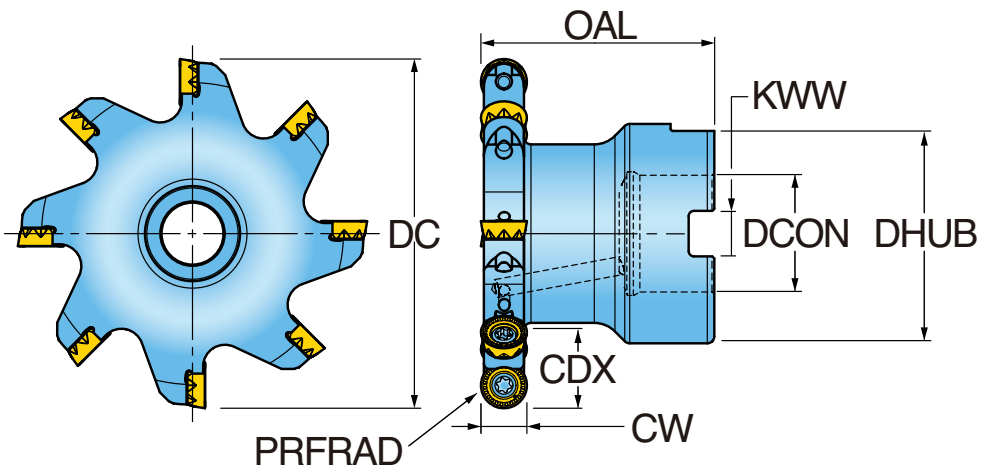
Note: Feed and speed recommendations are starting operating parameters. They are only guidelines from which further optimization should take place. Operating parameters are influenced by many machining variables. These variables may cause for reductions in feeds and speed or dramatic increases. Additionally, DOC and WOC may need to be revised to optimize the tools performance.

COPY PAGE AND FILL IN INFORMATION TO COMMUNICATE BASIC DESIGN REQUIREMENTS

SPECIFICATIONS

DC	Cutting Diameter	
OAL	Overall Length	
CW	Width of Cut	
DHUB	Hub Diameter	
CDX	Max. Radial DOC	
DCON	Bore Diameter	
KWW	Keyway	
PRFRAD	Profile Radius	
ZNP	Total No. of Inserts	
CSP	Coolant Thru by Tool	
I.C.	Insert Inscribed circle	

RADIAL DRIVE



CUSTOMER	CUSTOMER NO.		
STREET	CITY	STATE	ZIP
CONTACT PERSON	PHONE		
EMAIL	DATE		
QUANTITY	ANNUAL QUANTITY		
SALES ENGINEER			

APPLICATION TYPE
MATERIAL BEING MACHINED
GUAGE LENGTH REQUIRED

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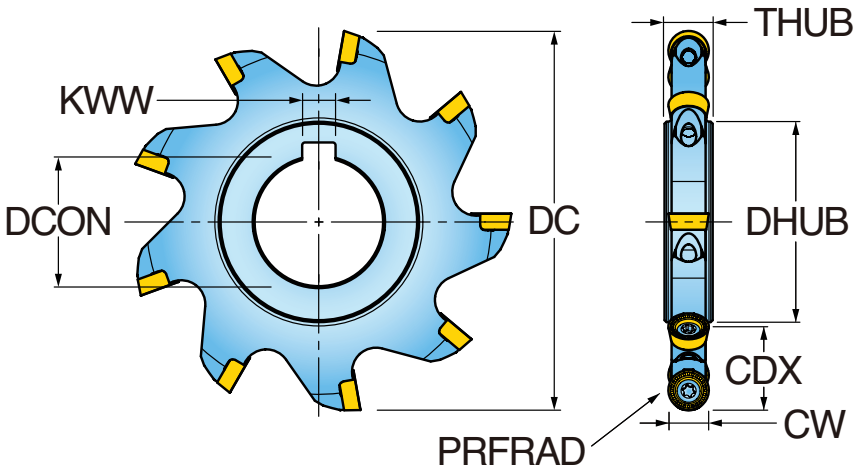
CDX	Max. Radial DOC	
DCON	Bore Diameter	
KWW	Keyway	
THUB	Hub Width	
PRFRAD	Profile Radius	
ZEFP	No. of Effective Inserts	
ZNP	Total No. of Inserts	
CSP	Coolant Thru by Tool	
I.C.	Insert Inscribed circle	

AXIAL DRIVE



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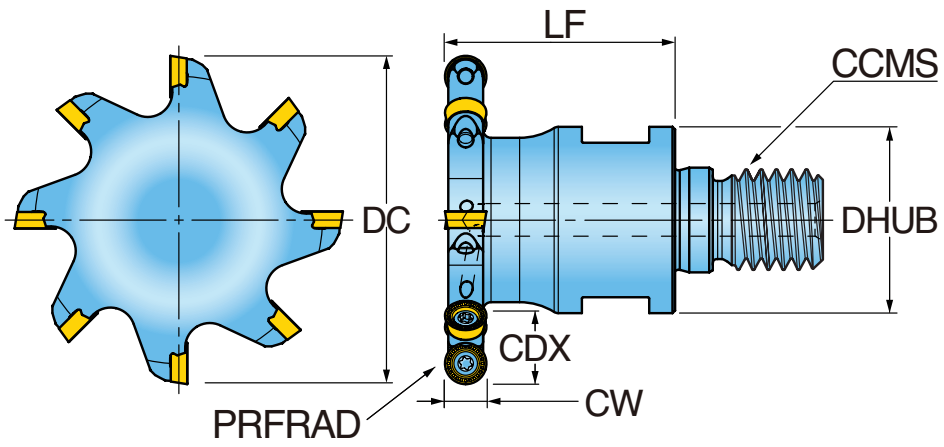
SPECIFICATIONS

DC	Cutting Diameter	
LF	Functional Length	
CW	Width of Cut	
DHUB	Hub Diameter	
CCMS	Thread Size	
CDX	Max. Radial DOC	
PRFRAD	Profile Radius	
ZEFP	No. of Effective Inserts	
CSP	Coolant Thru by Tool	
I.C.	Insert Inscribed circle	

M20 TOP-ON



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