SFEEDUP™ HIGH SPEED & FEED

INDUSTRY 4.0 PRODUCT ANNOUNCEMENT •UPDATE• 2023

DIPOSFEED™

MILLING PRODUCTS

Cutter Series:
1TG1B (4MM)
1TG1F, TG1F (6MM)
1TG1G, TG1G, TG2G (9MM)
1TG1J, TG1J, TG2J (11MM)

Diameters:
.312" to 4.000"

Insert Series:
UNLU04
UNLU06 (Formerly HiFeed Mini)
UNLU09 (Formerly HiFeed Midi)
UNLU11

Insert Grades:
IN2504
IN2505
IN2510
IN2530
IN6530
IN6537
IN2035
IN7035

Applications:
Die Mold, Aerospace, Oil and Gas, Rail, General Purpose

New IC Sizes, New Diameter Ranges, New Grade AND a New Name, DIPOSFEED™!

The new DIPOSFEED family of high feed milling cutters offers newfound productivity with a wide application range! Indexable high feed insert sizes include 4 mm, 6 mm, 9 mm, and 11 mm. Super strong insert geometries, latest grades, strong insert clamping and an optimal high feed design ensures worry-free machining! The new DIPOSFEED will SFEEDUP your milling process, reduce cycle times and increase through-put! Proven performance, proven results!

Features & Benefits:

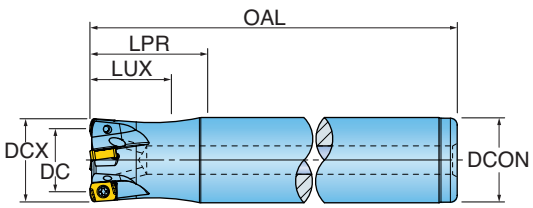
- Cutter body options include: End Mill, Top-On, Chip Surfer and Face Mill
- Cutter diameter range, .312" up to 4.00"
- Higher insert densities for super productivity!
- Depth of cut (DOC) capability from .5 mm (.020") to 2 mm (.078")
- APT ranges from .007" to .160" allow for extreme productivity!
- Optimal insert cutting edge preparations and rake face geometries for all material groups.
- Inserts offer 4 cutting edges for cost-effective machining and economy!
- Rigid clamping & high tensile clamping screws
- Lower cutting forces and efficient milling
- An expanded high-feed family under one new name, DIPOSFEED! (formerly, HiFeed Mini & Midi)

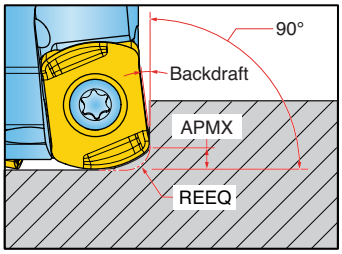
Member IMC Group Ingersoll Cutting Tools

NEW-325-5
(4/2023)
1/23

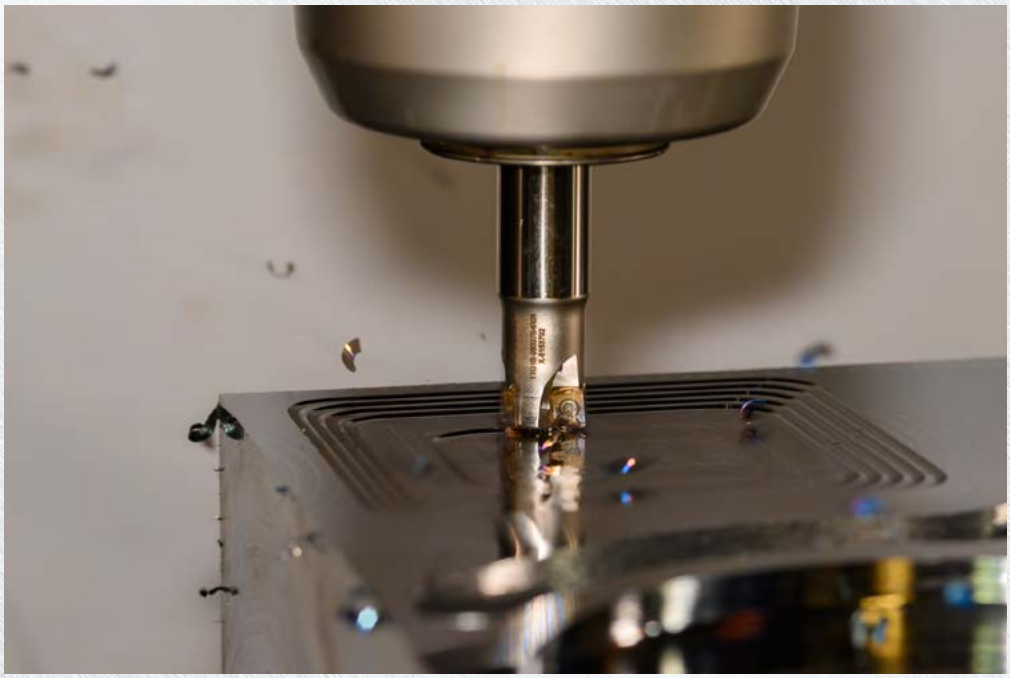
DIPOSFEED 04 SERIES 1TG1B (CYLINDRICAL SHANK)

END MILLS (4MM INSERT)



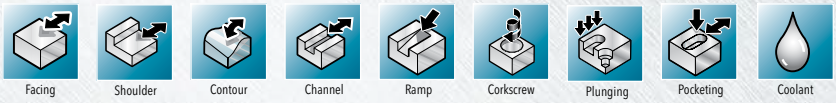


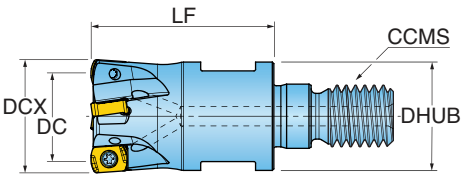
Part Number	DCX Cutting Dia. Max.	DC Cutting Dia.	LUX Usable Length Max.	LPR Protruding Length	OAL Overall Length	ZEFF Eff. Teeth	REEQ Program Radius Equivalent	DCON Shank Dia.	RMPX Ramp Angle Max.	APMX Depth of Cut Max.
1TG1B-03007R7R01	0.312	0.150	0.62	0.75	3.25	1	0.035	0.312	.64	0.020
1TG1B-03007R8R01	0.375	0.207	0.62	0.75	4.00	1	0.035	0.375	.75	0.020
1TG1B-04007R9R01	0.438	0.266	0.62	0.75	4.00	2	0.035	0.438	.85	0.020
1TG1B-05007S4R01	0.500	0.327	0.62	0.75	4.50	3	0.035	0.500	.9	0.020
1TG1B-06010S6R01	0.625	0.450	0.98	1.00	6.00	4	0.035	0.625	.7	0.020
1TG1B-07010S7R01	0.750	0.575	0.98	1.00	7.50	4	0.035	0.750	1.1	0.020
1TG1B-08010S8R01	0.875	0.700	0.98	1.00	7.50	5	0.035	0.875	1	0.020
1TG1B-10010S1R01	1.000	0.824	0.98	1.00	8.00	6	0.035	1.000	.85	0.020

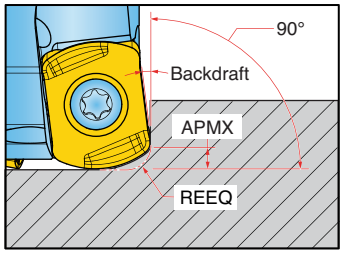


DIPOSFEED™ 04 SERIES 1TG1B (TOP•ON STYLE)

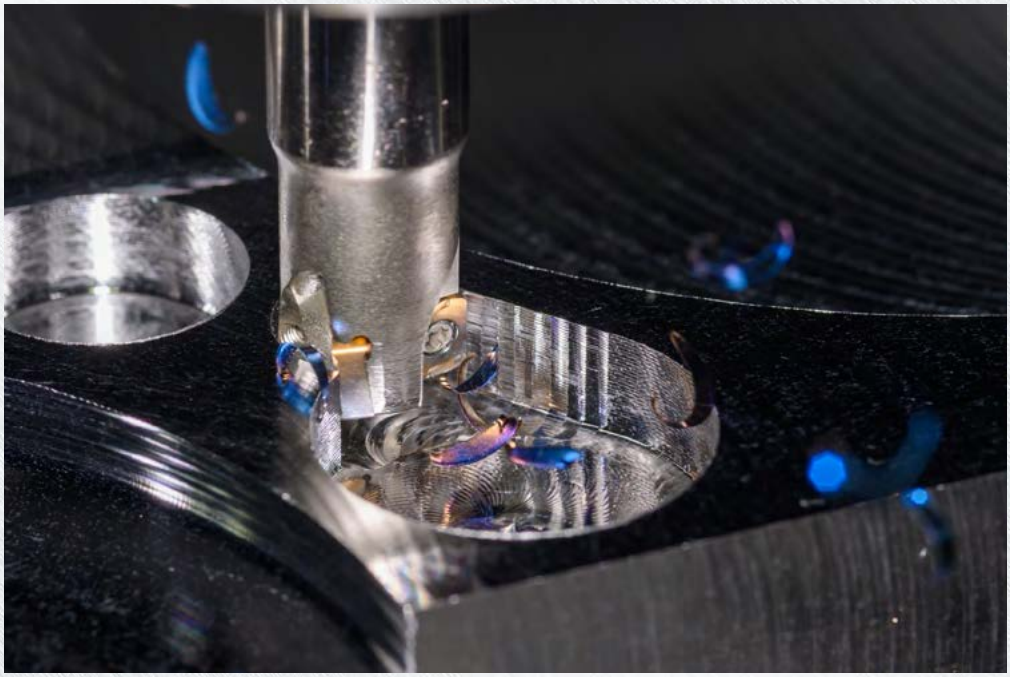
MODULAR END MILLS (4MM INSERT)





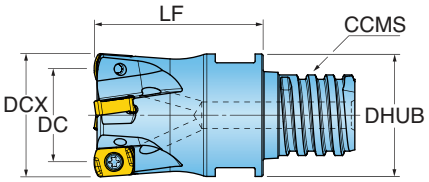


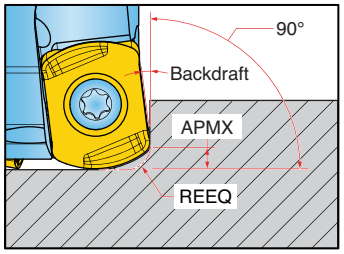
Part Number	DCX Cutting Dia. Max.	DC Cutting Diameter	LF Functional Length	ZEFF Effective Teeth	REEQ Program Radius Equivalent	DHUB Hub Diameter	CCMS Connection Code	RMPX Ramp Angle Max.	APMX Depth of Cut Max.
1TG1B-03006X4R01	0.394	0.224	0.67	2	0.035	0.38	TopOn M06	.9	0.020
1TG1B-04006X4R01	0.438	0.266	0.67	2	0.035	0.41	TopOn M06	.8	0.020
1TG1B-05006X4R01	0.500	0.327	0.67	3	0.035	0.47	TopOn M06	1	0.020
1TG1B-06009X5R01	0.625	0.450	0.98	4	0.035	0.50	TopOn M08	.7	0.020
1TG1B-07011X6R01	0.750	0.575	1.18	4	0.035	0.70	TopOn M10	1.25	0.020
1TG1B-08011X6R01	0.875	0.700	1.18	5	0.035	0.70	TopOn M10	1	0.020
1TG1B-10013X7R01	1.000	0.824	1.37	6	0.035	0.82	TopOn M12	.85	0.020
1TG1B-12015X8R01	1.250	1.074	1.57	8	0.035	1.13	TopOn M16	.64	0.020



DIPOSFEED™ 04 SERIES 1TG1B (CHIP•SURFER STYLE)

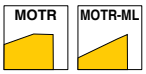
HI-FEED MODULAR END MILLS (4MM INSERT)



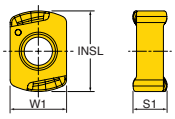


Part Number	DCX Cutting Dia. Max.	DC Cutting Diameter	LF Functional Length	ZEFF Effective Teeth	REEQ Program Radius Equivalent	DHUB Hub Diameter	CCMS Connection Code	RMPX Ramp Angle Max.	APMX Depth of Cut Max.
1TG1B-03006T6R01	0.394	0.224	0.63	2	0.035	0.37	Chip Surfer T06	.91	0.020
1TG1B-04006T6R01	0.438	0.266	0.63	2	0.035	0.37	Chip Surfer T06	.88	0.020
1TG1B-05006T8R01	0.500	0.327	0.65	3	0.035	0.49	Chip Surfer T08	1	0.020
1TG1B-06008TRR01	0.625	0.450	0.80	4	0.035	0.61	Chip Surfer T10	.7	0.020
1TG1B-07010TSR01	0.750	0.575	1.00	4	0.035	0.73	Chip Surfer T12	1.25	0.020
1TG1B-08010TSR01	0.875	0.700	1.00	5	0.035	0.73	Chip Surfer T12	1	0.020
1TG1B-10012TUR01	1.000	0.824	1.25	6	0.035	0.95	Chip Surfer T15	.85	0.020

DIPOSFEED™ 04 INSERTS



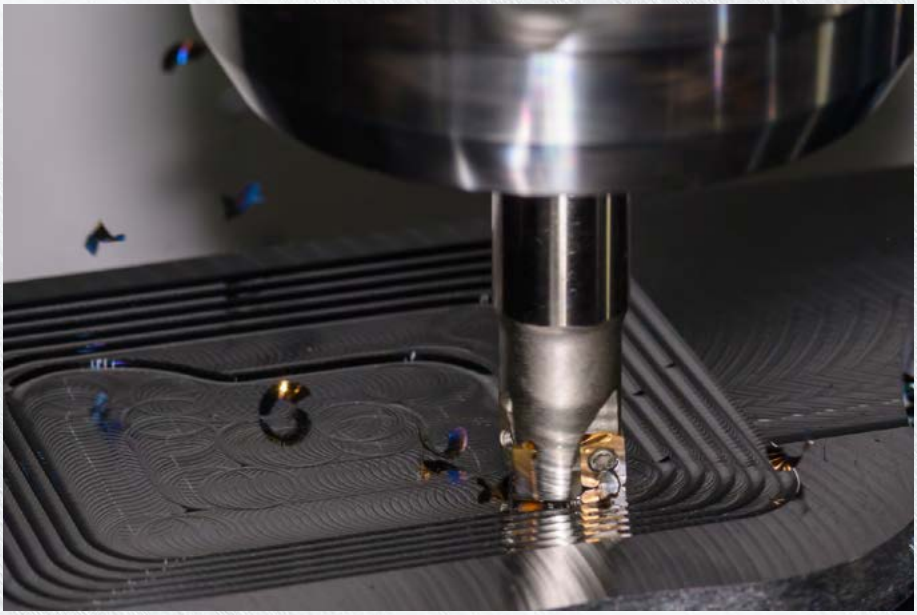
UNLU04



Part Number	Application	REEQ Program Radius Equivalent	INSL Insert Length	W1 Insert Width	S1 Thickness Overall	NOI Number of Indexes	IH Insert Hand	Grade	IN2504	IN2505	IN2530	IN2035
UNLU0402M0TR	Multi-Purpose	.035	.236	.165	.098	4	Right		•	•	•	
UNLU0402M0TR-ML	Precision	.035	.236	.165	.098	4	Right			•	•	•

DIPOSFEED™ 04 HARDWARE

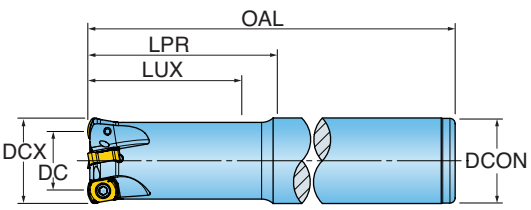
	 Screw	 Driver	 **OPTIONAL** Torque Driver Handle	 **OPTIONAL** Preset Torque Bit	 **OPTIONAL** Torque Driver Bit	 **OPTIONAL** Wrench	
1TG1B-03007R7R01	SM18-041-00	DS-TP06S	DS-A00-.25S	DT-05-.25	DS-TP06TB	-	
1TG1B-03007R8R01	SM18-041-00	DS-TP06S	DS-A00-.25S	DT-05-.25	DS-TP06TB	-	
1TG1B-04007R9R01	SM18-041-00	DS-TP06S	DS-A00-.25S	DT-05-.25	DS-TP06TB	-	
1TG1B-05007S4R01	SM18-041-00	DS-TP06S	DS-A00-.25S	DT-05-.25	DS-TP06TB	-	
1TG1B-06010S6R01	SM18-041-00	DS-TP06S	DS-A00-.25S	DT-05-.25	DS-TP06TB	-	
1TG1B-07010S7R01	SM18-041-00	DS-TP06S	DS-A00-.25S	DT-05-.25	DS-TP06TB	-	
1TG1B-08010S8R01	SM18-041-00	DS-TP06S	DS-A00-.25S	DT-05-.25	DS-TP06TB	-	
1TG1B-10010S1R01	SM18-041-00	DS-TP06S	DS-A00-.25S	DT-05-.25	DS-TP06TB	-	
1TG1B-03006X4R01	SM18-041-00	DS-TP06S	DS-A00-.25S	DT-05-.25	DS-TP06TB	-	
1TG1B-04006X4R01	SM18-041-00	DS-TP06S	DS-A00-.25S	DT-05-.25	DS-TP06TB	-	
1TG1B-05006X4R01	SM18-041-00	DS-TP06S	DS-A00-.25S	DT-05-.25	DS-TP06TB	-	
1TG1B-06009X5R01	SM18-041-00	DS-TP06S	DS-A00-.25S	DT-05-.25	DS-TP06TB	610MM	
1TG1G-07011X6R01	SM18-041-00	DS-TP06S	DS-A00-.25S	DT-05-.25	DS-TP06TB	615MM	
1TG1G-08011X6R01	SM18-041-00	DS-TP06S	DS-A00-.25S	DT-05-.25	DS-TP06TB	615MM	
1TG1B-10013X7R01	SM18-041-00	DS-TP06S	DS-A00-.25S	DT-05-.25	DS-TP06TB	617MM	
1TG1B-12015X8R01	SM18-041-00	DS-TP06S	DS-A00-.25S	DT-05-.25	DS-TP06TB	622MM	
1TG1B-03006T6R01	SM18-041-00	DS-TP06S	DS-A00-.25S	DT-05-.25	DS-TP06TB	WS-0029	
1TG1B-04006T6R01	SM18-041-00	DS-TP06S	DS-A00-.25S	DT-05-.25	DS-TP06TB	WS-0029	
1TG1B-05006T8R01	SM18-041-00	DS-TP06S	DS-A00-.25S	DT-05-.25	DS-TP06TB	WS-0030	
1TG1B-06008TRR01	SM18-041-00	DS-TP06S	DS-A00-.25S	DT-05-.25	DS-TP06TB	WS-0044	
1TG1B-07010TSR01	SM18-041-00	DS-TP06S	DS-A00-.25S	DT-05-.25	DS-TP06TB	WS-0059	
1TG1B-08010TSR01	SM18-041-00	DS-TP06S	DS-A00-.25S	DT-05-.25	DS-TP06TB	WS-0059	
1TG1B-10012TUR01	SM18-041-00	DS-TP06S	DS-A00-.25S	DT-05-.25	DS-TP06TB	WS-0059	

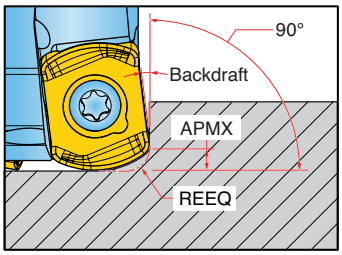


DIPOSFEED 06 SERIES 1TG1F (CYLINDRICAL/WELDON SHANK)

FORMERLY HIFEED MINI

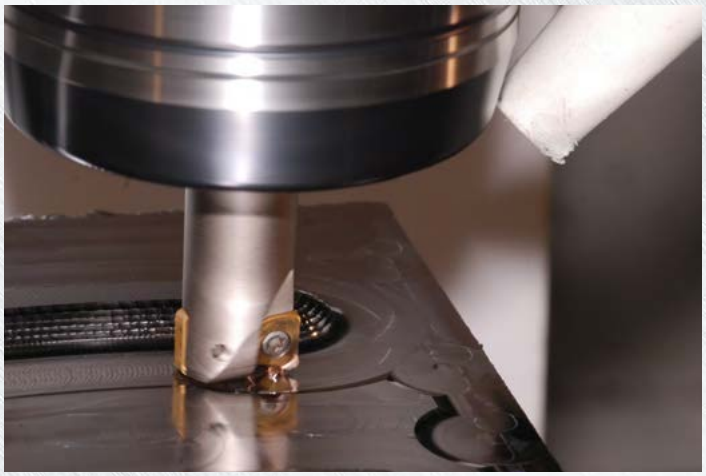
END MILLS (6MM INSERT)





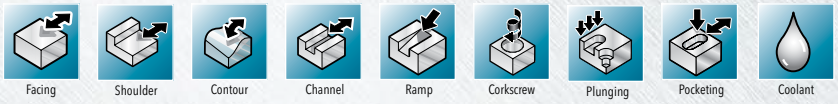
Part Number	DCX Cutting Dia. Max.	DC Cutting Dia.	LUX Usable Length Max.	LPR Protruding Length	OAL Overall Length	ZEFF Eff. Teeth	REEQ Program Radius Equivalent	DCON Shank Dia.	RMPX Ramp Angle Max.	APMX Depth of Cut Max.
1TG1F-06015S6R01	0.625	0.365	1.26	1.40	4.00	2	0.060	0.625	1.5	0.028
1TG1F-06015ULR01	0.625	0.365	1.26	1.40	4.00	2	0.060	15.50 mm	1.5	0.028
1TG1F-07017UMR01	0.750	0.476	1.50	1.66	5.00	3	0.060	18.50 mm	1.4	0.032
1TG1F-07017UMR02	0.750	0.476	1.50	1.66	6.25	3	0.060	18.50 mm	1.4	0.032
1TG1F-07022S7R01	0.750	0.476	2.00	2.17	5.00	3	0.060	0.750	1.4	0.032
1TG1F-07032S7R01	0.750	0.476	3.00	3.15	6.23	3	0.060	0.750	1.4	0.032
1TG1F-08019S7R01	0.875	0.573	1.82	1.93	7.75	3	0.060	0.750	1.1	0.043
1TG1F-08019UNR01	0.875	0.573	1.75	1.93	7.75	3	0.060	21.50 mm	1.1	0.043
1TG1F-10022S1R01	1.000	0.696	2.00	2.17	10.00	4	0.060	1.000	.8	0.043
1TG1F-10022T5R01	1.000	0.696	2.00	2.16	7.00	4	0.060	25.00 mm	.8	0.043
1TG1F-10022T5R02	1.000	0.696	2.00	2.16	10.00	4	0.060	25.00 mm	.8	0.043
1TG1F-10032S1R01	1.000	0.696	2.00	3.17	7.00	4	0.060	1.000	.8	0.043
1TG1F-1203281R01*	1.250	0.946	3.00	3.17	5.50	5	0.060	1.250	.6	0.043
1TG1F-12050E2R01*	1.250	0.946	4.75	4.92	8.00	5	0.060	1.250	.6	0.043
1TG1F-15015E2R01*	1.500	1.196	2.88	3.00	6.00	6	0.060	1.250	.5	0.043

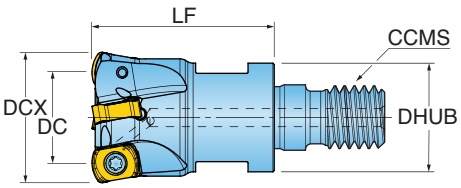
*** Weldon Shank**

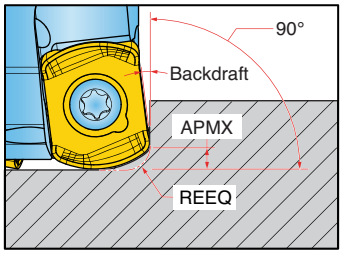


DIPOSFEED™ 06 SERIES 1TG1F (TOP•ON STYLE) FORMERLY HI•FEED MINI

MODULAR END MILLS (6MM INSERT)



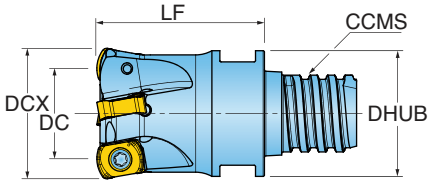


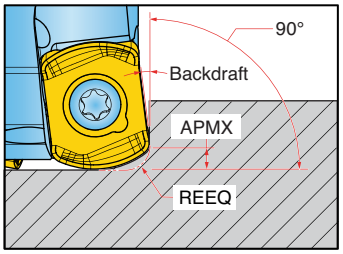


Part Number	DCX Cutting Dia. Max.	DC Cutting Diameter	LF Functional Length	ZEFF Effective Teeth	REEQ Program Radius Equivalent	DHUB Hub Diameter	CCMS Connection Code	RMPX Ramp Angle Max.	APMX Depth of Cut Max.
1TG1F-06010X5R01	0.625	0.365	0.98	2	0.060	0.51	TopOn M08	1.5	0.028
1TG1F-07011X6R01	0.750	0.476	1.18	3	0.060	0.51	TopOn M10	1.4	0.032
1TG1F-10013X7R01	1.000	0.696	1.37	4	0.060	0.82	TopOn M12	.8	0.043
1TG1F-12015X8R01	1.250	0.946	1.57	5	0.060	1.14	TopOn M16	.6	0.043
1TG1F-15015X8R10	1.500	1.196	1.57	6	0.060	1.14	TopOn M16	.8	0.043
1TG1F-15017X9R01	1.500	1.196	1.75	6	0.060	1.42	TopOn M20	.8	0.043

DIPOSFEED™ 06 SERIES 1TG1F (CHIP•SURFER STYLE) FORMERLY HI•FEED MINI

HI-FEED MODULAR END MILLS (6MM INSERT)



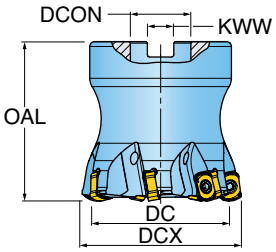


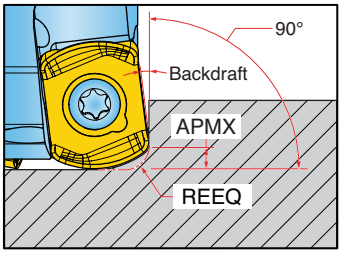
Part Number	DCX Cutting Dia. Max.	DC Cutting Diameter	LF Functional Length	ZEFF Effective Teeth	REEQ Program Radius Equivalent	DHUB Hub Diameter	CCMS Connection Code	RMPX Ramp Angle Max.	APMX Depth of Cut Max.
1TG1F-06008TRR01	0.625	0.365	0.83	2	0.060	0.60	Chip Surfer T10	1.5	0.028
1TG1F-07010TSR01	0.750	0.476	1.02	3	0.060	0.72	Chip Surfer T12	1.4	0.028
1TG1F-10012TUR01	1.000	0.706	1.26	4	0.060	0.95	Chip Surfer T15	.8	0.043

DIPOSFEED™ 06 SERIES TG1F FORMERLY HIFEED MINI

FACE MILLS (6MM INSERT)

Facing | Shoulder | Contour | Channel | Ramp | Corkscrew | Plunging | Pocketing | Coolant



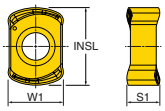


Part Number	DCX Cutting Dia. Max.	DC Cutting Dia.	OAL Overall Length	ZEFF Eff. Teeth	REEQ Program Radius Equivalent	DCON Shank Dia.	KWW Keyway	RMPX Ramp Angle Max.	APMX Depth of Cut Max.
TG1F-20R01	2.000	1.696	1.97	7	0.060	0.750	0.31	.5	0.043

DIPOSFEED™ 06 INSERTS FORMERLY HIFEED MINI

MOTR | MOTR-MM | MOTR-ML

UNLU06

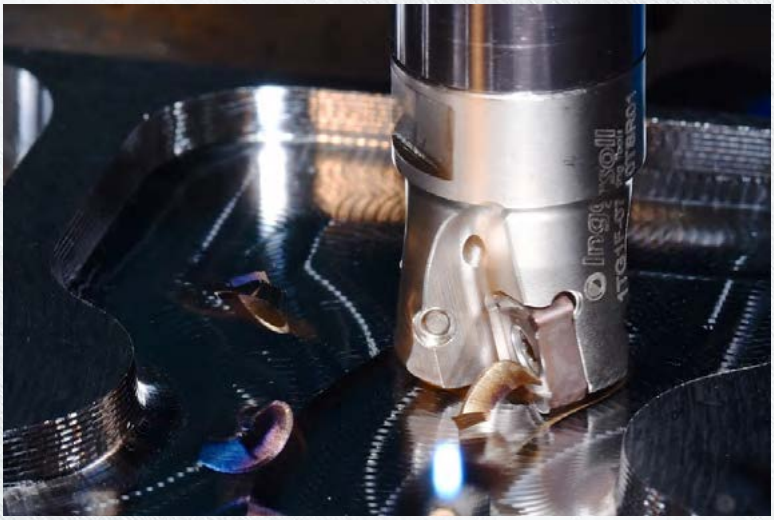


Part Number	Application	REEQ Program Radius Equivalent	INSL Insert Length	W1 Insert Width	S1 Thickness Overall	NOI Number of Indexes	IH Insert Hand	Grade	IN2035	IN2504	IN2505	IN2510	IN2530	IN7035
UNLU0603M0TR	Multi-Purpose	0.060	0.354	0.251	0.142	4	Right		•	•	•	•	•	
UNLU0603M0TR-MM	Positive	0.060	0.354	0.251	0.142	4	Right		•	•	•		•	•
UNLU0603M0TR-ML	Precision	0.060	0.354	0.251	0.142	4	Right		•		•		•	•

DIPOSFEED™ 06 HARDWARE

FORMERLY HIFEED MINI

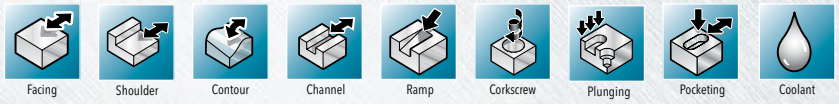
	 Insert Screw	 Driver	 Socket Head Cap Screw	 **OPTIONAL** Coolant Bolt	 **OPTIONAL** Torque Driver Handle	 **OPTIONAL** Preset Torque Bit	 **OPTIONAL** Torque Driver Bit	 **OPTIONAL** Wrench
1TG1F-06015S6R01	SM25-075-20	DS-T08W	-	-	DS-A00-.25T	DT-11-.25	DS-0021	-
1TG1F-06015ULR01	SM25-075-20	DS-T08W	-	-	DS-A00-.25T	DT-11-.25	DS-0021	-
1TG1F-07017UMR01	SM25-075-20	DS-T08W	-	-	DS-A00-.25T	DT-11-.25	DS-0021	-
1TG1F-07017UMR02	SM25-075-20	DS-T08W	-	-	DS-A00-.25T	DT-11-.25	DS-0021	-
1TG1F-07022S7R01	SM25-075-20	DS-T08W	-	-	DS-A00-.25T	DT-11-.25	DS-0021	-
1TG1F-07032S7R01	SM25-075-20	DS-T08W	-	-	DS-A00-.25T	DT-11-.25	DS-0021	-
1TG1F-08019S7R01	SM25-075-20	DS-T08W	-	-	DS-A00-.25T	DT-11-.25	DS-0021	-
1TG1F-08019UNR01	SM25-075-20	DS-T08W	-	-	DS-A00-.25T	DT-11-.25	DS-0021	-
1TG1F-10022S1R01	SM25-075-20	DS-T08W	-	-	DS-A00-.25T	DT-11-.25	DS-0021	-
1TG1F-10022T5R01	SM25-075-20	DS-T08W	-	-	DS-A00-.25T	DT-11-.25	DS-0021	-
1TG1F-10022T5R02	SM25-075-20	DS-T08W	-	-	DS-A00-.25T	DT-11-.25	DS-0021	-
1TG1F-10032S1R01	SM25-075-20	DS-T08W	-	-	DS-A00-.25T	DT-11-.25	DS-0021	-
1TG1F-1203281R01	SM25-075-20	DS-T08W	-	-	DS-A00-.25T	DT-11-.25	DS-0021	-
1TG1F-12050E2R01	SM25-075-20	DS-T08W	-	-	DS-A00-.25T	DT-11-.25	DS-0021	-
1TG1F-15015E2R01	SM25-075-20	DS-T08W	-	-	DS-A00-.25T	DT-11-.25	DS-0021	-
1TG1F-06010X5R01	SM25-075-20	DS-T08W	-	-	DS-A00-.25T	DT-11-.25	DS-0021	610MM
1TG1F-07011X6R01	SM25-075-20	DS-T08W	-	-	DS-A00-.25T	DT-11-.25	DS-0021	615MM
1TG1F-10013X7R01	SM25-075-20	DS-T08W	-	-	DS-A00-.25T	DT-11-.25	DS-0021	617MM
1TG1F-12015X8R01	SM25-075-20	DS-T08W	-	-	DS-A00-.25T	DT-11-.25	DS-0021	622MM
1TG1F-15015X8R10	SM25-075-20	DS-T08W	-	-	DS-A00-.25T	DT-11-.25	DS-0021	622MM
1TG1F-15017X9R01	SM25-075-20	DS-T08W	-	-	DS-A00-.25T	DT-11-.25	DS-0021	630MM
1TG1F-06008TRR01	SM25-075-20	DS-T08W	-	-	DS-A00-.25T	DT-11-.25	DS-0021	WS-0044
1TG1F-07010TSR01	SM25-075-20	DS-T08W	-	-	DS-A00-.25T	DT-11-.25	DS-0021	WS-0059
1TG1F-10012TUR01	SM25-075-20	DS-T08W	-	-	DS-A00-.25T	DT-11-.25	DS-0021	WS-0061
TG1F-20R01	SM25-075-20	DS-T08W	SD-06-48	SD-06-A6	DS-A00-.25T	DT-11-.25	DS-0021	-

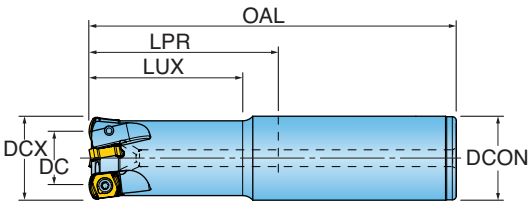


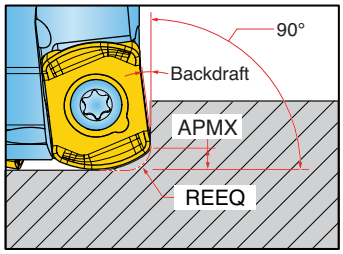
DIPOSFEED™ 09 SERIES 1TG1G (CYLINDRICAL/WELDON SHANK)

FORMERLY HIFEED MIDI™

END MILLS (9MM INSERT)







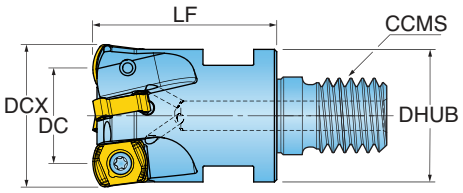
Part Number	DCX Cutting Dia. Max.	DC Cutting Dia.	LUX Usable Length Max.	LPR Protruding Length	OAL Overall Length	ZEFF Eff. Teeth	REEQ Program Radius Equivalent	DCON Shank Dia.	RMPX Ramp Angle Max.	APMX Depth of Cut Max.
1TG1G-10019S1R03*	1.000	0.594	1.80	1.97	7.00	3	0.094	1.000	3	0.060
1TG1G-10020S1R03*	1.000	0.594	1.83	2.00	10.00	3	0.094	1.000	3	0.060
1TG1G-12027E2R03	1.250	0.841	2.57	2.75	5.75	3	0.094	1.250	2	0.060
1TG1G-12027E2R04	1.250	0.841	2.57	2.75	5.75	4	0.094	1.250	2	0.060
1TG1G-12047E2R03	1.250	0.841	4.57	4.75	7.75	3	0.094	1.250	2	0.060
1TG1G-15016E2R04	1.500	1.090	1.45	1.69	6.00	4	0.094	1.250	1.5	0.060
1TG1G-15016E2R05	1.500	1.090	1.45	1.69	6.00	5	0.094	1.250	1.5	0.060

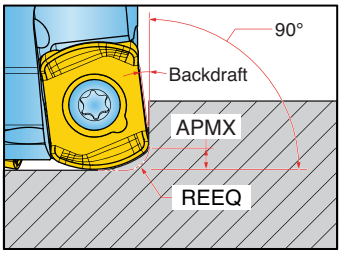
*** Cylindrical Shank**

DIPOSFEED™ 09 SERIES 1TG1G (TOP•ON STYLE)

FORMERLY HIFEED MIDI™

MODULAR END MILLS (9MM INSERT)





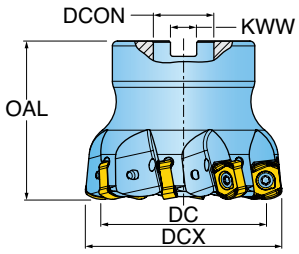
Part Number	DCX Cutting Dia. Max.	DC Cutting Diameter	LF Functional Length	ZEFF Effective Teeth	REEQ Program Radius Equivalent	DHUB Hub Diameter	CCMS Connection Code	RMPX Ramp Angle Max.	APMX Depth of Cut Max.
1TG1G-10015X7R03	1.000	0.594	1.57	3	0.094	0.82	TopOn M12	3	0.060
1TG1G-12015X8R04	1.250	0.841	1.57	4	0.094	1.13	TopOn M16	2	0.060
1TG1G-15015X9R10	1.500	1.090	1.57	5	0.094	1.42	TopOn M20	1.5	0.060

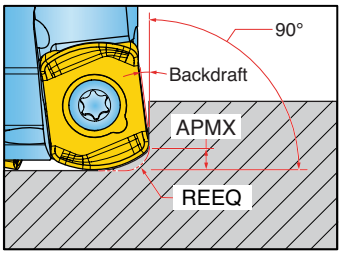
DIPOSFEED™ 09 SERIES TG1G, TG2G

FORMERLY HIFEED MIDI™

FACE MILLS (9MM INSERT)

Facing | Shoulder | Contour | Channel | Ramp | Corkscrew | Plunging | Pocketing | Coolant





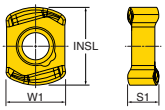
Part Number	DCX Cutting Dia. Max.	DC Cutting Dia.	OAL Overall Length	ZEFF Eff. Teeth	REEQ Program Radius Equivalent	DCON Shank Dia.	KWW Keyway	RMPX Ramp Angle Max.	APMX Depth of Cut Max.
TG1G-20R01	2.000	1.593	1.97	7	0.094	0.750	0.31	1	0.060
TG2G-20R01	2.000	1.593	1.97	6	0.094	0.750	0.31	1	0.060
TG1G-25R01	2.500	2.090	1.97	8	0.094	0.750	0.31	.8	0.060
TG1G-25R02	2.500	2.090	1.97	9	0.094	0.750	0.31	.8	0.060
TG1G-30R01	3.000	2.566	1.75	9	0.094	1.000	0.38	.6	0.060
TG2G-30R01	3.000	2.566	1.75	7	0.094	1.000	0.38	.6	0.060

DIPOSFEED™ 09 INSERTS

FORMERLY HIFEED MIDI™

MOTR | MOTR-MM | MOTR-ML

UNLU09



Part Number	Application	REEQ Program Radius Equivalent	INSL Insert Length	W1 Insert Width	S1 Thickness Overall	NOI Number of Indexes	IH Insert Hand	Grade	IN2035	IN2504	IN2505	IN2510	IN2530	IN7035
UNLU0904M0TR	Multi-Purpose	0.094	0.469	0.361	.189	4	Right		•	•	•	•	•	
UNLU0904M0TR-MM	Positive Geometry	0.094	0.469	0.361	.189	4	Right		•	•	•		•	•
UNLU0904M0TR-ML	Precision	0.094	0.469	0.361	.189	4	Right		•		•		•	•

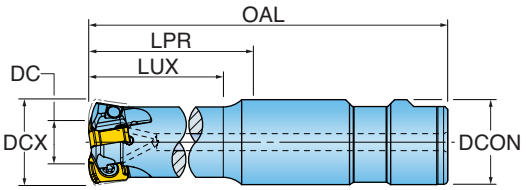
DIPOSFEED™ 09 HARDWARE

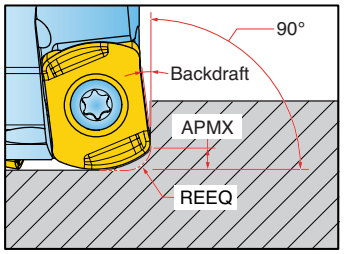
FORMERLY HI-FEED MIDI™

	Screw	Driver Handle	Driver Blade	Socket Head Cap Screw	**OPTIONAL** Coolant Bolt	**OPTIONAL** Torque Driver Handle	**OPTIONAL** Preset Torque Bit	**OPTIONAL** Torque Driver Bit	**OPTIONAL** Wrench
1TG1G-10019S1R03	SM35-088-10	DS-A00T	DS-T106B	-	-	DS-A00-.25-T	DT-30-.25	DS-T10B1	-
1TG1G-10020S1R03	SM35-088-10	DS-A00T	DS-T106B	-	-	DS-A00-.25-T	DT-30-.25	DS-T10B1	-
1TG1G-12027E2R03	SM35-088-10	DS-A00T	DS-T106B	-	-	DS-A00-.25-T	DT-30-.25	DS-T10B1	-
1TG1G-12027E2R04	SM35-088-10	DS-A00T	DS-T106B	-	-	DS-A00-.25-T	DT-30-.25	DS-T10B1	-
1TG1G-12047E2R03	SM35-088-10	DS-A00T	DS-T106B	-	-	DS-A00-.25-T	DT-30-.25	DS-T10B1	-
1TG1G-15016E2R04	SM35-088-10	DS-A00T	DS-T106B	-	-	DS-A00-.25-T	DT-30-.25	DS-T10B1	-
1TG1G-15016E2R05	SM35-088-10	DS-A00T	DS-T106B	-	-	DS-A00-.25-T	DT-30-.25	DS-T10B1	-
1TG1G-10015X7R03	SM35-088-10	DS-A00T	DS-T106B	-	-	DS-A00-.25-T	DT-30-.25	DS-T10B1	617MM
1TG1G-12015X8R04	SM35-088-10	DS-A00T	DS-T106B	-	-	DS-A00-.25-T	DT-30-.25	DS-T10B1	622MM
1TG1G-15015X9R10	SM35-088-10	DS-A00T	DS-T106B	-	-	DS-A00-.25-T	DT-30-.25	DS-T10B1	630MM
TG1G-20R01	SM35-088-10	DS-A00T	DS-T106B	SD-06-48	SD-06-A6	DS-A00-.25-T	DT-30-.25	DS-T10B1	-
TG2G-20R01	SM35-088-10	DS-A00T	DS-T106B	SD-06-48	SD-06-A6	DS-A00-.25-T	DT-30-.25	DS-T10B1	-
TG1G-25R01	SM35-088-10	DS-A00T	DS-T106B	SD-06-48	SD-06-A6	DS-A00-.25-T	DT-30-.25	DS-T10B1	-
TG1G-30R01	SM35-088-10	DS-A00T	DS-T106B	SD-08-46	SD-08-92	DS-A00-.25-T	DT-30-.25	DS-T10B1	-
TG2G-30R01	SM35-088-10	DS-A00T	DS-T106B	SD-08-46	SD-08-92	DS-A00-.25-T	DT-30-.25	DS-T10B1	-

DIPOSFEED™ 11 SERIES 1TG1J (WELDON SHANK)

END MILLS (11MM INSERT)

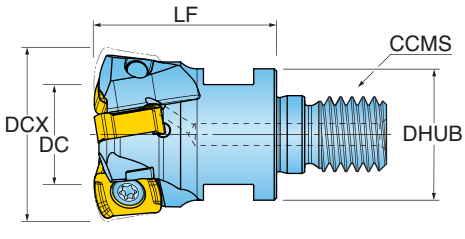


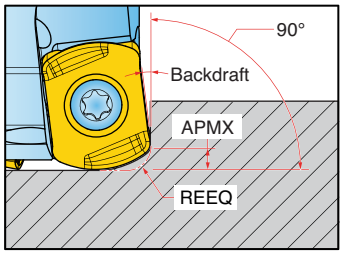


Part Number	DCX Cutting Dia. Max.	DC Cutting Dia.	LUX Usable Length Max.	LPR Protruding Length	OAL Overall Length	ZEFF Eff. Teeth	REEQ Program Radius Equivalent	DCON Shank Dia.	RMPX Ramp Angle Max.	APMX Depth of Cut Max.
1TG1J-12025E2R01	1.250	0.650	2.20	2.50	5.50	2	0.120	1.250	.48	0.078
1TG1J-12030E2R01	1.250	0.650	2.70	3.00	6.00	3	0.120	1.250	.48	0.078
1TG1J-15016E2R01	1.500	0.900	1.60	1.69	6.00	3	0.120	1.250	.54	0.078

DIPOSFEED™ 11 SERIES 1TG1J (TOP•ON STYLE)

MODULAR END MILLS (11MM INSERT)

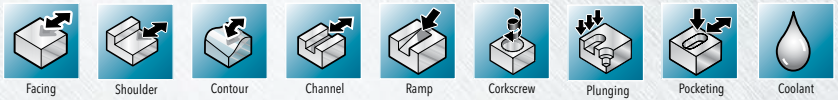


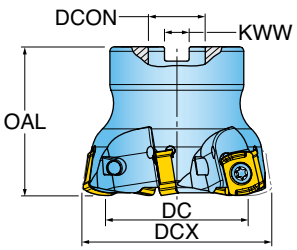


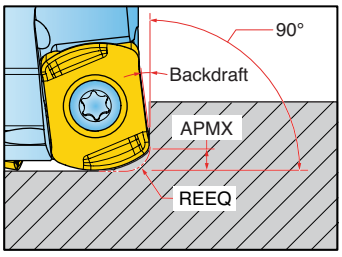
Part Number	DCX Cutting Dia. Max.	DC Cutting Diameter	LF Functional Length	ZEFF Effective Teeth	REEQ Program Radius Equivalent	DHUB Hub Diameter	CCMS Connection Code	RMPX Ramp Angle Max.	APMX Depth of Cut Max.
1TG1J-12015X8R01	1.250	0.650	1.57	2	0.120	1.13	TopOn M16	.48	0.078
1TG1J-15015X8R01	1.500	0.900	1.57	3	0.120	1.13	TopOn M16	.54	0.078
1TG1J-15015X9R01	1.500	0.900	1.57	3	0.120	1.42	TopOn M20	.54	0.078

DIPOSFEED™ 11 SERIES TG1J, TG2J

FACE MILLS (11MM INSERT)

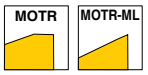




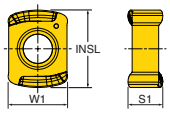


Part Number	DCX Cutting Dia. Max.	DC Cutting Dia.	OAL Overall Length	ZEFF Eff. Teeth	REEQ Program Radius Equivalent	DCON Shank Dia.	KWW Keyway	RMPX Ramp Angle Max.	APMX Depth of Cut Max.
TG1J-20R01	2.000	1.384	1.970	5	0.120	0.750	0.31	.5	0.078
TG2J-20R01	2.000	1.384	1.970	4	0.120	0.750	0.31	.5	0.078
TG1J-25R01	2.500	1.884	1.970	6	0.120	0.750	0.31	.45	0.078
TG2J-25R01	2.500	1.884	1.970	5	0.120	0.750	0.31	.45	0.078
TG1J-30R01	3.000	2.384	1.750	7	0.120	1.000	0.38	.35	0.078
TG2J-30R01	3.000	2.384	1.750	6	0.120	1.000	0.38	.35	0.078
TG1J-40R01	4.000	3.384	2.375	7	0.120	1.000	0.38	.3	0.078
TG2J-40R01	4.000	3.384	2.375	6	0.120	1.000	0.38	.3	0.078

DIPOSFEED™ 11 INSERTS



UNLU11

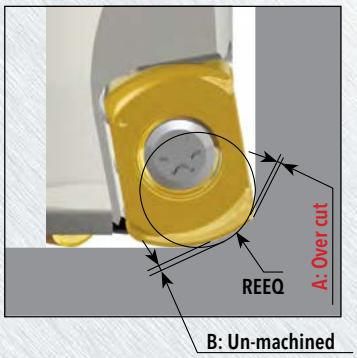


Part Number	Application	REEQ Program Radius Equivalent	INSL Insert Length	W1 Insert Width	S1 Thickness Overall	NOI Number of Indexes	IH Insert Hand	Grade	IN2504	IN2505	IN2530	IN6537	IN2035
UNLU1105M0TR	Multi-Purpose	.120	.575	.441	.256	4	Right		•	•	•	•	
UNLU1105M0TR-ML	Precision	.120	.575	.441	.256	4	Right			•	•		•

DIPOSFEED™ 11 HARDWARE

	 Screw	 Driver Handle	 Driver Blade	 Socket Head Cap Screw	 **OPTIONAL** Coolant Bolt	 **OPTIONAL** Torque Driver Handle	 **OPTIONAL** Preset Torque Bit	 **OPTIONAL** Torque Driver Bit	 **OPTIONAL** Wrench
1TG1J-12025E2R01	SM50-127-10	DS-A00T	DS-T206B	-	-	DS-A00-.25-T	DT-44-.25	DS-T20B1	-
1TG1J-12030E2R01	SM50-127-10	DS-A00T	DS-T206B	-	-	DS-A00-.25-T	DT-44-.25	DS-T20B1	-
1TG1J-15016E2R01	SM50-127-10	DS-A00T	DS-T206B	-	-	DS-A00-.25-T	DT-44-.25	DS-T20B1	-
1TG1J-12015X8R01	SM50-127-10	DS-A00T	DS-T206B	-	-	DS-A00-.25-T	DT-44-.25	DS-T20B1	622MM
1TG1J-15015X8R01	SM50-127-10	DS-A00T	DS-T206B	-	-	DS-A00-.25-T	DT-44-.25	DS-T20B1	622MM
1TG1J-15015X9R01	SM50-127-10	DS-A00T	DS-T206B	-	-	DS-A00-.25-T	DT-44-.25	DS-T20B1	630MM
TG2J-20R01	SM50-127-10	DS-A00T	DS-T206B	SD-06-48	SD-06-A6	DS-A00-.25-T	DT-44-.25	DS-T20B1	-
TG1J-20R01	SM50-127-10	DS-A00T	DS-T206B	SD-06-48	SD-06-A6	DS-A00-.25-T	DT-44-.25	DS-T20B1	-
TG2J-25R01	SM50-127-10	DS-A00T	DS-T206B	SD-06-48	SD-06-A6	DS-A00-.25-T	DT-44-.25	DS-T20B1	-
TG1J-25R01	SM50-127-10	DS-A00T	DS-T206B	SD-06-48	SD-06-A6	DS-A00-.25-T	DT-44-.25	DS-T20B1	-
TG2J-30R01	SM50-127-10	DS-A00T	DS-T206B	SD-08-46	SD-08-92	DS-A00-.25-T	DT-44-.25	DS-T20B1	-
TG1J-30R01	SM50-127-10	DS-A00T	DS-T206B	SD-08-46	SD-08-92	DS-A00-.25-T	DT-44-.25	DS-T20B1	-
TG2J-40R01	SM50-127-10	DS-A00T	DS-T206B	SD-12-82	SD-12-99	DS-A00-.25-T	DT-44-.25	DS-T20B1	-
TG1J-40R01	SM50-127-10	DS-A00T	DS-T206B	SD-12-82	SD-12-99	DS-A00-.25-T	DT-44-.25	DS-T20B1	-

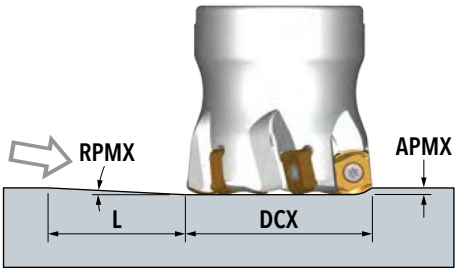
DIPOSFEED™ PROGRAMMING TECHNICAL DATA



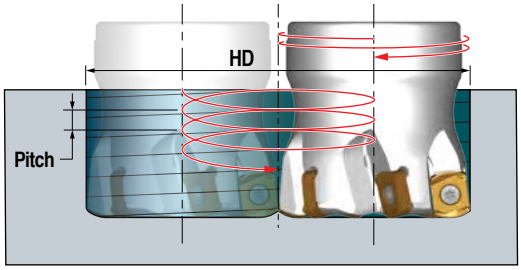
Part Number	REEQ Program Radius Equivalent	A Over Cut	B Un-Machined
UNLU0402M0TR	0.035	0	0.01
UNLU0603M0TR	0.060	0	.010 ---> .022 Max.
UNLU0904M0TR	0.094	0	0.025
UNLU1105M0TR	0.120	0	0.035

DIPOSFEED 04 RECOMMENDED RAMPING ANGLE

- **Straight Ramping**



- **Helical Milling**

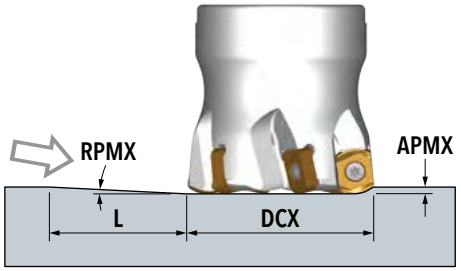


DCX Cutting Dia. Max.	Straight Ramp Down			Helical Ramp Down		
	RPMX Ramp Angle Max.	APMX Depth of Cut Max.	L Min. Length	HD Min. Dia.	HD Max. Dia.	Max. Pitch / Rev.
.312	.60°	.020 (.5MM)	1.910	0.429	-	0.004
				-	0.625	0.010
.375	.75°		1.528	0.530	-	0.005
				-	0.750	0.014
.394	.90°		1.273	0.561	-	0.007
				-	0.789	0.018
.438	.85°		1.348	0.637	-	0.009
				-	0.875	0.020
.500	.95°		1.206	0.748	-	0.010
				-	1.000	0.020
.625	.65°		1.763	0.922	-	0.010
				-	1.250	0.020
.750	1.2°		0.955	1.202	-	0.020
				-	1.500	0.020
.875	.95°		1.206	1.450	-	0.020
				-	1.750	0.020
1.000	.8°		1.432	1.700	-	0.020
				-	2.000	0.020
1.250	.6°		1.910	2.198	-	0.020
				-	2.500	0.020

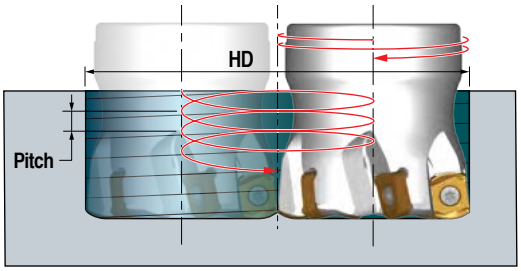
DIPOSFEED 06 RECOMMENDED RAMPING ANGLE

FORMERLY HIFEED MINI

- Straight Ramping



- Helical Milling

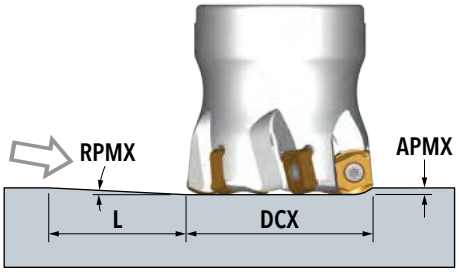


DCX Cutting Dia. Max.	Straight Ramp Down			Helical Ramp Down		
	RPMX Ramp Angle Max.	APMX Depth of Cut Max.	L Min. Length	HD Min. Dia.	HD Max. Dia.	Max. Pitch / Rev.
0.625	1.5°	0.028	1.069	.875	-	0.020
				-	1.25	0.050
0.750	1.5°	0.032	1.222	1.092	-	0.025
				-	1.500	0.060
0.875	1.0°	0.043	2.463	1.312	-	0.020
				-	1.750	0.045
1.000	.95°		2.593	1.558	-	0.025
				-	2.000	0.050
1.250	.65°		3.790	2.058	-	0.025
				-	2.500	0.040
1.500	.5°		4.927	2.556	-	0.025
				-	3.000	0.040
2.000	.35°		7.039	3.532	-	0.025
				-	4.000	0.035

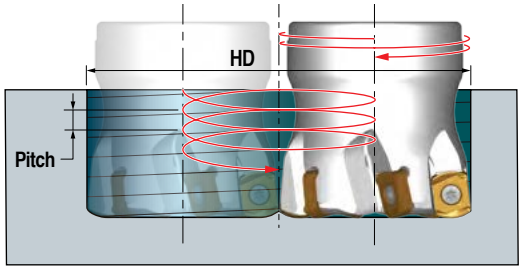
DIPOSFEED 09 RECOMMENDED RAMPING ANGLE

FORMERLY HI-FEED MIDI

- Straight Ramping



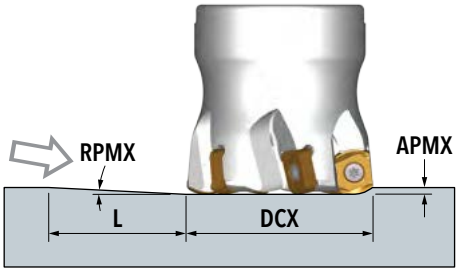
- Helical Milling



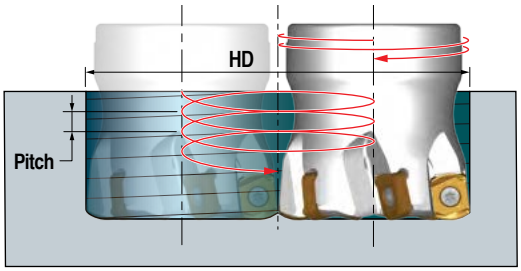
DCX Cutting Dia. Max.	Straight Ramp Down			Helical Ramp Down		
	RPMX Ramp Angle Max.	APMX Depth of Cut Max.	L Min. Length	HD Min. Dia.	HD Max. Dia.	Max. Pitch / Rev.
1.000	3.0°	0.060	1.145	1.354	-	0.060
				-	2.000	
1.250	2.0°		1.718	1.842	-	
				-	2.500	
1.500	1.5°		2.291	2.338	-	
				-	3.000	
2.000	1.0°		3.437	3.344	-	
				-	4.000	
2.500	.75°		3.437	4.336	-	
				-	5.000	
3.000	.5°		6.875	5.344	-	
				-	6.000	

DIPOSFEED 11 RECOMMENDED RAMPING ANGLE

- **Straight Ramping**



- **Helical Milling**



DCX Cutting Dia. Max.	Straight Ramp Down			Helical Ramp Down		
	RPMX Ramp Angle Max.	APMX Depth of Cut Max.	L Min. Length	HD Min. Dia.	HD Max. Dia.	Max. Pitch / Rev.
1.250	.45°	0.078	10.020	1.760		0.010
					2.500	0.030
1.500	.50°		9.018	2.280		0.020
					3.000	0.035
2.000	.50°		9.018	3.200		0.030
					4.000	0.050
2.500	.45°		10.020	4.182		0.040
					5.000	0.060
3.000	.35°		12.883	5.180		0.040
					6.000	0.055
4.000	.30°		15.030	7.170		0.050
					8.000	0.060

DIPOSFEED™ 04 OPERATING GUIDELINES

Materials				Vc Cutting Speed SFM	fz Feed/Tooth (inch)	Harder <----------> Tougher			Coolant
ISO	Mat'l Group #VDI 3323	Type	Examples			IN2504	IN2505	IN2530	
P	1 thru 5	Non-alloy Steel	1018, A36, 1045, A572, 1070	400 -1000	.007-.060		1	2	NO
	6 thru 9	Low-alloy Steel	4140, 4340, P20, 8620, 300M	300-900		2	1	3	
	10, 11	High-alloy Steel	H13, A2, D2, M2, T1	300-650		2	1	3	
M	12 thru 13	Stainless Steel (Ferritic & Martensitic)	410, 416, 440	300-650	.007-.030		2	1	YES
	14	Stainless Steel (Austenitic)	303, 304, 316, 15-5, 17-4	300-550			2	1	
K	15 thru 16	Gray Cast Iron	CLS. 20, 30, 45	500-1300	.007-.040		1		NO
	17 thru 20	Nodular Cast Iron	60-40-18, 100-70-03				1		
S	31 thru 35	High-Temp Alloys	Inconel, Hastelloy, Nimonic, Monel	65-150	.007-.025		2	1	YES
	36 thru 37	Titanium Alloys	6AL-4V, 5Al-5Mo-5V-3Cr	100-250			2	1	
H	38 thru 39	Hardened Steel >48	A2, 01, D2	160-350	.007-.020	1	2		NO

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.

DIPOSFEED™ 06 OPERATING GUIDELINES FORMERLY HI-FEED MINI

Materials				Vc Cutting Speed SFM	fz Feed/Tooth (inch)	Harder <----------> Tougher						Coolant
ISO	Mat'l Group #VDI 3323	Type	Examples			IN2504	IN2505	IN2510	IN2530	IN2035	IN7035	
P	1 thru 5	Non-alloy Steel	1018, A36, 1045, A572, 1070	400 -1000	.010-.060		1		2			NO
	6 thru 9	Low-alloy Steel	4140, 4340, P20, 8620, 300M	300-900		2	1		3			
	10, 11	High-alloy Steel	H13, A2, D2, M2, T1	300-650	.010-.040	2	1		3			
M	12 thru 13	Stainless Steel (Ferritic & Martensitic)	410, 416, 440	300-650	.010-.030				3	2	1	YES
	14	Stainless Stee (Austenitic)	303, 304, 316, 15-5, 17-4	300-550					3	2	1	
K	15 thru 16	Gray Cast Iron	CLS. 20, 30, 45	400-750	.020-.040		2	1				NO
	17 thru 20	Nodular Cast Iron	60-40-18, 100-70-03				2	1				
S	31 thru 35	High-Temp Alloys	Inconel, Hastelloy, Nimonic, Monel	65-150	0.010-.030				3	2	1	YES
	36 thru 37	Titanium Alloys	6AL-4V, 5Al-5Mo-5V-3Cr	100-250					3	2	1	
H	38 thru 39	Hardened Steel >48	A2, 01, D2	160-350	.010-025	1	2					NO

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.

DIPOSFEED™ 09 OPERATING GUIDELINES

FORMERLY HIFEED MDI™

Materials				Vc Cutting Speed SFM	fz Feed/Tooth (inch)	Harder <----------> Tougher						Coolant
ISO	Mat'l Group #VDI 3323	Type	Examples			IN2504	IN2505	IN2510	IN2530	IN2035	IN7035	
P	1 thru 5	Non-alloy Steel	1018, A36, 1045, A572, 1070	400 -1000	.010-.060		1		2			NO
	6 thru 9	Low-alloy Steel	4140, 4340, P20, 8620, 300M	400-850	.015-.118	2	1		3			
	10, 11	High-alloy Steel	H13, A2, D2, M2, T1	300-600	.010-.100	2	1		3			
M	12 thru 13	Stainless Steel (Ferritic & Martensitic)	410, 416, 440	330-700	.010-.100				3	2	1	YES
	14	Stainless Steel (Austenitic)	303, 304, 316, 15-5, 17-4	260-560	.010-.080				3	2	1	
K	15 thru 16	Gray Cast Iron	CLS. 20, 30, 45	500-1300	.020-.040		2	1				NO
	17 thru 20	Nodular Cast Iron	60-40-18, 100-70-03				2	1				
S	31 thru 35	High-Temp Alloys	Inconel, Hastelloy, Nimonic, Monel	65-200	.010-.040				3	2	1	YES
	36 thru 37	Titanium Alloys	6AL-4V, 5Al-5Mo-5V-3Cr	100-250	.010-.060				3	2	1	
H	38 thru 39	Hardened Steel >48	A2, 01, D2	160-375	.010-.080	1	2					NO

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.

DIPOSFEED™ 11 OPERATING GUIDELINES

Materials				Vc Cutting Speed SFM	fz Feed/Tooth (inch)	Harder <----------> Tougher					Coolant
ISO	Mat'l Group #VDI 3323	Type	Examples			IN2504	IN2505	IN6537	IN2530	IN2035	
P	1 thru 5	Non-alloy Steel	1018, A36, 1045, A572, 1070	400 -1000	.012-.160		2	1			NO
	6 thru 9	Low-alloy Steel	4140, 4340, P20, 8620, 300M	300-900		3	2	1			
	10, 11	High-alloy Steel	H13, A2, D2, M2, T1	300-650	.012-.100	3	2	1			
M	12 thru 13	Stainless Steel (Ferritic & Martensitic)	410, 416, 440	300-650	.012-.100		3		2	1	YES
	14	Stainless Steel (Austenitic)	303, 304, 316, 15-5, 17-4	300-550			3		2	1	
K	15 thru 16	Gray Cast Iron	CLS. 20, 30, 45	500-1300	.012-.060		1				NO
	17 thru 20	Nodular Cast Iron	"00-70-03				1				
S	31 thru 35	High-Temp Alloys	Inconel, Hastelloy, Nimonic, Monel	65-150	.012-.060		2		1		YES
	36 thru 37	Titanium Alloys	6AL-4V, 5Al-5Mo-5V-3Cr	100-250			2		1		
H	38 thru 39	Hardened Steel >48	A2, 01, D2	160-350	.012-.080	1	2				NO

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.