



# DIPOSFEED™

MILLING PRODUCTS



**Cutter Series:**

- 1TG1B (4MM) **NEW**
- 1TG1F, TG1F (6MM)
- 1TG1G, TG1G, TG2G (9MM)
- 1TG1J, TG1J, TG2J (11MM) **NEW**

**Diameters:**

.312" to 4.000"

**Insert Series:**

- UNLU04 **NEW**
- UNLU06 (Formerly HiFeed Mini)
- UNLU09 (Formerly HiFeed Midi)
- UNLU11 **NEW**

**Insert Grades:**

- IN2504
- IN2505
- IN2510
- IN2530
- IN6530
- IN6537 **NEW**
- 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 4MM, 6MM, 9MM and 11MM. 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:**

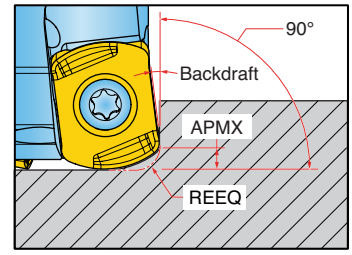
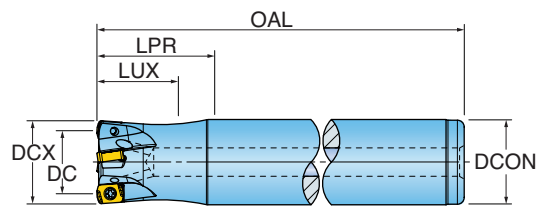
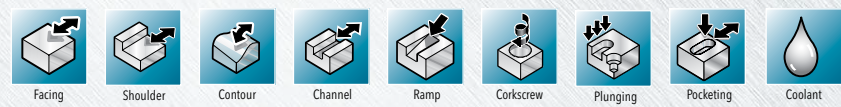
- Cutter body options include: End Mill, Top-On, Chip Surfer and Face Mill
- Cutter diameter range, .312 up to 4.00 inch
- Higher insert densities for super productivity!
- Depth of cut (DOC) capability from .5mm (.020) to 2mm (.078)
- APT ranges from .007 to .160 allow for extreme productivity!
- Optimal insert cutting edge preparations & 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)



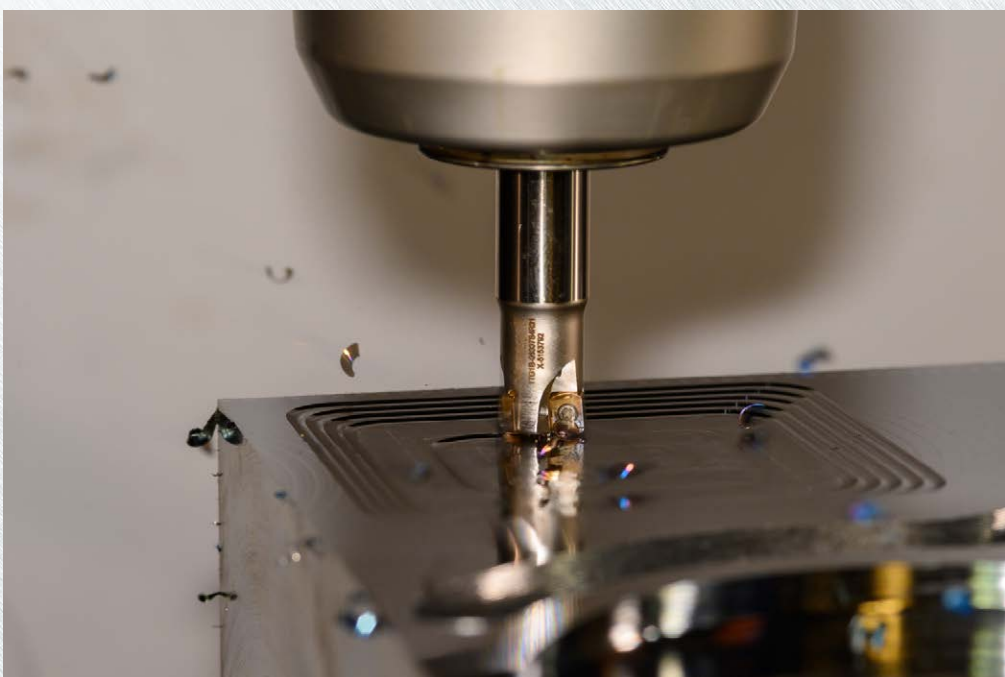


**DIPOSFEEED™ 04 SERIES 1TG1B (CYLINDRICAL SHANK) NEW**

**END MILLS (4MM INSERT)**



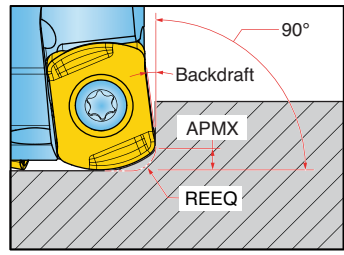
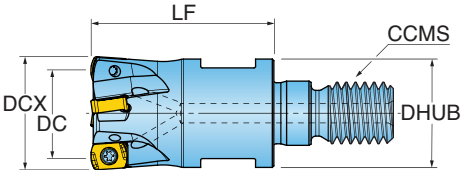
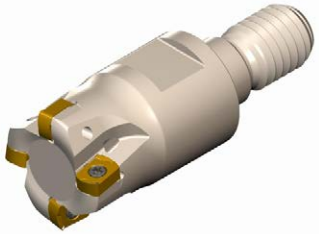
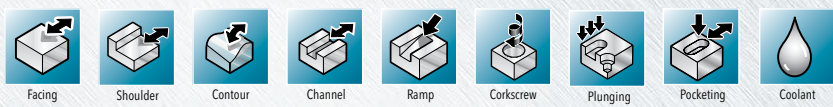
Part Number	DCX Cutting Dia. Max.	DC Cutting Dia.	LUX Usable Length Max.	LPR Protruding Length	OAL Overall Length	ZEFF Eff. Teeth	REEQ Program Radius Equivalent	DCON Shank Dia.	RMPX Ramp Angle Max.	APMX Depth of Cut Max.
1TG1B-03007R7R01	0.312	0.150	0.62	0.75	3.25	1	0.035	0.312	.64	0.020
1TG1B-03007R8R01	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



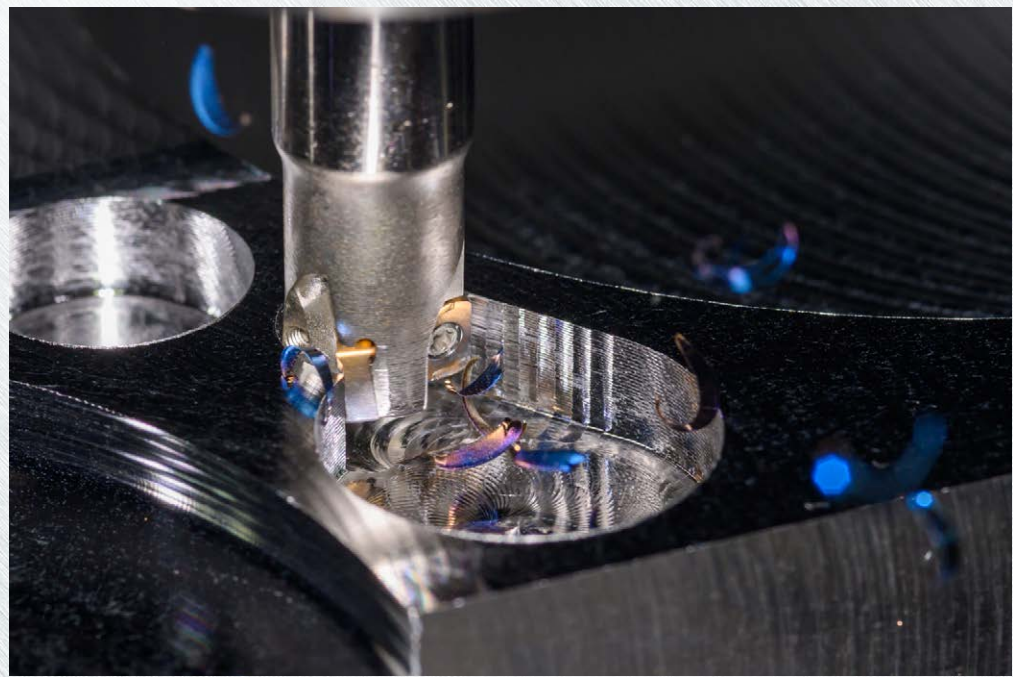


**DIPOSFEED™ 04 SERIES 1TG1B (TOP-ON STYLE) NEW**

**MODULAR END MILLS (4MM INSERT)**



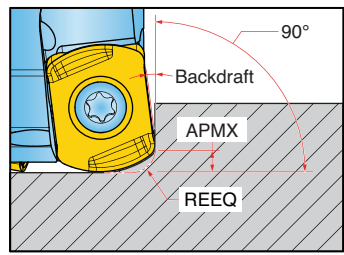
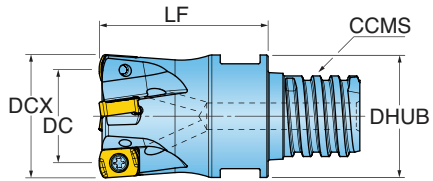
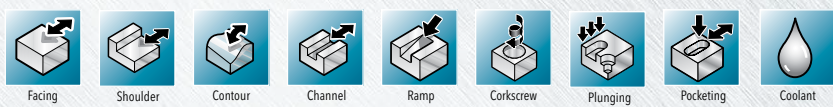
Part Number	DCX Cutting Dia. Max.	DC Cutting Diameter	LF Functional Length	ZEFF Effective Teeth	REEQ Program Radius Equivalent	DHUB Hub Diameter	CCMS Connection Code	RMPX Ramp Angle Max.	APMX Depth of Cut Max.
1TG1B-03006X4R01	0.394	0.224	0.67	2	0.035	0.38	TopOn M06	.9	0.020
1TG1B-04006X4R01	0.438	0.266	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





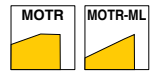
**DIPOSFEEED™ 04 SERIES 1TG1B (CHIP•SURFER STYLE) NEW**

HI-FEED MODULAR END MILLS  
(4MM INSERT)

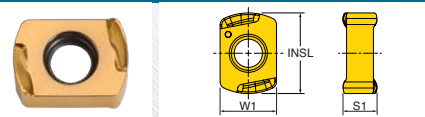


Part Number	DCX Cutting Dia. Max.	DC Cutting Diameter	LF Functional Length	ZEFF Effective Teeth	REEQ Program Radius Equivalent	DHUB Hub Diameter	CCMS Connection Code	RMPX Ramp Angle Max.	APMX Depth of Cut Max.
1TG1B-03006T6R01	0.394	0.224	0.63	2	0.035	0.37	Chip Surfer T06	.91	0.020
1TG1B-04006T6R01	0.438	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

**DIPOSFEEED™ 04 INSERTS NEW**









UNLU04

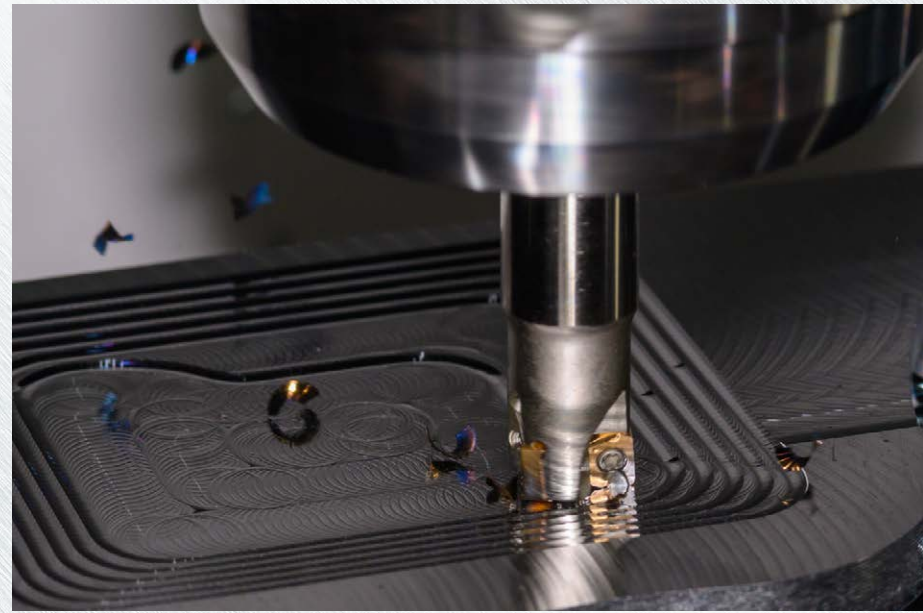


Part Number	Application	REEQ Program Radius Equivalent	INSL Insert Length	W1 Insert Width	S1 Thickness Overall	NOI Number of Indexes	IH Insert Hand	Grade	IN2504	IN2505	IN2530
UNLU0402MOTR	Multi-Purpose	.035	.236	.165	.098	4	Right		•	•	•
UNLU0402MOTR-ML	Precision	.035	.236	.165	.098	4	Right			•	•



**DIPOSFEED™ 04 HARDWARE** NEW

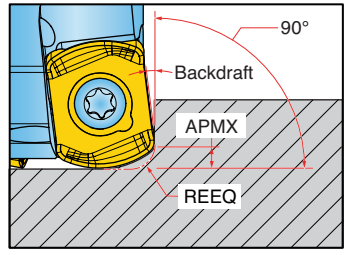
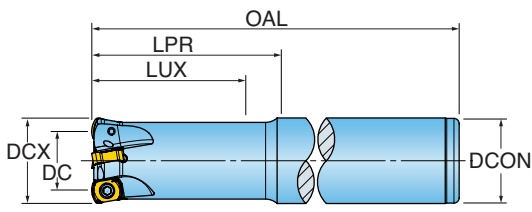
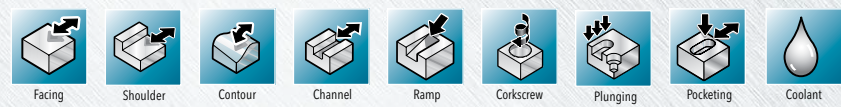
							
	Screw	Driver	**OPTIONAL** Torque Driver Handle	**OPTIONAL** Preset Torque Bit	**OPTIONAL** Torque Driver Bit	**OPTIONAL** Wrench	
1TG1B-03007R7R01	SM18-041-00	DS-TP06S	DS-A00-.25S	DT-05-.25	DS-TP06TB	-	
1TG1B-03007R8R01	SM18-041-00	DS-TP06S	DS-A00-.25S	DT-05-.25	DS-TP06TB	-	
1TG1B-04007R9R01	SM18-041-00	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	
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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	





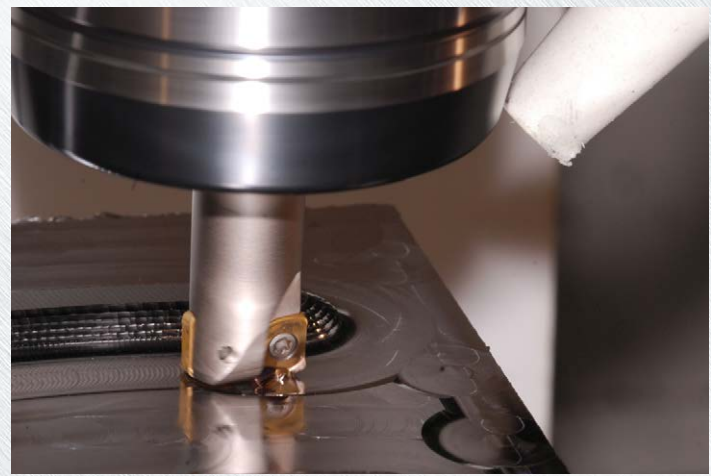
**DIPOSFEEED™ 06 SERIES 1TG1F (CYLINDRICAL/WELDON SHANK) FORMERLY HI-FEED MINI**

**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

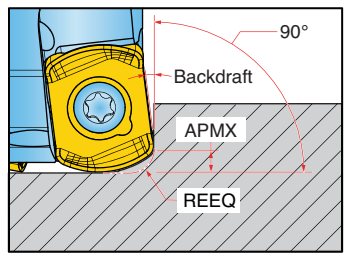
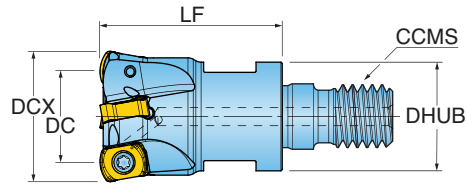
\* Weldon Shank





**DIPOSFEEED™ 06 SERIES 1TG1F (TOP•ON STYLE)** *FORMERLY HI•FEED<sup>MINI</sup>*

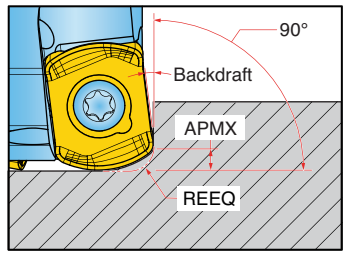
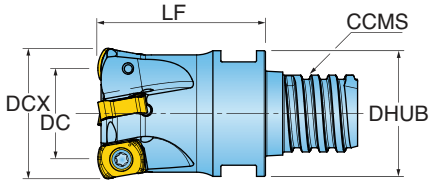
**MODULAR END MILLS (6MM INSERT)**



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

**DIPOSFEEED™ 06 SERIES 1TG1F (CHIP•SURFER STYLE)** *FORMERLY HI•FEED<sup>MINI</sup>*

**HI-FEED MODULAR END MILLS (6MM INSERT)**

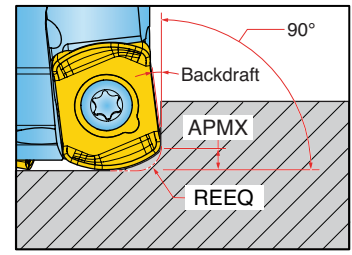
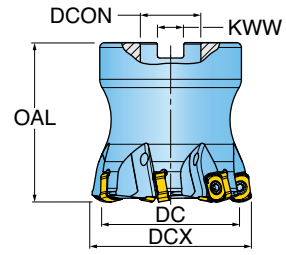
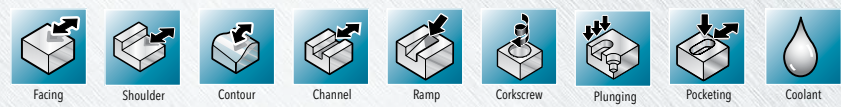


Part Number	DCX Cutting Dia. Max.	DC Cutting Diameter	LF Functional Length	ZEFF Effective Teeth	REEQ Program Radius Equivalent	DHUB Hub Diameter	CCMS Connection Code	RMPX Ramp Angle Max.	APMX Depth of Cut Max.
1TG1F-06008TRR01	0.625	0.365	0.83	2	0.060	0.60	Chip Surfer T10	1.5	0.028
1TG1F-07010TSR01	0.750	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



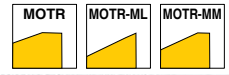
**DIPOSFEEED™ 06 SERIES TG1F** FORMERLY **HI-FEED MINI**

FACE MILLS (6MM INSERT)

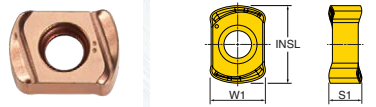


Part Number	DCX Cutting Dia. Max.	DC Cutting Dia.	OAL Overall Length	ZEFF Eff. Teeth	REEQ Program Radius Equivalent	DCON Shank Dia.	KWW Keyway	RMPX Ramp Angle Max.	APMX Depth of Cut Max.
TG1F-20R01	2.000	1.696	1.97	7	0.060	0.750	0.31	.5	0.043

**DIPOSFEEED™ 06 INSERTS** FORMERLY **HI-FEED MINI**



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
UNLU0603MOTR	Multi-Purpose	0.060	0.354	0.251	0.142	4	Right		•	•	•	•	•	
UNLU0603MOTR-ML	Precision	0.060	0.354	0.251	0.142	4	Right		•		•		•	•
UNLU0603MOTR-MM	Positive	0.060	0.354	0.251	0.142	4	Right		•	•	•		•	•

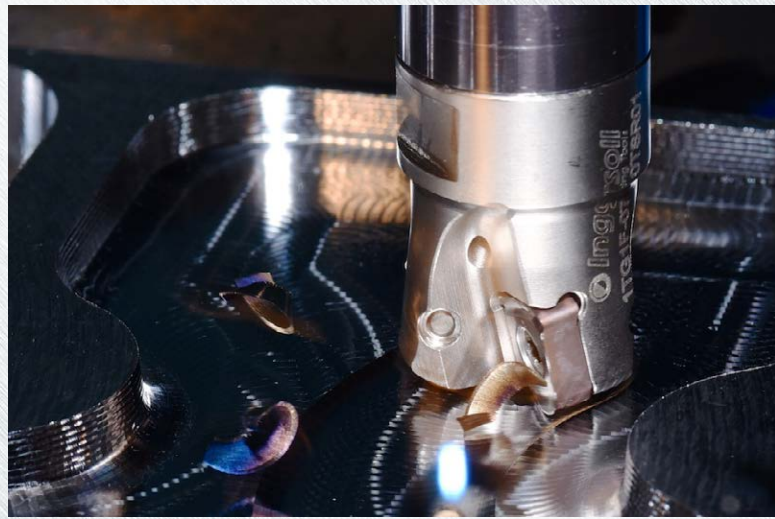






**DIPOSFEEED™ 06 HARDWARE** **FORMERLY**  
**HiFEED™ MINI**

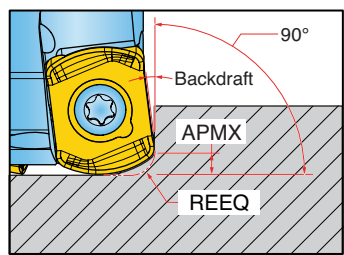
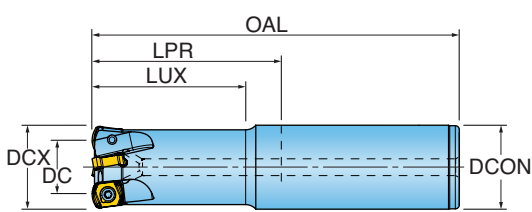
								
	Insert Screw	Driver	Socket Head Cap Screw	Coolant Bolt	Torque Driver Handle	Preset Torque Bit	Torque Driver Bit	Wrench
1TG1F-0601556R01	SM25-075-20	DS-T08W	-	-	DS-A00-.25T	DT-11-.25	DS-0021	-
1TG1F-06015ULR01	SM25-075-20	DS-T08W	-	-	DS-A00-.25T	DT-11-.25	DS-0021	-
1TG1F-07017UMR01	SM25-075-20	DS-T08W	-	-	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	-





**DIPOSFEEED™ 09 SERIES 1TG1G (CYLINDRICAL/WELDON SHANK) FORMERLY HI-FEED™ MIDI™**

**END MILLS (9MM INSERT)**

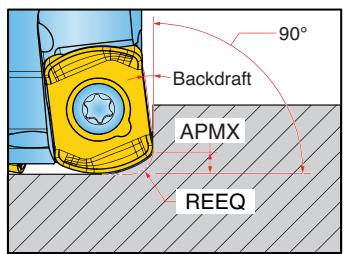
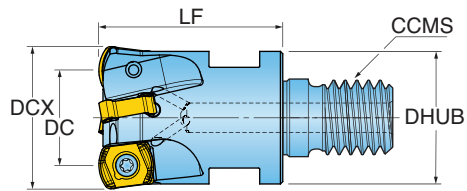


Part Number	DCX Cutting Dia. Max.	DC Cutting Dia.	LUX Usable Length Max.	LPR Protruding Length	OAL Overall Length	ZEFF Eff. Teeth	REEQ Program Radius Equivalent	DCON Shank Dia.	RMPX Ramp Angle Max.	APMX Depth of Cut Max.
1TG1G-10019S1R03*	1.000	0.594	1.80	1.97	7.00	3	0.094	1.000	3	0.060
1TG1G-10020S1R03*	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

**DIPOSFEEED™ 09 SERIES 1TG1G (TOP-ON STYLE) FORMERLY HI-FEED™ MIDI™**

**MODULAR END MILLS (9MM INSERT)**

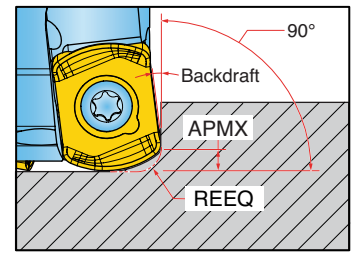
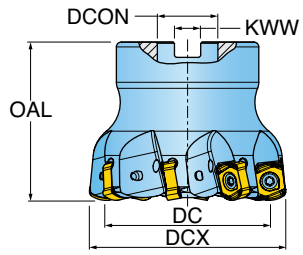


Part Number	DCX Cutting Dia. Max.	DC Cutting Diameter	LF Functional Length	ZEFF Effective Teeth	REEQ Program Radius Equivalent	DHUB Hub Diameter	CCMS Connection Code	RMPX Ramp Angle Max.	APMX Depth of Cut Max.
1TG1G-10015X7R03	1.000	0.594	1.57	3	0.094	0.82	TopOn M12	3	0.060
1TG1G-12015X8R04	1.250	0.841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



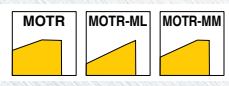
**DIPOSFEEED™ 09 SERIES TG1G, TG2G** **FORMERLY HI-FEED MIBI™**

**FACE MILLS (9MM INSERT)**

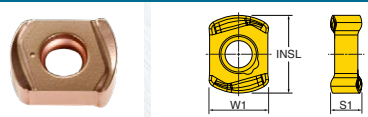


Part Number	DCX Cutting Dia. Max.	DC Cutting Dia.	OAL Overall Length	ZEFF Eff. Teeth	REEQ Program Radius Equivalent	DCON Shank Dia.	KWW Keyway	RMPX Ramp Angle Max.	APMX Depth of Cut Max.
TG1G-20R01	2.000	1.593	1.97	7	0.094	0.750	0.31	1	0.060
TG2G-20R01	2.000	1.593	1.97	6	0.094	0.750	0.31	1	0.060
TG1G-25R01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

**DIPOSFEEED™ 09 INSERTS** **FORMERLY HI-FEED MIBI™**












**UNLU09**

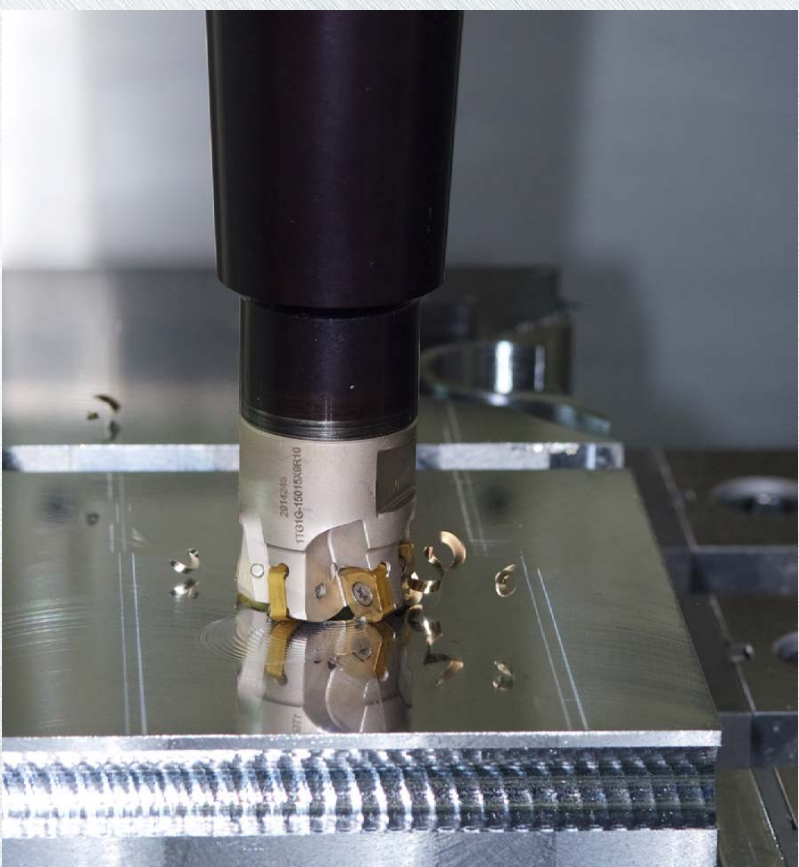


Part Number	Application	REEQ Program Radius Equivalent	INSL Insert Length	W1 Insert Width	S1 Thickness Overall	NOI Number of Indexes	IH Insert Hand	Grade	IN2035	IN2504	IN2505	IN2510	IN2530	IN7035
UNLU0904MOTR	Multi-Purpose	0.094	0.469	0.361	.189	4	Right		•	•	•	•	•	•
UNLU0904MOTR-ML	Precision	0.094	0.469	0.361	.189	4	Right		•		•		•	•
UNLU0904MOTR-MM	Positive Geometry	0.094	0.469	0.361	.189	4	Right		•	•	•		•	•



**DIPOSFEEED™ 09 HARDWARE** FORMERLY **HI-FEED MIBI™**

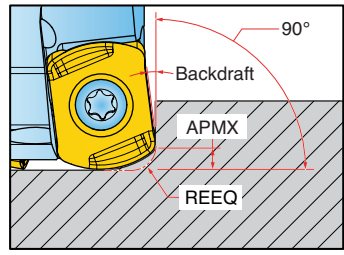
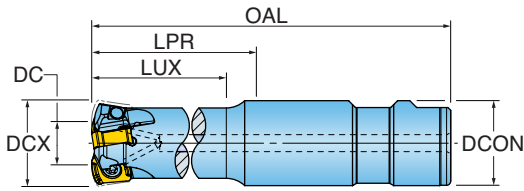
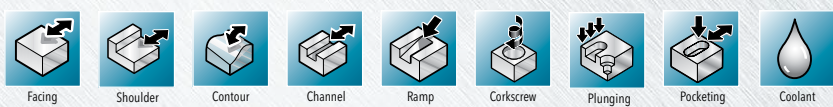
									
	Screw	Driver Handle	Driver Blade	Socket Head Cap Screw	**OPTIONAL** Coolant Bolt	**OPTIONAL** Torque Driver Handle	**OPTIONAL** Preset Torque Bit	**OPTIONAL** Torque Driver Bit	**OPTIONAL** Wrench
1TG1G-10019S1R03	SM35-088-10	DS-A00T	DS-T106B	-	-	DS-A00-.25-T	DT-30-.25	DS-T10B1	-
1TG1G-10020S1R03	SM35-088-10	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	-





**DIPOSFEEED™ 11 SERIES 1TG1J (WELDON SHANK) NEW**

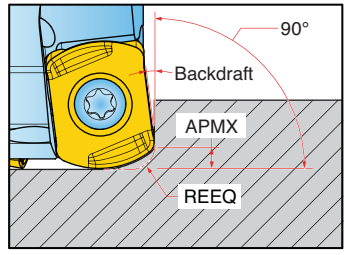
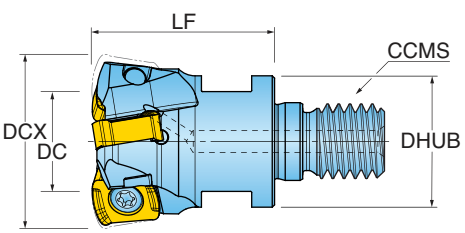
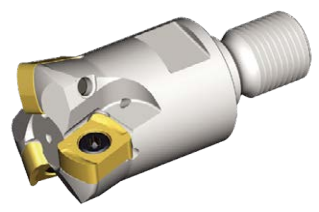
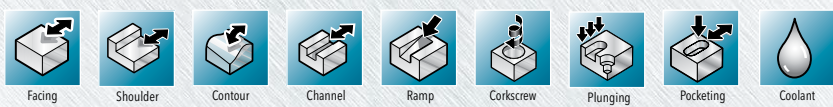
**END MILLS (11MM INSERT)**



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

**DIPOSFEEED™ 11 SERIES 1TG1J (TOP•ON STYLE) NEW**

**MODULAR END MILLS (11MM INSERT)**

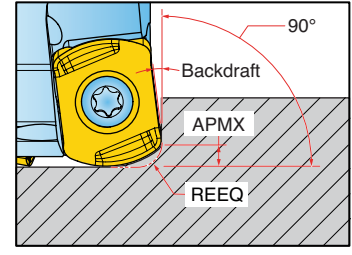
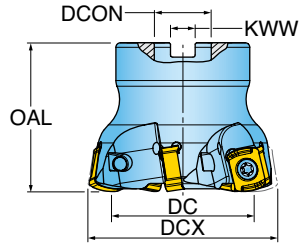
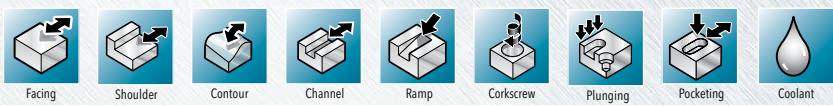


Part Number	DCX Cutting Dia. Max.	DC Cutting Diameter	LF Functional Length	ZEFF Effective Teeth	REEQ Program Radius Equivalent	DHUB Hub Diameter	CCMS Connection Code	RMPX Ramp Angle Max.	APMX Depth of Cut Max.
1TG1J-12015X8R01	1.250	0.650	1.57	2	0.120	1.13	TopOn M16	.48	0.078
1TG1J-15015X8R01	1.500	0.900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



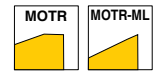
**DIPOSFEEED™ 11 SERIES TG1J, TG2J** **NEW**

FACE MILLS (11MM INSERT)

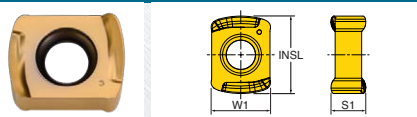


Part Number	DCX Cutting Dia. Max.	DC Cutting Dia.	OAL Overall Length	ZEFF Eff. Teeth	REEQ Program Radius Equivalent	DCON Shank Dia.	KWW Keyway	RMPX Ramp Angle Max.	APMX Depth of Cut Max.
TG1J-20R01	2.000	1.384	1.970	5	0.120	0.750	0.31	.5	0.078
TG2J-20R01	2.000	1.384	1.970	4	0.120	0.750	0.31	.5	0.078
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

**DIPOSFEEED™ 11 INSERTS** **NEW**



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
UNLU1105MOTR	Multi-Purpose	.120	.575	.441	.256	4	Right		•	•	•	•
UNLU1105MOTR-ML	Precision	.120	.575	.441	.256	4	Right			•	•	

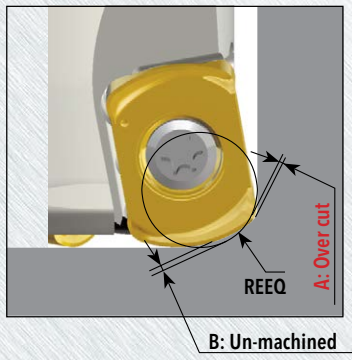


**DIPOSFEED™ 11 HARDWARE** NEW

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

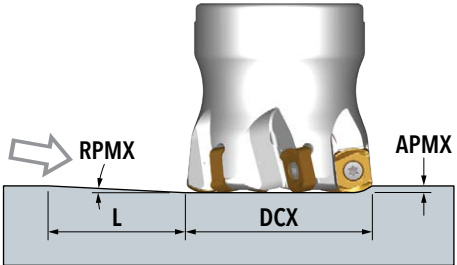


Part Number	REEQ Program Radius Equivalent	A Over Cut	B Un-Machined
UNLU0402M0TR	0.035	0	0.01
UNLU0603M0TR	0.060	0	.010 ---> .022 Max.
UNLU0904M0TR	0.094	0	0.025
UNLU1105M0TR	0.120	0	0.035

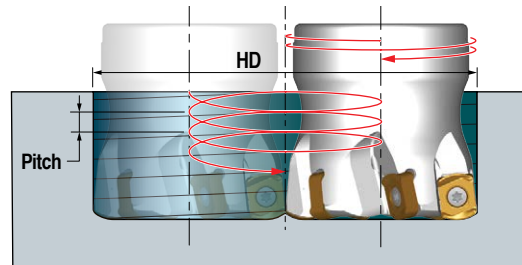


**DIPOSFEEED™ 04 RECOMMENDED RAMPING ANGLE** NEW

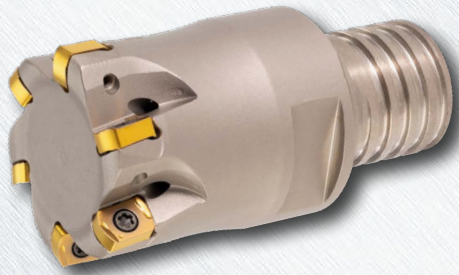
• Straight Ramping



• 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	

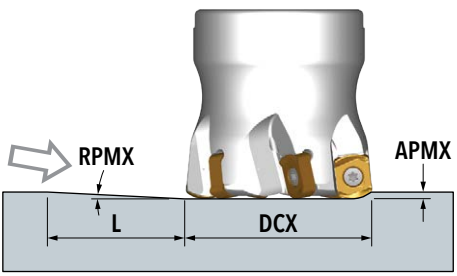




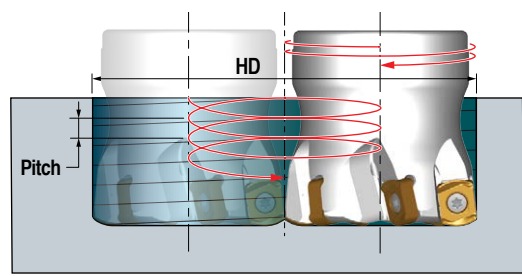


**DIPOSFEEED™ 06 RECOMMENDED RAMPING ANGLE** FORMERLY HI-FEED MINI

• Straight Ramping



• Helical Milling



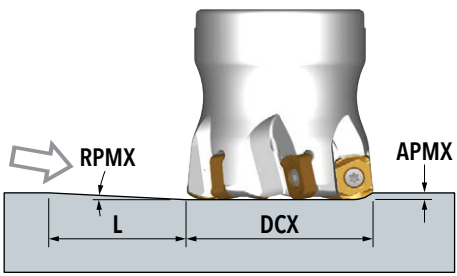
DCX Cutting Dia. Max.	Straight Ramp Down			Helical Ramp Down		
	RPMX Ramp Angle Max.	APMX Depth of Cut Max.	L Min. Length	HD Min. Dia.	HD Max. Dia.	Max. Pitch / Rev.
0.625	1.5°	0.028	1.069	.875	-	0.020
				-	1.25	0.050
0.750	1.5°	0.032	1.222	1.092	-	0.025
				-	1.500	0.060
0.875	1.0°	0.043	2.463	1.312	-	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	



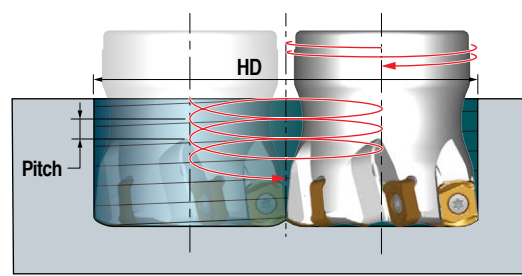


**DIPOSFEEED™ 09 RECOMMENDED RAMPING ANGLE** FORMERLY HI-FEED MDCI™

• Straight Ramping



• Helical Milling



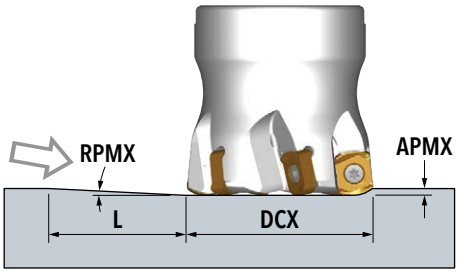
DCX Cutting Dia. Max.	Straight Ramp Down			Helical Ramp Down			
	RPMX Ramp Angle Max.	APMX Depth of Cut Max.	L Min. Length	HD Min. Dia.	HD Max. Dia.	Max. Pitch / Rev.	
1.000	3.0°	0.060	1.145	1.354	-	0.060	
1.250	2.0°		1.718	1.842	-		
1.500	1.5°		2.291	2.338	-		
2.000	1.0°		3.437	3.344	-		
2.500	.75°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



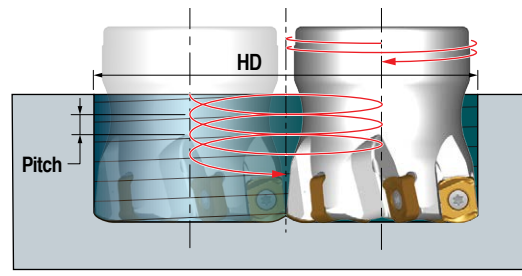


**DIPOSFEED™ 11 RECOMMENDED RAMPING ANGLE** NEW

• 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
1.500	.50°		9.018	2.280	2.500	0.030
2.000	.50°		9.018	3.200	3.000	0.035
2.500	.45°		10.020	4.182	4.000	0.050
3.000	.35°		12.883	5.180	5.000	0.060
4.000	.30°		15.030	7.170	6.000	0.055
					8.000	0.060

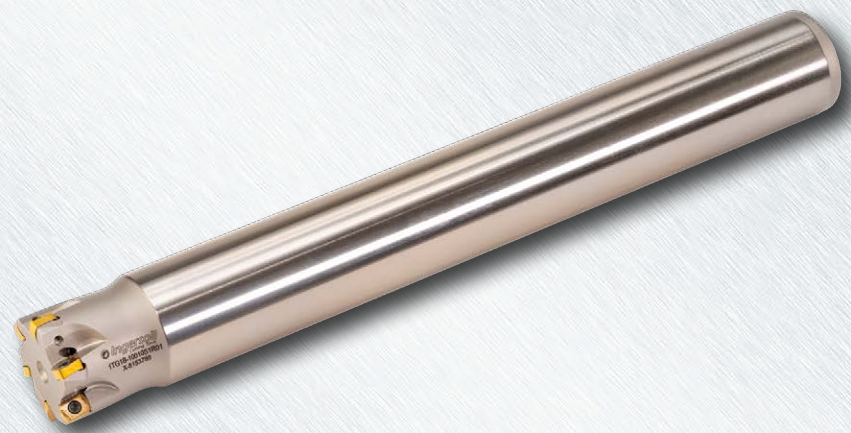




**DIPOSFEED™ 04 OPERATING GUIDELINES** NEW

ISO	Materials			Vc Cutting Speed SFM	fz Feed/Tooth (inch)	Harder <-----> Tougher			Coolant
	Mat'l Group #VDI 3323	Type	Examples			IN2504	IN2505	IN2530	
<b>P</b>	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	
<b>M</b>	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	
<b>K</b>	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		
<b>S</b>	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	
<b>H</b>	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.





**DIPOSFEEED™ 06 OPERATING GUIDELINES** FORMERLY HI-FEED MINI

ISO	Materials			Vc Cutting Speed SFM	fz Feed/Tooth (inch)	Harder <-----> Tougher						Coolant
	Mat'l Group #VDI 3323	Type	Examples			IN2504	IN2505	IN2510	IN2530	IN2035	IN7035	
<b>P</b>	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		2	1		3			
<b>M</b>	12 thru 13	"Stainless Steel (Ferritic & Martensitic)"	410, 416, 440	300-650	.010-.030				3	2	1	YES
	14	Stainless Steel (Austenitic)	"303, 304, 316, 15-5, 17-4"	300-550					3	2	1	
<b>K</b>	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				
<b>S</b>	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	
<b>H</b>	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.





**DIPOSFEEED™ 09 OPERATING GUIDELINES** FORMERLY HI-FEED MDT™

ISO	Materials			Vc Cutting Speed SFM	fz Feed/Tooth (inch)	Harder <-----> Tougher						Coolant
	Mat'l Group #VDI 3323	Type	Examples			IN2504	IN2505	IN2510	IN2530	IN2035	IN7035	
<b>P</b>	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			
<b>M</b>	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	
<b>K</b>	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				
<b>S</b>	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	
<b>H</b>	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** NEW

ISO	Materials			Vc Cutting Speed SFM	fz Feed/Tooth (inch)	Harder <-----> Tougher				Coolant
	Mat'l Group #VDI 3323	Type	Examples			IN2504	IN2505	IN6537	IN2530	
<b>P</b>	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		3	2	1		
<b>M</b>	12 thru 13	"Stainless Steel (Ferritic & Martensitic)"	410, 416, 440	300-650	.012-.100		2		1	YES
	14	Stainless Steel (Austenitic)	"303, 304, 316, 15-5, 17-4"	300-550			2		1	
<b>K</b>	15 thru 16	Gray Cast Iron	CLS. 20, 30, 45	500-1300	.012-.060		1			NO
	17 thru 20	Nodular Cast Iron	"60-40-18, 100-70-03"				1			
<b>S</b>	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	
<b>H</b>	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.

