SFEEDUP™ HIGH SPEED & FEED

INDUSTRY 4.0 PRODUCT ANNOUNCEMENT •UPDATE• 2024

HIPOSTRIO™

MILLING PRODUCTS

Cutter Series: (DOC)
1KJ1B (.13")
1KJ1D, KJ5D, KJ6D (.27")
1KJ1G, KJ5G, KJ6G (.41")
1KJ1P, KJ5P, KJ6P (.57")
1K_1B Chamfer Mill (Modular)
1K_1D Chamfer Mill (Cyl.)

Insert Series:
THLS04, THES06, THLS06
THES10, THLS10, THES13, THLS13

Adaptions
Cylindrical, Weldon, Top-On, ChipSurfer, Face Mill

Diameter Range:
.312" - 6.500"
10.00-160.00mm

Cutting Edge Angle:
30°, 45°, 60°, 90°

Corner Geometry
.008R, .015R, .031R, .062R, .094R, .125R

Materials:
Cast Iron, Aluminum, Steel, Stainless Steel, Hard Steel, High-Temp Alloys, Titanium

3-Edged HiPosTrio inserts priced like 2-Edged HiPos product equals 1 free edge!

Ingersoll's HiPosTrio line has been expanded to include a new 04 IC size insert that accommodates smaller diameter and higher density end mills…making it a great solid carbide alternative. It compliments an already superb general purpose 90° Milling line that blends performance and economy.

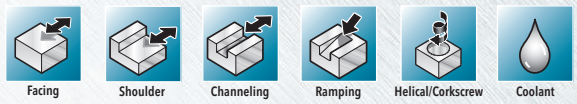
Features & Benefits:

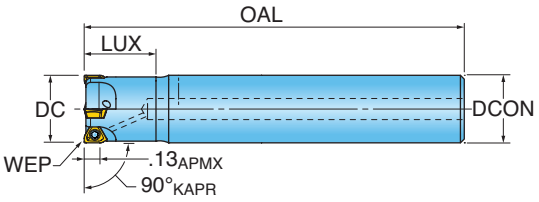
- High positive cutting geometry; ideal for small machines and gummy materials
- Four insert sizes for complete cutter diameter, depth & density coverage; New 4mm insert size
- Ramping capability for cutting versatility
- Inserts with integrated wiper flats typically produce surface finishes between 32-63 Ra
- All cutters with coolant thru up to 5.00" diameter
- New cutter and insert expansions to existing lines

Member IMC Group Ingersoll Cutting Tools

HIPOSTRIO™ 04 SERIES: 1KJ1B (CYLINDRICAL SHANK)

90° END MILL (4MM INSERT)





WEP - See insert drawing for wiper options.

INCH

Part Number	DC Cutting Diameter	LUX Usable Length Max.	OAL Overall Length	ZEFF Effective Teeth	DCON Shank Diameter	RMPX Ramp Angle Max.
1KJ1B-03006R7R01	0.312	0.62	3.00	1	0.312	2.1
1KJ1B-03007R8R01	0.375	0.75	3.00	1	0.375	2.1
1KJ1B-04007S4R01	0.437	0.75	3.00	2	0.500	3.0
1KJ1B-05008S4R01	0.500	0.87	3.50	3	0.500	2.5
1KJ1B-05010S6R01	0.562	1.00	3.50	3	0.625	2.2
1KJ1B-06010S6R01	0.625	1.00	3.50	4	0.625	1.6

METRIC

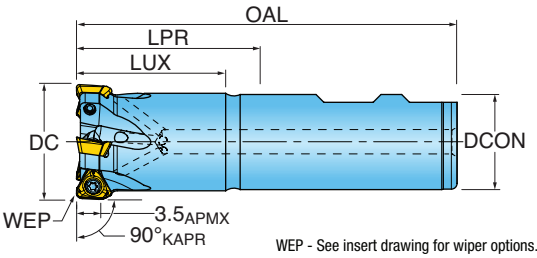
Part Number	DC Cutting Diameter	LUX Usable Length Max.	OAL Overall Length	ZEFF Effective Teeth	DCON Shank Diameter	RMPX Ramp Angle Max.
1KJ1B010016T1R00	10.00	16.0	55.0	2	10.00	5.5
1KJ1B012017T2R00	12.00	17.0	60.0	3	12.00	2.5
1KJ1B016019T3R00	16.00	19.0	90.0	4	16.00	1.7
1KJ1B020017T4R00	20.00	17.0	105.0	5	20.00	1.3
1KJ1B025065T4R00	25.00	65.0	115.0	6	20.00	0.7

*Designed with modification in mind. Extend usable length by turning back the neck diameter or shorten the overall length by cutting off back end.

HIPOSTRIO™ 04 SERIES: 1KJ1B (WELDON STYLE)

90° MODULAR END MILL (4MM INSERT)

Facing | Shoulder | Channeling | Ramping | Helical/Corkscrew | Coolant



WEP - See insert drawing for wiper options.

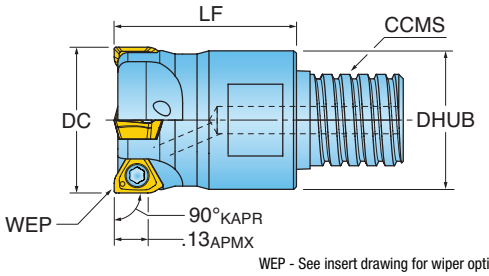
METRIC

Part Number	DC Cutting Diameter	LUX Usable Length Max.	LPR Protruding Length	OAL Overall Length	ZEFF Effective Teeth	DCON Shank Diameter	RMPX Ramp Angle Max.
1KJ1B010018W3R00	10.00	18.0	32.0	80.0	2	16.00	5.5
1KJ1B012020W3R00	12.00	20.0	32.0	80.0	3	16.00	2.5
1KJ1B016026W3R00	16.00	26.0	37.0	85.0	4	16.00	1.7
1KJ1B020030W4R00	20.00	30.0	40.0	90.0	5	20.00	1.3
1KJ1B025040W5R00	25.00	40.0	44.0	100.0	6	25.00	0.7

HIPOSTRIO™ 04 SERIES: 1KJ1B (CHIPSURFER STYLE)

90° MODULAR END MILL (4MM INSERT)

Facing | Shoulder | Channeling | Ramping | Helical/Corkscrew | Coolant

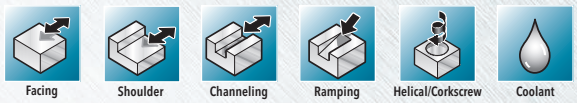


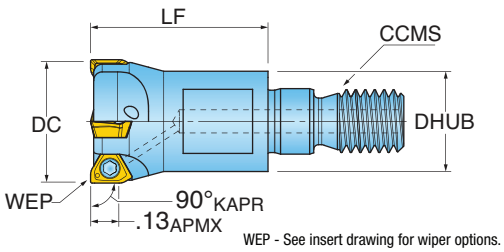
WEP - See insert drawing for wiper options.

Part Number	DC Cutting Diameter	LF Functional Length	ZEFF Effective Teeth	CCMS Connection Code	DHUB Hub Diameter	RMPX Ramp Angle Max.
1KJ1B-05006T8R01	0.500	0.65	3	Chip Surfer T08	0.48	2.5
1KJ1B-06008TRR01	0.625	0.80	4	Chip Surfer T10	0.60	1.6

HIPOSTRIO™ 04 SERIES: 1KJ1B (TOP•ON STYLE)

90° MODULAR END MILL (4MM INSERT)





WEP - See insert drawing for wiper options.

INCH

Part Number	DC Cutting Diameter	LF Functional Length	ZEFF Effective Teeth	CCMS Connection Code	DHUB Hub Diameter	RMPX Ramp Angle Max.
1KJ1B-05075X4R01	0.500	0.75	3	TopOn M06	0.46	2.5
1KJ1B-06087X5R01	0.625	0.88	4	TopOn M08	0.50	1.6

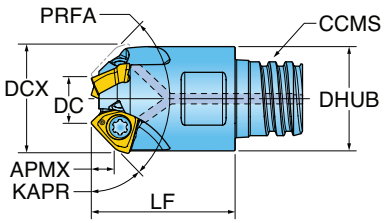
METRIC

Part Number	DC Cutting Diameter	LF Functional Length	ZEFF Effective Teeth	CCMS Connection Code	DHUB Hub Diameter	RMPX Ramp Angle Max.
1KJ1B010017X4R00	10.00	17.0	2	TopOn M06	9.8	5.5
1KJ1B012023X4R00	12.00	23.0	3	TopOn M06	11.8	2.5
1KJ1B012023X4R01	12.00	23.0	2	TopOn M06	11.8	2.5
1KJ1B016023X5R00	16.00	23.0	4	TopOn M08	13.0	1.7
1KJ1B020030X6R00	20.00	30.0	5	TopOnM10	18.0	1.3
1KJ1B025035X7R00	25.00	35.0	6	TopOnM12	21.0	0.7

HIPOSTRIO™ 04 SERIES: 1K_1B (CHIPSURFER STYLE)

MODULAR CHAMFER MILL (4MM INSERT)

Lead Angle | Chamfer | Coolant

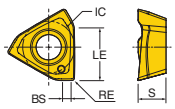


Part Number	DC Cutting Diameter	DCX Cutting Diameter Max.	KAPR Cutting Edge Angle	PRFA Profile Angle	APMX Depth of Cut Max.	LF Functional Length	ZEFF Effective Teeth	CCMS Connection Code	DHUB Hub Diameter
1KM1B-03006T8R01	0.330	0.500	60	60	0.125	0.65	3	Chip Surfer T08	0.48
1KN1B-02006T8R01	0.236	0.490	45	90	0.098	0.65	3	Chip Surfer T08	0.48
1KP1B-02006T8R01	0.236	0.555	30	120	0.068	0.65	3	Chip Surfer T08	0.48

HIPOSTRIO™ 04 INSERTS

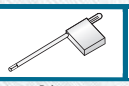
M

THLS04_M



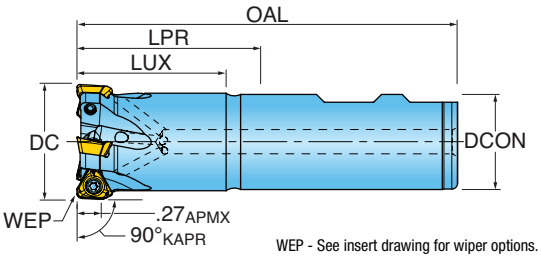
Part Number	Application	RE Corner Radius	BS Wiper Length	LE Cutting Edge Eff. Length	IC Inscribed Circle Dia.	S Thickness	IH Insert Hand	NOI Number of Indexes	Grade	IN2505	IN2530
THLS040202R-M	Multi-Purpose	0.008	0.027	0.130	0.153	0.083	Right	3		•	•
THLS040204R-M	Multi-Purpose	0.015	0.019	0.130	0.153	0.083	Right	3		•	•

HIPOSTRIO™ 04 HARDWARE

				 **OPTIONAL**	 **OPTIONAL**	 **OPTIONAL**	 **OPTIONAL**	 **OPTIONAL**	 **OPTIONAL**
		Insert Screw	Driver	Wrench	Thin Wrench	Torque Wrench	Torque Driver Handle	Preset Torque Bit	Torque Driver Bit
INCH	1KJ1B-03006R7R01	SM18-041-00	DS-TP06S-NEU	-	-	-	DS-A00-.25-S	DT-05-.25	DS-TP06B
	1KJ1B-03007R8R01	SM18-041-00	DS-TP06S-NEU	-	-	-	DS-A00-.25-S	DT-05-.25	DS-TP06B
	1KJ1B-04007S4R01	SM18-041-00	DS-TP06S-NEU	-	-	-	DS-A00-.25-S	DT-05-.25	DS-TP06B
	1KJ1B-05008S4R01	SM18-041-00	DS-TP06S-NEU	-	-	-	DS-A00-.25-S	DT-05-.25	DS-TP06B
	1KJ1B-05010S6R01	SM18-041-00	DS-TP06S-NEU	-	-	-	DS-A00-.25-S	DT-05-.25	DS-TP06B
	1KJ1B-06010S6R01	SM18-041-00	DS-TP06S-NEU	-	-	-	DS-A00-.25-S	DT-05-.25	DS-TP06B
	1KJ1B-03006T6R01	SM18-041-00	DS-TP06S-NEU	-	WS-0029	DT-90-08	DS-A00-.25-S	DT-05-.25	DS-TP06B
	1KJ1B-05006T8R01	SM18-041-00	DS-TP06S-NEU	-	WS-0030	DT-130-10	DS-A00-.25-S	DT-05-.25	DS-TP06B
	1KJ1B-06008TRR01	SM18-041-00	DS-TP06S-NEU	-	WS-0044	DT-250-13	DS-A00-.25-S	DT-05-.25	DS-TP06B
	1KJ1B-05075X4R01	SM18-041-00	DS-TP06S-NEU	-	-	-	DS-A00-.25-S	DT-05-.25	DS-TP06B
	1KJ1B-06087X5R01	SM18-041-00	DS-TP06S-NEU	610MM	-	-	DS-A00-.25-S	DT-05-.25	DS-TP06B
METRIC	1KJ1B010016T1R00	SM18-041-00	DS-TP06S-NEU	-	-	-	DS-A00-.25-S	DT-05-.25	DS-TP06B
	1KJ1B012017T2R00	SM18-041-00	DS-TP06S-NEU	-	-	-	DS-A00-.25-S	DT-05-.25	DS-TP06B
	1KJ1B016019T3R00	SM18-041-00	DS-TP06S-NEU	-	-	-	DS-A00-.25-S	DT-05-.25	DS-TP06B
	1KJ1B020017T4R00	SM18-041-00	DS-TP06S-NEU	-	-	-	DS-A00-.25-S	DT-05-.25	DS-TP06B
	1KJ1B025065T4R00	SM18-041-00	DS-TP06S-NEU	-	-	-	DS-A00-.25-S	DT-05-.25	DS-TP06B
	1KJ1B010018W3R00	SM18-041-00	DS-TP06S-NEU	-	-	-	DS-A00-.25-S	DT-05-.25	DS-TP06B
	1KJ1B012020W3R00	SM18-041-00	DS-TP06S-NEU	-	-	-	DS-A00-.25-S	DT-05-.25	DS-TP06B
	1KJ1B016026W3R00	SM18-041-00	DS-TP06S-NEU	-	-	-	DS-A00-.25-S	DT-05-.25	DS-TP06B
	1KJ1B020030W4R00	SM18-041-00	DS-TP06S-NEU	-	-	-	DS-A00-.25-S	DT-05-.25	DS-TP06B
	1KJ1B025040W5R00	SM18-041-00	DS-TP06S-NEU	-	-	-	DS-A00-.25-S	DT-05-.25	DS-TP06B
	1KJ1B010017X4R00	SM18-041-00	DS-TP06S-NEU	-	-	-	DS-A00-.25-S	DT-05-.25	DS-TP06B
	1KJ1B012023X4R00	SM18-041-00	DS-TP06S-NEU	-	-	-	DS-A00-.25-S	DT-05-.25	DS-TP06B
	1KJ1B012023X4R01	SM18-041-00	DS-TP06S-NEU	-	-	-	DS-A00-.25-S	DT-05-.25	DS-TP06B
	1KJ1B016023X5R00	SM18-041-00	DS-TP06S-NEU	610MM	-	-	DS-A00-.25-S	DT-05-.25	DS-TP06B
	1KJ1B020030X6R00	SM18-041-00	DS-TP06S-NEU	615MM	-	-	DS-A00-.25-S	DT-05-.25	DS-TP06B
	1KJ1B025035X7R00	SM18-041-00	DS-TP06S-NEU	617MM	-	-	DS-A00-.25-S	DT-05-.25	DS-TP06B

HIPOSTRIO™ 06 SERIES: 1KJ1D (WELDON SHANK)

90° END MILL (6MM INSERT)



WEP - See insert drawing for wiper options.

INCH

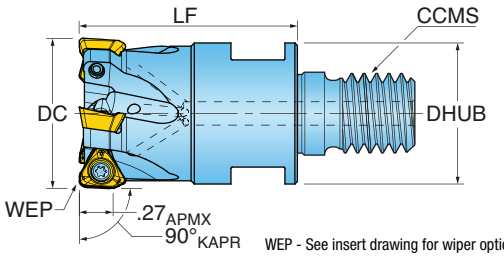
Part Number	DC Cutting Diameter	LUX Usable Length Max.	LPR Protruding Length	OAL Overall Length	ZEFF Effective Teeth	DCON Shank Diameter	RMPX Ramp Angle Max.
1KJ1D-0601279R01	0.625	1.22	1.25	3.25	1	0.625	4.0
1KJ1D-0702084R01	0.725	1.80	2.00	4.00	2	0.750	3.1
1KJ1D-0701184R01	0.750	1.05	1.25	3.25	2	0.750	3.1
1KJ1D-0701784R01	0.750	1.55	1.75	3.75	2	0.750	3.1
1KJ1D-0703084R01	0.750	2.80	3.00	5.00	2	0.750	3.1
1KJ1D-0801784R01	0.875	1.75	1.75	3.75	2	0.750	2.5
1KJ1D-1001780R01	1.000	1.55	1.75	4.00	3	1.000	2.1
1KJ1D-1001784R01	1.000	1.75	1.75	3.75	3	0.750	2.1
1KJ1D-1003780R01	1.000	3.38	3.75	6.00	3	1.000	2.1
1KJ1D-1003784R01	1.000	3.55	3.75	6.00	3	0.750	2.1
1KJ1D-1201780R01	1.250	1.75	1.75	4.00	5	1.000	1.5
1KJ1D-1201784R01	1.250	1.75	1.75	3.75	4	0.750	1.5
1KJ1D-1501780R01	1.500	1.75	1.75	4.00	6	1.000	1.3
1KJ1D-1501784R01	1.500	1.75	1.75	3.75	5	0.750	1.3
1KJ1D-1502281R01	1.500	2.25	2.25	4.50	6	1.250	1.3

METRIC

Part Number	DC Cutting Diameter	LUX Usable Length Max.	LPR Protruding Length	OAL Overall Length	ZEFF Effective Teeth	DCON Shank Diameter	RMPX Ramp Angle Max.
1KJ1D020025W4R00	20.00	25.0	40.0	90.0	2	20.00	3.3
1KJ1D020075W4R00	20.00	75.0	50.0	125.0	2	20.00	3.3
1KJ1D025030W5R00	25.00	30.0	44.0	100.0	3	25.00	2.8
1KJ1D025085W5R00	25.00	85.0	99.0	145.0	3	25.00	2.8
1KJ1D032040W6R00	32.00	40.0	50.0	110.0	5	32.00	1.8
1KJ1D040040W6R00	40.00	40.0	55.0	115.0	6	32.00	1.3

HIPOSTRIO™ 06 SERIES: 1KJ1D (TOPON M-ADAPTION)

90° MODULAR END MILL (6MM INSERT)



WEP - See insert drawing for wiper options.

INCH

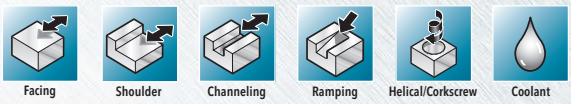
Part Number	DC Cutting Diameter	LF Functional Length	ZEFF Effective Teeth	CCMS Connection Code	DHUB Hub Diameter	RMPX Ramp Angle Max.
1KJ1D-07015X6R01	0.750	1.50	2	TopOn M10	.69	3.1
1KJ1D-10015X7R01	1.000	1.50	2	TopOn M12	.81	2.1
1KJ1D-10015X7R02	1.000	1.50	3	TopOn M12	.81	2.1
1KJ1D-12017X8R02	1.250	1.75	5	TopOn M16	1.13	1.5
1KJ1D-15017X8R01	1.500	1.75	5	TopOn M16	1.13	1.3

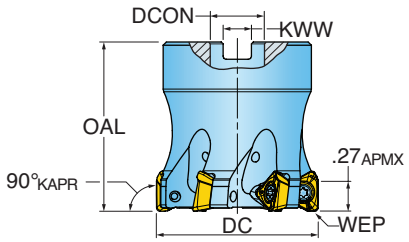
METRIC

Part Number	DC Cutting Diameter	LF Functional Length	ZEFF Effective Teeth	CCMS Connection Code	DHUB Hub Diameter	RMPX Ramp Angle Max.
1KJ1D020035X6R00	20.00	35.0	2	TopOnM10	18.0	3.3
1KJ1D025035X7R00	25.00	35.0	3	TopOnM12	21.0	2.8
1KJ1D032043X8R00	32.00	43.0	5	TopOnM16	29.0	1.8
1KJ1D035043X8R00	35.00	43.0	5	TopOnM16	29.0	1.6
1KJ1D040043X8R00	40.00	43.0	6	TopOnM16	29.0	1.3

HIPOSTRIO™ 06 SERIES: KJ5D, KJ6D

90° FACE MILL (6MM INSERT)





WEP - See insert drawing for wiper options.

INCH

Part Number	DC Cutting Diameter	OAL Overall Length	ZEFF Effective Teeth	DCON Bore Diameter	KWW Keyway	RMPX Ramp Angle Max.
KJ5D-15R01	1.500	1.57	6	0.500	0.250	1.3
KJ5D-20R01	2.000	1.57	7	0.750	0.312	1.2
KJ6D-30R01	3.000	1.75	9	1.000	0.375	0.4

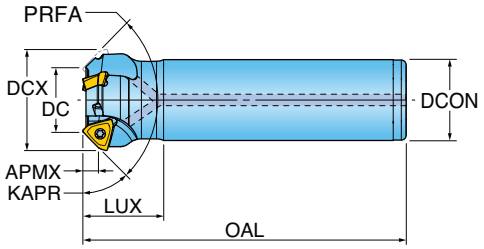
METRIC

Part Number	DC Cutting Diameter	OAL Overall Length	ZEFF Effective Teeth	DCON Bore Diameter	KWW Keyway	RMPX Ramp Angle Max.
KJ5D035R00	35.00	40.00	5	16.00	8.40	1.6
KJ5D040R00	40.00	40.00	6	16.00	8.40	1.3
KJ6D040R00	40.00	40.00	4	16.00	8.40	1.3
KJ5D050400	50.00	40.00	7	22.00	10.40	1.0
KJ6D050R00	50.00	40.00	5	22.00	10.40	1.0
KJ5D063R00	63.00	40.00	9	22.00	10.40	0.8
KJ6D063R00	63.00	40.00	7	22.00	10.40	0.8

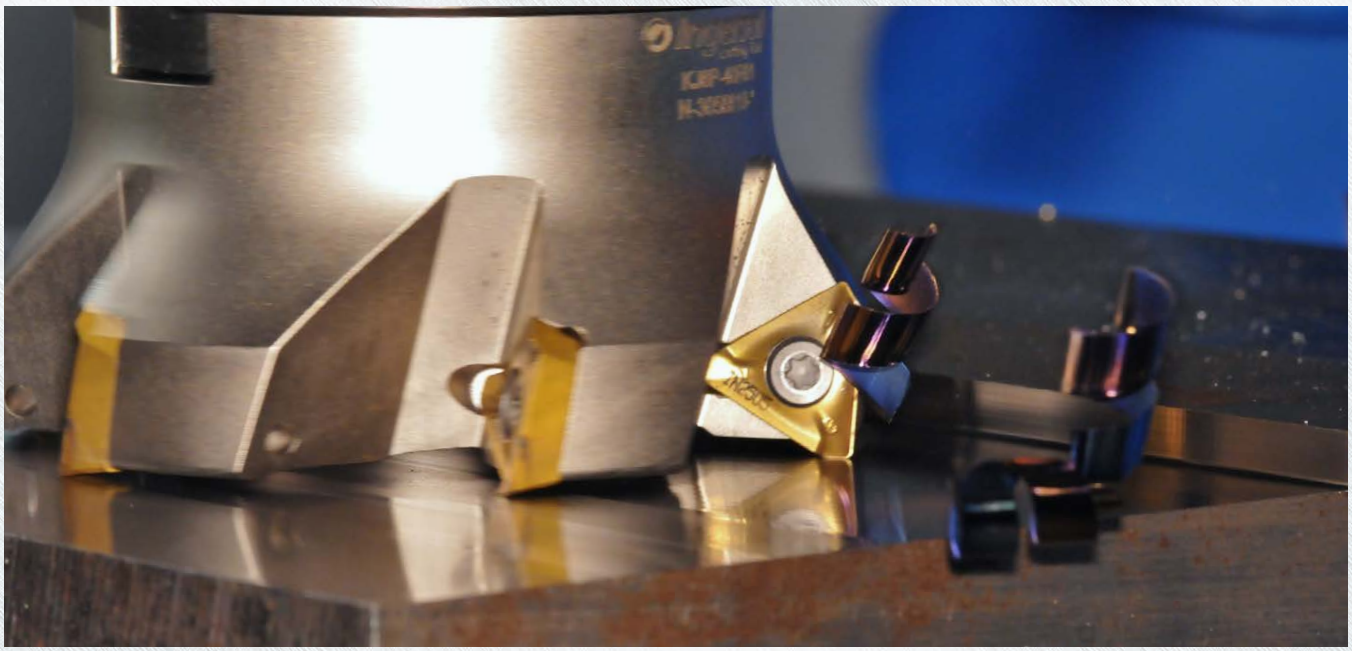
HIPOSTRIO™ 06 SERIES: 1K_1D (CYLINDRICAL SHANK)

CHAMFER MILL (6MM INSERT)

Lead Angle | Chamfer | Coolant



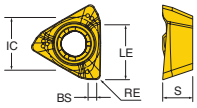
Part Number	DC Cutting Diameter	DCX Cutting Diameter Max.	KAPR Cutting Edge Angle	PRFA Profile Angle	APMX Depth of Cut Max.	LUX Useable Length Max.	OAL Overall Length	ZEFF Effective Teeth	DCON Shank Diameter
1KM1D-07010S1R01	0.750	1.042	60	60	0.227	1.00	4.00	3	1.000
1KN1D-07010S1R01	0.750	1.184	45	90	0.180	1.00	4.00	3	1.000
1KP1D-07010S1R01	0.750	1.297	30	120	0.125	1.00	4.00	3	1.000



HIPOSTRIO™ 06 INSERTS

R P HR

THES06



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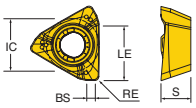

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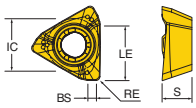

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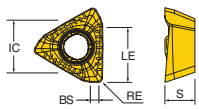
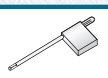


Part Number	Application	RE Corner Radius	BS Wiper Length	LE Cutting Edge Length	IC Inscribed Circle Diameter	S Thickness	NOI Number of Indexes	Grade	IN10K	IN2035	IN2036	IN2504	IN2505	IN2510	IN2530	IN2540	IN4030
THES060404R	Multi-Purpose; Ground Periphery	0.015 R	0.051	0.270	0.272	0.157	3						•				
THES060408R	Multi-Purpose; Ground Periphery	0.031 R	0.035	0.270	0.272	0.157	3						•				
THES060404FR-P	Grd/Pol for Al	0.015 R	0.051	0.270	0.272	0.157	3		•								
THES060408FR-P	Grd/Pol for Al	0.031 R	0.035	0.270	0.272	0.157	3		•								
THLS060404R	Multi-Purpose	0.015 R	0.051	0.270	0.272	0.157	3					•	•	•	•		
THLS060408R	Multi-Purpose	0.031 R	0.035	0.270	0.272	0.157	3					•	•	•	•	•	•
THLS060416R	Multi-Purpose	0.062 R	0.022	0.270	0.272	0.157	3					•	•				
THLS060404R-HR	SS/Hi-Temp/Ti	0.015 R	0.051	0.270	0.272	0.157	3			•	•		•				
THLS060408R-HR	SS/Hi-Temp/Ti	0.031 R	0.035	0.270	0.272	0.157	3			•	•		•		•		

HIPOSTRIO™ 06 HARDWARE

		 Insert Screw	 Screw Driver	 Retention Bolt	 Retention Bolt w/Coolant	 Wrench	 **OPTIONAL** Torque Driver Handle	 **OPTIONAL** Preset Torque Bit	 **OPTIONAL** Torque Driver Bit
INCH	1KJ1D-0601279R01	SM25-065-R0	DS-T08W	-	-	-	DS-A00-.25-S	DT-11-.25	DS-TP08B
	1KJ1D-0702084R01	SM25-065-R0	DS-T08W	-	-	-	DS-A00-.25-S	DT-11-.25	DS-TP08B
	1KJ1D-0701184R01	SM25-065-R0	DS-T08W	-	-	-	DS-A00-.25-S	DT-11-.25	DS-TP08B
	1KJ1D-0701784R01	SM25-065-R0	DS-T08W	-	-	-	DS-A00-.25-S	DT-11-.25	DS-TP08B
	1KJ1D-0703084R01	SM25-065-R0	DS-T08W	-	-	-	DS-A00-.25-S	DT-11-.25	DS-TP08B
	1KJ1D-0801784R01	SM25-065-R0	DS-T08W	-	-	-	DS-A00-.25-S	DT-11-.25	DS-TP08B
	1KJ1D-1001780R01	SM25-065-R0	DS-T08W	-	-	-	DS-A00-.25-S	DT-11-.25	DS-TP08B
	1KJ1D-1001784R01	SM25-065-R0	DS-T08W	-	-	-	DS-A00-.25-S	DT-11-.25	DS-TP08B
	1KJ1D-1003780R01	SM25-065-R0	DS-T08W	-	-	-	DS-A00-.25-S	DT-11-.25	DS-TP08B
	1KJ1D-1003784R01	SM25-065-R0	DS-T08W	-	-	-	DS-A00-.25-S	DT-11-.25	DS-TP08B
	1KJ1D-1201780R01	SM25-065-R0	DS-T08W	-	-	-	DS-A00-.25-S	DT-11-.25	DS-TP08B
	1KJ1D-1201784R01	SM25-065-R0	DS-T08W	-	-	-	DS-A00-.25-S	DT-11-.25	DS-TP08B
	1KJ1D-1501780R01	SM25-065-R0	DS-T08W	-	-	-	DS-A00-.25-S	DT-11-.25	DS-TP08B
	1KJ1D-1501784R01	SM25-065-R0	DS-T08W	-	-	-	DS-A00-.25-S	DT-11-.25	DS-TP08B
	1KJ1D-1502281R01	SM25-065-R0	DS-T08W	-	-	-	DS-A00-.25-S	DT-11-.25	DS-TP08B
	1KJ1D-07015X6R01	SM25-065-R0	DS-T08W	-	-	615MM	DS-A00-.25-S	DT-11-.25	DS-TP08B
	1KJ1D-10015X7R01	SM25-065-R0	DS-T08W	-	-	617MM	DS-A00-.25-S	DT-11-.25	DS-TP08B
	1KJ1D-10015X7R02	SM25-065-R0	DS-T08W	-	-	617MM	DS-A00-.25-S	DT-11-.25	DS-TP08B
	1KJ1D-12017X8R02	SM25-065-R0	DS-T08W	-	-	622MM	DS-A00-.25-S	DT-11-.25	DS-TP08B
	1KJ1D-15017X8R01	SM25-065-R0	DS-T08W	-	-	622MM	DS-A00-.25-S	DT-11-.25	DS-TP08B
	KJ5D-15R01	SM25-065-R0	DS-T08W	SD-04-46	-	-	DS-A00-.25-S	DT-11-.25	DS-TP08B
	KJ5D-20R01	SM25-065-R0	DS-T08W	SD-06-46	SD-06-89	-	DS-A00-.25-S	DT-11-.25	DS-TP08B
	KJ6D-30R01	SM25-065-R0	DS-T08W	SD-08-46	SD-08-92	-	DS-A00-.25-S	DT-11-.25	DS-TP08B
METRIC	1KJ1D020025W4R00	SM25-065-R0	DS-T08W	-	-	-	DS-A00-.25-S	DT-11-.25	DS-TP08B
	1KJ1D020075W4R00	SM25-065-R0	DS-T08W	-	-	-	DS-A00-.25-S	DT-11-.25	DS-TP08B
	1KJ1D025030W5R00	SM25-065-R0	DS-T08W	-	-	-	DS-A00-.25-S	DT-11-.25	DS-TP08B
	1KJ1D025085W5R00	SM25-065-R0	DS-T08W	-	-	-	DS-A00-.25-S	DT-11-.25	DS-TP08B
	1KJ1D032040W6R00	SM25-065-R0	DS-T08W	-	-	-	DS-A00-.25-S	DT-11-.25	DS-TP08B
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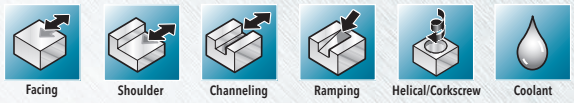
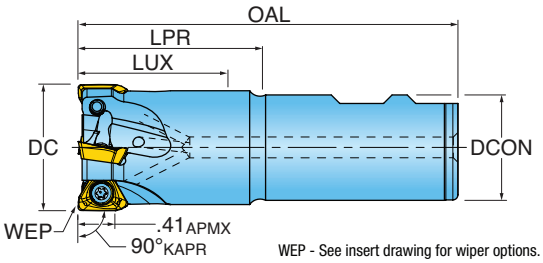
	1KJ1D032043X8R00	SM25-065-R0	DS-T08W	-	-	622MM	DS-A00-.25-S	DT-11-.25	DS-TP08B
	1KJ1D035043X8R00	SM25-065-R0	DS-T08W	-	-	622MM	DS-A00-.25-S	DT-11-.25	DS-TP08B
	1KJ1D040043X8R00	SM25-065-R0	DS-T08W	-	-	622MM	DS-A00-.25-S	DT-11-.25	DS-TP08B
	KJ5D035R00	SM25-065-R0	DS-T08W	-	ISO4762M8X25-12.9	-	DS-A00-.25-S	DT-11-.25	DS-TP08B
	KJ5D040R00	SM25-065-R0	DS-T08W	-	ISO4762M8X25-12.9	-	DS-A00-.25-S	DT-11-.25	DS-TP08B
	KJ6D040R00	SM25-065-R0	DS-T08W	-	ISO4762M8X25-12.9	-	DS-A00-.25-S	DT-11-.25	DS-TP08B
	KJ5D050400	SM25-065-R0	DS-T08W	-	ISO4762M10X25-12.9	-	DS-A00-.25-S	DT-11-.25	DS-TP08B
	KJ6D050R00	SM25-065-R0	DS-T08W	-	ISO4762M10X25-12.9	-	DS-A00-.25-S	DT-11-.25	DS-TP08B
	KJ5D063R00	SM25-065-R0	DS-T08W	-	ISO4762M10X25-12.9	-	DS-A00-.25-S	DT-11-.25	DS-TP08B
	KJ6D063R00	SM25-065-R0	DS-T08W	-	ISO4762M10X25-12.9	-	DS-A00-.25-S	DT-11-.25	DS-TP08B

HIPOSTRIO™ 10 SERIES: 1KJ1G (WELDON SHANK)

90° END MILL (10MM INSERT)





WEP - See insert drawing for wiper options.

INCH

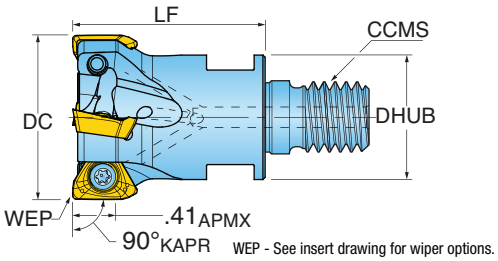
Part Number	DC Cutting Diameter	LUX Usable Length Max.	LPR Protruding Length	OAL Overall Length	ZEFF Effective Teeth	DCON Shank Diameter	RMPX Ramp Angle Max.
1KJ1G-1201784R01	1.250	1.75	1.75	3.75	3	0.750	2.3
1KJ1G-1202281R01	1.250	2.05	2.25	4.50	2	1.250	2.3
1KJ1G-1202281R02	1.250	2.05	2.25	4.50	3	1.250	2.3
1KJ1G-1204281R01	1.250	4.05	4.25	6.50	3	1.250	0
1KJ1G-1502281R01	1.500	2.20	2.25	4.50	3	1.250	1.8
1KJ1G-1502281R02	1.500	2.20	2.25	4.50	4	1.250	1.8
1KJ1G-1504281R01	1.500	4.25	4.25	6.50	3	1.250	0
1KJ1G-2002281R01	2.000	2.25	2.25	4.50	5	1.250	1.5

METRIC

Part Number	DC Cutting Diameter	LUX Usable Length Max.	LPR Protruding Length	OAL Overall Length	ZEFF Effective Teeth	DCON Shank Diameter	RMPX Ramp Angle Max.
1KJ1G032040W6R00	32.00	40.0	50.0	110.0	3	32.00	3.0
1KJ1G040040W6R00	40.00	40.0	50.0	110.0	4	32.00	2.0

HIPOSTRIO™ 10 SERIES: 1KJ1G (TOPON M-ADAPTION)

90° MODULAR END MILL (10MM INSERT)



WEP - See insert drawing for wiper options.

INCH

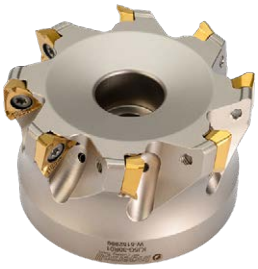
Part Number	DC Cutting Diameter	LF Functional Length	ZEFF Effective Teeth	CCMS Connection Code	DHUB Hub Diameter	RMPX Ramp Angle Max.
1KJ1G-12017X8R01	1.250	1.50	3	TopOn M16	1.13	2.3
1KJ1G-15017X8R01	1.500	1.75	4	TopOn M16	1.13	1.8

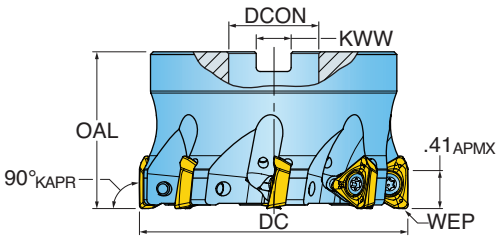
METRIC

Part Number	DC Cutting Diameter	LF Functional Length	ZEFF Effective Teeth	CCMS Connection Code	DHUB Hub Diameter	RMPX Ramp Angle Max.
1KJ1G032043X8R00	32.00	43.0	3	TopOnM16	29.0	3.2
1KJ1G035043X8R00	35.00	43.0	3	TopOnM16	29.0	2.4
1KJ1G040043X8R00	40.00	43.0	4	TopOnM16	29.0	2.0

HIPOSTRIO™ 10 SERIES: KJ5G, KJ6G

90° FACE MILL (10MM INSERT)





WEP - See insert drawing for wiper options.

INCH

Part Number	DC Cutting Diameter	OAL Overall Length	ZEFF Effective Teeth	DCON Bore Diameter	KWW Keyway	RMPX Ramp Angle Max.
KJ6G-15R01	1.500	1.375	4	0.500	0.250	1.4
KJ5G-20R01	2.000	1.570	5	0.750	0.312	1.5
KJ6G-20R01	2.000	1.570	3	0.750	0.312	0.8
KJ5G-25R01	2.500	1.570	6	0.750	0.312	1.1
KJ5G-30R01	3.000	1.750	8	1.000	0.375	0.8
KJ6G-30R01	3.000	1.750	5	1.000	0.375	0.8
KJ6G-30R02	3.000	1.750	3	1.000	0.375	0.8
KJ5G-40R02	4.000	2.375	10	1.500	0.625	0.6
KJ6G-40R02	4.000	2.375	8	1.500	0.625	0.6
KJ6G-50R02	5.000	2.375	11	1.500	0.625	0.5

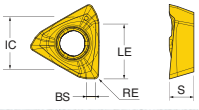
METRIC

Part Number	DC Cutting Diameter	OAL Overall Length	ZEFF Effective Teeth	DCON Bore Diameter	KWW Keyway	RMPX Ramp Angle Max.
KJ5G050R00	50.00	40.00	5	22.00	10.40	1.5
KJ6G050R00	50.00	40.00	4	22.00	10.40	1.5
KJ5G063R00	63.00	40.00	6	22.00	10.40	1.1
KJ6G063R00	63.00	40.00	4	22.00	10.40	1.1
KJ5G080R00	80.00	50.00	8	27.00	12.40	0.8
KJ6G080R00	80.00	50.00	6	27.00	12.40	0.8
KJ5G100R00	100.00	50.00	10	32.00	14.40	0.6
KJ6G100R00	100.00	50.00	8	32.00	14.40	0.6
KJ5G125R00	125.00	63.00	12	40.00	16.40	0.5
KJ6G125R00	125.00	63.00	9	40.00	16.40	0.5

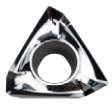
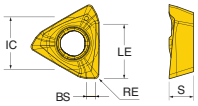
HIPOSTRIO™ 10 INSERTS

R P HR

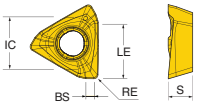
THES10

THES10_P

THLS10

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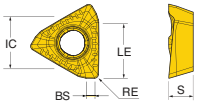
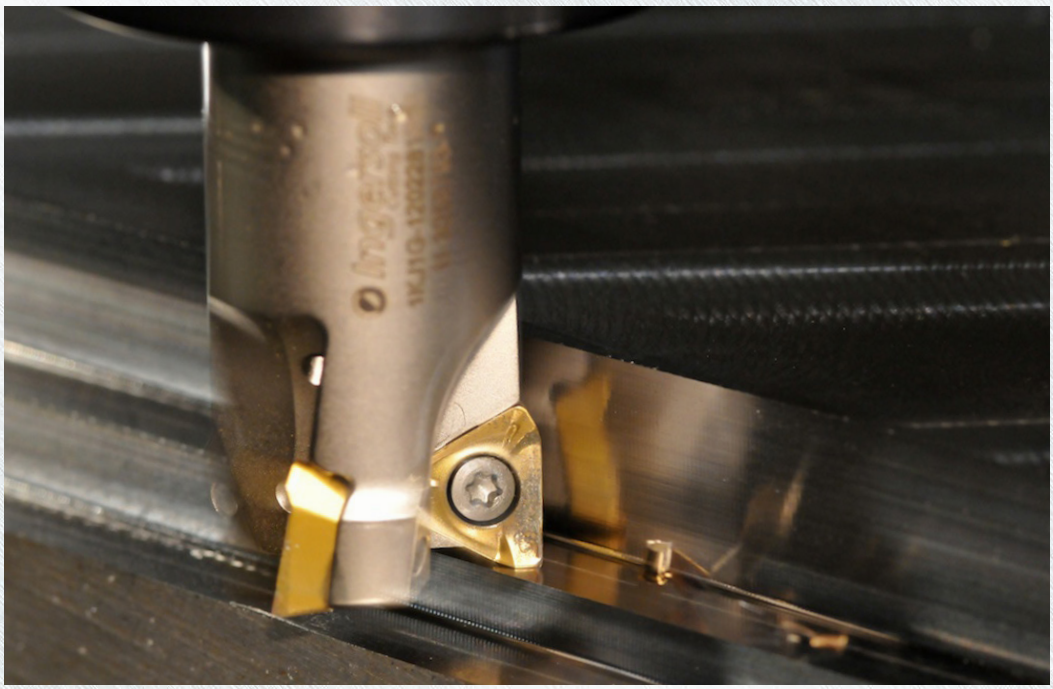


Part Number	Application	RE Corner Radius	BS Wiper Length	LE Cutting Edge Length	IC Inscribed Circle Diameter	S Thickness	NOI No. of Indexes	Grade	IN10K	IN2035	IN2036	IN2504	IN2505	IN2510	IN2530	IN2540	IN4030	IN6537
THES100504R	Multi-Purpose; Ground Periphery	0.015 R	0.078	0.430	0.421	0.197	3						•					
THES100508R	Multi-Purpose; Ground Periphery	0.031 R	0.062	0.430	0.421	0.197	3						•					
THES100516R	Multi-Purpose; Ground Periphery	0.062 R	0.031	0.430	0.421	0.197	3						•					
THES100504FR-P	Grd/Pol for Al	0.015 R	0.078	0.430	0.421	0.197	3		•									
THES100508FR-P	Grd/Pol for Al	0.031 R	0.062	0.430	0.421	0.197	3		•									
THLS100508R	Multi-Purpose	0.031 R	0.062	0.430	0.421	0.197	3					•	•	•	•	•	•	•
THLS100516R	Multi-Purpose	0.062 R	0.031	0.430	0.421	0.197	3					•	•					
THLS100524R	Multi-Purpose	0.094 R	0.020	0.430	0.421	0.197	3						•					
THLS100508R-HR	SS/Hi-Temp/Ti	0.031 R	0.062	0.430	0.421	0.197	3			•	•		•		•			
THES100516R-HR	SS/Hi-Temp/Ti	0.062 R	0.039	0.430	0.421	0.197	3			•								



HIPOSTRIO™ 10 HARDWARE

									
		Insert Screw	Driver Handle	Torx Driver Blade	Retention Bolt	Retention Bolt w/Coolant	Wrench	**OPTIONAL** Torque Driver Handle	**OPTIONAL** Torque Driver Bit	**OPTIONAL** Preset Torque Bit
INCH	1KJ1G-1201784R01	SM40-100-R0	DS-A00T	DS-T156B	-	-	-	DS-A00-.25-T	DS-T15B1	DT-35-.25
	1KJ1G-1202281R01	SM40-100-R0	DS-A00T	DS-T156B	-	-	-	DS-A00-.25-T	DS-T15B1	DT-35-.25
	1KJ1G-1202281R02	SM40-100-R0	DS-A00T	DS-T156B	-	-	-	DS-A00-.25-T	DS-T15B1	DT-35-.25
	1KJ1G-1204281R01	SM40-100-R0	DS-A00T	DS-T156B	-	-	-	DS-A00-.25-T	DS-T15B1	DT-35-.25
	1KJ1G-1502281R01	SM40-100-R0	DS-A00T	DS-T156B	-	-	-	DS-A00-.25-T	DS-T15B1	DT-35-.25
	1KJ1G-1502281R02	SM40-100-R0	DS-A00T	DS-T156B	-	-	-	DS-A00-.25-T	DS-T15B1	DT-35-.25
	1KJ1G-1504281R01	SM40-100-R0	DS-A00T	DS-T156B	-	-	-	DS-A00-.25-T	DS-T15B1	DT-35-.25
	1KJ1G-2002281R01	SM40-100-R0	DS-A00T	DS-T156B	-	-	-	DS-A00-.25-T	DS-T15B1	DT-35-.25
	1KJ1G-12017X8R01	SM40-100-R0	DS-A00T	DS-T156B	-	-	622MM	DS-A00-.25-T	DS-T15B1	DT-35-.25
	1KJ1G-15017X8R01	SM40-100-R0	DS-A00T	DS-T156B	-	-	622MM	DS-A00-.25-T	DS-T15B1	DT-35-.25
	KJ6G-15R01	SM40-100-R0	DS-A00T	DS-T156B	SE04-15	-	-	DS-A00-.25-T	DS-T15B1	DT-35-.25
	KJ5G-20R01	SM40-100-R0	DS-A00T	DS-T156B	SD-06-46	SD-06-89	-	DS-A00-.25-T	DS-T15B1	DT-35-.25
	KJ6G-20R01	SM40-100-R0	DS-A00T	DS-T156B	SD-06-46	SD-06-89	-	DS-A00-.25-T	DS-T15B1	DT-35-.25
	KJ5G-25R01	SM40-100-R0	DS-A00T	DS-T156B	SD-06-46	SD-06-89	-	DS-A00-.25-T	DS-T15B1	DT-35-.25
	KJ5G-30R01	SM40-100-R0	DS-A00T	DS-T156B	SD-08-46	SD-08-92	-	DS-A00-.25-T	DS-T15B1	DT-35-.25
	KJ6G-30R01	SM40-100-R0	DS-A00T	DS-T156B	SD-08-46	SD-08-92	-	DS-A00-.25-T	DS-T15B1	DT-35-.25
	KJ6G-30R02	SM40-100-R0	DS-A00T	DS-T156B	SD-08-46	SD-08-92	-	DS-A00-.25-T	DS-T15B1	DT-35-.25
	KJ5G-40R01	SM40-100-R0	DS-A00T	DS-T156B	SD-12-89	SD-12-99	-	DS-A00-.25-T	DS-T15B1	DT-35-.25
	KJ6G-40R01	SM40-100-R0	DS-A00T	DS-T156B	SD-12-89	SD-12-99	-	DS-A00-.25-T	DS-T15B1	DT-35-.25
	KJ6G-50R01	SM40-100-R0	DS-A00T	DS-T156B	SD-12-89	SD-12-99	-	DS-A00-.25-T	DS-T15B1	DT-35-.25
METRIC	1KJ1G032040W6R00	SM40-100-R0	DS-A00T	DS-T156B				DS-A00-.25-T	DS-T15B1	DT-35-.25
	1KJ1G040040W6R00	SM40-100-R0	DS-A00T	DS-T156B				DS-A00-.25-T	DS-T15B1	DT-35-.25
	1KJ1G032043X8R00	SM40-100-R0	DS-A00T	DS-T156B			622MM	DS-A00-.25-T	DS-T15B1	DT-35-.25
	1KJ1G035043X8R00	SM40-100-R0	DS-A00T	DS-T156B			622MM	DS-A00-.25-T	DS-T15B1	DT-35-.25
	1KJ1G040043X8R00	SM40-100-R0	DS-A00T	DS-T156B			622MM	DS-A00-.25-T	DS-T15B1	DT-35-.25
	KJ5G050R00	SM40-100-R0	DS-A00T	DS-T156B		ISO4762M10X25-12.9		DS-A00-.25-T	DS-T15B1	DT-35-.25
	KJ6G050R00	SM40-100-R0	DS-A00T	DS-T156B		ISO4762M10X25-12.9		DS-A00-.25-T	DS-T15B1	DT-35-.25
	KJ5G063R00	SM40-100-R0	DS-A00T	DS-T156B		ISO4762M10X25-12.9		DS-A00-.25-T	DS-T15B1	DT-35-.25
	KJ6G063R00	SM40-100-R0	DS-A00T	DS-T156B		ISO4762M10X25-12.9		DS-A00-.25-T	DS-T15B1	DT-35-.25
	KJ5G080R00	SM40-100-R0	DS-A00T	DS-T156B		ISO4762M12X35-12.9		DS-A00-.25-T	DS-T15B1	DT-35-.25
	KJ6G080R00	SM40-100-R0	DS-A00T	DS-T156B		ISO4762M12X35-12.9		DS-A00-.25-T	DS-T15B1	DT-35-.25
	KJ5G100R00	SM40-100-R0	DS-A00T	DS-T156B		ISO4762M16X30-12.9		DS-A00-.25-T	DS-T15B1	DT-35-.25
	KJ6G100R00	SM40-100-R0	DS-A00T	DS-T156B		ISO4762M16X30-12.9		DS-A00-.25-T	DS-T15B1	DT-35-.25
	KJ5G125R00	SM40-100-R0	DS-A00T	DS-T156B		ISO4762M20X40-12.9		DS-A00-.25-T	DS-T15B1	DT-35-.25
	KJ6G125R00	SM40-100-R0	DS-A00T	DS-T156B		ISO4762M20X40-12.9		DS-A00-.25-T	DS-T15B1	DT-35-.25
	KJ5P063R00	SM40-100-R0	DS-A00T	DS-T156B		ISO4762M10X25-12.9		DS-A00-.25-T	DS-T15B1	DT-35-.25
	KJ6P063R00	SM40-100-R0	DS-A00T	DS-T156B		ISO4762M10X25-12.9		DS-A00-.25-T	DS-T15B1	DT-35-.25
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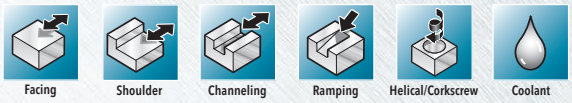
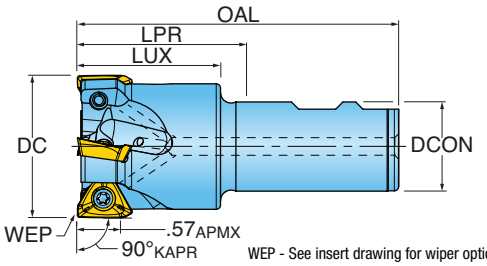
	KJ5P100R00	SM40-100-R0	DS-A00T	DS-T156B		ISO4762M16X30-12.9		DS-A00-.25-T	DS-T15B1	DT-35-.25
	KJ6P100R00	SM40-100-R0	DS-A00T	DS-T156B		ISO4762M16X30-12.9		DS-A00-.25-T	DS-T15B1	DT-35-.25
	KJ5P125R00	SM40-100-R0	DS-A00T	DS-T156B		ISO4762M20X40-12.9		DS-A00-.25-T	DS-T15B1	DT-35-.25
	KJ6P125R00	SM40-100-R0	DS-A00T	DS-T156B		ISO4762M20X40-12.9		DS-A00-.25-T	DS-T15B1	DT-35-.25
	KJ5P160R00	SM40-100-R0	DS-A00T	DS-T156B	ISO4762M20X40-12.9			DS-A00-.25-T	DS-T15B1	DT-35-.25
	KJ6P160R00	SM40-100-R0	DS-A00T	DS-T156B	ISO4762M20X40-12.9			DS-A00-.25-T	DS-T15B1	DT-35-.25

HIPOSTRIO™ 13 SERIES: 1KJ1P (WELDON SHANK)

90° END MILL (13MM INSERT)



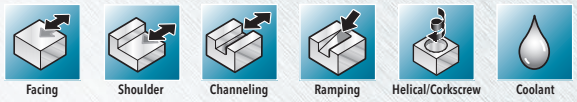


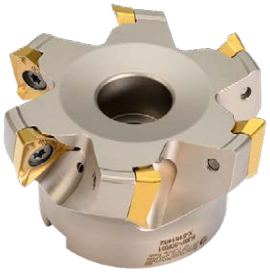
WEP - See insert drawing for wiper options.

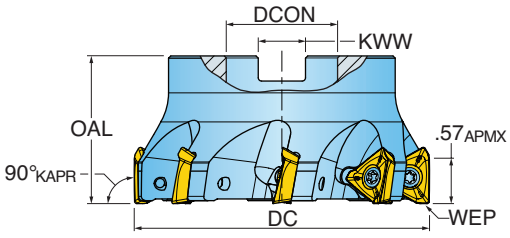
Part Number	DC Cutting Diameter	LUX Usable Length Max.	LPR Protruding Length	OAL Overall Length	ZEFF Effective Teeth	DCON Shank Diameter	RMPX Ramp Angle Max.
1KJ1P-2002281R01	2.000	2.00	2.25	4.50	4	1.250	1.5

HIPOSTRIO™ 13 SERIES: KJ5P, KJ6P

90° FACE MILL (13MM INSERT)







WEP - See insert drawing for wiper options.

INCH

Part Number	DC Cutting Diameter	OAL Overall Length	ZEFF Effective Teeth	DCON Bore Diameter	KWW Keyway	CSP Coolant	RMPX Ramp Angle Max.
KJ5P-20R01	2.000	1.750	5	.750	0.312	Yes	1.5
KJ6P-20R01	2.000	1.750	4	.750	0.312	Yes	1.5
KJ5P-25R01	2.500	1.750	6	.750	0.312	Yes	1.5
KJ5P-30R01	3.000	1.750	7	1.000	0.375	Yes	1.0
KJ6P-30R01	3.000	1.750	6	1.000	0.375	Yes	1.0
KJ5P-40R02	4.000	2.375	8	1.500	0.625	Yes	0.7
KJ6P-40R02	4.000	2.375	6	1.500	0.625	Yes	0.7
KJ6P-50R02	5.000	2.000	9	1.500	0.625	Yes	0.8
KJ5P-60R01	6.000	2.000	12	1.500	0.625	No	0.6
KJ6P-60R01	6.000	2.000	8	1.500	0.625	No	0.6
KJ6P-65R01*	6.500	2.000	10	1.500	0.625	No	0.4

* Ideal for Boring Mills with a 6.0 Quill.

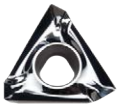
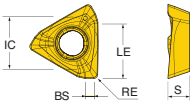
METRIC

Part Number	DC Cutting Diameter	OAL Overall Length	ZEFF Effective Teeth	DCON Bore Diameter	KWW Keyway	DBC Bolt Circle Diameter	CSP Coolant	RMPX Ramp Angle Max.
KJ5P063R00	63.00	40.00	6	22.00	10.40	NA	Yes	1.7
KJ6P063R00	63.00	40.00	4	22.00	10.40	NA	Yes	1.7
KJ5P080R00	80.00	50.00	7	27.00	12.40	NA	Yes	1.3
KJ6P080R00	80.00	50.00	5	27.00	12.40	NA	Yes	1.3
KJ5P100R00	100.00	50.00	8	32.00	14.40	NA	Yes	1.0
KJ6P100R00	100.00	50.00	6	32.00	14.40	NA	Yes	1.0
KJ5P125R00	125.00	63.00	10	40.00	16.40	NA	Yes	0.8
KJ6P125R00	125.00	63.00	8	40.00	16.40	NA	Yes	0.8
KJ5P160R00	160.00	63.00	12	40.00	16.40	66.7	No	0.6
KJ6P160R00	160.00	63.00	9	40.00	16.40	66.7	No	0.6

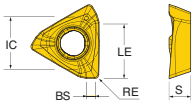
HIPOSTRIO™ 13 INSERTS

R P HR

THES13_P

THLS13

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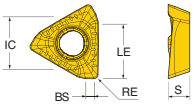


Part Number	Application	RE Corner Radius	BS Wiper Length	LE Cutting Edge Length	IC Inscribed Circle Diameter	S Thickness	NOI No. of Indexes	Grade	IN10K	IN2035	IN2505	IN2510	IN2530	IN2540	IN4030	IN6537
THES130604FR-P	Grd/Pol for Al	0.015 R	0.078	0.590	0.531	0.236	3		•							
THES130608FR-P	Grd/Pol for Al	0.031 R	0.078	0.590	0.531	0.236	3		•							
THLS130608R	Multi-Purpose	0.031 R	0.078	0.590	0.531	0.236	3				•	•	•	•	•	•
THLS130616R	Multi-Purpose	0.062 R	0.047	0.590	0.531	0.236	3				•		•			
THLS130624R	Multi-Purpose	0.094 R	0.024	0.590	0.531	0.236	3				•					
THLS130632R	Multi-Purpose	0.125 R	0.020	0.590	0.531	0.236	3				•					
THLS130608R-HR	SS/Hi-Temp/Ti	0.031 R	0.078	0.590	0.531	0.236	3			•	•		•			
THLS130616R-HR	SS/Hi-Temp/Ti	0.062 R	0.047	0.590	0.531	0.236	3			•						
THLS130624R-HR	SS/Hi-Temp/Ti	0.094 R	0.024	0.590	0.531	0.236	3			•						
THLS130632R-HR	SS/Hi-Temp/Ti	0.125 R	0.020	0.590	0.531	0.236	3			•						

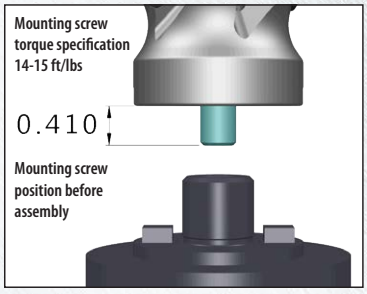
HIPOSTRIO™ 13 HARDWARE

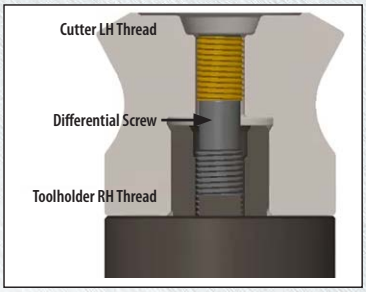
							 **OPTIONAL**	 **OPTIONAL**	 **OPTIONAL**
	Insert Screw	Driver Handle	Torx Driver Blade	Differential Screw	Retention Bolt	Retention Bolt w/Coolant	Torque Driver Handle	Torque Driver Bit	Preset Torque Bit
INCH	1KJ1P-2002281R01	SM45-120-R0	DS-A00T	DS-T206B	-	-	-	DS-A00-.25-T	DS-T20B1	DT-44-.25
	KJ5P-20R01	SM45-100-R0	DS-A00T	DS-T206B	SB-04-15	-	-	DS-A00-.25-T	DS-T20B1	DT-44-.25
	KJ6P-20R01	SM45-100-R0	DS-A00T	DS-T206B	SB-04-15	-	-	DS-A00-.25-T	DS-T20B1	DT-44-.25
	KJ5P-25R01	SM45-120-R0	DS-A00T	DS-T206B	-	SD-06-47	SD-06-89	DS-A00-.25-T	DS-T20B1	DT-44-.25
	KJ5P-30R01	SM45-120-R0	DS-A00T	DS-T206B	-	SD-08-47	SD-08-92	DS-A00-.25-T	DS-T20B1	DT-44-.25
	KJ6P-30R01	SM45-120-R0	DS-A00T	DS-T206B	-	SD-08-46	SD-08-92	DS-A00-.25-T	DS-T20B1	DT-44-.25
	KJ5P-40R02	SM45-120-R0	DS-A00T	DS-T206B	-	-	SD-12-99	DS-A00-.25-T	DS-T20B1	DT-44-.25
	KJ6P-40R02	SM45-120-R0	DS-A00T	DS-T206B	-	-	SD-12-99	DS-A00-.25-T	DS-T20B1	DT-44-.25
	KJ6P-50R02	SM45-120-R0	DS-A00T	DS-T206B	-	-	SD-12-99	DS-A00-.25-T	DS-T20B1	DT-44-.25
	KJ5P-60R01	SM45-120-R0	DS-A00T	DS-T206B	-	-	-	DS-A00-.25-T	DS-T20B1	DT-44-.25
	KJ6P-60R01	SM45-120-R0	DS-A00T	DS-T206B	-	-	-	DS-A00-.25-T	DS-T20B1	DT-44-.25
	KJ6P-65R01	SM45-120-R0	DS-A00T	DS-T206B	-	-	-	DS-A00-.25-T	DS-T20B1	DT-44-.25
METRIC	KJ5P063R00	SM45-120-R0	DS-A00T	DS-T206B	-	-	DIN912M10X25-12.9	DS-A00-.25-T	DS-T20B1	DT-44-.25
	KJ6P063R00	SM45-120-R0	DS-A00T	DS-T206B	-	-	DIN912M10X25-12.9	DS-A00-.25-T	DS-T20B1	DT-44-.25
	KJ5P080R00	SM45-120-R0	DS-A00T	DS-T206B	-	-	DIN912M12X35-12.9	DS-A00-.25-T	DS-T20B1	DT-44-.25
	KJ6P080R00	SM45-120-R0	DS-A00T	DS-T206B	-	-	DIN912M12X35-12.9	DS-A00-.25-T	DS-T20B1	DT-44-.25
	KJ5P100R00	SM45-120-R0	DS-A00T	DS-T206B	-	-	DIN912M16X30-12.9	DS-A00-.25-T	DS-T20B1	DT-44-.25
	KJ6P100R00	SM45-120-R0	DS-A00T	DS-T206B	-	-	DIN912M16X30-12.9	DS-A00-.25-T	DS-T20B1	DT-44-.25
	KJ5P125R00	SM45-120-R0	DS-A00T	DS-T206B	-	-	DIN912M20X40-12.9	DS-A00-.25-T	DS-T20B1	DT-44-.25
	KJ6P125R00	SM45-120-R0	DS-A00T	DS-T206B	-	-	DIN912M20X40-12.9	DS-A00-.25-T	DS-T20B1	DT-44-.25
	KJ5P160R00	SM45-120-R0	DS-A00T	DS-T206B	-	-	-	DS-A00-.25-T	DS-T20B1	DT-44-.25
	KJ6P160R00	SM45-120-R0	DS-A00T	DS-T206B	-	-	-	DS-A00-.25-T	DS-T20B1	DT-44-.25

HIPOSTRIO™ 13 KJ5P-20R01 & KJ6P-20R01 MOUNTING SCREW ASSEMBLY

See link below for instructional video showing proper assembly:

https://youtu.be/fYQ1smLdYjo

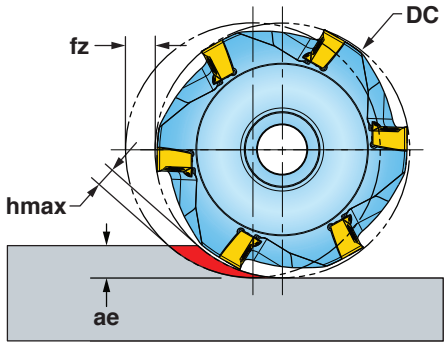




Properly Assembled

HIPOSTRIO™ 04 OPERATING GUIDELINES

Chip Thinning



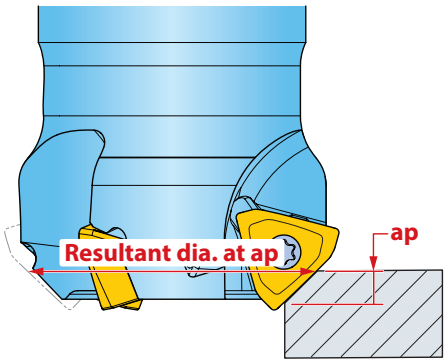
* When ae is less than 25% DC, recommend use of Chip Thinning Calculator to ensure hmax falls within fz range.

Materials				Vc Cutting Speed SFM	fz* Feed/Tooth (inch)	Harder..... Tougher		Coolant
ISO	Mat'l Group #VDI 3323	Type	Examples			IN2505	IN2530	
P	1 thru 5	Non-alloy Steel	1018, A36, 1045, A572, 1070	400-1000	.0015-.0030	2	1	No
	6 thru 9	Low-alloy Steel	4140, 4340, P20, 8620, 300M	350-700				
	10, 11	High-alloy Steel	H13, A2, D2, M2, T1	300-600				
M	12 thru 13	Stainless Steel (Ferritic & Martensitic)	410, 416, 440	350-600	.0015-.0030	2	1	Yes
	14	Stainless Steel (Austenitic)	303, 304, 316, 15-5, 17-4	300-550				May not be required at high speeds
K	15 thru 16	Gray Cast Iron	CLS. 20, 30, 45	500-1000	.0015-.0035	1		No
	17 thru 20	Nodular Cast Iron	60-40-18, 100-70-03	400-800				
S	31 thru 35	High-Temp Alloys	Inconel, Hastelloy, Nimonic, Monel	65-200	.0015-.0030	1	2	Yes
	36 thru 37	Titanium Alloys	6Al-4V, 5Al-5Mo-5V-3Cr	85-200				

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.

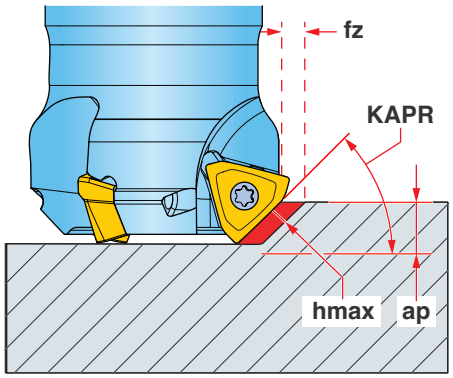
HIPOSTRIO™ 04 OPERATING GUIDELINES - SERIES 1K_1B

RPM Calculation



Calculation is to be made using the resultant diameter at ap.

Chip Thinning



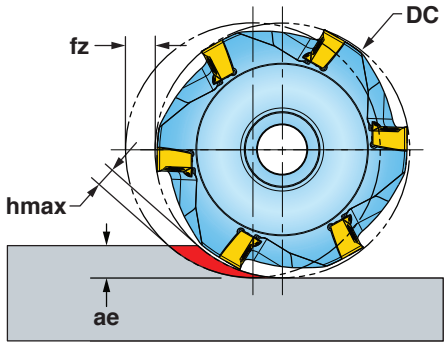
Chip Thinning calculator is recommended to ensure hmax falls within fz range

Materials				Vc Cutting Speed SFM	fz* Feed/Tooth (inch)	Harder.....Tougher		Coolant
ISO	Mat'l Group #VDI 3323	Type	Examples			IN2505	IN2530	
P	1 thru 5	Non-alloy Steel	1018, A36, 1045, A572, 1070	400-1000	.0015-.0030	2	1	No
	6 thru 9	Low-alloy Steel	4140, 4340, P20, 8620, 300M	350-700				
	10, 11	High-alloy Steel	H13, A2, D2, M2, T1	300-600				
M	12 thru 13	Stainless Steel (Ferritic & Martensitic)	410, 416, 440	400-700	.0015-.0030	2	1	May not be required at high speeds
	14	Stainless Steel (Austenitic)	303, 304, 316, 15-5, 17-4	300-600				
K	15 thru 16	Gray Cast Iron	CLS. 20, 30, 45	500-1000	.0015-.0035	1	2	No
	17 thru 20	Nodular Cast Iron	60-40-18, 100-70-03	400-800				
S	31 thru 35	High-Temp Alloys	Inconel, Hastelloy, Nimonic, Monel	75-120	.0015-.0030	2	1	Yes
	36 thru 37	Titanium Alloys	6Al-4V, 5Al-5Mo-5V-3Cr	100-150		1	2	

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.

HIPOSTRIO™ 06 OPERATING GUIDELINES

Chip Thinning



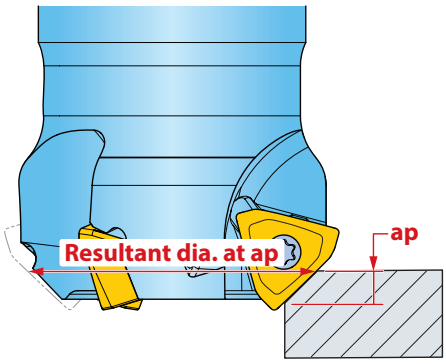
* When ae is less than 25% DC, recommend use of Chip Thinning Calculator to ensure hmax falls within fz range.

Materials				Vc Cutting Speed SFM	fz* Feed/Tooth (inch)	Harder.....Tougher							Coolant
ISO	Mat'l Group #VDI 3323	Type	Examples			IN2504	IN2540	IN10K	IN2510	IN2505	IN4030 IN2530	IN2035	
P	1 thru 5	Non-alloy Steel	1018, A36, 1045, A572, 1070	400-1000	.003-.006		3			2	1		No
	6 thru 9	Low-alloy Steel	4140, 4340, P20, 8620, 300M	350-700									
	10, 11	High-alloy Steel	H13, A2, D2, M2, T1	300-600									
M	12 thru 13	Stainless Steel (Ferritic & Martensitic)	410, 416, 440	350-600	.003-.005		4			3	2	1	Yes
	14	Stainless Steel (Austenitic)	303, 304, 316, 15-5, 17-4	300-550									May not be required at high speeds
K	15 thru 16	Gray Cast Iron	CLS. 20, 30, 45	500-1000	.003-.006	2			1	3			No
	17 thru 20	Nodular Cast Iron	60-40-18, 100-70-03	400-800									
N	21 - 30	Aluminum	7075, 6061	1000-3000	.003-.007			1					Yes
S	31 thru 35	High-Temp Alloys	Inconel, Hastelloy, Nimonic, Monel	65-200	.003-.005					2	3	1	Yes
	36 thru 37	Titanium Alloys	6Al-4V, 5Al-5Mo-5V-3Cr	85-200						3	2	1	
H	38 thru 39	Hardened Steel >48	A2, O1, D2	130-250	.002-.004	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.

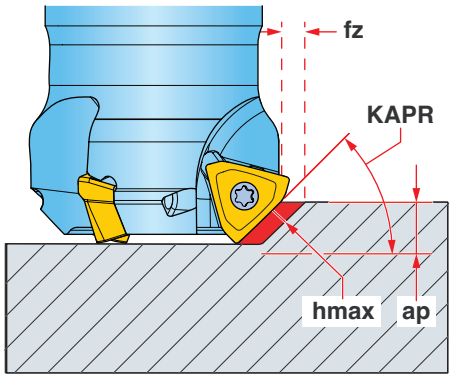
HIPOSTRIO™ 06 OPERATING GUIDELINES - SERIES 1K_1D

RPM Calculation



Calculation is to be made using the resultant diameter at ap.

Chip Thinning



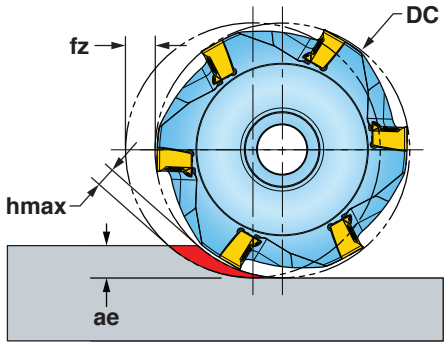
Chip Thinning calculator is recommended to ensure hmax falls within fz range

Materials				Vc Cutting Speed SFM	fz* Feed/Tooth (inch)	Harder.....Tougher							Coolant
ISO	Mat'l Group #VDI 3323	Type	Examples			IN2504	IN2540	IN10K	IN2510	IN2505	IN2530 IN4030	IN2035	
P	1 thru 5	Non-alloy Steel	1018, A36, 1045, A572, 1070	400-1000	.003-.006		3			2	1		No
	6 thru 9	Low-alloy Steel	4140, 4340, P20, 8620, 300M	350-700									
	10, 11	High-alloy Steel	H13, A2, D2, M2, T1	300-600									
M	12 thru 13	Stainless Steel (Ferritic & Martensitic)	410, 416, 440	350-600	.003-.005		4			3	2	1	Yes
	14	Stainless Steel (Austenitic)	303, 304, 316, 15-5, 17-4	300-550									May not be required at high speeds
K	15 thru 16	Gray Cast Iron	CLS. 20, 30, 45	500-1000	.003-.006	1			2	3	4		No
	17 thru 20	Nodular Cast Iron	60-40-18, 100-70-03	400-800									
N	21 - 30	Aluminum	7075, 6061	1000-3000	.003-.007			1					Yes
S	31 thru 35	High-Temp Alloys	Inconel, Hastelloy, Nimonic, Monel	65-200	.003-.005					3	2	1	Yes
	36 thru 37	Titanium Alloys	6Al-4V, 5Al-5Mo-5V-3Cr	85-200						2	3	1	
H	38 thru 39	Hardened Steel >48	A2, O1, D2	130-250	.002-.004	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.

HIPOSTRIO™ 10 OPERATING GUIDELINES

Chip Thinning



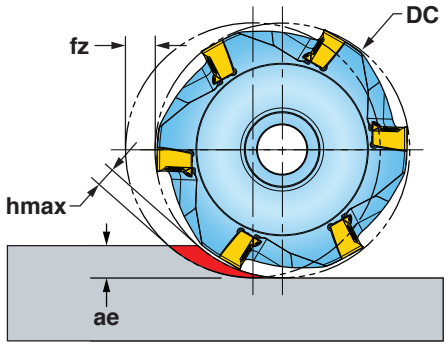
* When ae is less than 25% DC, recommend use of Chip Thinning Calculator to ensure hmax falls within fz range.

Materials				Vc Cutting Speed SFM	fz* Feed/Tooth (inch)	Harder.....Tougher								Coolant
ISO	Mat'l Group #VDI 3323	Type	Examples			IN2504	IN2540	IN10K	IN2510	IN2505	IN4030 IN2530	IN2035	IN6537	
P	1 thru 5	Non-alloy Steel	1018, A36, 1045, A572, 1070	400-1000	.003-.008		4			3	2		1	No
	6 thru 9	Low-alloy Steel	4140, 4340, P20, 8620, 300M	350-700										
	10, 11	High-alloy Steel	H13, A2, D2, M2, T1	300-600										
M	12 thru 13	Stainless Steel (Ferritic & Martensitic)	410, 416, 440	350-600	.003-.006		4			3	2	1		Yes
	14	Stainless Steel (Austenitic)	303, 304, 316, 15-5, 17-4	300-550										May not be required at high speeds
K	15 thru 16	Gray Cast Iron	CLS. 20, 30, 45	500-1000	.003-.008	2			1	3				No
	17 thru 20	Nodular Cast Iron	60-40-18, 100-70-03	400-800										
N	21 - 30	Aluminum	7075, 6061	1000-3000	.003-.010			1						Yes
S	31 thru 35	High-Temp Alloys	Inconel, Hastelloy, Nimonic, Monel	65-200	.003-.005					2	3	1		Yes
	36 thru 37	Titanium Alloys	6Al-4V, 5Al-5Mo-5V-3Cr	85-200						3	2	1		
H	38 thru 39	Hardened Steel >48	A2, O1, D2	130-250	.003-.005	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.

HIPOSTRIO™ 13 OPERATING GUIDELINES

Chip Thinning

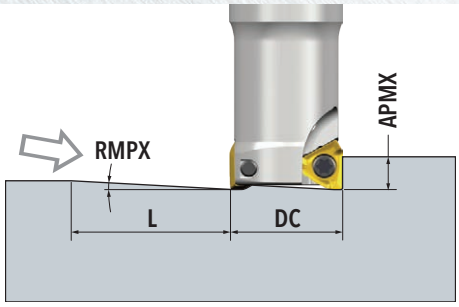


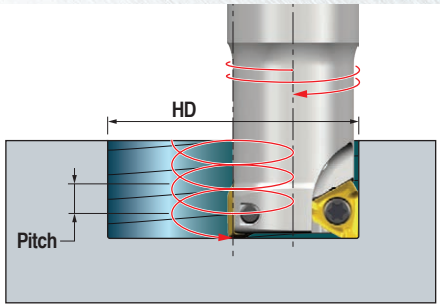
* When ae is less than 25% DC, recommend use of Chip Thinning Calculator to ensure hmax falls within fz range.

Materials				Vc Cutting Speed SFM	fz* Feed/Tooth (inch)	Harder.....Tougher								Coolant
ISO	Mat'l Group #VDI 3323	Type	Examples			IN2504	IN2540	IN10K	IN2510	IN2505	IN4030 IN2530	IN2035	IN6537	
P	1 thru 5	Non-alloy Steel	1018, A36, 1045, A572, 1070	400-1000	.003-.009		4			3	2		1	No
	6 thru 9	Low-alloy Steel	4140, 4340, P20, 8620, 300M	350-700										
	10, 11	High-alloy Steel	H13, A2, D2, M2, T1	300-600										
M	12 thru 13	Stainless Steel (Ferritic & Martensitic)	410, 416, 440	350-600	.003-.007		4			3	2	1		Yes
	14	Stainless Steel (Austenitic)	303, 304, 316, 15-5, 17-4	300-550										May not be required at high speeds
K	15 thru 16	Gray Cast Iron	CLS. 20, 30, 45	500-1000	.003-.010	2			1	3				No
	17 thru 20	Nodular Cast Iron	60-40-18, 100-70-03	400-800										
N	21 - 30	Aluminum	7075, 6061	1000-3000	.003-.010			1						Yes
S	31 thru 35	High-Temp Alloys	Inconel, Hastelloy, Nimonic, Monel	65-200	.003-.006					2	3	1		Yes
	36 thru 37	Titanium Alloys	6Al-4V, 5Al-5Mo-5V-3Cr	85-200						3	2	1		
H	38 thru 39	Hardened Steel >48	A2, O1, D2	130-250	.003-.005	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.

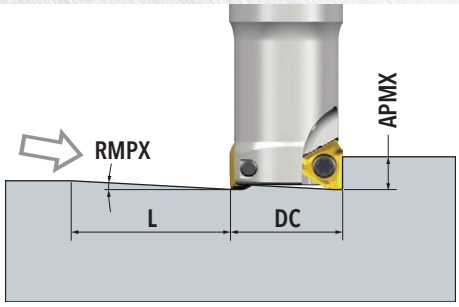
HIPOSTRIO™ 04 RAMP DATA USING SERIES THLS04

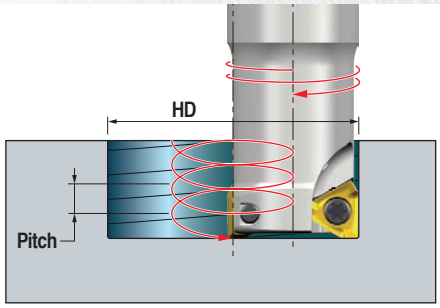




DC Cutter Diameter	Straight Ramp			Helical Ramp		
	RMPX Ramp Angle Max.	APMX Depth of Cut Max.	L Ramp Length Min.	HD Hole Diameter Min.	HD Hole Diameter Max.	Pitch Max.
0.312	2.1	0.13	3.6	0.52		.023
					0.62	.035
0.375	2.1	0.13	3.6	0.67		.031
					0.75	.047
0.437	3.6	0.13	2.2	0.75		.062
					0.87	.082
0.500	2.5	0.13	3.1	0.90		.055
					1.00	.066
0.562	2.1	0.13	3.6	0.99		.051
					1.12	.062
0.625	1.6	0.13	4.9	1.15		.043
					1.25	.055

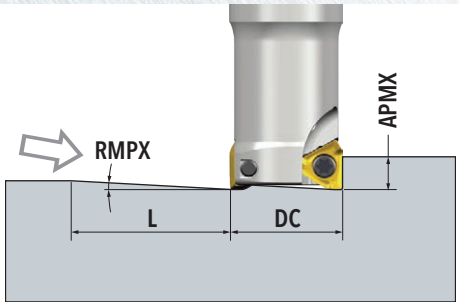
HIPOSTRIO™ 06 RAMP DATA USING SERIES TH_S06

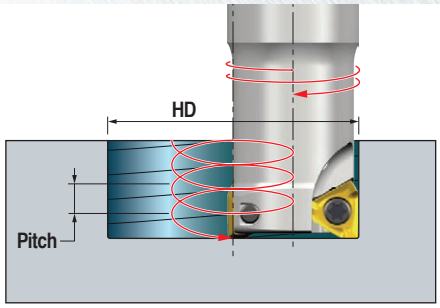




DC Cutter Diameter	Straight Ramp			Helical Ramp		
	RMPX Ramp Angle Max.	APMX Depth of Cut Max.	L Ramp Length Min.	HD Hole Diameter Min.	HD Hole Diameter Max.	Pitch Max.
0.625	4.0	0.27	3.8	0.94		0.080
					1.25	0.110
0.750	3.1	0.27	4.9	1.19		0.080
					1.50	0.130
0.875	2.5	0.27	6.1	0.56		0.090
					1.75	0.140
1.000	2.1	0.27	7.3	1.69		0.100
					2.00	0.120
1.250	1.5	0.27	10.3	2.19		0.090
					2.50	0.110
1.500	1.3	0.27	11.8	2.69		0.090
					3.00	0.110
2.000	1.2	0.27	12.8	3.69		0.100
					4.00	0.120
3.000	0.4	0.27	38.6	5.69		0.100
					6.00	0.110

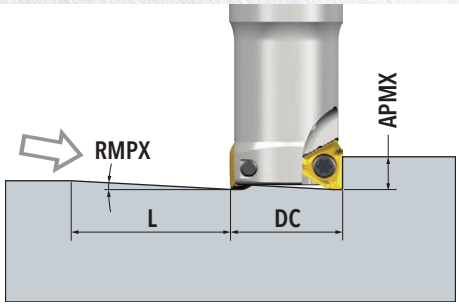
HIPOSTRIO™ 10 RAMP DATA USING SERIES TH_S10

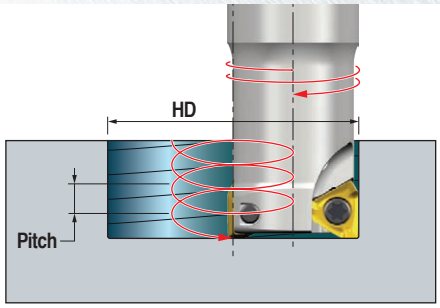




DC Cutter Diameter	Straight Ramp			Helical Ramp		
	RMPX Ramp Angle Max.	APMX Depth of Cut Max.	L Ramp Length Min.	HD Hole Diameter Min.	HD Hole Diameter Max.	Pitch Max.
1.250	2.7	0.41	8.6	2.04		0.120
					2.50	0.180
1.500	1.7	0.41	13.8	2.57		0.100
					3.00	0.130
2.000	1.2	0.41	19.5	3.58		0.100
					4.00	0.120
2.500	1.0	0.41	23.4	4.57		0.110
					5.00	0.120
3.000	0.7	0.41	33.5	5.57		0.110
					6.00	0.120
4.000	0.6	0.41	39.1	7.57		0.110
					8.00	0.120
5.000	0.4	0.41	58.7	9.57		0.110
					10.00	0.110

HIPOSTRIO™ 13 RAMP DATA USING SERIES TH_S13





DC Cutter Diameter	Straight Ramp			Helical Ramp		
	RMPX Ramp Angle Max.	APMX Depth of Cut Max.	L Ramp Length Min.	HD Hole Diameter Min.	HD Hole Diameter Max.	Pitch Max.
2.000	1.5	0.57	21.7	3.49		0.140
					4.00	0.160
2.500	1.1	0.57	29.6	4.50		0.130
					5.00	0.140
3.000	0.8	0.57	40.8	5.51		0.130
					6.00	0.140
4.000	0.6	0.57	54.4	7.51		0.120
					8.00	0.140
5.000	0.5	0.57	65.3	9.53		0.120
					10.00	0.130
6.000	0.4	0.57	81.6	11.53		0.120
					12.00	0.130
6.500	0.2	0.57	163.0	12.53		0.120
					13.00	0.130