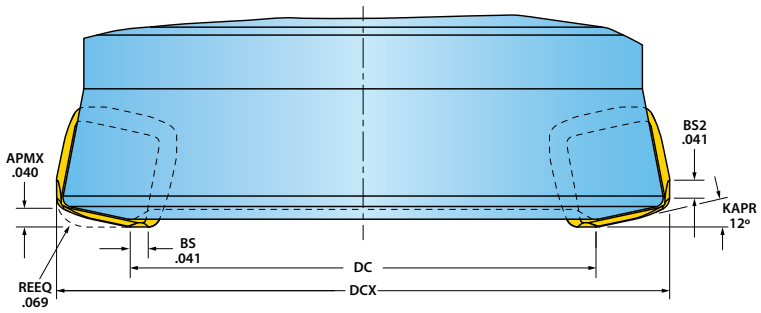
6 mm • Programming Data NEW

DEFINITIONS

- » **DCX:** maximum cutting diameter
- » **DC:** effective cutter diameter
- » **KAPR:** cutting edge angle
- » **APMX:** maximum depth of cut
- » **REEQ:** program radius
- » **BS:** axial wiper length
- » **BS2:** radial wiper length



Part Number	DCX Cutting Dia. Max.	DC Cutting Dia.
15G1D-06015S6R01	0.625	0.314
15G1D-07020S7R01	0.750	0.438
15G1D-07030S7R01	0.750	0.438
15G1D-08020S8R01	0.875	0.562
15G1D-10020S1R01	1.000	0.686
15G1D-10030S1R01	1.000	0.686
15G1D-12030S9R01	1.250	0.936
15G1D-06010X5R01	0.625	0.314
15G1D-07010X6R01	0.750	0.438
15G1D-08010X7R01	0.875	0.562
15G1D-10013X7R01	1.000	0.686
15G1D-12015X8R01	1.250	0.936
15G1D-15015X8R01	1.500	1.186
15G1D-15017X9R01	1.500	1.186
15G1D-06008TRR01	0.625	0.314
15G1D-07010TSR01	0.750	0.438
15G1D-10012TUR01	1.000	0.686
5G1D-15R01	1.500	1.186
5G1D-20R01	2.000	1.686
5G1D-20R02	2.000	1.686

6 mm • Programming Tips NEW

- » The shape of the insert nose can be approximated by programming as-if the insert had a **.069"** corner radius (REEQ). The difference will result in an unmachined area that's approximately **.0186"** deep.
- » The recommendations for cutting speed, chip-thickness grade, and insert geometry are starting recommendations and should be optimized based on the type and rate of edge failure.
- » The **Machining Calculator App**, on Ingersoll's website, is another resource for estimating and optimizing parameters. There are additional inputs like the radial width of cut and the effective rake angle can be included into the estimates.