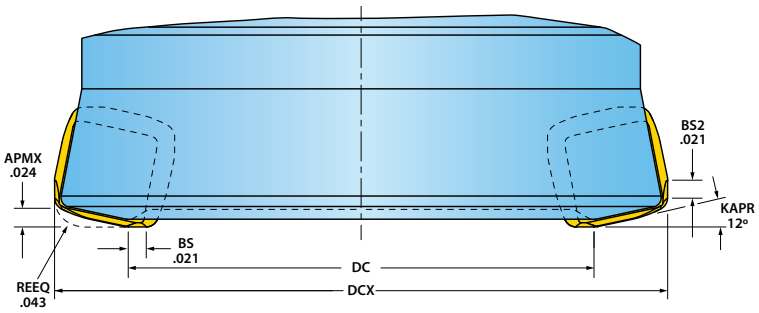
# 4 mm • Programming Data

## DEFINITIONS

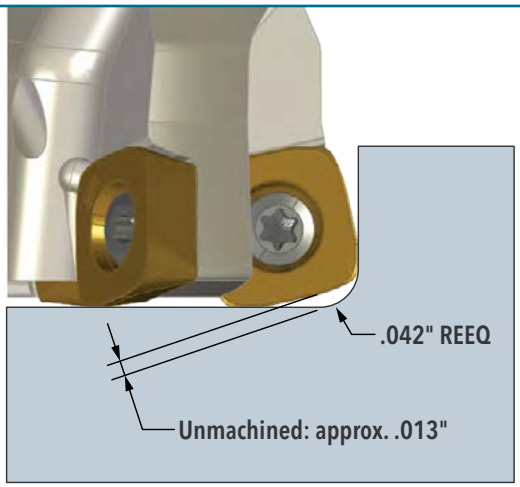
» **DCX:** maximum cutting diameter
» **DC:** effective cutter diameter
» **KAPR:** cutting edge angle
» **APMX:** maximum depth of cut
» **REEQ:** program radius
» **BS:** axial wiper length
» **BS2:** radial wiper length




| Part Number | DCX Cutting Dia. Max. | DC Cutting Dia. |
|---|---|---|
| 15G1B-03006T6R01 | 0.375 | 0.167 |
| 15G1B-03015R8R01 | 0.375 | 0.167 |
| 15G1B-05007T8R01 | 0.500 | 0.291 |
| 15G1B-05007X4R01 | 0.500 | 0.291 |
| 15G1B-05015S4R01 | 0.500 | 0.291 |
| 15G1B-06008TRR01 | 0.625 | 0.415 |
| 15G1B-06010X5R01 | 0.625 | 0.415 |
| 15G1B-06015S6R01 | 0.625 | 0.415 |
| 15G1B-07010TSR01 | 0.750 | 0.540 |
| 15G1B-07010X6R01 | 0.750 | 0.540 |
| 15G1B-07015S7R01 | 0.750 | 0.540 |

# 4 mm • Programming Tips

» The shape of the insert nose can be approximated by programming as-if the insert had a **.042"** corner radius (REEQ). The difference will result in an unmachined area that's approximately **.013"** 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.