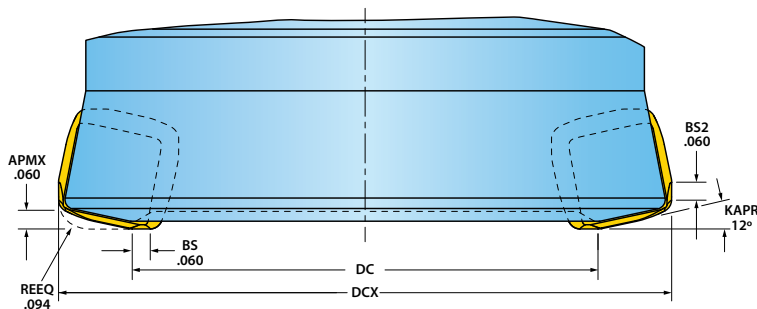


## 9 mm • Programming Data

### 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.
15G1F-10019S1R01	1.000	0.524
15G1F-10020S1R01	1.000	0.524
15G1F-10015X7R01	1.000	0.524
15G1F-12047S9R02	1.250	0.773
15G1F-12047S9R01	1.250	0.773
15G1F-12027E2R02	1.250	0.773
15G1F-12027E2R01	1.250	0.773
15G1F-12047E2R01	1.250	0.773
15G1F-12015X8R02	1.250	0.773
15G1F-15060S9R02	1.500	1.022
15G1F-15060S9R01	1.500	1.022
15G1F-15016E2R02	1.500	1.022
15G1F-15016E2R01	1.500	1.022
15G1F-15017X9R01	1.500	1.022
5G5F-20R01	2.000	1.521
5G6F-20R01	2.000	1.521
5G5F-25R01	2.500	2.020
5G5F-30R01	3.000	2.520
5G6F-30R01	3.000	2.520

## 9 mm • Programming Tips

- » The shape of the insert nose can be approximated by programming as-if the insert had a **.094"** corner radius (REEQ). The difference will result in an unmachined area that's approximately **.030"** 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.

