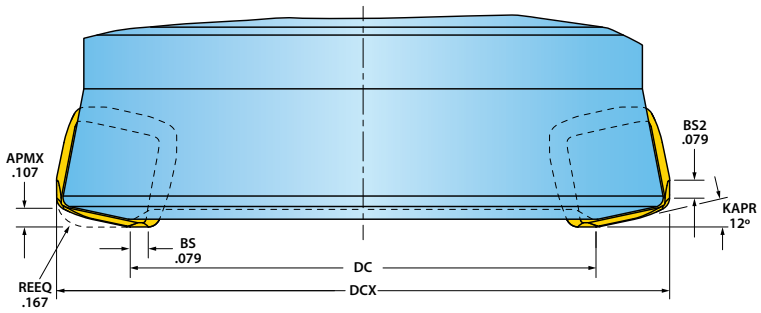
16 mm • Programming Data

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.
5G5Q-25R01	2.500	1.645
5G5Q-25R02	2.500	1.645
5G5Q-30R01	3.000	2.144
5G6Q-30R01	3.000	2.144
5G5Q-30R02	3.000	2.144
5G5Q-40R01	4.000	3.144
5G6Q-40R01	4.000	3.144
5G6Q-50R01	5.000	4.144
5G6Q-60R01	6.000	5.144

16 mm • Programming Tips

- » The shape of the insert nose can be approximated by programming as-if the insert had a **.167"** corner radius (REEQ). The difference will result in an unmachined area that's approximately **.056"** 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.