INDUSTRY 4.0
PRODUCT ANNOUNCEMENT
•UPDATE•
2025

DIPOSTRIO™

MILLING PRODUCTS

Cutter Series (Applications)
FHU
(Flat Bottom Plunge Mill)
1WJ1D / WJ_D
(Rough, Ramp, Drill Mill)
1WJ1F / WJ_F
(Rough, Ramp, Drill Mill)
1DJ_F / DJ_F
(Rough & Finish Mill)
1DJ_P / DJ_P
(Rough & Finish Mill)

Diameter Range
.750-6.00
16-125mm

Corner Radii
.008, .015, .020, .031 & .062 R

Materials
Iron, Steel, Stainless Steel, Aluminum, Hi-Temps Titanium & Hard Steel

Trigon shape inserts offer 6-Edge-Economy; Oriented for multiple applications.

Features & Benefits:

- Plunge Mills that generate a flat bottom; ideal for light duty machines, deep reaches and relieving corners in a pocket
- Mills for roughing and aggressive ramping; produce 63-125 Ra surface finishes
- Mills with integrated wipers for roughing and finishing; produce 20-32 Ra surface finishes
- Dovetail pocket designs for secure clamping; thick inserts for utmost durability
- Inserts with multiple corner radii; grades for ferrous and non-ferrous materials
- Cutters ported with coolant through

Member IMC Group
Ingersoll Cutting Tools

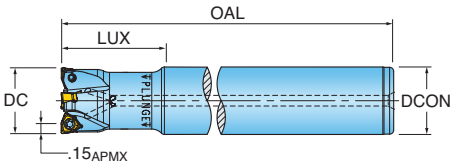
NEW-356-5
(01/2025)
1/24

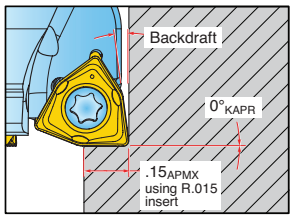
DIPOSTRIO™ 04 SERIES FHU (CYLINDRICAL SHANK)

FLAT BOTTOM PLUNGE ROUGH MILL (4MM INSERT)

Plunging

Coolant





Part Number	DC Cutting Dia.	LUX Usable Length Max.	OAL Overall Length	ZEFF Effective Teeth	DCON Shank Dia.
FHU-07030S7R01	0.750	1.50	5.00	3	0.750
FHU-10032S1R01	1.000	1.50	5.50	4	1.000

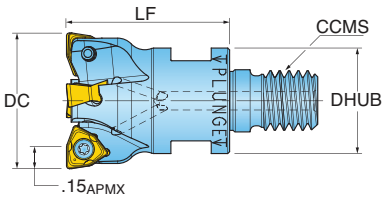
Note: Cutter body can be modified; shorten by cutting off back end or add usable length by turning back neck diameter.

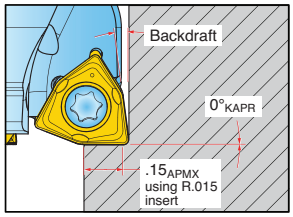
DIPOSTRIO™ 04 SERIES FHU (TOP-ON STYLE)

FLAT BOTTOM PLUNGE ROUGH MILL (4MM INSERT)

Plunging

Coolant





INCH

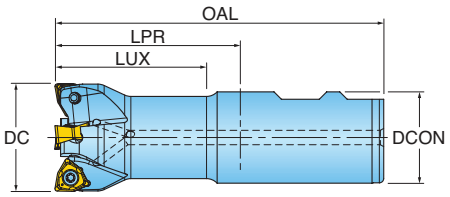
Part Number	DC Cutting Dia.	LF Functional Length	ZEFF Effective Teeth	CCMS Connection Code Machine Side	DHUB Hub Dia.
FHU-07012X6R01	0.750	1.25	3	TopOn M10	0.69
FHU-10015X7R01	1.000	1.50	4	TopOn M12	0.81

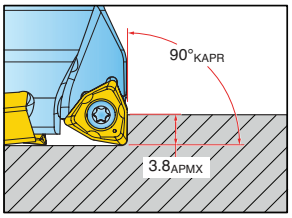
METRIC

Part Number	DC Cutting Dia.	LF Functional Length	ZEFF Effective Teeth	CCMS Connection Code Machine Side	DHUB Hub Dia.
FHU020030X6R00	20	30	3	TopOn M10	18
FHU025035X7R00	25	35	4	TopOn M12	21
FHU030043X7R00	30	43	5	TopOn M16	29
FHU032043X8R00	32	43	6	TopOn M16	29
FHU035043X8R00	35	43	6	TopOn M16	29
FHU040043X8R00	40	43	7	TopOn M16	29
FHU042043X8R00	42	43	7	TopOn M16	29

DIPOSTRIO™ 04 SERIES 1WJ1D_W (WELDON SHANK)

90° ROUGH & RAMP END MILL (4MM INSERT)



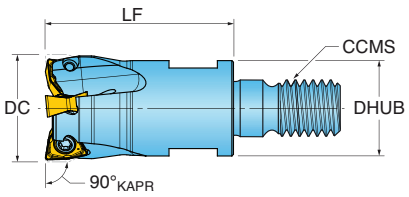


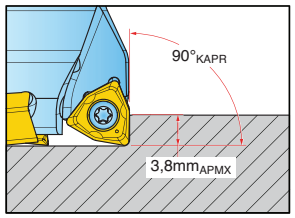
Part Number	DC Cutting Dia.	LUX Usable Length Max.	OAL Overall Length	ZEFF Effective Teeth	DCON Shank Dia.
1WJ1D016026W3R00	16	26	85	2	16
1WJ1D020030W4R00	20	30	90	3	20
1WJ1D025040W5R00	25	40	100	5	25
1WJ1D032040W5R00	32	40	100	6	25

DIPOSTRIO™ 04 SERIES 1WJ1D_X (TOP-ON STYLE)

90° ROUGH & RAMP END MILL (4MM INSERT)

Facing | Shoulder Milling | Channeling | Ramping | Pocketing | Corkscrew | Coolant



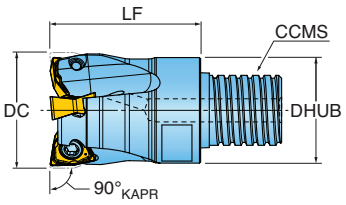


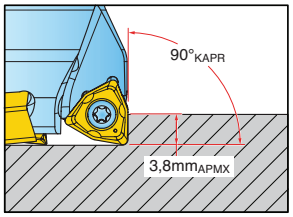
Part Number	DC Cutting Dia.	LF Functional Length	OAL Overall Length	ZEFF Effective Teeth	CCMS Connection Code Machine Side	DHUB Hub Dia.
1WJ1D016023X5R00	16	23	40.8	2	TopOn M8	13
1WJ1D020035X6R00	20	35	54.8	3	TopOn M10	18
1WJ1D025035X7R00	25	35	57	5	TopOn M12	21
1WJ1D032043X8R00	32	43	67	6	TopOn M16	29
1WJ1D035043X8R00	35	43	67	6	TopOn M16	29
1WJ1D040043X8R00	40	43	67	7	TopOn M16	29

DIPOSTRIO™ 04 SERIES 1WJ1D_T (CHIP-SURFER STYLE)

90° ROUGH & RAMP END MILL (4MM INSERT)

Facing | Shoulder Milling | Channeling | Ramping | Pocketing | Corkscrew | Coolant

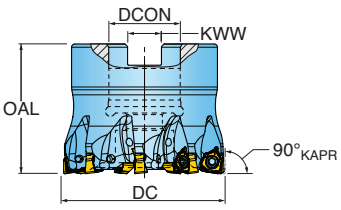


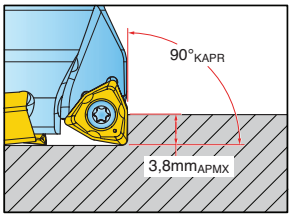


Part Number	DC Cutting Dia.	LF Functional Length	OAL Overall Length	ZEFF Effective Teeth	CCMS Connection Code Machine Side	DHUB Hub Dia.
1WJ1D016026TRR00	16	26	37.9	2	Chip Surfer T10	15.2
1WJ1D020026TSR00	20	26	40	3	Chip Surfer T12	18.3
1WJ1D025032TUR00	25	32	49.1	5	Chip Surfer T15	23.9

DIPOSTRIO™ 04 SERIES WJ5D, WJ6D

90° ROUGH & RAMP FACE MILL (4MM INSERT)





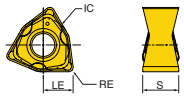
METRIC

Part Number	DC Cutting Dia.	OAL Overall Length	ZEFF Effective Teeth	DCON Shank Dia.	KWW Keyway
WJ5D032R00	32	35	6	16	8.4
WJ5D040R01	40	40	7	16	8.4
WJ6D040R01	40	40	5	16	8.4
WJ5D040R00	40	40	7	22	10.4
WJ6D040R00	40	40	5	22	10.4
WJ5D050R00	50	40	9	22	10.4
WJ6D050R00	50	40	6	22	10.4
WJ5D063R00	63	40	11	22	10.4
WJ6D063R00	63	40	8	22	10.4

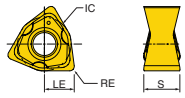
DIPOSTRIO™ 04 INSERTS

N P

WMNU_N



WMCU_FN-P



Part Number	Application	RE/BCH Corner Radius/ Chamfer	LE Cutting Edge Length	IC Inscribed Circle Dia.	S Thickness (To Cutting Edge)	NOI Number of Indexes	IH Insert Hand	Grade	IN10K	IN2035	IN2504	IN2505	IN2530	IN4030	IN6537
WNMU04T302N	Multi-Purpose	0.008 R	0.302	0.246	0.159	6	Neutral					•	•		
WNMU04T304N	Multi-Purpose	0.015 R	0.298	0.246	0.157	6	Neutral			•	•	•	•	•	•
WNCU04T302FN-P	Non-Ferrous	0.008 R	0.302	0.246	0.159	6	Neutral		•						
WNCU04T304FN-P	Non-Ferrous	0.015 R	0.298	0.246	0.157	6	Neutral		•						
WNCU04T308FN-P	Non-Ferrous	0.031 R	0.291	0.246	0.152	6	Neutral		•						

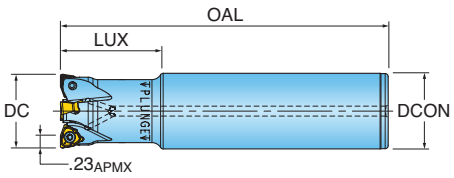
DIPOSTRIO™ 04 HARDWARE

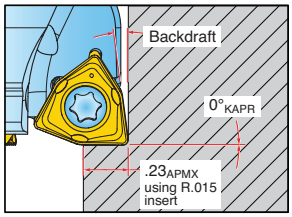
	 Insert Screw	 Wing Style Driver	 Retention Bolt	 **OPTIONAL** TopOn Wrench	 **OPTIONAL** ChipSurfer Wrench	 **OPTIONAL** ChipSurfer Torque Wrench	 **OPTIONAL** Torque Driver Handle	 **OPTIONAL** Preset Torque Bit	 **OPTIONAL** Torque Driver Bit
FHU-07030S7R01	SM25-064-00	DS-T08W					DS-A00-.25-S	DS-11-.30	DS-T08B
FHU10032S1R01	SM25-064-00	DS-T08W					DS-A00-.25-S	DS-11-.30	DS-T08B
FHU-07012X6R01	SM25-064-00	DS-T08W		615 MM			DS-A00-.25-S	DS-11-.30	DS-T08B
FHU-10015X7R01	SM25-064-00	DS-T08W		617 MM			DS-A00-.25-S	DS-11-.30	DS-T08B
FHU020030X6R00	SM25-064-00	DS-T08W		615 MM			DS-A00-.25-S	DS-11-.25	DS-T08B
FHU025035X7R00	SM25-064-00	DS-T08W		617 MM			DS-A00-.25-S	DS-11-.26	DS-T08B
FHU030043X7R00	SM25-064-00	DS-T08W		617 MM			DS-A00-.25-S	DS-11-.27	DS-T08B
FHU032043X8R00	SM25-064-00	DS-T08W		622 MM			DS-A00-.25-S	DS-11-.28	DS-T08B
FHU035043X8R00	SM25-064-00	DS-T08W		622 MM			DS-A00-.25-S	DS-11-.29	DS-T08B
FHU040043X8R00	SM25-064-00	DS-T08W		622 MM			DS-A00-.25-S	DS-11-.30	DS-T08B
FHU042043X8R00	SM25-064-00	DS-T08W		622 MM			DS-A00-.25-S	DS-11-.30	DS-T08B
1WJ1D016026W3R00	SM25-064-00	DS-T08W					DS-A00-.25-S	DS-11-.25	DS-T08B
1WJ1D020030W4R00	SM25-064-00	DS-T08W					DS-A00-.25-S	DS-11-.26	DS-T08B
1WJ1D025040W5R00	SM25-064-00	DS-T08W					DS-A00-.25-S	DS-11-.27	DS-T08B
1WJ1D032040W5R00	SM25-064-00	DS-T08W					DS-A00-.25-S	DS-11-.28	DS-T08B
1WJ1D016026TRR00	SM25-064-00	DS-T08W			WS-0044	DT-250-13	DS-A00-.25-S	DS-11-.25	DS-T08B
1WJ1D020026TSR00	SM25-064-00	DS-T08W			WS-0059	DT-250-16	DS-A00-.25-S	DS-11-.26	DS-T08B
1WJ1D025032TUR00	SM25-064-00	DS-T08W			WS-0061	DT-350-20	DS-A00-.25-S	DS-11-.27	DS-T08B
1WJ1D016023X5R00	SM25-064-00	DS-T08W		610 MM			DS-A00-.25-S	DS-11-.25	DS-T08B
1WJ1D020035X6R00	SM25-064-00	DS-T08W		615 MM			DS-A00-.25-S	DS-11-.26	DS-T08B
1WJ1D025035X7R00	SM25-064-00	DS-T08W		617 MM			DS-A00-.25-S	DS-11-.27	DS-T08B
1WJ1D032043X8R00	SM25-064-00	DS-T08W		622 MM			DS-A00-.25-S	DS-11-.28	DS-T08B
1WJ1D035043X8R00	SM25-064-00	DS-T08W		622 MM			DS-A00-.25-S	DS-11-.29	DS-T08B
1WJ1D040043X8R00	SM25-064-00	DS-T08W		622 MM			DS-A00-.25-S	DS-11-.30	DS-T08B
WJ5D032R00	SM25-064-00	DS-T08W	DIN912M8X25-12.9				DS-A00-.25-S	DS-11-.31	DS-T08B
WJ5D040R01	SM25-064-00	DS-T08W	DIN912M8X25-12.9				DS-A00-.25-S	DS-11-.32	DS-T08B
WJ6D040R01	SM25-064-00	DS-T08W	DIN912M8X25-12.9				DS-A00-.25-S	DS-11-.33	DS-T08B
WJ5D040R00	SM25-064-00	DS-T08W	DIN912M10X25-12.9				DS-A00-.25-S	DS-11-.34	DS-T08B
WJ6D040R00	SM25-064-00	DS-T08W	DIN912M10X25-12.9				DS-A00-.25-S	DS-11-.35	DS-T08B
WJ5D050R00	SM25-064-00	DS-T08W	DIN912M10X25-12.9				DS-A00-.25-S	DS-11-.36	DS-T08B
WJ6D050R00	SM25-064-00	DS-T08W	DIN912M10X25-12.9				DS-A00-.25-S	DS-11-.37	DS-T08B
WJ5D063R00	SM25-064-00	DS-T08W	DIN912M10X25-12.9				DS-A00-.25-S	DS-11-.38	DS-T08B
WJ6D063R00	SM25-064-00	DS-T08W	DIN912M10X25-12.9				DS-A00-.25-S	DS-11-.39	DS-T08B

DIPOSTRIO™ 06 SERIES FHU (CYLINDRICAL SHANK)

FLAT BOTTOM PLUNGE ROUGH MILL (6MM INSERT)

Plunging | Coolant





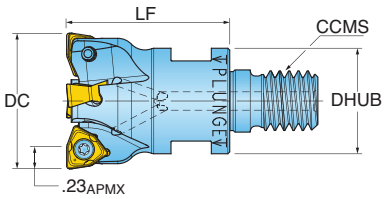
Part Number	DC Cutting Dia.	LUX Usable Length Max.	OAL Overall Length	ZEFF Effective Teeth	DCON Shank Dia.
FHU-12037S9R01	1.250	2.00	6.00	3	1.250
FHU-15038S5R01	1.500	2.00	6.50	4	1.500

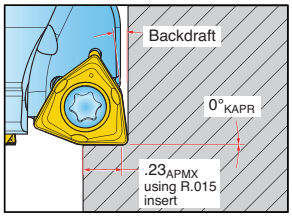
Note: Cutter body can be modified; shorten by cutting off back end or add usable length by turning back neck diameter.

DIPOSTRIO™ 06 SERIES FHU (TOP-ON STYLE)

FLAT BOTTOM PLUNGE ROUGH MILL (6MM INSERT)

Plunging | Coolant

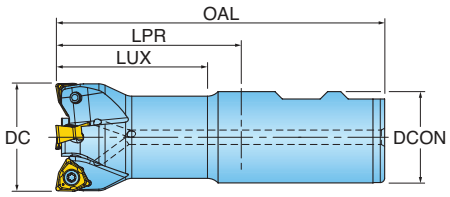


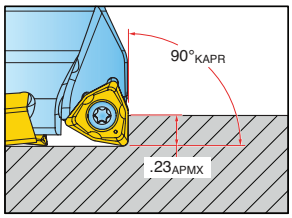


Part Number	DC Cutting Dia.	LF Functional Length	ZEFF Effective Teeth	CCMS Connection Code Machine Side	DHUB Hub Dia.
FHU-12017X8R01	1.250	1.75	3	TopOn M16	1.13
FHU-15017X8R01	1.500	1.75	4	TopOn M16	1.13

DIPOSTRIO™ 06 SERIES 1WJ1F (WELDON SHANK)

90° ROUGH & RAMP END MILL (6MM INSERT)





INCH

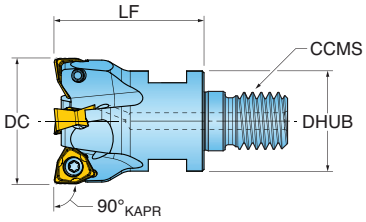
Part Number	DC Cutting Dia.	LUX Usable Length Max.	LPR Protruding Length	OAL Overall Length	ZEFF Effective Teeth	DCON Shank Dia.
1WJ1F-1001780R01	1.000	1.72	1.75	4.00	2	1.000
1WJ1F-1202281R01	1.250	2.22	2.25	4.50	3	1.250
1WJ1F-1502281R01	1.500	2.22	2.25	4.50	4	1.250

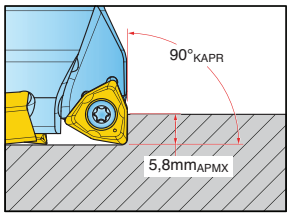
METRIC

Part Number	DC Cutting Dia.	LUX Usable Length Max.	LPR Protruding Length	OAL Overall Length	ZEFF Effective Teeth	DCON Shank Dia.
1WJ1F025030W5R00	25	30	68	100	2	25
1WJ1F032040W6R00	32	40	74	110	3	32
1WJ1F040040W6R00	40	40	79	115	4	32

DIPOSTRIO™ 06 SERIES 1WJ1F_X (TOP-ON STYLE)

90° ROUGH & RAMP END MILL (6MM INSERT)

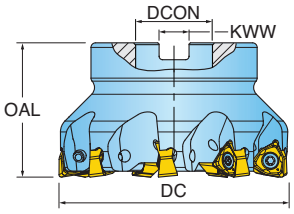


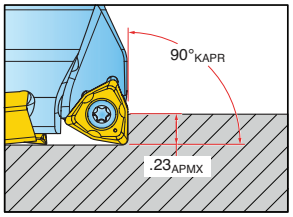


Part Number	DC Cutting Dia.	LF Functional Length	ZEFF Effective Teeth	CCMS Connection Code Machine Side	DHUB Hub Dia.
1WJ1F025035X7R00	25	35	2	TopOn M12	21
1WJ1F032043X8R00	32	43	3	TopOn M16	29
1WJ1F040043X8R00	40	43	4	TopOn M16	29

DIPOSTRIO™ 06 SERIES WJ5F

90° ROUGH & RAMP FACE MILL (6MM INSERT)





INCH

Part Number	DC Cutting Dia.	OAL Overall Length	ZEFF Effective Teeth	DCON Shank Dia.	KWW Keyway
WJ5F-20R01	2.000	1.57	6	0.750	0.312
WJ5F-25R01	2.500	1.57	7	0.750	0.312
WJ5F-30R01	3.000	1.75	9	1.000	0.375
WJ5F-40R01	4.000	2.38	11	1.500	0.625

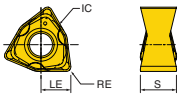
METRIC

Part Number	DC Cutting Dia.	OAL Overall Length	ZEFF Effective Teeth	DCON Shank Dia.	KWW Keyway
WJ5F040R00	40	40	4	16	8.4
WJ6F050R00	50	40	4	22	10.4
WJ5F050R00	50	40	6	22	10.4
WJ6F063R00	63	40	5	22	10.4
WJ5F063R00	63	40	7	22	10.4
WJ6F080R00	80	50	7	27	12.4
WJ5F080R00	80	50	9	27	12.4
WJ6F100R00	100	50	8	32	14.4
WJ5F100R00	100	50	11	32	14.4
WJ6F125R00	125	63	10	40	16.4
WJ5F125R00	125	63	14	40	16.4

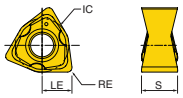
DIPOSTRIO™ 06 INSERTS

N P

WMNU_N



WMCU_FN-P



Part Number	Application	RE/BCH Corner Radius/ Chamfer	LE Cutting Edge Length	IC Inscribed Circle Dia.	S Thickness (To Cutting Edge)	NOI Number of Indexes	IH Insert Hand	Grade	IN10K	IN2035	IN2504	IN2505	IN2530	IN4030	IN6535	IN6537
WNMU060604N	Multi-Purpose	0.015 R	0.230	0.370	0.254	6	Neutral			•	•	•	•	•		
WNMU060608N	Multi-Purpose	0.031 R	0.230	0.370	0.244	6	Neutral			•	•	•	•	•	•	•
WNCU060604FN-P	Non-Ferrous	0.015 R	0.230	0.370	0.254	6	Neutral		•							
WNCU060608FN-P	Non-Ferrous	0.031 R	0.230	0.370	0.249	6	Neutral		•							
WNCU060616FN-P	Non-Ferrous	0.062 R	0.230	0.370	0.237	6	Neutral		•							

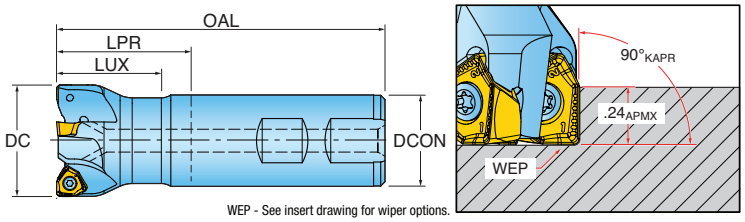
DIPOSTRIO™ 06 HARDWARE

	Insert Screw	Driver Handle	Driver Blade	**OPTIONAL** TopOn Wrench	Retention Bolt	**OPTIONAL** Coolant Bolt	**OPTIONAL** Torque Driver Handle	**OPTIONAL** Preset Torque Bit	**OPTIONAL** Torque Driver Bit
FHU-12037S9R01	SM35-088-60	DS-A00T	DS-T106B				DS-A00-.25-T	DT-30-.25	DS-T10B1
FHU-15038S5R01	SM35-088-60	DS-A00T	DS-T106B				DS-A00-.25-T	DT-30-.25	DS-T10B1
FHU-12017X8R01	SM35-088-60	DS-A00T	DS-T106B	622mm			DS-A00-.25-T	DT-30-.25	DS-T10B1
FHU-15017X8R01	SM35-088-60	DS-A00T	DS-T106B	622mm			DS-A00-.25-T	DT-30-.25	DS-T10B1
1WJ1F-1001780R01	SM35-088-60	DS-A00T	DS-T106B				DS-A00-.25-T	DT-30-.25	DS-T10B1
1WJ1F-1202281R01	SM35-088-60	DS-A00T	DS-T106B				DS-A00-.25-T	DT-30-.25	DS-T10B1
1WJ1F-1502281R01	SM35-088-60	DS-A00T	DS-T106B				DS-A00-.25-T	DT-30-.25	DS-T10B1
1WJ1F025030W5R00	SM35-088-60	DS-A00T	DS-T106B				DS-A00-.25-T	DT-30-.25	DS-T10B1
1WJ1F032040W6R00	SM35-088-60	DS-A00T	DS-T106B				DS-A00-.25-T	DT-30-.25	DS-T10B1
1WJ1F040040W6R00	SM35-088-60	DS-A00T	DS-T106B				DS-A00-.25-T	DT-30-.25	DS-T10B1
1WJ1F025035X7R00	SM35-088-60	DS-A00T	DS-T106B	617mm			DS-A00-.25-T	DT-30-.25	DS-T10B1
1WJ1F032043X8R00	SM35-088-60	DS-A00T	DS-T106B	622mm			DS-A00-.25-T	DT-30-.25	DS-T10B1
1WJ1F040043X8R00	SM35-088-60	DS-A00T	DS-T106B	622mm			DS-A00-.25-T	DT-30-.25	DS-T10B1
WJ5F-20R01	SM35-088-60	DS-A00T	DS-T106B		SD-06-46	SD-06-89	DS-A00-.25-T	DT-30-.25	DS-T10B1
WJ5F-25R01	SM35-088-60	DS-A00T	DS-T106B		SD-06-46	SD-06-89	DS-A00-.25-T	DT-30-.25	DS-T10B1
WJ5F-30R01	SM35-088-60	DS-A00T	DS-T106B		SD-08-46	SD-08-92	DS-A00-.25-T	DT-30-.25	DS-T10B1
WJ5F-40R01	SM35-088-60	DS-A00T	DS-T106B		SD-12-82	SD-12-99	DS-A00-.25-T	DT-30-.25	DS-T10B1
WJ5F040R00	SM35-088-60	DS-A00T	DS-T106B			DIN912M8X25-12.9	DS-A00-.25-T	DT-30-.25	DS-T10B1
WJ5F050R00	SM35-088-60	DS-A00T	DS-T106B			DIN912M10X25-12.9	DS-A00-.25-T	DT-30-.25	DS-T10B1
WJ6F050R00	SM35-088-60	DS-A00T	DS-T106B			DIN912M10X25-12.9	DS-A00-.25-T	DT-30-.25	DS-T10B1
WJ5F063R00	SM35-088-60	DS-A00T	DS-T106B			DIN912M10X25-12.9	DS-A00-.25-T	DT-30-.25	DS-T10B1
WJ6F063R00	SM35-088-60	DS-A00T	DS-T106B			DIN912M10X25-12.9	DS-A00-.25-T	DT-30-.25	DS-T10B1
WJ5F080R00	SM35-088-60	DS-A00T	DS-T106B			DIN912M12X35-12.9	DS-A00-.25-T	DT-30-.25	DS-T10B1
WJ6F080R00	SM35-088-60	DS-A00T	DS-T106B			DIN912M12X35-12.9	DS-A00-.25-T	DT-30-.25	DS-T10B1
WJ5F100R00	SM35-088-60	DS-A00T	DS-T106B			DIN912M16X30-12.9	DS-A00-.25-T	DT-30-.25	DS-T10B1
WJ6F100R00	SM35-088-60	DS-A00T	DS-T106B			DIN912M16X30-12.9	DS-A00-.25-T	DT-30-.25	DS-T10B1
WJ5F125R00	SM35-088-60	DS-A00T	DS-T106B			DIN912M20X40-12.9	DS-A00-.25-T	DT-30-.25	DS-T10B1
WJ6F125R00	SM35-088-60	DS-A00T	DS-T106B			DIN912M20X40-12.9	DS-A00-.25-T	DT-30-.25	DS-T10B1

DIPOSTRIO™ 09 SERIES 1DJ1F (WELDON SHANK)

90° ROUGH & FINISH END MILL (9MM INSERT)

Facing | Shoulder Milling | Channeling | Slabbing | Coolant

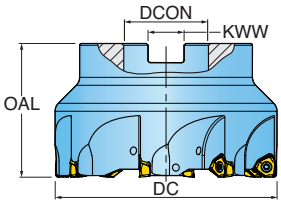


WEP - See insert drawing for wiper options.

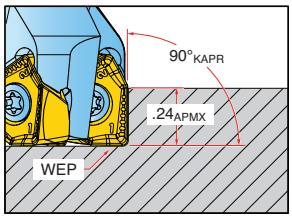
Part Number	DC Cutting Dia.	LUX Usable Length Max.	LPR Protruding Length	OAL Overall Length	ZEFF Effective Teeth	DCON Shank Dia.
1DJ1F-1001584R01	1.000	1.50	1.50	3.50	2	0.750
1DJ1F-1001780R01	1.000	1.70	1.75	4.00	2	1.000
1DJ1F-1003780R01	1.000	3.70	3.75	6.00	2	1.000
1DJ1F-1201584R01	1.250	1.50	1.50	3.50	3	0.750
1DJ1F-1202281R01	1.250	2.20	2.25	4.50	3	1.250
1DJ1F-1204281R01	1.250	4.20	4.25	6.50	3	1.250
1DJ1F-1502281R01	1.500	2.20	2.25	4.50	4	1.250

DIPOSTRIO™ 09 SERIES DJ5F, DJ6F

90° ROUGH & FINISH FACE MILL (9MM INSERT)



WEP - See insert drawing for wiper options.



INCH

Part Number	DC Cutting Dia.	OAL Overall Length	ZEFF Effective Teeth	DCON Shank Dia.	KWW Keyway
DJ5F-20R01	2.000	1.57	5	0.750	0.312
DJ5F-20R02	2.000	1.57	6	0.750	0.312
DJ5F-25R01	2.500	1.57	6	0.750	0.312
DJ5F-30R01	3.000	1.75	7	1.000	0.375
DJ5F-30R02	3.000	1.75	9	1.000	0.375
DJ5F-40R01	4.000	2.38	11	1.500	0.625
DJ6F-40R01	4.000	2.38	8	1.500	0.625

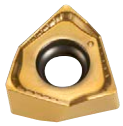
METRIC

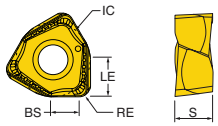
Part Number	DC Cutting Dia.	OAL Overall Length	ZEFF Effective Teeth	DCON Shank Dia.	KWW Keyway
DJ5F040R00	40	40	4	16	8.4
DJ5F050R00	50	40	6	22	10.4
DJ5F063R00	63	40	7	22	10.4
DJ5F080R00	80	50	9	27	12.4
DJ5F100R00	100	63	14	40	16.4
DJ5F125R00	125	63	14	40	16.4

DIPOSTRIO™ 09 INSERTS

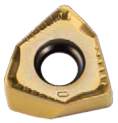
R ML P

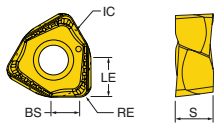
WNGU09_R



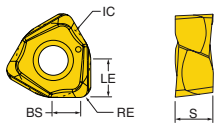


WNGU09_R-ML





WNGU09_FR-P



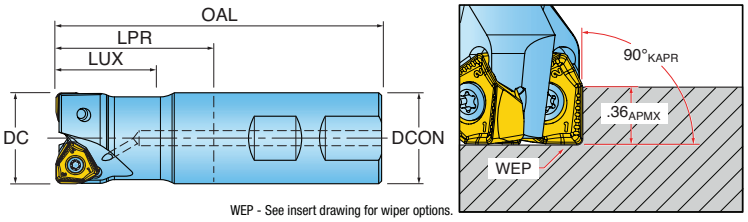
Part Number	Application	RE/BCH Corner Radius/ Chamfer	BS Wiper Length	LE Cutting Edge Length	IC Inscribed Circle Dia.	S Thickness (To Cutting Edge)	NOI Number of Indexes	IH Insert Hand	Grade	IN10K	IN2504	IN2505	IN2510	IN2530	IN2540	IN6537
WNGU090404R	Multi-Purpose	0.015 R	0.093	0.240	0.365	0.187	6	Right			•	•	•	•	•	
WNGU090405R	Multi-Purpose	0.020 R	0.093	0.240	0.365	0.187	6	Right				•				
WNGU090408R	Multi-Purpose	0.031 R	0.077	0.240	0.365	0.187	6	Right			•	•	•	•	•	•
WNGU090410R	Multi-Purpose	0.039 R	0.069	0.240	0.365	0.187	6	Right				•				
WNGU090416R	Multi-Purpose	0.062 R	0.046	0.240	0.365	0.187	6	Right				•	•	•		
WNGU090404R-ML	Multi-Purpose Keen Edge	0.015 R	0.093	0.240	0.365	0.187	6	Right				•	•	•		
WNGU090408R-ML	Multi-Purpose Keen Edge	0.031 R	0.077	0.240	0.365	0.187	6	Right				•	•	•		
WNGU090416R-ML	Multi-Purpose Keen Edge	0.062 R	0.046	0.240	0.365	0.187	6	Right				•	•	•		
WNGU090404FR-P	Non-Ferrous	0.015 R	0.093	0.240	0.365	0.187	6	Right		•						
WNGU090408FR-P	Non-Ferrous	0.031 R	0.077	0.240	0.365	0.187	6	Right		•						

DIPOSTRIO™ 09 HARDWARE

	 Insert Screw	 Wing Style Driver	 Retention Bolt	 **OPTIONAL** Coolant Bolt	 **OPTIONAL** Torque Driver Handle	 **OPTIONAL** Preset Torque Bit	 **OPTIONAL** Torque Driver Bit
1DJ1F-1001584R01	SM30-085-10	DS-T09W			DS-A00-.25-T	DT-18-.25	DS-T09B
1DJ1F-1001780R01	SM30-085-10	DS-T09W			DS-A00-.25-T	DT-18-.25	DS-T09B
1DJ1F-1003780R01	SM30-085-10	DS-T09W			DS-A00-.25-T	DT-18-.25	DS-T09B
1DJ1F-1201584R01	SM30-085-10	DS-T09W			DS-A00-.25-T	DT-18-.25	DS-T09B
1DJ1F-1202281R01	SM30-085-10	DS-T09W			DS-A00-.25-T	DT-18-.25	DS-T09B
1DJ1F-1204281R01	SM30-085-10	DS-T09W			DS-A00-.25-T	DT-18-.25	DS-T09B
1DJ1F-1502281R01	SM30-085-10	DS-T09W			DS-A00-.25-T	DT-18-.25	DS-T09B
DJ5F-20R01	SM30-085-10	DS-T09W	SD-06-46	SD-06-89	DS-A00-.25-T	DT-18-.25	DS-T09B
DJ5F-20R02	SM30-085-10	DS-T09W	SD-06-46	SD-06-89	DS-A00-.25-T	DT-18-.25	DS-T09B
DJ5F-25R01	SM30-085-10	DS-T09W	SD-06-46	SD-06-89	DS-A00-.25-T	DT-18-.25	DS-T09B
DJ5F-30R01	SM30-085-10	DS-T09W	SD-08-46	SD-08-92	DS-A00-.25-T	DT-18-.25	DS-T09B
DJ5F-30R02	SM30-085-10	DS-T09W	SD-08-46	SD-08-92	DS-A00-.25-T	DT-18-.25	DS-T09B
DJ5F-40R01	SM30-085-10	DS-T09W	SD-12-82	SD-12-99	DS-A00-.25-T	DT-18-.25	DS-T09B
DJ6F-40R01	SM30-085-10	DS-T09W	SD-12-82	SD-12-99	DS-A00-.25-T	DT-18-.25	DS-T09B
DJ5F040R00	SM30-085-10	DS-T09W		DIN912M8X25-12.9	DS-A00-.25-T	DT-18-.25	DS-T09B
DJ5F050R00	SM30-085-10	DS-T09W		DIN912M10X25-12.9	DS-A00-.25-T	DT-18-.25	DS-T09B
DJ5F063R00	SM30-085-10	DS-T09W		DIN912M10X25-12.9	DS-A00-.25-T	DT-18-.25	DS-T09B
DJ5F080R00	SM30-085-10	DS-T09W		DIN912M12X35-12.9	DS-A00-.25-T	DT-18-.25	DS-T09B
DJ5F100R00	SM30-085-10	DS-T09W		DIN912M20X40-12.9	DS-A00-.25-T	DT-18-.25	DS-T09B
DJ5F125R00	SM30-085-10	DS-T09W		DIN912M20X40-12.9	DS-A00-.25-T	DT-18-.25	DS-T09B

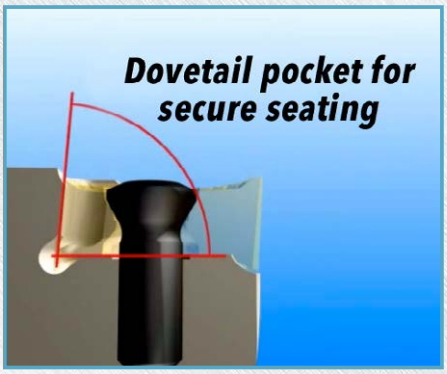
DIPOSTRIO™ 13 SERIES 1DJ1P (WELDON SHANK)

90° ROUGH & FINISH END MILL (13MM INSERT)



WEP - See insert drawing for wiper options.

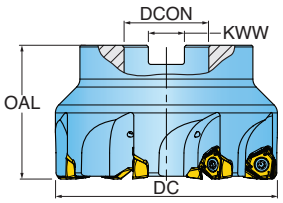
Part Number	DC Cutting Dia.	LUX Usable Length Max.	LPR Protruding Length	OAL Overall Length	ZEFF Effective Teeth	DCON Shank Dia.
1DJ1P-1202281R01	1.250	2.20	2.25	4.50	2	1.250
1DJ1P-1502281R01	1.500	2.25	2.25	4.50	3	1.250



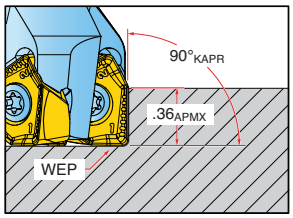
DIPOSTRIO™ 13 SERIES DJ5P, DJ6P

90° ROUGH & FINISH FACE MILL (13MM INSERT)

Facing | Shoulder Milling | Channeling



WEP - See insert drawing for wiper options.



INCH

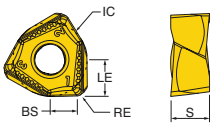
Part Number	DC Cutting Dia.	OAL Overall Length	ZEFF Effective Teeth	DCON Shank Dia.	KWW Keyway	CSP Coolant
DJ5P-20R01	2.000	1.57	5	0.750	0.312	Yes
DJ6P-20R01	2.000	1.57	4	0.750	0.312	Yes
DJ5P-25R01	2.500	1.57	6	0.750	0.312	Yes
DJ5P-30R01	3.000	1.75	7	1.000	0.375	Yes
DJ5P-30R02	3.000	1.75	9	1.000	0.375	Yes
DJ5P-40R01	4.000	2.38	8	1.500	0.625	Yes
DJ5P-40R02	4.000	2.38	11	1.500	0.625	Yes
DJ5P-60R01	6.000	2.00	16	1.500	0.625	No
DJ6P-60R01	6.000	2.00	12	1.500	0.625	No

METRIC

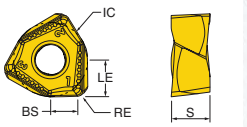
Part Number	DC Cutting Dia.	OAL Overall Length	ZEFF Effective Teeth	DCON Shank Dia.	KWW Keyway	CSP Coolant
DJ6P050R00	50	40	4	22	10.4	Yes
DJ5P050R00	50	40	5	22	10.4	Yes
DJ6P063R00	63	40	5	22	10.4	Yes
DJ5P063R00	63	40	7	22	10.4	Yes
DJ6P080R00	80	50	6	27	12.4	Yes
DJ5P080R00	80	50	9	27	12.4	Yes
DJ6P100R00	100	50	7	32	14.4	Yes
DJ5P100R00	100	50	11	32	14.4	Yes
DJ6P125R00	125	63	9	40	16.4	Yes
DJ5P125R00	125	63	14	40	16.4	Yes
DJ6P160F00	160	63	11	40	16.4	No
DJ5P160R00	160	63	16	40	16.4	No

DIPOSTRIO™ 13 INSERTS

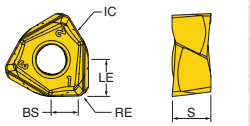
WNGU13_R



WNGU13_R-ML



WNGU13_FR-P



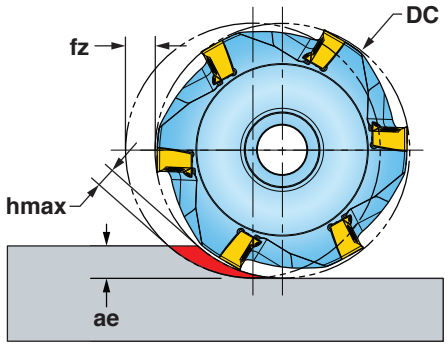
Part Number	Application	RE/BCH Corner Radius/ Chamfer	BS Wiper Length	LE Cutting Edge Length	IC Inscribed Circle Dia.	S Thickness (To Cutting Edge)	NOI No. of Indexes	IH Insert Hand	Grade	IN10K	IN2504	IN2505	IN2510	IN2530	IN2540	IN6537
WNGU130604R	Multi-Purp.	0.015 R	0.086	0.360	0.514	0.265	6	Right				•	•	•		
WNGU130608R	Multi-Purp.	0.031 R	0.078	0.360	0.514	0.265	6	Right			•	•	•	•	•	•
WNGU130616R	Multi-Purp.	0.062 R	0.047	0.360	0.514	0.265	6	Right				•	•	•	•	•
WNGU130604R-ML	Multi-Purp. Keen Edge	0.015 R	0.086	0.360	0.514	0.265	6	Right				•	•	•		
WNGU130608R-ML	Multi-Purp. Keen Edge	0.031 R	0.078	0.360	0.514	0.265	6	Right				•	•	•		
WNGU130616R-ML	Multi-Purp. Keen Edge	0.062 R	0.047	0.360	0.514	0.265	6	Right				•	•	•		
WNGU130604FR-P	Non-Ferrous	0.015 R	0.086	0.360	0.514	0.265	6	Right		•						
WNGU130608FR-P	Non-Ferrous	0.031 R	0.078	0.360	0.514	0.265	6	Right		•						

DIPOSTRIO™ 13 HARDWARE

	 Insert Screw	 Driver Handle	 Driver Blade	 Retention Bolt	 **OPTIONAL** Coolant Bolt	 **OPTIONAL** Torque Driver Handle	 **OPTIONAL** Preset Torque Bit	 **OPTIONAL** Torque Driver Bit
1DJ1P-1202281R01	SM40-100-R0	DS-A00T	DS-T156B			DS-A00-.25-T	DT-35-.25	DS-T15B1
1DJ1P-1204281R01	SM40-100-R0	DS-A00T	DS-T156B			DS-A00-.25-T	DT-35-.25	DS-T15B1
1DJ1P-1502281R01	SM40-100-R0	DS-A00T	DS-T156B			DS-A00-.25-T	DT-35-.25	DS-T15B1
1DJ1P-1504281R01	SM40-100-R0	DS-A00T	DS-T156B			DS-A00-.25-T	DT-35-.25	DS-T15B1
1DJ1P-2002281R01	SM40-100-R0	DS-A00T	DS-T156B			DS-A00-.25-T	DT-35-.25	DS-T15B1
DJ6P050R00	SM40-100-R0	DS-A00T	DS-T156B	DIN912M10X25-12.9		DS-A00-.25-T	DT-35-.25	DS-T15B1
DJ5P050R00	SM40-100-R0	DS-A00T	DS-T156B	DIN912M10X25-12.9		DS-A00-.25-T	DT-35-.25	DS-T15B1
DJ6P063R00	SM40-100-R0	DS-A00T	DS-T156B	DIN912M10X25-12.9		DS-A00-.25-T	DT-35-.25	DS-T15B1
DJ5P063R00	SM40-100-R0	DS-A00T	DS-T156B	DIN912M10X25-12.9		DS-A00-.25-T	DT-35-.25	DS-T15B1
DJ6P080R00	SM40-100-R0	DS-A00T	DS-T156B	DIN912M12X35-12.9		DS-A00-.25-T	DT-35-.25	DS-T15B1
DJ5P080R00	SM40-100-R0	DS-A00T	DS-T156B	DIN912M12X35-12.9		DS-A00-.25-T	DT-35-.25	DS-T15B1
DJ6P100R00	SM40-100-R0	DS-A00T	DS-T156B	DIN912M16X30-12.9		DS-A00-.25-T	DT-35-.25	DS-T15B1
DJ5P100R00	SM40-100-R0	DS-A00T	DS-T156B	DIN912M16X30-12.9		DS-A00-.25-T	DT-35-.25	DS-T15B1
DJ6P125R00	SM40-100-R0	DS-A00T	DS-T156B	DIN912M20X40-12.9		DS-A00-.25-T	DT-35-.25	DS-T15B1
DJ5P125R00	SM40-100-R0	DS-A00T	DS-T156B	DIN912M20X40-12.9		DS-A00-.25-T	DT-35-.25	DS-T15B1
DJ6P160F00	SM40-100-R0	DS-A00T	DS-T156B	DIN912M20X40-12.9		DS-A00-.25-T	DT-35-.25	DS-T15B1
DJ5P160R00	SM40-100-R0	DS-A00T	DS-T156B	DIN912M20X40-12.9		DS-A00-.25-T	DT-35-.25	DS-T15B1
DJ5P-20R01	SM40-100-R0	DS-A00T	DS-T156B	SD-06-46	SD-06-89	DS-A00-.25-T	DT-35-.25	DS-T15B1
DJ6P-20R01	SM40-100-R0	DS-A00T	DS-T156B	SD-06-46	SD-06-89	DS-A00-.25-T	DT-35-.25	DS-T15B1
DJ5P-25R01	SM40-100-R0	DS-A00T	DS-T156B	SD-06-46	SD-06-89	DS-A00-.25-T	DT-35-.25	DS-T15B1
DJ5P-30R01	SM40-100-R0	DS-A00T	DS-T156B	SD-08-46	SD-08-92	DS-A00-.25-T	DT-35-.25	DS-T15B1
DJ5P-30R02	SM40-100-R0	DS-A00T	DS-T156B	SD-08-46	SD-08-92	DS-A00-.25-T	DT-35-.25	DS-T15B1
DJ5P-40R01	SM40-100-R0	DS-A00T	DS-T156B	SD-12-82	SD-12-99	DS-A00-.25-T	DT-35-.25	DS-T15B1
DJ5P-40R02	SM40-100-R0	DS-A00T	DS-T156B	SD-12-82	SD-12-99	DS-A00-.25-T	DT-35-.25	DS-T15B1
DJ5P-50R10	SM40-100-R0	DS-A00T	DS-T156B	SD-12-82	SD-12-99	DS-A00-.25-T	DT-35-.25	DS-T15B1
DJ5P-60R01	SM40-100-R0	DS-A00T	DS-T156B	SD-12-82	SD-12-99	DS-A00-.25-T	DT-35-.25	DS-T15B1
DJ6P-60R01	SM40-100-R0	DS-A00T	DS-T156B	SD-12-82	SD-12-99	DS-A00-.25-T	DT-35-.25	DS-T15B1

DIPOSTRIO™ 04 OPERATING GUIDELINES

Chip Thinning



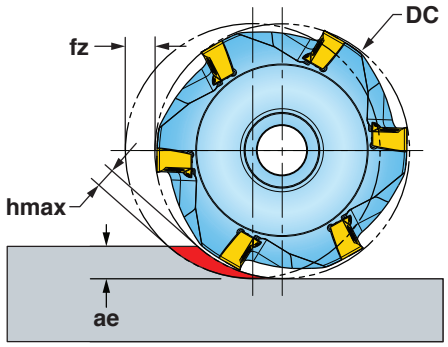
* When ae is less than 25% DC, recommend use of Chip Thinning Calculator to ensure hmax falls within fz range.

Materials				Vc Cutting Speed SFM	fz* Feed/Tooth (inch)	Harder <----------> Tougher						Coolant
ISO	Mat'l Group #VDI 3323	Type	Examples			IN2504	IN10K	IN2505	IN4030 IN2530	IN2035 IN6535	IN6537	
P	1 - 5	Non-alloy Steel	1018, A36, 1045, A572, 1070	400-1000	.003-.005	4		3	2		1	No
	6 - 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 - 13	Stainless Steel (Ferritic & Martensitic)	410, 416, 440	350-600	.003-.005			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 - 16	Gray Cast Iron	CLS. 20, 30, 45	500-1000	.003-.006	1		2	3		4	No
	17 - 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 - 35	High-Temp Alloys	Inconel, Hastelloy, Nimonic, Monel	65-150	.003-.005			2	3	1		Yes
	36 - 37	Titanium Alloys	6Al-4V, 5Al-5Mo-5V-3Cr	85-200				3	2	1		
H	38 - 39	Hardened Steel >48	A2, O1, D2	130-250	.003-.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.

DIPOSTRIO™ 06 OPERATING GUIDELINES

Chip Thinning



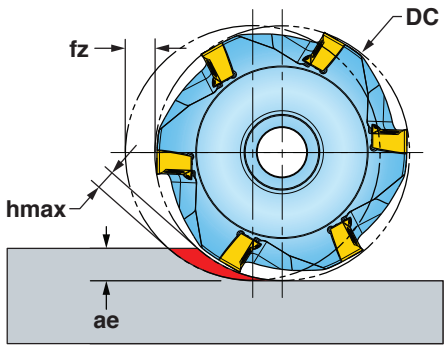
* When ae is less than 25% DC, recommend use of Chip Thinning Calculator to ensure hmax falls within fz range.

Materials				Vc Cutting Speed SFM	fz* Feed/Tooth (inch)	Harder <----------> Tougher						Coolant
ISO	Mat'l Group #VDI 3323	Type	Examples			IN2504	IN10K	IN2505	IN4030 IN2530	IN6535 IN2035	IN6537	
P	1 - 5	Non-alloy Steel	1018, A36, 1045, A572, 1070	400-1000	.003-.008	4		3	2		1	No
	6 - 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 - 13	Stainless Steel (Ferritic & Martensitic)	410, 416, 440	350-600	.003-.007			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 - 16	Gray Cast Iron	CLS. 20, 30, 45	500-1000	.003-.008	1		2	3		4	No
	17 - 20	Nodular Cast Iron	60-40-18, 100-70-03	400-800								
N	21 - 30	Aluminum	7075, 6061	1000-3000	.003-.008		1					Yes
S	31 - 35	High-Temp Alloys	Inconel, Hastelloy, Nimonic, Monel	65-150	.003-.006			2	3	1		Yes
	36 - 37	Titanium Alloys	6Al-4V, 5Al-5Mo-5V-3Cr	85-200				3	2	1		
H	38 - 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.

DIPOSTRIO™ 09 OPERATING GUIDELINES

Chip Thinning



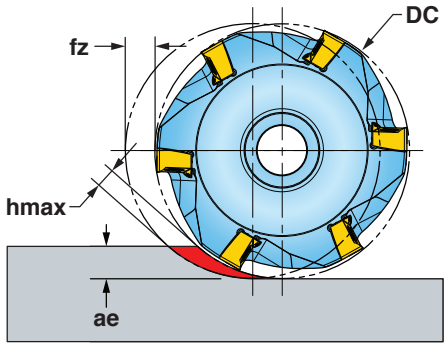
* When ae is less than 25% DC, recommend use of Chip Thinning Calculator to ensure hmax falls within fz range.

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	IN2530	IN6537	
P	1 - 5	Non-alloy Steel	1018, A36, 1045, A572, 1070	400-1000	.003-.008	5	4			3	2	1	No
	6 - 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 - 13	Stainless Steel (Ferritic & Martensitic)	410, 416, 440	350-600	.003-.007		4			2	1	3	Yes
	14	Stainless Steel (Austenitic)	303, 304, 316, 15-5, 17-4	300-550									May not be required at high speeds
K	15 - 16	Gray Cast Iron	CLS. 20, 30, 45	500-1000	.003-.008	1			2	3		4	No
	17 - 20	Nodular Cast Iron	60-40-18, 100-70-03	400-800									
N	21 - 30	Aluminum	7075, 6061	1000-3000	.003-.008			1					Yes
S	31 - 35	High-Temp Alloys	Inconel, Hastelloy, Nimonic, Monel	65-150	.003-.006					1	2		Yes
	36 - 37	Titanium Alloys	6Al-4V, 5Al-5Mo-5V-3Cr	85-200						2	1		
H	38 - 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.

DIPOSTRIO™ 13 OPERATING GUIDELINES

Chip Thinning



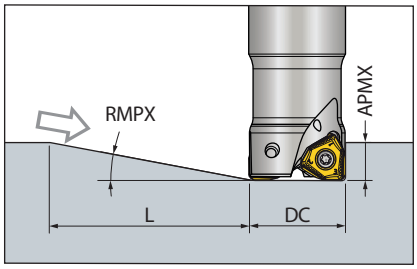
* When ae is less than 25% DC, recommend use of Chip Thinning Calculator to ensure hmax falls within fz range.

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	IN2530	IN6537	
P	1 - 5	Non-alloy Steel	1018, A36, 1045, A572, 1070	400-1000	.003-.010	5	4			3	2	1	No
	6 - 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 - 13	Stainless Steel (Ferritic & Martensitic)	410, 416, 440	350-600	.003-.008		4			2	1	3	Yes
	14	Stainless Steel (Austenitic)	303, 304, 316, 15-5, 17-4	300-550									May not be required at high speeds
K	15 - 16	Gray Cast Iron	CLS. 20, 30, 45	500-1000	.003-.010	1			2	3		4	No
	17 - 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 - 35	High-Temp Alloys	Inconel, Hastelloy, Nimonic, Monel	65-150	.003-.006					1	2		Yes
	36 - 37	Titanium Alloys	6Al-4V, 5Al-5Mo-5V-3Cr	85-200						2	1		
H	38 - 39	Hardened Steel >48	A2, O1, D2	130-250	.003-.005	1				2			No

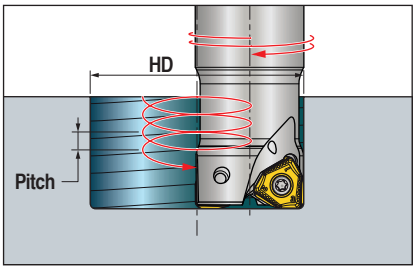
Note: Feed and speed recommendations are starting operating parameters. They are only guidelines from which further optimization should take place. Operating parameters are influenced by many machining variables. These variables may cause for reductions in feeds and speed or dramatic increases. Additionally, DOC and WOC may need to be revised to optimize the tools performance.

DIPOSTRIO™ 04 RAMPING DATA

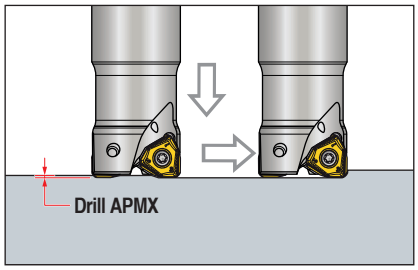
Straight Ramping



Helical Ramping



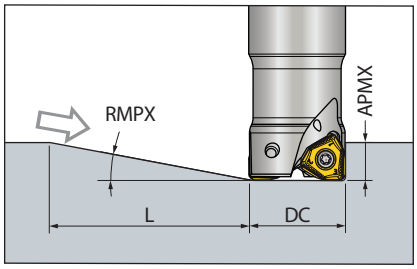
Drill Mill



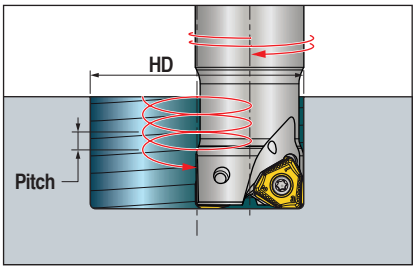
DC Cutter Diameter	Straight Ramp			Helical Ramp			Drill Mill
	RMPX Ramp Angle Max.	APMX Depth of Cut Max.	L Ramp Length Min.	HD Hole Dia. Min.	HD Hole Dia. Max.	Pitch Max.	Drill APMX Depth of Cut Max.
16	3.0	5.80	110.7	24.10		1.300	0.50
					31.20	2.500	
20	2.4	5.80	138.4	31.70		1.500	0.50
					39.20	2.500	
25	1.9	5.80	174.8	41.40		1.700	0.60
					49.20	2.500	
32	1.5	5.80	221.5	55.20		1.900	0.60
					63.20	2.600	
35	1.7	5.80	195.4	60.50		2.400	0.80
					69.20	3.200	
40	2.1	5.80	158.2	69.30		3.400	1.20
					79.20	3.800	
50	2.5	5.80	132.8	87.20		3.800	1.90
					99.20	3.800	
63	2.4	5.80	138.4	111.5		3.8	2.30
					125.2	3.8	

DIPOSTRIO™ 06 RAMPING DATA

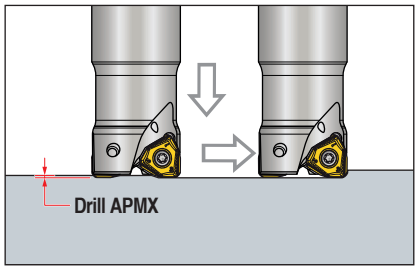
Straight Ramping



Helical Ramping



Drill Mill



DC Cutter Diameter	Straight Ramp			Helical Ramp			Drill Mill
	RMPX Ramp Angle Max.	APMX Depth of Cut Max.	L Ramp Length Min.	HD Hole Dia. Min.	HD Hole Dia. Max.	Pitch Max.	Drill APMX Depth of Cut Max.
1.000	2.7	0.23	4.8	1.54		0.079	0.035
					2.00	0.148	
1.250	2.0	0.23	6.5	2.04		0.086	0.035
					2.50	0.136	
1.500	1.6	0.23	8.2	2.54		0.090	0.034
					3.00	0.131	
2.000	1.4	0.23	9.4	3.48		0.113	0.044
					4.00	0.153	
2.500	1.8	0.23	7.3	4.40		0.188	0.068
					5.00	0.230	
3.000	2.1	0.23	6.2	5.30		0.230	0.100
					6.00	0.230	
4.000	2.2	0.23	5.9	7.15		0.230	0.137
					8.00	0.230	
5.000	1.3	0.23	10.1	9.09		0.230	0.110
					10.00	0.230	