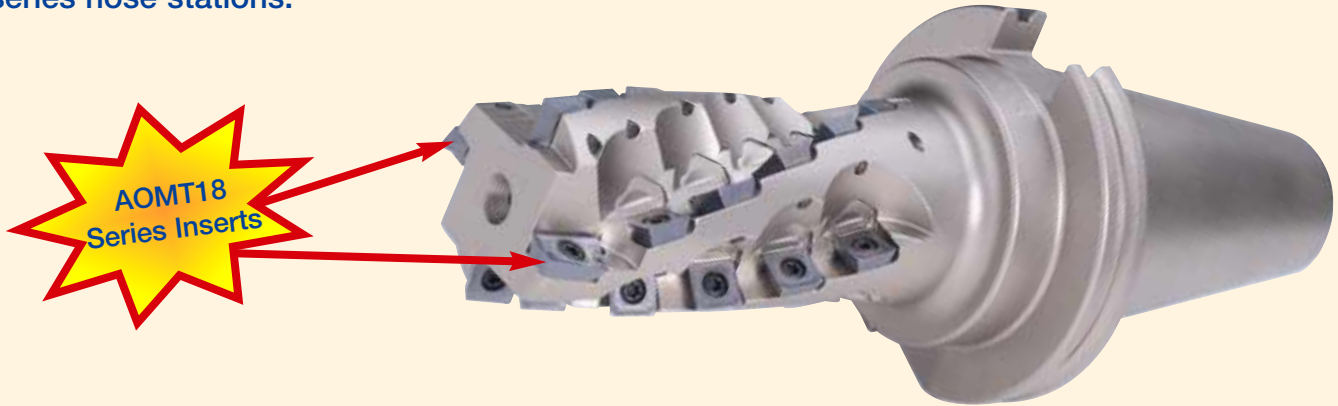


POWER•QUAD™

HEAVY-DUTY FLUTED END MILL INSERTS

Ideal for roughing applications, the Power•Quad 23J6G cutter series has been upgraded from the Hi•Pos APKT16 series nose stations to the more robust and free cutting Hi•Pos+ AOMT18 series nose stations.



AOMT18 VS. APKT16 INSERTS

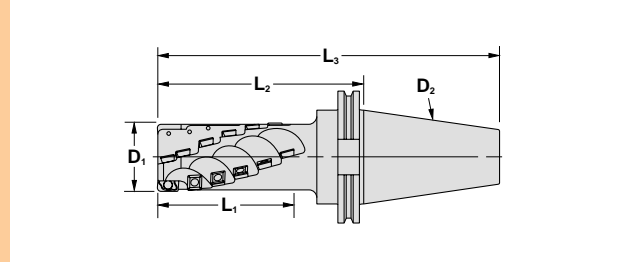


POWERQUAD™ 0° HEAVY-DUTY FLUTED END MILL SERIES 23J6G

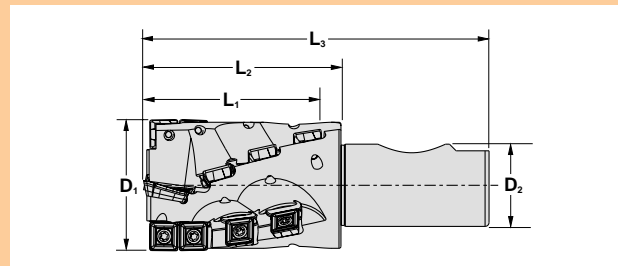
Diameters
1.500" to 2.000"

Max. Depth of Cut
2.32" to 6.12"

Insert Corner
.031", .062", .093",
and .125"R



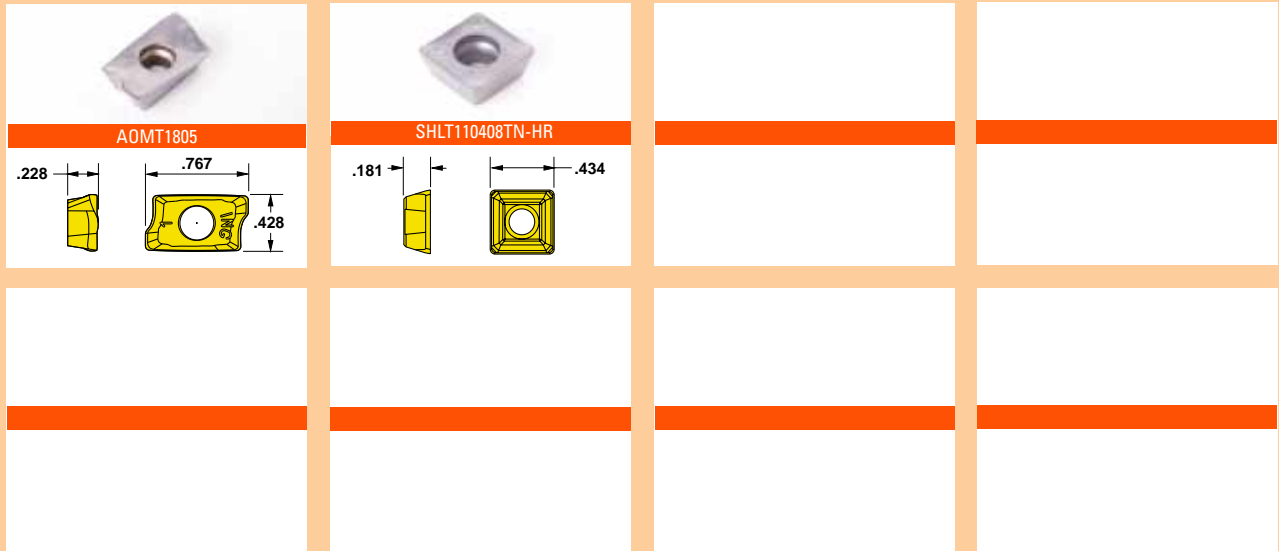
D ₁ Nominal Dia.	Cutter Number	L ₁ Max. Depth of Cut	L ₂ Exten.	L ₃ Overall Length	D ₂ Shank Size/Style	No. of Flutes Effective	No. of Flutes Total	No. of Inserts End	No. of Inserts Side	Weight with Carbide
NEW 1.500	23J6G-1502881R00	2.350	2.875	5.125	1.250 Weldon	2	4	2	12	1.6 lb.
NEW 2.000	23J6G-2005052R00	4.390	5.000	8.250	2.000 Wel/Put	2	4	2	24	5.6 lb.
NEW 2.000	23J6G-2006145R00	4.040	6.125	11.125	50 NMTB	2	4	2	22	10.1 lb.
NEW 2.000	23J6G-2006148R00	4.040	6.125	10.125	50 V-Flange	2	4	2	22	9.5 lb.
NEW 2.000	23J6G-2008048R00	6.100	8.000	12.00	50 V-Flange	2	4	2	34	10.3 lb.



D ₁ Nominal Dia.	Cutter Number	L ₁ Max. Depth of Cut	L ₂ Exten.	L ₃ Overall Length	D ₂ Shank Size/Style	No. of Flutes Effective	No. of Flutes Total	No. of Inserts End	No. of Inserts Side	Weight with Carbide
NEW 2.000	23J6G-2003081R00	2.670	3.000	5.250	1.250 Mod. Weldon*	2	4	2	14	2.5 lb.

*Specially engineered weldon style shank draws cutter into the face of the holder for increased rigidity.

INSERTS



Insert Number	Application	Corner	Grades								
			IN	30M	40P	2005	2030	2015	2040	1030	6530
NEW AOMT180508R	Multi-Purpose	.031R				■	■	■	■	■	
NEW AOMT180516R	Multi-Purpose	.062R				■	■	■	■	■	
NEW AOMT180524R	Multi-Purpose	.093R				■			■	■	
NEW AOMT180532R	Multi-Purpose	.125R				■	■	■	■	■	
NEW AOMT180548R	Multi-Purpose	.187R				■					
NEW AOMT180564R	Multi-Purpose	.250R				■			■	■	
SHLT110408TN-HR	Multi-purpose	.031R		■	■	■				■	■

HARDWARE

Insert Screw		Driver	
Part No.	Torque	Part No.	
SM40-093-20	30-35 in. lbs.	DS-T15T (Tx-15)	

Series 25J, 23J, 23S, 23W					Grades*										Coolant	
Material	Brinell Hardness	SFM	Feed per Insert	Side*					End*†							
				IN30M	IN40P	IN6530	IN2005	IN1030	IN2005	IN1030	IN2015	IN2030	IN2040			
Aluminum	6061-T6, 7075 T-6	-	1000-3000	.003-.006	1			2	3		1	2			Yes	
Cast Iron	Gray	150-250	250-400	.003-.006			1	2	3			2	1		No	
	Nodular		200-350													
Steel	Low Carbon 1018-8620	150-250	250-500	.003-.006		3		2	1						No	
	High Carbon F-6180, Nitr alloy 52100	250-400	200-350	.003-.006		3		2	1							
	Alloyed Steel 4140, 4340, 6150	150-300	250-400	.003-.006		3		2	1		3	1		4		2
	Tool Steel A-6, D-1, D-2, P-20	Up to 300 300 to 500	250-400 150-250						1							
Stainless Steel	300 Series, 304, 316	-	250-400	.003-.006											May not be required at high speeds	
	400 Series 15-5 PH, 17-4 PH	Up to 320	300-600		4		2	3	1		2	3		1		
	13-8 PH	-	200-250													Yes
Nickel Alloys	Inconel 600, 706, 718, 903, Hastelloy, Waspalloy	-	75-120	.003-.006	3			2	1		2	3		1	Yes	
Titanium	6AL-4V	-	100-150	.003-.006	3			1	2		1	3		2	Yes	

*In order of preference.

†For Series 23J6G and 23S2G only.