

HI•POSQUAD™

SDMT120608FR- FOR HI-TEMP ALLOYS/TITANIUM

Ingersoll Cutting Tools announces the addition of a new insert to the 5J1H series Hi•PosQuad line for applications in Hi-temp alloys and titanium.

Equipped with a true helical cutting edge (similar to Hi•Pos), this Quad insert also has increased positive rake face geometry - Stocked in grades IN2030 and IN2005.

NEW



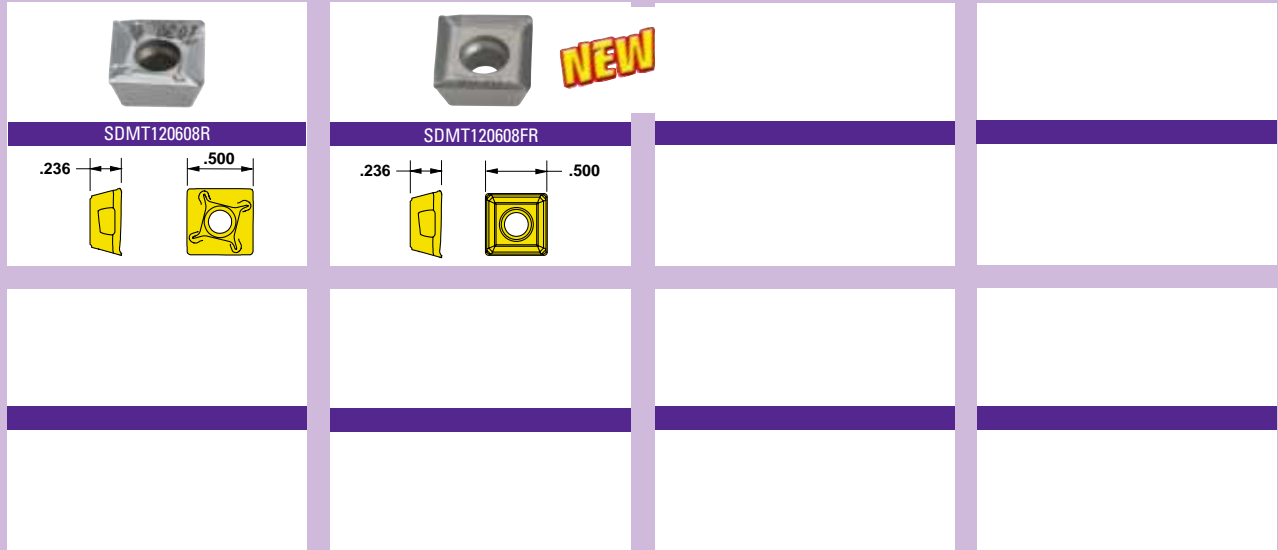
SDMT120608FR
GEOMETRY FOR HI-TEMP/TITANIUM



SDMT120608R
MULTI-PURPOSE GEOMETRY



INSERTS



| Insert Number | Geometry | Application | Corner | Grades | | | | |
|-------------------------|-------------------|--------------------|--------|--------|------|------|------|------|
| | | | | IN | 2005 | 1030 | 5015 | 2030 |
| SDMT120608R | Positive/Positive | Multi-purpose | .031R | | ■ | ■ | ■ | |
| NEW SDMT120608FR | Hi-Positive | Hi-temp / Titanium | .031R | | ■ | | | ■ |
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HARDWARE

| Insert Screw | | Driver | |
|--------------|----------------|--------------------|--|
| Part No. | Torque | Part No. | |
| SM40-120-20 | 30-35 in. lbs. | DS-T15T (Tx-15) | |

| Series 5J1H | | Brinell Hardness | SFM | Feed per Insert | Grades* | | | | Coolant |
|-----------------|--|------------------|-----------|-----------------|---------|--------|--------|--------|------------------------------------|
| Material | | | | | IN2005 | IN1030 | IN5015 | IN2030 | |
| Aluminum | 6061 T-6, 7075 T-6, 2024 | - | 1500-3000 | .003-.008 | 1 | 2 | | | Yes |
| Cast Iron | Gray | 150-250 | 300-1000 | .003-.008 | 2 | 3 | 1 | | No |
| | Nodular | | 300-600 | | | | | | |
| Steel | Low Carbon 1018, 8620 | 100-250 | 400-1000 | .003-.008 | 2 | 1 | | 3 | No |
| | High Carbon F-6180, Nitalloy 52100 | 250-400 | 350-500 | .003-.006 | | | | | |
| | Alloyed Steel 4140, 4340, 6150 | 150-300 | 300-700 | .003-.007 | | | | | |
| | Tool Steel A-6, D-1, D-2, P-20 | Up to 300 | | | | | | | |
| Stainless Steel | 300 Series, 304, 316 | - | 300-700 | .003-.006 | 3 | 1 | | 2 | May not be required at high speeds |
| | 400 Series 15-5 PH, 17-4 PH | Up to 320 | 400-900 | | | | | | |
| | 13-8 PH | - | 200-400 | | | | | | |
| Nickel Alloys | Inconel 600, 706, 718, 903, Hastelloy, Waspalloy | - | 75-120 | .003-.006 | 2 | | | 1 | Yes |
| Titanium | 6AL-4V | - | 100-150 | .003-.006 | 1 | | | 2 | Yes |

*In order of preference.