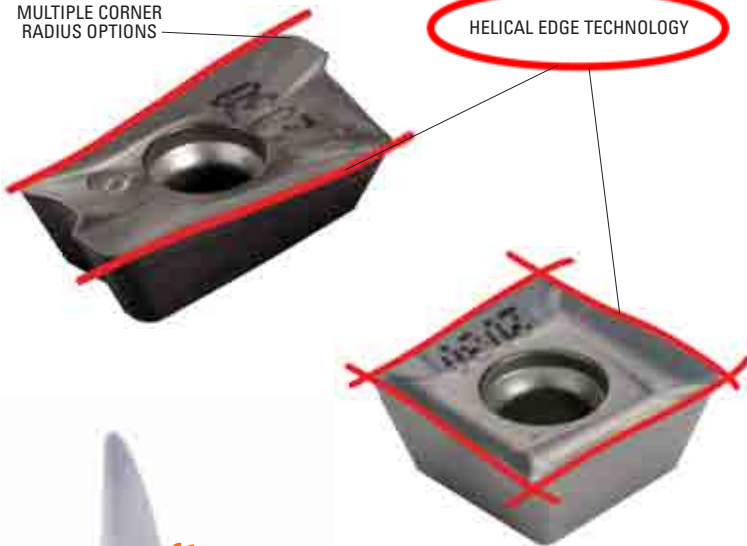


## HIPOSQUAD™

Ingersoll introduces the 25J3H series of All Effective Extended Flute Mills. Equipped with the 18 mm HiPOS+ on the nose for corner radius options and the BEEFY 12 mm HiPOSquad up the side for 4 edged shearing economy, it stands apart from the competition with helical edge technology placed on ALL cutting edges for productivity benefits.

MULTIPLE CORNER RADIUS OPTIONS

HELICAL EDGE TECHNOLOGY



EXTENDED FLUTE END MILL



EXTENDED FLUTE SHELL MILL

**"BIG, LONG AND TOOTHY"**

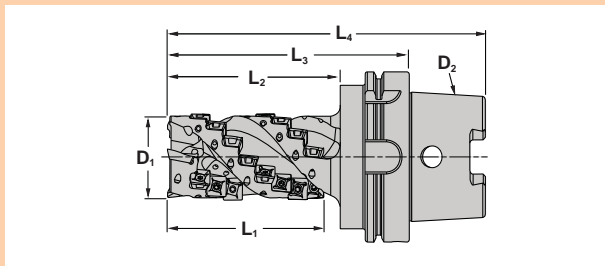


### FEATURES AND BENEFITS

- Helical edge technology for clean shearing metal cutting action
- 4 edged side insert offers an economical advantage over it's 2 edged brothers
- .015, .031, .062, .093 & .125 corner radius options
- Shares the same SDMT12 inserts as found on our 5J1H series Face Mills
- Two Insert geometry choices: MultiPurpose for Steel & Iron and Hi Temp geometry
- HSK, Cat, BT, InnoFit, Weldon and Shell Mill adaption offerings on the shelf
- Coolant through the tool for use on Stainless Steel and Hi Temp Alloy materials
- Optional coolant through retention bolts on the shelf

**HI-POSQUAD™ EXTENDED FLUTE END MILL SERIES 25J3H**

**Diameters** 2.000" to 3.000"  
**Max Dept of Cut** 2.33"-4.01"  
**Insert Corner** 0.015", 0.031", 0.062", 0.093", 0.125"

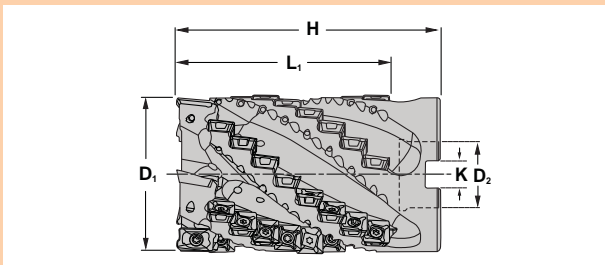


Part Number	D <sub>1</sub> Effective Diameter	L <sub>1</sub> Length of Cut	L <sub>2</sub> Projection Length	L <sub>3</sub> Extension Length	L <sub>4</sub> Overall Length	D <sub>2</sub> Shank Size Style	Number Effective Flutes	Number Inserts End	Number Inserts Side
25J3H-2006048R01	2.000	4.01	4.63	6.00	10.000	Cat 50	3	3	24
25J3H-20060B5R01	2.000	4.01	5.50	6.00	10.008	BT 50	3	3	24
25J3H-2002781R01	2.000	2.33	-	2.75	5.000	1.250 Mod. Weldon *	3	3	12
25J3H-20042Z4R01	2.000	3.59	-	4.25	5.620	Z4 InnoFit	3	3	21
25J3H-20062H1R01	2.000	4.01	4.72	6.00	8.214	HSK100	3	3	24
25J3H-30062H1R01	3.000	4.01	4.72	6.00	8.214	HSK100	4	4	32

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

**HI-POSQUAD™ EXTENDED FLUTE SHELL MILL SERIES 25J3H**

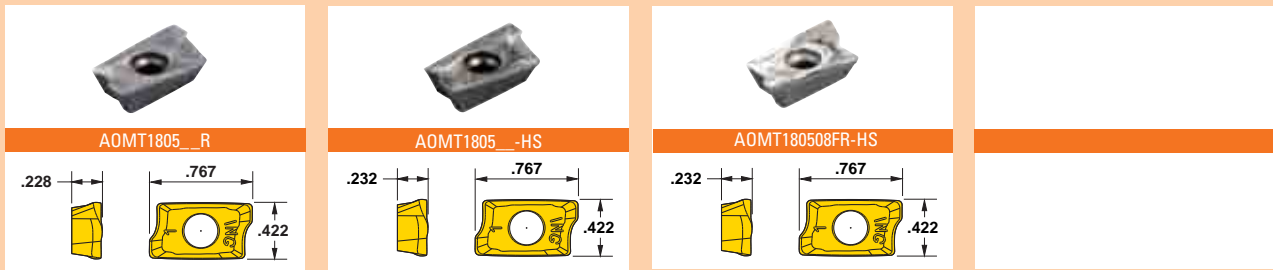
**Diameters** 2.000" to 3.000"  
**Max Dept of Cut** 2.33"-4.01"  
**Insert Corner** 0.015", 0.031", 0.062", 0.093", 0.125"



Part Number	D <sub>1</sub> Effective Diameter	L <sub>1</sub> Length of Cut	H Height	D <sub>2</sub> Bora Dia	Number Keyway Width	Number Effective Flutes	Number Inserts End	Number Inserts Side	Optional Ret Bolt	Coolant* thru Ret Bolt
25J3H-25040D3R01	2.500	3.17	4.00	1.00	0.375	4	4	24	SD08-81	SD-08-C5
25J3H-30050D4R01	3.000	4.01	5.00	1.25	0.500	4	4	32	SD10-A2	SD-10-A8
25J3H-30050D4R11	3.000	4.01	5.00	1.25	0.500	5	5	40	SD10-A2	SD-10-A8
25J3H-40047D5R01	4.000	4.01	4.75	1.50	0.625	5	5	40	SD12-54	SD-12-B1

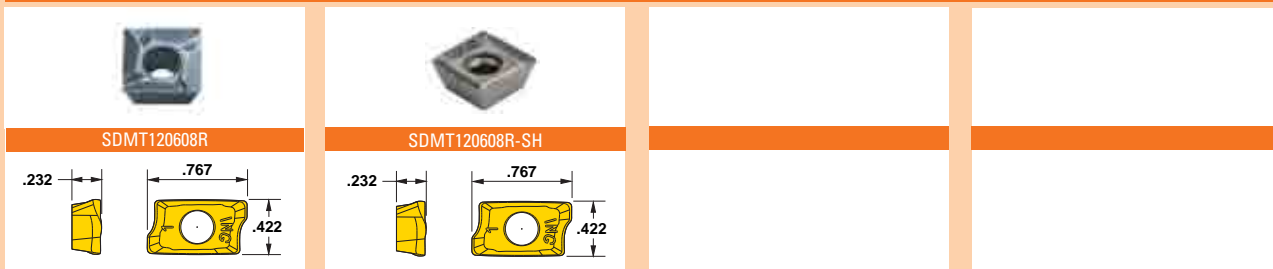
\* Order separately

## END INSERTS



Insert Number	Application	Corner	Grades					
			IN	30M	2005	2030	2015	2040
<b>END INSERTS</b>								
AOMT180504R-HS	Hi-Temp/Titanium	.015R				■		
AOMT180508R-HS	Hi-Temp/Titanium	.031R		■	■	■		
AOMT180516R-HS	Hi-Temp/Titanium	.062R		■	■	■		
AOMT180508R	Multi-Purpose	.031R			■	■	■	■
AOMT180516R	Multi-Purpose	.062R			■	■	■	■
AOMT180524R	Multi-Purpose	.093R			■			■
AOMT180532R	Multi-Purpose	.125R			■	■	■	■

## SIDE INSERTS



Insert Number	Application	Corner	Grades			
			IN	2005	1030	5015
<b>SIDE INSERTS</b>						
SDMT120608R	Multi-Purpose	.031R		■	■	■
SDMT120608R-HS	HiTemp/Titanium	.031R		■		■

## HARDWARE

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

Series 25J3H					Grades							Coolant
Material	Brinell Hardness	SFM	Feed per Insert	30M	IN2005	IN1030	IN2015	IN2030	IN2040	IN5015		
Aluminum	6061-T6, 7075-T6, 2024	-	1500-3000	.003-.008	1	2					Yes	
Cast Iron	Gray	150-250	300-1000	.003-.008	2	3	1*	3	1		No	
	Nodular		300-600									
Steel	Low Carbon 1018, 8620	100-250	400-1000	.003-.008			1	1*	2		No	
	High Carbon F-6180, Nitralloy 52100	250-400	350-500	.003-.006								
	Alloyed Steel 4140, 4340, 6150	150-300	300-700	.003-.007	2	1		1*	3			
	Tool Steel A-6, D-1, D-2, P-20											Up to 300
Stainless Steel	300 Series, 304, 316	-	300-700	.003-.006	2	1		1*			May not be required at high speeds	
	400 Series, 15-5 PH, 17-4 PH	-	400-900								Yes	
	13-8 PH	-	200-400								Yes	
Nickel Alloys	Inconel 600, 706, 718, 903, Hastelloy, Waspalloy	-	75-120	.003-.006	1	2		2*			Yes	
Titanium	6AL-4V	-	100-150	.003-.006	1	2		2*			Yes	

\*Preferred for higher SFM.



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