

ISO PLUS 90

TWO SIDED TECHNOLOGY IS INCORPORATED INTO ISO TRIANGLE INSERTS FOR AN INGERSOLL EXCLUSIVE PRODUCT NAMED ISO PLUS. USERS BENEFIT BY DOUBLING THEIR CUTTING EDGES FROM 3 TO 6 WHILE ALSO TAKING ADVANTAGE OF CLEAN SHEARING PRESSED RAKE FACE PERFORMANCE.



FEATURES AND BENEFITS

- TWO SIDED INSERT ADDS VALUE BY DOUBLING THE NUMBER OF 90 DEGREE CUTTING EDGES (3+3)
- THICK, ROBUST AND HEAVY DUTY INSERT ADDS DURABILITY TO DEMANDING CUTTING CONDITIONS
- POSITIVE RAKE FACE GEOMETRY BENEFITS MACHINING EFFICIENCY
- STRONG CORNER CONFIGURATION FOR HEAVY DUTY ROUGHING
- .085 WIPER FLAT FOR GOOD SURFACE FINISHES
- COOLANT THROUGH THE TOOL OFFERED
- .590 DEPTH OF CUT CAPABILITY



ISOPLUS 90° FACE MILL SERIES DJ5H/DJ6H

Diameters 2.500"-6.000"
Cutting Edge Length .590"
Insert Corner R.093



Shoulder



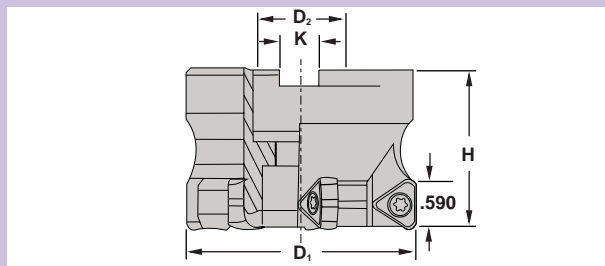
Channeling



Facing



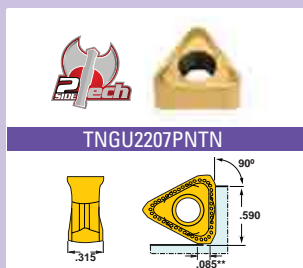
Coolant



Cutter Number	D ₁ Nominal Diameter	D ₂ Bore Size	K Keyway	H Height	Number of Inserts	SHCS	SHCS w/ Coolant thru*
Low Density							
DJ6H-25R01	2.500	1.00	0.37	2.375	3	SD-08-46	SD-08-92
DJ6H-30R01	3.000	1.00	0.37	2.375	4	SD-08-46	SD-08-92
DJ6H-40R01	4.000	1.50	0.62	2.375	5	-	-
DJ6H-60R01	6.000	1.50	0.62	2.375	8	-	-
Medium Density							
DJ5H-25R01	2.500	1.00	0.37	2.375	4	SD-08-46	SD-08-92
DJ5H-30R01	3.000	1.00	0.37	2.375	6	SD-08-46	SD-08-92
DJ5H-40R01	4.000	1.50	0.62	2.375	7	-	-
DJ5H-60R01	6.000	1.50	0.62	2.375	10	-	-

*Order Separately

INSERTS



TNGU2207PNTN

Insert Number	Application	Grades			
		IN	2010	2030	2505
TNGU2207PNTN	Multi-Purpose	■	■	■	

**Faceted corner simulates R.093

HARDWARE

Insert Screw		Driver		Preset Torque Driver		Torx Bit	
Part No.	Torque	Part No.	Part No.	Part No.	Part No.	Part No.	Part No.
SM45-120-R0	40 in. lbs.	DS-T20T	DT-40-01	DT-40-01	DT-40-01	DS-T20B1	DS-T20B1

Series DJ5H/DJ6H					Grades			Coolant
Material	Brinell Hardness	SFM	Feed per Insert	INV2015	INV2030	INV2505		
Aluminum	7075 - T6, 6061 - T6, 2024	-	1500-10000	.004-.020	1		Yes	
Cast Iron	Gray	150-250	300-1000	.0064-.018	1	2	No	
	Nodular		300-600	.006-.018	1	2	No	
Steel	Low Carbon 1018, 8620	100-250	400-1000	.006-.018	1	2	No	
	High Carbon F-6180	250-400	350-500	.006-.015			No	
	Alloyed Steel 4140, 4340	150-300	300-800	.006-.018			No	
	Tool Steel A-6, D-1, D-2	Up to 300					No	
Stainless Steel	300 Series, 304, 316	-	300-700	.004-.012	1	2	?@ HighSpeed	
	400 Series 15-5 PH	Up to 320	350-700				?@ HighSpeed	
	13-8 PH	-	200-400				Yes	
Nickel Alloys	Inconel, Hastelloy, Waspalloy	-	75-120	.003-.006	2	1	Yes	
Titanium	6AL-4V	-	100-150	.005-.008	1	2	Yes	



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