

HIPOPOSQUAD™ 90° LEAD TOPON END MILL SERIES 15J1C

Diameters
.500" to 1.250"

Max. Depth of Cut
.178"

Insert Corner
.015"R



Shoulder



Channeling



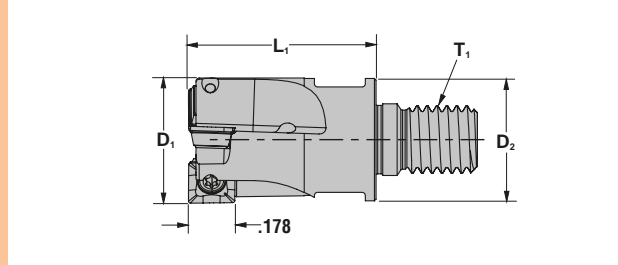
Facing



Ramping



Coolant Thru



D ₁ Nominal Diameter	Cutter Number	L ₁ Extension Length	D ₂ Neck Diameter	T ₁ Shank Size/Style	Number of Inserts	Wrench Size	Max Ramp Angle
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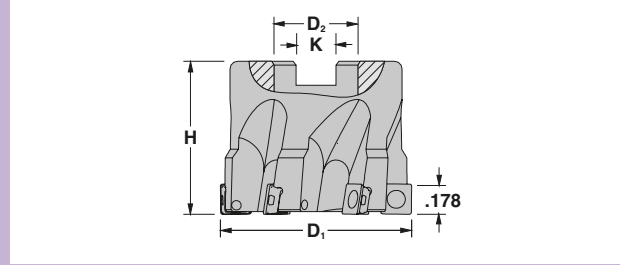
.500	15J1C-05010X4R01	1.00	0.46	M6	2	7mm	.5
.625	15J1C-06010X5R01	1.00	0.51	M8	3	10mm	.5
.750	15J1C-07015X6R01	1.50	0.71	M10	3	15mm	3
.750	15J1C-07015X6R02	1.50	0.71	M10	4	15mm	3
1.000	15J1C-10015X7R01	1.50	0.82	M12	5	17mm	2
1.250	15J1C-12017X8R01	1.75	1.14	M16	6	22mm	1.4

HIPOPOSQUAD™ 90° LEAD FACE MILL SERIES 5J5C

Diameters
1.500" to 2.000"

Max. Depth of Cut
.178"

Insert Corner
.015"R



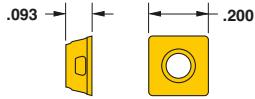
D ₁ Effective Diameter	Cutter Number	Number of Inserts	H Height	D ₂ Bore Diameter	Retention Bolt	K Keyway
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1.500	5J5C-15R01	8	1.57	0.75	SD06-46	0.31
2.000	5J5C-20R01	10	1.57	0.75	SD06-46	0.31

INSERTS



SHMT050204N



Insert
Number

Application

Corner

Grades

IN 2005 2030

SHMT050204N

Multi-Purpose

.015R

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HARDWARE

Insert Screw	Driver	Preset Torque Driver	Torx Bit
Part No.	Part No.	Part No.	Part No.
SM20-043-00	DS-TP06S (TxPlus-06)	DTN005S	DS-TP06TB
Torque			
5 in. lbs.			

OPERATING GUIDELINES

Series 15J1C, 5J5C

Material	Brinell Hardness	SFM	Feed per Insert	Grades		Coolant
				IN2005	IN2030	
Aluminum	6061 T-6, 7075 T-6, 2024	-	1000-8000	.003-.008	1	Yes
Cast Iron	Gray	150-250	500-1200	.002-.004	1 2	No
	Nodular		400-800			
Steel	Low Carbon 1018-8620	150-250	600-1200	.002-.004	2 1	No
	High Carbon F-6180, Nitralloy 52100	250-400	400-600			
	Alloyed Steel 4140, 4340, 6150	150-300	400-800			
	Tool Steel A-6, D-1, D-2, P-20	Up to 300				
Stainless Steel	300 Series, 304, 316	-	400-800	.002-.004	2 1	May not be required at high speeds
	400 Series 15-5 PH, 17-4 PH	Up to 320	500-1000			Yes
	13-8 PH	-	200-400			
Nickel Alloys	Inconel, Hastelloy, Waspalloy	-	75-120	.002-.003	2 1	Yes
Titanium	6AL-4V	-	80-150	.002-.003	1 2	Yes