

# TOP•ON™

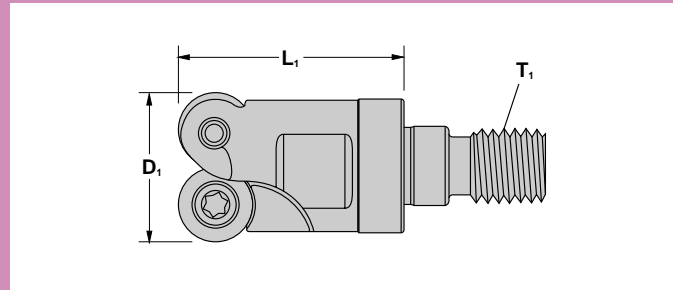
## NEW

## INCH CUTTER BODIES NOW AVAILABLE!!



### FORM•MASTER+ SERIES 15B1 (TOP•ON STYLE)

|                                |  |   |
|--------------------------------|--|---|
| <b>Diameters</b><br>.750-1.500 | <b>Cutting Edge Radius</b><br>4, 5, 6, and 8mm | <b>Button I.C.</b><br>8, 10, 12, and 16mm |
|--------------------------------|--|---|

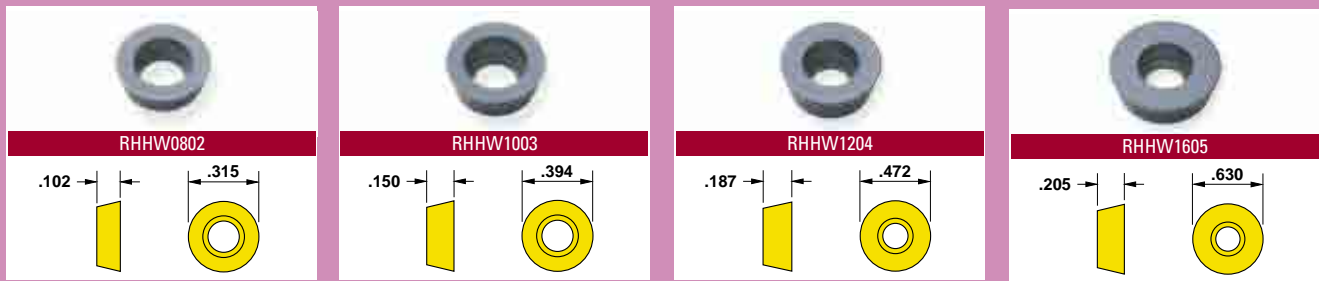


| D <sub>1</sub><br>Nominal<br>Diameter | T <sub>1</sub><br>Adaption | Cutter<br>Number        | Insert<br>Inscribed<br>Circle | L <sub>1</sub><br>Extension<br>from Holder | Number<br>of Inserts | Wrench<br>Size |
|---------------------------------------|----------------------------|-------------------------|-------------------------------|--|----------------------|----------------|
| .750                                  | M10                        | <b>15B1E-07512X6R01</b> | 8mm                           | 1.25                                       | 2                    | 15mm           |
| 1.000                                 | M12                        | <b>15B1H-10015X7R01</b> | 12mm                          | 1.50                                       | 2                    | 17mm           |
| 1.000                                 | M12                        | <b>15B1G-10012X7R01</b> | 10mm                          | 1.25                                       | 3                    | 17mm           |
| 1.250                                 | M16                        | <b>15B1K-12015X8R01</b> | 16mm                          | 1.50                                       | 2                    | 22mm           |
| 1.250                                 | M16                        | <b>15B1H-12015X8R01</b> | 12mm                          | 1.50                                       | 3                    | 22mm           |
| 1.500                                 | M16                        | <b>15B1G-15012X8R01</b> | 10mm                          | 1.25                                       | 5                    | 22mm           |
| 1.500                                 | M16                        | <b>15B1H-15015X8R01</b> | 12mm                          | 1.50                                       | 3                    | 22mm           |

#### Recommended Depth of Cut

| Insert Series | Recommended Depth of Cut |
|---------------|--------------------------|
| RHHW0802      | .010-.040                |
| RHHW1003      | .010-.060                |
| RHHW1204      | .010-.080                |
| RHHW1605      | .010-.100                |

## INSERTS



| Insert Number | Insert Inscribed Circle | Grades |      |      |
|---------------|-------------------------|--------|------|------|
|               |                         | IN     | 2004 | 2015 |
| RHHW0802MOTN  | 8mm                     | ■      | ■    | ■    |
| RHHW1003MOTN  | 10mm                    | ■      | ■    | ■    |
| RHHW1204MOTN  | 12mm                    | ■      | ■    | ■    |
| RHHW1605MOTN  | 16mm                    | ■      | ■    | ■    |

## HARDWARE

| Insert Inscribed Circle | Insert Screw |                | Driver          |  |
|-------------------------|--------------|----------------|-----------------|--|
|                         | Part No.     | Torque         | Part No.        |  |
| 8mm                     | SM30-053-00  | 13-18 in. lbs. | DS-T09W (Tx-09) |  |
| 10mm                    | SM40-080-10  | 30-35 in. lbs. | DS-T15T (Tx-15) |  |
| 12mm                    | SM40-080-10  | 30-35 in. lbs. | DS-T15T (Tx-15) |  |
| 16mm                    | SM50-100-10  | 35-40 in. lbs. | DS-T20T (Tx-20) |  |

## TOP•ON Series 15B (15B)

| Material        | Brinell Hardness                                 | SFM       | Feed per Insert** | Grades*     |              |              |              |              |              | Coolant                            |    |
|-----------------|--|-----------|-------------------|-------------|--------------|--------------|--------------|--------------|--------------|------------------------------------|----|
|                 |  |           |                   | IN40P (235) | IN1530 (581) | IN1540 (588) | IN8330 (708) | IN2030 (831) | IN2040 (835) |                                    |    |
| Aluminum        | 6061 T-6, 7075 T-6                               | -         | 1300-1950         | .030-.047   | 1            | 2            | 3            | 4            | Yes          |                                    |    |
| Cast Iron       | Gray   | 150-250   | 590-720           | .020-.039   | 1            | 2            | 3            |              | No           |                                    |    |
|                 | Nodular  |           | 520-720           |             |              |              |              |              |              |                                    |    |
| Steel           | Low Carbon 1018-8620                             | 100-250   | 490-650           | .020-.039   | 6            | 5            | 4            | 1            | 3            | 2                                  | No |
|                 | High Carbon F-6180, Nitralloy 52100              | 250-400   |                   |             |              |              |              |              |              |                                    |    |
|                 | Alloyed Steel 4140, 4340, 6150                   | 150-300   |                   |             |              |              |              |              |              |                                    |    |
|                 | Tool Steel A-6, D-1, D-2, P-20                   | Up to 300 |                   |             |              |              |              |              |              |                                    |    |
| Stainless Steel | 300 Series, 304, 316                             | -         | 490-590           | .020-.039   | 2            |              | 3            | 1            | 4            | May not be required at high speeds |    |
|                 | 400 Series 15-5 PH, 17-4 PH                      | Up to 320 | 200-600           |             |              |              |              |              |              |                                    |    |
|                 | 13-8 PH  | -         | 300-800           |             |              |              |              |              |              |                                    |    |
| Nickel Alloys   | Inconel 600, 706, 718, 903, Hastelloy, Waspalloy | -         | 75-120            | .010-.015   | 1            | 3            | 4            | 2            | Yes          |                                    |    |
| Titanium        | 6AL-4V   | -         | 100-150           | .010-.015   | 2            | 3            | 1            |              | Yes          |                                    |    |

\*In order of preference. \*\*Chip thinning factor applied to feed recommendation.