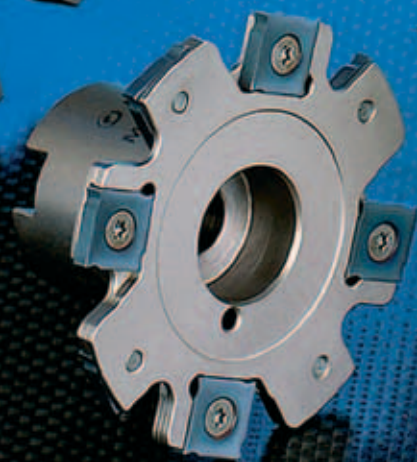
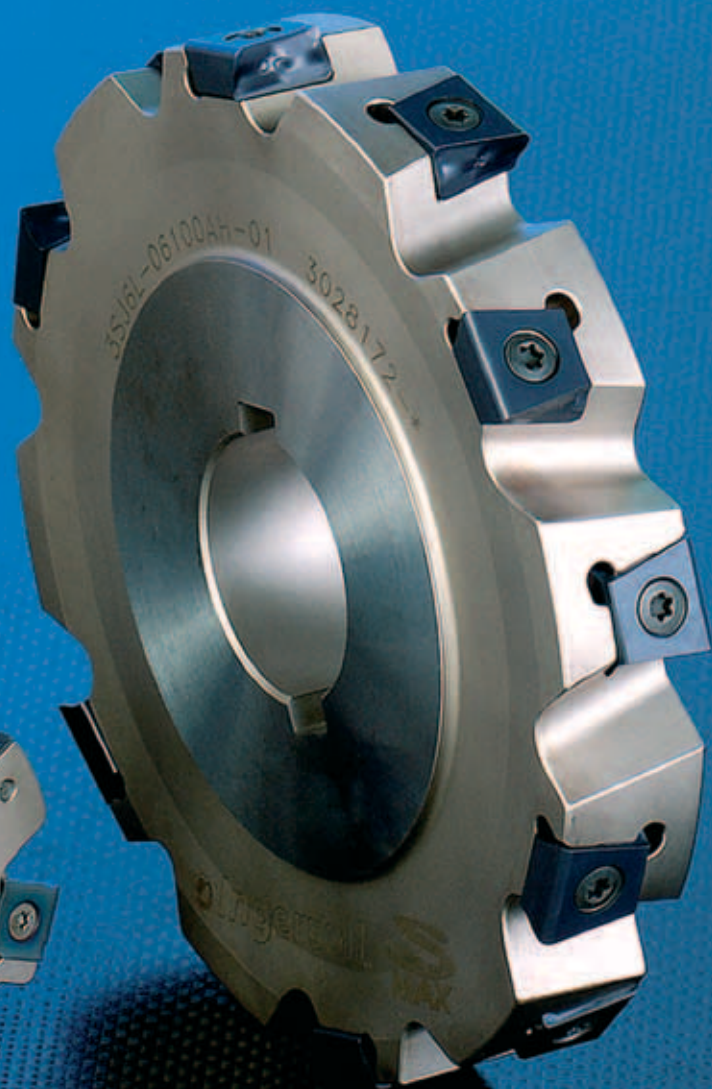
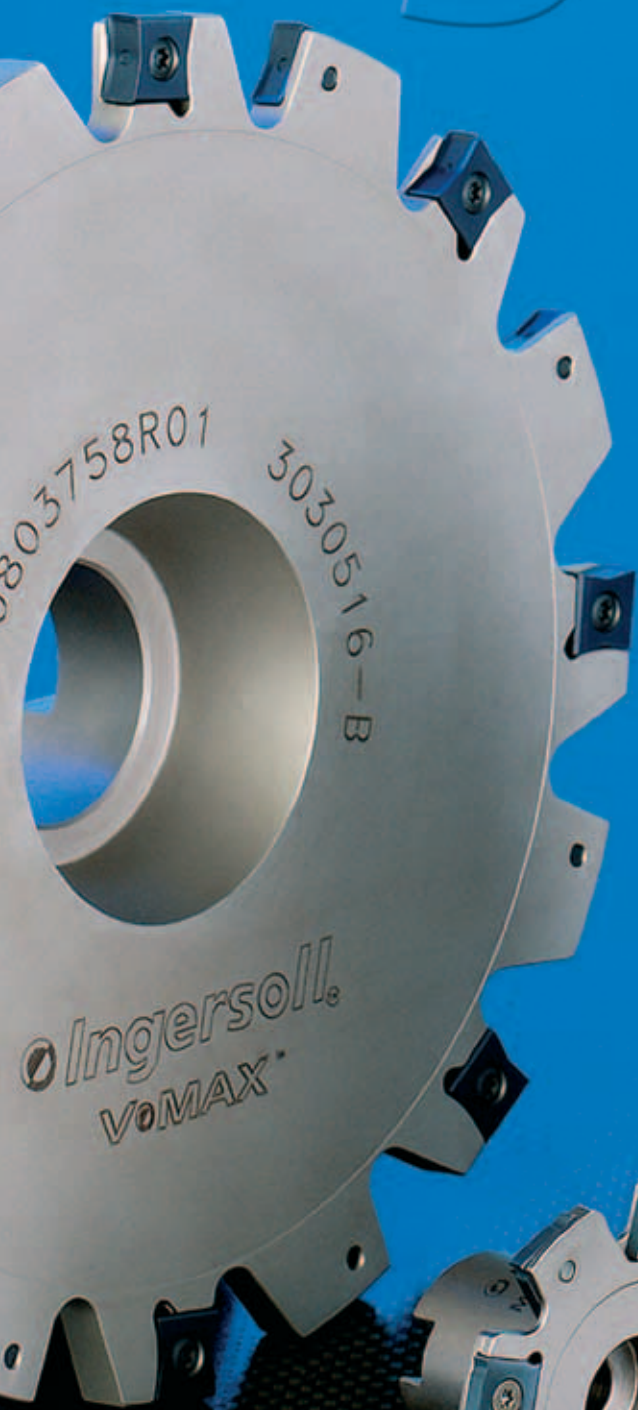


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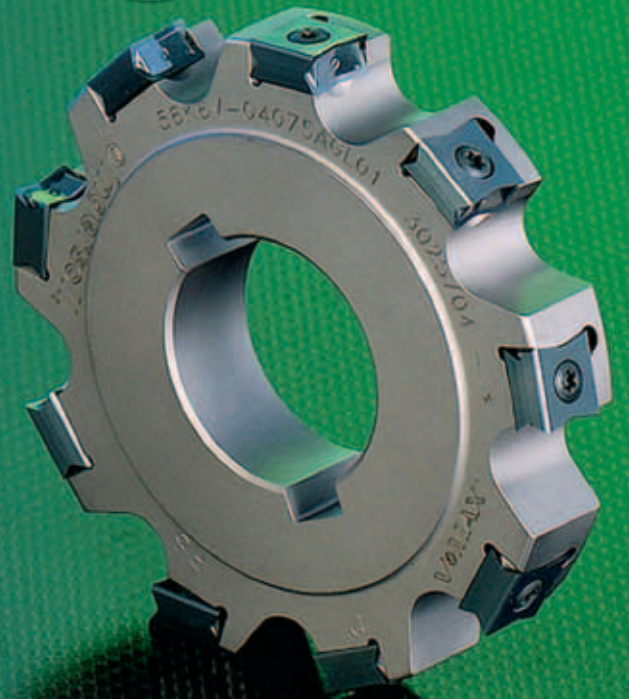


CUTTING TOOLS

CUTTING TOOLS

SLOTTERS

Cutting Tools



Member IMC Group
Ingersoll
Cutting Tools

SLOTTERS

SLOTTERS

	Diameter Range	Width	Description	Series	Page
	4.000-10.000	.625-1.000	 Heavy-Duty Axial Slotters	3SJ6	314
	4.000-10.000	.625-1.000	 Heavy-Duty Radial Slotters	3SJ6	316
	3.000-10.000	.460	 Heavy-Duty Half-Side Mill	5VK6V	318
	4.000-8.000	.375-.500	 Medium-Density Axial Slotter	3VL5V	320
	4.000-8.000	.375-.500	 Medium-Density Radial Slotter	3VL5V	322
	.953-2.175	.500-1.250	 T-Slot End Mill	15T, 12T	324
	3.000-6.000	.063-.250	 Light-Duty Narrow Slotters	31J	326
	3.000-8.000	.156-.312	 Medium-Duty Axial Slotters	38L5	328
	2.500-5.000	.156-.312	 Medium-Duty Radial Slotters	38L5	330
	4.000-8.000	.375-.500	 Medium-Duty Radial Slotters	35J6E	332

SLOT

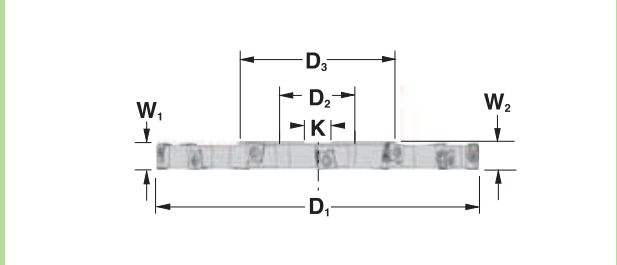


HEAVY-DUTY AXIAL DRIVE SLOTTER SERIES 3SJ6

Diameters
 4.000" to 10.000"
Width of Cut
 .625" - 1.000"
 (4 indexes)
Insert Corner
 .031", .062", .094" and .125"R
 (2RH/2LH)



Slotting

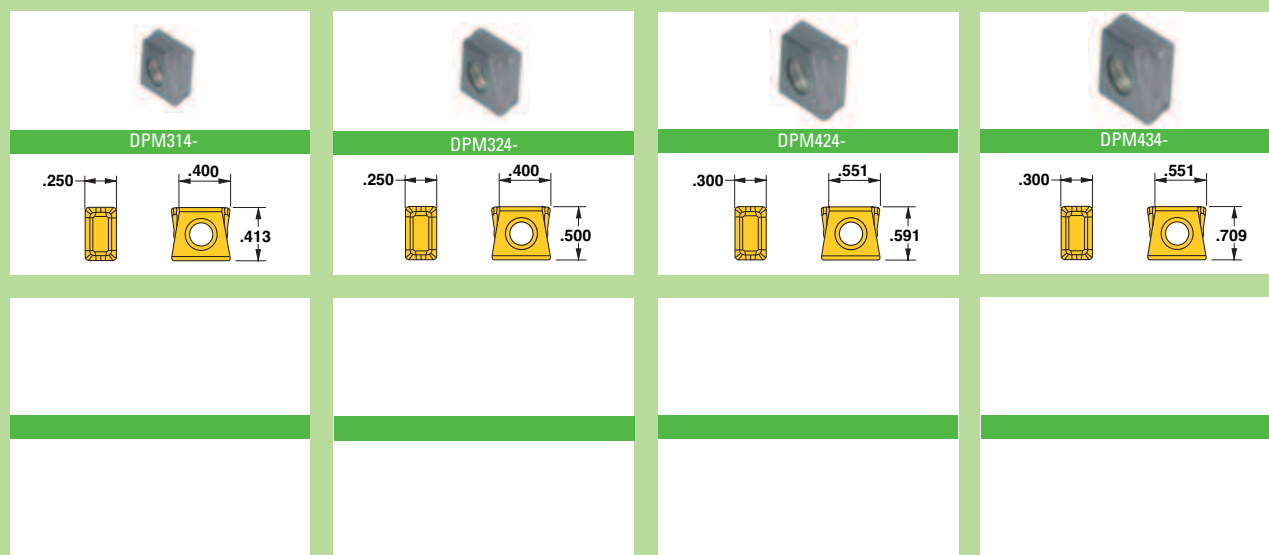


W ₁ Cutter Width	D ₁ Nominal Diameter	Cutter Number	D ₂ Bore Diameter	W ₂ Hub Width	D ₃ Hub Diameter	K Keyway	Number of Inserts		Uses Insert Series
							*Total	Eff.	

.625	4.000	3SJ6E-04062AG-01	1.250	.625	2.25	.32	10	5	DPM314
.750	4.000	3SJ6H-04075AG-01	1.250	.750	2.25	.32	10	5	DPM324
1.000	4.000	3SJ6L-04100AG-01	1.250	1.000	2.25	.32	8	4	DPM424
.625	5.000	3SJ6E-05062AH-01	1.500	.625	2.75	.38	12	6	DPM314
.750	5.000	3SJ6H-05075AH-01	1.500	.750	2.75	.38	12	6	DPM324
1.000	5.000	3SJ6L-05100AH-01	1.500	1.000	2.75	.38	10	5	DPM424
.625	6.000	3SJ6E-06062AH-01	1.500	.625	3.50	.38	14	7	DPM314
.750	6.000	3SJ6H-06075AH-01	1.500	.750	3.50	.38	14	7	DPM324
1.000	6.000	3SJ6L-06100AH-01	1.500	1.000	3.50	.38	12	6	DPM424
.625	8.000	3SJ6E-08062AK-01	2.000	.625	3.50	.50	16	8	DPM314
.750	8.000	3SJ6H-08075AK-01	2.000	.750	3.50	.50	16	8	DPM324
1.000	8.000	3SJ6L-08100AK-01	2.000	1.000	3.50	.50	14	7	DPM424
.625	10.000	3SJ6E-10062AK-01	2.000	.625	3.50	.50	18	9	DPM314
.750	10.000	3SJ6H-10075AK-01	2.000	.750	3.50	.50	18	9	DPM324
1.000	10.000	3SJ6L-10100AK-01	2.000	1.000	3.50	.50	16	8	DPM424

Product Note: Full and half pitch axial Keyway on stock tools.
 *Total Inserts in Cutter are two times the number of effective inserts.

INSERTS



Insert Number	Width Range	Corner	Grades				
			IN	2015	2040	2005	1530
DPM314-001	.612-.747	.031R	■			■	■
DPM314-002	.612-.747	.062R	■			■	■
DPM314-003	.612-.747	.094R	■			■	■
DPM314-004	.612-.747	.125R	■			■	■
DPM324-001	.709-.921	.031R	■			■	■
DPM324-002	.709-.921	.062R	■			■	■
DPM324-003	.709-.921	.094R	■			■	■
DPM324-004	.709-.921	.125R	■			■	■
DPM424-001	.825-1.103	.031R	■	■		■	
DPM424-002	.825-1.103	.062R	■	■		■	
DPM424-003	.825-1.103	.094R	■	■		■	
DPM424-004	.825-1.103	.125R	■	■		■	
DPM434-001	.934-1.341	.031R	■	■	■	■	■
DPM434-002	.934-1.341	.062R	■	■	■	■	
DPM434-003	.934-1.341	.094R				■	
DPM434-004	.934-1.341	.125R				■	

HARDWARE

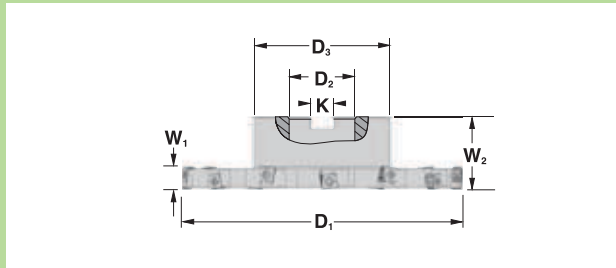
Insert Screw			Driver
Insert Series	Part No.	Torque	Part No.
DPM314, DPM324	SM40-120-20 (SE02-81)	25-30 in. lbs.	DS-T15T (Tx-15)
DPM424, DPM434	SM40-160-10 (SE03-70)	35-40 in. lbs.	DS-T20T (Tx-20)

For technical information, see page XX.



HEAVY-DUTY RADIAL DRIVE SLOTTER SERIES 3SJ6

Diameters
 4.000" to 10.000"
Width of Cut
 .625" - 1.000"
 (4 indexes)
Insert Corner
 .031", .062", .094" and .125"R
 (2RH/2LH)

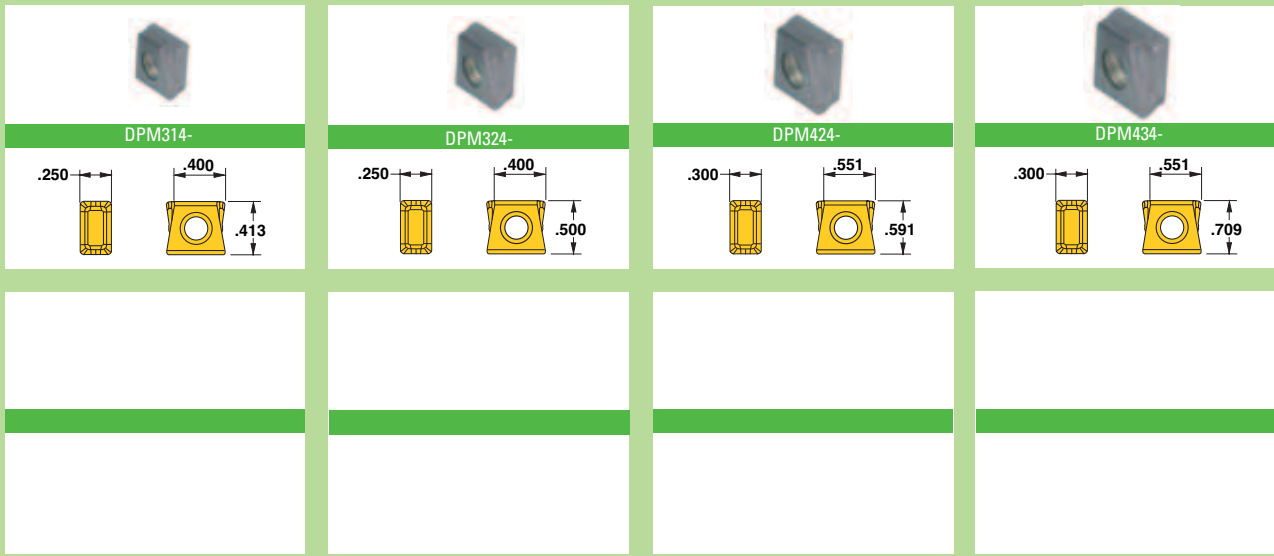


W ₁ Cutter Width	D ₁ Nominal Diameter	Cutter Number	D ₂ Bore Diameter	W ₂ Hub Width	D ₃ Hub Diameter	K Keyway	Number of Inserts		Uses Insert Series
							*Total	Eff.	

.625	4.000	3SJ6E-0406257R01	1.000	1.50	2.00	.38	10	5	DPM314
.750	4.000	3SJ6H-0407557R01	1.000	1.50	2.00	.38	10	5	DPM324
1.000	4.000	3SJ6L-0410057R01	1.000	1.50	2.00	.38	8	4	DPM424
.625	5.000	3SJ6E-0506257R01	1.000	1.50	2.75	.38	12	6	DPM314
.750	5.000	3SJ6H-0507557R01	1.000	1.50	2.75	.38	12	6	DPM324
1.000	5.000	3SJ6L-0510057R01	1.000	1.50	2.75	.38	10	5	DPM424
.625	6.000	3SJ6E-0606258R01	1.500	2.00	3.81	.63	14	7	DPM314
.750	6.000	3SJ6H-0607558R01	1.500	2.00	3.81	.63	14	7	DPM324
1.000	6.000	3SJ6L-0610058R01	1.500	2.00	3.81	.63	12	6	DPM424
.625	8.000	3SJ6E-0806258R01	1.500	2.00	3.81	.63	16	8	DPM314
.750	8.000	3SJ6H-0807558R01	1.500	2.00	3.81	.63	16	8	DPM324
1.000	8.000	3SJ6L-0810058R01	1.500	2.00	3.81	.63	14	7	DPM424
.625	10.000	3SJ6E-1006261R01	2.500	2.00	4.87	1.00	18	9	DPM314
.750	10.000	3SJ6H-1007561R01	2.500	2.00	4.87	1.00	18	9	DPM324
1.000	10.000	3SJ6L-1010061R01	2.500	2.00	4.87	1.00	16	8	DPM424

*Total Inserts in Cutter are two times the number of effective inserts.

INSERTS



Insert Number	Width Range	Corner	Grades				
			IN	2015	2040	2005	1530
DPM314-001	.612-.747	.031R	■			■	■
DPM314-002	.612-.747	.062R	■			■	■
DPM314-003	.612-.747	.094R	■			■	■
DPM314-004	.612-.747	.125R	■			■	■
DPM324-001	.709-.921	.031R	■			■	■
DPM324-002	.709-.921	.062R	■			■	■
DPM324-003	.709-.921	.094R	■			■	■
DPM324-004	.709-.921	.125R	■			■	■
DPM424-001	.825-1.103	.031R	■	■		■	
DPM424-002	.825-1.103	.062R	■	■		■	
DPM424-003	.825-1.103	.094R	■	■		■	
DPM424-004	.825-1.103	.125R	■	■		■	
DPM434-001	.934-1.341	.031R	■	■	■	■	■
DPM434-002	.934-1.341	.062R	■	■	■	■	
DPM434-003	.934-1.341	.094R				■	
DPM434-004	.934-1.341	.125R				■	

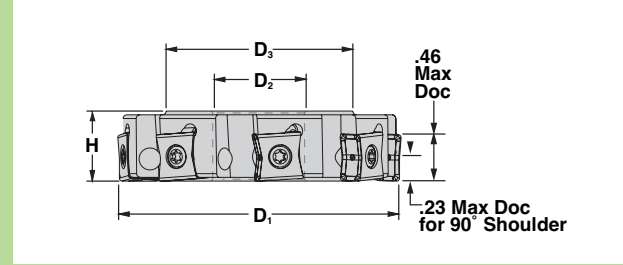
HARDWARE

Insert Screw			Driver
Insert Series	Part No.	Torque	Part No.
DPM314, DPM324	SM40-120-20 (SE02-81)	25-30 in. lbs.	DS-T15T (Tx-15)
DPM424, DPM434	SM40-160-10 (SE03-70)	35-40 in. lbs.	DS-T20T (Tx-20)

For technical information, see page XX.

VOMAX™ 0° HEAVY-DUTY HALF-SIDE MILL SERIES 5VK6V

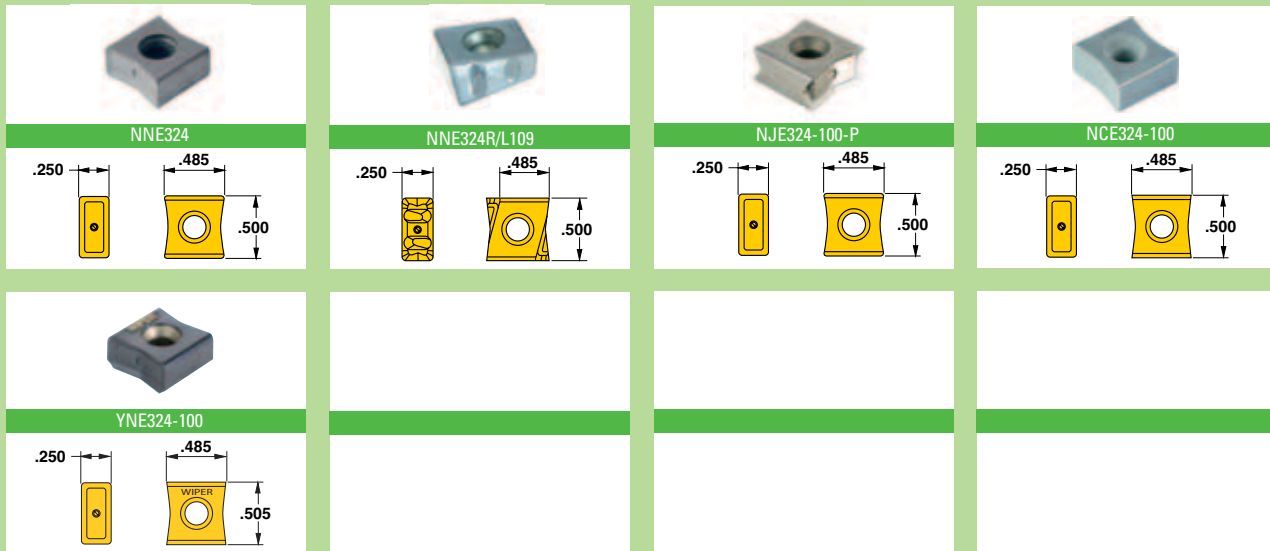
Diameters 3.000" to 10.000"	Cutting Edge Length .460" .230" (4RH/4LH)	Insert Corner .031", .063", .125"r and .031" x 45° chamfer
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D ₁ Effective Diameter	Cutter Number	D ₂ Bore Diameter	H Height	D ₃ Hub Diameter	Keyway	Number of Inserts	
						*Total	Eff.
Right-Hand Rotation							
3.000	5VK6V-03075AFR01	1.000	.750	2.00	.25	16	8
4.000	5VK6V-04075AGR01	1.250	.750	2.75	.38	18	9
5.000	5VK6V-05075AHR01	1.500	.750	2.75	.38	20	10
6.000	5VK6V-06075AHR01	1.500	.750	2.75	.38	26	13
8.000	5VK6V-08075AKR01	2.000	.750	4.00	.50	32	16
10.000	5VK6V-10075AKR01	2.000	.750	4.00	.50	40	20
Left-Hand Rotation							
3.000	5VK6V-03075AFL01	1.000	.750	2.00	.25	16	8
4.000	5VK6V-04075AGL01	1.250	.750	2.75	.38	18	9
5.000	5VK6V-05075AHL01	1.500	.750	2.75	.38	20	10
6.000	5VK6V-06075AHL01	1.500	.750	2.75	.38	26	13
8.000	5VK6V-08075AKL01	2.000	.750	4.00	.50	32	16
10.000	5VK6V-10075AKL01	2.000	.750	4.00	.50	40	20

*Total Inserts in Cutter are two times the number of effective inserts.

INSERTS



Insert Number	Application	Corner	Cut Edge Configuration	Grades										
				IN	2005	2010	2030	2015	2040	1530	6515	15K	70N	
NNE324-100	Multi-Purpose	.031R	4RH/4LH	■		■	■	■	■	■				
NNE324-102	Multi-Purpose	.063R	4RH/4LH				■	■	■	■				
NNE324-104	Multi-Purpose	.031 x 45°	4RH/4LH			■		■					■	
NNE324-125	Multi-Purpose	.125R	4RH/4LH				■							
YNE324-100	Wiper	.031R	2RH/2LH				■	■	■				■	
NNE324R109	Multi-Purpose	.031R	4RH	■	■	■	■	■	■				■	
NNE324L109	Multi-Purpose	.031R	4LH	■		■	■	■	■				■	
NJE324-100-P	Polished	.031R	4RH/4LH											■
NCE324-100	SiN	.031R	4RH/4LH											■

HARDWARE

Insert Screw		Driver
Part No.	Torque	Part No.
SM40-120-20 (SE02-81)	25-30 in. lbs.	DS-T15T (Tx-15)

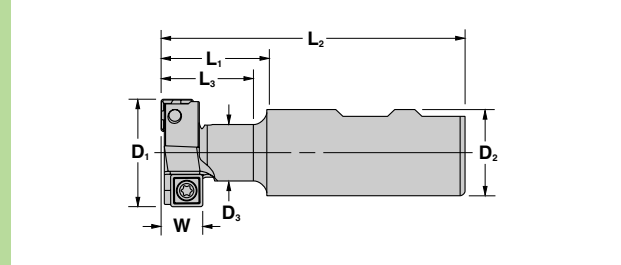
For technical information, see page XX.

SLOT-MAX™ T-SLOT END MILL SERIES 15T, 12T

Diameters
.953" to 2.175"

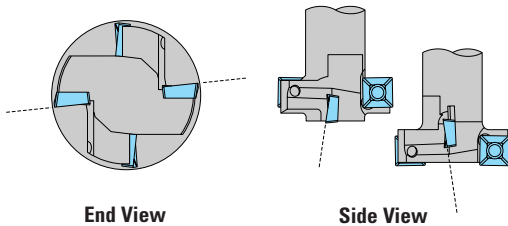
Width of Cut
.385" to 1.094"

Insert Corner
.015" and .031"R



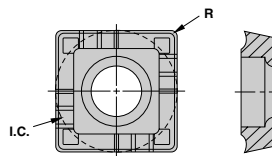
"T"- Bolt Size	D ₁ Nominal Diameter	Cutter Number	W Width of Cut	L ₁ Exten.	L ₂ Overall Length	D ₂ Shank Size/Style	D ₃ Neck Dia.	L ₃ Neck Length	No. of Flutes	No. of Effective Flutes	Total No. of Inserts
.500	.953	15T1D-0902580R01	.385	2.50	4.75	1.000 Weldon	.51	1.10	4	2	4
.625	1.250	15T1F-1201280R01	.480	1.25	3.50	1.000 Weldon	.66	1.06	2	1	2
.750	1.464	15T1F-1401580R01	.620	1.50	3.75	1.000 Weldon	.79	1.38	4	2	4
1.000	1.795	12T1B-1701981R01	.828	1.94	4.19	1.250 Weldon	.87	1.71	4	2	4
1.250	2.175	12T1B-2102281R01	1.094	2.25	4.50	1.250 Weldon	1.21	2.13	6	3	6

15T1D Insert Loading: Insert Series SPLT060204R



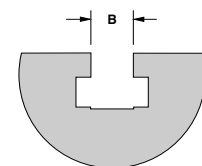
When loading SPLT060204R inserts into Series 15T1D cutters, care must be taken to be sure they are properly installed. Improper loading will damage the cutter.

15T1D Insert Loading: Insert Series SPLT060204R-DM04



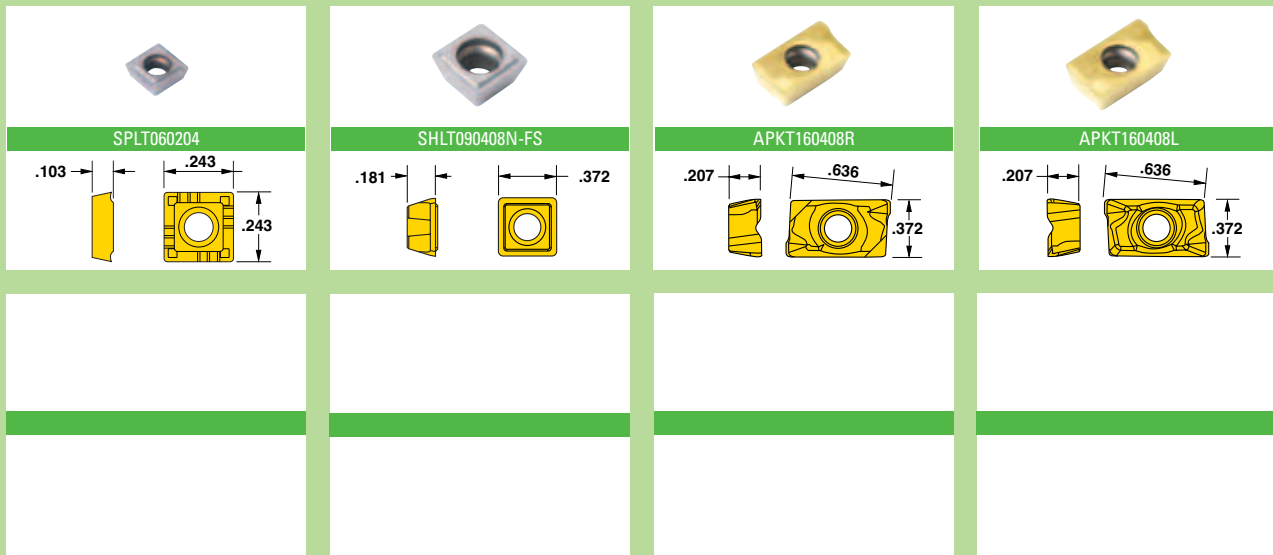
Series SPLT060204R-DM04 inserts are symmetrically designed. They provide four cutting edges and cannot be loaded improperly.

Channeling for Series 15T and 12T End Mills



The channel depth must extend beyond the depth of the T-slot and the channel width should not be less than the "B" dimension for a given ANSI standard T-slot.

INSERTS



Cutter Number	Qty. Each	Insert Number	Application	Corner	Grades					
					IN	30M	6515	2005	1030	1040
15T1D-0902580R01	4	SPLT060204R	Multi-Purpose	.015R	■				■	■
15T1D-0902580R01	4	SPLT060204R-DM04	Multi-Purpose	.015R					■	
15T1F-1201280R01	2	SHLT090408N-FS	Multi-Purpose	.031R			■	■	■	
15T1F-1401580R01	4	SHLT090408N-FS	Multi-Purpose	.031R			■	■	■	
12T1B-1701981R01	2	APKT160408R	Multi-Purpose	.031R					■	■
12T1B-1701981R01	2	APKT160408L	Multi-Purpose	.031R					■	■
12T1B-2102281R01	2	APKT160408R	Multi-Purpose	.031R					■	■
12T1B-2102281R01	2	APKT160408L	Multi-Purpose	.031R					■	■

HARDWARE

Cutter Series	Insert Screw		Driver
	Part No.	Torque	
15T1D	SM22-052-00	7-11 in. lbs.	DS-T07W (Tx-07)
15T1F-12	SM40-080-30	30-35 in. lbs.	DS-T15T (Tx-15)
15T1F-14	SM40-093-20	30-35 in. lbs.	DS-T15T (Tx-15)
12T1B	SM40-120-20	30-35 in. lbs.	DS-T15T (Tx-15)

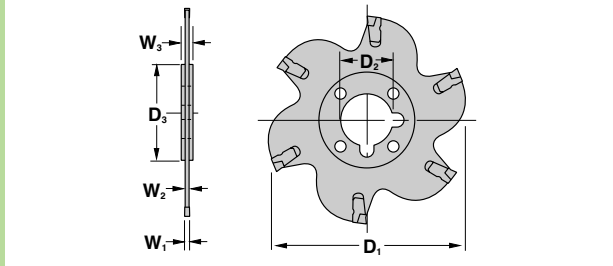
For technical information, see page XX.

SLOT-IN™ LIGHT-DUTY NARROW SLOTTERS SERIES 31J

Diameters 3.000" to 4.000" Width of Cut .063" Insert Corner .006"r; Full Radius



Integral Hub

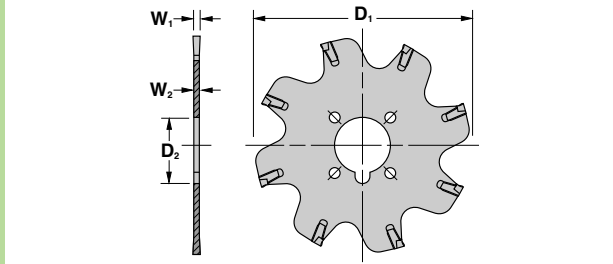
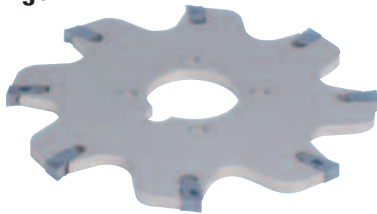


W ₁ Nominal Width	D ₁ Nominal Diameter	Cutter Number	D ₂ Bore Dia.	W ₂ Body Width	W ₃ Hub Width	D ₃ Hub Dia.	Keyway Qty.	Max. Radial DOC	No. of Effective Inserts	Insert Series No.	Max. RPM
.063	3.000	31J6A-03006AF-01	1.000	.049	.094	1.54	2	.71	8	GCXF071601N	1050
.063	4.000	31J6A-04006AF-01	1.000	.049	.094	1.54	2	1.21	10	GCXF071601N	780

Diameters 4.000" to 6.000" Width of Cut .122" to .250" Insert Corner .122", .188" and .250"r



Drive Flange



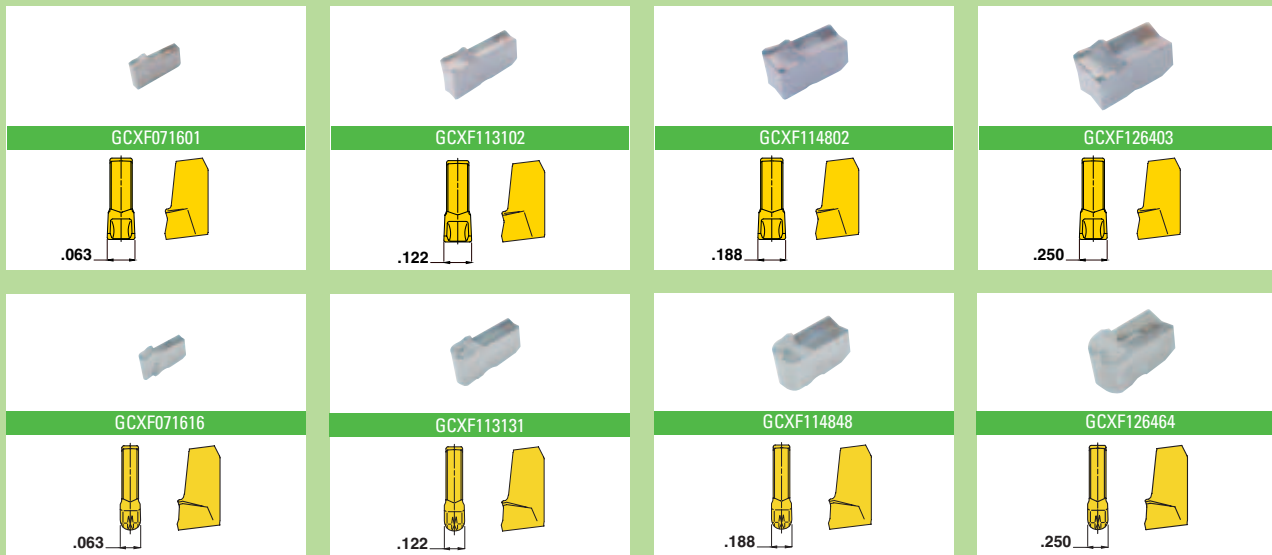
W ₁ Nominal Width	D ₁ Nominal Diameter	Cutter Number	D ₂ Bore Dia.	W ₂ Body Width	W ₃ Hub Width	D ₃ Hub Dia.	Keyway Qty.	Max. Radial DOC	No. of Effective Inserts	Insert Series No.	Max. RPM
.122	4.000	31J6B-04012AV-01	1.000	.094	-	-	2	1.08	6	GCXF113102N	780
.188	4.000	31J6C-04018AV-01	1.000	.157	-	-	2	1.08	6	GCXF114802N	780
.122	5.000	31J6B-05012AW-01	1.250	.094	-	-	1	1.40	8	GCXF113102N	630
.188	5.000	31J6C-05018AW-01	1.250	.157	-	-	1	1.40	8	GCXF114802N	630
.250	5.000	31J6D-05025AW-01	1.250	.203	-	-	1	1.40	8	GCXF126403N	630
.122	6.000	31J6B-06012AX-01	1.500	.094	-	-	2	1.41	10	GCXF113102N	520
.188	6.000	31J6C-06018AX-01	1.500	.157	-	-	2	1.41	10	GCXF114802N	520
.250	6.000	31J6D-06025AX-01	1.500	.203	-	-	2	1.41	10	GCXF126403N	520

HARDWARE

Insert Extractor	
Cutter Width	Part No.
.063	DR-0032
.122-.250	DR-0031

Drive Flange				
Bore	Part No.	Thickness	Overall Dia.	Keyway
1.000	FL-0002	.390	1.81	.25
1.250	FL-0003	.390	2.16	.32
1.500	FL-0004	.470	3.15	.38

INSERTS



Insert/Cutter Width	Insert Number	Corner	Grades	
			IN	1030
.063	GCXF071601N-E	.006R	■	
	GCXF071616N-E	.031 Full Radius	■	
.122	GCXF113102N-E	.008R	■	
	GCXF113131N-E	.061 Full Radius	■	
.188	GCXF114803N-E	.011R	■	
	GCXF114848N-E	.094 Full Radius	■	
.250	GCXF126403N-E	.014R	■	
	GCXF126464N-E	.125 Full Radius	■	

Insert Loading Procedure

1. Be sure insert pockets are free of dirt prior to assembly.
2. Manually place insert into seat and tap into position using a plastic hammer.
3. When properly seated, there should be no gap between the top of the insert and the cutter body locator.



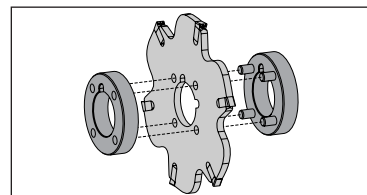
Insert Removal Procedure

1. To remove inserts from the cutter body, first, place insert extractor into space behind the insert.
2. Turn the extractor 90° until the insert is dislodged from the pocket.
3. One extractor is provided with each cutter.



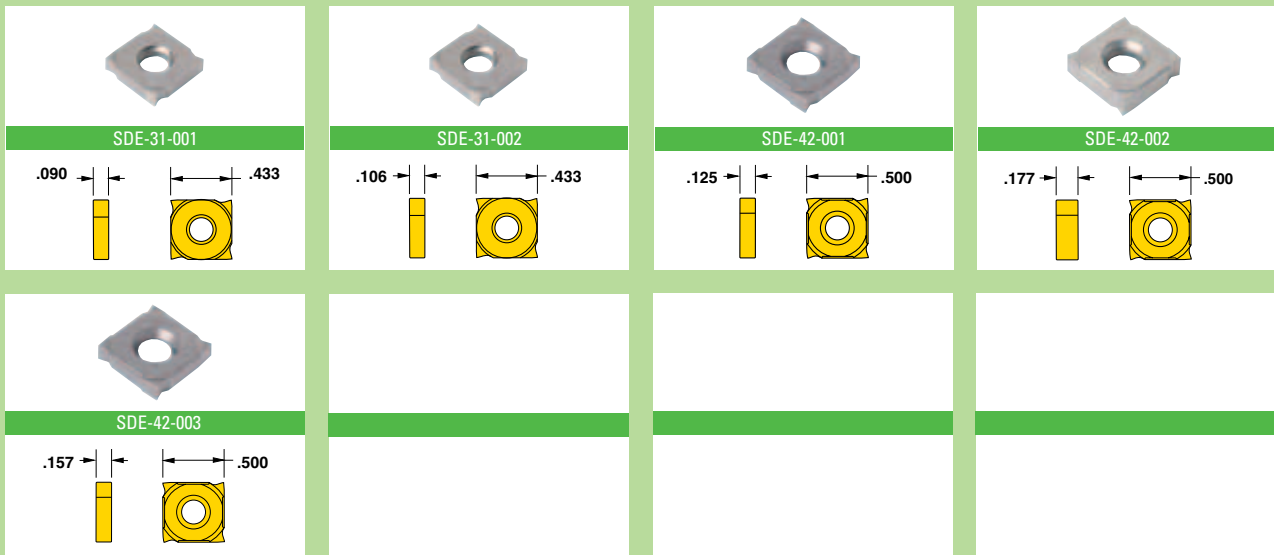
Cutter Mounting

When using drive flange-style cutter bodies, the use of a drive flange set is highly recommended to provide more bearing surface for the drive key. Without the drive flange set, the drive flange key or arbor may be damaged when the cutter is run at high speeds.



For technical information, see page XX.

INSERTS



Insert Number	Width	Grades	
		IN	1030
SDE-31-001	.156		■
SDE-31-002	.187		■
SDE-42-001	.250		■
SDE-42-002	.312		■
SDE-42-003	.250*		■

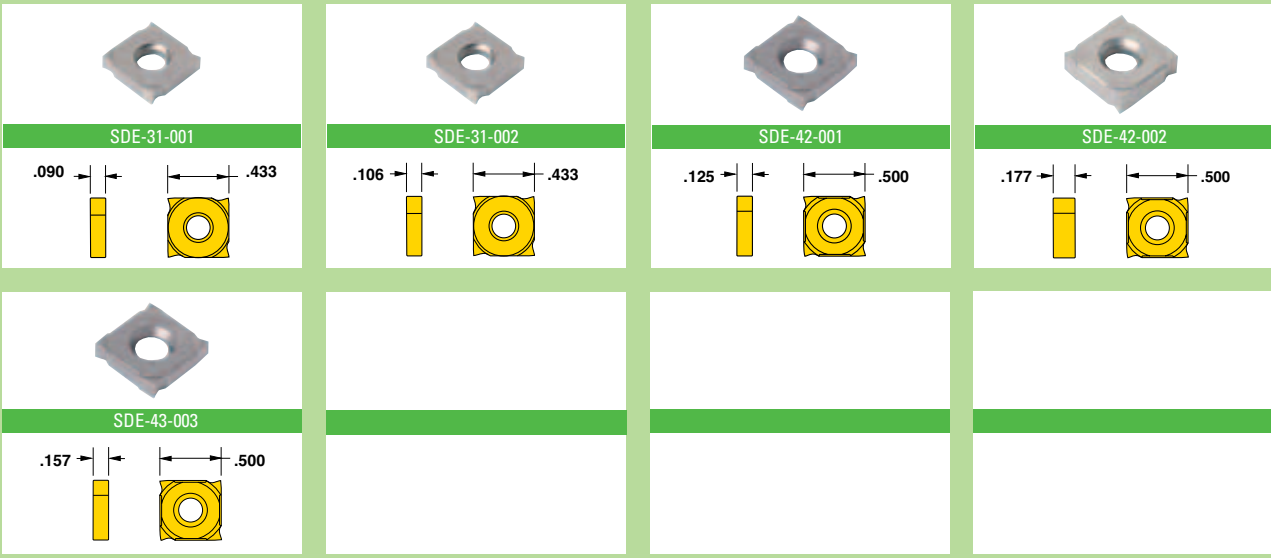
*Fits ONLY Competitor Cutter!

HARDWARE

Cutter Series	Insert Screw		Driver
	Part No.	Torque	
.156	SM35-034-50	25-30 in. lbs.	DS-T09S (Tx-09)
.187	SM35-042-50	25-30 in. lbs.	DS-T09S (Tx-09)
.250	SM40-050-50	30-35 in. lbs.	DS-T15S (Tx-15)
.312	SM40-060-50	30-35 in. lbs.	DS-T15S (Tx-15)

For technical information, see page XX.

INSERTS



Insert Number	Width	Grades	
		IN	1030
SDE-31-001	.156		■
SDE-31-002	.187		■
SDE-42-001	.250		■
SDE-42-002	.312		■
SDE-42-003	.250*		■

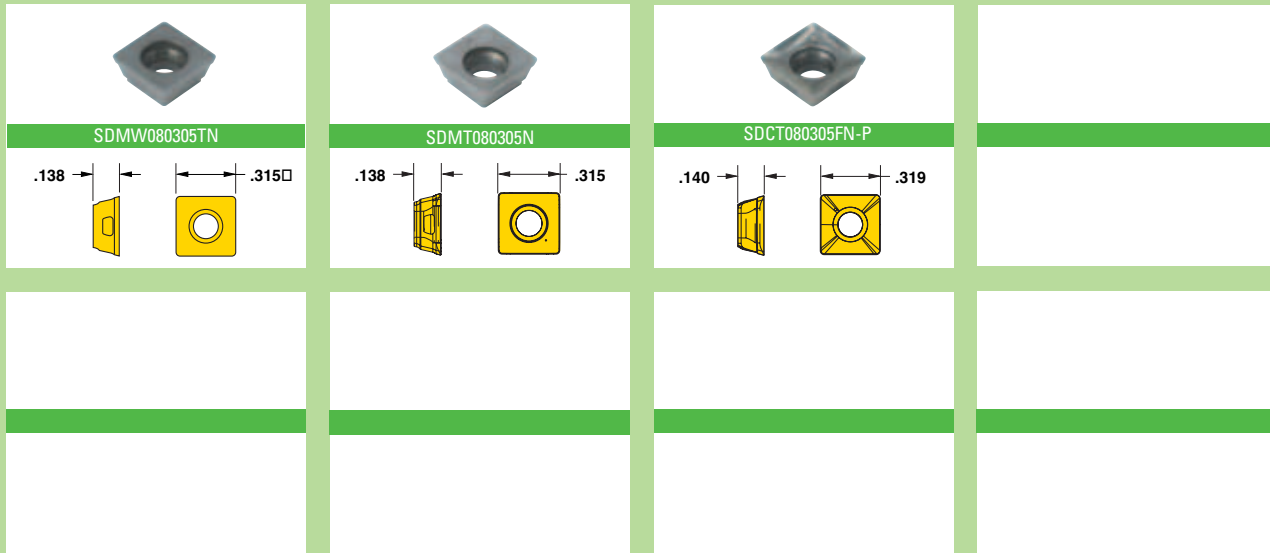
*Fits ONLY Competitor Cutter!

HARDWARE

Cutter Series	Insert Screw		Driver
	Part No.	Torque	
.156	SM35-034-50	25-30 in. lbs.	DS-T09S (Tx-09)
.187	SM35-042-50	25-30 in. lbs.	DS-T09S (Tx-09)
.250	SM40-050-50	30-35 in. lbs.	DS-T15S (Tx-15)
.312	SM40-060-50	30-35 in. lbs.	DS-T15S (Tx-15)

For technical information, see page XX.

INSERTS



Insert Number	Application	Corner	Grades						
			IN	30M	2005	2030	2015	2040	1030
SDMT080305N	Multi-Purpose	.020R			■	■	■	■	■
SDMW080305TN	Flat Top	.020R			■	■	■	■	■
SDCT080305FN-P	Ground/Polished	.020R		■					
SDMT080308N	Multi-Purpose	.031R							■
SDMW080308TN	Flat Top	.031R							■
SDMT080316N	Multi-Purpose	.062R							■
SDMW080316TN	Flat Top	.062R							■

HARDWARE

Insert Screw		Driver	
Part No.	Torque	Part No.	
SM30-065-00	13-18 in. lbs.	DS-T09T (Tx-09)	

For technical information, see page XX.