

Member IMC Group

Ingersoll

Cutting Tools

DEKA™

FAMILY

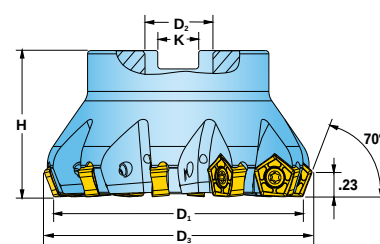


Part of the
Ingersoll
CHASE
line

Diameters
1.500" to 8.000"

Cutting Edge Length
.230"

Insert Corner
.030"R



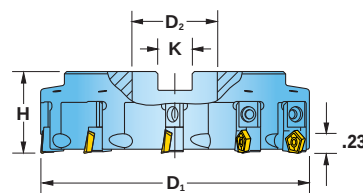
D ₁ Effective Diameter	Cutter Number	Number of Inserts	H Height	D ₂ Bore Diameter	D ₃ Overall Diameter	Retention Bolt	Coolant Thru Retention Bolt*	K Keyway
Medium Density								
1.500	DM6G-15R01	4	1.570	.500	1.71	SD-04-86	-	.25
2.000	DM6G-20R01	4	1.570	.750	2.21	SD-06-46	SD-06-89	.31
2.500	DM6G-25R01	6	1.570	.750	2.71	SD-06-46	SD-06-89	.31
3.000	DM6G-30R01	7	1.750	1.000	3.21	SD-08-46	SD-08-92	.38
4.000	DM6G-40R01	8	2.375	1.500	4.21	SD-12-82	SD-12-99	.62
5.000	DM6G-50R01	10	2.375	1.500	5.21	SD-12-82	SD-12-99	.62
6.000	DM6G-60R01	12	2.375	1.500	6.21	SD-12-82	SD-12-99	.62
8.000	DM6G-80R10	16	2.375	2.500	8.21	4.00 B.C.	-	1.00
High Density								
2.000	DM5G-20R01	6	1.570	.750	2.21	SD-06-46	SD-06-89	.31
2.500	DM5G-25R01	8	1.570	.750	2.71	SD-06-46	SD-06-89	.31
3.000	DM5G-30R01	10	1.750	1.000	3.21	SD-08-46	SD-08-92	.38
4.000	DM5G-40R01	12	2.375	1.500	4.21	SD-12-82	SD-12-99	.62
5.000	DM5G-50R01	16	2.375	1.500	5.25	-	-	.62
6.000	DM5G-60R01	20	2.375	1.500	6.26	-	-	.62

*Order Separately

Diameters
4.000" to 12.000"

Cutting Edge Length
.230"

Insert Corner
.030"R



Insert Style	D ₁ Nominal Dia.	Cartridge** Number	Cutter Number	Number of Inserts	H Height	D ₂ Bore Diameter	Bolt Circle	Weight with Cartridges	K Keyway
	4.000	55H-11R07	4W2A-04R01	6	2.375	1.500	-	4.11 lbs.	.63
	6.000	55H-11R07	4W2A-06R01	8	2.375	1.500	-	10.13 lbs.	.63
	8.000	55H-11R07	4W2A-08R01	10	2.375	2.500	4.00	17.11 lbs.	1.00
	10.000	55H-11R07	4W2A-10R01	12	2.375	2.500	4.00	28.8 lbs.	1.00
	12.000	55H-11R07	4W2A-12R01	14	2.375	2.500	4.00, 7.00	39.15 lbs.	1.00

**Order Separately

INSERTS



Insert Number	Application	Corner	Grades								
			IN	05S	1030	2005	2015	2030	2505	DD15	70N
PNCU0805GNTR	Multi-Purpose	.030R			■	■	■	■		■	
PNCU0805GNTR-W	Wiper	.030R				■		■	■	■	
PNCU0805GNR	Silicon Nitride	.030R								■	
PNCU0805GNFR-P	Sharp/Polished (Aluminum)	.030R		■							
PNCQ0804GNTN	Flat Top (Heavy Duty)	.030R				■		■			
 PNCU0805GNFR-HS	Hi-Temp/Titanium	.030R						■	■		

HARDWARE

	Cartridge		Cartridge Screw		Driver
	Part No.		Part No.	Torque	Part No.
	55H-11R07		SD03-89	150-180 in. lbs.	DS-H05T (5mm hex)
Axial Adjusting Screw			Driver		
Part No.			Part No.		
SA04-42			DS-H03T (3mm hex)		
Insert Screw			Driver		
Part No.		Torque	Part No.		
SM40-100-10		40 in. lbs.	DS-T15T (Tx-15)		
OPTIONAL TORQUE DRIVER			BIT - for Optional Torque Driver		
Part No.			Part No.		
 DT-40-01			DS-T15B1		

HI-FEEDDEKA™ TOP-ON END MILL SERIES 1DP1G

Diameters
1.250" to 1.500"

Insert Corner
.18



Facing

Lead Angle

Pocketing

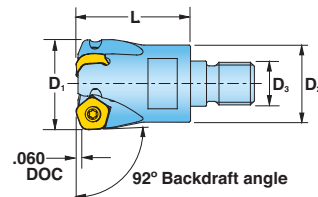
Contour

Corkscrew

Ramping

Channeling

Coolant Thru



D ₁ Effective Diameter	Cutter Number	D ₂ Neck Diameter	D ₃ Adaption	L OAL Length	Number of Inserts	Ramp Angle
1.250	1DP1G-12015X8R01	1.14	M16	1.500	2	0.15
1.500	1DP1G-15017X8R01	1.14	M16	1.750	3	0.19

HI-FEEDDEKA™ END MILL SERIES 1DP1G

Diameters
1.250" to 1.500"

Insert Corner
.18



Facing

Lead Angle

Pocketing

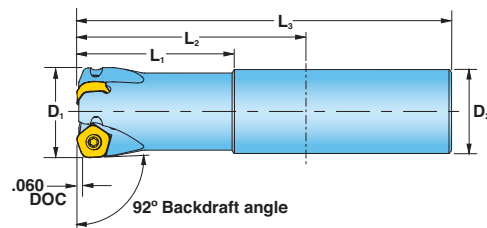
Contour

Corkscrew

Ramping

Channeling

Coolant Thru



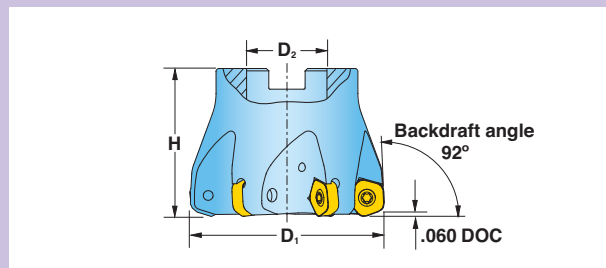
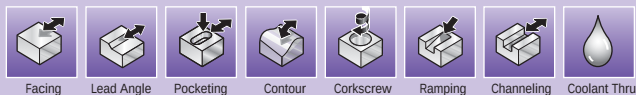
D ₁ Effective Diameter	Cutter Number	D ₂ Adaption	L ₁ Projection Length	L ₂ Extension Length	L ₃ OAL Length	Number of Inserts	Ramp Angle
1.250	1DP1G-1202781R01	1.250 Weldon	2.72	2.75	5.000	2	0.15
1.250	1DP1G-12057S9R01	1.250 cyl	3.50	5.75	8.000	2	0.15
1.500	1DP1G-1503386R01	1.500 Weldon	3.30	3.34	6.000	3	0.19
1.500	1DP1G-15073S5R01	1.500 cyl	4.00	7.34	10.000	3	0.19

Indersoll

HI-FEED DEKA™ FACE MILL SERIES DP5G

Diameters
2.000" to 6.000"

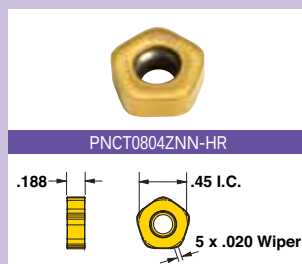
Insert Corner
.18



D ₁ Effective Diameter	Cutter Number	D ₂ Bore Diameter	H Height	Number Effective Inserts	Keyway	Ramp Angle	SHCS	SHCS w/* Coolant Thru
2.000	DP5G-20R01	0.75	1.625	5	0.31	0.64	SD06-46	SD06-89
2.000	DP5G-20R02	0.75	1.625	3	0.31	0.64	SD06-46	SD06-89
2.500	DP5G-25R01	0.75	1.625	4	0.31	0.74	SD06-46	SD06-89
3.000	DP5G-30R01	1.00	2.000	5	0.38	0.80	SD08-46	SD08-92
4.000	DP5G-40R01	1.50	2.375	6	0.62	1.16	SD12-82	SD12-99
6.000	DP5G-60R01	1.50	2.375	8	0.62	0.72	SD12-82	SD12-99

*Order Separately

INSERTS



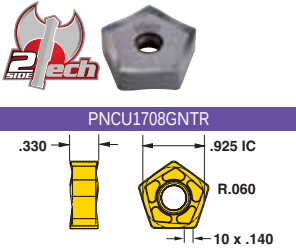
Insert Number	Application	Cutting Edge Configuration	Indexes per Insert	*Corner Radius	Grades			
					IN	2030	2005	2505
PNCQ0804ZNTN	Hi Feed	Neutral	10	.18	■	■		
PNCT0804ZNN-HR	Hi Feed	Positive	5	.18	■			■

HARDWARE

Insert Screw			Standard Driver	
Part No.	Torque		Part No.	
SM40-093-20	40 in. lbs.		DS-T15T (TX-15)	
OPTIONAL TORQUE DRIVER			BIT - for Optional Torque Driver	
Part No.			Part No.	
DT-40-01			DS-T15B1	

CHASEline

INSERTS

[illegible]

*** Please specify hone when ordering.**

HARDWARE

Insert Screw		Wrench
Part No.	Torque	Part No.
SM50-130-R0	55 in. lbs.	DS-T20T (Tx-20)

Hilposdeka™ OPERATING GUIDELINES:

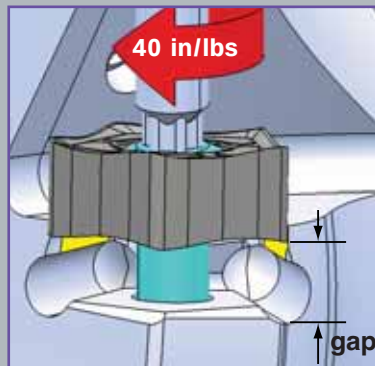
Series DM6G, DM5G					Grades*							Coolant
					IN05S	IN1030	IN2005/IN2505	IN2015	IN2030	DD15	IN70N	
Material		Brinell Hardness	SFM	Feed per Insert								
Aluminum	7075 - T6, 6061 - T6, 2024	-	1650-2500	.005-.020	1		3	2				Yes
Cast Iron	Gray	150-250	300-1000	.008-.020			3	2		1		No
			1800+	.005-.008						1		
	Nodular	150-250	300-600	.008-.015			3	1		2		
			1500+	.004-.007						1		
Steel	Low Carbon 1018, 8620	150-250	400-1000	.008-.020	1	2		1**			No	
	High Carbon F-6180	250-400	350-500	.008-.015								
	Alloyed Steel 4140, 4340	150-300	300-700	.008-.020								
	Tool Steel A-6, D-1, D-2	Up to 300										
Stainless Steel	300 Series, 304, 316	-	300-700	.007-.015	1	2		1**			May not be required at High Speeds	
	400 Series, 15-5 PH	Up to 320	400-900								Yes	
	13-8 PH	-	200-400									
Nickel Alloys	Inconel, Hastelloy, Waspalloy	-	75-120	.004-.012			2		1		Yes	
Titanium	6AL-4V	-	100-150	.005-.014			1		2		Yes	

*In order of preference.

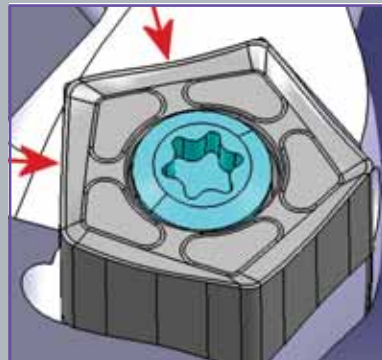
**Preferred for higher surface footage.

ASSEMBLY INSTRUCTIONS FOR DM5G

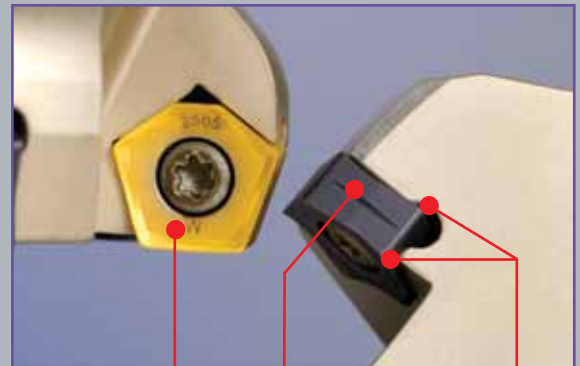
1. Screw down the insert together with the insert screw in the direction of the pocket seating surface (with gap as shown). The insert should be inside the seat roughly located by the yellow marked surfaces.



2. Push the insert slightly against the clamping surfaces before tightening the insert screw (see red arrows). The correct tightening torque is 40 inch pounds.



WIPER EDGE IDENTIFICATION



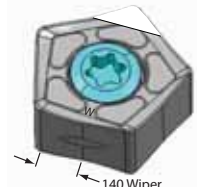
Edge marked with "W" makes contact with workpiece.

2 cutting edges
Indentation on rake face makes contact with workpiece

TIPS FOR FINISHING



.055 Wiper
During finishing operations the feed rate per revolution should not exceed .055"



.140 Wiper
During finishing operations the feed rate per revolution should not exceed .140"

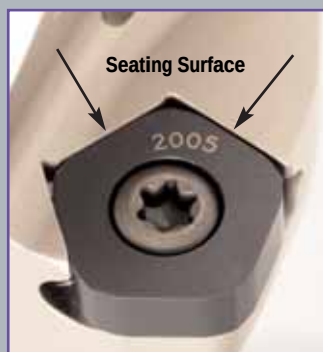
Series 1DP1G, DP5G							Grades*	
Material		Brinell Hardness	SFM	APT**	IN2030	IN2005	Coolant	
Cast Iron	Gray	150-250	600-1000	.040-.100		1	No	
	Nodular	150-250	500-900	.040-.100		1	No	
Steel	Low Carbon 1018, 8620	150-250	400-1000	.040-.100	2	1	No	
	High Carbon F-6180	250-400	350-500	.040-.078				
	Alloyed Steel 4140, 4340	150-300	300-700	.040-.060				
	Tool Steel A-6, D-1, D-2	Up to 300						
Stainless Steel	400 Series, 15-5 PH	Up to 320	250-600	.030-.070	2	1	May not be required at High Speeds	
	13-8 PH	-					Yes	

*Grades in order of preference.

**Chipthinning factor based on extreme lead angle is included.

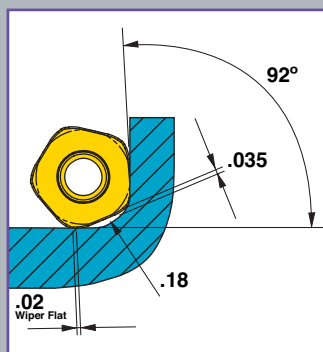
MOUNTING INSTRUCTIONS

For tightening the insert screws, please always use a torque driver (40 in. lbs.). We recommend our driver DT-40-01 with Torque bit DS-T15B1.



PROGRAMMING TIP

Please use a corner radius of .18" in your NC-program when machining 3D-contours. The maximum allowance will then be up to .035".





■ **HIPOSD EKA^{HD}** OPERATING GUIDELINES:

Series DM5Q, DM6Q					Grades				Coolant
Material		Brinell Hardness	SFM	Feed per Insert	IN2005	IN2030	IN2040	DD15	
Cast Iron	Gray	150-250	300-1000	.007-.025	2			1	No
	Nodular		300-600	.007-.020	2			1	
Steel	Low Carbon 1018-8620	150-250	400-1000	.008-.025	3	2	1		No
	High Carbon F-6180	250-400	350-500	.008-.020					
	Alloyed Steel 4140, 4340	150-300	300-700	.008-.020	3	1	2		
	Tool Steel A-6, D-1, D-2	Up to 300							
Stainless Steel	300 Series, 304, 316	-	250-600	.007-.018	2	1			May not be required at high speeds
	400 Series 15-5 PH	Up to 320	300-600						Yes
	13-8 PH	-	200-550						

SPECIFICATIONS

Adaption: _____

Diameter (1.00 Min): _____

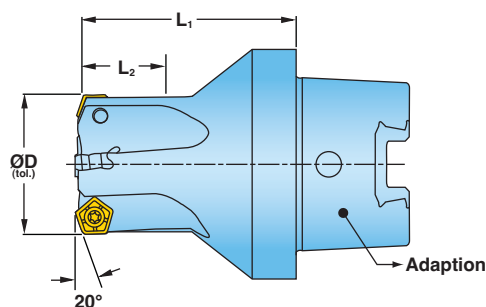
Diameter Tolerance: _____

Extension Length (L1): _____

Length Tolerance: _____

Drill Depth (L2): _____

Effective: _____



APPLICATION INFORMATION

Application: (circle 2)	Rough or SemiFin / Blind hole / Through hole
Coolant: (circle 1)	Through spindle / Flood / None

SPECIFICATIONS

Adaption: _____

Diameter 1 (1.75 Min): _____

Diameter 1 Tolerance: _____

Extension Length (L): _____

Step Length L:

L1 Tolerance: _____

Diameter 2 (.500 Min): _____

Diameter 2 Tolerance: _____

Step Length L2: _____

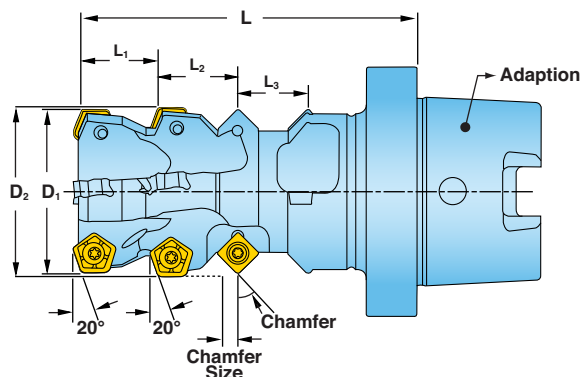
L2 Tolerance: _____

Effective: _____

Chamfer Angle: _____

L3: _____

Chamfer Size: _____



APPLICATION INFORMATION

Station 1: (circle 2)	Rough or SemiFin / Blind hole or Through hole
Station 2: (circle 1)	Rough / SemiFin / Finish
Coolant: (circle 1)	Through spindle / Flood / None

CUSTOMER

CUSTOMER NO.

STREET

CITY

STATE

ZIP

CONTACT PERSON

PHONE

FAX

EMAIL

QUANTITY

ANNUAL QUANTITY

SALES ENGINEER



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