



IN6537

NEW OPTIMIZED GRADE

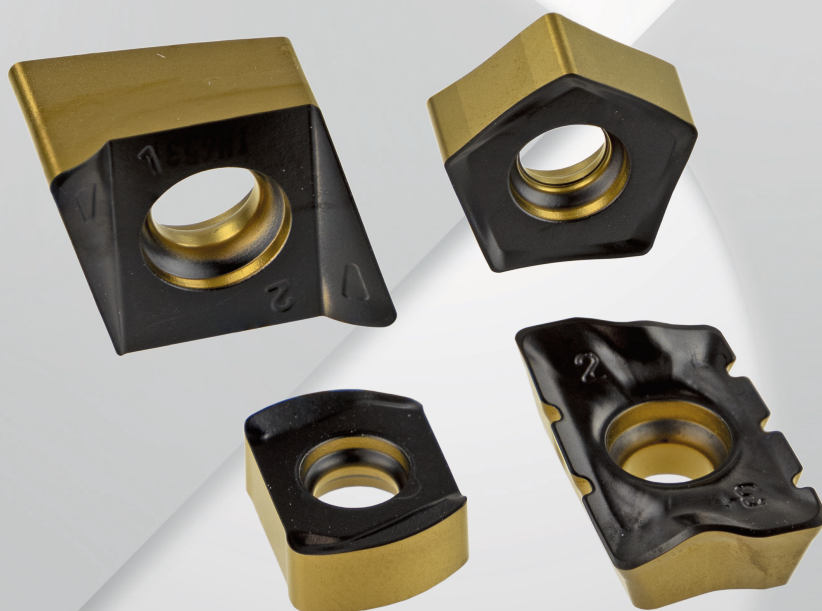


**NEW OPTIMIZED GRADE FOR GENERAL PURPOSE,
HIGH-SPEED AND HIGH FEED MACHINING OF STEEL**

Optimized for high-speed and high feed machining of steel •

Stable tool life •

Wide application range •



■ GRADE IN6537

■ Product Overview

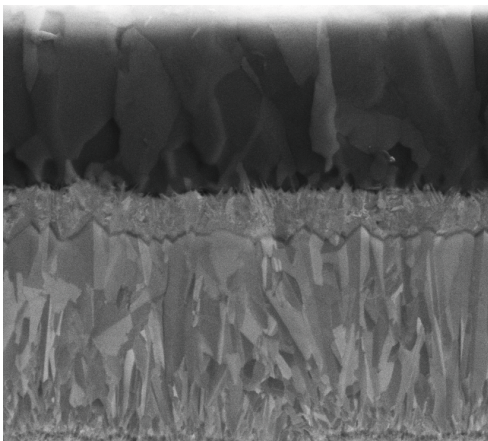
Ingersoll has launched a new grade for general purpose, high-speed and high feed machining of steel – the IN6537 grade.

The new IN6537 grade for milling applications, combines an ultra-high toughness substrate with Al_2O_3 +TiCN CVD coating which has excellent wear resistance. This ensures optimal performance for high-speed and high feed machining, as well as general purpose processing of steel.

This line of black colored inserts' top surface is treated with a state-of-the-art coating technology with post treatment that minimizes friction during machining. Thus, it provides excellent stability even in high-speed, high feed machining conditions.

■ Grade Features

- Optimized for high-speed and high feed machining of steel
- Ensures stable tool life with consistent wear in unstable conditions
- Wide applications – roughing and medium, dry and wet machining



← Minimized friction due to the newest surface treatment technology

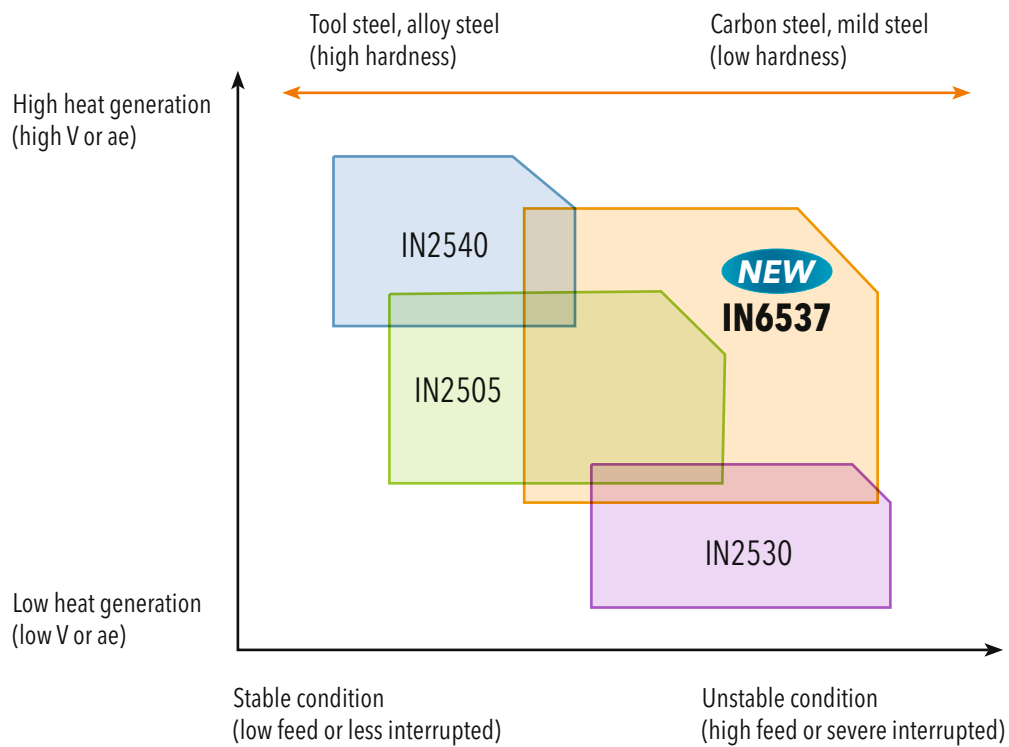
← Al_2O_3 layer for better heat resistance

← Uniform and stable adhesive layer

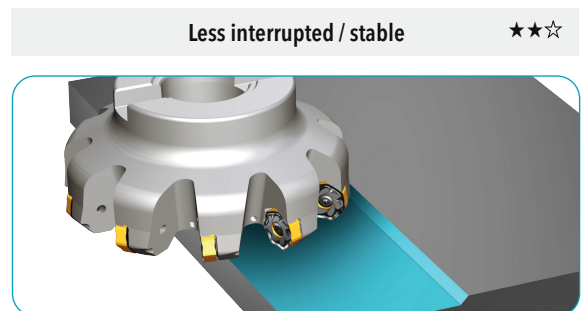
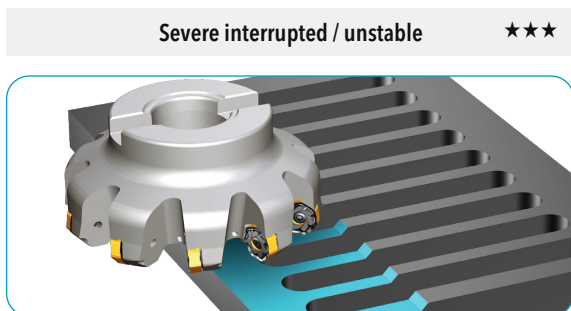
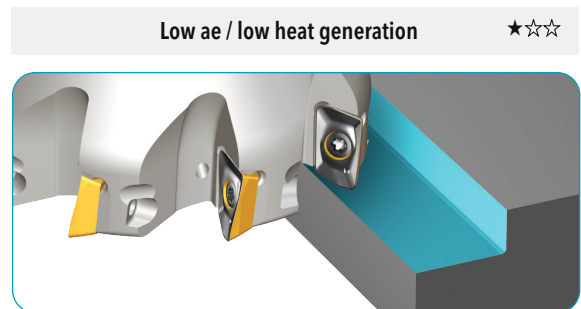
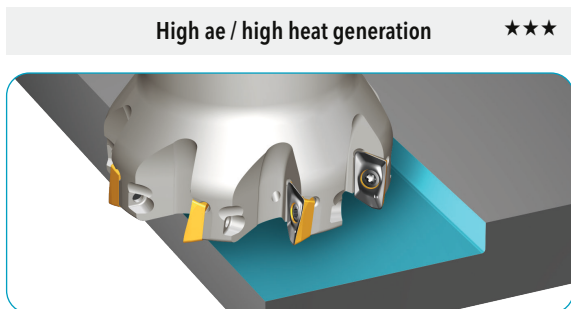
← TiCN layer for high hardness and high toughness

GRADE IN6537

Application Range

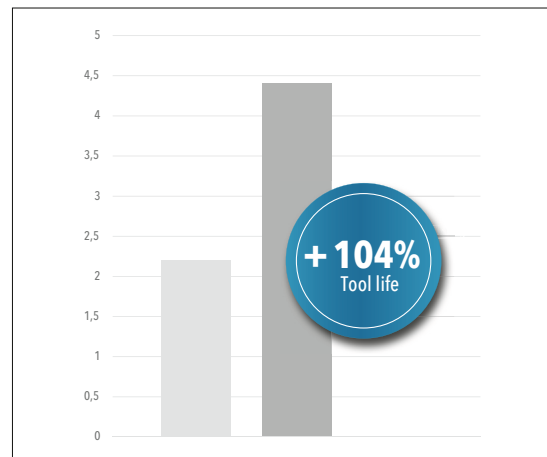


Recommended Applications

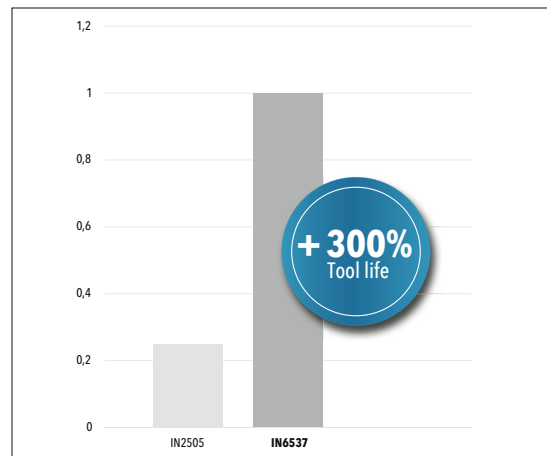


Test reports

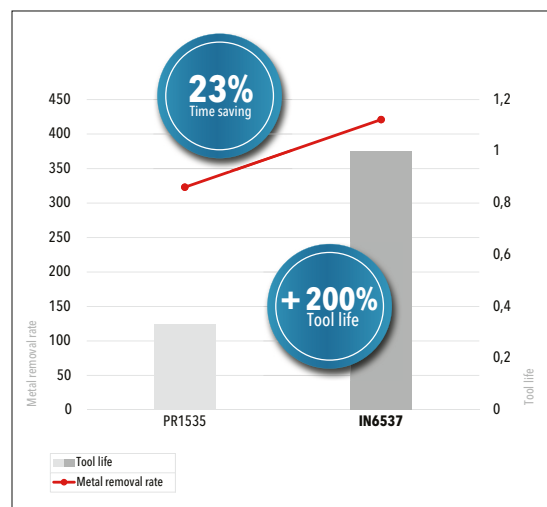
Test 1		Competition	Ingersoll
Material		Construction steel S355J2	
Insert		PNMU 1205ANER-GH	HNGU0605ANTR-MM
Grade		PR1525	IN6537
Tool diameter	(mm)	100	100
Cutting speed Vc	(m/min)	170	236
Feed rate fz	(mm)	0,4	0,3
Cooling		Air	
Tool life		2 h 20 min	4 h 40 min



Test 2		Ingersoll	Ingersoll
Material		High-speed steel (HSS) 1.3343	
Insert		UNLU0603M0TR	
Grade		IN2505	IN6537
Tool diameter	(mm)	32	
Cutting speed Vc	(m/min)	110	
Feed rate fz	(mm)	0,8	
Cooling		Air	
Tool life		0,25	1



Test 3		Competition	Ingersoll
Material		Quenched and tempered steel C45E	
Insert		SOMT140520ER-LD	UNLU0904M0TR
Grade		PR1535	IN6537
Tool diameter	(mm)	66	
Cutting speed Vc	(m/min)	170	
Feed rate fz	(mm)	1,17	0,951
Cooling		Air	
Tool life		0,33	1
Metal removal rate	(cm ³ /min)	323	421



GRADE IN6537

Inserts in IN6537

The following inserts are available in the new grade **IN6537**:

Item-Nr.	Designation	Item-Nr.	Designation
6338567	ANHU160708R	6257495	SDXS0904MPR-MR
6338570	AOMT170508R	3724086	SDXS130515R-PH K
6265513	BOMT09T304R	3723672	SDXS1305MPR-MM K
6265514	BOMT09T308R	6257496	SDXS1305MPR-MR
6258640	BOMT130404R	3723674	SDXS1305MPR-MR1
6265515	BOMT130408R	3723872	SDXS1605MPR-MM
3721157	DGM212R100 J	6257497	SDXS1605MPR-MR
3721164	DGM212R101 J	3723871	SDXS1605MPR-MR1
3724658	DGM324R300 A	6257498	SDXS1906MPR-MR
6321693	HNGU0605ANTR-M	6236177	SQGU1105ANR-M
6266167	HNGU0605ANTR-MM	6247140	SQGU1406ANR-M
6326075	HNGU1007ANTR-HR	6338587	THLS100508R
6321159	HNGU1007ANTR-M	6253059	UNHU060320R-HF
6266168	HNGU1007ANTR-MM	6253060	UNHU090432R-HF
6260995	MNHU060308R	6253061	UNHU110640R-HF
6260996	MNHU090408R-M	6253062	UNHU140750R-HF
6321649	MNHU110608PNR-M	6252699	UNLU0402M0TR
6260997	MNHU110608R-M	6338573	UNLU0603M0TR
6321650	MNHU140708PNR-M	6338574	UNLU0904M0TR
6187984	MNHU140708R-M	6187873	UNLU1105M0TR
3723055	ONCU0505ANTN-HR J	6247677	UNLV0603M0TR
3716643	PNCU0805GNTR J	3723737	WCNT060205FR-FL
6338577	RNLU1205MON-M	3723736	WCNW060205TR
6338578	RNLU1205MON-S	6265517	WNMU04T304N
6217351	RNLU1606MON-M	6265518	WNMU060608N
6249517	RNLU1606MON-S	6265516	ZOMT130404R
3097954	RPLX10T3MON-HR1	6345462	ZOMT170508R
3723857	SDXS0603MPR-MM		
6257494	SDXS0603MPR-MR		
3723629	SDXS0904MPR-MM		



Ingersoll Cutting Tools

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