

NEW

Member IMC Group
Ingersoll
Cutting Tools

SPEEDUP
HIGH SPEED & FEED

DIPOSFEEED

HIGH FEED MILLS AND
INSERTS UNLU04/-06/-09/-11

VERSATILE HIGH FEED MILLS WITH STRONG 4-EDGED INSERTS

- Insert with 4 cutting edges •
- Improved productivity •
- Smooth cutting and excellent insert rigidity •
- Applies to a variety of applications •
- 4 insert sizes with 2 resp. 3 geometrys each and 4 different grades •



Product Overview

DiPosFeed family has been extended with new inserts UNLU04, UNLU09 and UNLU11 and cutters.

To meet market demand, smaller double-sided four corner designed **UNLU04** inserts have been launched for small and high feed machining applications.

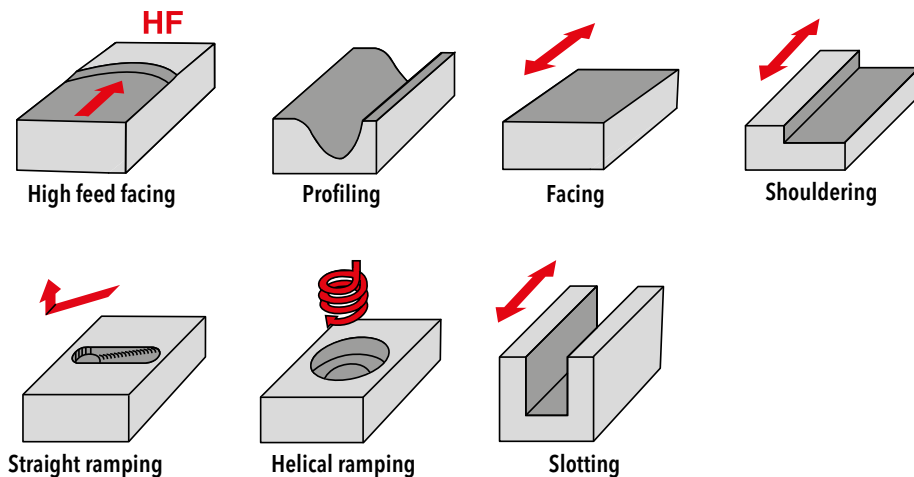
The smaller size inserts mean more inserts can be mounted to the same diameter cutters, which will greatly improve productivity over the existing UNLU06 type under similar conditions. These are available from Ø10 (Z2) to Ø20 (Z5) as end mills and from Ø10 (Z2) to Ø32 (Z8) as screw-in type mills and also as modular ChipSurfer connection 'TS'.

The cutters come in all types: face mill, end mill and modular types.

As part of the new campaign, the design of the new DiPosFeed series underlines Ingersoll's new direction. The new logo will also be applied to all UNLU indexable inserts and milling cutters.

In order to complete the high feed program of the double-sided UNLU inserts, in addition to the existing 6 mm and the new 4 mm, the sizes 9 mm and 11 mm have also been included in the program. Thus, the tool diameter range from Ø10 - Ø 100 mm is covered within this series.

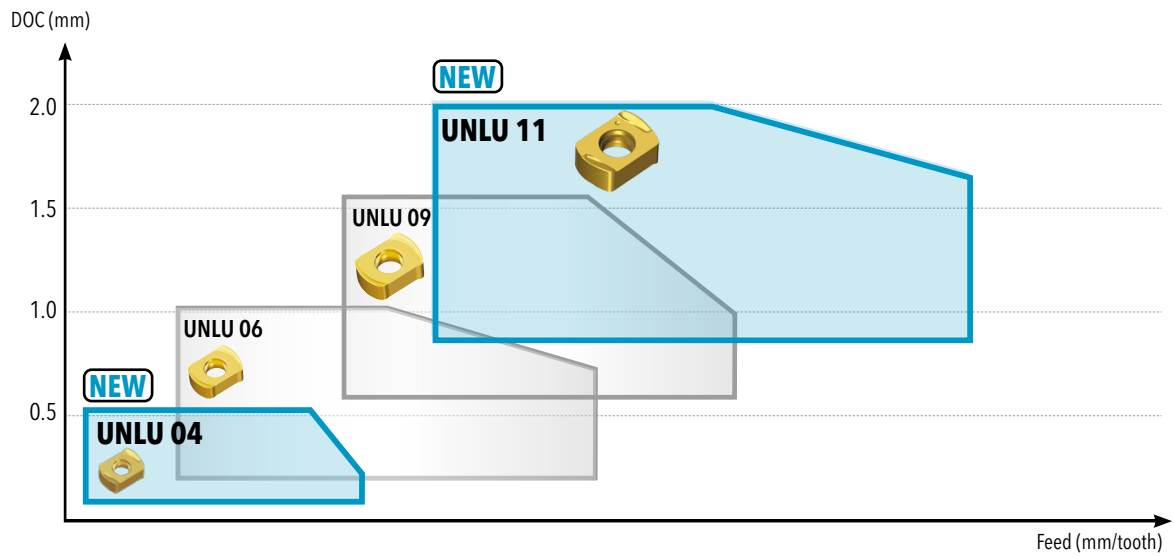
Application Range



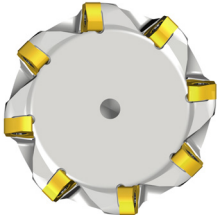
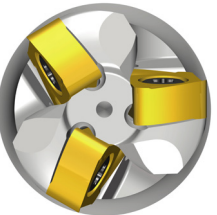
Advantages

- Double-sided four corners insert
- Smaller insert size means more inserts can be fitted into similar size cutters (improved productivity)
- Smooth cutting and excellent insert rigidity
- Applies to a variety of applications
- 4 insert sizes with 2 resp. 3 geometries each and 4 different grades

UNLU Application Range



Maximum Number of Teeth by Diameter

Insert Diameter	UNLU 04	UNLU 06	UNLU 09	UNLU 11
Ø10	2	-	-	-
Ø12	3	-	-	-
Ø16	4	2	-	-
Ø20	5	3	-	-
Ø25	7	4	2	-
Ø30	-	5	3	-
Ø32	8	5	4	3
				



UNLU04



Insert:	UNLU0402M0TR	UNLU0402M0TR-ML
Recomm. cutting depth:	ap = 0,5 mm	ap = 0,5 mm
Machining group:	P / M / K / H	M / S

Recommended cutting data

ISO	material	cutting speed Vc [m/min]				feed per tooth fz [mm]
		1st choice dry machining resp. wear resistant carbide		1st choice wet machining resp. rough carbide		
P	unalloyed steel	IN2505 / IN2504	160 – 220	IN6537	130 – 180	0,5 – 1,0
	alloyed steel 800 N/mm²	IN2505 / IN2504	140 – 200	IN6537	110 – 160	0,5 – 0,8
	alloyed steel 1100 N/mm²	IN2505 / IN2504	120 – 180	IN6537	100 – 150	0,5 – 0,7
M	stainless steel	IN6537 / IN2535	90 – 150	IN6537 / IN2535	80 – 130	0,5 – 0,8
K	gray cast iron	IN2505 / IN6537	160 – 250	IN6537	140 – 200	0,5 – 1,0
	nodular cast iron	IN2505 / IN6537	140 – 200	IN6537	120 – 170	0,5 – 0,8
N	aluminum	–	–	–	–	–
S	high temperature alloys	IN6537	50 – 80	IN6537 / IN2535	50 – 70	0,3 – 0,6
	titanium alloys	–	–	IN6537 / IN2535	30 – 40	0,3 – 0,6
H	hard machining < 54 HRC	IN2504	60 – 100	–	–	0,2 – 0,5
	hard machining < 63 HRC	–	–	–	–	–

Tips:

- The worse the material machinability, the smaller the tool engagement should be chosen.
- The smaller the cutting tool diameter, the higher the cutting speed can be.
- Approach feed should be reduced by 30%.
- 4-edged insert
- Programming radius R0,9

Ramping data and circular interpolation:

tool diameter [mm]	max. ramp. angle [°]	min. bore dia. [mm]	max. ap/rev. [mm]	max. bore dia. [mm]
10	0,6	16,6	0,2	10
12	1	20,6	0,4	24
16	1	28,6	0,5	32
20	1	36,6	0,5	40
25	0,7	46,6	0,5	50
32	0,6	60,6	0,5	64

General information:

Insert screw: **SM18-041-00**

Torque: **0,5 Nm**

Torque wrench: **DTN005S with bit DS-TP06TB**

UNLU06



Insert	UNLU0603M0TR	UNLU0603M0TR - ML	UNLU0603M0TR - MM
Recomm. cutting depth:	ap = 0,8 mm	ap = 0,5 mm	ap = 0,6 mm
max. cutting depth:	ap = 1,0 mm	ap = 1,0 mm	ap = 1,0 mm
Machining group:	P / M / K / H	S	M / S

Recommended cutting data

ISO	material	cutting speed Vc [m/min]				feed per tooth fz [mm]
		1st choice dry machining resp. wear resistant carbide		1st choice wet machining resp. rough carbide		
P	unalloyed steel	IN2505 / IN2504	160 – 220	IN6537	130 – 180	0,7 – 1,3
	alloyed steel 800 N/mm²	IN2505 / IN2504	140 – 200	IN6537	110 – 160	0,6 – 1,2
	alloyed steel 1100 N/mm²	IN2505 / IN2504	120 – 180	IN6537	100 – 150	0,5 – 1
M	stainless steel<	IN2036	90 – 150	IN2036 / IN6537	80 – 130	0,6 – 0,9
K	gray cast iron	IN2505 / IN2504	160 – 250	IN6537	140 – 200	0,7 – 1,3
	nodular cast iron	IN2505 / IN2504	140 – 200	IN6537	120 – 170	0,5 – 1
N	aluminum	–	–	–	–	–
S	high temperature alloys	IN2036	50 – 80	IN2036	50 – 70	0,4 – 0,7
	titanium alloys	–	–	IN2036 / IN6537	30 – 40	0,3 – 0,6
H	hard machining < 54 HRC	IN2504	60 – 100	–	–	0,2 – 0,5
	hard machining < 63 HRC	–	–	–	–	–

Tips:

- The worse the material machinability, the smaller the tool engagement should be choosen.
- The smaller the cutting tool diameter, the higher the cutting speed can be.
- Approach feed should be reduced by 30%.
- For 16 mm tool diameter max. feed ap = 0,7 mm.

- 4-edged insert
- Programming radius R2

Ramping data and circular interpolation:

tool diameter [mm]	max. ramp. angle [°]	min. bore dia. [mm]	max. ap/rev. [mm]	bore dia. flat bottom [mm]	max. ap/rev. [mm]	max. bore dia. [mm]	max. ap/rev. [mm]
16 R2	2,0	22,1	0,6	25,4	1,0	32	1,0
20 R2	1,8	28,6	0,8	32,3	1,0	40	1,0
25 R2	1,3	38,4	0,9	42,3	1,0	50	1,0
30 R2	1,0	48,4	1,0	52,3	1,0	60	1,0
32 R2	1,0	52,4	1,0	56,3	1,0	64	1,0
35 R2	0,8	58,4	1,0	62,3	1,0	70	1,0
40 R2	0,8	68,2	1,0	72,3	1,0	80	1,0
42 R2	0,7	72,3	1,0	76,3	1,0	84	1,0
50 R2	0,6	88,1	1,0	92,3	1,0	100	1,0
52 R2	0,6	92,1	1,0	96,2	1,0	104	1,0
63 R2	0,5	113,9	1,0	118,2	1,0	126	1,0
66 R2	0,5	120,0	1,0	124,2	1,0	132	1,0
80 R2	0,4	147,9	1,0	152,2	1,0	160	1,0
85 R2	0,4	157,9	1,0	162,2	1,0	170	1,0

General information:

Insert screw: **SM25-064-00**

Torque: **1,1 Nm**

Torque wrench: **DTN011S with bit DS-T08TB**

UNLU09



Insert:	UNLU0904MOTR	UNLU0904MOTR-ML	UNLU0904MOTR-MM
Recomm. cutting depth:	ap = 1,0 mm	ap = 0,8 mm	ap = 0,8 mm
max. Schnitttiefe:	ap = 1,5 mm	ap = 1,5 mm	ap = 1,5 mm
Machining group:	P / M / K / H	S	M / S

Recommended cutting data

ISO	material	cutting speed Vc [m/min]				feed per tooth fz [mm]
		1st choice dry machining resp. wear resistant carbide		1st choice wet machining resp. rough carbide		
P	unalloyed steel	IN2505 / IN2504	160 – 220	IN6537	130-180	0,8-1,5
	alloyed steel 800 N/mm²	IN2505 / IN2504	140 – 200	IN6537	110-160	0,8-1,3
	alloyed steel 1100 N/mm²	IN2505 / IN2504	120 – 180	IN6537	100-150	0,8-1,2
M	stainless steel	IN6537 / IN2036	90 – 150	IN6537 / IN2036	80-130	0,7-1,0
K	gray cast iron	IN2505 / IN6537	160 – 250	IN6537	140-200	0,8-1,5
	nodular cast iron	IN2505 / IN6537	140 – 200	IN6537	120-170	0,8-1,2
N	aluminum	-	-	-	-	-
S	high temperature alloys	IN2036	50 – 80	IN2036	50-70	0,7-1,0
	titanium alloys	-	-	IN2036	30-40	0,7-0,9
H	hard machining < 54 HRC	IN2504	60 – 100	-	-	0,4-0,7
	hard machining < 63 HRC	-	-	-	-	-

Tips:

- The worse the material machinability, the smaller the tool engagement should be chosen.
- The smaller the cutting tool diameter, the higher the cutting speed can be.
- Approach feed should be reduced by 30%.
- 4-edged insert
- Programming radius R2,5

Ramping data and circular interpolation:

tool diameter [mm]	max. ramp. angle [°]	min. bore dia. [mm]	max. ap/rev. [mm]	max. bore dia. [mm]
25	3,0	42	1,5	50
32	2,0	56	1,5	64
35	1,5	59	1,5	70
40	1,3	72	1,5	80
42	1,1	76	1,5	84
50	1,0	92	1,5	100
52	1,0	96	1,5	104
63	0,8	118	1,5	126
66	0,8	124	1,5	132
80	0,8	152	1,5	160

General information:

Insert screw: **SM35-088-10**

Torque: **3,0 Nm**

Torque wrench: **DTN030S with bit DS-T10TB**

UNLU11



Insert:	UNLU1105MOTR	UNLU1105MOTR-ML
Recomm. cutting depth:	ap = 1,5 mm	ap = 1,2 mm
max. Schnitttiefe:	ap = 2,0 mm	ap = 2,0 mm
Machining group:	P / M / K / H	M / S

Recommended cutting data

ISO	material	cutting speed Vc [m/min]				feed per tooth fz [mm]
		1st choice dry machining resp. wear resistant carbide		1st choice wet machining resp. rough carbide		
P	unalloyed steel	IN2505 / IN2504	160 – 220	IN6537	130-180	0,8-2,0
	alloyed steel 800 N/mm²	IN2505 / IN2504	140 – 200	IN6537	110-160	0,8-1,8
	alloyed steel 1100 N/mm²	IN2505 / IN2504	120 – 180	IN6537	100-150	0,8-1,6
M	stainless steel	IN6537	90 – 150	IN6537	80-130	0,8-1,2
K	gray cast iron	IN2505 / IN6537	160 – 250	IN6537	140-200	0,8-2,0
	nodular cast iron	IN2505 / IN6537	140 – 200	IN6537	120-170	0,8-1,6
N	aluminum	–	–	–	–	–
S	high temperature alloys	IN6537	50 – 80	IN6537	50-70	0,8-1,4
	titanium alloys	–	–	IN6537	30-40	0,7-1,2
H	hard machining < 54 HRC	IN2504	60 – 100	–	–	0,5-1,0
	hard machining < 63 HRC	–	–	–	–	–

Tips:

- The worse the material machinability, the smaller the tool engagement should be choosen.
- The smaller the cutting tool diameter, the higher the cutting speed can be.
- Approach feed should be reduced by 30%.
- 4-edged insert
- Programming radius R3,0

Ramping data and circular interpolation:

tool diameter [mm]	max. ramp. angle [°]	min. bore dia.[mm]	max. ap/rev.[mm]	max. bore dia.[mm]
30	0,5	41	2	60
32	0,5	45	2	64
35	0,5	51	2	70
40	0,55	61	2	80
42	0,5	65	2	84
50	0,5	81	2	100
52	0,45	85	2	104
63	0,45	107	2	126
66	0,4	113	2	132
80	0,35	141	2	160
100	0,3	181	2	200
125	0,25	231	2	250
160	0,2	301	2	320
200	0,15	381	2	400

General information:

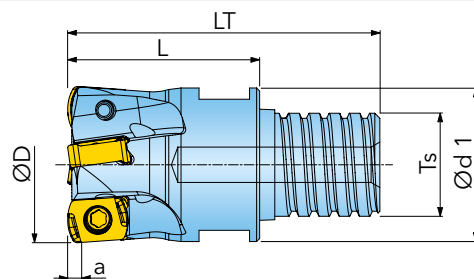
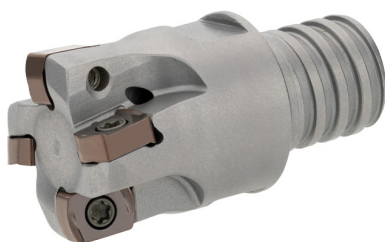
Insert screw: **TS 50A1211/HG**

Torque: **6,0 Nm**

Torque wrench: **DTNV00S with bit DS-T20TB**

DIPOS^{FEED} HIGH FEED MILL 1TG1B...

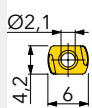
FOR EXCHANGEABLE HEAD SYSTEM



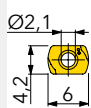
Designation	D	d1	LT	L	a	Rp	Ts	Z		IK	kg
1TG1B010016T6R00	10	9,7	22,65	16	0,5	0,9	T6	2	0,6	✓	0,01
1TG1B012017T8R00	12	11,5	25,0	17	0,5	0,9	T8	3	1,0	✓	0,01
1TG1B016019TTR00	16	15,2	30,8	19	0,5	0,9	T10	4	1,0	✓	0,03
1TG1B020022TSR00	20	18,3	35,8	22	0,5	0,9	T12	5	1,0	✓	0,05
1TG1B025032TUR00	25	23,9	49,6	32	0,5	0,9	T15	7	0,7	✓	0,10

Rp = Programming radius

UNLU0402MOTR



UNLU0402MOTR-ML



Designation	fz(min/max)	Design	Grade	IN2504	IN2505	IN6537					
UNLU0402MOTR	0,20/0,70	semi-positive geometry									
UNLU0402MOTR-ML	0,20/0,70	positive geometry									

● = P ● = M ● = K ● = N ● = S ○ = H

SPARE PARTS



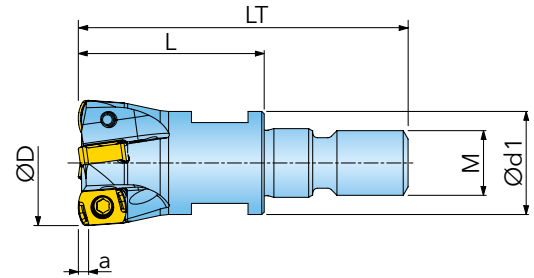
Special thread

	T6	T8	T10	T12	T15
SM18-041-00 (0,5Nm)	TXPLUS06x90-B	WS-0029 (10,0Nm)	WS-0030 (15,0Nm)	WS-0044 (28,0Nm)	WS-0059 (28,0Nm)
SM18-041-00 (0,5Nm)	TXPLUS06x90-B	WS-0061 (28,0Nm)			

① = Insert screw ② = Torx bit ③ = Wrench

DIPOSFEED HIGH FEED MILL 1TG1B...X

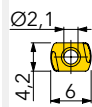
SCREW-IN TYPE ADAPTION



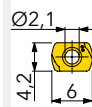
Designation	D	d1	LT	L	a	Rp	M	Z		 IK	 kg
1TG1B010017X4R00	10	9,7	31,5	17	0,5	0,9	M6	2	0,6	✓	0,01
1TG1B012017X4R00	12	11	31,5	17	0,5	0,9	M6	3	1,0	✓	0,01
1TG1B016023X5R01	16	13	40,8	23	0,5	0,9	M8	3	1,0	✓	0,03
1TG1B016023X5R00	16	13	40,8	23	0,5	0,9	M8	4	1,0	✓	0,03
1TG1B020023X6R00	20	18	42,8	23	0,5	0,9	M10	5	1,0	✓	0,05
1TG1B025027X7R00	25	21	49	27	0,5	0,9	M12	7	0,7	✓	0,09
1TG1B032027X8R00	32	29	51	27	0,5	0,9	M16	8	0,6	✓	0,15

Rp = Programming radius

UNLU0402M0TR



UNLU0402M0TR-ML



Designation	fz(min/max)	Design	Grade	IN2504	IN2505	IN6537					
UNLU0402M0TR	0,20/0,70	semi-positive geometry									
UNLU0402M0TR-ML	0,20/0,70	positive geometry									

● = P ● = M ● = K ● = N ● = S ○ = H

SPARE PARTS



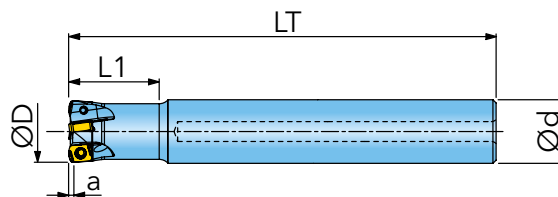
SM18-041-00 (0,5Nm)

TXPLU506x90-B

① = Insert screw ② = Torx bit

DIPOSF^{FEED} HIGH FEED CUTTER 1TG1B...T

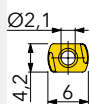
ADAPTION ACC. TO DIN 1835 A



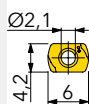
Designation	D	d	LT	L1	a	Rp	Z		IK	kg
1TG1B010020T1R00	10	10	100	20	0,5	0,9	2	0,6	✓	0,05
1TG1B012020T2R00	12	12	110	20	0,5	0,9	3	1,0	✓	0,08
1TG1B016025T3R00	16	16	150	25	0,5	0,9	4	1,0	✓	0,20
1TG1B020025T4R00	20	20	200	25	0,5	0,9	5	1,0	✓	0,44

Rp = Programming radius

UNLU0402MOTR



UNLU0402MOTR-ML



Designation	fz(min/max)	Design	Grade	IN2504	IN2505	IN6537					
UNLU0402MOTR	0,20/0,70	semi-positive geometry		●	●	●					
UNLU0402MOTR-ML	0,20/0,70	positive geometry			●						

● = P ● = M ● = K ● = N ● = S ○ = H

SPARE PARTS

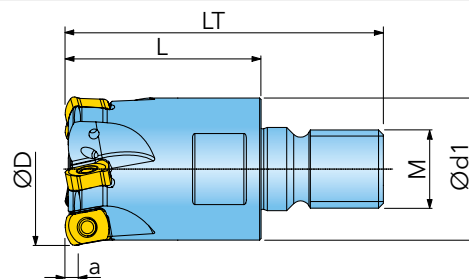


SM18-041-00 (0,5Nm) TXPLUS06x90-B

① = Insert screw ② = Torx bit

DIPOSFEED HIGH FEED MILL 1TG1F...X

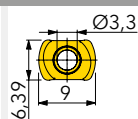
SCREW-IN TYPE ADAPTION



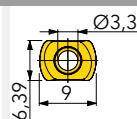
Designation	D	d1	LT	L	a	Rp	M	Z			
1TG1F016025X5R00	16	13	42,8	25	1	1,6	M8	2	2	✓	0,03
1TG1F020030X6R00	20	18	49,8	30	1	1,9	M10	3	1,8	✓	0,05
1TG1F025035X7R00	25	21	57	35	1	1,9	M12	4	1,3	✓	0,09
1TG1F030043X8R00	30	29	67	43	1	1,9	M16	5	1	✓	0,21
1TG1F032040X8R00	32	29	64	40	1	1,9	M16	5	1	✓	0,21
1TG1F032040X8R01	32	29	64	40	1	1,9	M16	6	1	✓	0,21
1TG1F035043X8R00	35	29	67	43	1	1,9	M16	5	0,8	✓	0,24
1TG1F035043X8R01	35	29	67	43	1	1,9	M16	4	0,8	✓	0,24
1TG1F042043X8R00	42	29	67	43	1	1,9	M16	6	0,7	✓	0,28
1TG1F042043X8R01	42	29	67	43	1	1,9	M16	5	0,7	✓	0,28

Rp = Programming radius

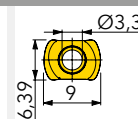
UNLU0603MOTR



UNLU0603MOTR-MM



UNLU0603MOTR-ML



Designation	fz(min/max)	Design	Grade	IN2036	IN2504	IN2505	IN6537				
UNLU0603MOTR	0,50/1,2	semi-positive geometry									
UNLU0603MOTR-MM	0,50/1,00	positive geometry									
UNLU0603MOTR-ML	0,50/1,00	Inconel and titanium geometry									

● = P ● = M ● = K ● = N ● = S ○ = H

SPARE PARTS



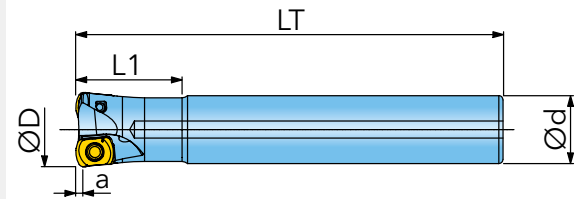
SM25-064-00 (1,1Nm)

TX08x90-B

① = Insert screw ② = Torx bit

DIPOS^{FEED} HIGH FEED MILL 1TG1F...T/U

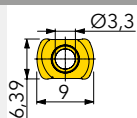
ADAPTION ACC. TO DIN 1835 A



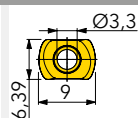
Designation	D	d	LT	L1	a	Rp	Z		
1TG1F016030T3R00	16	16	100	30	1	1,6	2	✓	0,14
1TG1F020050T4R00	20	20	130	50	1	1,9	3	✓	0,26
1TG1F025060T5R00	25	25	140	60	1	1,9	4	✓	0,44
1TG1F030070U7R00	30	32	150	70	1	1,9	5	✓	0,76
1TG1F032070U7R01	32	32	150	70	1	1,9	6	✓	0,81
1TG1F032070U7R00	32	32	150	70	1	1,9	5	✓	0,81
1TG1F040090U7R00	40	32	150	40	1	1,9	6	✓	0,96

Rp = Programming radius

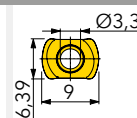
UNLU0603M0TR



UNLU0603M0TR-MM



UNLU0603M0TR-ML



Designation	fz(min/max)	Design	Grade	IN2036	IN2504	IN2505	IN6537				
UNLU0603M0TR	0,50/1,20	semi-positive geometry									
UNLU0603M0TR-MM	0,50/1,00	positive geometry									
UNLU0603M0TR-ML	0,50/1,00	Inconel and titanium geometry									

● = P ● = M ● = K ● = N ● = S ○ = H

SPARE PARTS



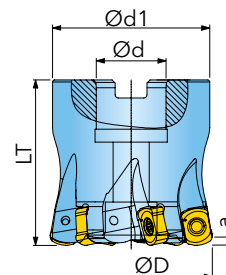
SM25-064-00 (1,1Nm)

TX08x90-B

① = Insert screw ② = Torx bit

DIPOSFEED HIGH FEED MILL TG1F

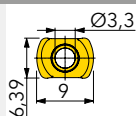
ADAPTION ACC. TO DIN 8030



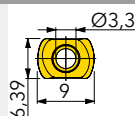
Designation	D	d	d1	LT	a	Rp	Z			
TG1F032R00	32	16	30	40	1	1,9	5	1	✓	0,12
TG1F032R01	32	16	30	40	1	1,9	6	1	✓	0,11
TG1F040R00	40	22	38	40	1	1,9	6	0,8	✓	0,19
TG1F042R00	42	22	38	40	1	1,9	6	0,7	✓	0,25
TG1F042R10	42	16	38	40	1	1,9	6	0,7	✓	0,28
TG1F050R00	50	22	45	50	1	1,9	7	0,6	✓	0,39
TG1F052R00	52	22	40	50	1	1,9	7	0,6	✓	0,37
TG1F063R00	63	22	48	50	1	1,9	8	0,5	✓	0,67
TG1F066R00	66	27	58	50	1	1,9	8	0,5	✓	0,69
TG1F080R00	80	27	60	50	1	1,9	9	0,4	✓	1,35
TG1F085R00	85	27	70	50	1	1,9	9	0,4	✓	1,40

Rp = Programming radius

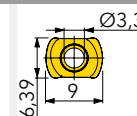
UNLU0603M0TR



UNLU0603M0TR-MM



UNLU0603M0TR-ML



Designation	fz(min/max)	Design	Grade	IN2036	IN2504	IN2505	IN6537				
UNLU0603M0TR	0,50/1,20	semi-positive geometry									
UNLU0603M0TR-MM	0,50/1,00	positive geometry									
UNLU0603M0TR-ML	0,50/1,00	Inconel and titanium geometry									

● = P ● = M ● = K ● = N ● = S ○ = H

SPARE PARTS



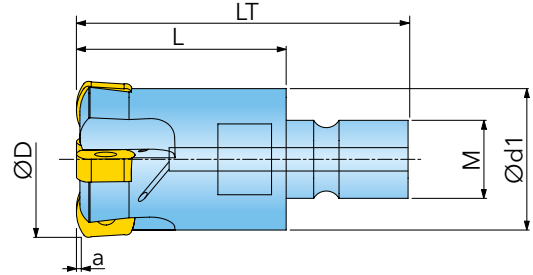
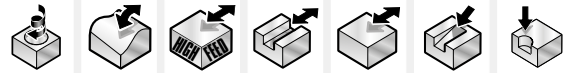
SM25-064-00 (1,1Nm)

TX08x90-B

① = Insert screw ② = Torx bit

DIPOSFEEED HIGH FEED MILL 1TG1G...X

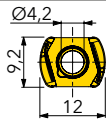
SCREW-IN TYPE ADAPTION



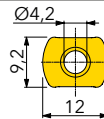
Designation	D	d1	LT	L	a	Rp	M	Z		IK	kg
1TG1G025035X7R00	25	21,0	57	35	1,5	2,5	M12	2	3	✓	0,22
1TG1G025035X7R01	25	21,0	57	35	1,5	2,5	M12	3	3	✓	0,10
1TG1G032043X8R00	32	29,0	67	43	1,5	2,5	M16	3	2	✓	0,22
1TG1G032043X8R01	32	29,0	67	43	1,5	2,5	M16	4	2	✓	0,22
1TG1G035043X8R01	35	29,0	67	43	1,5	2,5	M16	3	1,5	✓	0,23
1TG1G035043X8R00	35	29,0	67	43	1,5	2,5	M16	4	1,5	✓	0,24
1TG1G040043X8R01	40	29,0	67	43	1,5	2,5	M16	4	1,3	✓	0,27
1TG1G040043X8R00	40	29,0	67	43	1,5	2,5	M16	5	1,3	✓	0,28
1TG1G042043X8R00	42	29,0	67	43	1,5	2,5	M16	5	1,1	✓	0,30

Rp = Programming radius

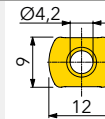
UNLU0904M0TR



UNLU0904M0TR-MM



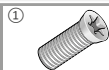
UNLU0904M0TR-ML



Designation	fz(min/max)	Design	Grade	IN2036	IN2504	IN2505	IN6537				
UNLU0904M0TR	0,40/1,50	semi-positive geometry		●	●	●	●				
UNLU0904M0TR-MM	0,40/1,50	positive geometry		●		●					
UNLU0904M0TR-ML	0,40/1,50	Inconel and titanium geometry		●		●					

● = P ● = M ● = K ● = N ● = S ○ = H

SPARE PARTS

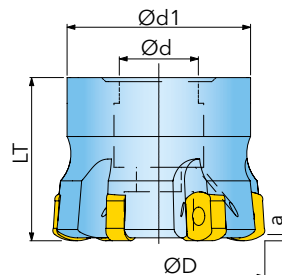


SM35-088-10 (3,0Nm) TX10x90-B

① = Insert screw ② = Torx bit

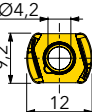
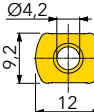
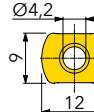
DIPOSFEED HIGH FEED MILL TG_G

ADAPTION ACC. TO DIN 8030



Designation	D	d	d1	LT	a	Rp	Z			
TG2G050R00	50	22,0	45,0	50	1,5	2,5	6	1	✓	0,41
TG1G050R00	50	22,0	45,0	50	1,5	2,5	7	1	✓	0,42
TG2G052R00	52	22,0	45,0	40	1,5	2,5	6	1	✓	0,35
TG1G052R00	52	22,0	45,0	40	1,5	2,5	7	1	✓	0,36
TG2G063R00	63	22,0	47,0	50	1,5	2,5	6	0,8	✓	0,63
TG1G063R00	63	22,0	47,0	50	1,5	2,5	8	0,8	✓	0,62
TG2G066R00	66	27,0	58,0	50	1,5	2,5	5	0,8	✓	1,60
TG1G066R00	66	27,0	58,0	50	1,5	2,5	8	0,8	✓	0,78
TG2G080R00	80	27,0	70,0	50	1,5	2,5	8	0,8	✓	1,18
TG1G080R00	80	27,0	70,0	50	1,5	2,5	10	0,8	✓	1,20

Rp = Programming radius

UNLU0904MOTR			UNLU0904MOTR-MM			UNLU0904MOTR-ML						
												
Designation	fz(min/max)	Design	Grade	IN2036	IN2504	IN2505	IN6537					
UNLU0904MOTR	0,40/1,50	semi-positive geometry										
UNLU0904MOTR-MM	0,40/1,50	positive geometry										
UNLU0904MOTR-ML	0,40/1,50	Inconel and titanium geometry										

● = P ● = M ● = K ● = N ● = S ○ = H

SPARE PARTS

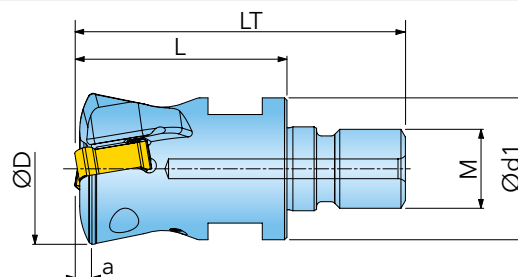


SM35-088-10 (3,0Nm) TX10x90-B

① = Insert screw ② = Torx bit

DIPOS^{FEED} HIGH FEED MILL 1TG1J...X

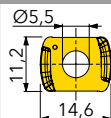
SCREW-IN TYPE ADAPTION



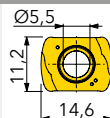
Designation	D	d1	LT	L	a	Rp	M	Z		IK	kg
1TG1J030043X8R00	30	29	67	43	2	3,0	M16	2	0,5	✓	0,18
1TG1J032043X8R00	32	29	67	43	2	3,0	M16	2	0,5	✓	0,19
1TG1J035043X8R00	35	29	67	43	2	3,0	M16	3	0,5	✓	0,19
1TG1J040043X8R00	40	29	67	43	2	3,0	M16	3	0,5	✓	0,21
1TG1J042043X8R00	42	29	67	43	2	3,0	M16	3	0,5	✓	0,22

Rp = Programming radius

UNLU1105M0TR



UNLU1105M0TR-ML



Designation	fz(min/max)	Design	Grade	IN2504	IN2505	IN6537					
UNLU1105M0TR	0,50/2,00	semi-positive geometry		●	●	●					
UNLU1105M0TR-ML	0,50/2,00	positive geometry			●						

● = P ● = M ● = K ● = N ● = S ○ = H

SPARE PARTS



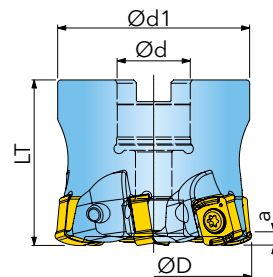
TS 50A1211/HG (6Nm)

TX10x90-B

① = Insert screw ② = Torx bit

DIPOSFEED HIGH FEED MILL TG_J

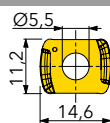
ADAPTION ACC. TO DIN 8030



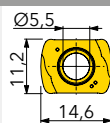
Designation	D	d	d1	LT	a	Rp	Z			
TG2J050R00	50	22	45	40	2	3,0	4	0,50	✓	0,30
TG1J050R00	50	22	45	40	2	3,0	5	0,50	✓	0,30
TG1J052R00	52	22	45	40	2	3,0	5	0,45	✓	0,30
TG2J063R00	63	22	58	50	2	3,0	5	0,45	✓	0,70
TG1J063R00	63	22	58	50	2	3,0	6	0,45	✓	0,70
TG1J066R00	66	22	58	50	2	3,0	6	0,40	✓	0,80
TG1J066R01	66	27	58	50	2	3,0	6	0,40	✓	0,75
TG2J080R00	80	27	70	60	2	3,0	6	0,35	✓	1,40
TG1J080R00	80	27	70	60	2	3,0	7	0,35	✓	1,40
TG2J100R00	100	32	85	60	2	3,0	6	0,30	✓	2,20
TG1J100R00	100	32	85	60	2	3,0	7	0,30	✓	2,20

Rp = Programming radius

UNLU1105M0TR



UNLU1105M0TR-ML



Designation	fz(min/max)	Design	Grade	IN2504	IN2505	IN6537					
UNLU1105M0TR	0,50/2,00	semi-positive geometry									
UNLU1105M0TR-ML	0,50/2,00	positive geometry									

● = P ● = M ● = K ● = N ● = S ○ = H

SPARE PARTS



TS 50A1211/HG (6Nm)

TX10x90-B

① = Insert screw ② = Torx bit

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DIPOSFEED