

INGERSOLL INTRODUCES...A NEW 45 DEGREE LEAD QUAD HI SHEAR FACE MILL!

**Targeting small & mid-sized
machine spindles requiring
.16" DOC or less.**

MULTI-CUT™

- **DIAMETER RANGE
FROM 1.250 - 4.00**
- **COOLANT THROUGH**
- **STRONG 3.5 MM
INSERT SCREW**
- **MULTI-PURPOSE GRADES
FOR STEELS, STAINLESS
STEEL, HI TEMP ALLOYS
AND IRON**



MULTICUT™ HIGH SHEAR 45° FACE MILL SERIES 5N6G

Diameters
1.250" to 4.000"

Max. Depth of Cut
.158"

Insert Corner
.055" x 45



Facing



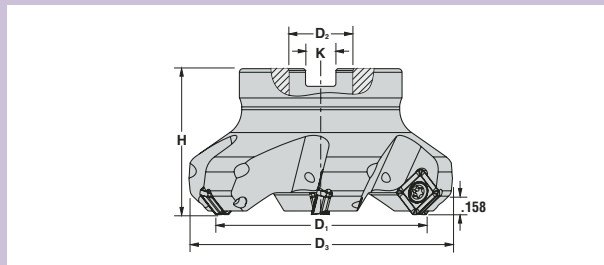
Lead Angle



Chamfer

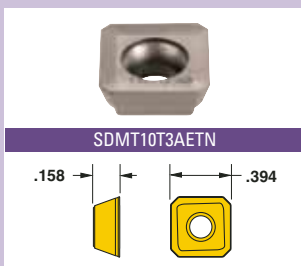


Coolant Thru



D ₁ Effective Diameter	Cutter Number	Number of Inserts	H Height	D ₂ Bore Diameter	D ₃ Overall Diameter	Retention Bolt	K Keyway
1.250	5N6G-12R01	4	1.57	0.500	1.70	SD-04-46	.25
1.500	5N6G-15R01	4	1.57	0.750	1.95	SD-06-46	.31
2.000	5N6G-20R01	5	1.57	0.750	2.45	SD-06-46	.31
2.500	5N6G-25R01	6	1.57	0.750	2.95	SD-06-46	.31
3.000	5N6G-30R01	7	2.00	1.000	3.45	SD-08-46	.38
4.000	5N6G-40R01	8	2.00	1.500	4.44	SD-12-82	.63

INSERTS



Insert Number	Application	Corner	Grades		
			IN	2030	2015
SDMT10T3AETN	Multi-Purpose	.055 x 45	■	■	

HARDWARE

Insert Screw		Driver	Preset Torque Driver	Torx Bit
Part No.	Torque	Part No.	Part No.	Part No.
SM35-087-70	30-35 in. lbs.	DS-T15T (Tx-15)	DT-35-02	DS-T15B1

■ OPERATING GUIDELINES

Material	Brinell Hardness	SFM	Feed per Insert	Grades		Coolant
				IN2030	IN2015	
Aluminum	6061-T6, 7075-T6, 2024	-	1500-3000	.004-.010	1	Yes
Cast Iron	Gray	150-250	300-1000	.004-.010	1	No
	Nodular	150-250	300-600		1	
Steel	Low Carbon 1018, 8620	150-250	400-1000	.004-.010	1	No
	High Carbon F-6180	250-400	350-500			
	Alloyed Steel 4140, 4340	150-300	300-700			
	Tool Steel A-6, D-1, D-2	Up to 300				
Stainless Steel	300 Series, 304, 316	-	300-700	.004-.010	1	? @Hi Speeds
	400 Series, 15-5 PH	-	400-900			
	13-8 PH	-	200-400			Yes
Nickel Alloys	Inconel 600, 706, 718, 903,	-	75-120	.003-.006	1	Yes
	Hastelloy, Waspalloy	-				
Titanium	6AL-4V	-	100-150	.003-.006	1	Yes

*Preferred for higher surface footage.