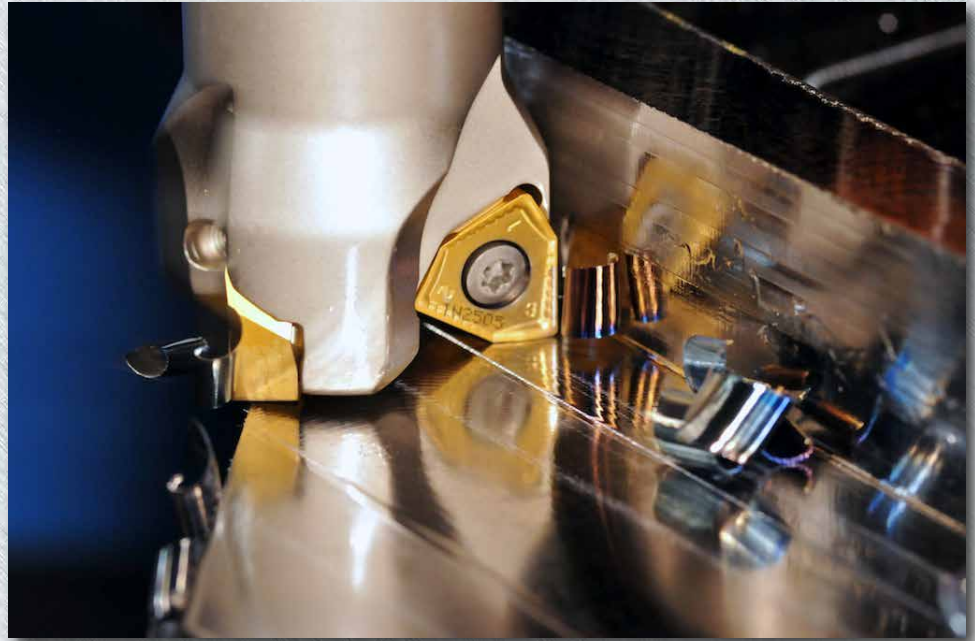


## 90° ROUGH AND FINISH MILL WITH 6 CUTTING EDGES!



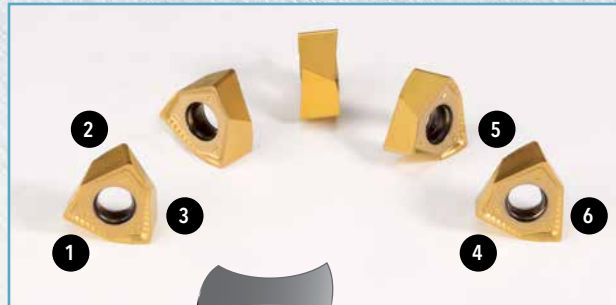
**Diameters:**  
1.00" - 6.00"

**Depth of Cut:**  
WNGU09 - .24  
WNGU13 - .36

**Corner Configurations:**  
.015", .020", .031", .039", .062"R

**Applications:**  
Roughing, finishing, one-cuts,  
channel milling and  
cutting 90° shoulders

**Materials:**  
Cast iron, steel, stainless steels,  
titanium, high-temp alloys



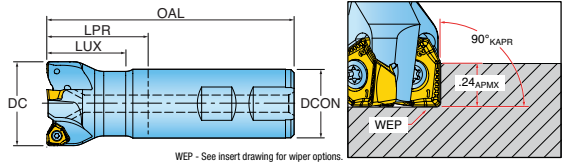
### Features & Benefits

- Positive and efficient helical cutting edge action
- Integrated wiper flats for 20-32 Ra surface finishes
- Coolant through the tool
- Thick insert for durable applications

**PRODUCT  
ANNOUNCEMENT  
UPDATE  
2018**

**SERIES 1DJ1F (WELDON STYLE) (09 INSERTS)**

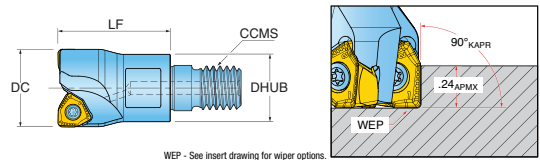
90° ROUGH & FINISH END MILL



Part Number	DC Cutting Dia.	LUX Usable Length Max.	LPR Protruding Length	OAL Overall Length	ZEFF Effective Teeth	DCON Shank Dia.
1DJ1F-1001584R01	1.000	1.50	1.50	3.50	2	0.750
1DJ1F-1001780R01	1.000	1.70	1.75	4.00	2	1.000
1DJ1F-1003780R01	1.000	3.70	3.75	6.00	2	1.000
1DJ1F-1201584R01	1.250	1.50	1.50	3.50	3	0.750
1DJ1F-1202281R01	1.250	2.20	2.25	4.50	3	1.250
1DJ1F-1204281R01	1.250	4.20	4.25	6.50	3	1.250
1DJ1F-1502281R01	1.500	2.20	2.25	4.50	4	1.250

**SERIES 1DJ1F (TOP-ON STYLE) (09 INSERTS)**

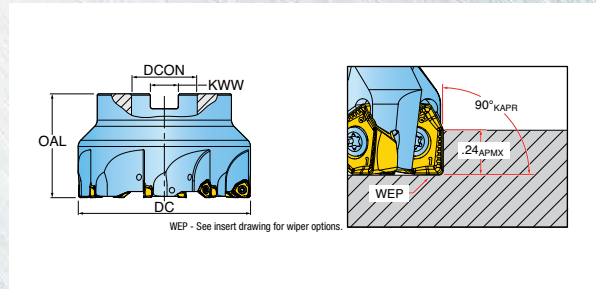
90° ROUGH & FINISH END MILL



Part Number	DC Cutting Dia.	LF Functional Length	ZEFF Effective Teeth	CCMS Connection Code Machine Side
1DJ1F-10015X7R01	1.000	1.50	2	TopOn M12
1DJ1F-12017X8R01	1.250	1.75	3	TopOn M16

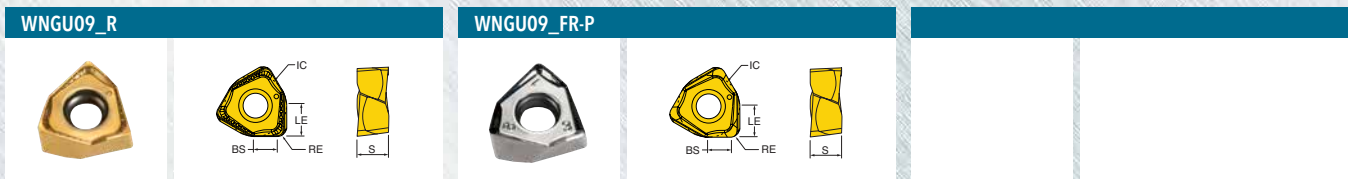
**SERIES DJ5F, DJ6F (09 INSERTS)**

90° ROUGH & FINISH FACE MILL



Part Number	DC Cutting Dia.	OAL Overall Length	ZEFF Effective Teeth	DCON Shank Dia.	KWW Keyway	RMPX Ramp Angle Max.
DJ5F-20R01	2.000	2.000	1.57	5	0.750	0.312
DJ5F-20R02	2.000	2.000	1.57	6	0.750	0.312
DJ5F-25R01	2.500	2.500	1.57	6	0.750	0.312
DJ5F-30R01	3.000	3.000	1.75	7	1.000	0.375
DJ5F-30R02	3.000	3.000	1.75	9	1.000	0.375
DJ5F-40R01	4.000	4.000	2.38	11	1.500	0.625
DJ6F-40R01	4.000	4.000	2.38	8	1.500	0.625

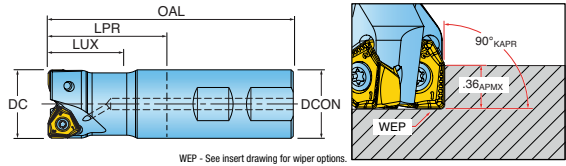
**09 INSERTS**



Part Number	Application	RE/BCH Corner Radius/ Chamfer	BS Wiper Length	LE Cutting Edge Length	IC Inscribed Circle Dia.	S Thickness (To Cutting Edge)	NOI Number of Indexes	IH Insert Hand	Grade	IN2505	IN2510	IN2530	IN2540	IN10K
WNGU090404R	Multi-Purpose	0.015 R	0.093	0.240	0.365	0.187	6	Right	•					
WNGU090405R	Multi-Purpose	0.020 R	0.093	0.240	0.365	0.187	6	Right	•					
WNGU090408R	Multi-Purpose	0.031 R	0.077	0.240	0.365	0.187	6	Right	•	•	•	•		
WNGU090410R	Multi-Purpose	0.039 R	0.069	0.240	0.365	0.187	6	Right	•					
WNGU090416R	Multi-Purpose	0.062 R	0.046	0.240	0.365	0.187	6	Right	•	•	•			
WNGU090404FR-P	Non-Ferrous	0.015 R	0.093	0.240	0.365	0.187	6	Right						•
WNGU090408FR-P	Non-Ferrous	0.031 R	0.077	0.240	0.365	0.187	6	Right						•

**SERIES 1DJ1P (WELDON STYLE) (13 INSERTS)**

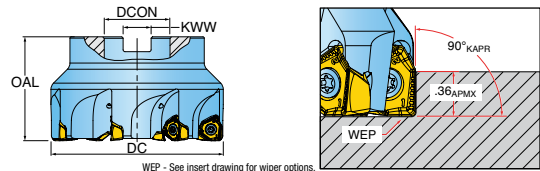
**90° ROUGH & FINISH END MILL**



Part Number	DC Cutting Dia.	LUX Usable Length Max.	LPR Protruding Length	OAL Overall Length	ZEFF Effective Teeth	DCON Shank Dia.
1DJ1P-1202281R01	1.250	2.20	2.25	4.50	2	1.250
1DJ1P-1204281R01	1.250	4.20	4.25	6.50	2	1.250
1DJ1P-1502281R01	1.500	2.25	2.25	4.50	3	1.250
1DJ1P-1504281R01	1.500	4.20	4.25	6.50	3	1.250
1DJ1P-2002281R01	2.000	2.25	2.25	4.50	5	1.250

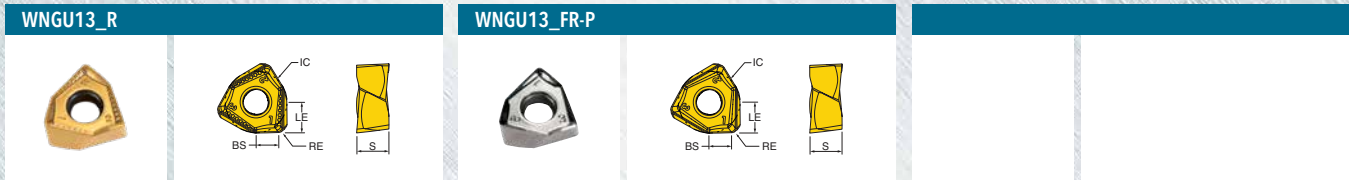
**SERIES DJ5P, DJ6P (13 INSERTS)**

**90° ROUGH & FINISH FACE MILL**









Part Number	DC Cutting Dia.	DCX Cutting Dia. Max.	OAL Overall Length	ZEFF Effective Teeth	DCON Shank Dia.	KWW Keyway	CSP Coolant
DJ5P-20R01	2.000	2.000	1.57	5	0.750	0.312	Yes
DJ6P-20R01	2.000	2.000	1.57	4	0.750	0.312	Yes
DJ5P-25R01	2.500	2.500	1.57	6	0.750	0.312	Yes
DJ5P-30R01	3.000	3.000	1.75	7	1.000	0.375	Yes
DJ5P-30R02	3.000	3.000	1.75	9	1.000	0.375	Yes
DJ5P-40R01	4.000	4.000	2.38	8	1.500	0.625	Yes
DJ5P-40R02	4.000	4.000	2.38	11	1.500	0.625	Yes
DJ5P-60R01	6.000	6.000	2.00	16	1.500	0.625	No
DJ6P-60R01	6.000	6.000	2.00	12	1.500	0.625	No

## 13 INSERTS



Part Number	Application	RE/BCH Corner Radius/ Chamfer	BS Wiper Length	LE Cutting Edge Length	IC Inscribed Circle Dia.	S Thickness (To Cutting Edge)	NOI Number of Indexes	IH Insert Hand	Grade	IN2505	IN2510	IN2530	IN2540	IN10K
WNGU130604R	Multi-Purpose	0.015 R	0.086	0.360	0.514	0.265	6	Right	•					
WNGU130608R	Multi-Purpose	0.031 R	0.078	0.360	0.514	0.265	6	Right	•	•	•	•	•	
WNGU130616R	Multi-Purpose	0.062 R	0.047	0.360	0.514	0.265	6	Right	•	•	•	•	•	
WNGU130604FR-P	Non-Ferrous	0.015 R	0.086	0.360	0.514	0.265	6	Right						•
WNGU130608FR-P	Non-Ferrous	0.031 R	0.078	0.360	0.514	0.265	6	Right						•

## HARDWARE

						
	Insert Screw	Driver	Driver Handle	Driver Blade	Retention Bolt	Optional Coolant Bolt
1DJ1F	SM30-085-10	DS-T09W	-	-	-	-
DJ5F-20R01	SM30-085-10	DS-T09W	-	-	SD-06-46	SD-06-89
DJ5F-20R02	SM30-085-10	DS-T09W	-	-	SD-06-46	SD-06-89
DJ5F-25R01	SM30-085-10	DS-T09W	-	-	SD-06-46	SD-06-89
DJ5F-30R01	SM30-085-10	DS-T09W	-	-	SD-08-46	SD-08-92
DJ5F-30R02	SM30-085-10	DS-T09W	-	-	SD-08-46	SD-08-92
DJ5F-40R01	SM30-085-10	DS-T09W	-	-	SD-12-82	SD-12-99
DJ6F-40R01	SM30-085-10	DS-T09W	-	-	SD-12-82	SD-12-99
1DJ1P	SM40-100-R0	-	DS-A00T	DS-T156B	-	-
DJ5P-20R01	SM40-100-R0	-	DS-A00T	DS-T156B	SD-06-46	SD-06-89
DJ6P-20R01	SM40-100-R0	-	DS-A00T	DS-T156B	SD-06-46	SD-06-89
DJ5P-25R01	SM40-100-R0	-	DS-A00T	DS-T156B	SD-06-46	SD-06-89
DJ5P-30R01	SM40-100-R0	-	DS-A00T	DS-T156B	SD-08-46	SD-08-92
DJ5P-30R02	SM40-100-R0	-	DS-A00T	DS-T156B	SD-08-46	SD-08-92
DJ5P-40R01	SM40-100-R0	-	DS-A00T	DS-T156B	SD-12-82	SD-12-99
DJ5P-40R02	SM40-100-R0	-	DS-A00T	DS-T156B	SD-12-82	SD-12-99
DJ6P-60R01	SM40-100-R0	-	DS-A00T	DS-T156B	-	-

## OPERATING GUIDELINES

DiPos Hexa - Series 1DJ1F, DJ5F, 1DJ1P, DJ5P, DJ6P					IN10K	IN2505	IN2510	IN2530	IN2540	Coolant
Material	Brinnell Hardness	SFM	Feed per Insert							
Aluminum	6061 T6, 7075 T6, 2024	-	1500-8000	.004 - .010	1					
Cast Iron	Gray	150 - 250	300 - 1000	.004 - .010		2	1			No
	Nodular		300 - 600							
Steel	Low Carbon 1018, 8620	150 - 250	400 - 1000	.004 - .010		2		1	3	No
	High Carbon F-6180, Nitralloy 52100	250 - 400	350 - 500	.004 - .008						
	Alloyed Steel 4140, 4340, 6150	150 - 300	300 - 700	.004 - .010						
	Tool Steel A-6, D-1, D-2, P20	Up to 300								
Stainless Steel	300 Series, 304, 316	-	300 - 700	.004 - .010		2		1		May not be required at high speeds
	400 Series 15-5 PH, 17-4 PH	Up to 320	400 - 900							Yes
	13-8 PH	-	200 - 400							Yes
Nickel Alloys	Inconel 600, 706, 718, 903, Hastelloy, Waspalloy	-	75-120	.003 - .006		2		1		Yes
Titanium	6AL-4V	-	100 - 150	.004 - .006		2		1		Yes