

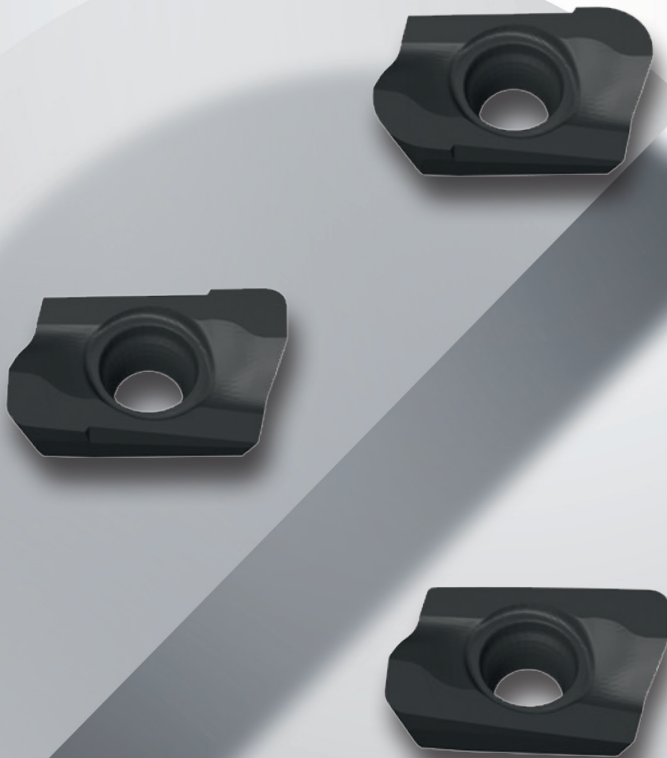


**HiPOS<sup>+</sup>**

PRECISION INSERT BODT09T3...

### GROUND PRECISION INSERT BODT09T3...

- Excellent surface finishes due to an all ground precision insert
- Fits all existing HiPos+ standard cutters for BOMT09
- New carbide grade IN2504 for hard machining



## Product overview

To expand the application range of the popular HiPos+ series for BOMT09T3\_\_R, Ingersoll developed the **all ground precision insert BODT09T3...**

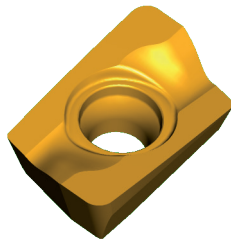
This insert is now part of our standard offering and can be used for finishing operations when **face or shoulder milling**. Best face milling results can be obtained when using the axially adjustable shoulder mill series 2J5P, although **BODT09** fits all existing standard cutters for BOMT09.

For finishing of shoulders and contours in hardened steels, like the ones commonly used in die and mould accounts, the new carbide grade **IN2504** and a recessed insert for a **max. depth of cut of 3 mm** have been developed.

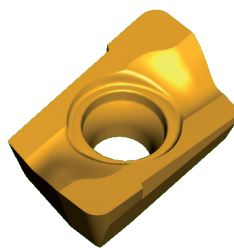
The reduced depth of cut minimizes radial deflections so a **step-free shoulder** is achieved much easier, although there are many parameters that will have an impact on the result.

**High-precision cutters** can be produced upon request.

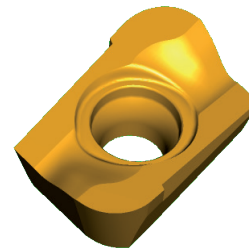
## Insert geometries



**BODT09T308R**  
R0.8 ap max = 8.9 mm



**BODT09T308R-001**  
R0.8 ap max = 3 mm



**BODT09T320R-001**  
R2.0 ap max = 3 mm

## Recommended cutting data for hard machining with IN2504 at 55...63 HRC:

	Vc [m/min]	fz [mm]	ap [mm]	ae [mm]
Finishing of plane surfaces:	50 - 100	0.05 - 0.07	0.2	0.5 - 1xD
Finishing of shoulders:	130 - 200	0.05 - 0.10	0.5 - 2.0	< 0.2

### 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.

## Advantages

- Excellent surface finishes due to an all ground precision insert
- Fits all existing HiPos+ standard cutters for BOMT09
- New carbide grade IN2504 for hard machining