

ANPA

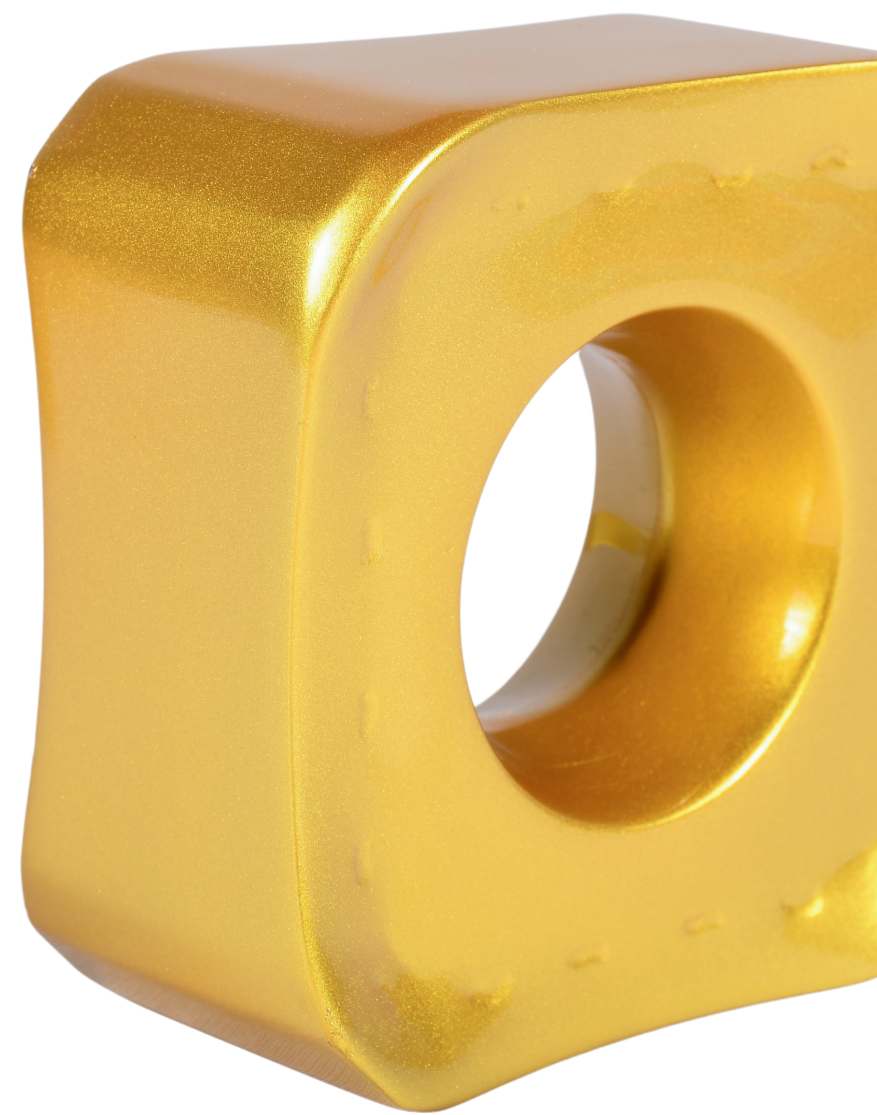
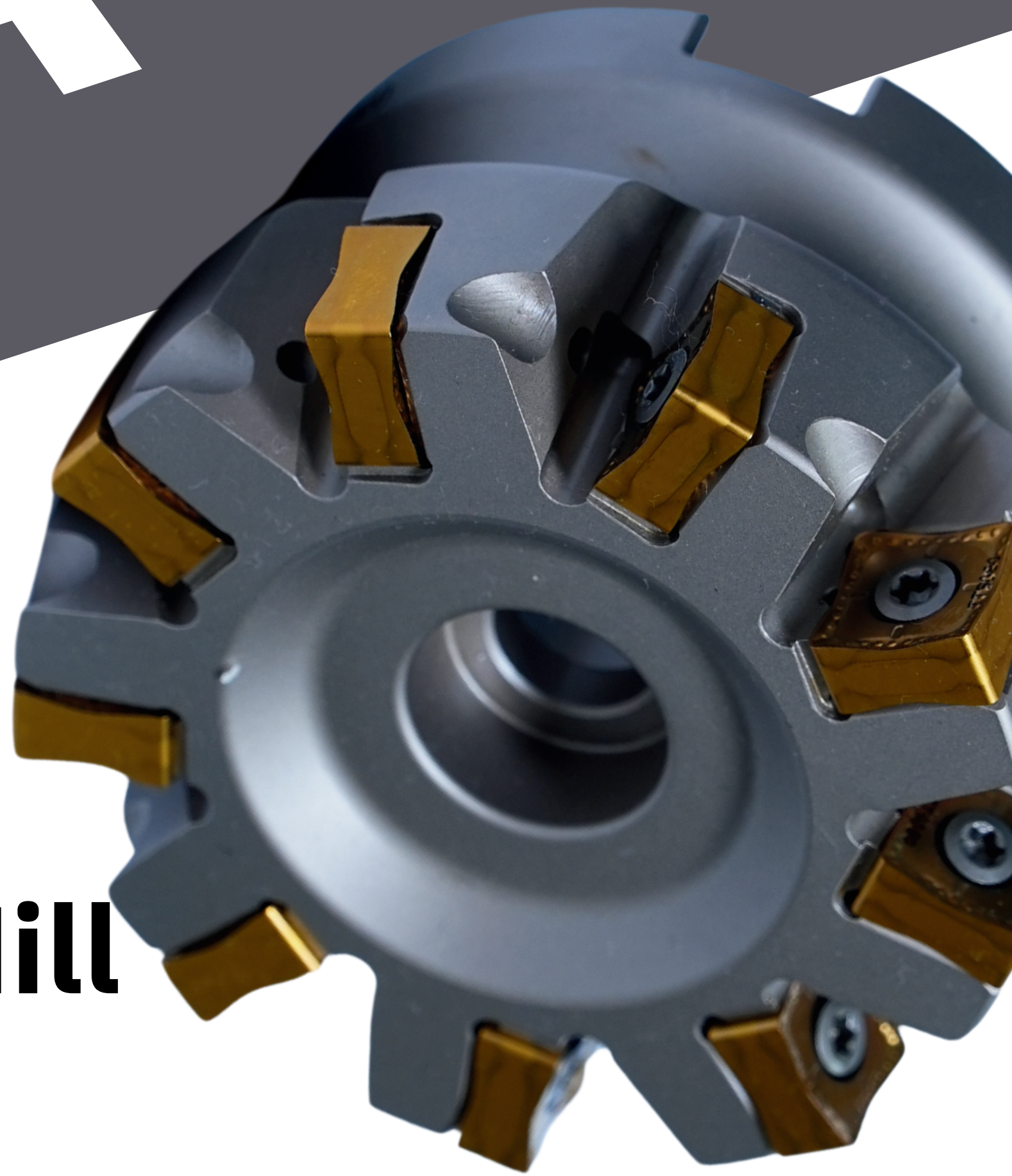
New Product Announcement

March 2025

DC/NPA/001/25

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Introducing D2Mill (88° Facemill)



Duracarb Milling Line New Product Announcement

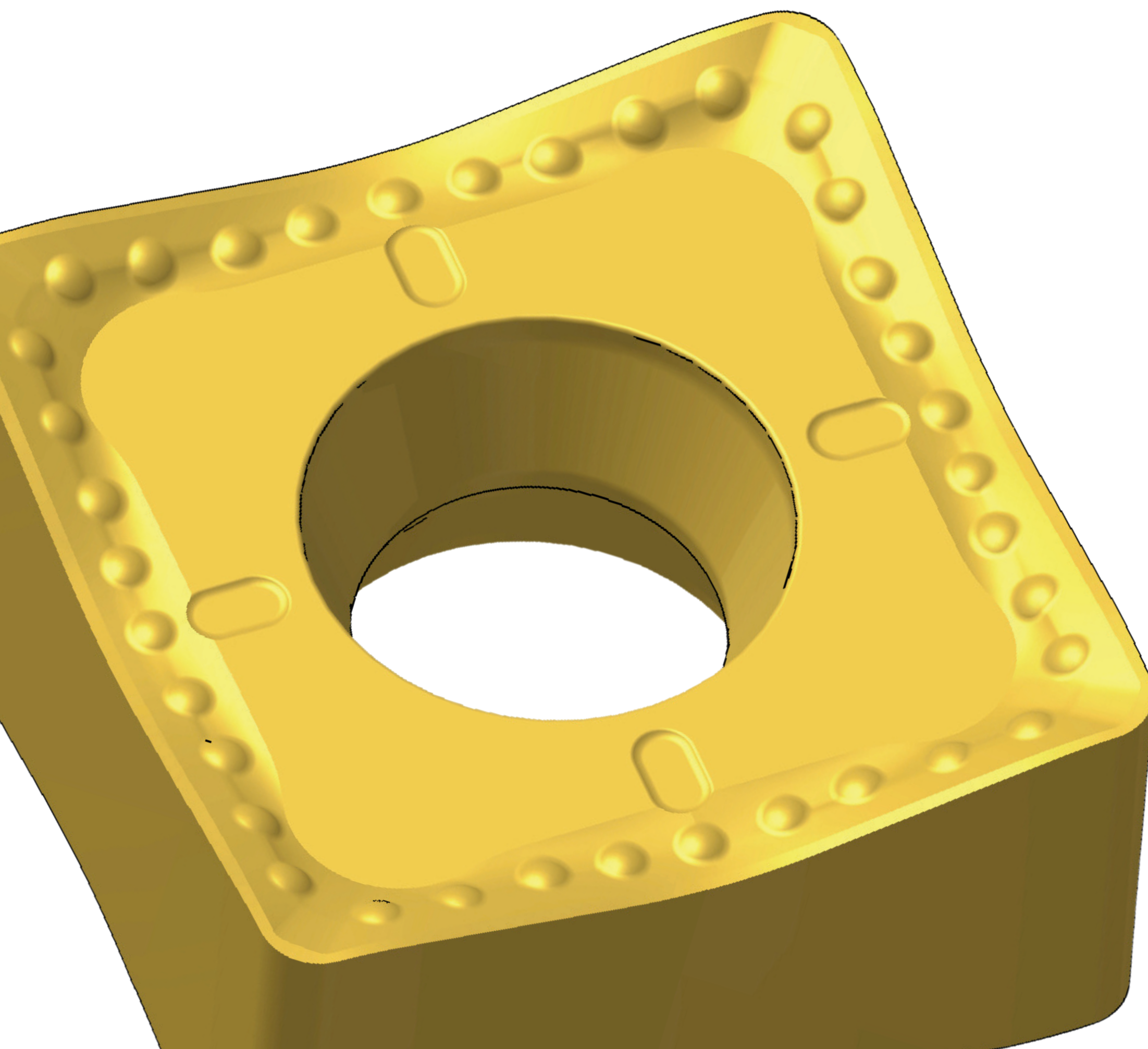
KEY POINT

Face mill cutter with SNGU 12 XNTN insert

Duracarb is proud to announce the launch of D2Mill (88° Facemill) series that opens new possibilities in general and shoulder milling applications. This new line offers cutters in 88° entering angle and can be suitably applied to achieve improved performance in face milling.

The 88° angle cutter is ideal for general milling especially in applications having space restrictions like milling close to shoulders and fixture constraints. The high entering angle enables the milling operation to be performed without obstruction. Ideally suited to general facing and automotive applications.

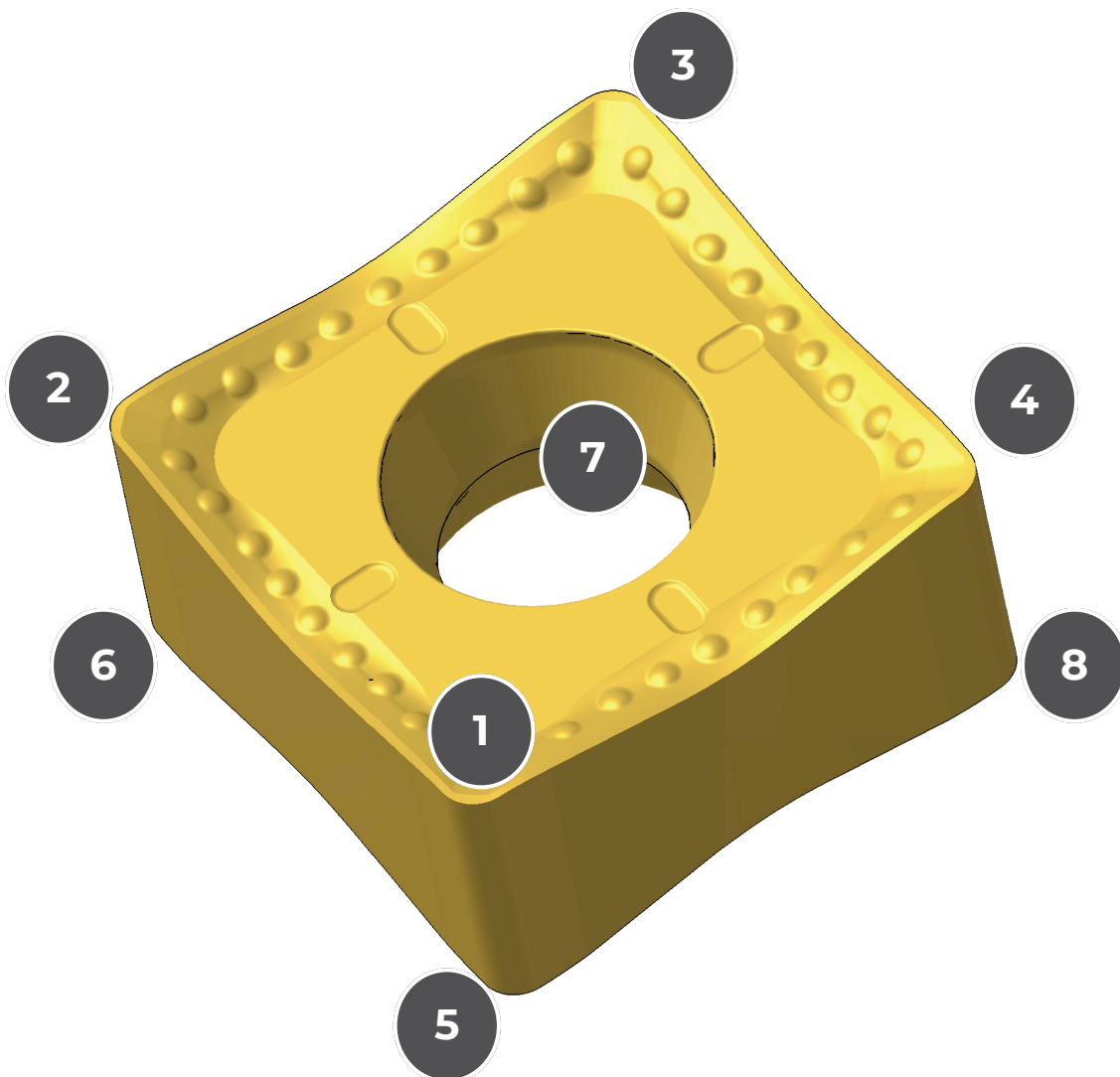
The strong, double sided square insert SNGU 12 XNTN with 8 cutting edges greatly enhances operational economy. The D2Mill cutter and SNGU 12 XNTN insert are loaded with features that increase performance and productivity.



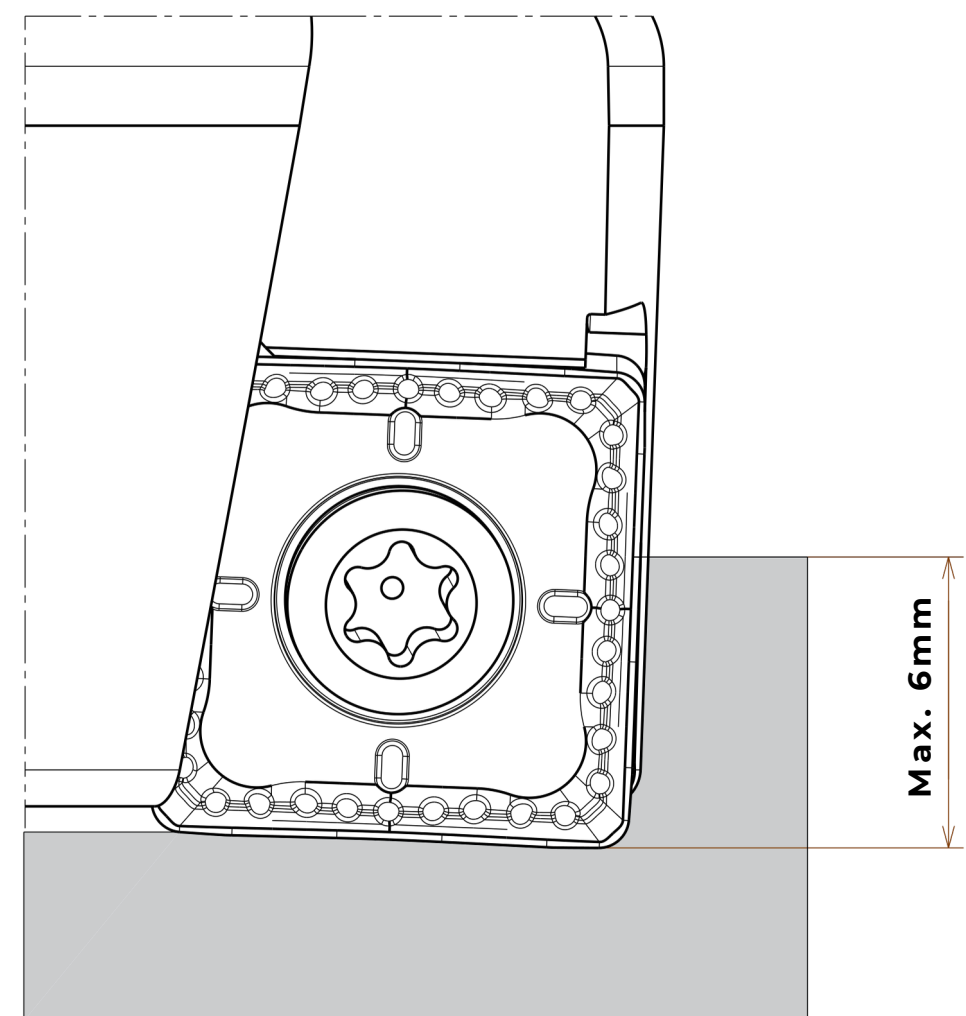
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Features and Benefits

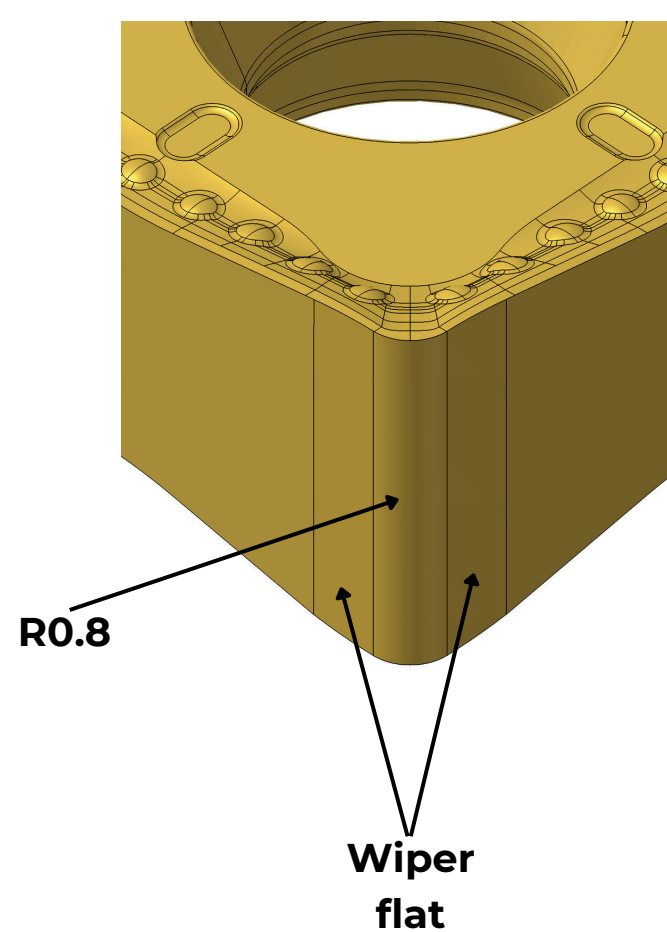
8 cutting edges per insert for economical machining



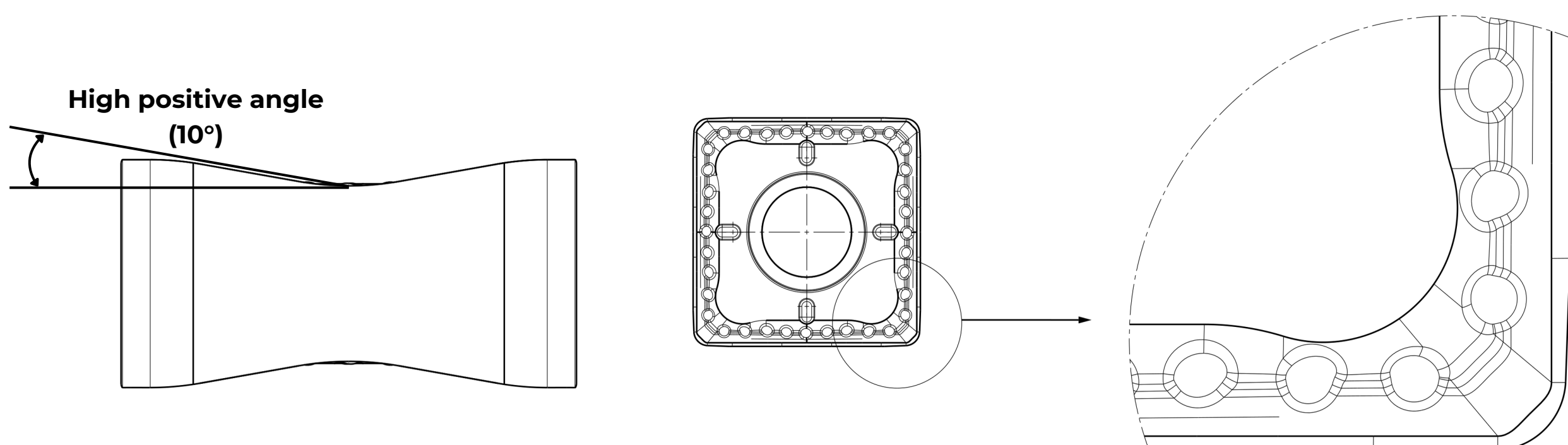
Large depth of cut in face milling operations



Wiper flat with corner R

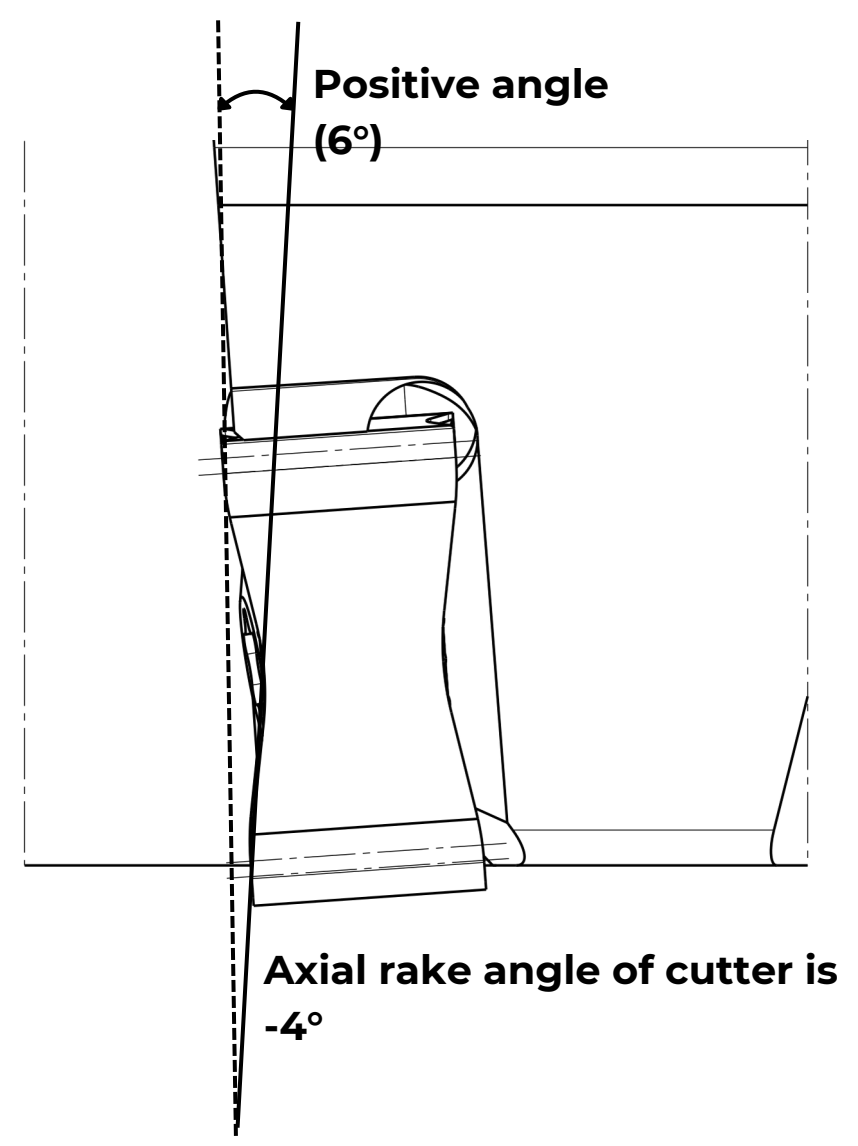
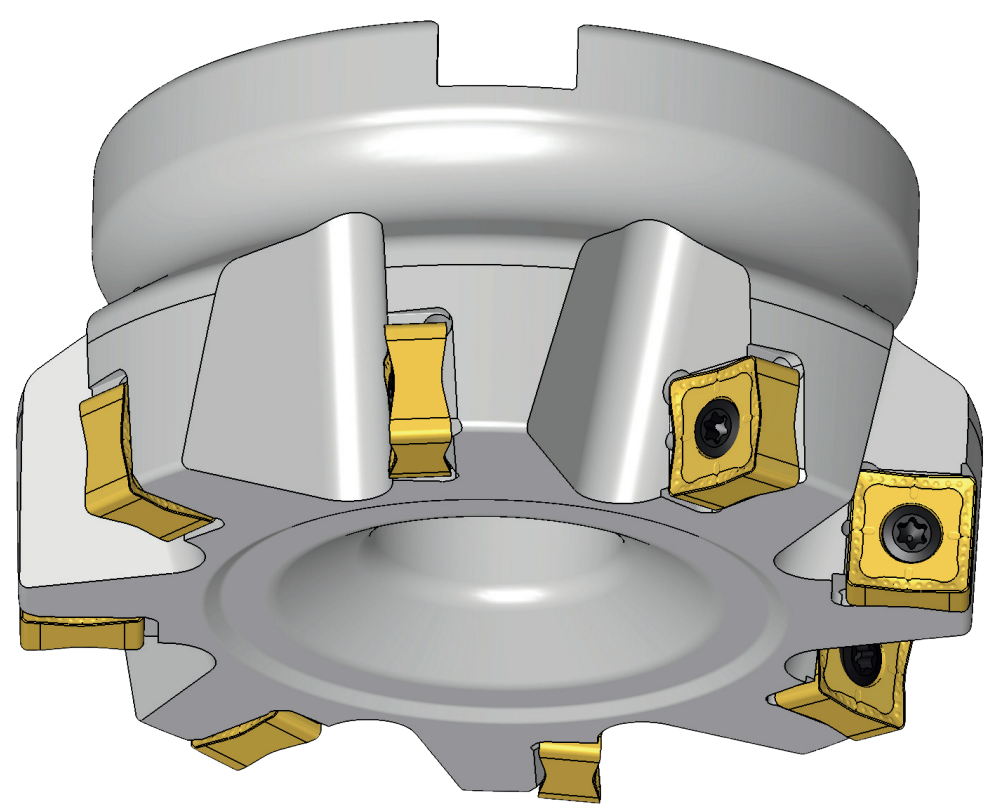


High positive insert geometry and dimple chip breaker lower the cutting forces and temperatures

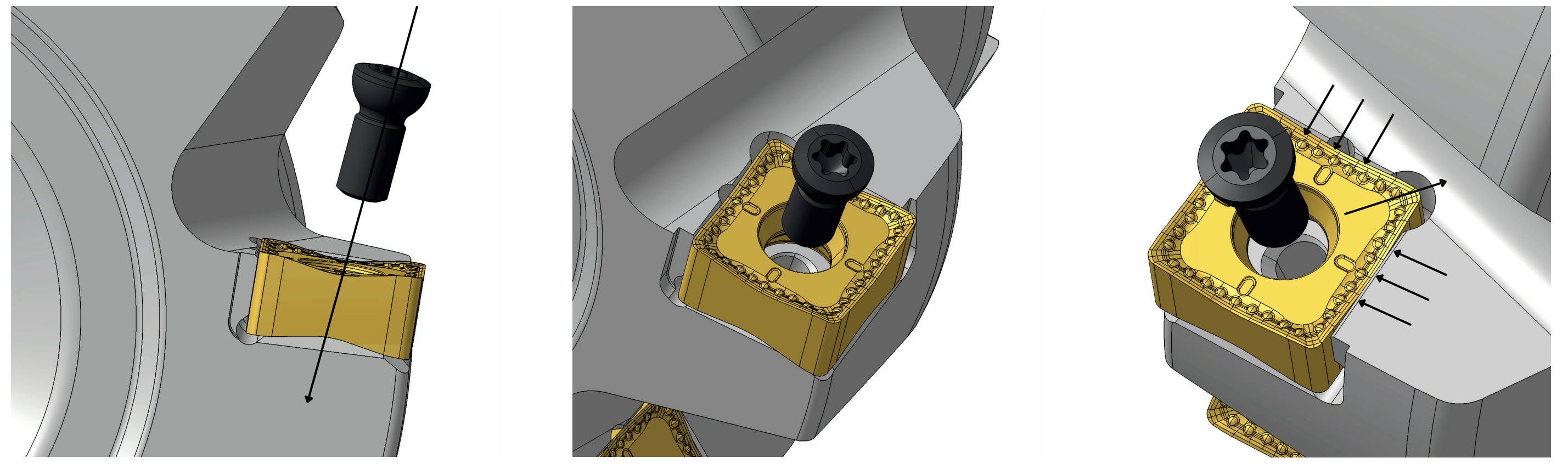


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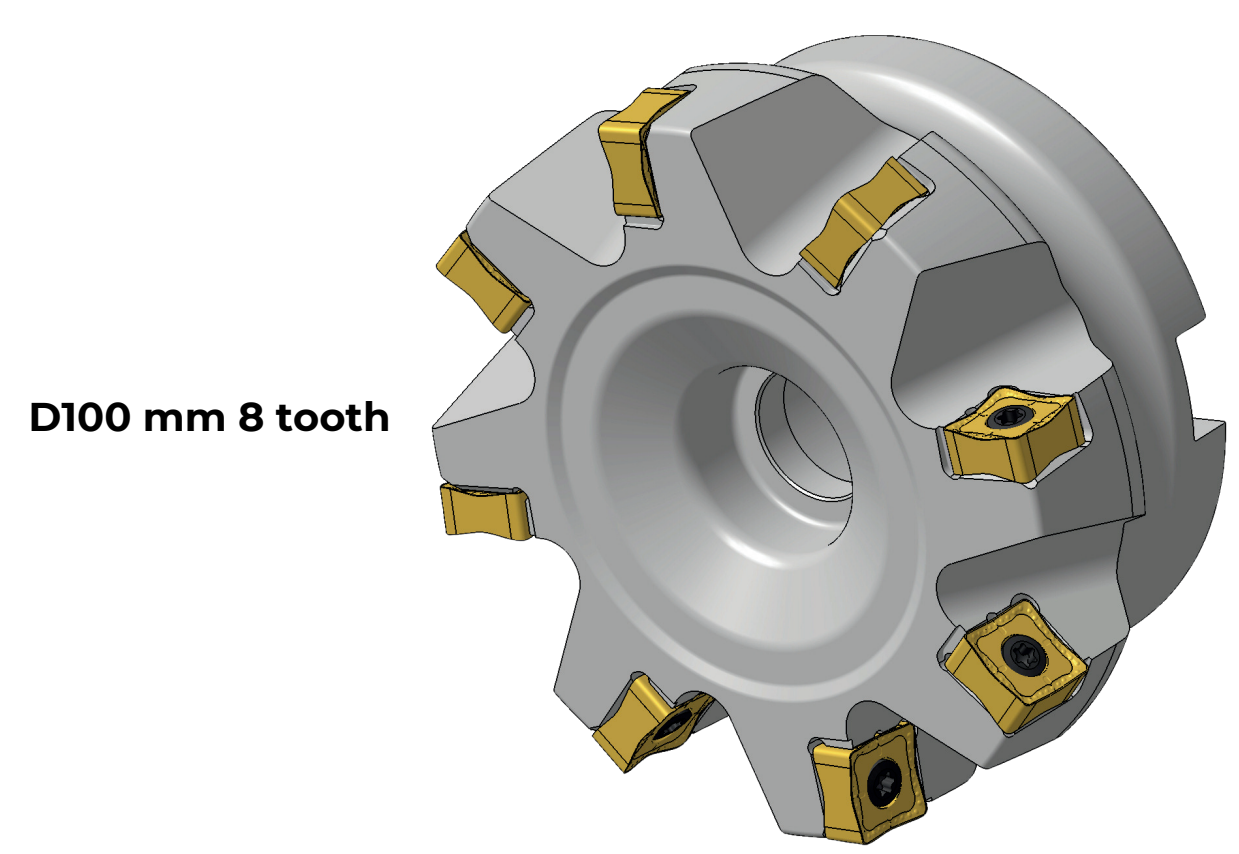
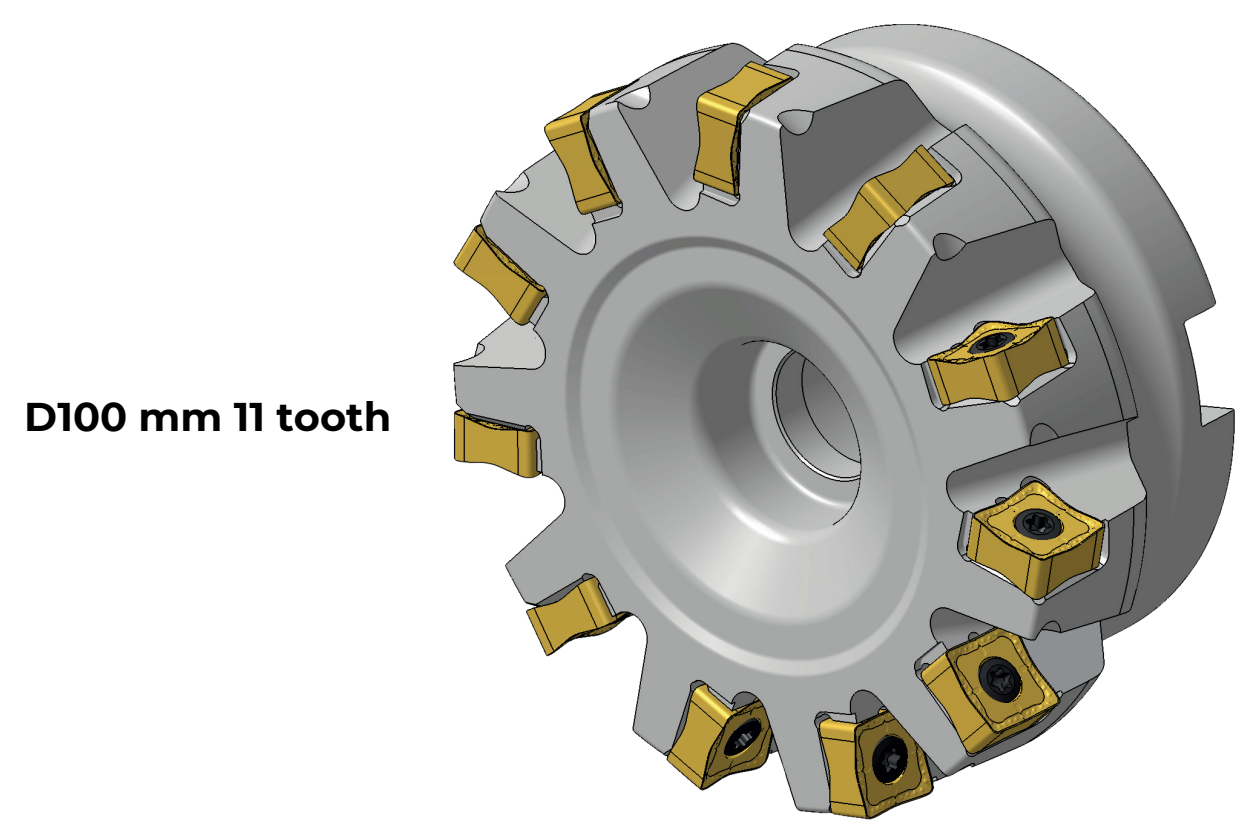
Low power requirement and smooth cutting possible due to positive



Unique angled screw clamping gives secure insert clamping and high density pitch option



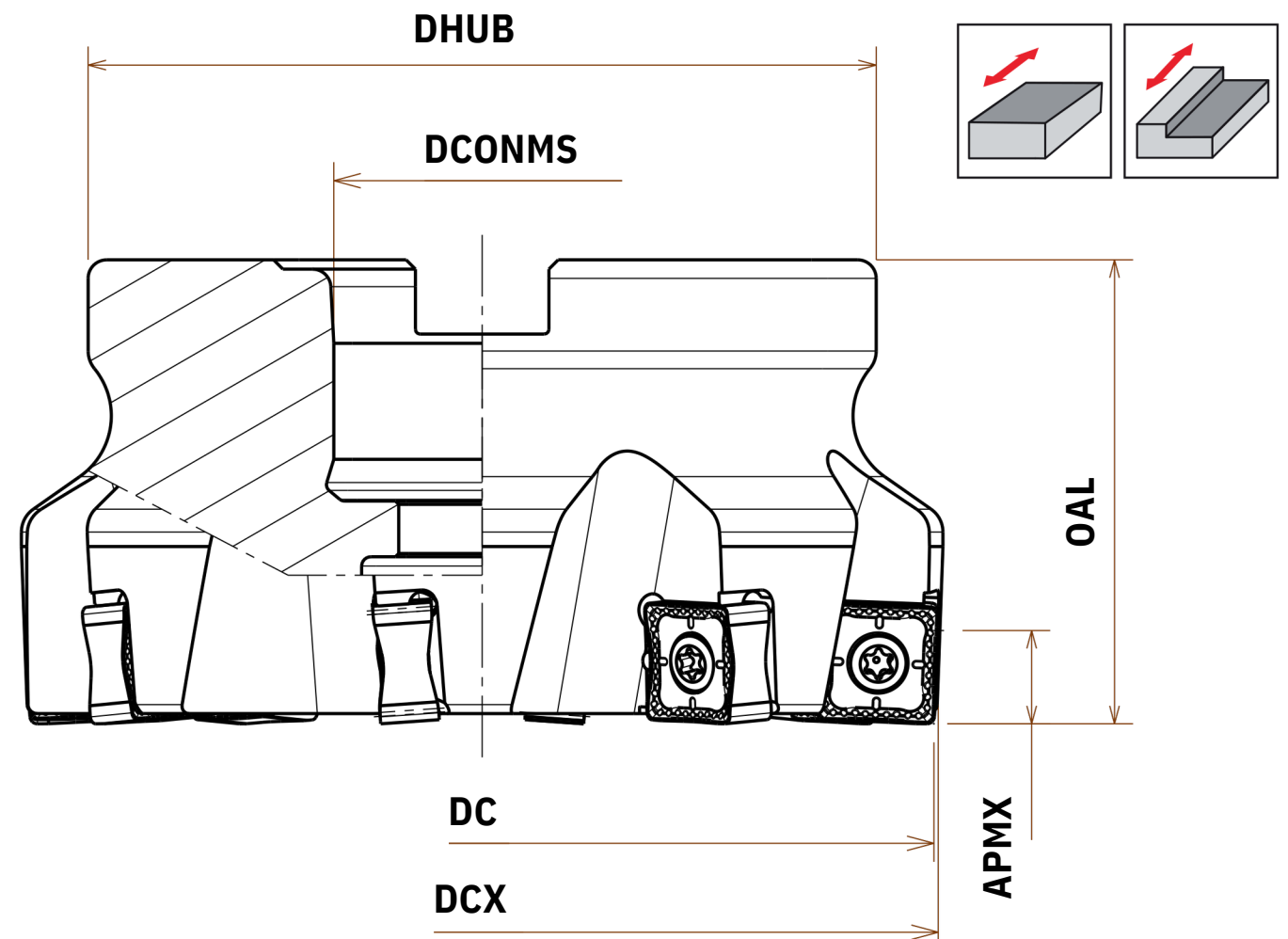
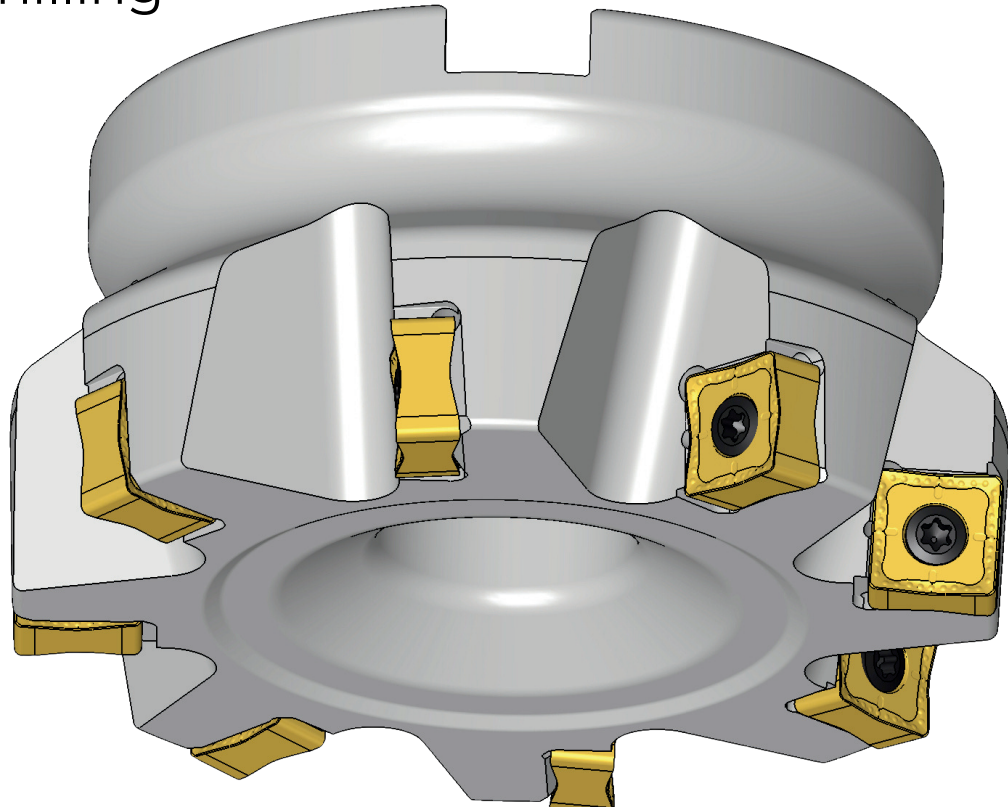
The fine pitch cutter improves productivity with its high feed rate capability and long tool life



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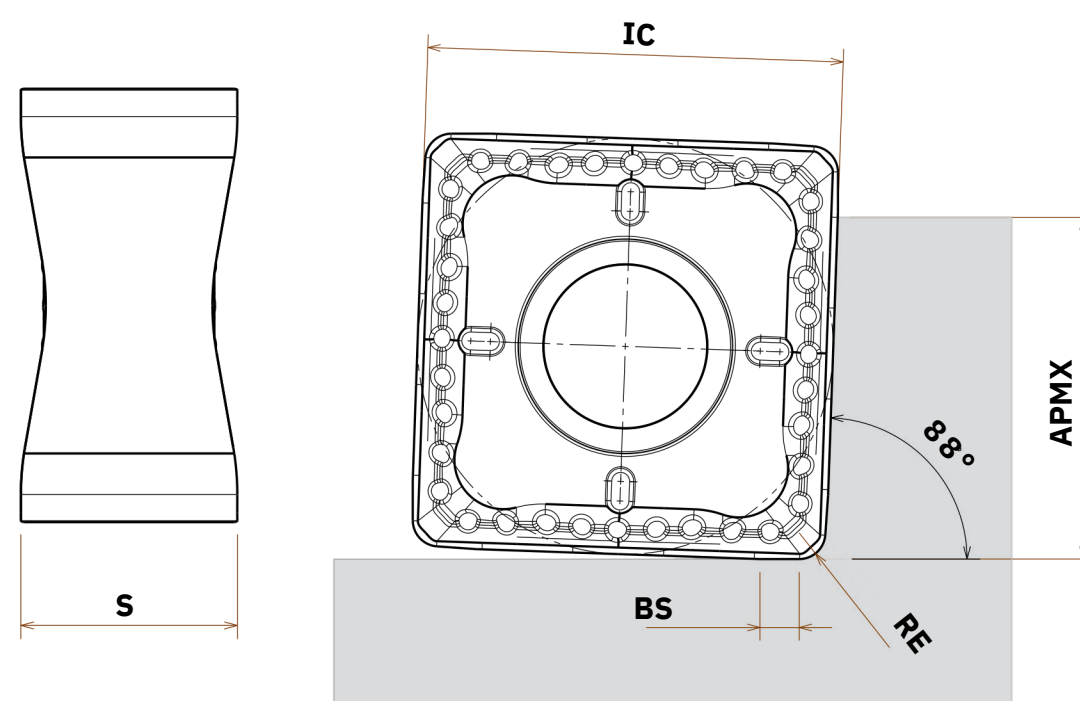
D2-Mill (88° Face Mill) holders

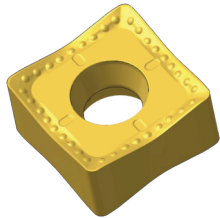
For face milling



Designation	CICT* (P+Q)	Dimension (mm)						Arbor Style	Weigh t (KG)	Mounting Bolt
		DC	DCX	DHUB	DCONMS	APMX	OAL			
88F4-D50-22R-SN12	4	50	51.2	45	22	6	40	A	0.3	SH M10x1.5x30
88F5-D63-22R-SN12	5	63	64.2	47	22	6	40	A	0.5	SH M10x1.5x30
88F6-D80-27R-SN12	6	80	81.2	70	27	6	50	A	1.2	SH M12x1.75x35
88F9-D80-27R-SN12	9	80	81.2	70	27	6	50	A	1.1	SH M12x1.75x35
88F8-D100-32R-SN12	8	100	101.2	85	32	6	50	A	1.9	SH M12x1.75x35
88F11-D100-32R-SN12	11	100	101.2	85	32	6	50	A	1.8	SH M12x1.75x35
88F9-D125-40R-SN12	9	125	126.2	85	40	6	63	B	2.9	-

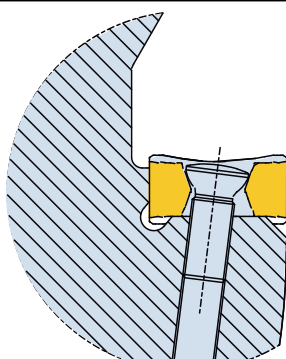
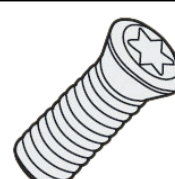
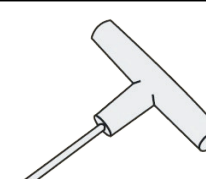
SNGU 12... XNTN-M



Insert	Designation	Dimension (mm)					ap (mm)	Feed (mm/tooth)	Coated	
		IC=L	S	RE	APMX	BS			DC9200	DC9800
	SNGU 120508 XNTN-M	12.7	6.35	0.8	6.0	1.2	1 - 6	0.2 - 0.1	.	.

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Spare Parts - SNGU12...M

Component	Screw	Wrench
		
	DS 40B100I-TS	DTTW-15

Recommended Cutting Conditions

Machining Data

ISO	Material		Condition	Tensile Strength (N/mm ²)	Hardness HB	Cutting Speed VC (m/min)	
						DC9800	DC9200
P	Non-alloy steel, cast steel, free cutting steel	<.025%C	Annealed	420	125	190-310	
		>=0.25%C	Annealed	650	190	160-260	
		<0.55%C	Quenched and tempered	850	250	105-185	
		>=0.55%C	Annealed	750	220	120-200	
			Quenched and tempered	1000	300	95-160	
	Low alloy steel and cast steel (Less than 5% of alloying elements)		Annealed	600	200	160-250	
		Quenched and tempered		930	275	120-200	
				1000	300	95-175	
	High alloy steel, cast steel and tool steel		1200	350	80-150		
			Annealed	680	200	75-135	
M	Stainless steel and cast steel		Quenched and tempered	1100	325	65-120	
		Ferritic / martensitic		680	200	100-250	
		Martensitic		820	240	80-200	
K	Gray cast iron (CG)	Austenitic		600	180	110-260	
		Ferritic			160		160-300
	Cast iron nodular (GGG)	Pearlitic			250		125-250
		Ferritic			180		100-200
	Malleable cast iron	Pearlitic			260		90-180
		Ferritic			130		160-260
H	Hardened Steel	Pearlitic			230		110-230
		Hardened			55HRC	40-60	
	Chilled cast iron	Hardened			60HRC	30-55	
		Cast			400	60-100	
	Cast iron nodular	Hardened			55HRC	40-60	

■ Steel
 ■ Stainless Steel
 ■ Cast Iron
 ■ Hardened Steel