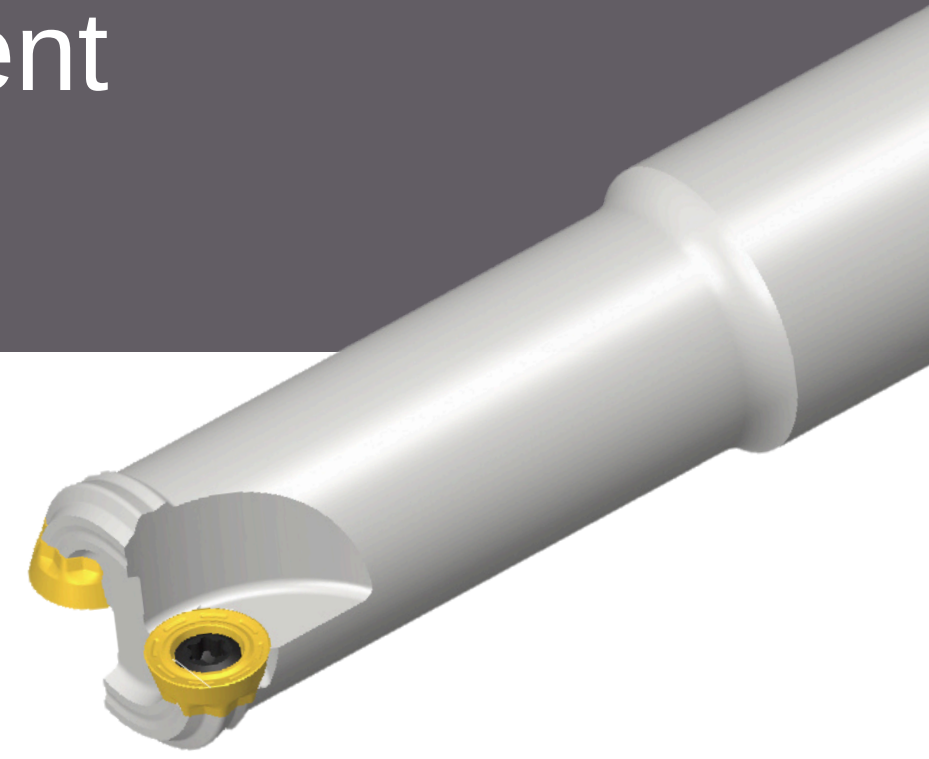


DURA

Duracarb Milling Line New Product Announcement



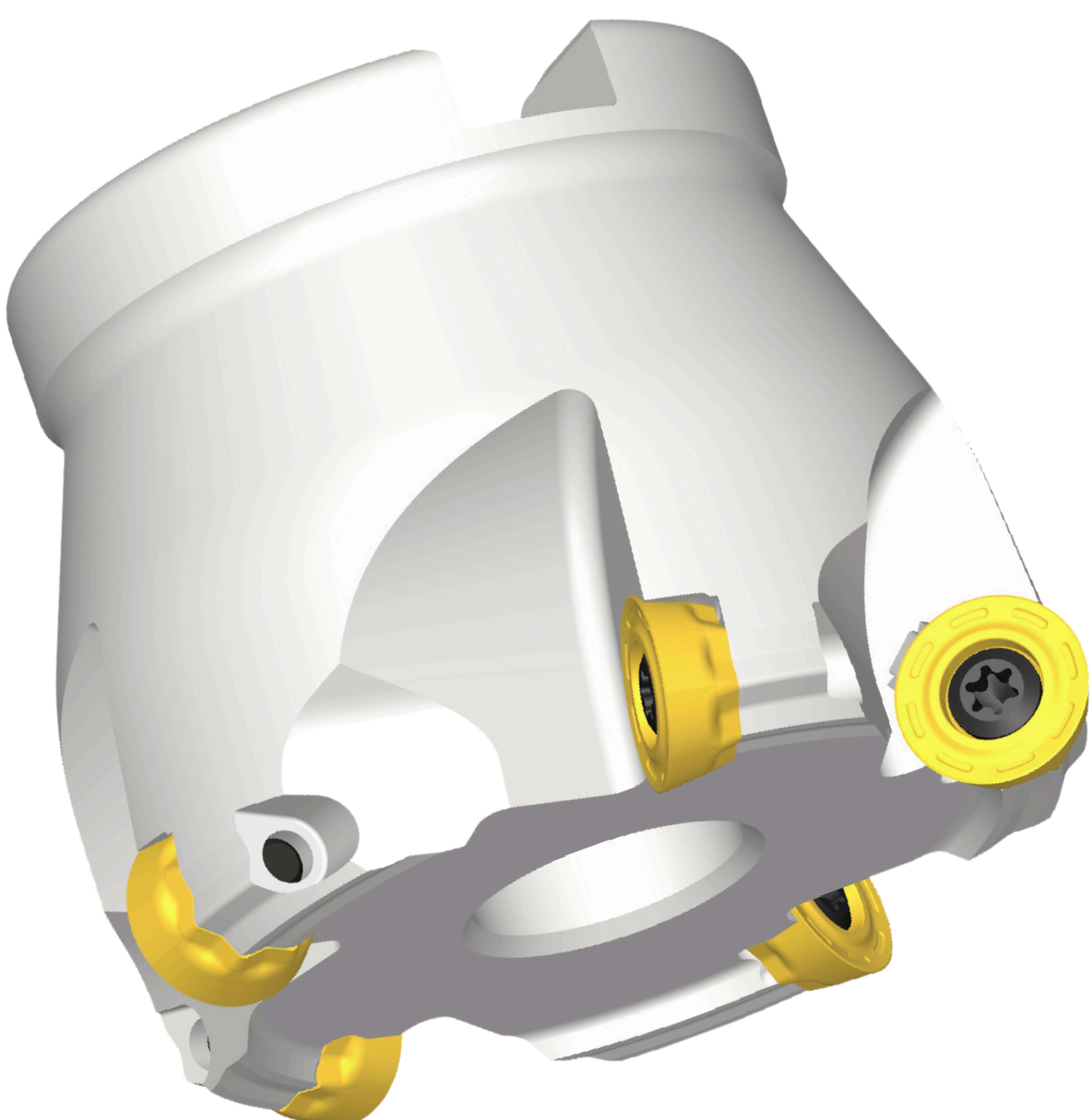
Introducing DURA MOLD Mill

New Cutter with Strong Insert

Duracarb India's DURA MOLD Mill improves the existing line with its thick and robust new design including 8 indexing insert edges. Our customers now have an improved solution for machining in stable conditions while reducing tooling costs.

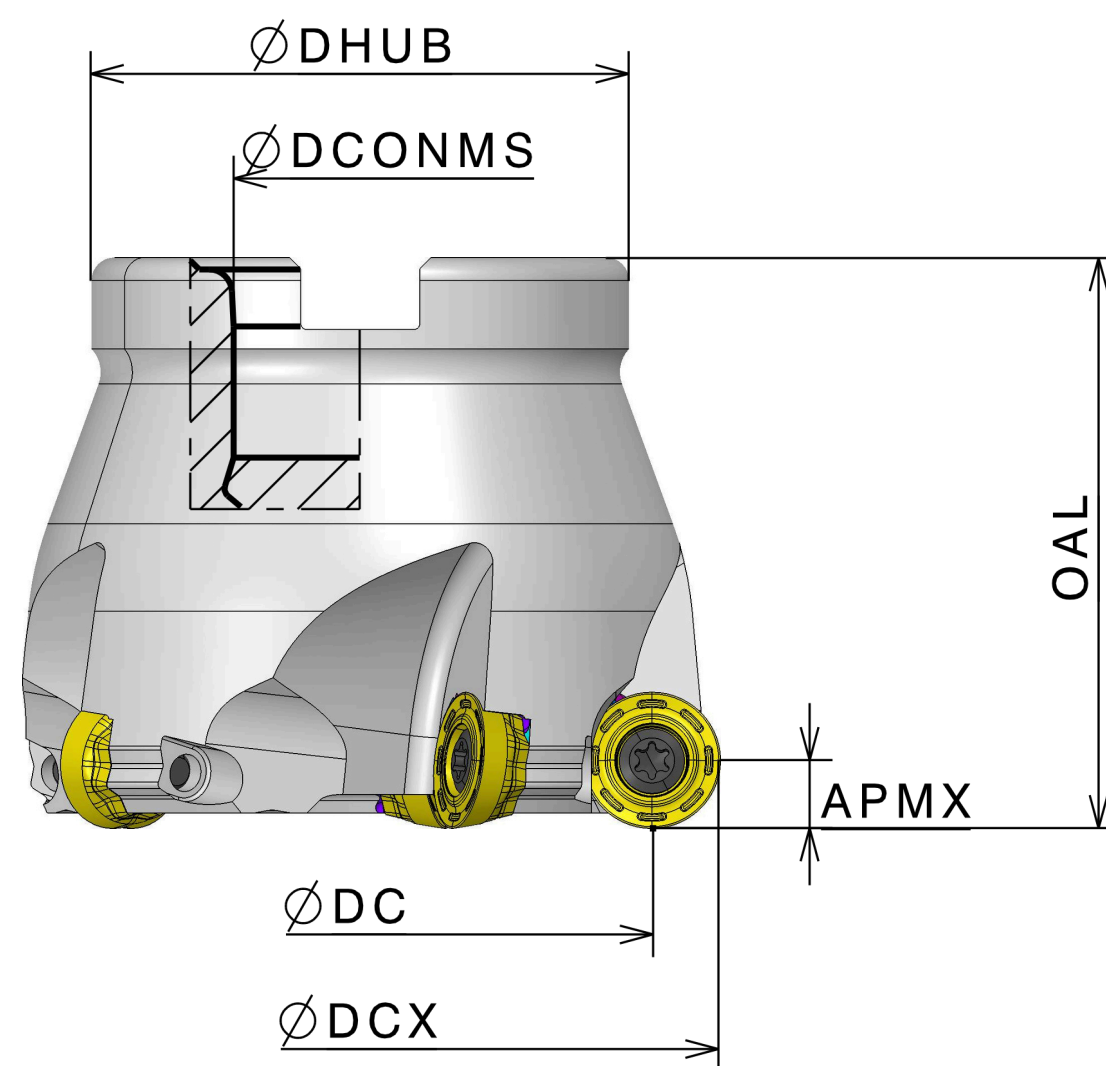
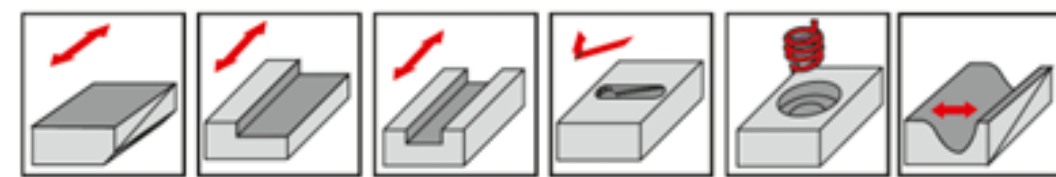
For contour, copy and radius milling of mold & die applications and any other demanding operations such as roughing for aerospace parts and heavy industrial products, customers can obtain the following benefits:

- Higher insert thickness, stronger screw systems for heavy or demanding applications
- Exceptional performance at very high feed rates
- Reliable machining even under difficult conditions
- Long tool life through optimum geometry of inserts
- Anti-rotating system



DURA MOLD Face Mills

FRD□-D□□-22R-12



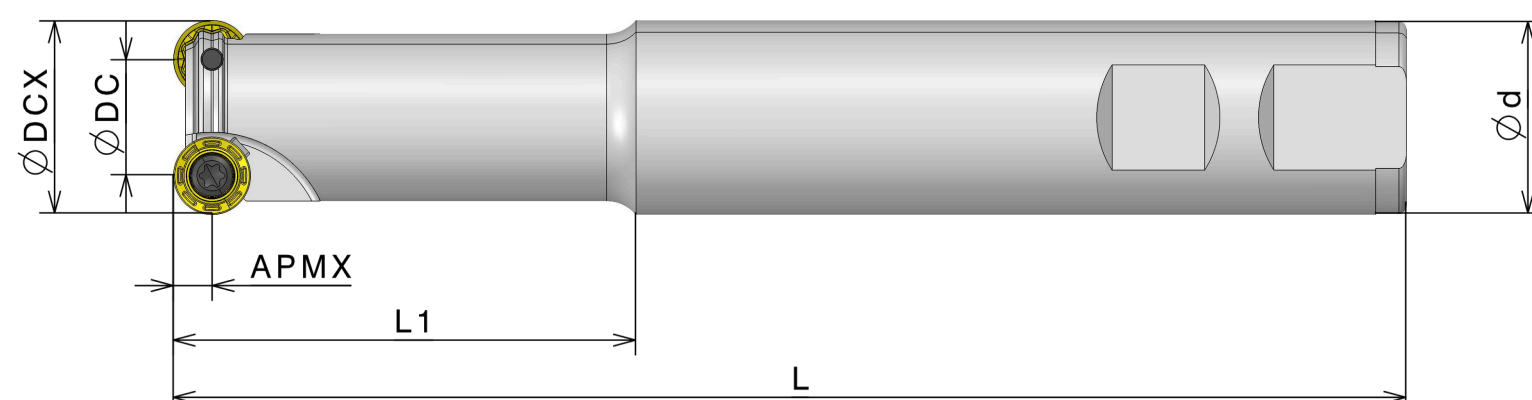
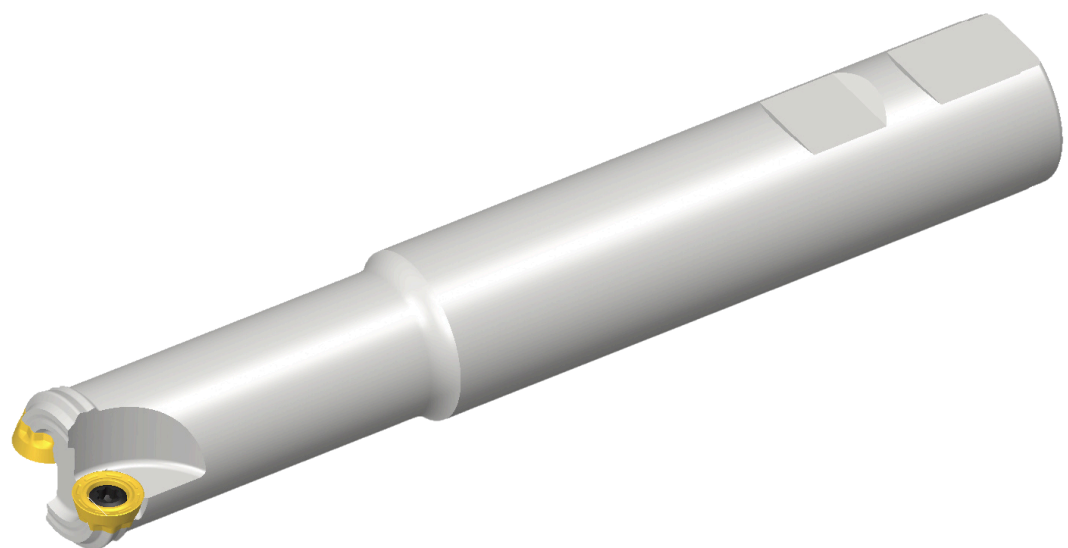
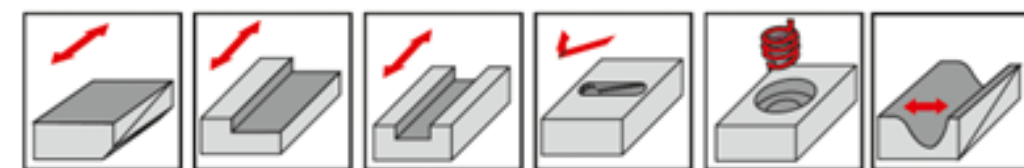
Designation	MIID	CICT	Dimension (mm)						Weight (KG)	Mounting Bolt
			DCX	DC	OAL	DHUB	DCONMS	APMX		
FRD5-D50-22R-12	RDMX 1204-DM	5	50	38	50	45	22	0.5 - 6	0.4	SH M10x1.5x30
FRD4-D52-22R-12		4	52	40	50	45	22	0.5 - 6	0.4	
FRD5-D63-22R-12		5	63	51	50	47	22	0.5 - 6	0.6	

Spare Parts

Component	Insert Screw	Wrench
	DS 400933I	DTTW-15

DURA MOLD End Mills

ERD2-□□□□W-10-L160

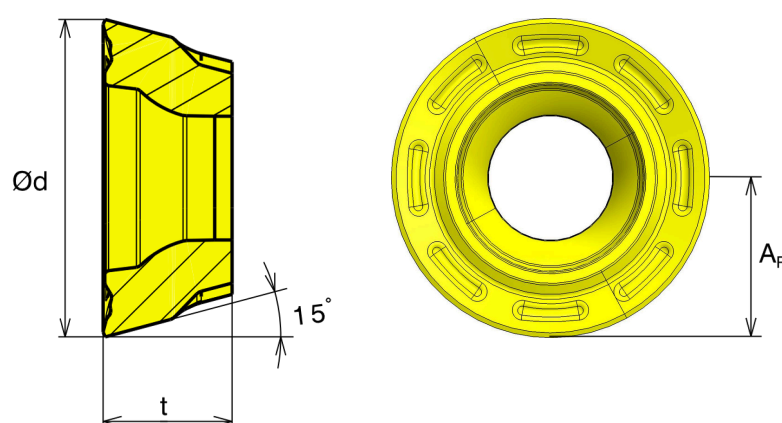


Designation	MIID	CICT	Dimension (mm)					
			DCX	DC	d	L	L1	APMX
ERD2-2020W-10-L160	RDMX 10T3-DM	2	20	10	20	160	60	0.4 - 5
ERD2-2525W-10-L160		2	25	15	25	160	60	0.4 - 5
ERD3-2525W-10-L160		3	25	15	25	160	60	0.4 - 5

Spare Parts

Component	Insert Screw	Wrench
	DS 35070I/HG	DTDW-15

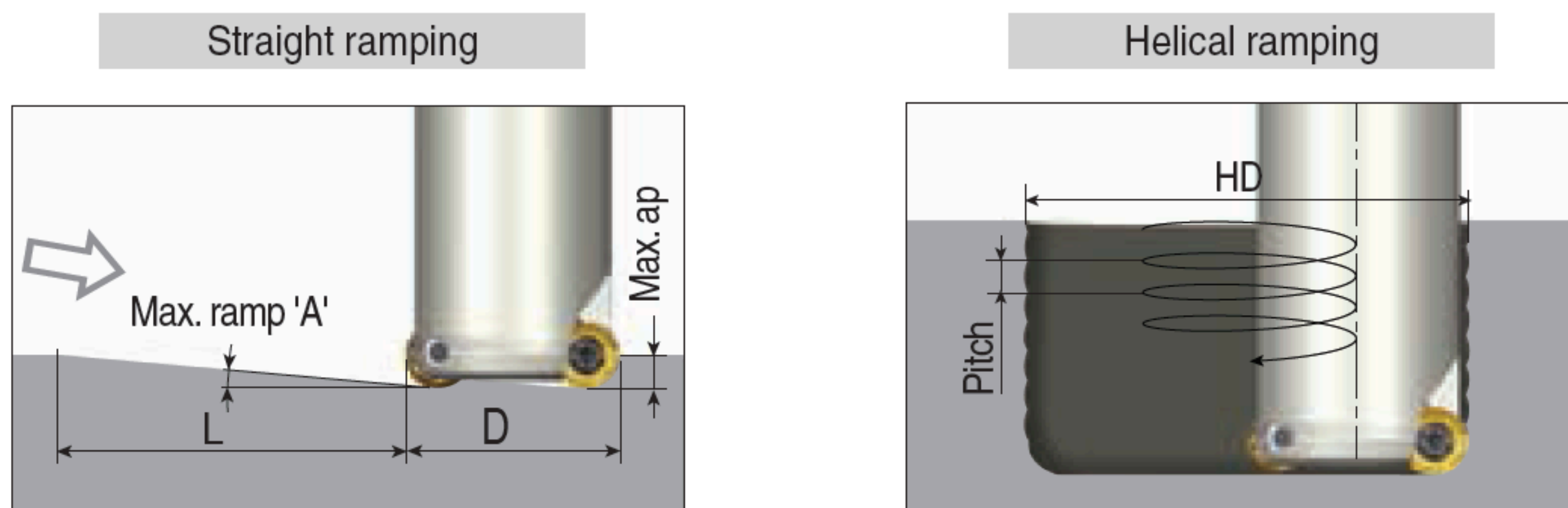
RDMX □□□□ -DM



Insert	Designation	Dimension (mm)				Grade		Application
		R	d	t	Ap	DP5035	DP5320	End Mill & Cutter
	RDMX 10T3-DM	5	10	3.97	5	•	•	ERD2-□□□□W-10-L160
	RDMX 1204-DM	6	12	4.76	6	•	•	FRD□-D□□-22R-12

Duracarb Milling Line New Product Announcement

Ramping Data



Ramping Data RDMX 10T3-DM

Cutter Dia	Straight Ramp Down			Helical Ramp Down		
	Max. Ramp (A°)	Max. ap (mm)	Min. Length (L)	Min. Dia.	Max. Dia.	Max. Pitch/Rev.
Ø20	20	5	14	22		1.9
					40	4.3
Ø25	15	5	19	32		5.0
					50	4.3

Ramping Data RDMX 1204-DM

Cutter Dia	Straight Ramp Down			Helical Ramp Down		
	Max. Ramp (A°)	Max. ap (mm)	Min. Length (L)	Min. Dia.	Max. Dia.	Max. Pitch/Rev.
Ø50	7.5	6	46	78		5.1
					100	5.1
Ø52	6	6	57	82		5.1
					104	5.1
Ø63	5	6	69	104		5.1
					126	5.1

Duracarb Milling Line New Product Announcement

Recommended Conditions

ISO	Material	Hardness BHN	Speed (m/min)	Recommended Grades	Feed (mm/tooth)	
					RD10	RD12
P	Low Carbon Steel	85-175	220-300	DP5320	0.10 - 0.45	0.15 - 0.60
	High Carbon Steel	175-225	150-250	DP5320	0.10 - 0.40	0.15 - 0.55
	Alloyed Steel	275-325	100-180	DP5035,DP5320	0.10 - 0.35	0.15 - 0.45
	Tool Steel	200-250	85-150	DP5035,DP5320	0.10 - 0.35	0.15 - 0.45
M	Stainless 300 Series	-	110-180	DP5035,DP5320	0.10 - 0.40	0.10 - 0.50
	Stainless 400 Series	-	110-220	DP5035,DP5320	0.10 - 0.40	0.10 - 0.50
S	Inconel Hastelloy Waspalloy	-	25-45	DP5035,DP5320	0.10 - 0.25	0.10 - 0.35
	Titanium 6AL-4V	-	35-60	DP5035,DP5320	0.10 - 0.30	0.10 - 0.35
K	Grey Cast Iron	190-220	110-210	DP5320	0.10 - 0.50	0.10 - 0.60
	Nodular Cast Iron	140-200	120-210	DP5320	0.10 - 0.50	0.10 - 0.60