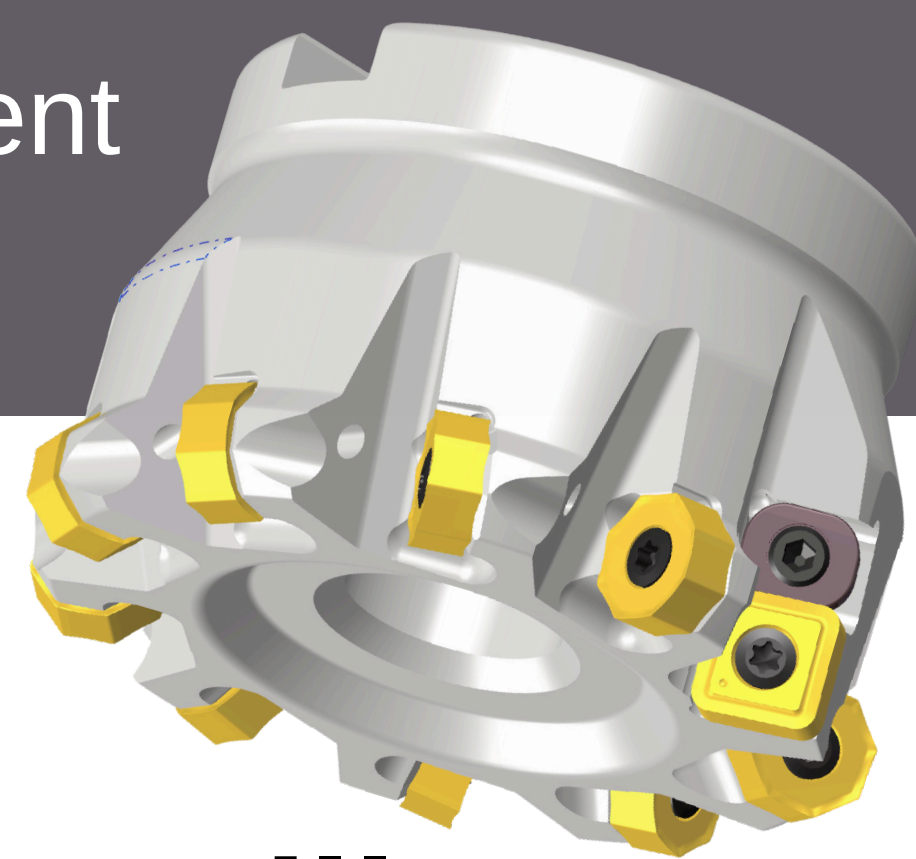


Duracarb Milling Line

New Product Announcement

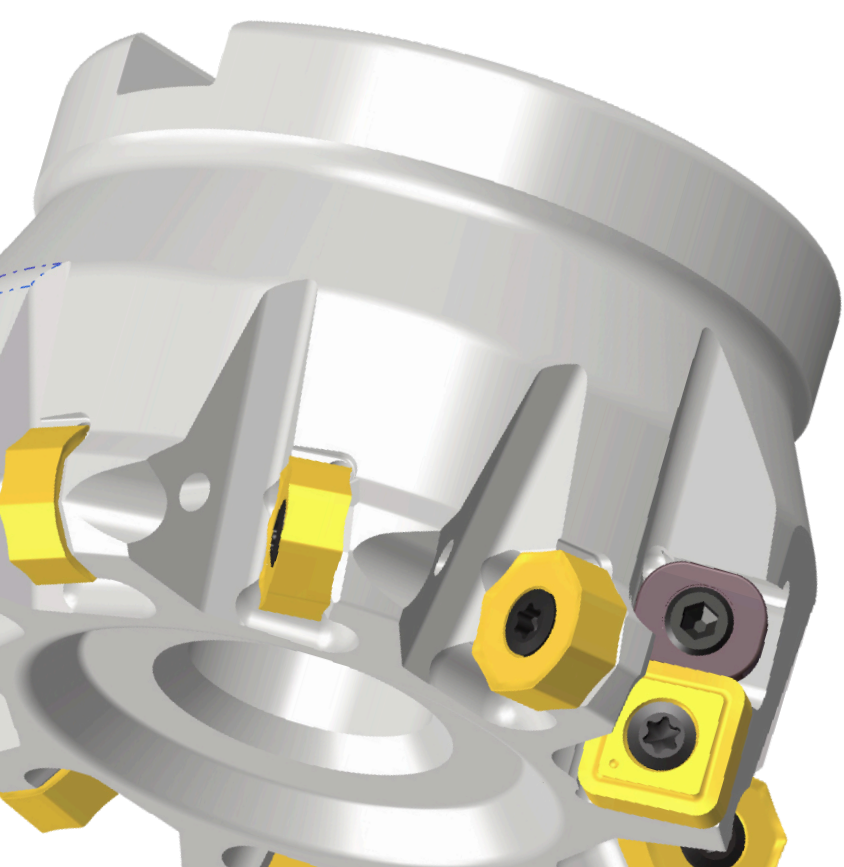


Introducing D2-43° Fin Mill

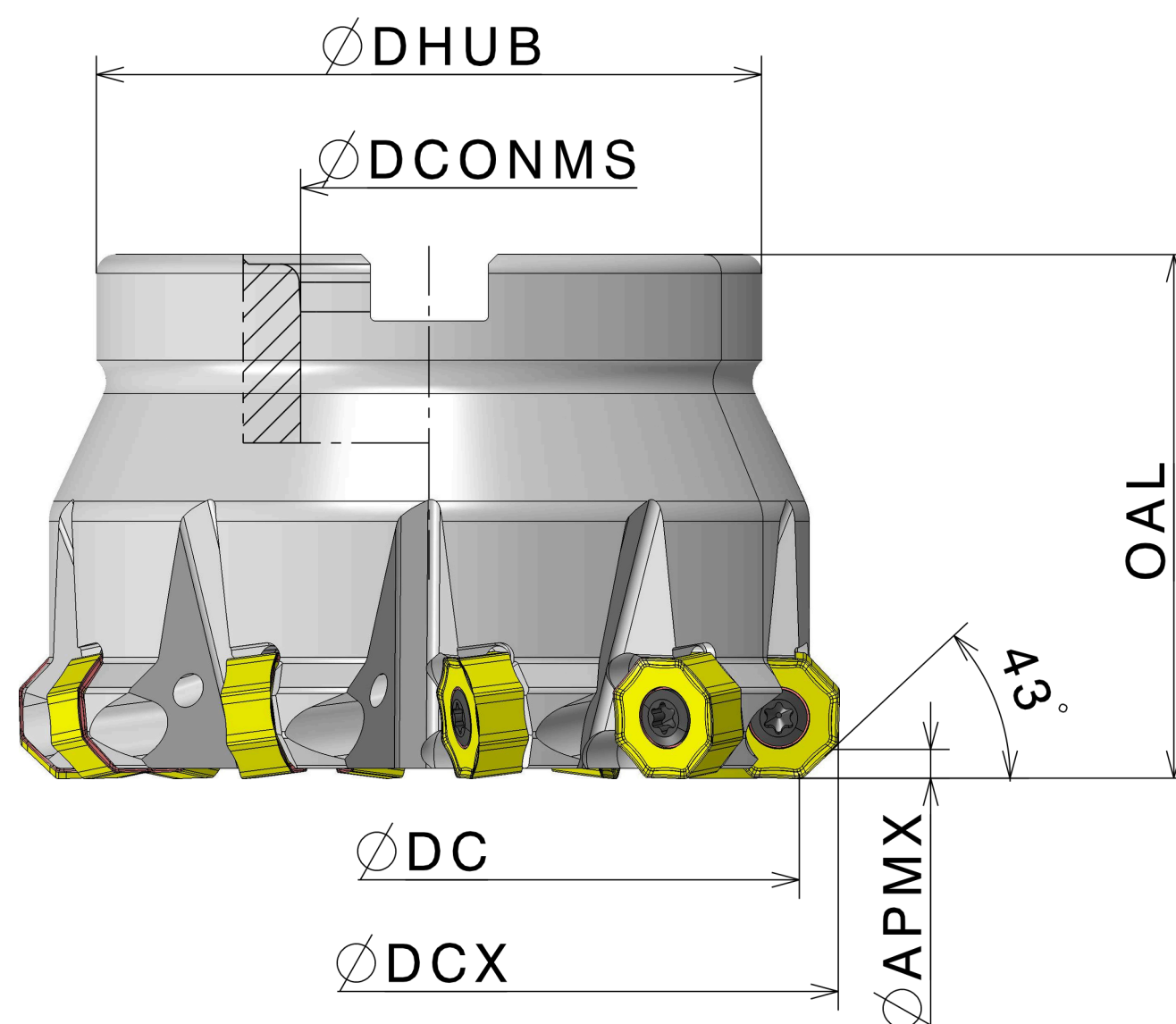
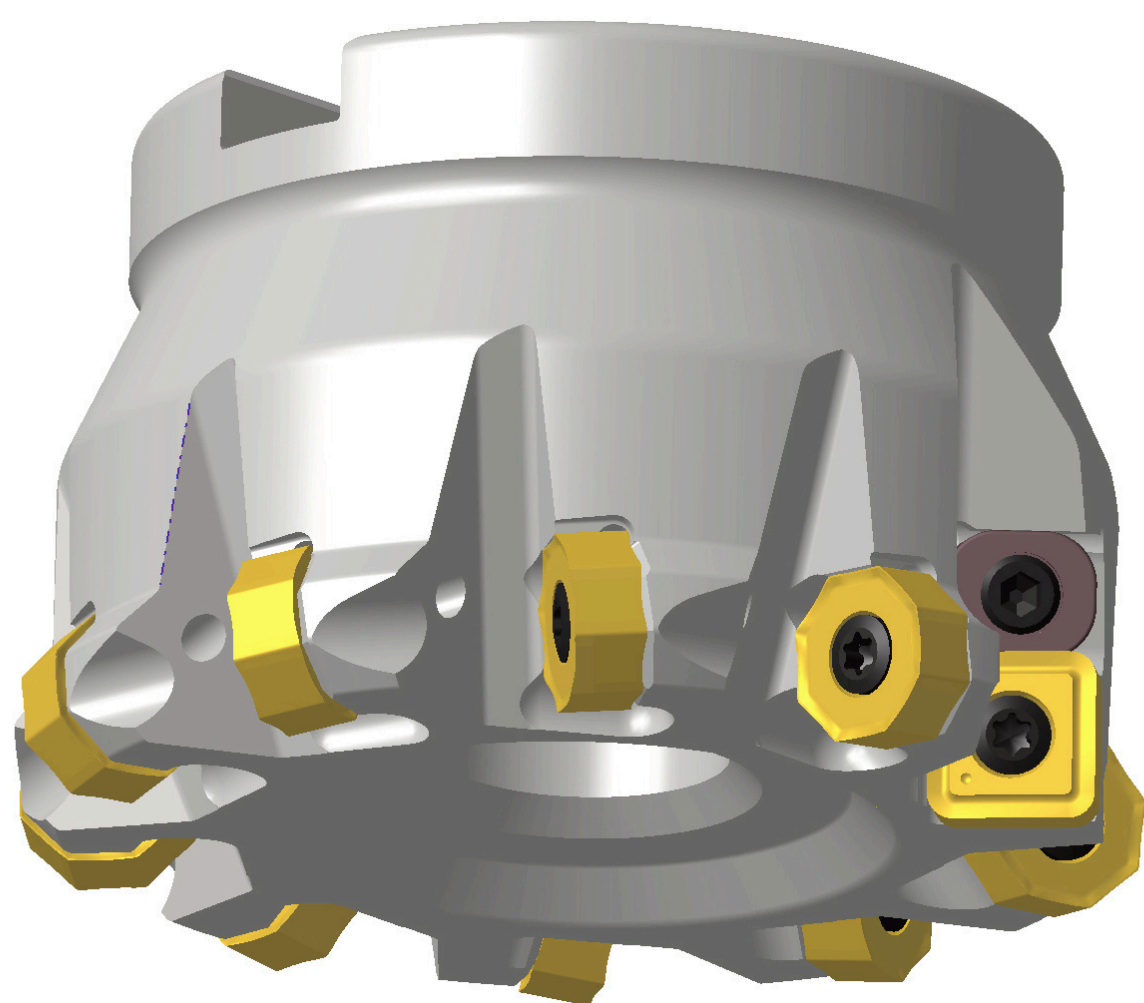
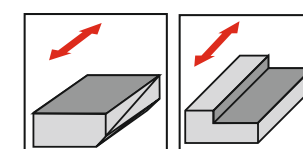
Face mill cutter with ONMU 05 & SN 12 Inserts

In the world of metalworking, achieving precise cuts and a smooth finish is crucial. Introducing the innovative face mill cutter featuring ONMU 05 and SN 12 inserts, designed to revolutionize your milling experience. This advanced cutter offers many benefits to enhance your workflow:

- Cutters are equipped with combination of dual sided- economical 16 corners inserts and the wiper inserts with 8 corner
- Cutters are offered for 43° approach angle with up to 1mm APMX for finish milling only.
- Rigid clamping using M4 screw for ONMU and M3.5 screw for SN12 wiper inserts.
- Capable of face milling on smaller machines and thin walled components due to positive cutting geometry resulting in lower loads.
- Optimized cutter design ensure smooth cutting with free vibrations.
- Low axial force result in for excellent surface finish min of 0.8 Ra.
- Unique position of the insert increases tool life and durability.



D2-Mill (43° Face Mill) holders For finish milling

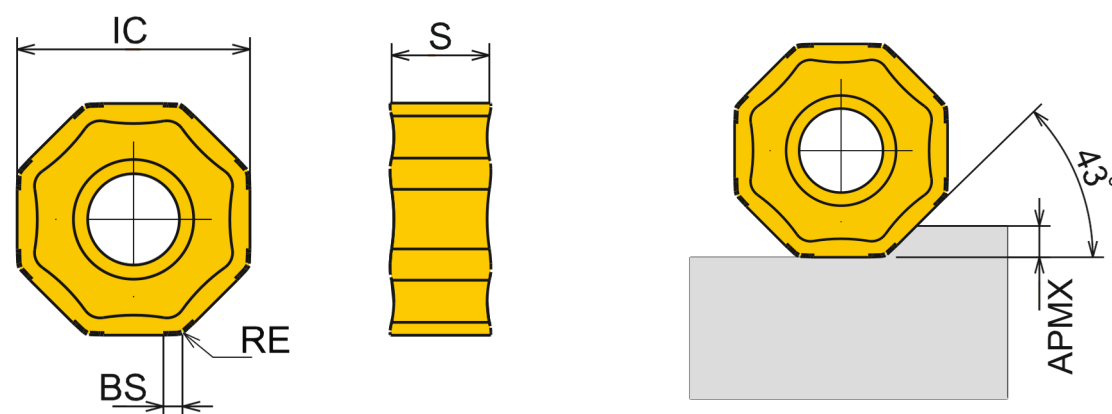


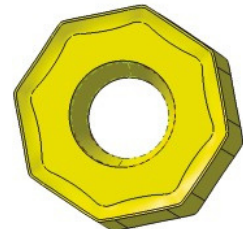
Designation	CICT* (P+Q)	Dimension (mm)						Arbor Style	Weight (KG)	Mounting Bolt
		DC	DCX	DHUB	DCONMS	APMX	OAL			
90F6 D63-22R-SN12-W	5+1	63	63.7	47	22	1	50	A	0.7	SH M10x1.5x30
90F9 D80-27R-SN12-W	8+1	80	80.7	70	27	1	50	A	1.2	SH M12x1.75x35
90F12 D100-32R-SN12-W	10+2	100	100.7	75	32	1	50	A	1.8	SH M16x2x35
90F15 D125-40R-SN12-W	12+3	125	125.7	90	40	1	63	A	3.7	SH M20x2.5x40
90F20 D160-40R-SN12-W	16+4	160	160.7	110	40	1	63	A	6.4	SH M20x2.5x40

* NOTE: "P" represents SNGU insert qty and "Q" represents SN 1204(Wiper) qty

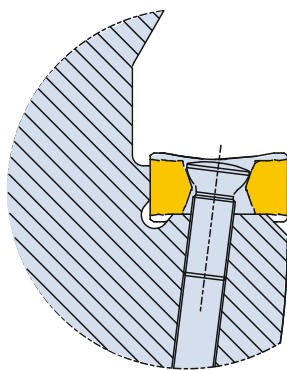

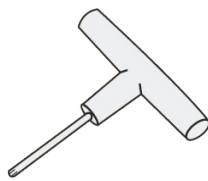
Duracarb Milling Line New Product Announcement

ONMU 05

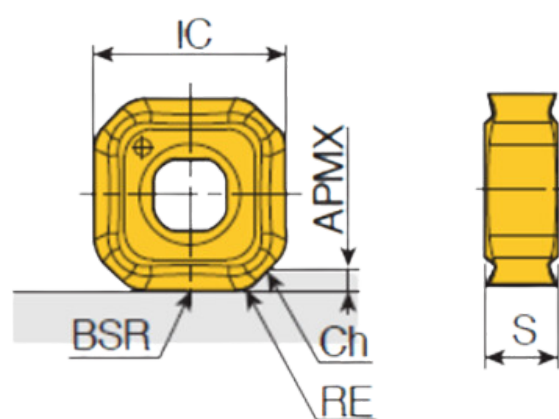


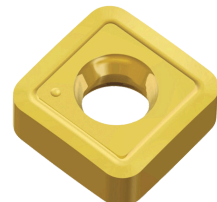
Insert	Designation	Dimension (mm)					Coated				
		IC=L	S	RE	APMX	BS	DP5320	DC9200	DP7320	DC9800	DP5035
	ONMU 050505	12.7	6.02	0.8	6.0	1.6	•	•	•	•	•

Spare Parts - SNGU12...M

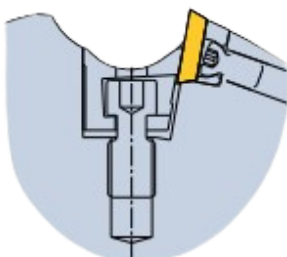
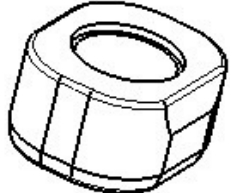
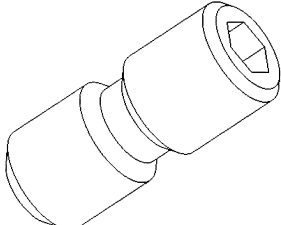


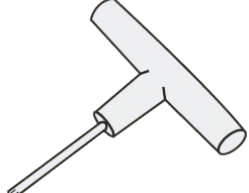
Component	Screw	Wrench
		
	DS 40B100I-TS	DTTW-15

SN 12



Insert	Designation	Dimension (mm)						Coated
		IC	BSR	S	CH	RE	APMX	DP7320
	SN 1204-W	12.7	800	4.76	-	2	1	•

Spare Parts - SN 12

Component	Wedge	Wedge Screw	Wrench	Insert Screw	Wrench
					
	AJT 1109N	WS 6	DTTW-3	DS 35C110I	DTTW-15

Duracarb Milling Line New Product Announcement

Recommended Conditions

ISO	Material	Brinell	D.O.C (mm)	Speed (m/min)	Recommended Grades	Feed (mm/tooth)
P	Low Carbon Steel	85-175	0.5-1	180-300	DC9800, DP5320, DP5035	0.08-0.15
	High Carbon Steel	175-225	0.5-1	130-280	DC9800, DP5320, DP5035	0.08-0.15
	Alloyed Steel	275-325	0.5-1	120-250	DC9800, DP5320, DP5035	0.08-0.15
	Tool Steel	200-250	0.5-1	80-200	DC9800, DP5320, DP5035	0.08-0.15
K	Grey Cast Iron	190-220	0.5-1	180-300	DC9200, DP7320	0.08-0.2
	Nodular Cast Iron	140-200	0.5-1	180-300	DC9200, DP7320	0.08-0.2