SOLID CARBIDE HIGH PERFORMANCE END MILLS

Welcome to our Application Based Cutting Tools (ABCT) Concept. If you machine the same materials very frequently, and your operations are also regular, then you would love our ABCT.

Based on your inputs regarding material you wish to machine, and the operation on the machine, we have created a suffix code that you will put along with the Order Code for the High Performance Cutting Tool Range mentioned in the next page.

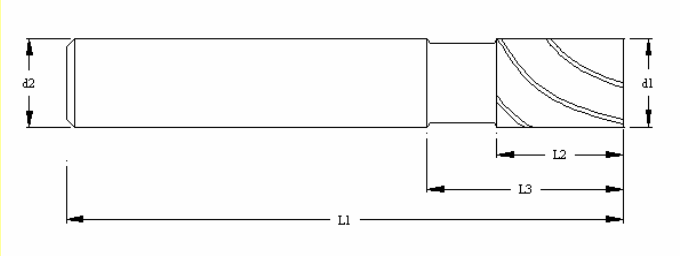
Depending on the suffix, we design a Tool which is specifically designed for that Particular Application, using an optimum combination of substrate, geometry and coating.

These tools of-course will produce better results in terms of Material Removal Rate and also in Terms of longevity between re-sharpening. A slightly higher initial investment, but as you would notice will substantially reduce your machining time and increase productivity, through higher tool life and reduced tool change time.

MATERIAL DESCRIPTION		DESCRIPTION OF MILLING OPERATION	
MATERIAL	CODE	SLOTTING	SIDE MILLING
		ROUGHING	MEDIUM
LOW CARBON STEEL	1	A01	B01
FREE CUTTING STEEL	2	A02	B02
MEDIUM CARBON STEEL	3	A03	B03
HIGH CARBON STEEL	4	A04	B04
ALLOY STEELS	5	A05	B05
DIE STEELS	6	A06	B06
TOOL STEELS	7	A07	B07
GREY CAST IRON	9	A09	B09
LOW ALLOY CAST IRON	10	A10	B10
NODULAR CAST IRON	11	A11	B11
HIGH ALLOY CAST IRON	12	A12	B12

SOLID CARBIDE HIGH PERFORMANCE END MILLS

FOR REGULAR AND HARD PARTS



FLUTES AND HELIX MATERIAL/OPERATION DEPENDENT

TOLERANCE
CUTTING DIA: h10
SHANK DIA:h6
OAL: +/- 4MM
FL:+/- 2MM

SDI SPECIAL STANDARD

ECCENTRIC SERIES: HIGH PERFORMANCE ENDMILLS

REGULAR <48HRc							HARD PART >48HRc					
d1	L1	L2	L3	ORDER CODE	COOLAN HOLE SUFFIX -CH		d1	L1	L2	L3	ORDER CODE	COOLAN HOLE SUFFIX -CH
4	52	8	8	ER04			4	52	4	8	EH04	
6	52	12	12	ER06			6	52	6	12	EH06	
8	52	16	16	ER08			8	52	8	16	EH08	
10	80	20	20	ER10			10	80	10	20	EH10	
12	80	24	24	ER12			12	80	12	24	EH12	
14	80	28	28	ER14			14	80	14	28	EH14	
16	105	32	32	ER16			16	80	16	32	EH16	

ORDERING CODE FOR SOLID CARBIDE HIGH PERFORMANCE END MILLS AS PER ORDER

TOOL TYPE	DIAMETER	SHANK DIA	FLUTE LENGTH	OAL	CORNER CHAMFER	COATING
SCER OR SCEH	XX.XX	XX	XX	XX	YY.YY **X** YY	TiN TiCN TiAlN AlTiN

EQUILIBRIUM SERIES: VIBRATION AND CHATTER RESISTANT HIGH PERFORMANCE END MILLS
ENERGY SERIES: ROUGHING END MILLS WITH ROUGH AND FINISH PROFILE

EQUILIBRIUM 38-38 DEG HELIX						ENERGY : ROUGHING END MILLS				
d1	L1	L2	ORDER CODE	COOLAN HOLE SUFFIX -CH		d1	L1	L2	ORDER CODE	COOLAN HOLE SUFFIX -CH
8	54	10	EQ08			8	54	12	ENR08	
10	63	12	EQ10			10	63	15	ENR10	
12	80	14	EQ12			12	80	18	ENR12	
14	80	16	EQ14			14	80	20	ENR14	
16	80	18	EQ16			16	80	22	ENR16	