

“ Feathermill ”



DSG-HSG type



“ Feathermill ”



“ Feathermill ”



■ DSG45-4000 Type

Small size inserts offer excellent total economy and transmit excellent machining.

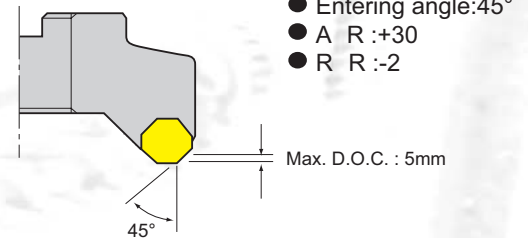


Fig.1

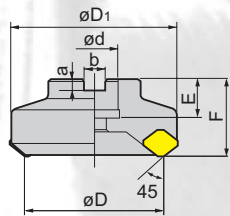


Fig.2

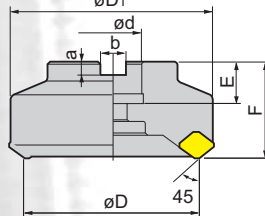


Fig.3

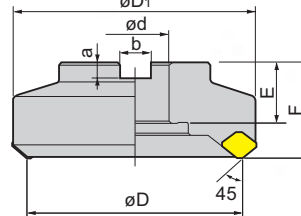
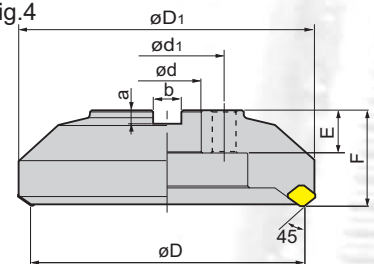


Fig.4



■ Body

Cat. No.	Stock	No. of inserts	Dimensions (mm)								Fig.
			ϕD	ϕD_1	F	ϕd	ϕd_1	a	b	E	
DSG45-4063M-22R-F	●	4	63	76	40	22	-	6	10.4	20	1
DSG45-4080M-27R-F	●	5	80	93	50	27	-	7	12.4	22	2
DSG45-4100M-32R-F	●	6	100	113	50	32	-	8	14.4	32	3
DSG45-4125M-40R-F	●	8	125	138	63	40	-	9	16.4	35	3
DSG45-4160M-40R-F	●	10	160	173	63	40	66.7	9	16.4	28	4
DSG45-4200M-60R-F	●	12	200	213	63	60	101.6	14	25.7	32	4

Fig.1 SGHN1203AZN-21

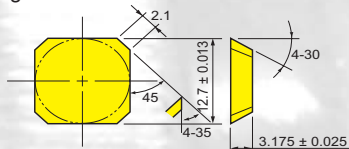


Fig.2 SGHN1203AZN-F2 (For aluminum alloy)

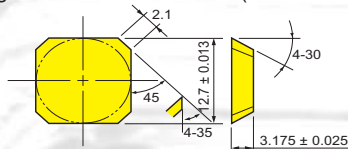
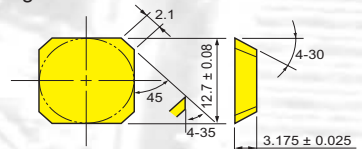


Fig.3 SGLN1203AZN-21



■ Inserts

Cat. No.	Coated				Cermet		Uncoated		Fig.
	JC5030	JC5040	NEW JC730U	JC610	CX90		KT9		
SGHN1203AZN-21	●	●	●	●	●		●	1	
SGHN1203AZN-F2							●	2	
NEW SGLN1203AZN-21	●							3	

■ Parts

Wedge	Wedge screw	Wrench
81106-1R	LS-180 (8.0 N-m)	A-27

■ Recommended cutting conditions

Work materials	Vc (m/min)	fz (mm/tooth)	Insert grades
Carbon steel & Alloy steel	150-300	0.2-0.5	CX90, JC730U JC5030, JC5040
Stainless steel	150-220	0.2-0.3	JC730U JC5030, JC5040
Cast iron	150-250	0.2-0.4	JC610
Aluminum alloy	300-800	0.2-0.5	KT9



“ Feathermill-Tough ”

Indexable Tools

■ HSG45-5000-RS Type

Inserts mounted in cartridges and strong clamping mechanism offer heavy duty cutting with good stability.

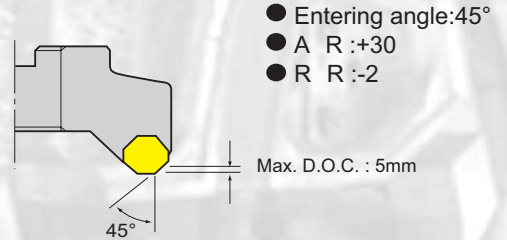


Fig.1

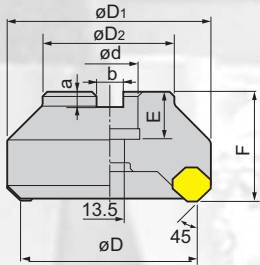


Fig.2

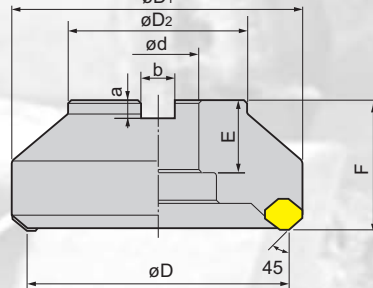
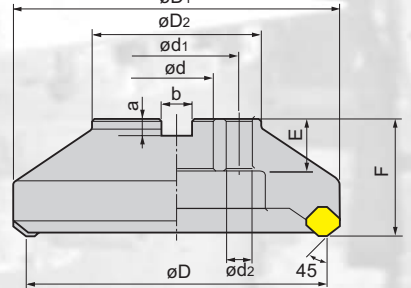


Fig.3



■ Body

Cat. No.	Stock	No. of inserts	Dimensions (mm)										Fig.
			ϕD	ϕD_1	ϕD_2	F	ϕd	ϕd_1	ϕd_2	a	b	E	
HSG45-5080-27RS-F	●	4	80	93	60	50	27	-	-	7	12.4	22	1
HSG45-5100-32RS-F	●	5	100	113	70	50	32	-	-	8	14.4	32	2
HSG45-5125-40RS-F	●	6	125	138	85	63	40	-	-	9	16.4	35	2
HSG45-5160-40RS-F	●	8	160	173	100	63	40	66.7	14	9	16.4	28	3
HSG45-5200-60RS-F	●	10	200	213	154	63	60	101.6	18	14	25.7	32	3
HSG45-5250-60RS-F	●	12	250	263	154	63	60	101.6	18	14	25.7	32	3

Fig.1 SGHN1504AZN-44

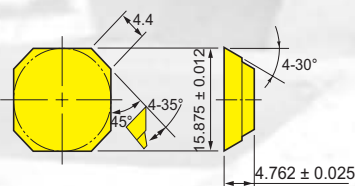


Fig.2 SGHN1504AZR-F1 For devibration

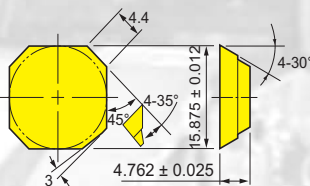


Fig.3 SGLN1504AZN-44

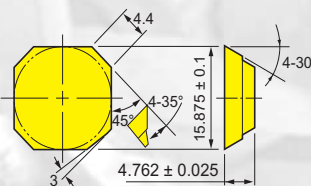
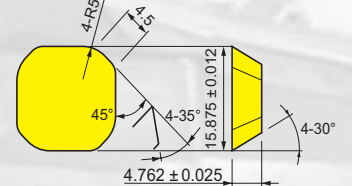


Fig.4 SGHN1504AZR5



■ Inserts

Cat. No.	Coated				Cermet		Uncoated		Fig.
	JC5030	JC5040	NEW JC730U	JC610	CX90		KT9		
SGHN1504AZN-44	●	●	●	●	●		●	1	
SGHN1504AZR-F1	●			●	●		○	2	
NEW SGLN1504AZN-44	●							3	
NEW SGLN1504AZR5		●						4	

○ Will not be available after current stock exhausted.

“ Feathermill-Tough ”



■ HSG45-5000RS Type

■ Parts

Wedge	Wedge screw	Wrench	Cartridges	Cartridge screw
DX-80808	LS-180 (8.0 N-m)	A-27	ST451R for Ø 80 & 100mm. or ST452R for Ø 125+250 mm.	LS-140

■ Recommended cutting conditions

Work materials	Vc (m/min)	fz (mm/tooth)	Insert grades
Carbon steel & Alloy steel	150-300	0.2-0.5	CX90, JC730U JC5030, JC5040
Stainless steel	150-220	0.2-0.3	JC730U JC5030, JC5040
Cast iron	150-250	0.2-0.4	JC610
Aluminum alloy	300-800	0.2-0.5	KT9

■ Recommended cutting conditions for high feed application with SGHN1504AZR5

Work materials	Hardness (HB)	Insert grade	Vc (m/min)	fz (mm/tooth)	Depth Ap
Carbon steel & Alloy steel	180 - 280	JC5040	150 - 200	1.0 - 2.0	Up to 5

Note: Over 1.5mm depth of cut requires machine's kW. (40cm³/kW)

■ Cutting data for high feed Feathermill High metal removal rate (f=1.45mm/tooth at 5mm depth)

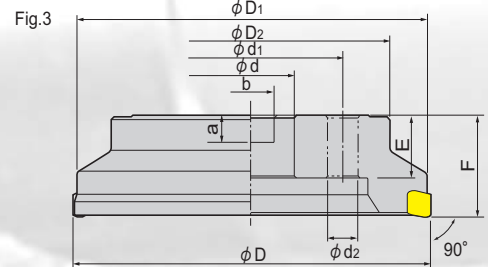
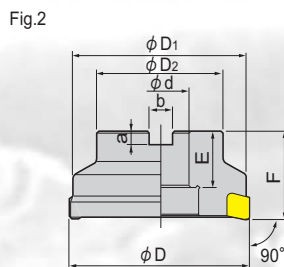
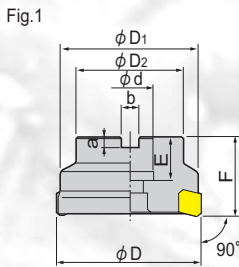
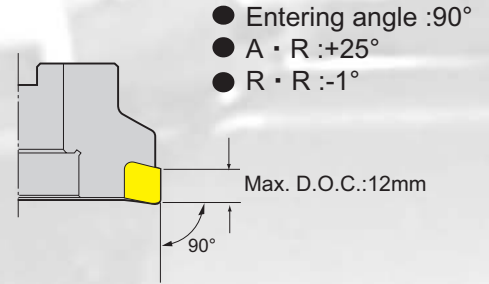
Chips at face milling 1) Ap=2mm, f=1.45mm/th, Q=800cm ³ 	Work	Part name	Frame
		Material	Low carbon steel (SS400)
1) Ap=5mm, f=1.45mm/th, Q=2,000cm ³ 	Tool	Tool No.	HSG45-5125R (125, 6N)
		Insert No.	SGLN1504AZR5, JC5040
Result	Cutting conditions	Cutting speed	181 m/min (460 min ⁻¹)
		Feed speed	4,000 mm/min, 1.45 mm/th
		Ap	1): 2 mm, 2): 5 mm
		Ae	100 mm
		Coolant	Air blow
Current condition is Ap=8mm, F=800mm/min. Q=832cm ³ /min. Feathermill could cut with 2) condition. Q=2,000cm ³ /min.		Machine	Horizontal NC milling, 70kW

“ Feathermill-Sumiyoshi ”



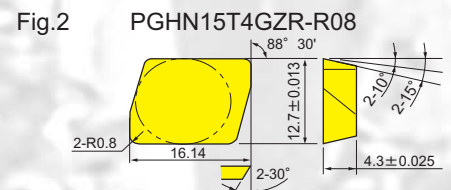
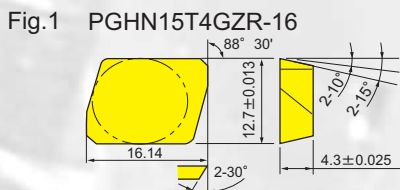
■ DPG90-5000 Type

High impact resistance offers high productivity and security. Able to cut up to 12mm deep.



■ Body

Cat. No.	Stock	No. of inserts	Dimensions (mm)										Fig.
			ϕ D	ϕ D ₁	ϕ D ₂	F	ϕ d	ϕ d ₁	ϕ d ₂	a	b	E	
DPG90-5080-27R-F	●	5	80	76	60	50	27	—	—	7	12.4	22	1
DPG90-5100-32R-F	●	6	100	96	70	50	32	—	—	8	14.4	32	2
DPG90-5125-40R-F	●	8	125	121	85	63	40	—	—	9	16.4	35	2
DPG90-5160-40R-F	●	10	160	156	100	63	40	66.7	14	9	16.4	28	3
DPG90-5200-60R-F	●	12	200	196	154	63	60	101.6	18	14	25.7	32	3
DPG90-5250-60R-F	●	14	250	246	154	63	60	101.6	18	14	25.7	32	3



■ Inserts

Cat. No.	Coated		Cermet		Uncoated		Fig.
	JC5030	JC610	CX90		KT9		
PGHN15T4GZR-16	●	●	●		●		1
PGHN15T4GZR-R08	●	●	●		●		2

■ Parts

Wedge	Wedge screw	Wrench
81406-1R	LS-180 (8.0 N-m)	A-27

■ Recommended cutting conditions

Work materials	Vc (m/min)	fz (mm/tooth)	Insert grades
Carbon steel & Alloy steel	150–250	0.15–0.4	CX90 JC5030
Stainless steel	150–220	0.15–0.3	CX90 JC5030
Cast iron	80–250	0.2–0.4	JC610 KT9
Aluminum alloy	300–800	0.2–0.5	KT9



DIJET INDUSTRIAL CO., LTD.

2-1-18, Kami-Higashi, Hirano-ku, Osaka 547-0002, Japan
Phone: +81-6-6794-0167 Fax: +81-6-6793-3930

Overseas division:

DIJET INDUSTRIAL CO., LTD. Unit 2 Mundells Court, Welwyn Garden City,
(Europe) Herts AL7 1EN, England
Phone. +44(0)1707-325444
Fax. +44(0)1707-330197

DIJET EUROPEAN Via Sega 2618/B
TECHNICAL SERVICE 35010 San Giorgio in Bosco (PD) Italy
(Italy) Phone. +39 049 599-4392
Fax. +39 049 599-4935

DIJET INDUSTRIAL CO., LTD. 699 Srinakarindr Road, Modernform Tower
Bangkok 15 th Floor, Kweang Suanluang
Representative Office Khet Suanluang, Bangkok 10250, Thailand
Phone. +66(0)2-722-8258, 8259
Fax. +66(0)2-722-8260

DIJET INDUSTRIAL CO., LTD. Room No.1007 Tomson Commercial Building.,
Shanghai 710 Dongfang Rd., Shanghai 200122
Representative Office Phone. +86-21-5058-1698
Fax. +86-21-5058-1699

DIJET Incorporated 45807 Helm Street, Plymouth, MI 48170 U.S.A.
(U.S.A.) Phone. +1-734-454-9100
Fax. +1-734-454-9395

 **Web Site:**
www.dijet.com

 **Japanese Web Site**
www.dijet.co.jp

0120-39-81-39

FAX 06-6793-1230



WARNING:
Grinding produces hazardous dust.
To avoid adverse health, use adequate ventilation and
read Material Safety Data Sheet first.
Cutting tools may fragment in use.
Wear eye protection in the vicinity of their operation.

Your local stockist is:

 **TECHNO**
TRADE
VERSPANENDE GEREEDSCHAPPEN

Telefoon (0475) 549 000

Telefax (0475) 549 001

Postbus 7 6100 AA Echt