

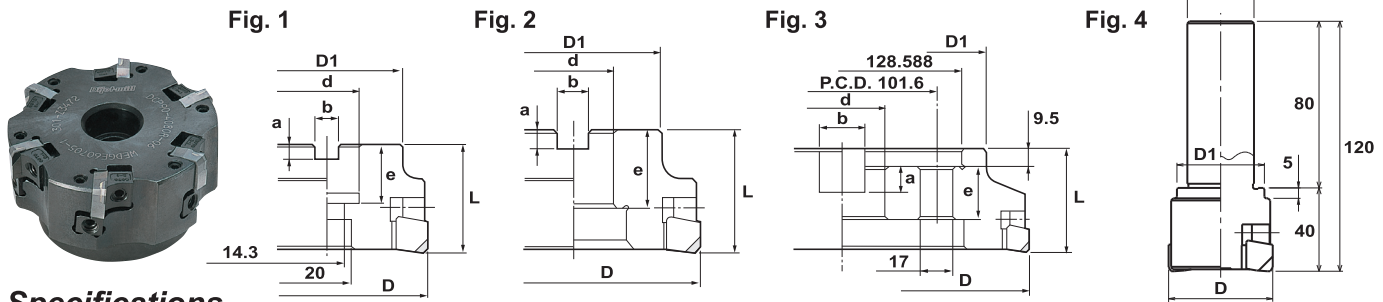
Spalcut Mill

METRIC

FACE MILL DCP90 Type

- "Spalcut Mill" is specially designed to use JDA inserts for longer tool life, high precision and high speed cutting.

Entering Angle	: 90°	A.R. : +6°
		R.R. : +1° ~ 3°
Max. D.O.C.	Roughing:	under 3mm
	Finishing:	under 0.5mm

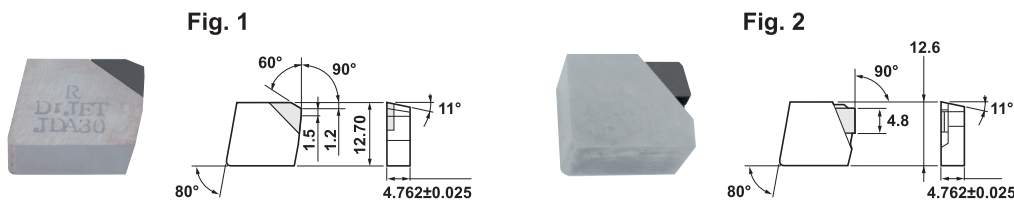


Specifications

CATALOG NUMBER	STK	DIMENSIONS							FIG.	INSERT	Q	PARTS		
		D	D1	L	d	a	b	e				Wrench Wedge / Adjustable Wedge	Wedge / Screw	Adjustable Wedge / Adjustable Screw
DCP90-4080R-06	•	80	60	44	25.4	6	9.5	24	1	C46PP-W90R	6	A-030 LW-025	60705-1 *LS-101	ADW6R LSM-512
DCP90-4100R-08	•	100	70	50	31.75	8	12.7	32	2		8			
DCP90-4125R-08	•	125	85	54	38.1	10	15.9	36	2		8			
DCP90-4160R-12	•	160	100	56	50.8	11	19	37	2		12			
DCP90-4200R-16	•	200	154	56	47.625	14.3	25.4	28.5	3		16			
DCP90-4250R-16	•	250	154	56	47.625	14.3	25.4	28.5	3		16			
DCP90-4050R-S32	•	50	42	-	32	-	-	-	4	3	60705-1 *LS-101 or LS-106	ADW7R		
DCP90-4063R-S32	•	63	42	-	32	-	-	-	4	4	60705-1 *LS-101	LSM-512		

Note: All cutters are supplied without inserts.

INSERTS



Specifications

CATALOG NUMBER	DIMENSIONS		FIG.	PCD (diamond)	
	IC	T		JDA30 (wear resistant)	JDA735 (chip resistant)
C46PPN-W90R	12.7	4.762	1	•	•
C46PPN-W90R-B (wiper)	12.7	4.762	2	•	•

Recommended Cutting Data

WORK MATERIALS		INSERT GRADE	Vc (m/min)	fz (mm/tooth)
Pure Aluminum (99% ~)		JDA30, JDA735	1000 - 2500	0.10 - 0.25
Aluminum Alloys	Forging	Non-heat treated	JDA30, JDA735	1000 - 2500
		Heat treated	JDA30, JDA735	1000 - 2500
	Casting	Si<13%	JDA30, JDA735	1000 - 2500
		Si≥13%	JDA30, JDA735	400 - 800