

Feathermill

METRIC

FACE MILL DSG45-4 Type

- High positive cutter with smaller inserts.
- High axial rake angle and wide chip pocket create excellent chip ejection.

Entering Angle : 45°	A.R. : +30°
	R.R. : -2° ~ -4°
Max. D.O.C.	5mm



Fig. 1

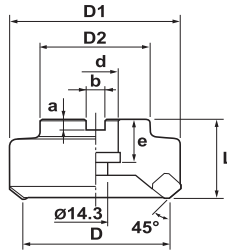


Fig. 2

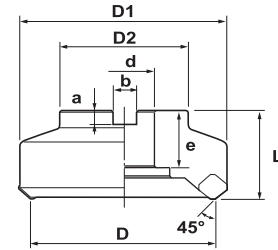


Fig. 3

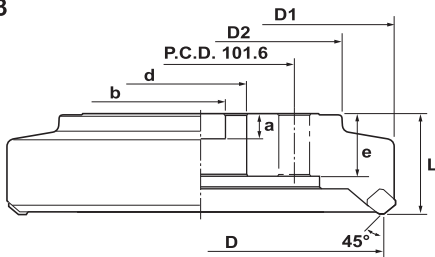


Fig. 4

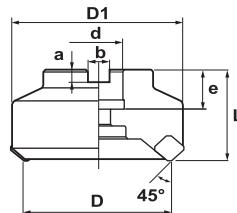
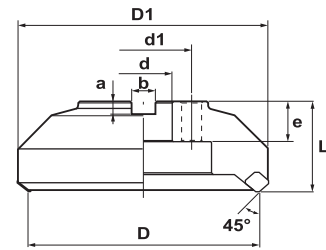


Fig. 5



Specifications

CATALOG NUMBER	STK	DIMENSIONS								FIG.	INSERT	Q	PARTS		
		D	D1	L	d	D2	a	b	e				Screw	Wrench	Wedge
DSG45-4080R	•	80	93	44	25.4	60	6	9.5	24	1		4	LS-180	T-27	81106-1R
DSG45-4100R	•	100	113	50	31.75	70	8	12.7	32	2	5				
DSG45-4125R	•	125	138	54	38.1	80	10	15.9	36	2	6				
DSG45-4160R	•	160	173	56	50.8	100	11	19	37	2	8				
DSG45-4200R	•	200	213	56	47.625	154	14.3	25.4	34.5	3	10				
DSG45-4250R	•	250	263	56	47.625	154	14.3	25.4	34.5	3	12				

Note: All cutters are supplied without inserts.

Specifications - Fine Pitch

CATALOG NUMBER	STK	DIMENSIONS									FIG.	INSERT	Q	PARTS		
		D	D1	L	d	d1	a	b	e	Screw				Wrench	Wedge	
DSG45-4063M-22R-F	•	63	76	40	22	-	6	10.4	20	1		4	LS-180	T-27	81106-1R	
DSG45-4080M-27R-F	•	80	93	50	27	-	7	12.4	22	4	5					
DSG45-4100M-32R-F	•	100	113	50	32	-	8	14.4	32	2	6					
DSG45-4125M-40R-F	•	125	138	63	40	-	9	16.4	35	2	8					
DSG45-4160M-40R-F	•	160	173	63	40	66.7	9	16.4	28	5	10					
DSG45-4200M-60R-F	•	200	213	63	60	101.6	14	25.7	32	5	12					

Note: All cutters are supplied without inserts.



METRIC

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END MILL DSG45-4 Type

Entering Angle : 45°	A.R. : +30°
	R.R. : -2° ~ -4°
Max. D.O.C.	5mm

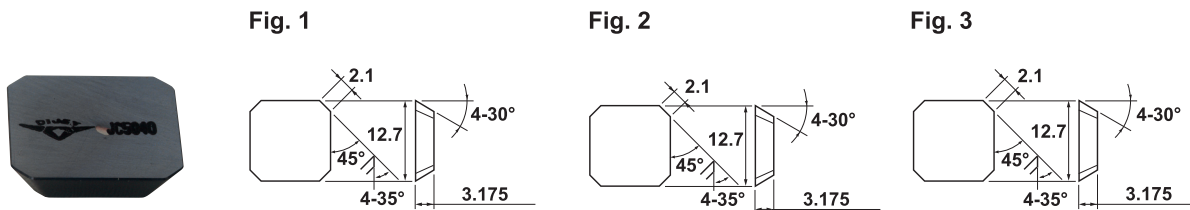


Specifications

CATALOG NUMBER	STK	DIMENSIONS			INSERT	Q	PARTS		
		D	D1	d			Screw	Wrench	Wedge
DSG45-4050S32	•	50	64	32	SGHN1203AZN-21	4	LS-180	T-27	81106-1R
DSG45-4063S32	•	63	77	32	SGHN1203AZN-F2	4			
					SGLN1203AZN-21				

Note: All cutters are supplied without inserts.

INSERTS



(for aluminum - sharp edge & polished)

Specifications - Metric

CATALOG NUMBER	DIMENSIONS			FIG.	COATED				CERMET	UNCOATED
	IC	T	IC TOLERANCE		JC5030	JC610	JC5040	JC730U		
SGHN1203AZN-21	12.7	3.175	H	1	•	•	•	•	•	•
SGHN1203AZN-F2	12.7	3.175	H	2						•
SGLN1203AZN-21	12.7	3.175	L	3	•					

Recommended Cutting Data

WORK MATERIALS	INSERT GRADE	Vc (m/min)	fz (mm/tooth)
Carbon Steel & Alloy Steel (180-280HB)	JC5030, JC5040, JC730U, CX90	180 - 300	0.2 - 0.5
Stainless Steel (~270HB)	JC5040, JC730U, CX90	120 - 220	0.2 - 0.3
Cast Iron (200-250HB)	JC610	150 - 250	0.2 - 0.4
Aluminum Alloy	KT9	300 - 800	0.2 - 0.5