



# ***DIJET CARBIDE TOOLS***

**Indexable Tools A2.1**

**High Feed**

# DIJET CARBIDE TOOLS

## Meeting the Trust of Customers

The industrial world, which is making remarkable progress, poses various difficult problems toward tooling. Dijet has been meeting the trust of customers with continuous development of new tools and materials using our experience of more than 50 years as a total carbide tool manufacturer.



QM Series

A-1



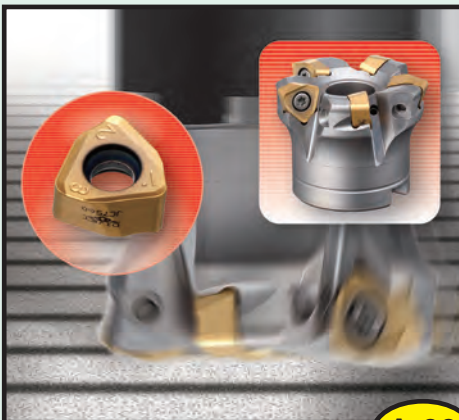
QM Max GII

A-19



SKS GII

A-25



SKS Extreme

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SKS

A-45

## HOW TO USE THE CATALOG

Please note that products in this catalog are continuously under study and are improved.

The products therefore may be changed in the future and thus become different from the catalog.

Stock status is mentioned for the products in this catalog. However, please note that the products here may be replaced by the new grades and products in the future.

Regarding stock status:

- Stock standard items (NOTE: Some items may be stocked in Japan - delivery approximately 2 weeks.)
- Non stock standard items (Inquire)

See Technical Catalog for grade information and spare part information.

## CUTTING STYLES



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\*Note: End mill style not G-body

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\*Note: End mill style not G-body

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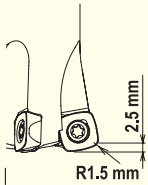
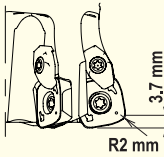

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\*Note: End mill style not G-body

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\*Note: End mill style not G-body












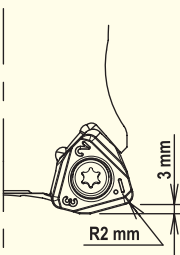

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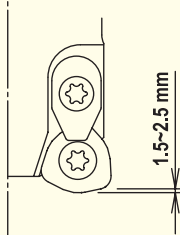







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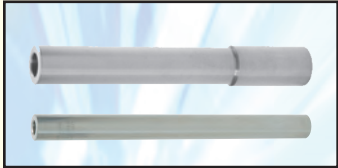






### High Feed Diemaster - SKS Page

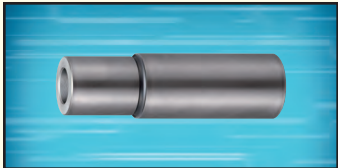

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# QM Mini

## MPM Style High Feed Mill



- High speed and high efficient machining.
- Multiple insert choices - High Feed Milling, Shoulder Milling of steel & aluminum, Milling of high hardened steels, Finishing side & bottom face.
- Able to machine wide variety of materials including high temp alloys.
- Capable of running on low horse power & compact machines.
- G-body is a GN surface-hardening treatment on thermal resistant high strength steel giving a hardness over 65 HRC and secures insert pocket and holder against thermal deformation improving body durability.



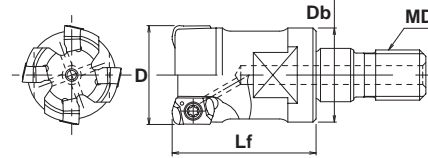
# QM Mini

INCH

METRIC

## QM MINI

New Generation of High Feed Mills  
MPM Style - G Body



### Modular Head Specifications

	CATALOG NUMBER	STK	DIMENSIONS				HEAD TORQUE		INSERT	Q	PARTS	
			D	Lf	Db	MD	lbs./ft	Nm			Screw	Wrench
INCH	MPM-3050-M6	•	.500	.787	.452	M6	5.9	8	EOM**0602**ZER EOHW0602**ZTR YOHW0602**ZER-12 ZOMT0602**ZER	3	DSW-1840H	T-06
	MPM-4062-M8	•	.625	.905	.590	M8	11.8	16		4		
	MPM-5075-M10	•	.750	1.18	.708	M10	11.8	16		5		
	MPM-6100-M12	•	1.00	1.37	.945	M12	14.7	20		6		
	MPM-8125-M16	•	1.25	1.69	1.14	M16	18.4	25		8		
METRIC	MPM-2010-M6	•	10	18	9.5	M6	5.9	8	EOM**0602**ZER EOHW0602**ZTR YOHW0602**ZER-12 ZOMT0602**ZER	2	DSW-1840H	T-06
	MPM-2011-M6	•	11	18	9.7	M6	5.9	8		2		
	MPM-3012-M6	•	12	20	11.2	M6	5.9	8		3		
	MPM-3013-M6	•	13	20	11.5	M6	5.9	8		3		
	MPM-4016-M8	•	16	23	15	M8	11.8	16		4		
	MPM-4017-M8	•	17	23	15	M8	11.8	16		4		
	MPM-5020-M10	•	20	30	19	M10	11.8	16		5		
	MPM-5021-M10	•	21	30	19	M10	11.8	16		5		
	MPM-6025-M12	•	25	35	23.6	M12	14.7	20		6		
	MPM-7030-M16	•	30	43	29	M16	18.4	25		7		
MPM-8032-M16	•	32	43	29	M16	18.4	25	8				

See page A-59 for Modular Head Shanks.

Note: All cutters are supplied without inserts or wrenches.



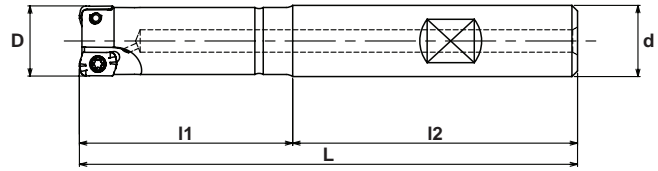


**INCH**

**METRIC**

**QM Mini**

**PME Style**



**Specifications for End Mill - Inch**

CATALOG NUMBER	STK	DIMENSIONS					INSERT	Q	PARTS	
		D	L	I1	I2	d			Screw	Wrench
PME-2037-1.0-S037LG*	•	.375	3.50	1.00	2.50	.375	EOM**0602**ZER	2	DSW-1840H	T-06
PME-3050-1.5-S050LG	•	.500	3.50	1.50	2.00	.500	EOHW0602**ZTR	3		
PME-4062-1.5-S062LG	•	.625	4.50	1.50	3.00	.625	YOHW0602**ZER-12 ZOMT0602**ZER	4		

\*Note: Recommended to use only high feed insert.

Note: All cutters are supplied without inserts or wrenches.



Fig. 1

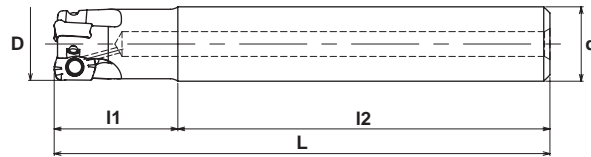
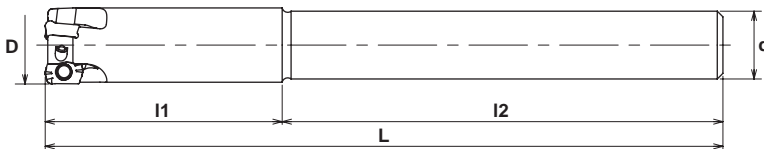


Fig. 2



**Specifications for End Mill - Metric**

CATALOG NUMBER	STK	DIMENSIONS					FIG.	INSERT	Q	PARTS	
		D	L	I1	I2	d				Screw	Wrench
PME2010S10	•	10	80	20	60	10	1	EOM**0602**ZER EOHW0602**ZTR YOHW0602**ZER-12 ZOMT0602**ZER	2	DSW-1840H	T-06
PME3012S12	•	12	80	20	60	12	1		3		
PME3014S12	•	14	80	20	60	12	1		3		
PME2011S10-LS	•	11	120	33	87	10	2		2		
PME3013S12-LS	•	13	120	39	81	12	2		3		
PME3014S12-LS	•	14	120	42	78	12	2		3		

Note: All cutters are supplied without inserts or wrenches.

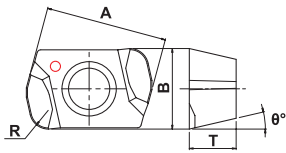


# QM Mini

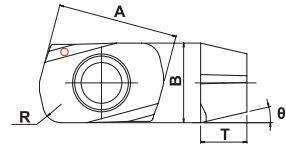
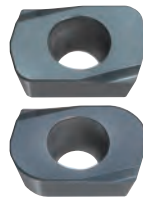
**METRIC**

## INSERTS

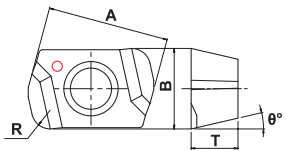
High feed insert (EOMT)



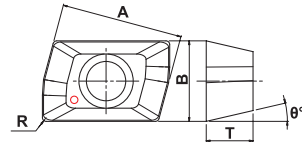
High hardened steel (EOHW)



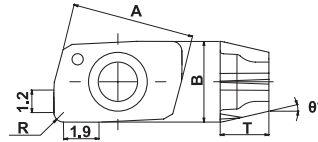
High feed insert for unfavorable condition (EOMW)



Shoulder milling insert (ZOMT)



"MIRROR INSERT" for finishing side & bottom face (YOHW)



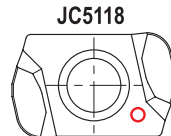
TYPE	CATALOG NUMBER	TOLERANCE	DIMENSIONS					PVD COATED					
			A	B	T	R	Ø	JC5118	JC8118	DH102	JC7560	JC8015	JC8050
High feed insert	EOMT060210ZER	M	6.5	4.3	2.5	1.0	13°		•		•		•
	EOMT060220ZER	M	6.5	4.3	2.5	2.0	13°		•				•
High feed insert for unfavorable condition	EOMW060210ZER	M	6.5	4.3	2.5	1.0	13°		•		•		•
High hardened steel	EOHW060210ZTR	H	6.5	4.3	2.5	1.0	13°		•	•			
	EOHW060220ZTR	H	6.5	4.3	2.5	2.0	13°		•	•	•		
Shoulder milling insert	ZOMT060202ZER	M	6.5	4.3	2.5	0.2	13°	•					•
	ZOMT060204ZER	M	6.5	4.3	2.5	0.4	13°	•					•
	ZOMT060208ZER	M	6.5	4.3	2.5	0.8	13°	•					•
"MIRROR INSERT" for finishing side & bottom face	YOHW060203ZER-12	H	6.5	4.3	2.6	0.3	13°			•		•	
	YOHW060205ZER-12	H	6.5	4.3	2.6	0.5	13°			•		•	
	YOHW060208ZER-12	H	6.5	4.3	2.6	0.8	13°			•		•	

### DISCRIMINATION OF GRADE FOR MPM / PME INSERT

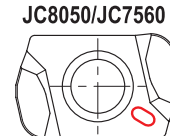
Each grade shows different mark around the hole for identification.



Discrimination mark



JC5118



JC8050/JC7560

### MAGNETISER



- Magnetizing and demagnetizing the wrench can easily be done by inserting the tip into the magnetizer and rubbing lightly.
- Do not use in the vicinity of the equipment that can be influenced with magnetism.

CATALOG NUMBER	STOCK
MAGNETISER	•

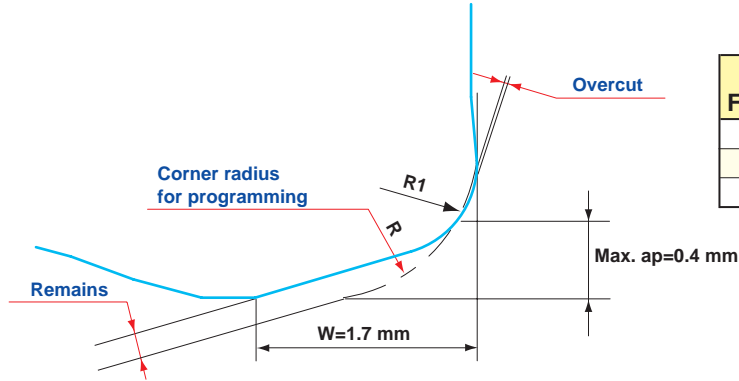


**INCH**

**METRIC**

**QM Mini**

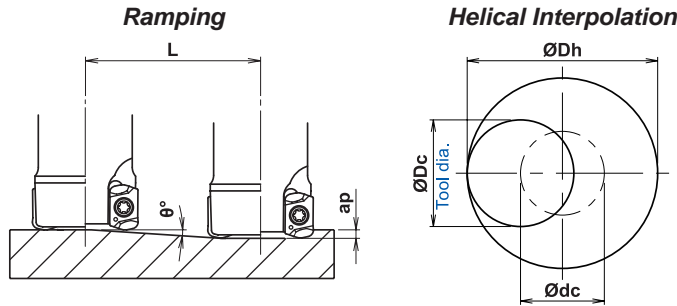
**Definition of corner shape for programming**



CORNER RADIUS FOR PROGRAMMING	Overcut	Remains
R1.0 (Standard)	0	0.17
R1.5	0.09	0.08
R2.0	0.30	0

(mm)

**Recommended Data for Profile Milling**



- Calculation of tool pass dia.  

$$\text{Ødc} = \text{ØDh} - \text{ØDc}$$

Tool pass dia.    Bore dia.    Tool Dia.
- Depth of cut per one circuit should not exceed max. depth of cut ap.
- Down cutting is recommended, so tool pass rotation should be counterclockwise.

- In case of ramping and helical interpolation, apply 70% or less feed (F) from standard cutting condition table.
- In case of drilling, apply 50% or less Z axis feed speed from standard cutting condition table.
- Long consecutive chips may come out in case of drilling, confirm safe cutting conditions.

	CATALOG NUMBER	TOOL DIAMETER	EFFECTIVE CUTTING DIA.	MAX. DEPTH OF CUT: ap	RAMPING		HELICAL INTERPOLATION	
					MAX. RAMP ANGLE	TOTAL CUTTING LENGTH AT MAX AP: L	MIN. BORE DIAMETER: Dh min	MAX. BORE DIAMETER: Dh max
INCH	PME-2037-1.0-S037LG	.375	.247	.012	2°20'	.30	.55	.67
	MPM/PME-3050-***	.500	.366	.012	1°30'	.45	.80	.92
	MPM/PME-4062-***	.625	.491	.016	1°	.90	1.05	1.17
	MPM-5075-M10	.750	.616	.016	0°48'	1.12	1.30	1.42
	MPM-6100-M12	1.00	.866	.016	0°30'	1.80	1.80	1.92
	MPM-8125-M16	1.25	1.116	.016	0°24'	2.25	2.3	2.42
METRIC	MPM/PME-2010-***	10	6.6	0.3	2°18'	7.5	15	18
	MPM/PME-2011-***	11	7.6	0.3	1°54'	9	17	20
	MPM/PME-3012-***	12	8.5	0.3	1°36'	10.7	19	22
	MPM/PME-3013-***	13	9.5	0.3	1°24'	12.3	21	24
	PME3014***	14	10.5	0.4	1°15'	18.5	23	26
	MPM-4016-M8	16	12.5	0.4	1°	22.9	27	30
	MPM-4017-M8	17	13.5	0.4	0°54'	25.5	29	32
	MPM-5020-M10	20	16.5	0.4	0°45'	30.6	35	38
	MPM-5021-M10	21	17.5	0.4	0°42'	32.7	37	40
	MPM-6025-M12	25	21.5	0.4	0°30'	45.8	45	48
	MPM-7030-M16	30	26.5	0.4	0°27'	50.9	55	58
	MPM-8032-M16	32	28.5	0.4	0°24'	57.3	59	62



# QM Mini

**INCH**

**METRIC**

## Recommended Cutting Data for QM Mini

Material	Parameters	High Feed			Square Shoulder	Finish	
		EOMT	EOMW	EOHW	ZOMT	YOHW Side	YOHW Bottom
Gray Cast Iron	SFM	700	700	800	700	1,200	720
	IPT	.030"	.030"	.030"	.008"	.006"	.007"
	DOC	.015"	.015"	.015"	.030"	.030"	.005"
	WOC	70%	70%	70%	.008"	.004"	60%
	Grade	JC7560	JC7560	DH102	JC8050	DH102	DH102
Nodular Cast Iron	SFM	650	650	750	650	1,100	660
	IPT	.025"	.025"	.025"	.008"	.006"	.007"
	DOC	.015"	.015"	.015"	.030"	.030"	.005"
	WOC	70%	70%	70%	.008"	.004"	60%
	Grade	JC7560	JC7560	DH102	JC8050	DH102	DH102
Carbon Steel	SFM	600	600	700	600	1,000	600
	IPT	.020"	.020"	.020"	.008"	.006"	.007"
	DOC	.015"	.015"	.015"	.025"	.025"	.005"
	WOC	70%	70%	70%	.008"	.004"	60%
	Grade	JC8118	JC5118	DH102	JC5118	DH102	DH102
Low Alloy Steel	SFM	550	550	650	550	1,000	600
	IPT	.020"	.020"	.020"	.025"	.006"	.007"
	DOC	.015"	.015"	.015"	.025"	.025"	.005"
	WOC	60%	60%	60%	.008"	.004"	60%
	Grade	JC8118	JC5118	DH102	JC5118	DH102	DH102
Mold Steel	SFM	500	500	600	500	900	540
	IPT	.020"	.020"	.020"	.006"	.005"	.006"
	DOC	.015"	.015"	.015"	.025"	.025"	.005"
	WOC	60%	60%	60%	.008"	.004"	60%
	Grade	JC8050	JC8050	DH102	JC8050	DH102	DH102
Tool & Die Steel (40-50 HRC)	SFM	400	400	500	400	750	450
	IPT	.010"	.010"	.012"	.006"	.005"	.006"
	DOC	.010"	.010"	.012"	.025"	.020"	.004"
	WOC	60%	60%	60%	.008"	.004"	40%
	Grade	JC8118	JC5118	DH102	JC5118	DH102	DH102
Hardened Die Steel (50-60 HRC)	SFM	*	*	250	*	600	360
	IPT	*	*	.006"	*	.004"	.005"
	DOC	*	*	.008"	*	.020"	.004"
	WOC	*	*	40%	*	.003"	40%
	Grade	*	*	DH102	*	DH102	DH102
Stainless Steel	SFM	300	*	*	300	250	150
	IPT	.020"	*	*	.006"	.005"	.006"
	DOC	.015"	*	*	.020"	.025"	.005"
	WOC	60%	*	*	.008"	.004"	60%
	Grade	JC8050	*	*	JC8050	JC8015	JC8015
Titanium	SFM	200	*	*	200	300	180
	IPT	.015"	*	*	.004"	.003"	.004"
	DOC	.010"	*	*	.020"	.020"	.004"
	WOC	60%	*	*	.006"	.003"	60%
	Grade	JC8050	*	*	JC8050	JC8015	JC8015
Inconel	SFM	100	*	*	100	200	120
	IPT	.010"	*	*	.003"	.003"	.004"
	DOC	.010"	*	*	.015"	.015"	.003"
	WOC	60%	*	*	.004"	.003"	40%
	Grade	JC8050	*	*	JC8050	JC8015	JC8015
Graphite	SFM	*	*	600	*	*	*
	IPT	*	*	.020"	*	*	*
	DOC	*	*	.010"	*	*	*
	WOC	*	*	20%	*	*	*
	Grade	*	*	DH102	*	*	*

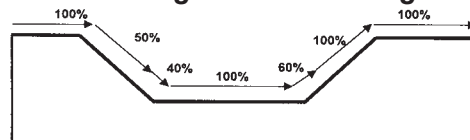
**NOTE:** 1. These parameters are for stable machining with steel bodies at lengths 4XD. See table below for longer applications.  
 2. RPM = 3.82 x SFM / Dia.  
 3. IPM = RPM x IPT x # of flutes (or teeth)

### Additional Cutting Data For Longer Tools

Reach/Dia.	~4.0	4.0~4.5	4.5~5.3	5.3~5.7	5.7~6.2	6.3~
rpm %	100	90	80	80	75	70
Feed %	100	90	90	80	75	70

**NOTE:** The above percentages should be applied, according to tool ratio.

### Reduced Cutting Data For Cutting Pattern



**NOTE:** Feed should be reduced when cutting the above pattern



# QM Max

## MQX Style High Feed Mill



- High speed and high efficient machining.
- Multiple insert choices - High Feed Milling, Shoulder Milling of steel & aluminum, Milling of high hardened steels, Finishing side & bottom face.
- Low cutting force good for long reach applications.
- Able to machine most materials.
- G-body is a GN surface-hardening treatment on thermal resistant high strength steel giving a hardness over 65 HRC and secures insert pocket and holder against thermal deformation improving body durability.



# QM Max

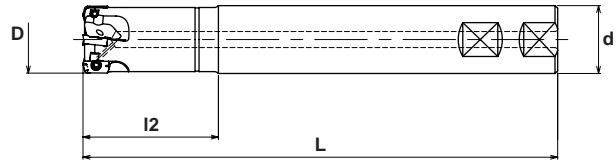
INCH

METRIC

## QM Max

New Generation of High Feed Mills

QXPS Style

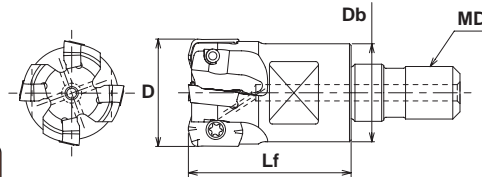


### Specifications - Inch

CATALOG NUMBER	STK	DIMENSIONS				INSERT	Q	PARTS	
		D	L	l2	d			Screw	Wrench
QXPS-3075-2.0-S075NP	•	.750	5.00	2.00	.750	EPMT1003**ZER	3	TSW-2556H	T-08
QXPS-3075-3.0-S075NP	•	.750	6.25	3.00	.750	EPMT1003**ZER	3		
QXPS-4100-2.0-S100NP	•	1.00	7.00	2.00	1.00	EPMW100312Z*R	4	DSW-2563H	T-08
QXPS-4100-3.0-S100NP	•	1.00	8.00	3.00	1.00	EPHW100316ZTR	4		
QXPS-5125-3.0-S125NP	•	1.25	5.50	3.00	1.25	ZPMT1003**ZER-**	5		
QXPS-5125-4.75-S125NP	•	1.25	8.00	4.75	1.25	ZPMT1003**ZER-**	5		
QXPS-6150-3.0-S125NP	•	1.50	5.50	3.00	1.50	YPHW1003**Z*R-**	6		
QXPS-6150-4.75-S125NP	•	1.50	8.00	4.75	1.50	YPHW1003**Z*R-**	6		

Note: All cutters are supplied without inserts or wrenches.

## MQX Style



### Specifications

	CATALOG NUMBER	STK	DIMENSIONS				HEAD TORQUE		INSERT	Q	PARTS	
			D	Lf	Db	MD	lbs./ft	Nm			Screw	Wrench
INCH	MQX-3075-M10	•	.750	1.18	.708	M10	11.8	16	EPMT1003**ZER	3	TSW-2556H	T-08
	MQX-5100-M12	•	1.00	1.38	.809	M12	14.7	20		5	DSW-2563H	T-08
	MQX-5125-M16	•	1.25	1.69	1.14	M16	18.4	25		5		
METRIC	MQX-2016-M8	•	16	23	14	M8	11.8	16	EPMT1003**ZER	2	TSW-2556H	T-08
	MQX-2017-M8	•	17	23	14	M8	11.8	16		2		
	MQX-3020-M10	•	20	30	18	M10	11.8	16		3		
	MQX-4020-M10	•	20	30	18	M10	11.8	16		4		
	MQX-4021-M10	•	21	30	18	M10	11.8	16		4		
	MQX-4025-M12	•	25	35	22.5	M12	14.7	20		4		
	MQX-5025-M12	•	25	35	22.5	M12	14.7	20		5	DSW-2563H	T-08
	MQX-4026-M12	•	26	35	22.5	M12	14.7	20		4		
	MQX-5026-M12	•	26	35	22.5	M12	14.7	20		5		
	MQX-5028-M12	•	28	35	23.6	M12	14.7	20		5		
	MQX-5030-M16	•	30	43	27	M16	18.4	25		5		
	MQX-5032-M16	•	32	43	29	M16	18.4	25		5		
	MQX-6032-M16	•	32	43	29	M16	18.4	25		6		
	MQX-5035-M16	•	35	43	29	M16	18.4	25		5		
	MQX-6035-M16	•	35	43	29	M16	18.4	25		6		
	MQX-6040-M16	•	40	43	32	M16	18.4	25		6		
	MQX-7040-M16	•	40	43	32	M16	18.4	25		7		
	MQX-6042-M16	o	42	43	32	M16	18.4	25		6		

See page A-59 for Modular Head Shanks.

o - longer delivery may apply.

Note: All cutters are supplied without inserts or wrenches.



**INCH**

**METRIC**

**QM Max**

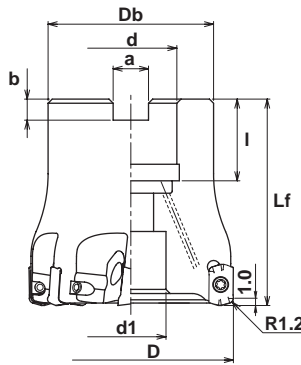
**QXP Style**

**G-Body**

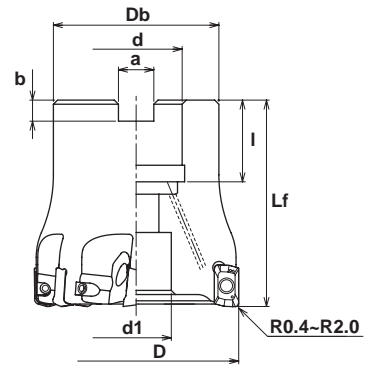


**Fig. 1**

**High Feed Milling**

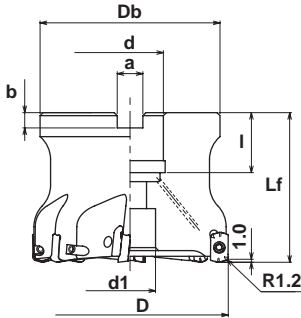


**Shoulder Milling**

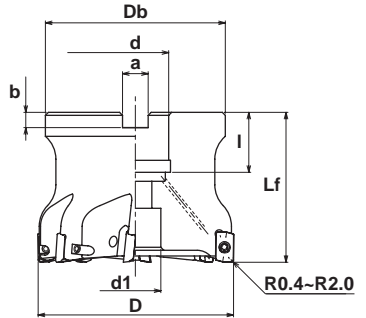


**Fig. 2**

**High Feed Milling**



**Shoulder Milling**



**Specifications - Inch**

CATALOG NUMBER	STK	DIMENSIONS								FIG.	INSERT	Q	PARTS	
		D	Lf	Db	d	d1	a	b	l				Screw	Wrench
QXP-8200R-075	•	2.00	2.00	1.77	.750	.63	.319	.197	.750	1	EPMT1003**ZER EPMW100312Z*R EPHW100316ZTR ZPMT1003**ZER** YPHW1003**Z*R**	8	DSW-2563H	T-08

Note: All cutters are supplied without inserts or wrenches.

**Specifications - Metric**

CATALOG NUMBER	STK	DIMENSIONS								FIG.	INSERT	Q	PARTS	
		D	Lf	Db	d	d1	a	b	l				Screw	Wrench
QXP-6040R-16	•	40	45	35	16	14	8.4	5.6	18	1	EPMT1003**ZER EPMW100312Z*R EPHW100316ZTR ZPMT1003**ZER** YPHW1003**Z*R**	6	DSW-2563H	T-08
QXP-7040R-16	•	40	45	35	16	14	8.4	5.6	18	1		7		
QXP-7050R-22	•	50	50	40	22	17	10.4	6.3	20	1		7		
QXP-8050R	•	50	50	40	22.225	17	8.4	5	20	1		8		
QXP-8050R-22	•	50	50	40	22	17	10.4	6.3	20	1		8		
QXP-8052R-22	◦	52	50	40	22	17	10.4	6.3	20	1		8		
QXP-8063R	•	63	50	48	22.225	17	8.4	5	20	1		8		
QXP-8063R-22	•	63	50	48	22	17	10.4	6.3	20	1		8		
QXP-8066R	•	66	50	60	22.225	17	8.4	5	20	2		8		
QXP-8066R-27	◦	66	50	48	27	20	12.4	7	22	2		8		

◦ - longer delivery may apply.

Note: All cutters are supplied without inserts or wrenches.

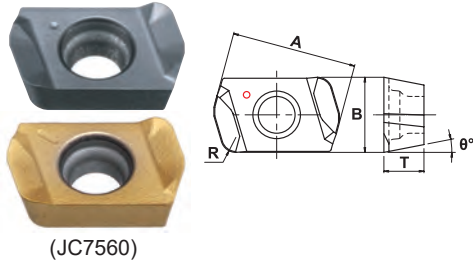


# QM Max

**INCH**

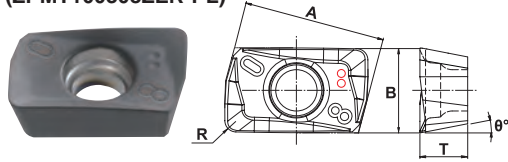
**METRIC**

High feed insert  
(EPMT100312ZER)

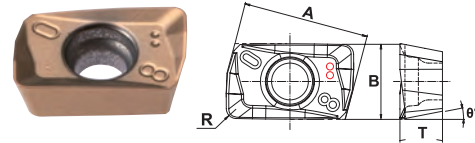


(JC7560)

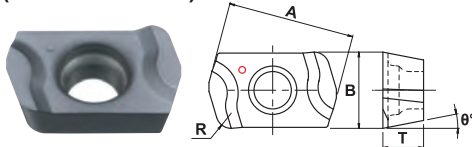
Shoulder insert from semi-finishing to side and bottom finishing  
(ZPMT100308ZER-PL)



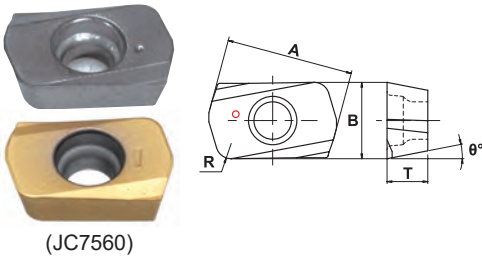
Shoulder insert for TiAlloy  
(ZPMT100308ZER-SL)



High feed insert for unfavorable conditions  
(EPMW100312ZER)

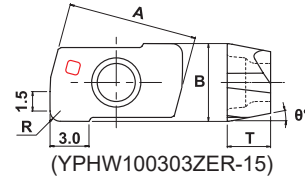


High feed insert for unfavorable conditions  
(EPMW100312ZTR)

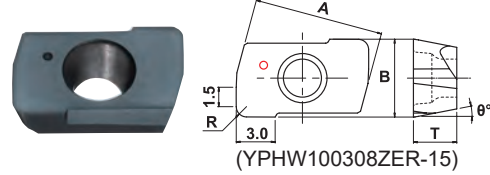


(JC7560)

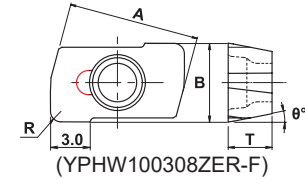
"Mirror Insert" for finishing side & bottom face  
(YPHW1003\*\*ZER-15) (YPHW100308ZTR-F1) (YPHW100308ZER-F)



(YPHW100303ZER-15)

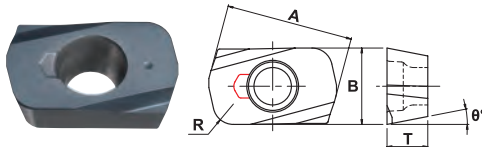


(YPHW100308ZER-15)

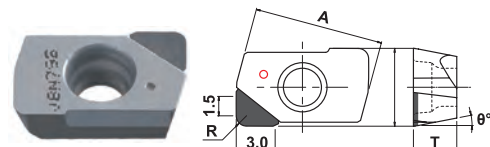


(YPHW100308ZER-F)

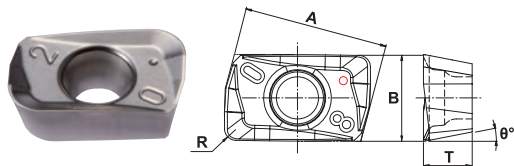
For high hardened steel  
(EPHW100316ZTR)



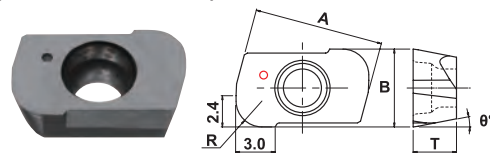
CBN



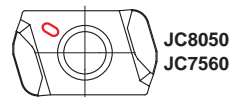
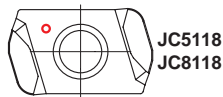
Shoulder insert for aluminum  
(ZPMT100308ZER-NL)



"Mirror Insert" for finishing side & bottom face and contouring  
(YPHW100320ZER-24)



Grade Markings:







INCH

METRIC

QM Max

## INSERTS

## Specifications for inserts

CATALOG NUMBER	TOLERANCE	DIMENSIONS						COATED						CBN	CERMET	UNCOATED
								PVD COATED								
		A	B	T	R	Ø	JC8118	DH102	JC7560	JC8015	JC8050	JC7518	JBN795	CX75	FC18	
EPMT100312ZER	M	10	6	3.2	1.2	11°	•		•		•					
EPMT100320ZER	M	10	6	3.2	2.0	11°	•									
EPMW100312ZER	M	10	6	3.2	1.2	11°	•				•					
EPMW100312ZTR	M	10	6	3.2	1.2	11°	•		•		•					
EPHW100316ZTR	H	10	6	3.2	1.6	11°	•	•								
ZPMT100320ZER	M	10	6	3.2	2.0	11°					•					
ZPMT100304ZER-NL	M	10.08	6	3.4	0.4	11°									•	
ZPMT100308ZER-NL	M	10.08	6	3.4	0.8	11°									•	
ZPMT100320ZER-NL	M	10.08	6	3.4	2.0	11°									•	
ZPMT100304ZER-PL	M	10.08	6	3.4	0.4	11°	•	•			•			•		
ZPMT100308ZER-PL	M	10.08	6	3.4	0.8	11°	•	•			•			•		
ZPMT100320ZER-PL	M	10.08	6	3.4	2.0	11°	•	•			•			•		
ZPMT100304ZER-SL	M	10.08	6	3.4	0.4	11°						•				
ZPMT100308ZER-SL	M	10.08	6	3.4	0.8	11°						•				
ZPMT100320ZER-SL	M	10.08	6	3.4	2.0	11°						•				
YPHW100303ZER-15	H	10.06	6	3.35	0.3	11°		•		•				•		
YPHW100308ZER-15	H	10.06	6	3.35	0.8	11°		•						•		
YPHW100308ZER-F	H	10.06	6	3.35	0.8	11°				•						
YPHW100308ZTR-F1	H	10.06	6	3.35	0.8	11°							•			
YPHW100320ZER-24	H	10.06	6	3.35	2.0	11°		•		•						



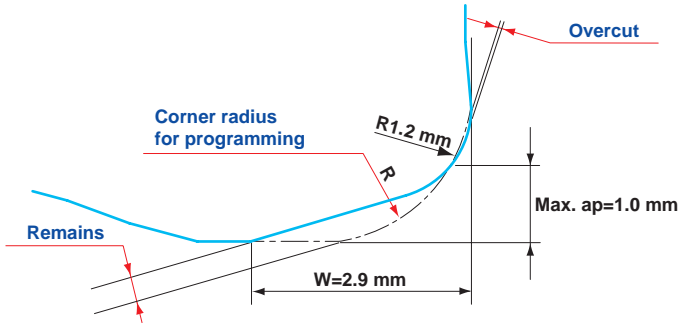
# QM Max

INCH

METRIC

## Definition of corner shape for programming

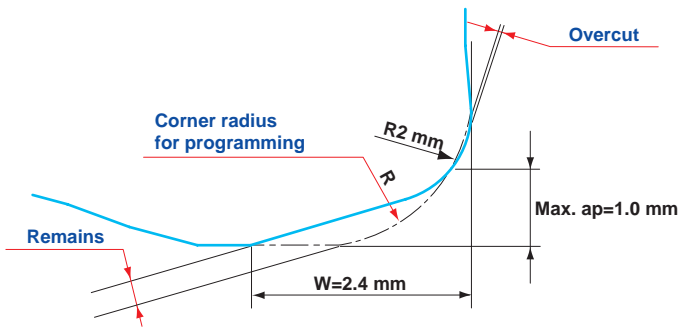
### EPMT/W Insert w/1.2mm Corner Radius



(mm)

CORNER RADIUS FOR PROGRAMMING	Overcut	Remains
R1.0	0	0.57
R1.5 (Standard)	0	0.45
R2.0	0.04	0.33
R2.5	0.21	0.21
R3.0	0.40	0.09

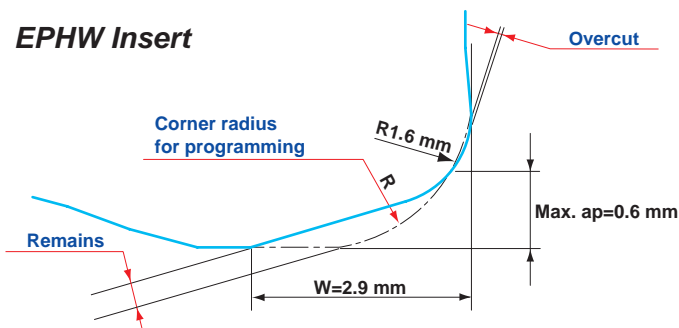
### EPMT Insert w/2.0mm Corner Radius



(mm)

CORNER RADIUS FOR PROGRAMMING	Overcut	Remains
R1.0	0	0.51
R1.5	0	0.31
R2.0 (Standard)	0	0.13
R2.5	0.12	0.04
R3.0	0.32	0

### EPHW Insert



(mm)

CORNER RADIUS FOR PROGRAMMING	Overcut	Remains
R1.0	0	0.42
R1.5 (Standard)	0	0.33
R2.0	0.01	0.23
R2.5	0.17	0.14
R3.0	0.37	0.05

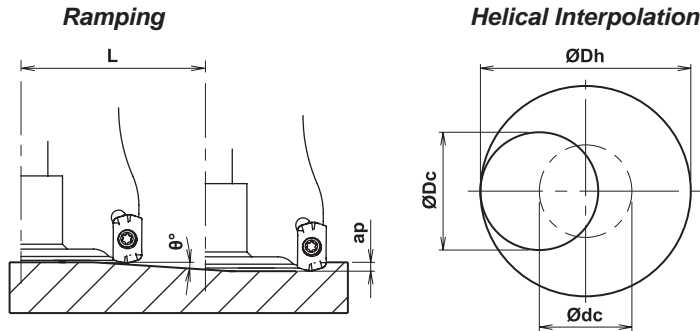


**INCH**

**METRIC**

**QM Max**

**Recommended Data for Profile Milling**



- Calculation of tool pass dia.  

$$\text{Tool pass dia.} = \text{Bore dia.} - \text{Tool Dia.}$$

$$\text{Ødc} = \text{ØDh} - \text{ØDc}$$
- Depth of cut per one circuit should not exceed max. depth of cut ap.
- Down cutting is recommended, so tool pass rotation should be counterclockwise.

- In case of ramping and helical interpolation, apply 70% or less feed (F) from standard cutting condition table.
- In case of drilling, apply 50% or less Z axis feed speed from standard cutting condition table.
- Long consecutive chips may come out in case of drilling, confirm safe cutting conditions.

	CATALOG NUMBER	TOOL DIAMETER	EFFECTIVE CUTTING DIA.	MAX. DEPTH OF CUT: ap	RAMPING		HELICAL INTERPOLATION	
					MAX. RAMP ANGLE	TOTAL CUTTING LENGTH AT MAX AP: L	MIN. BORE DIAMETER: Dh min	MAX. BORE DIAMETER: Dh max
INCH	MQX/QXPS-*075	.750	.520	.031	1°30'	1.20	1.11	1.42
	MQX/QXPS-*100	1.00	.768	.031	1°	1.80	1.61	1.92
	MQX/QXPS-*125	1.25	1.018	.031	0°54'	1.97	2.11	2.42
	QXPS-6150	1.50	1.268	.031	0°36'	2.96	2.61	2.92
	QXP-8200	2.00	1.768	.039	0°24'	5.59	3.61	3.92
METRIC	MQX-*016-M8	16	10.2	0.8	1°48'	25.5	22	30
	MQX-*017-M8	17	11.2	0.8	1°36'	28.6	24	32
	MQX-*020-M10	20	14.1	0.8	1°24'	32.7	30	38
	MQX-*021-M10	21	15.1	0.8	1°18'	35.3	32	40
	MQX-*025-M12	25	19.1	0.8	1°	45.8	40	48
	MQX-*026-M12	26	20.1	0.8	0°57'	48.2	42	50
	MQX-5028-M12	28	22.1	0.8	0°51'	53.9	46	54
	MQX-*030-M16	30	24.1	0.8	0°48'	57.3	50	58
	MQX-*032-M16	32	26.1	0.8	0°42'	65.5	54	62
	MQX-*035-M16	35	29.1	0.8	0°36'	76.4	60	68
	MQX-*040-M16	40	34.1	0.8	0°30'	91.7	70	78
	MQX-*042-M16	42	36.2	0.8	0°27'	101.9	74	82
	QXP-*040R-16	40	34.1	1	0°30'	114.6	70	78
	QXP-8050R	50	44.1	1	0°24'	143.2	90	98
	QXP-*050R-22	50	44.1	1	0°24'	143.2	90	98
	QXP-8052R-22	52	46.1	1	0°21'	163.7	94	102
	QXP-8063R	63	57.1	1	0°18'	191	116	124
	QXP-8063R-22	63	57.1	1	0°18'	191	116	124
	QXP-8066	66	60.1	1	0°18'	191	122	130
	QXP-8066R-27	66	60.1	1	0°18'	191	122	130

Note: The ramping angle 0.5° or less is recommended (please refer to the above table).



# QM Max

INCH

METRIC

## Recommended Cutting Data for QM Max - Face & Shoulder Milling

Material	Parameters	Face Milling				Shoulder Milling
		EPMT	EPMW-ZER	EPMW-ZTR	EPHW	ZPMT
Gray Cast Iron	SFM	700	700	700	*	700
	IPT	.025"	.030"	.030"	*	.008"
	DOC	.035"	.035"	.035"	*	.050"
	WOC	70%	70%	70%	*	60%
	Grade	JC8118/JC8050	JC8118	JC8118	*	JC8118
Nodular Cast Iron	SFM	650	650	650	*	650
	IPT	.025"	.030"	.030"	*	.008"
	DOC	.035"	.035"	.035"	*	.050"
	WOC	70%	70%	70%	*	60%
	Grade	JC8118/JC8050	JC8118	JC8118	*	JC8118
Carbon Steel	SFM	600	600	600	*	600
	IPT	.025"	.030"	.030"	*	.006"
	DOC	.030"	.030"	.030"	*	.040"
	WOC	70%	70%	70%	*	60%
	Grade	JC7560/JC8050	JC8050	JC7560/JC8050	*	JC8050
Low Alloy Steel	SFM	550	550	550	*	550
	IPT	.025"	.025"	.025"	*	.006"
	DOC	.025"	.025"	.025"	*	.040"
	WOC	60%	60%	60%	*	60%
	Grade	JC7560/JC8050	JC8050	JC7560/JC8050	*	JC8050
Mold Steel	SFM	500	500	500	*	500
	IPT	.025"	.025"	.025"	*	.006"
	DOC	.025"	.025"	.025"	*	.040"
	WOC	60%	60%	60%	*	60%
	Grade	JC8118/JC8050	JC8118/JC8050	JC8818/JC8050	*	JC8118
Tool & Die Steel (40-50 HRC)	SFM	400	400	400	500	400
	IPT	.015"	.020"	.020"	.020"	.005"
	DOC	.020"	.020"	.020"	.020"	.035"
	WOC	60%	60%	60%	60%	60%
	Grade	JC8118/JC8050	JC8118/JC8050	JC8118/JC8050	JC8118	JC8118
Hardened Die Steel (50-60 HRC)	SFM	*	*	*	250	200
	IPT	*	*	*	.012"	.004"
	DOC	*	*	*	.010"	.030"
	WOC	*	*	*	40%	40%
	Grade	*	*	*	DH102	DH102
Stainless Steel	SFM	300	*	*	*	300
	IPT	.020"	*	*	*	.006"
	DOC	.020"	*	*	*	.030"
	WOC	60%	*	*	*	60%
	Grade	JC8050/JC7560	*	*	*	JC8050
Titanium	SFM	200	*	*	*	200
	IPT	.015"	*	*	*	.006"
	DOC	.020"	*	*	*	.030"
	WOC	60%	*	*	*	60%
	Grade	JC7560/JC8050	*	*	*	JC7518
Inconel	SFM	100	*	*	*	100
	IPT	.010"	*	*	*	.006"
	DOC	.015"	*	*	*	.030"
	WOC	60%	*	*	*	60%
	Grade	JC8118/JC8050	*	*	*	JC7518
Aluminum ZPMT100308ZER-NL	SFM	*	*	*	*	1,500
	IPT	*	*	*	*	.008"
	DOC	*	*	*	*	.050"
	WOC	*	*	*	*	60%
	Grade	*	*	*	*	FC18
Graphite	SFM	*	*	*	600	*
	IPT	*	*	*	.025"	*
	DOC	*	*	*	.025"	*
	WOC	*	*	*	25%	*
	Grade	*	*	*	DH102	*

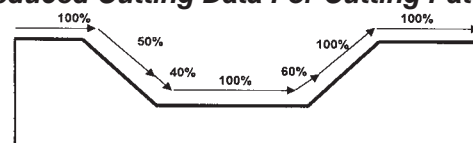
NOTE: 1. These parameters are for stable machining with steel bodies at lengths 4XD. See table below for longer applications.  
 2. RPM = 3.82 x SFM / Dia.  
 3. IPM = RPM x IPT x # of flutes (or teeth)

### Additional Cutting Data For Longer Tools

Reach/Dia.	~4.0	4.0~4.5	4.5~5.3	5.3~5.7	5.7~6.2	6.3~
rpm %	100	90	80	80	75	70
Feed %	100	90	90	80	75	70

NOTE: The above percentages should be applied, according to tool ratio.

### Reduced Cutting Data For Cutting Pattern



NOTE: Feed should be reduced when cutting the above pattern



**INCH**

**METRIC**

**QM Max**

**Recommended Cutting Data for QM Max - Side Finishing**

Material	Parameters	ZPMT-PL	YPHW-F	YPHW-15/-24	YPHW-F1	ZPMT-NL	ZPMT-SL
Gray Cast Iron	SFM	1,200	1,200	1,200	2,500	*	*
	IPT	.010"	.008"	.008"	.004"	*	*
	DOC	.125"	.080"	.040"	.030"	*	*
	WOC	.010"	.008"	.008"	.004"	*	*
	Grade	DH102	JC8015	DH102	JBN795	*	*
Nodular Cast Iron	SFM	1,100	1,100	1,100	2,500	*	*
	IPT	.010"	.008"	.008"	.004"	*	*
	DOC	.080"	.080"	.040"	.030"	*	*
	WOC	.010"	.008"	.008"	.004"	*	*
	Grade	DH102	JC8015	DH102	JBN795	*	*
Carbon Steel	SFM	1,000	1,000	1,000	*	*	*
	IPT	.010"	.008"	.008"	*	*	*
	DOC	.125"	.080"	.040"	*	*	*
	WOC	.008"	.008"	.008"	*	*	*
	Grade	DH102	JC8015	DH102	*	*	*
Low Alloy Steel	SFM	1,000	1,000	1,000	*	*	*
	IPT	.008"	.008"	.008"	*	*	*
	DOC	.125"	.080"	.040"	*	*	*
	WOC	.008"	.008"	.008"	*	*	*
	Grade	DH102	JC8015	DH102	*	*	*
Mold Steel	SFM	900	900	900	*	*	*
	IPT	.008"	.008"	.008"	*	*	*
	DOC	.125"	.080"	.040"	*	*	*
	WOC	.010"	.008"	.008"	*	*	*
	Grade	DH102	JC8015	DH102	*	*	*
Tool & Die Steel (40-50 HRC)	SFM	750	750	750	2,000	*	*
	IPT	.006"	.006"	.006"	.004"	*	*
	DOC	.100"	.080"	.040"	.020"	*	*
	WOC	.008"	.008"	.008"	.003"	*	*
	Grade	DH102	JC8015	DH102	JBN795	*	*
Hardened Die Steel (50-60 HRC)	SFM	600	600	600	1,500	*	*
	IPT	.004"	.004"	.004"	.003"	*	*
	DOC	.080"	.060"	.030"	.015"	*	*
	WOC	.004"	.004"	.004"	.003"	*	*
	Grade	DH102	JC8015	DH102	JBN795	*	*
Stainless Steel	SFM	250	250	250	*	*	*
	IPT	.008"	.008"	.008"	*	*	*
	DOC	.080"	.060"	.030"	*	*	*
	WOC	.008"	.008"	.008"	*	*	*
	Grade	JC8118	JC8015	JC8015	*	*	*
Titanium	SFM	*	*	*	*	*	300
	IPT	*	*	*	*	*	.005"
	DOC	*	*	*	*	*	.040"
	WOC	*	*	*	*	*	.004"
	Grade	*	*	*	*	*	JC7518
Inconel	SFM	*	*	*	*	*	300
	IPT	*	*	*	*	*	.005"
	DOC	*	*	*	*	*	.040"
	WOC	*	*	*	*	*	.004"
	Grade	*	*	*	*	*	JC7518
Aluminum	SFM	*	*	*	*	2,000	*
	IPT	*	*	*	*	.008"	*
	DOC	*	*	*	*	.080"	*
	WOC	*	*	*	*	.010"	*
	Grade	*	*	*	*	FC18	*

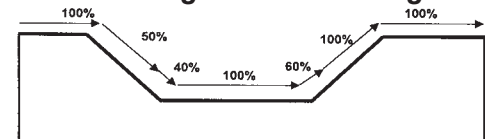
**NOTE:** 1. These parameters are for stable machining with steel bodies at lengths 4XD. See table below for longer applications.  
 2. RPM = 3.82 x SFM / Dia.  
 3. IPM = RPM x IPT x # of flutes (or teeth)

**Additional Cutting Data For Longer Tools**

Reach/Dia.	~4.0	4.0~4.5	4.5~5.3	5.3~5.7	5.7~6.2	6.3~
rpm %	100	90	80	80	75	70
Feed %	100	90	90	80	75	70

**NOTE:** The above percentages should be applied, according to tool ratio.

**Reduced Cutting Data For Cutting Pattern**



**NOTE:** Feed should be reduced when cutting the above pattern



# QM Max

INCH

METRIC

## Recommended Cutting Data for QM Max - Bottom Finishing

Material	Parameters	ZPMT-PL	YPHW-F	YPHW-15/-24	YPHW-F1	ZPMT-NL	ZPMT-SL
Gray Cast Iron	SFM	840	840	840	1,750	*	*
	IPT	.008"	.010"	.012"	.004"	*	*
	DOC	.008"	.008"	.010"	.003"	*	*
	WOC	60%	60%	60%	60%	*	*
	Grade	DH102	JC8015	DH102	JBN795	*	*
Nodular Cast Iron	SFM	770	770	770	1,750	*	*
	IPT	.008"	.010"	.012"	.004"	*	*
	DOC	.008"	.008"	.010"	.003"	*	*
	WOC	60%	60%	60%	60%	*	*
	Grade	DH102	JC8015	DH102	JBN795	*	*
Carbon Steel	SFM	700	700	700	*	*	*
	IPT	.010"	.010"	.012"	*	*	*
	DOC	.008"	.008"	.010"	*	*	*
	WOC	60%	60%	60%	*	*	*
	Grade	DH102	JC8015	DH102	*	*	*
Low Alloy Steel	SFM	700	700	700	*	*	*
	IPT	.008"	.010"	.012"	*	*	*
	DOC	.006"	.008"	.010"	*	*	*
	WOC	60%	60%	60%	*	*	*
	Grade	DH102	JC8015	DH102	*	*	*
Mold Steel	SFM	630	630	630	*	*	*
	IPT	.006"	.008"	.010"	*	*	*
	DOC	.006"	.008"	.010"	*	*	*
	WOC	60%	60%	60%	*	*	*
	Grade	DH102	JC8015	DH102	*	*	*
Tool & Die Steel (40-50 HRC)	SFM	525	525	525	1,400	*	*
	IPT	.006"	.006"	.008"	.004"	*	*
	DOC	.005"	.008"	.008"	.003"	*	*
	WOC	60%	60%	60%	60%	*	*
	Grade	DH102	JC8015	DH102	JBN795	*	*
Hardened Die Steel (50-60 HRC)	SFM	420	420	420	1,050	*	*
	IPT	.004"	.004"	.006"	.003"	*	*
	DOC	.004"	.005"	.005"	.003"	*	*
	WOC	40%	40%	40%	60%	*	*
	Grade	DH102	JC8015	DH102	JBN795	*	*
Stainless Steel	SFM	175	175	175	*	*	*
	IPT	.008"	.010"	.012"	*	*	*
	DOC	.006"	.008"	.010"	*	*	*
	WOC	60%	60%	60%	*	*	*
	Grade	JC8118	JC8015	JC8015	*	*	*
Titanium	SFM	*	*	*	*	*	210
	IPT	*	*	*	*	*	.005"
	DOC	*	*	*	*	*	.006"
	WOC	*	*	*	*	*	40%
	Grade	*	*	*	*	*	JC7518
Inconel	SFM	*	*	*	*	*	70
	IPT	*	*	*	*	*	.003"
	DOC	*	*	*	*	*	.005"
	WOC	*	*	*	*	*	40%
	Grade	*	*	*	*	*	JC7518
Aluminum	SFM	*	*	*	*	1,400	*
	IPT	*	*	*	*	.008"	*
	DOC	*	*	*	*	.080"	*
	WOC	*	*	*	*	.010"	*
	Grade	*	*	*	*	FC18	*

NOTE: 1. These parameters are for stable machining with steel bodies at lengths 4XD. See table below for longer applications.

2. RPM = 3.82 x SFM / Dia.

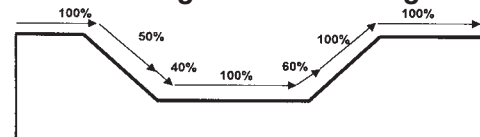
3. IPM = RPM x IPT x # of flutes (or teeth)

### Additional Cutting Data For Longer Tools

Reach/Dia.	~4.0	4.0~4.5	4.5~5.3	5.3~5.7	5.7~6.2	6.3~
rpm %	100	90	80	80	75	70
Feed %	100	90	90	80	75	70

NOTE: The above percentages should be applied, according to tool ratio.

### Reduced Cutting Data For Cutting Pattern



NOTE: Feed should be reduced when cutting the above pattern



INCH

METRIC

QM Max

Recommended Cutting Data for QM Max - Vertical Side Finishing

Material	Parameters	YPHW-15	YPHW-F
Gray Cast Iron	SFM	1,800	1,800
	IPT	.006"	.006"
	Peck Feed	.020" x D	.020" x D
	WOC	< .008"	< .008"
	Grade	JC8015	JC8015
Nodular Cast Iron	SFM	1,800	1,800
	IPT	.006"	.006"
	Peck Feed	.020" x D	.020" x D
	WOC	< .008"	< .008"
	Grade	JC8015	JC8015
Carbon Steel	SFM	1,480	1,480
	IPT	.007"	.007"
	Peck Feed	.020" x D	.020" x D
	WOC	< .008"	< .008"
	Grade	JC8015	JC8015
Low Alloy Steel	SFM	1,310	1,310
	IPT	.007"	.007"
	Peck Feed	.020" x D	.020" x D
	WOC	< .008"	< .008"
	Grade	JC8015	JC8015
Mold Steel	SFM	1,150	1,150
	IPT	.006"	.006"
	Peck Feed	.020" x D	.020" x D
	WOC	< .008"	< .008"
	Grade	JC8015	JC8015
Tool & Die Steel (40-50 HRC)	SFM	560	560
	IPT	.004"	.004"
	Peck Feed	.020" x D	.020" x D
	WOC	< .006"	< .006"
	Grade	DH102	JC8015
Hardened Die Steel (50-60 HRC)	SFM	*	*
	IPT	*	*
	Peck Feed	*	*
	WOC	*	*
	Grade	*	*
Stainless Steel	SFM	*	*
	IPT	*	*
	Peck Feed	*	*
	WOC	*	*
	Grade	*	*
Titanium	SFM	*	*
	IPT	*	*
	Peck Feed	*	*
	WOC	*	*
	Grade	*	*
Inconel	SFM	*	*
	IPT	*	*
	Peck Feed	*	*
	WOC	*	*
	Grade	*	*

**NOTE:** 1. These parameters are for stable machining with steel bodies at lengths 4XD. See table below for longer applications.  
 2. RPM = 3.82 x SFM / Dia.  
 3. IPM = RPM x IPT x # of flutes (or teeth)







# QM Max GII

## Max Master



- Double sided high feed insert with 4 cutting edges.
- Low cutting force with optimum cutting edge.
- New strong PH chipbreaker insert is excellent in fracture resistant and applicable to heavy applications.
- Excellent in ramping, helical interpolation and high efficient pocket milling.
- G-body is a GN surface-hardening treatment on thermal resistant high strength steel giving a hardness over 65 HRC and secures insert pocket and holder against thermal deformation improving body durability.

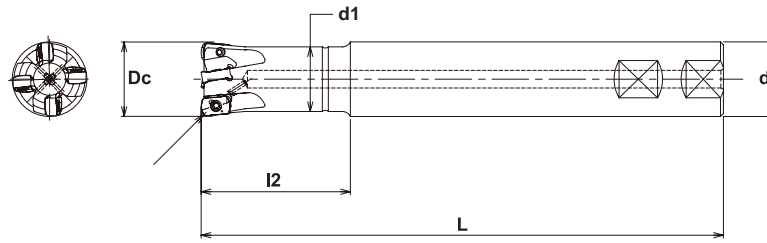


# QM Max GII

INCH

METRIC

## End Mill GMXS Style

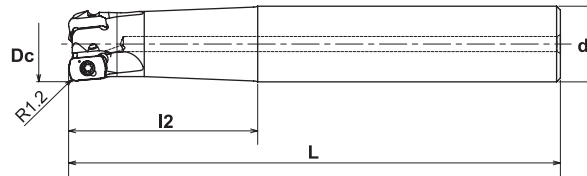


### Specifications - Inch

CATALOG NUMBER	STK	DIMENSIONS					INSERT	Q	PARTS	
		Dc	d1	l2	L	d			Screw	Wrench
GMXS-2062-2.0-S062NP	•	.625	.551	2.00	5.00	.625	ENMU100412ZER-**	2	TSW-2567H	T-08
GMXS-2062-3.0-S062NP	•	.625	.551	3.00	6.25	.625		2		
GMXS-3075-2.0-S075NP	•	.750	.677	2.00	5.00	.750		3		
GMXS-3075-3.0-S075NP	•	.750	.677	3.00	6.25	.750		3		
GMXS-3100-2.0-S100NP	•	1.00	.866	2.00	7.00	1.00		3		
GMXS-3100-3.0-S100NP	•	1.00	.866	3.00	8.00	1.00		3		
GMXS-4100-2.0-S100NP	•	1.00	.866	2.00	7.00	1.00		4		
GMXS-4100-3.0-S100NP	•	1.00	.866	3.00	8.00	1.00		4		
GMXS-5125-3.0-S125NP	•	1.25	1.14	3.00	5.50	1.25		5		
GMXS-5125-4.75-S125NP	•	1.25	1.14	4.75	8.00	1.25		5		

Note: All cutters are supplied without inserts or wrenches.

## GMX Style



### Specifications - Metric

CATALOG NUMBER	STK	DIMENSIONS				INSERT	Q	PARTS	
		Dc	l2	L	d			Screw	Wrench
GMX-2016-30-S16	•	16	30	100	16	ENMU100412ZER-**	2	TSW-2567H	T-08
GMX-2016-50-S16	•	16	50	150	16		2		
GMX-3020-50-S20	•	20	50	130	20		3		
GMX-3020-80-S20	•	20	80	160	20		3		
GMX-4025-60-S25	•	25	60	140	25		4		
GMX-4025-100-S25	•	25	100	180	25		4		
GMX-5032-70-S32	•	32	70	150	32		5		
GMX-5032-120-S32	•	32	120	200	32		5		

Note: All cutters are supplied without inserts or wrenches.

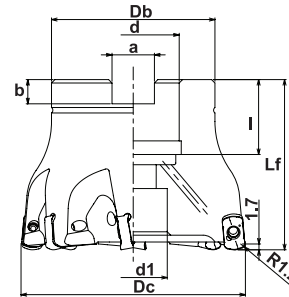


INCH

METRIC

# QM Max GII

## Face Mill GMX Style



### Specifications - Inch

CATALOG NUMBER	STK	DIMENSIONS								INSERT	Q	PARTS	
		Dc	Lf	Db	d	d1	a	b	l			Screw	Wrench
GMX-7200R-075	•	2.00	2.00	1.77	.750	.630	.319	.197	.750	ENMU100412ZER-**	7	TSW-2567H	T-08

Note: All cutters are supplied without inserts or wrenches.

### Specifications - Metric



CATALOG NUMBER	STK	DIMENSIONS								INSERT	Q	PARTS	
		Dc	Lf	Db	d	d1	a	b	l			Screw	Wrench
GMX-7050R	•	50	50	40	22.225	17	8.4	5	20	ENMU100412ZER-**	7	TSW-2567H	T-08
GMX-7050R-22	•	50	50	40	22	17	10.4	6.3	20		7		
GMX-7052R-22	◦	52	50	40	22	17	10.4	6.3	20		7		
GMX-7063R	•	63	50	48	22.225	17	8.4	5	20		7		
GMX-7063R-22	•	63	50	48	22	17	10.4	6.3	20		7		
GMX-7066R-22	◦	66	50	48	22	17	10.4	6.3	20		7		
GMX-7066R-27	◦	66	50	48	27	20	12.4	7	22		7		

◦ - longer delivery may apply.

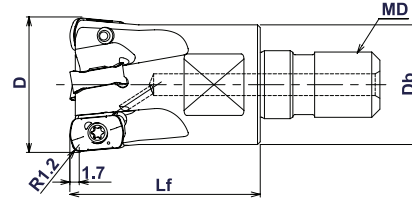
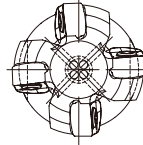
Note: All cutters are supplied without inserts or wrenches.



**INCH**

**METRIC**

**MODULAR HEAD**  
MXG Type - coolant thru



**G-Body**

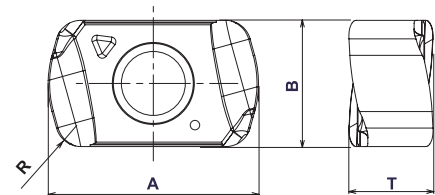
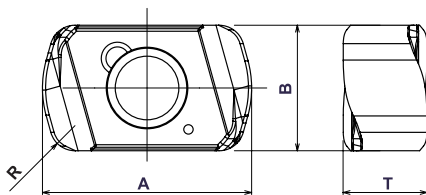
**Specifications**

	CATALOG NUMBER	STK	DIMENSIONS				Q	Head Torque		INSERT	PARTS	
			D	Lf	Db	MD		lbs/ft	Nm		Screw	Wrench
<b>INCH</b>	MXG-2062-M8	•	.625	.905	.551	M8	2	11.8	16	ENMU100412ZER-**	TSW-2567H	T-08
	MXG-3075-M10	•	.750	1.18	.708	M10	3	11.8	16			
	MXG-3100-M12	•	1.00	1.38	.866	M12	3	14.7	20			
	MXG-4100-M12	•	1.00	1.38	.866	M12	4	14.7	20			
	MXG-5125-M16	•	1.25	1.69	1.14	M16	5	18.4	25			
	MXG-6150-M16	•	1.50	1.69	1.14	M16	6	18.4	25			
<b>METRIC</b>	MXG-2016-M8	•	16	23	14	M8	2	11.8	16			
	MXG-2017-M8	•	17	23	14	M8	2	11.8	16			
	MXG-3020-M10	•	20	30	18	M10	3	11.8	16			
	MXG-3021-M10	•	21	30	18	M10	3	11.8	16			
	MXG-3025-M12	•	25	35	22	M12	3	14.7	20			
	MXG-4025-M12	•	25	35	22	M12	4	14.7	20			
	MXG-4026-M12	•	26	35	22.5	M12	4	14.7	20			
	MXG-5030-M16	•	30	43	27	M16	5	18.4	25			
	MXG-5032-M16	•	32	43	29	M16	5	18.4	25			
	MXG-5035-M16	•	35	43	29	M16	5	18.4	25			
	MXG-6040-M16	•	40	43	32	M16	6	18.4	25			
	MXG-6042-M16	o	42	43	32	M16	6	18.4	25			

o - longer delivery may apply.  
See page A-59 for Modular Head Shanks.

Note: All cutters are supplied without inserts or wrenches.

**INSERTS**



CATALOG NUMBER	TOLERANCE	DIMENSIONS				PVD COATED		
		A	B	T	R	JC7550	JC8118	JC7560
ENMU100412ZER-PH	M	10	6	4	1.2		•	•
ENMU100412ZER-SL	M	10	6	4	1.2	•		

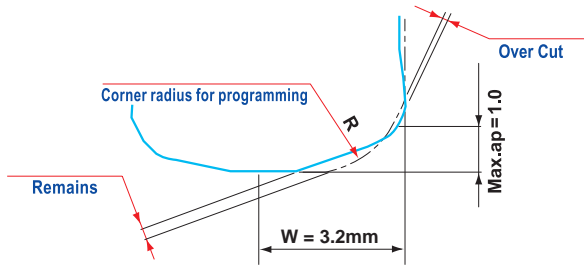


**INCH**

**METRIC**

# QM Max GII

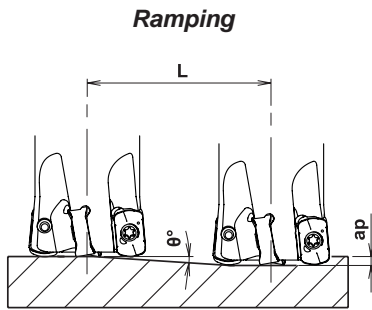
## Definition of corner shape for programming



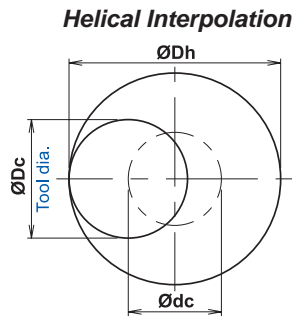
CORNER RADIUS FOR PROGRAMMING	Overcut	Remains
R1.0	0	0.52
R1.5 (Standard)	0	0.38
R2.0	0.08	0.24

(mm)

## Recommended Data for Profile Milling



**Ramping**



**Helical Interpolation**

• Calculation of tool pass dia.

$$\text{Tool pass dia.} = \text{Bore dia.} - \text{Tool Dia.}$$

• Calculation of tool pass dia.

- Down cutting is recommended, tool pass rotation should be counterclockwise.
- Depth of cut per one circuit should not exceed max. depth of cut Ap.
- In case of ramping and helical interpolation, apply 70% or less feed (F) from standard cutting condition table.

TOOL DIAMETER I	EFFECTIVE CUTTING DIA.	MAX. DEPTH OF CUT: AP	RAMPING		HELICAL INTERPOLATION		
			MAX. RAMP ANGLE	TOTAL CUTTING LENGTH AT MAX AP: L	MIN. BORE DIAMETER: Dh min	MAX. BORE DIAMETER: Dh max	
<b>INCH</b>	.625	.392	.027	1°36'	.960	.860	1.17
	.750	.510	.039	1°30'	1.49	1.11	1.42
	1.00	.760	.039	1°12'	1.86	1.61	1.92
	1.25	1.01	.039	0°54'	2.48	2.11	2.42
	1.50	1.26	.039	0°30'	4.46	2.61	2.92
	2.00	1.75	.039	0°18'	7.44	3.61	3.92
<b>METRIC</b>	16	10.1	0.7	1°36'	25.1	22	30
	17	11.1	0.7	1°36'	25.1	24	32
	20	13.9	1	1°30'	38.2	30	38
	21	14.9	1	1°30'	38.2	32	40
	25	18.9	1	1°12'	47.7	40	48
	26	19.9	1	1°12'	47.7	42	50
	30	23.9	1	0°54'	63.6	50	58
	32	25.9	1	0°54'	63.6	54	62
	35	28.8	1	0°42'	81.8	60	68
	40	33.8	1	0°30'	114.5	70	78
	42	35.8	1	0°30'	114.5	74	82
	50	43.8	1	0°24'	143.2	90	98
	52	45.8	1	0°24'	143.2	94	102
	63	56.8	1	0°18'	190.9	116	124
66	59.8	1	0°18'	190.9	122	130	



INCH

METRIC

### Recommended Cutting Data for MAX MASTER (QM Max GII)

Material	INSERT	Grade	SFM	IPT	DOC	WOC
Gray Cast Iron	-PH	JC8118 JC7560	700	.025" - .040"	.030" - .040"	70%
Nodular Cast Iron	-PH	JC8118 JC7560	650	.025" - .040"	.030" - .040"	70%
Carbon Steel	-PH	JC7560 JC8118	600	.025" - .040"	.030" - .040"	70%
Low Alloy Steel	-PH	JC7560 JC8118	550	.025" - .040"	.030" - .040"	70%
Mold Steel	-PH	JC8118 JC7560	500	.020" - .035"	.020" - .040"	60%
Tool & Die Steel (40-50 HRC)	-PH	JC8118 JC7560	400	.020" - .030"	.015" - .025"	60%
Hardened Die Steel (50-60 HRC)	-PH	JC8118 JC7560	250	.010" - .015"	.005" - .010"	40%
Stainless Steel	-SL -PH	JC7550 JC8118	300	.015" - .030"	.015" - .030"	60%
Titanium	-SL	JC7550	200	.010" - .025"	.012" - .020"	60%
Inconel	-SL	JC7550	100	.005" - .015"	.010" - .015"	60%

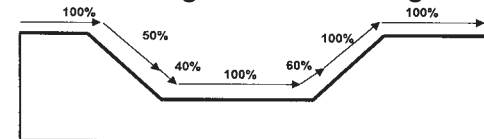
- NOTE:** 1. These parameters are for stable machining with steel bodies at lengths 4XD. See table below for longer applications.  
 2. RPM = 3.82 x SFM / Dia.  
 3. IPM = RPM x IPT x # of flutes (or teeth)

### Additional Cutting Data For Longer Tools

Reach/Dia.	~4.0	4.0~4.5	4.5~5.3	5.3~5.7	5.7~6.2	6.3~
rpm %	100	90	80	80	75	70
Feed %	100	90	90	80	75	70

**NOTE:** The above percentages should be applied, according to tool ratio.

### Reduced Cutting Data For Cutting Pattern



**NOTE:** Feed should be reduced when cutting the above pattern



# SKS GII

## High Feed SKG



- 4 corner positive insert with low cutting forces.
- High metal removal rate.
- Long reach applications.
- Good on high temp alloys & stainless steel.
- Three different insert sizes.
- G-body is a GN surface-hardening treatment on thermal resistant high strength steel giving a hardness over 65 HRC and secures insert pocket and holder against thermal deformation improving body durability.

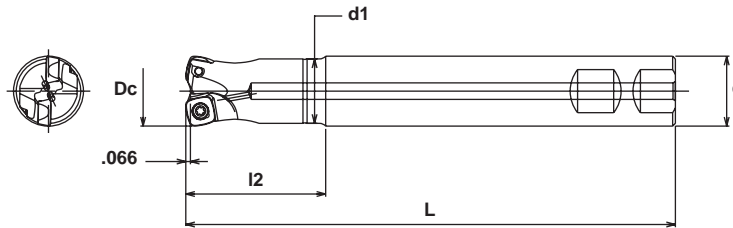


# SKS GII-10 High Feed

**INCH**

**METRIC**

**End Mill**  
**SKGS Style**

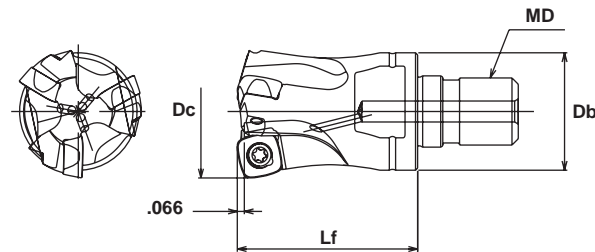


## Specifications

CATALOG NUMBER	STK	DIMENSIONS					INSERT	Q	PARTS	
		Dc	d1	I2	L	d			Screw	Wrench
SKGS-2100-2.0-10-S100NP	•	1.00	.921	2.0	7.00	1.00	SPNW100415ZTR SPET100415ZPER-SM SPMT100415ZPER-**	2	TSW-3509H	T-15
SKGS-2100-3.0-10-S100NP	•	1.00	.921	3.0	8.00	1.00		2		
SKGS-3125-2.0-10-S125NP	•	1.25	1.14	2.0	7.00	1.25		3		
SKGS-3125-3.0-10-S125NP	•	1.25	1.14	3.0	8.00	1.25		3		
SKGS-3150-3.0-10-S125NP	•	1.50	1.25	3.0	5.50	1.25		3		
SKGS-3150-4.75-10-S125NP	•	1.50	1.25	4.75	8.00	1.25		3		

Note: All cutters are supplied without inserts or wrenches.

**MODULAR HEAD**  
**MSG type - coolant thru**



## Specifications

	CATALOG NUMBER	STK	DIMENSIONS				Q	Head Torque		INSERT	PARTS	
			Dc	Lf	Db	MD		lbs/ft	Nm		Screw	Wrench
<b>INCH</b>	MSG-2100-10-M12	•	1.00	1.38	.905	M12	2	14.7	20	SPNW100415ZTR SPET100415ZPER-SM SPMT100415ZPER-**	TSW-3509H	T-15
	MSG-3125-10-M16	•	1.25	1.69	1.10	M16	3	18.4	25			
	MSG-3150-10-M16	•	1.50	1.69	1.25	M16	3	18.4	25			
<b>METRIC</b>	MSG-2025-10-M12	•	25	35	23	M12	2	14.7	20			
	MSG-3032-10-M16	•	32	43	28	M16	3	18.4	25			
	MSG-3035-10-M16	•	35	43	30	M16	3	18.4	25			
	MSG-4040-10-M16	•	40	43	32	M16	4	18.4	25			
	MSG-4042-10-M16	o	42	43	32	M16	4	18.4	25			

o - longer delivery may apply.  
See page A-59 for Modular Head Shanks.

Note: All cutters are supplied without inserts or wrenches.





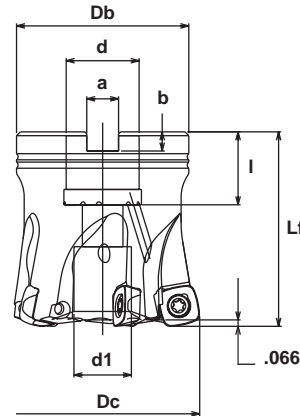
**INCH**

**METRIC**

# SKS GII-10 High Feed

**Face Mill**  
**SKG-10 Type**

**G-Body**



## Specifications - Inch

CATALOG NUMBER	STK	DIMENSIONS								INSERT	Q	PARTS	
		Dc	Lf	Db	d	d1	a	b	l			Screw	Wrench
SKG-5200R-075-10	•	2.00	2.00	1.77	.750	.590	.319	.197	.750	SPNW100415ZTR SPET100415ZPER-SM SPMT100415ZPER-**	5	TSW-3509H	A-15T
SKG-6250R-075-10	•	2.50	2.00	1.89	.750	.669	.319	.197	6				
SKG-7300R-100-10	•	3.00	2.00	2.21	1.00	.787	.374	.236	.866		7		
SKG-7300R-125-10	•	3.00	2.00	2.67	1.25	1.02	.500	.315	.866		7		

Note: All cutters are supplied without inserts or wrenches.

## Specifications - Metric

CATALOG NUMBER	STK	DIMENSIONS								INSERT	Q	PARTS	
		Dc	Lf	Db	d	d1	a	b	l			Screw	Wrench
SKG-4050R-10	•	50	50	40	22.225	14	8.4	5	20	SPNW100415ZTR SPET100415ZPER-SM SPMT100415ZPER-**	4	TSW-3509H	A-15T
SKG-4050R-10-22	•	50	50	40	22	14	10.4	6.3	20		4		
SKG-5050R-10	•	50	50	40	22.225	14	8.4	5	20		5		
SKG-5050R-10-22	•	50	50	40	22	14	10.4	6.3	20		5		
SKG-5052-10-22	◦	52	50	42	22	16.6	10.4	6.3	20		5		
SKG-5063R-10	•	63	50	48	22.225	17	8.4	5	20		5		
SKG-5063R-10-22	•	63	50	48	22	17	10.4	6.3	20		5		
SKG-5063R-10-27	•	63	50	48	27	20	12.4	7	20		5		
SKG-6063R-10	•	63	50	48	22.225	17	8.4	5	20		6		
SKG-6063R-10-22	•	63	50	48	22	17	10.4	6.3	20		6		
SKG-6063R-10-27	•	63	50	48	27	20	12.4	7	22		6		
SKG-6066R-10-27	◦	66	50	50	27	20	12.4	7	22		6		
SKG-6080R-10	•	80	70	65	31.75	26	12.7	8	32		6		
SKG-6080R-10-27	•	80	50	70	27	20	12.4	7	22		6		

◦ - longer delivery may apply.

Note: All cutters are supplied without inserts or wrenches.



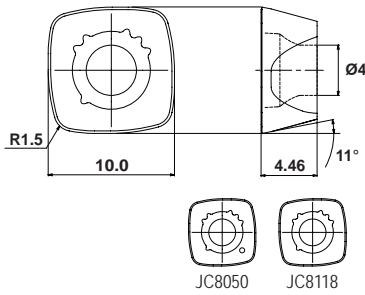
# SKS GII-10 High Feed

**METRIC**

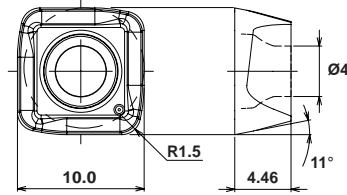
**Insert**  
**SKG-10 type**



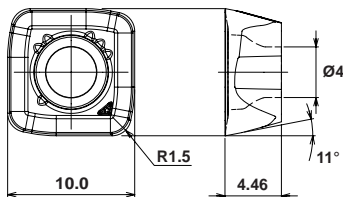
**Fig. 1**  
**SPNW100415ZTR**



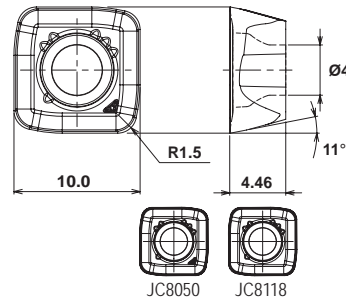
**Fig. 2**  
**SPET100415ZPER-SM**



**Fig. 3**  
**SPMT100415ZPER-SM**



**Fig. 4**  
**SPMT100415ZPTR-PM**



CATALOG NUMBER	TOLERANCE	PVD COATED			FIG.
		JC7550	JC8050	JC8118	
SPNW100415ZTR	N		•	•	1
SPET100415ZPER-SM	E	•			2
SPMT100415ZPER-SM	M	•			3
SPMT100415ZPTR-PM	M		•	•	4



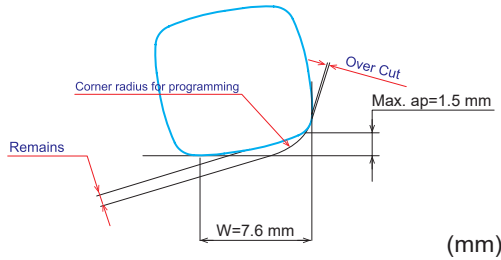
**INCH**

**METRIC**

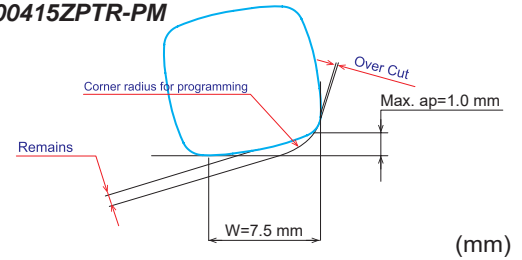
# SKS GII-10 High Feed

## Definition of corner shape for programming

SPNW100415ZTR



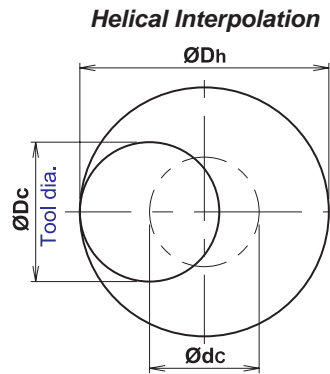
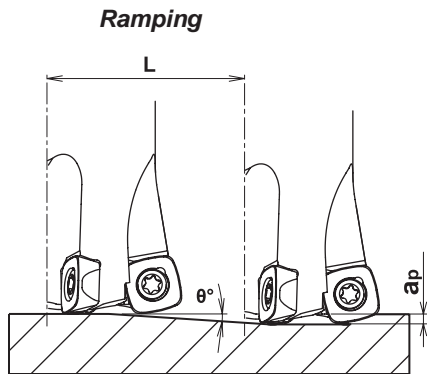
SPE(M)T100415ZPER-SM  
SPMT100415ZPTR-PM



CORNER RADIUS FOR PROGRAMMING	Overcut	Remains
R2.5	0	0.99
R3.0 (Standard)	0	0.84
R3.5	0.09	0.71
R4.0	0.23	0.59

CORNER RADIUS FOR PROGRAMMING	Overcut	Remains
R2.5 (Standard)	0	0.77
R3.0	0.09	0.68
R3.5	0.25	0.60
R4.0	0.43	0.52

## Recommended Data for Profile Milling



• Calculation of tool pass dia.  

$$\text{Tool pass dia.} = \text{Bore dia.} - \text{Tool Dia.}$$

$$\text{Ødc} = \text{ØDh} - \text{ØDc}$$

- Down cutting is recommended, tool pass rotation should be counterclockwise.
- Depth of cut per one circuit should not exceed max. depth of cut Ap.
- In case of ramping and helical interpolation, apply 70% or less feed (F) from standard cutting condition table.

TOOL DIAMETER I	EFFECTIVE CUTTING DIA.	MAX. DEPTH OF CUT: AP	RAMPING		HELICAL INTERPOLATION		
			MAX. RAMP ANGLE	TOTAL CUTTING LENGTH AT MAX AP: L	MIN. BORE DIAMETER: Dh min	MAX. BORE DIAMETER: Dh max	
INCH	1.00	.402	.059	1°	3.38	1.45	1.92
	1.25	.650	.059	1°	3.38	1.95	2.42
	1.50	.902	.059	1°	3.38	2.40	2.92
	2.00	1.402	.059	1°	3.38	3.45	3.92
	2.50	1.902	.059	0°45'	4.51	4.45	4.92
	3.00	2.402	.059	0°30'	6.77	5.45	5.92
METRIC	25	9.8	1.5	1°	85.9	36	48
	32	16.8	1.5	1°	85.9	50	78
	35	19.8	1.5	1°	85.9	56	70
	40	24.8	1.5	1°	85.9	66	78
	42	26.8	1.5	1°	85.9	70	82
	50	34.8	1.5	1°	85.9	86	98
	52	36.8	1.5	1°	85.9	90	102
	63	47.8	1.5	0°45'	114.6	112	124
	66	50.8	1.5	0°45'	114.6	118	130
	80	64.8	1.5	0°30'	171.9	146	158



# SKS GII-10 High Feed

**INCH**

**METRIC**

## Recommended Cutting Data for SKG-10

Material	Insert	Grade	SFM	LOW HORSEPOWER		HIGH HORSEPOWER		WOC
				IPT	DOC	IPT	DOC	
Gray Cast Iron	SPNW SPMT-PM	JC8118 JC8050	700	.030" - .050"	.020" - .040"	.050" - .070"	.040" - .060"	70%
Nodular Cast Iron	SPNW SPMT-PM	JC8118 JC8050	650	.025" - .040"	.020" - .040"	.040" - .060"	.040" - .060"	70%
Carbon Steel	SPNW SPMT-PM	JC8050 JC8118	600	.025" - .040"	.020" - .040"	.045" - .065"	.040" - .060"	70%
Low Alloy Steel	SPNW SPMT-PM	JC8050 JC8118	550	.025" - .040"	.020" - .040"	.040" - .060"	.040" - .060"	70%
Mold Steel	SPNW SPMT-PM	JC8118 JC8050	500	.015" - .025"	.015" - .035"	.040" - .060"	.040" - .060"	60%
Tool & Die Steel (40-50 HRC)	SPNW	JC8118	400	.010" - .020"	.010" - .020"	.015" - .025"	.020" - .035"	60%
Hardened Die Steel (50-60 HRC)	SPNW	JC8118	250	.005" - .010"	.005" - .010"	.005" - .015"	.005" - .010"	40%
Stainless Steel	SPMT-SM SPET-SM	JC7550	300	.010" - .020"	.015" - .025"	.015" - .030"	.025" - .040"	60%
Titanium	SPMT-SM SPET-SM	JC7550	200	.010" - .020"	.010" - .025"	.015" - .025"	.025" - .040"	60%
Inconel	SPMT-SM SPET-SM	JC7550	100	.005" - .015"	.010" - .025"	.015" - .025"	.025" - .040"	60%

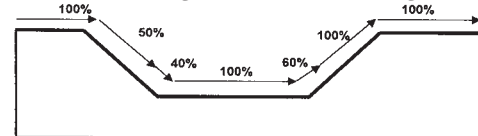
**NOTE:** 1. These parameters are for stable machining with steel bodies at lengths 4XD. See table below for longer applications.  
 2. RPM = 3.82 x SFM / Dia.  
 3. IPM = RPM x IPT x # of flutes (or teeth)

### Additional Cutting Data For Longer Tools

Reach/Dia.	~4.0	4.0~4.5	4.5~5.3	5.3~5.7	5.7~6.2	6.3~
rpm %	100	90	80	80	75	70
Feed %	100	90	90	80	75	70

**NOTE:** The above percentages should be applied, according to tool ratio.

### Reduced Cutting Data For Cutting Pattern



**NOTE:** Feed should be reduced when cutting the above pattern



**INCH**

**METRIC**

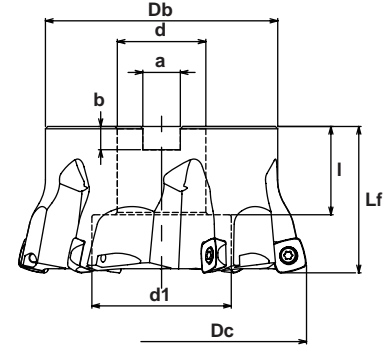
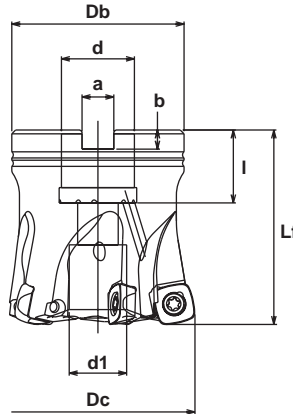
# SKS GII-14 High Feed

**Face Mill  
SKG-14 Type**



Fig. 1 coolant thru

Fig. 2 without coolant thru



## Specifications - Inch

CATALOG NUMBER	STK	DIMENSIONS								FIG.	INSERT	Q	PARTS	
		Dc	Lf	Db	d	d1	a	b	l				Screw	Wrench
SKG-4200R-075-14	•	2.00	2.00	1.77	.750	.630	.319	.197	.750	1	SPNW140515ZTR SPMT140520ZP*R-**	4	CSW-513H	A-20
SKG-5250R-100-14	•	2.50	2.00	1.90	1.00	.787	.374	.236	.945	1		5		
SKG-5300R-125-14	•	3.00	2.50	2.68	1.25	1.02	.500	.315	.866	1		5		
SKG-6300R-100-14	•	3.00	2.00	2.21	1.00	.787	.374	.236	.945	1		6		
SKG-6300R-125-14	•	3.00	2.50	2.68	1.25	1.02	.500	.315	.866	1		6		
SKG-6400R-150-14	•	4.00	2.50	3.00	1.50	1.26	.626	.393	1.02	1		6		
SKG-7400R-150-14	•	4.00	2.50	3.00	1.50	1.26	.626	.393	1.02	1		7		
SKG-7600R-150-14	•	6.00	2.50	3.93	1.50	1.26	.626	.393	1.02	1		7		

Note: All cutters are supplied without inserts or wrenches.

## Specifications - Metric

CATALOG NUMBER	STK	DIMENSIONS								FIG.	INSERT	Q	PARTS	
		Dc	Lf	Db	d	d1	a	b	l				Screw	Wrench
SKG-4050R-14	•	50	50	40	22.225	9.6	8.4	5	19	1	SPNW140515ZTR SPMT140520ZP*R-**	4	CSW-513H	A-20
SKG-4050R-14-22	•	50	50	40	22	9.6	10.4	6.3	19.05	1		4		
SKG-4052R-14-22	o	52	50	42	22	17	10.4	6.3	19.05	1		4		
SKG-4063R-14	•	63	50	48	22.225	17	8.4	5	20	1		4		
SKG-4063R-14-22	•	63	50	48	22	17	10.4	6.3	20	1		4		
SKG-4063R-14-27	•	63	50	48	27	20	12.4	7	22	1		4		
SKG-5066R-14-27	o	66	50	50	27	20	12.4	7	22	1		5		
SKG-5080R-14	•	80	70	65	31.75	26	12.7	8	32	1		5		
SKG-5080R-14-27	•	80	50	60	27	37	12.4	7	22	1		5		
SKG-6100R-14	•	100	70	70	31.75	26	12.7	8	32	1		6		
SKG-6100R-14-32	•	100	63	70	32	45	14.4	8	25	1		6		
SKG-6125R-14	•	125	63	100	38.1	60	15.9	10	38	2		6		
SKG-7160R-14	•	160	63	100	50.8	85	19	11	38	2		7		

o - longer delivery may apply.

Note: All cutters are supplied without inserts or wrenches.



# SKS GII-14 High Feed METRIC

## Insert SKG-14 type

Fig. 1

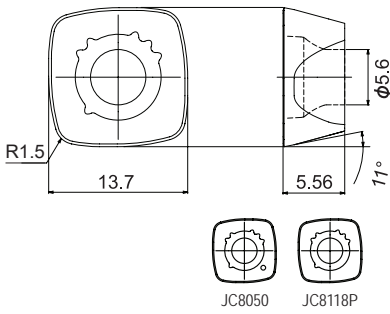


Fig. 2

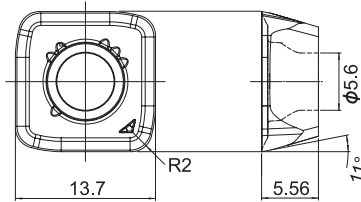
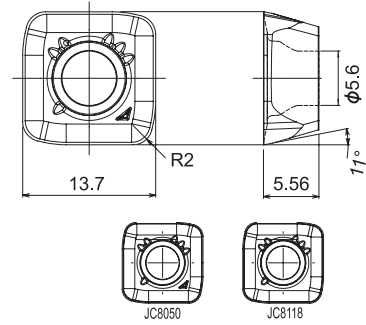


Fig. 3



CATALOG NUMBER	TOLERANCE	PVD COATED			FIG.
		JC7550	JC8050	JC8118	
SPNW140515ZTR	N		•	•	1
SPMT140520ZPER-SM	M	•			2
SPMT140520ZPTR-PM	M		•	•	3



**INCH**

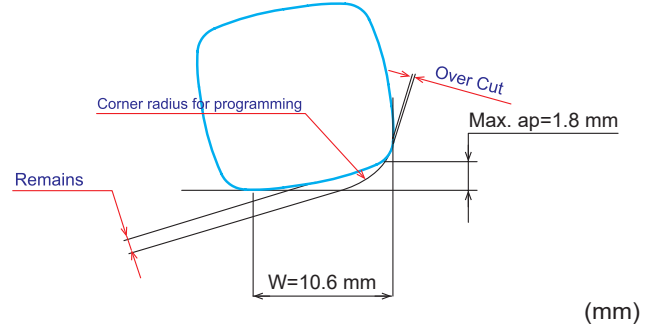
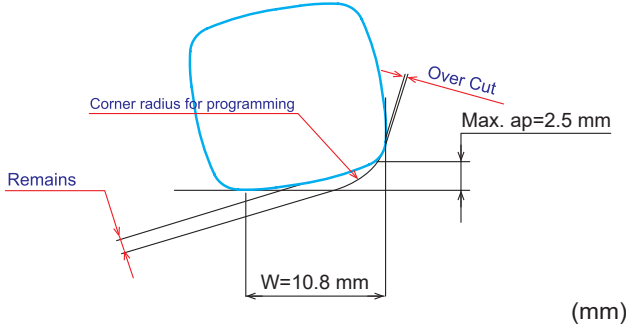
**METRIC**

# SKS GII-14 High Feed

## Definition of corner shape for programming

SPNW140515ZTR

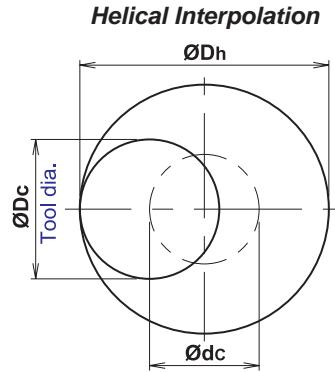
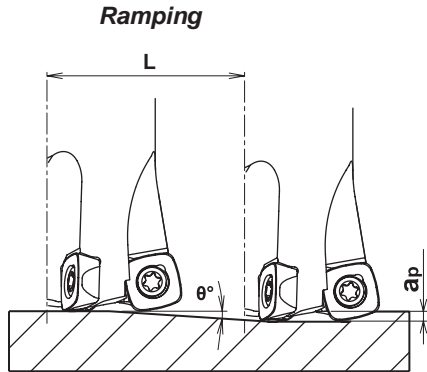
SPMT140520ZP\*R\*\*



CORNER RADIUS FOR PROGRAMMING	Overcut	Remains
R3.5	0	1.60
R4.0 (Standard)	0	1.46
R4.5	0.06	1.32
R5.0	0.17	1.19

CORNER RADIUS FOR PROGRAMMING	Overcut	Remains
R3.5 (Standard)	0	1.35
R4.0	0.02	1.25
R4.5	0.14	1.12
R5.0	0.26	1.05

## Recommended Data for Profile Milling



• Calculation of tool pass dia.

$$\text{Tool pass dia.} = \text{Bore dia.} - \text{Tool Dia.}$$

• Calculation of tool pass dia.

- Down cutting is recommended, tool pass rotation should be counterclockwise.
- Depth of cut per one circuit should not exceed max. depth of cut Ap.
- In case of ramping and helical interpolation, apply 70% or less feed (F) from standard cutting condition table.

	TOOL DIAMETER I	EFFECTIVE CUTTING DIA.	MAX. DEPTH OF CUT: AP	RAMPING		HELICAL INTERPOLATION	
				MAX. RAMP ANGLE	TOTAL CUTTING LENGTH AT MAX AP: L	MIN. BORE DIAMETER: Dh min	MAX. BORE DIAMETER: Dh max
<b>INCH</b>	2.00	1.15	.098	1°	5.64	3.21	3.92
	2.50	1.65	.098	0°45'	7.51	4.21	4.92
	3.00	2.15	.098	0°30'	11.28	5.21	5.92
	4.00	3.15	.098	0°20'	16.93	7.21	7.96
	6.00	5.15	.098	0°15'	22.56	11.21	11.92
<b>METRIC</b>	50	28.4	2.5	1°	143.2	80	98
	52	30.4	2.5	1°	143.2	84	102
	63	41.4	2.5	0°45'	191	106	124
	66	44.4	2.5	0°45'	191	112	130
	80	58.4	2.5	0°30'	286.5	140	158
	100	78.4	2.5	0°20'	430	180	198
	125	123.4	2.5	0°20'	430	230	248
160	138.4	2.5	0°15'	573	300	318	



# SKS GII-14 High Feed

**INCH**

**METRIC**

## Recommended Cutting Data for SKG-14

Material	Insert	Grade	SFM	LOW HORSEPOWER		HIGH HORSEPOWER		WOC
				IPT	DOC	IPT	DOC	
Gray Cast Iron	SPNW SPMT-PM	JC8118 JC8050	700	.030" - .050"	.020" - .040"	.060" - .080"	.060" - .080"	70%
Nodular Cast Iron	SPNW SPMT-PM	JC8118 JC8050	650	.025" - .040"	.020" - .040"	.050" - .070"	.060" - .080"	70%
Carbon Steel	SPNW SPMT-PM	JC8050 JC8118	600	.025" - .045"	.020" - .040"	.055" - .075"	.060" - .080"	70%
Low Alloy Steel	SPNW SPMT-PM	JC8050 JC8118	550	.025" - .040"	.020" - .040"	.050" - .070"	.060" - .080"	70%
Mold Steel	SPNW SPMT-PM	JC8118 JC8050	500	.015" - .025"	.015" - .035"	.050" - .070"	.060" - .080"	60%
Tool & Die Steel (40-50 HRC)	SPNW	JC8118	400	.010" - .020"	.010" - .020"	.020" - .040"	.040" - .060"	60%
Hardened Die Steel (50-60 HRC)	SPNW	JC8118	250	.005" - .010"	.005" - .010"	.005" - .015"	.010" - .015"	40%
Stainless Steel	SPMT-SM	JC7550	300	.010" - .020"	.015" - .025"	.020" - .040"	.025" - .060"	60%
Titanium	SPMT-SM	JC7550	200	.010" - .020"	.010" - .025"	.015" - .025"	.020" - .040"	60%
Inconel	SPMT-SM	JC7550	100	.005" - .015"	.010" - .025"	.015" - .025"	.020" - .040"	60%

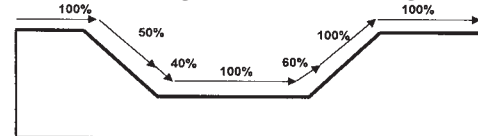
**NOTE:** 1. These parameters are for stable machining with steel bodies at lengths 4XD. See table below for longer applications.  
 2. RPM = 3.82 x SFM / Dia.  
 3. IPM = RPM x IPT x # of flutes (or teeth)

### Additional Cutting Data For Longer Tools

Reach/Dia.	~4.0	4.0~4.5	4.5~5.3	5.3~5.7	5.7~6.2	6.3~
rpm %	100	90	80	80	75	70
Feed %	100	90	90	80	75	70

**NOTE:** The above percentages should be applied, according to tool ratio.

### Reduced Cutting Data For Cutting Pattern



**NOTE:** Feed should be reduced when cutting the above pattern

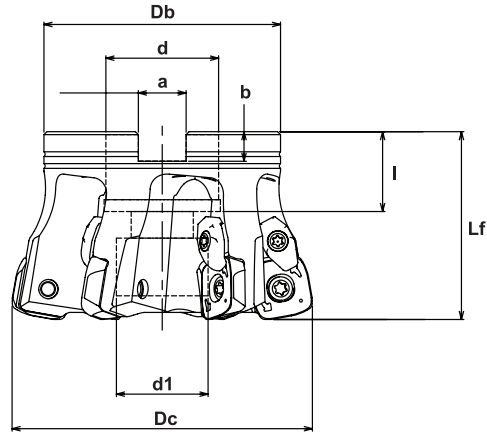




**INCH**

# SKS GII-20 High Feed

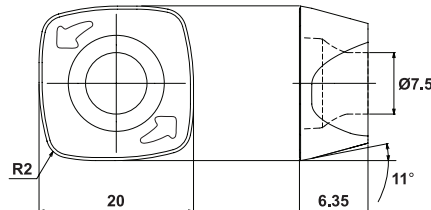
**Face Mill**  
**SKG-20 Type**



CATALOG NUMBER	STK	DIMENSIONS								INSERT	Q	PARTS	
		D	Lf	Db	d	d1	a	b	l			Insert Screw/ Wrench	Clamp/ Wrench
SKG-5300-100R-20LG	•	3.00	2.25	2.20	1.00	.787	.375	.236	.945	SPEW200620ZTR JC7560 or JC8118P	5	BSW-614H T-25	DCM-17 A-20
SKG-5400-150R-20	•	4.00	2.50	3.15	1.50	1.22	.626	.393	1.06		5	BSW-616H T-25	-
SKG-6400-150R-20	•	4.00	2.50	3.15	1.50	1.22	.626	.393	1.06		6	BSW-616H T-25	DCM-17 A-20
SKG-7500R-150-20LG	•	5.00	2.50	3.35	1.50	2.36	.626	.393	1.42		7	BSW-616H T-25	DCM-17 A-20

**Note: All cutters are supplied without inserts or wrenches.**

**Insert**  
**SKG-20 type**



CATALOG NUMBER	TOLERANCE	PVD COATED	
		JC7560	JC8118P
SPEW200620ZTR	E	•	•



# SKS GII-20 High Feed

**INCH**

## Recommended Cutting Data for SKG-20

Material	Grade	SFM	IPT	DOC	WOC
Gray Cast Iron	JC8118 JC7560	700	.080" - .100"	.080" - .100"	70%
Nodular Cast Iron	JC8118 JC7560	650	.070" - .090"	.080" - .100"	70%
Carbon Steel	JC7560 JC8118	600	.080" - .100"	.080" - .100"	70%
Low Alloy Steel	JC7560 JC8118	550	.070" - .090"	.080" - .100"	70%
Mold Steel	JC8118 JC7560	500	.070" - .090"	.060" - .100"	60%
Tool & Die Steel (40-50 HRC)	JC8118	400	.040" - .060"	.060" - .080"	60%

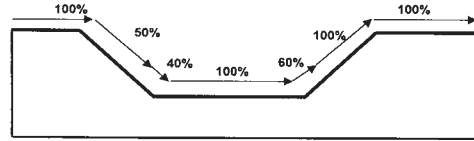
- NOTE:** 1. These parameters are for stable machining with steel bodies at lengths 4XD. See table below for longer applications.  
 2.  $RPM = 3.82 \times SFM / Dia.$   
 3.  $IPM = RPM \times IPT \times \# \text{ of flutes (or teeth)}$

## Additional Cutting Data For Longer Tools

Reach/Dia.	~4.0	4.0~4.5	4.5~5.3	5.3~5.7	5.7~6.2	6.3~
rpm %	100	90	80	80	75	70
Feed %	100	90	90	80	75	70

**NOTE:** The above percentages should be applied, according to tool ratio.

## Reduced Cutting Data For Cutting Pattern



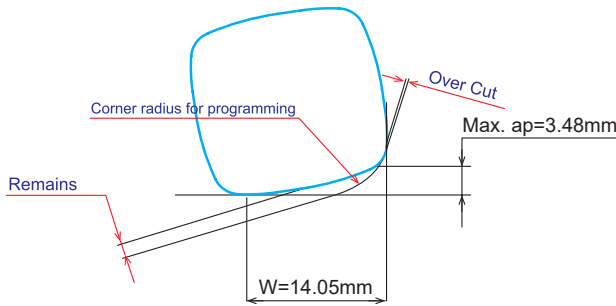
**NOTE:** Feed should be reduced when cutting the above pattern



**INCH**

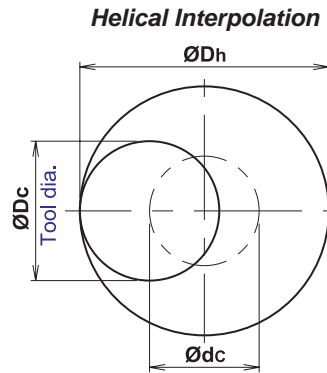
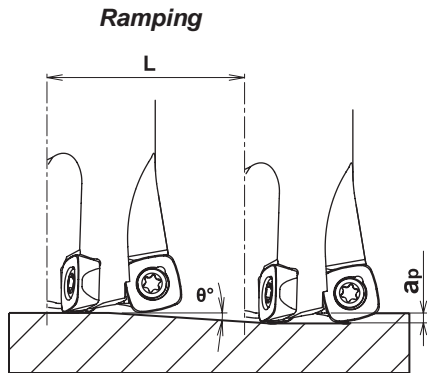
## SKS GII-20 High Feed

### Definition of corner shape for programming



(mm)		
CORNER RADIUS FOR PROGRAMMING	Overcut	Remains
R5	0	1.89
R5.5 (Standard)	0	1.75
R6	.048	1.60

### Recommended Data for Profile Milling



• Calculation of tool pass dia.  

$$\phi_{dc} = \phi_{Dh} - \phi_{Dc}$$
 Tool pass dia.    Bore dia.    Tool Dia.

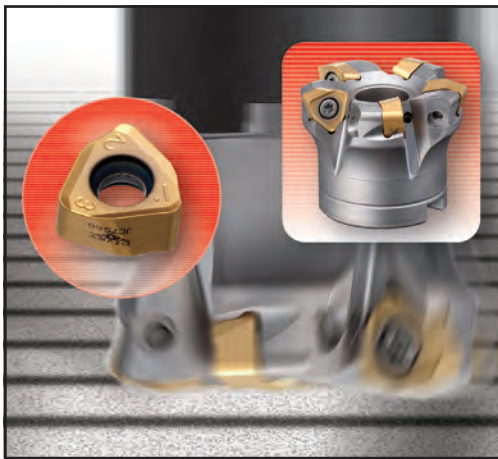
- Down cutting is recommended, tool pass rotation should be counterclockwise.
- Depth of cut per one circuit should not exceed max. depth of cut  $A_p$ .
- In case of ramping and helical interpolation, apply 70% or less feed (F) from standard cutting condition table.

TOOL DIAMETER I	EFFECTIVE CUTTING DIA.	MAX. DEPTH OF CUT: $A_p$	RAMPING		HELICAL INTERPOLATION		
			MAX. RAMP ANGLE	TOTAL CUTTING LENGTH AT MAX $A_p$ : L	MIN. BORE DIAMETER: $D_h$ min	MAX. BORE DIAMETER: $D_h$ max	
<b>INCH</b>	3.00	1.88	.137	1°20'	5.93	5.45	5.92
	4.00	2.88	.137	1°	7.89	7.49	7.96
	5.00	3.88	.137	0°40'	11.7	9.49	9.96





# SKS Extreme



- 6 corner double sided insert.
- Excellent ramping and helical interpolation.
- Insert grade JC7560 has improved fracture toughness for longer tool life.
- Stable high feed machining possible with long reach over L/D=6.
- G-body is a GN surface-hardening treatment on thermal resistant high strength steel giving a hardness over 65 HRC and secures insert pocket and holder against thermal deformation improving body durability.



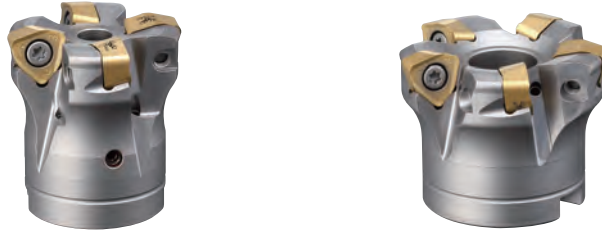
# SKS Extreme

**INCH**

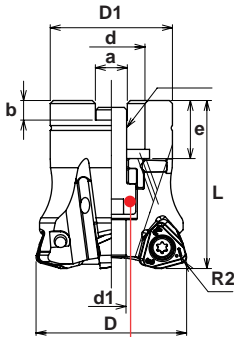
## FACE MILL

High Feed cutter with double sided insert  
EXSKS type

**G-Body**

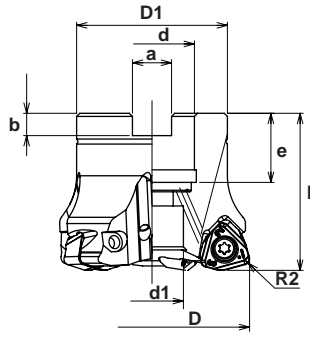


**Fig. 1**  
Coolant thru

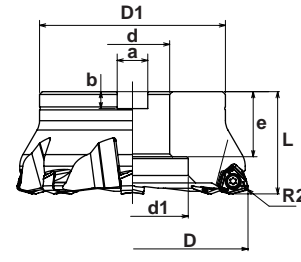


Set bolt built into the cutter body

**Fig. 2**  
Coolant thru



**Fig. 3**  
Not Coolant thru



### Specifications - Inch

CATALOG NUMBER	STK	DIMENSIONS								FIG.	INSERT	Q	PARTS	
		D	L	d	D1	a	b	e	d1				Screw	Wrench
EXSKS-4200-75R	•	2.00	2.25	.750	1.77	.319	.196	.750	.378	1	WNMU090720ZER-PM	4	CSW-513H	A-20
EXSKS-5250-75R	•	2.50	2.00	.750	2.36	.319	.196	.750	.630	2		5		
EXSKS-6300-100R	•	3.00	2.00	1.00	2.85	.374	.236	.750	.827	2		6		
EXSKS-6300-125R	•	3.00	2.50	1.25	2.85	.500	.315	1.25	1.02	2		6		
EXSKS-7400-150R	•	4.00	2.25	1.50	3.78	.626	.393	1.50	1.19	2		7		
EXSKS-8500-150R	•	5.00	2.25	1.50	3.34	.626	.393	1.50	2.36	3		8		
EXSKS-9600-150R	•	6.00	2.25	1.50	3.93	.626	.393	1.50	2.36	3		9		

Note: All cutters are supplied without inserts or wrenches.



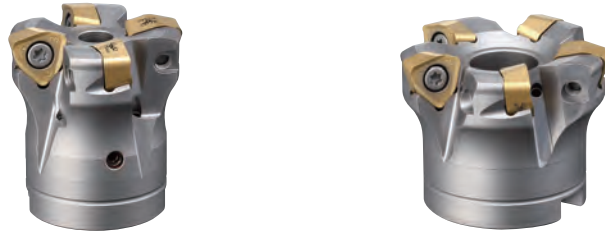
**METRIC**

**SKS Extreme**

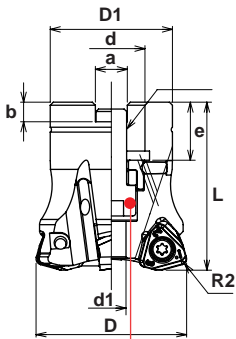
**FACE MILL**

**High Feed cutter with double sided insert  
EXSKS type**

**G-Body**

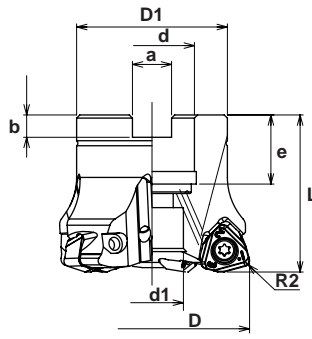


**Fig. 1**  
Coolant thru

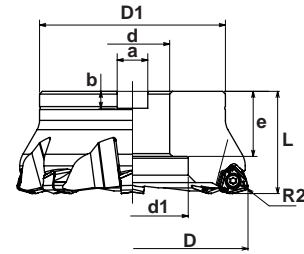


Set bolt built into the cutter body

**Fig. 2**  
Coolant thru



**Fig. 3**  
Not Coolant thru



**Specifications - Metric**

CATALOG NUMBER	STK	DIMENSIONS								FIG.	INSERT	Q	PARTS	
		D	L	d	D1	a	b	e	d1				Screw	Wrench
EXSKS-3050R	•	50	55	22.225	40	8.4	5	19	9.6	1	WNMU090720ZER-PM	3	CSW-513H	A-20
EXSKS-3050R-22	•	50	55	22	40	10.4	6.3	19	9.6	1		3		
EXSKS-4050R	•	50	55	22.225	40	8.4	5	19	9.6	1		4		
EXSKS-4050R-22	•	50	55	22	40	10.4	6.3	19	9.6	1		4		
EXSKS-4052R-22	◦	52	50	22	40	10.4	6.3	20	17	2		4		
EXSKS-4063R	•	63	50	22.225	48	8.4	5	20	17	2		4		
EXSKS-4063R-22	•	63	50	22	48	10.4	6.3	20	17	2		4		
EXSKS-5063R	•	63	50	22.225	48	8.4	5	20	17	2		5		
EXSKS-5063R-22	•	63	50	22	48	10.4	6.3	20	17	2		5		
EXSKS-5063R-27	•	63	50	27	48	12.4	7	22	20	2		5		
EXSKS-5066R-27	◦	66	50	27	48	12.4	7	22	20	2		5		
EXSKS-6080R	•	60	70	31.75	65	12.7	8	32	26	2		6		
EXSKS-6080R-27	•	80	55	27	65	12.4	7	22	37	3		6		
EXSKS-7100R	•	100	70	31.75	70	12.7	8	32	26	3		7		
EXSKS-7100R-32	•	100	55	32	85	14.4	8	32	45	3		7		
EXSKS-8125R	•	125	63	37.1	100	15.9	10	35	60	3		8		
EXSKS-8125R-40	•	125	55	40	100	16.4	9	35	60	3		8		
EXSKS-9160R	•	160	63	50.8	100	19	11	43	75	3		9		
EXSKS-9160R-40	•	160	55	40	100	16.4	9	35	85	3		9		

◦ - longer delivery may apply.

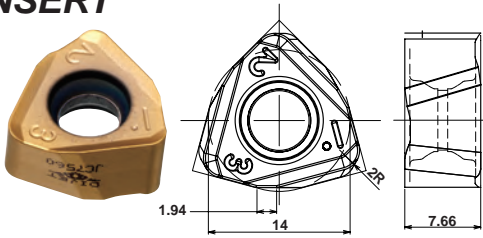
Note: All cutters are supplied without inserts or wrenches.



# SKS Extreme

**INCH**

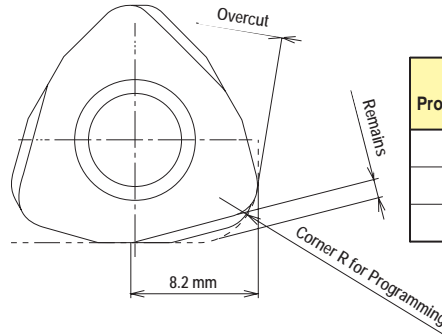
## INSERT



Each grade shows different mark around the hole for tool proof.



## Definition of Corner Shape for Programming

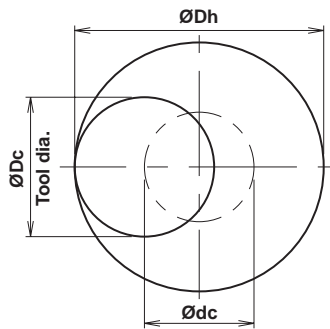
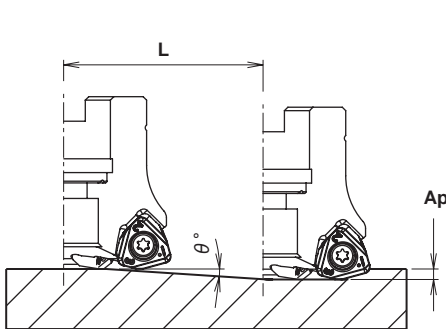


Corner R for Programming (mm)	Over cut (mm)	Remains (mm)
R3.0	0	1.41
R3.5	0	1.30
R4.0	0.025	1.19

Catalog Number	Tolerance	PVD Coated		
		JC7560	JC8118	JC8050
WNMU090720ZER-PM	M	•	•	•

## Recommended Data for Profile Milling

- Ramping
- Helical interpolation



- Calculation of tool pass dia.

$$\text{Tool pass dia. } \varnothing D_c = \text{Bore dia. } \varnothing D_h - \text{Tool Dia. } \varnothing D_c$$

- Depth of cut per one circuit should not exceed max. depth of cut  $A_p$
- Down cutting is recommended, so tool pass rotation should be counterclockwise

- In case of ramping and helical interpolation, apply 70% or less feed speed from standard cutting table.
- In case of drilling, apply 50% or less Z axis feed from standard cutting condition table.
- Long consecutive chips may come out in case of drilling, confirm safe operating conditions.

CATALOG NUMBER	TOOL DIA.	EFFECTIVE CUTTING DIA.	MAX. DEPTH OF CUT: $A_p$	RAMPING		HELICAL INTERPOLATION		MAX. DRILLING DEPTH: Z	
				MAX. ANGLE	TOTAL CUTTING LENGTH AT MAX. $A_p$ : L	MIN BORE DIA.: $D_h$	MAX BORE DIA.: $D_h$		
METRIC	EXSKS-*050	50	33.7	3	2°24'	71.6	68	96	2
	EXSKS-*052	52	35.7	3	2°24'	71.6	72	100	2
	EXSKS-*063	63	46.7	3	3°	57.3	94	122	2
	EXSKS-*066	66	49.7	3	2°42'	63.7	100	128	2
	EXSKS-*080	80	63.6	3	2°18'	74.7	128	156	2
	EXSKS-*100	100	83.6	3	1°42'	101.1	168	196	2
	EXSKS-*125	125	108.5	3	1°18'	132.2	218	246	2
	EXSKS-*160	160	143.5	3	1°	171.9	288	316	2
INCH	EXSKS-*200	2"	1.36"	.12"	2°24'	2.82"	2.74"	3.84"	.08"
	EXSKS-*250	2.5"	1.86"	.12"	3°	2.26"	3.74"	4.84"	.08"
	EXSKS-*300	3"	2.36"	.12"	2°18'	2.94"	4.74"	5.84"	.08"
	EXSKS-*400	4"	3.35"	.12"	1°42'	3.98"	6.74"	7.84"	.08"
	EXSKS-*500	5"	4.35"	.12"	1°18'	5.20"	8.74"	9.84"	.08"
	EXSKS-*600	6"	5.35"	.12"	1°	6.77"	10.74"	11.84"	.08"





INCH

METRIC

# SKS Extreme

## Recommended Cutting Data for SKS-Extreme

Material	Grade	SFM	LOW HORSEPOWER		HIGH HORSEPOWER		WOC
			IPT	DOC	IPT	DOC	
Gray Cast Iron	JC8118 JC7560	700	.030" - .060"	.030" - .050"	.060" - .080"	.080" - .100"	70%
Nodular Cast Iron	JC8118 JC7560	650	.030" - .050"	.030" - .050"	.050" - .070"	.080" - .100"	70%
Carbon Steel	JC7560 JC8050	600	.030" - .060"	.030" - .050"	.060" - .080"	.080" - .100"	70%
Low Alloy Steel	JC7560 JC8050	550	.030" - .050"	.025" - .050"	.050" - .070"	.070" - .090"	70%
Mold Steel	JC8118 JC7560	500	.025" - .040"	.025" - .040"	.040" - .060"	.050" - .070"	60%
Tool & Die Steel (40-50 HRC)	JC8118 JC7560	400	.020" - .030"	.020" - .035"	.025" - .040"	.030" - .050"	60%
Hardened Die Steel (50-60 HRC)	JC8118 JC7560	250	.010" - .015"	.010" - .015"	.010" - .020"	.010" - .015"	40%
Stainless Steel	JC8050 JC7560	300	.015" - .025"	.020" - .040"	.025" - .040"	.040" - .060"	60%

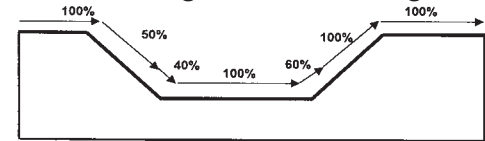
**NOTE:** 1. These parameters are for stable machining with steel bodies at lengths 4XD. See table below for longer applications.  
 2.  $RPM = 3.82 \times SFM / Dia.$   
 3.  $IPM = RPM \times IPT \times \# \text{ of flutes (or teeth)}$

### Additional Cutting Data For Longer Tools

Reach/Dia.	~4.0	4.0~4.5	4.5~5.3	5.3~5.7	5.7~6.2	6.3~
rpm %	100	90	80	80	75	70
Feed %	100	90	90	80	75	70

**NOTE:** The above percentages should be applied, according to tool ratio.

### Reduced Cutting Data For Cutting Pattern



**NOTE:** Feed should be reduced when cutting the above pattern





# SKS

## *High Feed Diemaster*



- Single sided trigon insert with 3 cutting edges.
- Positive axial rake (+8 deg.) reduces cutting pressure.
- Designed to focus tool pressure in the Z axis.
- Multiple insert grades and geometries to choose from.

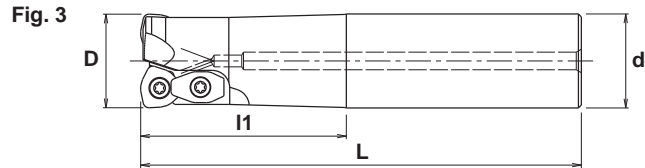
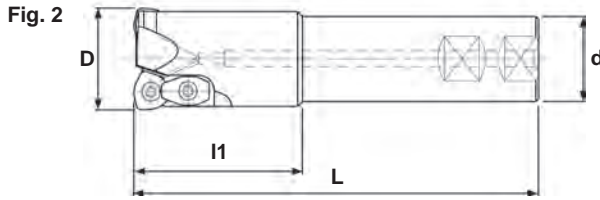
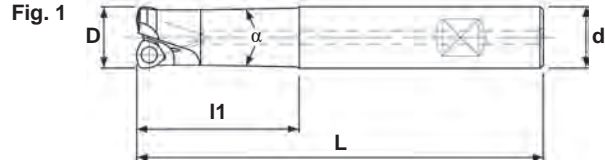


# SKS - High Feed Diemaster

**INCH**

**METRIC**

## END MILL SKS Type



### Specifications - Inch

CATALOG NUMBER	STK	DIMENSIONS					FIG.	INSERT	Q	PARTS		
		D	L	l1	d	$\alpha$				Screw	Wrench	Clamp
SKS-2062-1.5-S062	•	.625	4.00	1.50	.625	6°	1	WOMW04T215ZER WOMT04T215ZER	2	TSW-2556H	T-08SD	-
SKS-2062-2.5-S062	•	.625	5.00	2.50	.625	2°	1					
SKS-2075-2.0-S075	•	.750	5.00	2.00	.750	2°	1	WDMW050316Z*R WDMT050316ZER	2	DSW-306H	T-10	-
SKS-2075-4.0-S075	•	.750	7.00	4.00	.750	1°	1					
SKS-2075-6.0-S075	•	.750	9.00	6.00	.750	0°30'	1					
SKS-2100-2.5-S100	•	1.00	6.00	2.50	1.00	2°	3	WDMW06T320Z*R WDMT06T320ZER	2	CSW-408H	A-15T	DCM-18
SKS-2100-4.5-S100	•	1.00	8.00	4.50	1.00	1°	3					
SKS-2100-6.5-S100	•	1.00	10.00	6.50	1.00	0°30'	3					
SKS-2125-2.5-S125	•	1.25	6.00	2.50	1.25	2°	3	WDMW080520Z*R WDMT080520ZER	2	DSW-4510H	A-20	DCM-17
SKS-2125-4.5-S125	•	1.25	8.00	4.50	1.25	1°	3					
SKS-2125-6.5-S125	•	1.25	10.00	6.50	1.25	1°	3					
SKS-3150-2.5-S125	•	1.50	6.00	2.50	1.25	-	2	WDMW080520Z*R WDMT080520ZER	3	DSW-4510H	A-20	DC-17
SKS-3150-2.5-S150	•	1.50	6.00	2.50	1.50	-	3					
SKS-3150-5.0-S150	•	1.50	10.00	5.00	1.50	-	3					

Note: 1.5" diameter is not G-Body.

Note: All cutters are supplied without inserts or wrenches.

### Specifications - Metric

CATALOG NUMBER	STK	DIMENSIONS					FIG.	INSERT	Q	PARTS		
		D	L	l1	d					Screw	Wrench	Clamp
SKS-2016-20-S15	•	16	110	20	15	1	WOMW04T215ZER WOMT04T215ZER	2	TSW-2556H	T-08SD	-	
SKS-2016-50-S16	•	16	110	50	16	1						
SKS-2016-20L-S15	•	16	150	20	15	1						
SKS-2016-70-S16	•	16	150	70	16	1						
SKS-2017-20-S16	•	17	110	20	16	1						
SKS-2017-20L-S16	•	17	150	20	16	1						

Note: All cutters are supplied without inserts or wrenches.



**METRIC**

# SKS - High Feed Diemaster

**END MILL**  
**SKS Type**



Fig. 1

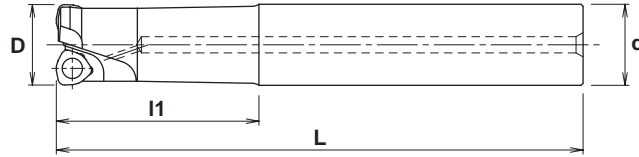


Fig. 2

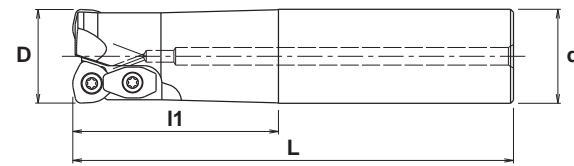
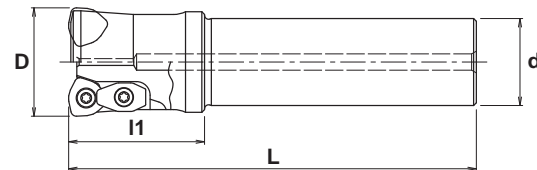


Fig. 3



## Specifications - Metric

CATALOG NUMBER	STK	DIMENSIONS				FIG.	INSERT	Q	PARTS		
		D	L	I1	d				Screw	Wrench	Clamp
SKS-2020-50-S20	•	20	130	50	20	1	WDMW050316Z*R WDMT050316ZER	2	DSW-306H	T-10	-
SKS-2020-100-S20	•	20	180	100	20	1					
SKS-2020-130-S20	•	20	250	130	20	1					
SKS-2021-50-S20	•	21	130	50	20	1	WDMW050316Z*R WDMT050316ZER	2	DSW-306H	T-10	-
SKS-2021-50L-S20	•	21	180	50	20	1					
SKS-2021-50E-S20	•	21	250	50	20	1					
SKS-2022-30L-S20	•	22	180	30	20	1	WDMW050316Z*R WDMT050316ZER	2	DSW-306H	T-10	-
SKS-2022-30E-S20	•	22	250	30	20	1					
SKS-2025-60-S25	•	25	140	60	25	2	WDMW06T320Z*R WDMT06T320ZER	2	CSW-408H	A-15T	DCM-18
SKS-2025-120-S25	•	25	200	120	25	2					
SKS-2025-180-S25	•	25	300	180	25	2					
SKS-2026-60-S25	•	26	140	60	25	2	WDMW06T320Z*R WDMT06T320ZER	2	CSW-408H	A-15T	DCM-18
SKS-2026-60L-S25	•	26	200	60	25	2					
SKS-2026-60E-S25	•	26	300	60	25	2					
SKS-2028-40E-S25	•	28	300	40	25	3	WDMW06T320Z*R WDMT06T320ZER	2	CSW-408H	A-15T	DCM-18
SKS-2030-40L-S28	•	30	200	40	28	3	WDMW06T320Z*R WDMT06T320ZER	2	CSW-408H	A-15T	DCM-18
SKS-2030-40E-S28	•	30	300	40	28	3					
SKS-2030-70-S32	•	30	150	70	32	2					
SKS-2030-120-S32	•	30	200	120	32	2					
SKS-2030-180-S32	•	30	300	180	32	2					
SKS-2032-70-S32	•	32	150	70	32	2	WDMW080520Z*R WDMT080520ZER	2	DSW-4510H	A-20	DCM-17
SKS-3032-70-S32	•	32	150	70	32	2		3			
SKS-2032-120-S32	•	32	200	120	32	2		2			
SKS-3032-120-S32	•	32	200	120	32	2		3			
SKS-2032-180-S32	•	32	300	180	32	2		2			
SKS-3032-180-S32	•	32	300	180	32	2		3			

Note: All cutters are supplied without inserts or wrenches.



# SKS - High Feed Diemaster

**METRIC**

## END MILL SKS Type



Fig. 1

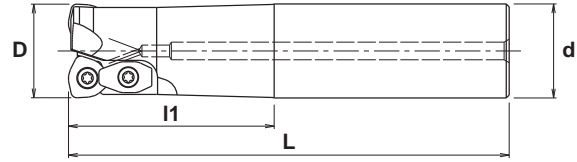
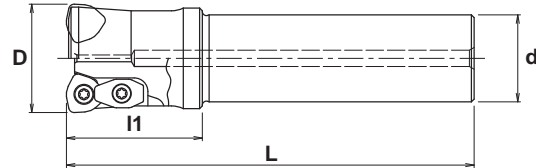


Fig. 2



### Specifications - Metric

CATALOG NUMBER	STK	DIMENSIONS				FIG.	INSERT	Q	PARTS		
		D	L	l1	d				Screw	Wrench	Clamp
SKS-2033-70-S32	•	33	150	70	32	2	WDMW080520Z*R WDMT080520ZER	2	DSW-4510H	A-20	DCM-17
SKS-2033-70L-S32	•	33	200	70	32	2					
SKS-2033-70E-S32	•	33	300	70	32	2					
SKS-3033-70-S32	•	33	150	70	32	2	WDMW06T320Z*R WDMT06T320ZER	3	CSW-408H	A-15T	DCM-18
SKS-3033-70L-S32	•	33	200	70	32	2					
SKS-3033-70E-S32	•	33	300	70	32	2					
SKS-2035-50L-S32	•	35	200	50	32	2	WDMW080520Z*R WDMT080520ZER	2	DSW-4510H	A-20	DCM-17
SKS-2035-50E-S32	•	35	300	50	32	2					
SKS-3040-50-S32	•	40	150	50	32	2	WDMW080520Z*R WDMT080520ZER	3	DSW-4510H	A-20	DCM-17
SKS-3040-50L-S32	•	40	250	50	32	2					
SKS-3040-50E-S32	•	40	300	50	32	2					
SKS-3040-50-S42	•	40	150	50	42	1					
SKS-3040-130-S42	•	40	250	130	42	1					
SKS-3040-180-S42	•	40	300	180	42	1					
SKS-3044-50-S42	•	44	150	50	42	2	WDMW080520Z*R WDMT080520ZER	3	DSW-4510H	A-20	DCM-17
SKS-3044-130-S42	•	44	250	130	42	2					
SKS-3044-180-S42	•	44	300	180	42	2					
SKS-3050-50-S32	•	50	150	50	32	2	WDMW080520Z*R WDMT080520ZER	3	DSW-4510H	A-20	DCM-17
SKS-3050-50-S42	•	50	150	50	42	2					
SKS-3050-50L-S42	•	50	250	50	42	2					
SKS-3050-50E-S42	•	50	300	50	42	2					
SKS-3050-50-S42-10	•	50	150	50	42	2	WDMW10X620Z*R WDMT10X620ZER	3	DSW-4512H	A-20	DCM-17
SKS-3050-50L-S42-10	•	50	250	50	42	2					
SKS-3050-50E-S42-10	•	50	300	50	42	2					

Note: All cutters are supplied without inserts or wrenches.



**INCH**

# SKS - High Feed Diemaster

**FACE MILL**  
SKS Type



Entering Angle	A.R. : +8°
	R.R. : -2°



Fig. 1

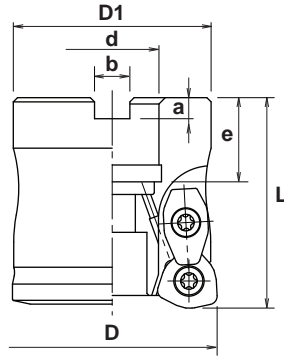


Fig. 2

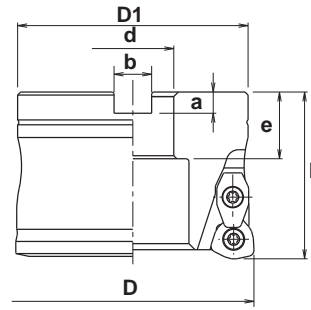
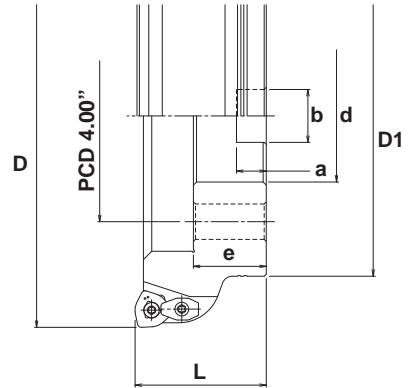


Fig. 3



## Specifications - Inch

CATALOG NUMBER	STK	DIMENSIONS							FIG.	INSERT	Q	PARTS		
		D	L	d	D1	a	b	e				Screw	Wrench	Clamp
SKS-4200-75R-08	•	2.00	2.00	.750	1.85	.197	.319	.750	1	WDMW080520Z*R WDMT080520ZER	4	DSW-4510H	A-20	DCM-17
SKS-5200-75R-06	•	2.00	2.00	.750	1.85	.197	.319	.750	1	WDMW06T320Z*R WDMT06T320ZER	5	CSW-408H	A-15T	DCM-18
SKS-4250-100R-08	•	2.50	2.00	1.00	2.36	.240	.375	.750	1	WDMW080520Z*R WDMT080520ZER	4	DSW-4510H	A-20	DCM-17
SKS-4250-100R-10	•	2.50	2.00	1.00	2.36	.240	.375	.750	1	WDMW10X620Z*R WDMT10X620ZER	4	DSW-4512H	A-20	DCM-17
SKS-5300-100R-08	•	3.00	2.00	1.00	2.85	.240	.375	.750	1	WDMW080520Z*R WDMT080520ZER	5	DSW-4510H	A-20	DCM-17
SKS-5300-100R-10	•	3.00	2.00	1.00	2.85	.240	.375	.750	1	WDMW10X620Z*R WDMT10X620ZER	5	DSW-4512H	A-20	DCM-17
SKS-5300-125R-10	•	3.00	2.48	1.25	2.85	.315	.500	1.26	1	WDMW10X620Z*R WDMT10X620ZER	5	DSW-4512H	A-20	DCM-17
SKS-6400-150R-08	•	4.00	2.25	1.50	3.78	.400	.630	1.00	1	WDMW080520Z*R WDMT080520ZER	6	DSW-4510H	A-20	DCM-17
SKS-6400-150R-10	•	4.00	2.25	1.50	3.78	.400	.630	1.00	1	WDMW10X620Z*R WDMT10X620ZER	6	DSW-4512H	A-20	DCM-17
SKS-6500-150R-10	•	5.00	2.25	1.50	3.35	.400	.630	1.42	2	WDMW10X620Z*R WDMT10X620ZER	6	DSW-4512H	A-20	DCM-17
SKS-7600-150R-10	•	6.00	2.25	1.50	3.94	.400	.630	1.42	2	WDMW10X620Z*R WDMT10X620ZER	7	DSW-4512H	A-20	DCM-17
SKS-9800-250R-10	•	8.00	2.48	2.50	6.06	.560	1.00	1.38	3	WDMW10X620Z*R WDMT10X620ZER	9	DSW-4512H	A-20	DCM-17

Note: All cutters are supplied without inserts or wrenches.



# SKS - High Feed Diemaster

**METRIC**
**FACE MILL**  
**SKS Type**
**G-Body**

Entering Angle	A.R. : +8°
	R.R. : -2°



Fig. 1

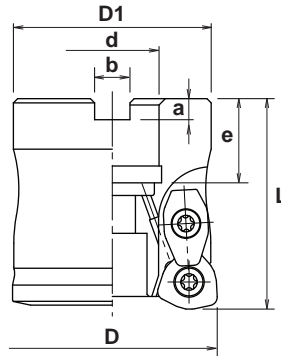
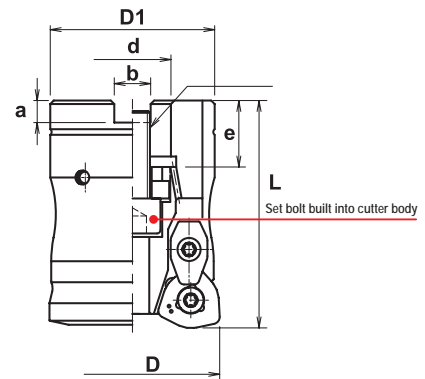


Fig. 2



## Specifications - Metric

CATALOG NUMBER	STK	DIMENSIONS							FIG.	INSERT	Q	PARTS		
		D	L	d	D1	a	b	e				Screw	Wrench	Clamp
SKS-3040R-06-16	•	40	45	16	37	5.6	8.4	18	1	WDMW06T320Z*R WDMT06T320ZER	3	CSW-408H	A-15T	DCM-18
SKS-3050R-08	•	50	50	22.225	47	5	8.4	20	1	WDMW080520Z*R WDMT080520ZER	3	DSW-4510H	A-20	DCM-17
SKS-3050R-08-22	•	50	50	22	47	6.3	10.4	20	1	WDMW080520Z*R WDMT080520ZER	3			
SKS-3050R-10	•	50	65	22.225	47	5	8.4	19	2	WDMW10X620Z*R WDMT10X620ZER	3	DSW-4512H	A-20	DCM-17
SKS-3050R-10-22	•	50	65	22	47	6.3	10.4	19	2		3			
SKS-3052R-10-22	•	52	65	22	47	6.3	10.4	19	2		3			
SKS-4050R-08	•	50	50	22.225	47	5	8.4	20	1	WDMW080520Z*R WDMT080520ZER	4	DSW-4510H	A-20	DCM-17
SKS-4050R-08-22	•	50	50	22	47	6.3	10.4	20	1		4			
SKS-5050R-06	•	50	50	22.225	47	5	8.4	20	1	WDMW06T320Z*R WDMT06T320ZER	5	CSW-408H	A-15T	DCM-18
SKS-5050R-06-22	•	50	50	22	47	6.3	10.4	20	1		5			
SKS-3052R-08-22*	•	52	50	22	47	6.3	10.4	20	1	WDMW080520Z*R WDMT080520ZER	3	DSW-4510H	A-20	DCM-17
SKS-4052R-08-22	•	52	50	22	47	6.3	10.4	20	1		4			
SKS-5052R-06-22	•	52	50	22	47	6.3	10.4	20	1	WDMW06T320Z*R WDMT06T320ZER	5	CSW-408H	A-15T	DCM-18
SKS-3063R-08	•	63	50	22.225	60	5	8.4	20	1	WDMW080520Z*R WDMT080520ZER	3	DSW-4510H	A-20	DCM-17
SKS-4063R-08	•	63	50	22.225	60	5	8.4	20	1		4			
SKS-4063R-08-22	•	63	50	22	60	6.3	10.4	20	1		4			
SKS-4063R-08-27	•	63	50	27	60	7	12.4	22	1		4			
SKS-4063R-10	•	63	50	22.225	60	5	8.4	20	1	WDMW10X620Z*R WDMT10X620ZER	4	DSW-4512H	A-20	DCM-17
SKS-4063R-10-22	•	63	50	22	60	6.3	10.4	20	1		4			
SKS-4063R-10-27	•	63	50	27	60	7	12.4	22	1		4			
SKS-5063R-08	•	63	50	22.225	47	5	8.4	20	1	WDMW080520Z*R WDMT080520ZER	5	DSW-4510H	A-20	DCM-17
SKS-5063R-08-22	•	63	50	22	60	6.3	10.4	20	1		5			
SKS-5063R-08-27	•	63	50	27	60	7	12.4	22	1		5			

\* Not G-Body

Note: All cutters are supplied without inserts or wrenches.





**METRIC**

# SKS - High Feed Diemaster

**FACE MILL**  
SKS Type



Entering Angle	A.R. : +8°
	R.R. : -2°



Fig. 1

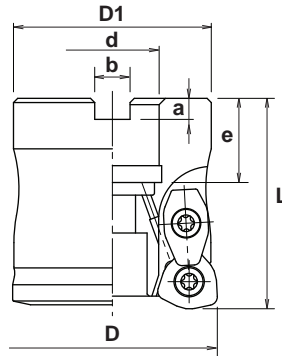
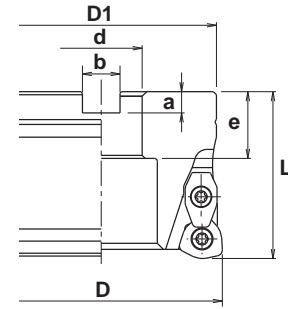


Fig. 2



## Specifications - Metric

CATALOG NUMBER	STK	DIMENSIONS							FIG.	INSERT	Q	PARTS		
		D	L	d	D1	a	b	e				Screw	Wrench	Clamp
SKS-4066R-08-27	•	66	50	27	61	7	12.4	22	1	WDMW080520Z*R WDMT080520ZER	4	DSW-4510H	A-20	DCM-17
SKS-5066R-08-27	•	66	50	27	60	7	12.4	22	1		5			
SKS-5080R-08	•	80	70	31.75	76	8	12.7	32	1	WDMW080520Z*R WDMT080520ZER	5	DSW-4510H	A-20	DCM-17
SKS-5080R-08-27	•	80	55	27	76	7	12.4	22	2		5			
SKS-5080R-10	•	80	70	31.75	76	8	12.7	32	1	WDMW10X620Z*R WDMT10X620ZER	5	DSW-4512H	A-20	DCM-17
SKS-5080R-10-27	•	80	55	27	76	7	12.4	22	2		5			
SKS-6080R-08-27	•	80	55	27	76	7	12.4	22	2	WDMW080520Z*R WDMT080520ZER	6	DSW-4510H	A-20	DCM-17
SKS-6100R-08	•	100	70	31.75	96	8	12.7	32	1		6			
SKS-6100R-08-32	•	100	55	32	96	8	14.4	32	2	WDMW080520Z*R WDMT080520ZER	6	DSW-4510H	A-20	DCM-17
SKS-6100R-10	•	100	70	31.75	96	8	12.7	32	1		6			
SKS-6100R-10-32	•	100	55	32	96	8	14.4	32	2	WDMW10X620Z*R WDMT10X620ZER	6	DSW-4512H	A-20	DCM-17
SKS-6125R-10	•	125	63	38.1	100	10	15.9	40	2		6			
SKS-6125R-10-40	•	125	55	40	85	9	16.4	35	2	WDMW10X620Z*R WDMT10X620ZER	6	DSW-4512H	A-20	DCM-17
SKS-7160R-10	•	160	63	50.8	100	11	19	43	2		7			
SKS-7160R-10-40	•	160	55	40	120	9	16.4	35	2	WDMW10X620Z*R WDMT10X620ZER	7	DSW-4512H	A-20	DCM-17
											7			

Note: All cutters are supplied without inserts or wrenches.

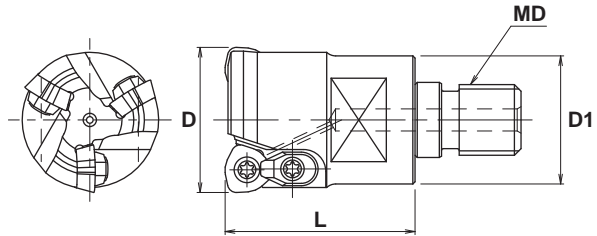
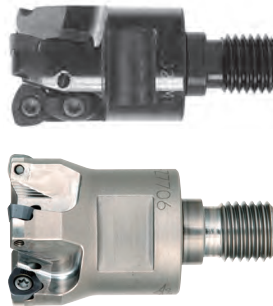


# SKS - High Feed Diemaster

INCH

METRIC

## MODULAR HEADS MSH Type



### Specifications - Inch

CATALOG NUMBER	STK	DIMENSIONS				HEAD TORQUE lbs/ft	INSERT	Q	PARTS		
		D	L	D1	MD				Screw	Wrench	Clamp
MSH-2062-M8	•	.625	.900	.591	M8	11.8	WO**04T215Z*R	2	TSW-2556H	T-08SD	-
MSH-2075-M10	•	.750	.910	.728	M10	11.8	WD**050316Z*R	2	DSW-306H	T-10	-
MSH-2100-M12	•	1.00	1.38	.945	M12	14.7	WD**06T320Z*R	2	CSW-408H	A-15T	DCM-18
MSH-2125-M16	•	1.25	1.69	1.14	M16	18.4	WD**080520Z*R	2	DSW-4510H	A-20	DCM-17
MSH-3125-M16	•	1.25	1.69	1.14	M16	18.4	WD**06T320Z*R	3	CSW-408H	A-15T	DCM-18

Note: All cutters are supplied without inserts or wrenches.

### Specifications - Metric

CATALOG NUMBER	STK	DIMENSIONS				HEAD TORQUE Nm	INSERT	Q	PARTS		
		D	L	D1	MD				Screw	Wrench	Clamp
MSH-2016-M8	•	16	23	15	M8	16	WO**04T215Z*R	2	TSW-2556H	T-08SD	-
MSH-2017-M8	•	17	23	15	M8	16	WO**04T215Z*R	2	TSW-2556H	T-08SD	-
MSH-2020-M10	•	20	30	19	M10	16	WD**050316Z*R	2	DSW-306H	T-10	-
MSH-2021-M10	•	21	30	19	M10	16	WD**050316Z*R	2	DSW-306H	T-10	-
MSH-2022-M10	•	22	30	19	M10	16	WD**050316Z*R	2	DSW-306H	T-10	-
MSH-2025-M12	•	25	35	23.6	M12	20	WD**06T320Z*R	2	CSW-408H	A-15T	DCM-18
MSH-2026-M12	•	26	35	23.6	M12	20	WD**06T320Z*R	2	CSW-408H	A-15T	DCM-18
MSH-2028-M12*	•	28	35	23.6	M12	20	WD**06T320Z*R	2	CSW-408H	A-15T	DCM-18
MSH-2030-M16	•	30	43	29	M16	25	WD**06T320Z*R	2	CSW-408H	A-15T	DCM-18
MSH-2032-M16	•	32	43	29	M16	25	WD**080520Z*R	2	DSW-4510H	A-20	DCM-17
MSH-3032-M16	•	32	43	29	M16	25	WD**06T320Z*R	3	CSW-408H	A-15T	DCM-18
MSH-2033-M16	•	33	43	29	M16	25	WD**080520Z*R	2	DSW-4510H	A-20	DCM-17
MSH-3033-M16	•	33	43	29	M16	25	WD**06T320Z*R	3	CSW-408H	A-15T	DCM-18
MSH-2035-M16	•	35	43	29	M16	25	WD**080520Z*R	2	DSW-4510H	A-20	DCM-17
MSH-3035-M16	•	35	43	29	M16	25	WD**06T320Z*R	3	CSW-408H	A-15T	DCM-18

\* Not G-Body

Note: All cutters are supplied without inserts or wrenches.

### Specifications - Metric - Fine Pitch (G-Body)

CATALOG NUMBER	STK	DIMENSIONS				HEAD TORQUE Nm	INSERT	Q	PARTS		
		D	L	D1	MD				Screw	Wrench	Clamp
MSH-3020-M10	•	20	30	19	M10	16	WO**04T215Z*R	3	TSW-2556H	T-08SD	-
MSH-3021-M10	•	21	30	19	M10	16	WO**04T215Z*R	3	TSW-2556H	T-08SD	-
MSH-3022-M10	•	22	30	20	M10	16	WO**04T215Z*R	3	TSW-2556H	T-08SD	-
MSH-3025-M12	•	25	35	23.6	M12	20	WD**050316Z*R	3	DSW-306H	T-10	-
MSH-3026-M12	•	26	35	23.6	M12	20	WD**050316Z*R	3	DSW-306H	T-10	-
MSH-3028-M12	•	28	35	23.6	M12	20	WD**050316Z*R	3	DSW-306H	T-10	-
MSH-3030-M16	•	30	43	29	M16	25	WD**050316Z*R	3	DSW-306H	T-10	-
MSH-4032-M16	•	32	43	29	M16	25	WD**050316Z*R	4	DSW-306H	T-10	-
MSH-5040-M16	•	40	43	32	M16	25	WD**050316Z*R	5	DSW-306H	T-10	-

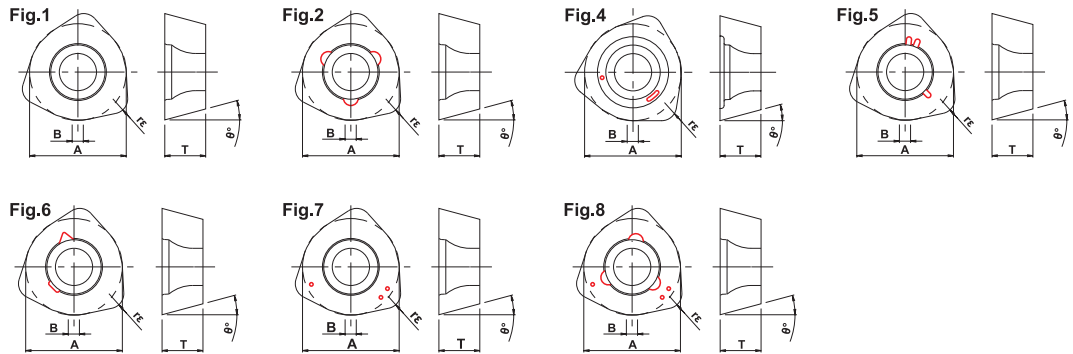
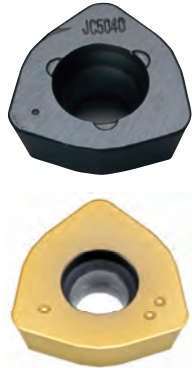
See page A-59 for Modular Head Shanks.

Note: All cutters are supplied without inserts or wrenches.



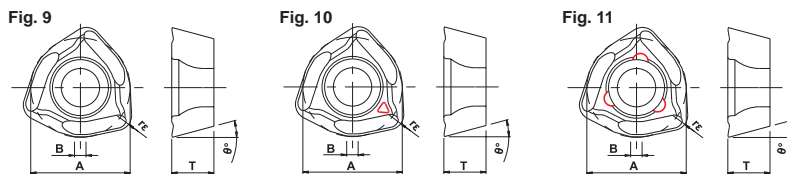
**METRIC**

# SKS Inserts



## Specifications for inserts

CATALOG NUMBER	TOLERANCE	DIMENSIONS					PVD COATED				
		A	B	T	rε	Ø	JC7560	JC8015	JC8050	JC5040	JC8118
WOMW04T215ZER	M	6.5	0.8	2.8	1.5	13°	• Fig. 1	• Fig. 1	• Fig. 1	• Fig. 2	• Fig. 1
WDMW050316ZER		8	1	3.2	1.6	15°			• Fig. 4		
WDMW050316ZTR		8	1	3.2	1.6	15°	• Fig. 1	• Fig. 1	• Fig. 1	• Fig. 2	• Fig. 1
WDMW06T320ZER		10	1.2	3.97	2	15°			• Fig. 4		
WDMW06T320ZTR		10	1.2	3.97	2	15°	• Fig. 1	• Fig. 1	• Fig. 1	• Fig. 2	• Fig. 1
WDMW080520ZER		13	1.5	5.5	2	15°			• Fig. 4		
WDMW080520ZTR		13	1.5	5.5	2	15°	• Fig. 5	• Fig. 5	• Fig. 5	• Fig. 6	• Fig. 5
WDMW10X620ZER		16	2	6	2	15°			• Fig. 4		
WDMW10X620ZTR		16	2	6	2	15°	• Fig. 7	• Fig. 7	• Fig. 7	• Fig. 8	• Fig. 7



## Specifications for inserts

CATALOG NUMBER	TOLERANCE	DIMENSIONS					PVD COATED				
		A	B	T	rε	Ø	JC7560	JC8015	JC8050	JC5040	JC8118
WOMT04T215ZER	M	6.5	0.8	2.8	1.5	13°	• Fig. 11	• Fig. 9	• Fig. 11		• Fig. 9
WDMT050316ZER		8	1	3.2	1.6	15°	• Fig. 10	• Fig. 9	• Fig. 10		• Fig. 9
WDMT06T320ZER		10	1.2	3.97	2	15°	• Fig. 10	• Fig. 9	• Fig. 10		• Fig. 9
WDMT080520ZER		13	1.5	5.5	2	15°	• Fig. 10	• Fig. 9	• Fig. 10		• Fig. 9
WDMT10X620ZER		16	2	6	2	15°	• Fig. 10	• Fig. 9	• Fig. 10		• Fig. 9

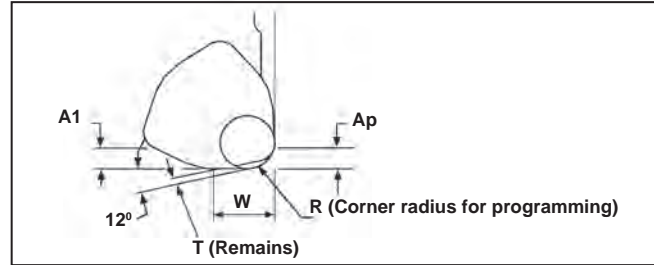


# SKS - High Feed Diemaster

**INCH**

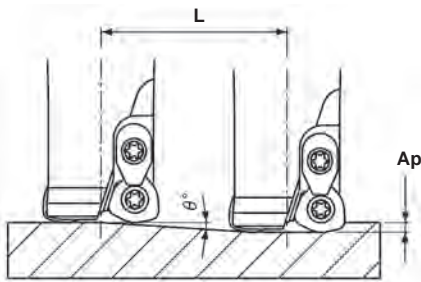
## Definition of Corner Shape for Programming

INSERT SIZE	W	Ap	T	A1	R
04	.106"	.031"	.011"	.031"	.059"
05	.142"	.049"	.014"	.047"	.079"
06	.177"	.059"	.017"	.059"	.098"
08	.236"	.079"	.025"	.079"	.118"
10	.291"	.098"	.036"	.098"	.118"

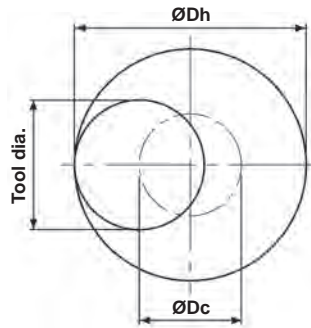


## Recommended Conditions For Helical Interpolation

- Ramping



- Helical interpolation



- Calculation of tool pass dia.

$$\text{Tool pass dia. } \varnothing D_c = \text{Bore dia. } \varnothing D_h - \text{Tool Dia. } I$$

- Down cutting is recommended, so tool pass rotation should be counterclockwise.
- Depth of cut per one circuit should not exceed max. depth of cut Ap.
- In case of ramping and helical interpolation, apply 70% or less feed (F) from standard cutting condition table.
- In case of drilling, apply 50% or less Z axis feed (F) from standard cutting condition table.
- Long consecutive chips may result in case of drilling, confirm safe operating conditions.

CATALOG NUMBER	TOOL DIA. (inch)	EFFECTIVE CUTTING DIA. (inch)	MAX. DEPTH OF CUT: AP (inch)	RAMPING		HELICAL INTERPOLATION		MAX. DRILLING DEPTH: Z (inch)
				MAX. ANGLE	TOTAL CUTTING LENGTH AT MAX. AP: L (inch)	MIN BORE DIA.: Dh (inch)	MAX BORE DIA.: Dh (inch)	
MSH-2062-M8	.625	.410	.031	2° 32'	.700	.980	1.13	.011
SKS-2075, MSH-2075-M10	.750	.465	.047	3° 18'	.819	1.11	1.38	.020
SKS-2100, MSH-2100-M12	1.00	.642	.059	3° 45'	.902	1.33	1.80	.039
SKS-2125, MSH-2125-M16	1.25	.780	.079	4° 06'	1.10	1.59	2.34	.059
SKS-2150, SKS-3150	1.50	1.03	.079	2° 54'	1.56	2.09	2.84	.059
SKS-5200-*	2.00	1.64	.059	1° 09'	2.35	3.33	3.85	.039
SKS-4200	2.00	1.53	.079	2°	2.26	3.09	3.84	.059
SKS-4250-*-08	2.50	2.02	.079	1° 30'	3.01	4.09	4.84	.059
SKS-5300-*-08	3.00	2.52	.079	1° 12'	3.76	5.09	5.84	.059
SKS-6400-*-08	4.00	3.52	.079	1°	4.51	7.09	7.84	.059
SKS-4250-*-10	2.50	1.91	.091	2° 42'	1.92	3.86	4.84	.071
SKS-5300-*-10	3.00	2.41	.091	2° 06'	2.47	4.86	5.84	.071
SKS-6400-*-10	4.00	3.41	.091	1° 30'	3.46	6.86	7.84	.071
SKS-6500-*-10	5.00	4.41	.091	1° 12'	4.32	8.86	9.84	.071
SKS-7600-*-10	6.00	5.41	.091	0° 54'	5.76	10.86	11.84	.071
SKS-9800-*-10	8.00	7.41	.091	0° 39'	7.98	14.85	15.83	.071

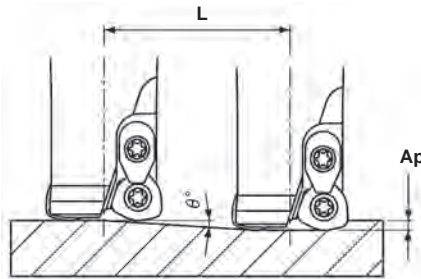


**METRIC**

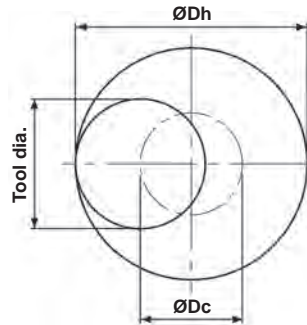
# SKS - High Feed Diemaster

## Recommended Data For Profile Milling with SKS

- Ramping



- Helical interpolation



- Calculation of tool pass dia.

$$\text{Tool pass dia. } \varnothing D_c = \text{Bore dia. } \varnothing D_h - \text{Tool Dia. } I$$

- Down cutting is recommended, so tool pass rotation should be counterclockwise.
- Depth of cut per one circuit should not exceed max. depth of cut  $A_p$ .
- In case of ramping and helical interpolation, apply 70% or less feed (F) from standard cutting condition table.
- In case of drilling, apply 50% or less Z axis feed (F) from standard cutting condition table.
- Long consecutive chips may result in case of drilling, confirm safe operating conditions.

CATALOG NUMBER	TOOL DIA. (mm)	EFFECTIVE CUTTING DIA. (mm)	MAX. DEPTH OF CUT: $A_p$ (mm)	RAMPING		HELICAL INTERPOLATION		MAX. DRILLING DEPTH: Z (mm)
				MAX. ANGLE	TOTAL CUTTING LENGTH AT MAX. $A_p$ : L (mm)	MIN BORE DIA.: $D_h$ (mm)	MAX BORE DIA.: $D_h$ (mm)	
SKS-2016	16	10.5	0.8	2° 30'	20.6	25	29	0.3
SKS-2017	17	11.5	0.8	2°	25.7	27	31	0.3
SKS-2020	20	12.7	1.2	3°	22.9	30	37	0.5
SKS-2021	21	13.7	1.2	2° 30'	27.5	32	39	0.5
SKS-2022	22	14.7	1.2	2°	34.4	34	41	0.5
SKS-2025	25	15.9	1.5	4°	21.5	33	46	1
SKS-2026	26	16.9	1.5	3° 30'	24.5	35	48	1
SKS-2028	28	18.9	1.5	3°	28.6	39	52	1
SKS-2030	30	20.9	1.5	2° 30'	34.4	43	56	1
SKS-2032	32	20	2	4°	28.6	41	60	1.5
SKS-3032	32	22.8	1.5	2° 15'	38.1	47	60	1
SKS-2033	33	21	2	3° 30'	32.7	43	62	1.5
SKS-3033	33	23.8	1.5	2° 6'	40.9	49	62	1
SKS-2035	35	23	2	3°	38.2	47	66	1.5
SKS-3035	35	25.8	1.5	2°	43	53	66	1
SKS-3040	40	28	2	2° 48'	40.9	57	76	1.5
SKS-3040-06	40	30.8	1.5	1° 36'	53.7	63	76	1
SKS-3044	44	32	2	2° 30'	45.8	65	84	1.5
SKS-3050-*-10	50	35.1	2.3	2° 18'	57.3	71	96	1.8
SKS-*050	50	38	2	2°	57.3	77	96	1.5
SKS-5050-06	50	40.8	1.5	1° 09'	59.8	83	96	1
SKS-*052	52	40	2	2°	57.3	81	100	1.5
SKS-5052-06	52	42.8	1.5	1° 06'	62.5	87	100	1
SKS-*063	63	51	2	1° 30'	76.4	103	122	1.5
SKS-*063-10	63	48	2.3	2° 42'	48.8	97	122	1.8
SKS-*066	66	54	2	1° 24'	81.8	109	128	1.5
SKS-*080	80	68	2	1° 12'	95.5	137	156	1.5
SKS-*080-10	80	65	2.3	2°	65.9	131	156	1.8
SKS-*100	100	88	2	1°	114.6	177	196	1.5
SKS-*100-10	100	85	2.3	1° 30'	87.8	171	196	1.8
SKS-*125-10	125	110	2.3	1° 12'	109.8	221	246	1.8
SKS-*160-10	160	145	2.3	0° 54'	146.4	291	316	1.8



# SKS - High Feed Diemaster

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## Recommended Cutting Data for SKS

Material	SFM	Parameters	INSERT SIZE				
			4	5	6	8	10
Gray Cast Iron	700	IPT	.030" - .040"	.040" - .050"	.050" - .060"	.060" - .070"	.070" - .080"
		DOC	.020"	.040"	.050"	.060"	.075"
		WOC	70%	70%	70%	70%	70%
Nodular Cast Iron	650	IPT	.025" - .035"	.035" - .045"	.045" - .055"	.055" - .065"	.065" - .075"
		DOC	.020"	.040"	.050"	.060"	.075"
		WOC	70%	70%	70%	70%	70%
Carbon Steel	600	IPT	.025" - .035"	.035" - .045"	.045" - .055"	.055" - .065"	.065" - .075"
		DOC	.015"	.020"	.030"	.050"	.070"
		WOC	70%	70%	70%	70%	70%
Low Alloy Steel	550	IPT	.020" - .030"	.030" - .040"	.040" - .050"	.050" - .060"	.060" - .070"
		DOC	.015"	.020"	.030"	.040"	.050"
		WOC	70%	70%	70%	70%	70%
Mold Steel	500	IPT	.015" - .025"	.020" - .030"	.030" - .040"	.040" - .050"	.050" - .060"
		DOC	.015"	.020"	.025"	.030"	.040"
		WOC	60%	60%	60%	60%	60%
Tool & Die Steel (40-50 HRC)	400	IPT	.010" - .020"	.015" - .025"	.020" - .030"	.025" - .035"	.030" - .040"
		DOC	.015"	.015"	.020"	.025"	.030"
		WOC	60%	60%	60%	60%	60%
Hardened Die Steel (50-60 HRC)	200	IPT	.005" - .008"	.006" - .010"	.006" - .010"	.008" - .012"	.008" - .012"
		DOC	.005"	.006"	.007"	.008"	.010"
		WOC	40%	40%	40%	40%	40%
Stainless Steel	300	IPT	.015" - .025"	.020" - .030"	.020" - .030"	.025" - .035"	.025" - .040"
		DOC	.015"	.020"	.025"	.030"	.035"
		WOC	60%	60%	60%	60%	60%
Titanium	200	IPT	.005" - .010"	.005" - .010"	.008" - .015"	.010" - .020"	.010" - .020"
		DOC	.010"	.010"	.010"	.015"	.020"
		WOC	60%	60%	60%	60%	60%
Inconel	100	IPT	.004" - .008"	.004" - .008"	.005" - .010"	.005" - .010"	.005" - .015"
		DOC	.010"	.010"	.015"	.015"	.020"
		WOC	60%	60%	60%	60%	60%

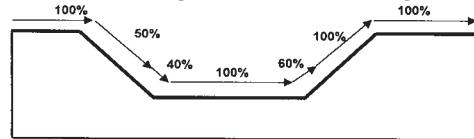
**NOTE:** 1. These parameters are for stable machining with steel bodies at lengths 4XD. See table below for longer applications.  
 2. RPM = 3.82 x SFM / Dia.  
 3. IPM = RPM x IPT x # of flutes (or teeth)

## Additional Cutting Data For Longer Tools

Reach/Dia.	~4.0	4.0~4.5	4.5~5.3	5.3~5.7	5.7~6.2	6.3~
rpm %	100	90	80	80	75	70
Feed %	100	90	90	80	75	70

**NOTE:** The above percentages should be applied, according to tool ratio.

## Reduced Cutting Data For Cutting Pattern



**NOTE:** Feed should be reduced when cutting the above pattern



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# SKS - High Feed Diemaster

## Insert & Grade Recommendation

Grade Catalog Number	Carbon Steel (S50C, S55C) 250HB			Mold Steel (HPM7, PX5, KPM30) 30-36HRC			Mold Steel (NAK80, HPM1) 38-43HRC		Die Steel (SKD61, SKD11) 255HB		
	JC5040	JC8050	JC7560	JC8118	JC8050	JC7560	JC8118	JC8015	JC5040	JC8050	JC7560
WOMW04T215ZER	○	○	◎	◎	●	○	◎	○	○	○	◎
WOMT04T215ZER		☆	☆	☆	☆		☆	☆		☆	☆
WDMW050316ZTR	○	○	◎	○	●	○	○	○	○	○	◎
WDMW050316ZER		●								●	
WDMT050316ZER		☆	☆	☆	☆	☆	☆	☆		☆	☆
WDMW06T320ZTR	○	○	◎	○	●	○	○	○	○	○	◎
WDMW06T320ZER		●								●	
WDMT06T320ZER		☆	☆	☆	☆	☆	☆	☆		☆	☆
WDMW080520ZTR	○	○	◎	○	●	○	○	○	○	○	◎
WDMW080520ZER		●								●	
WDMT080520ZER		☆	☆	☆	☆	☆	☆	☆		☆	☆
WDMW10X620ZTR	○	○	◎	○	●	○	○	○	○	○	◎
WDMW10X620ZER		●								●	
WDMT10X620ZER		☆	☆	☆	☆	☆	☆	☆		☆	☆

Grade Catalog Number	Cast Iron (FC250, FC300) 300HB			Nodular Iron (FCD500, FCD700) 300HB		Stainless (SUS304) 250HB			Hardened Die Steel (SKD61, DAC, DHA) 40-50HRC	
	JC8118	JC8015	JC7560	JC8118	JC8015	JC8050	JC7560	JC8118	JC8118	JC8015
WOMW04T215ZER	◎	○	○	◎	○	●		○	◎	○
WOMT04T215ZER	☆	☆	☆	☆	☆	○	◎		X	X
WDMW050316ZTR	●	○	○	●	○				●	○
WDMW050316ZER						●				
WDMT050316ZER	☆	☆	☆	☆	☆	○	◎		X	X
WDMW06T320ZTR	●	○	○	●	○				●	○
WDMW06T320ZER						●				
WDMT06T320ZER	☆	☆	☆	☆	☆	○	◎		X	X
WDMW080520ZTR	●	○	○	●	○				●	○
WDMW080520ZER						●				
WDMT080520ZER	☆	☆	☆	☆	☆	○	◎		X	X
WDMW10X620ZTR	●	○	○	●	○				●	○
WDMW10X620ZER						●				
WDMT10X620ZER	☆	☆	☆	☆	☆	○	◎		X	X

WD (O) MW ~ Flat Top    WD (O) MT ~ Chipbreaker

◎ = First Choice: Good Condition    ○ = Moderate Condition    ● = Unfavorable Condition    ☆ = Light Cutting    X = Not Recommended

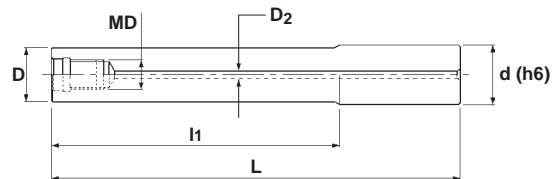




**INCH**

# Modular Head Holders

**Modular Head Holders**  
**MSN Type**  
**Solid Carbide with coolant thru**



## Specifications

CATALOG NUMBER	STK	DIMENSIONS					
		D	I1	L	d	MD	D2
MSN-M6-0.5-S050C	•	.452	.500	2.50	.500	M6	.118
MSN-M6-1.0-S050C	•	.452	1.00	3.15	.500	M6	.118
MSN-M6-2.0-S050C	•	.452	2.00	3.93	.500	M6	.118
MSN-M6-3.0-S050C	•	.452	3.00	5.12	.500	M6	.118
MSN-M8-0.5-S062C	•	.591	.500	3.50	.625	M8	.157
MSN-M8-1.0-S062C	•	.591	1.00	4.00	.625	M8	.157
MSN-M8-2.0-S062C	•	.591	2.00	5.00	.625	M8	.157
MSN-M8-4.0-S062C	•	.591	4.00	7.00	.625	M8	.157
MSN-M8-6.0-S062C	•	.591	6.00	9.00	.625	M8	.157
MSN-M10-0.5-S075C	•	.728	.500	3.50	.750	M10	.157
MSN-M10-1.0-S075C	•	.728	1.00	4.00	.750	M10	.157
MSN-M10-2.0-S075C	•	.728	2.00	5.00	.750	M10	.157
MSN-M10-3.0-S075C	•	.728	3.00	6.00	.750	M10	.157
MSN-M10-4.0-S075C	•	.728	4.00	7.00	.750	M10	.157
MSN-M10-5.0-S075C	•	.728	5.00	8.00	.750	M10	.157
MSN-M10-6.0-S075C	•	.728	6.00	9.00	.750	M10	.157
MSN-M12-0.5-S100C	•	.945	.500	3.50	1.00	M12	.236
MSN-M12-1.0-S100C	•	.945	1.00	4.00	1.00	M12	.236
MSN-M12-2.0-S100C	•	.945	2.00	5.00	1.00	M12	.236
MSN-M12-3.0-S100C	•	.945	3.00	6.00	1.00	M12	.236
MSN-M12-4.0-S100C	•	.945	4.00	7.00	1.00	M12	.236
MSN-M12-5.0-S100C	•	.945	5.00	8.00	1.00	M12	.236
MSN-M12-6.0-S100C	•	.945	6.00	9.00	1.00	M12	.236
MSN-M12-8.0-S100C	•	.945	8.00	11.00	1.00	M12	.236
MSN-M16-0.5-S125C	•	1.14	.500	3.50	1.25	M16	.315
MSN-M16-1.0-S125C	•	1.14	1.00	4.00	1.25	M16	.315
MSN-M16-2.0-S125C	•	1.14	2.00	5.00	1.25	M16	.315
MSN-M16-4.0-S125C	•	1.14	4.00	7.00	1.25	M16	.315
MSN-M16-6.0-S125C	•	1.14	6.00	9.00	1.25	M16	.315
MSN-M16-8.0-S125C	•	1.14	8.00	11.00	1.25	M16	.315

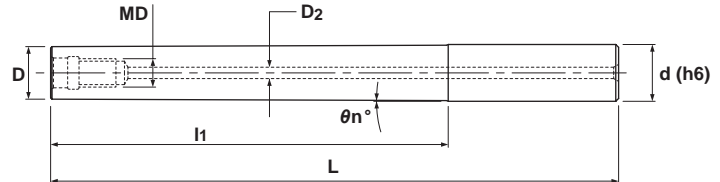
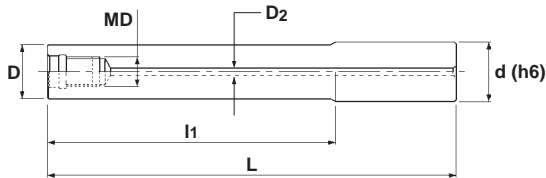
# Modular Head Holders

**METRIC**

## Modular Head Holders

### MSN Type

Solid Carbide with coolant thru


**Fig. 2**


## Specifications

CATALOG NUMBER	STK	DIMENSIONS							FIG.
		D	l1	L	d	$\theta_n^\circ$	MD	D2	
MSN-M6-12-S10C	•	9.7	12	60	10	-	M6	3	1
MSN-M6-30-S10C	•	9.7	30	80	10	-	M6	3	1
MSN-M6-50-S10C	•	9.7	50	100	10	-	M6	3	1
MSN-M6-80-S10C	•	9.7	80	130	10	-	M6	3	1
MSN-M6-15-S12C	•	11.5	15	60	12	-	M6	3	1
MSN-M6-30-S12C	•	11.5	30	80	12	-	M6	3	1
MSN-M6-35T-S12C	•	9.5	35	92	12	3°	M6	3	2
MSN-M6-50-S12C	•	11.5	50	100	12	-	M6	3	1
MSN-M6-57T-S12C	•	9.5	57	114	12	2°	M6	3	2
MSN-M6-65T-S16C	•	11.2	65	125	16	3°30'	M6	3	2
MSN-M6-80-S12C	•	11.5	80	130	12	-	M6	3	1
MSN-M6-15-S16C	•	13.5	15	60	16	-	M6	3	1
MSN-M6-30-S16C	•	13.5	30	80	16	-	M6	3	1
MSN-M6-50-S16C	•	13.5	50	100	16	-	M6	3	1
MSN-M6-80-S16C	•	13.5	80	130	16	-	M6	3	1
MSN-M8-20-S16C	•	15.5	20	75	16	-	M8	4	1
MSN-M8-40-S16C	•	15.5	40	95	16	-	M8	4	1
MSN-M8-40T-S20C	•	14.5	40	100	20	7°	M8	4	2
MSN-M8-77T-S20C	•	14.5	77	143	20	3°30'	M8	4	2
MSN-M8-80-S16C	•	15.5	80	135	16	-	M8	4	1
MSN-M8-120-S16C	•	15.5	120	175	16	-	M8	4	1
MSN-M8-152-S16C	•	15.5	152	207	16	-	M8	4	1
MSN-M10-20-S20C	•	19.5	20	80	20	-	M10	6	1
MSN-M10-40-S20C	•	19.5	40	100	20	-	M10	4	1
MSN-M10-40T-S20C	•	18.5	40	100	20	0°43'	M10	4	2
MSN-M10-70-S20C	•	19.5	70	130	20	-	M10	4	1
MSN-M10-85T-S25C	•	18.5	85	161	25	4°	M10	4	2
MSN-M10-90-S20C	•	19.5	90	150	20	-	M10	4	1
MSN-M10-90T-S20C	•	18.5	90	150	20	0°19'	M10	4	2
MSN-M10-140-S20C	•	19.5	140	200	20	-	M10	4	1
MSN-M10-140T-S20C	•	18.5	140	200	20	0°12'	M10	4	2
MSN-M10-160-S20C	•	19.5	160	220	20	-	M10	4	1
MSN-M10-210-S20C	•	19.5	210	270	20	-	M10	4	1

**METRIC**

# Modular Head Holders

**Modular Head Holders**  
**MSN Type**  
**Solid Carbide with coolant thru**



Fig. 1

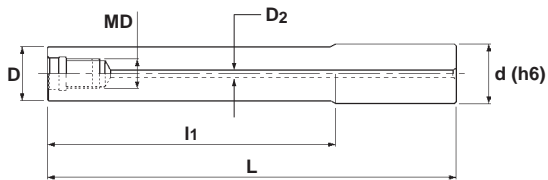
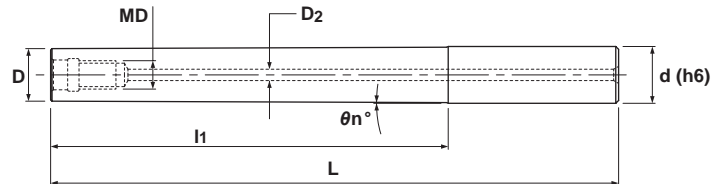


Fig. 2



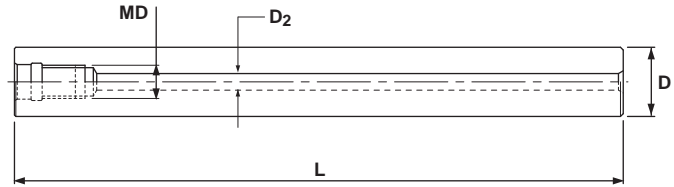
## Specifications

CATALOG NUMBER	STK	DIMENSIONS							FIG.
		D	l1	L	d	$\theta n^\circ$	MD	D2	
MSN-M12-25-S25C	•	24	25	90	25	-	M12	6	1
MSN-M12-55-S25C	•	24	55	120	25	-	M12	6	1
MSN-M12-100T-S32C	•	23.5	100	180	32	4°	M12	6	2
MSN-M12-105-S25C	•	24	105	170	25	-	M12	6	1
MSN-M12-135-S25C	•	24	135	215	25	-	M12	6	1
MSN-M12-155-S25C	•	24	155	220	25	-	M12	6	1
MSN-M12-200-S25C	•	24	200	265	25	-	M12	6	1
MSN-M16-25-S32C	•	29	25	90	32	-	M16	8	1
MSN-M16-55-S32C	•	29	55	120	32	-	M16	8	1
MSN-M16-77-S32C	•	29	77	157	32	-	M16	8	1
MSN-M16-97-S32C	•	29	97	177	32	-	M16	8	1
MSN-M16-105-S32C	•	29	105	170	32	-	M16	8	1
MSN-M16-117T-S32C	•	29	117	197	32	1°15'	M16	8	2
MSN-M16-127-S32C	•	29	127	207	32	-	M16	8	1
MSN-M16-127T-S32C	•	29	127	207	32	1°	M16	8	2
MSN-M16-155-S32C	•	29	155	220	32	-	M16	8	1
MSN-M16-177-S32C	•	29	177	257	32	-	M16	8	1
MSN-M16-177T-S32C	•	29	177	257	32	0°45'	M16	8	2
MSN-M16-195-S32C	•	29	195	260	32	-	M16	8	1
MSN-M16-197T-S32C	•	29	197	277	32	0°45'	M16	8	2
MSN-M16-225-S32C	•	29	225	290	32	-	M16	8	1
MSN-M16-245-S32C	•	29	245	310	32	-	M16	8	1
MSN-M16-295-S32C	•	29	295	360	32	-	M16	8	1

# Modular Head Holders

**METRIC**

**Modular Head Holders**  
**MSN Type - Straight**  
**Solid Carbide with coolant thru**



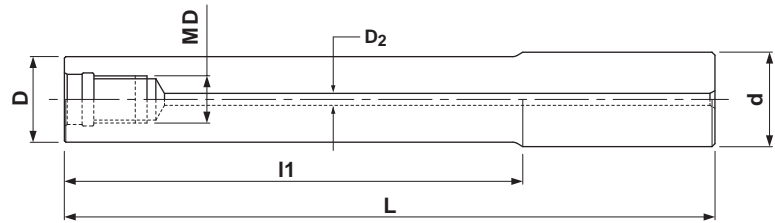
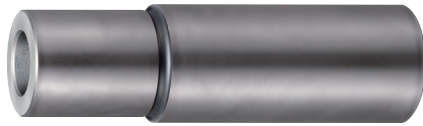
## Specifications

CATALOG NUMBER	STK	DIMENSIONS			
		D	L	MD	D2
MSN-M6-67S-S9.8C	•	9.8	67	M6	3
MSN-M6-107S-S9.8C	•	9.8	107	M6	3
MSN-M6-82S-S10C	•	10	82	M6	3
MSN-M6-122S-S10C	•	10	122	M6	3
MSN-M6-80S-S11.8C	•	11.8	80	M6	3
MSN-M6-120S-S11.8C	•	11.8	120	M6	3
MSN-M6-90S-S12C	•	12	90	M6	3
MSN-M6-130S-S12C	•	12	130	M6	3
MSN-M8-87S-S14C	•	14	87	M8	4
MSN-M8-137S-S14C	•	14	137	M8	4
MSN-M8-97S-S15C	•	15	97	M8	4
MSN-M8-147S-S15C	•	15	147	M8	4
MSN-M8-197S-S15C	•	15	197	M8	4
MSN-M8-107S-S16C	•	16	107	M8	4
MSN-M8-157S-S16C	•	16	157	M8	4
MSN-M10-130S-S18C	•	18	130	M10	4
MSN-M10-190S-S18C	•	18	190	M10	4
MSN-M10-240S-S18C	•	18	240	M10	4
MSN-M10-130S-S20C	•	20	130	M10	4
MSN-M10-190S-S20C	•	20	190	M10	4
MSN-M10-250S-S20C	•	20	250	M10	4
MSN-M12-185S-S23C	•	23	185	M12	6
MSN-M12-265S-S23C	•	23	265	M12	6
MSN-M12-185S-S24C	•	24	185	M12	6
MSN-M12-265S-S24C	•	24	265	M12	6
MSN-M12-145S-S25C	•	25	145	M12	6
MSN-M12-215S-S25C	•	25	215	M12	6
MSN-M12-285S-S25C	•	25	285	M12	6
MSN-M16-160S-S28C	•	28	160	M16	8
MSN-M16-230S-S28C	•	28	230	M16	8
MSN-M16-310S-S28C	•	28	310	M16	8
MSN-M16-157S-S32C	•	32	157	M16	8
MSN-M16-217S-S32C	•	32	217	M16	8
MSN-M16-287S-S32C	•	32	287	M16	8
MSN-M16-357S-S32C	•	32	357	M16	8

**INCH**
**METRIC**

# Modular Head Holders

Modular Head Holders  
 MGN Type  
 G-Body with coolant thru



## Specifications - Inch

CATALOG NUMBER	STK	DIMENSIONS					
		D	l1	L	d	MD	D2
MGN-M6-0.5-S050	•	.452	.500	2.50	.500	M6	.118
MGN-M6-1.0-S050	•	.452	1.00	3.15	.500	M6	.118
MGN-M6-2.0-S050	•	.452	2.00	3.93	.500	M6	.118
MGN-M8-0.5-S062	•	.591	.500	3.50	.625	M8	.157
MGN-M8-1.0-S062	•	.591	1.00	4.00	.625	M8	.157
MGN-M8-2.0-S062	•	.591	2.00	5.00	.625	M8	.157
MGN-M10-0.5-S075	•	.728	.500	3.50	.750	M10	.157
MGN-M10-1.0-S075	•	.728	1.00	4.00	.750	M10	.157
MGN-M10-2.0-S075	•	.728	2.00	5.00	.750	M10	.157
MGN-M12-0.5-S100	•	.945	.500	3.50	1.00	M12	.236
MGN-M12-1.0-S100	•	.945	1.00	4.00	1.00	M12	.236
MGN-M12-2.0-S100	•	.945	2.00	5.00	1.00	M12	.236
MGN-M12-3.0-S100	•	.945	3.00	6.00	1.00	M12	.236
MGN-M16-0.5-S125	•	1.14	.500	3.50	1.25	M16	.315
MGN-M16-1.0-S125	•	1.14	1.00	4.00	1.25	M16	.315
MGN-M16-2.0-S125	•	1.14	2.00	5.00	1.25	M16	.315
MGN-M16-3.0-S125	•	1.14	3.00	6.00	1.25	M16	.315

## Specifications - Metric

CATALOG NUMBER	STK	DIMENSIONS					
		D	l1	L	d	MD	D2
MGN-M8-17-S16	•	15.5	17	97	16	M8	4
MGN-M10-30-S20	•	19	30	100	20	M10	4
MGN-M12-35-S25	•	24	35	105	25	M12	4
MGN-M12-85-S25	•	24	85	165	25	M12	4
MGN-M16-37-S32	•	29	37	107	32	M16	6
MGN-M16-77-S32	•	29	77	157	32	M16	6

CATALOG NUMBER	DESCRIPTION	PAGE NUMBER
<b>A</b>		
A-15T	Wrench	A-27, A-46, A-47, A-49, A-50, A-52
A-20	Wrench	A-31, A-35, A-40, A-41, A-47, A-48, A-49, A-50, A-51, A-52
<b>B</b>		
BSW-614H	Screw	A-35
BSW-616H	Screw	A-35
<b>C</b>		
CSW-408H	Screw	A-47, A-49, A-50, A-52
CSW-513H	Screw	A-31, A-40, A-41
<b>D</b>		
DCM-17	Clamp Assembly	A-35, A-46, A-47, A-48, A-49, A-50, A-51, A-52
DCM-18	Clamp Assembly	A-46, A-47, A-49, A-50, A-52
DSW-1840H	Screw	A-2, A-3
DSW-2563H	Screw	A-8, A-9
DSW-306H	Screw	A-46, A-47, A-48, A-52
DSW-4510H	Screw	A-46, A-47, A-48, A-49, A-50, A-51, A-52
DSW-4512H	Screw	A-48, A-49, A-50, A-51
<b>E</b>		
ENMU100412ZER-PH	QM Max GII (Max Master) Insert	A-22
ENMU100412ZER-SL	QM Max GII (Max Master) Insert	A-22
EOHW0602**ZTR	QM Mini Insert for Hardened Steel	A-4
EOMT0602**ZER	QM Mini High Feed Insert	A-4
EOMW060210ZER	QM Mini High Feed Insert for Unfavorable	A-4
EPHW100316ZTR	QM Max Insert for Hardened Steel	A-11
EPMT1003**ZER	QM Max High Feed Insert	A-11
EPMW100312ZER	QM Max High Feed Insert for Unfavorable	A-11
EPMW100312ZTR	QM Max High Feed Insert for Unfavorable	A-11
EXSKS-...	Inch SKS Extreme Face Mill	A-40
EXSKS-...	Metric SKS Extreme Face Mill	A-41
<b>G</b>		
GMX-...	Inch QM Max GII (Max Master) Face Mill	A-21
GMX-...	Metric QM Max GII (Max Master) Face Mill	A-21
GMXS-...	Inch QM Max GII (Max Master) End Mill	A-20
GMXS-...	Metric QM Max GII (Max Master) End Mill	A-20
<b>M</b>		
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MPM-...	Metric QM Mini Modular Head	A-2
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MQX-...	Metric QM Max Modular Heads	A-8
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MSG-...	Metric SKS GII-10 Modular Head	A-26
MSH-...	Inch SKS High Feed Modular Head	A-52
MSH-...	Metric SKS High Feed Modular Head	A-52
MSN-...-S...-C	Inch Modular Head Carbide Holder	A-59
MSN-...-S...-C	Metric Modular Head Carbide Holder	A-60

CATALOG NUMBER	DESCRIPTION	PAGE NUMBER
<b>M</b>		
MSN-...S-S...-C	Metric Modular Head Carbide Holder	A-62
MSN-...T-S...C	Metric Modular Head Carbide Holder	A-60
MXG-...	Inch QM Max GII (Max Master ) Mod. Head	A-22
MXG-...	Metric QM Max GII (Max Master) Mod. Head	A-22
<b>P</b>		
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PME-...	Metric QM Mini End Mill	A-3
<b>Q</b>		
QXP-...	Inch QM Max Face Mill	A-9
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<b>S</b>		
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SPET100415ZPER-SM	SKS GII-10 Chipbreaker, ground IC	A-28
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SPMT100415ZPER-SM	SKS GII-10 Chipbreaker, pressed IC	A-28
SPMT100415ZPTR-PM	SKS GII-10 Chipbreaker, pressed	A-28
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SPMT140520ZPTR-PM	SKS GII-14 Chipbreaker, pressed	A-32
SPNW100415ZTR	SKS GII-10 Flat Top Insert	A-28
SPNW140515ZTR	SKS GII-14 Flat Top Insert	A-32
<b>T</b>		
T-06	Wrench	A-2, A-3
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T-08SD	Wrench	A-46, A-52
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T-15	Wrench	A-26
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TSW-2556H	Screw	A-8, A-46
TSW-2567H	Screw	A-20, A-21, A-22
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<b>W</b>		
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WDMT10X620ZER	SKS High Feed Insert	A-53
WDMW050316ZER	SKS High Feed Insert	A-53
WDMW050316ZTR	SKS High Feed Insert	A-53
WDMW06T320ZER	SKS High Feed Insert	A-53

CATALOG NUMBER	DESCRIPTION	PAGE NUMBER
<b>W</b>		
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WDMW080520ZER	SKS High Feed Insert	A-53
WDMW080520ZTR	SKS High Feed Insert	A-53
WDMW10X620ZER	SKS High Feed Insert	A-53
WDMW10X620ZTR	SKS High Feed Insert	A-53
WNUMU090720ZER-PM	SKS Extreme Insert	A-42
WOMT04T215ZER	SKS High Feed Insert	A-53
WOMW04T215ZER	SKS High Feed Insert	A-53
<b>Y</b>		
YOHW0602**ZER-12	QM Mini Insert for Finishing Side & Bottom	A-4
YPHW1003**ZER-15	QM Max Insert for Finishing Side & Bottom	A-11
YPHW100308ZER-F	QM Max Insert for Finishing Side & Bottom	A-11
YPHW100308ZTR-F1	QM Max CBN Insert	A-11
YPHW100320ZER-24	QM Max Insert for Finishing Side & Bottom	A-11
<b>Z</b>		
ZOMT0602**ZER	QM Mini Insert for Shoulder Milling	A-4
ZPMT1003**ZER	QM Max Insert for Shoulder Milling	A-11
ZPMT1003**ZER-NL	QM Max Insert for Shoulder Milling	A-11
ZPMT1003**ZER-PL	QM Max Insert for Shoulder Milling	A-11
ZPMT1003**ZER-SL	QM Max Insert for Shoulder Milling	A-11







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