

# PRODUCT NEWS

PN-U-006

TYPE  
SSV

 **DIJET®**

# SIC-EVO

Multi functional indexable cutter.

- Face mill type  $\varnothing$  2.00" ~  $\varnothing$  4.00" ( $\varnothing$  40mm ~  $\varnothing$  125mm)
- Modular type  $\varnothing$  1.00" ~ 1.50" ( $\varnothing$  25mm ~  $\varnothing$  40mm)
- Endmill type  $\varnothing$  1.00" ~ 1.50" ( $\varnothing$  25mm ~  $\varnothing$  50mm)



# SIC-EVO

Indexable End Mill SSV type

# SIC-EVO

Indexable Cutter SSV type

**Multi functional indexable cutter  
“SIC-EVO” achieves  
high efficient and stable shoulder milling.**



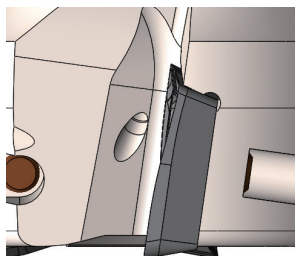
**Feature 1**

Max. depth of cut ( $a_p$ )=15mm is possible.  
SIC-EVO can be used for wide variety of applications  
such as face milling, slotting, pocket milling & side milling.

**Arc geometry on the periphery cutting edge**

Cusp height can be smaller even in case of large  $a_p$ .  
Achieves high efficient & high precision machining for  
vertical walls.

Capable of various milling, applications  
such as ramping and helical machining



High positive geometry with  
low cutting force.

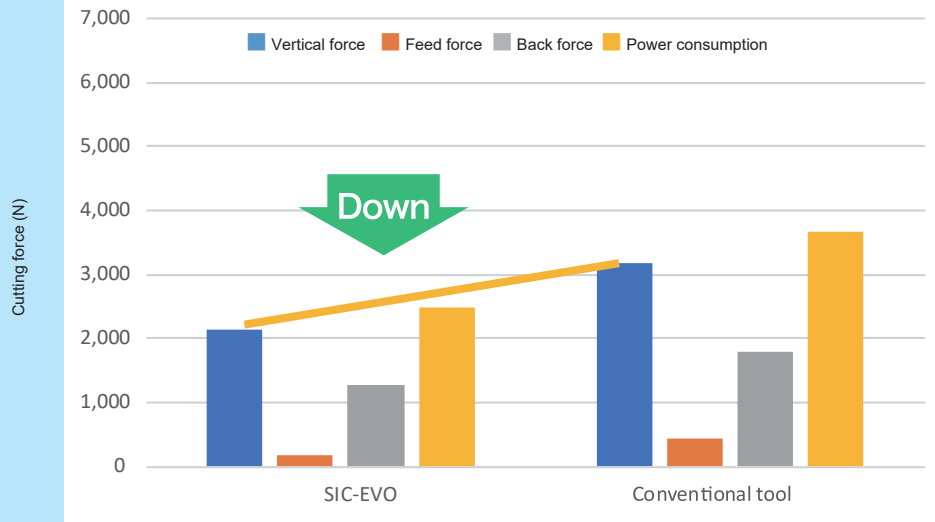
**Feature 2**

Available corner radii: R0.4, R0.8, R1.6, R2.0, and R3.0

## Application

ISO	P				M				K				S				H					
	P01	P10	P20	P30	P40	M01	M10	M20	M30	M40	K01	K10	K20	K30	S01	S10	S20	S30	H01	H10	H20	
Applicable range			JC8118		JC8050			JC8118		JC8050			JC8118								JC8118	

## Cutting force comparison



Material : 1055

• Tool dia. :  $\phi 25$

• Cutting conditions:

$V_c=200\text{m/min}$ ,  $f_z=0.1\text{mm/t}$

$a_p=15\text{mm}$ ,  $a_e=1\text{mm}$

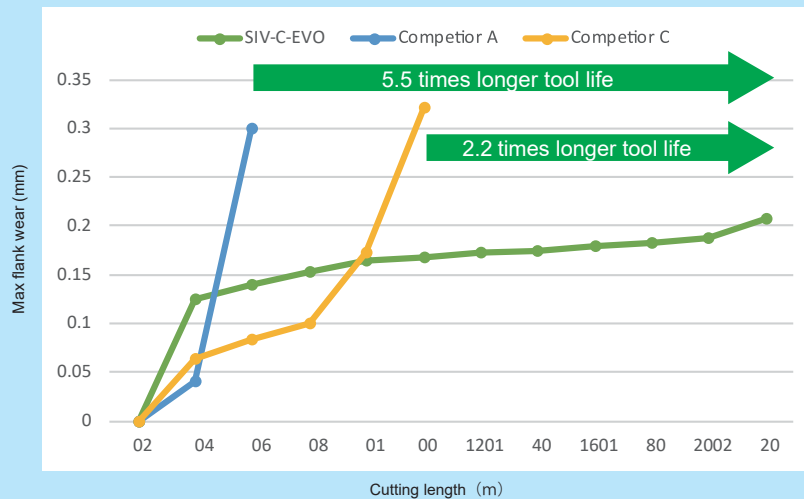
Test by one insert

Down cut,

Air blow (internal)

**Achieved low cutting force**

## Tool life comparison



Material : P20

• Tool dia. :  $\phi 25\text{mm}$

• Cutting conditions:

$V_c=150\text{m/min}$ ,  $f_z=0.3\text{mm/t}$

$a_p=14\text{mm}$ ,  $a_e=1\text{mm}$

Test by one insert

Down cut,

Air blow (internal)

Cutting length	40m	80m	100m	180m
Competitor A				
Competitor C				
DIJET				

**Stable roughing is possible!**



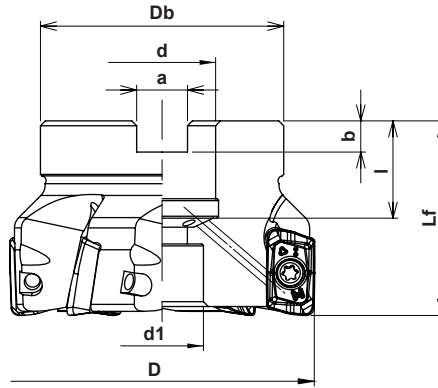
# SIC-EVO

**INCH**

**METRIC**

## FACE MILL SSV type

With coolant hole



### Specifications - Inch

CATALOG NUMBER	STK	DIMENSIONS								Q	INSERT	PARTS Screw & Wrench
		D	Lf	Db	d	d1	a	b	l			
SSV-4200R-075	•	2.0	1.57	1.85	.750	.590	.318	.196	.750	4	ZOMT1605**ZER-PM ZOET160508ZER-PM ZOET160508ZFR-NL	DSW-4075H T-15
SSV-5200R-075	•	2.0	1.57	1.85	.750	.590	.318	.196	.750	5		
SSV-6250R-100	•	2.5	1.75	1.96	1.00	.787	.374	.236	.750	6		
SSV-7300R-100	•	3.0	1.75	2.21	1.00	.787	.374	.236	.750	7		
SSV-8400R-150	•	4.0	2.25	3.78	1.50	1.02	.626	.394	1.00	8		

Note: All cutters supplied without inserts, wrench, & moly.

### Specifications - Metric

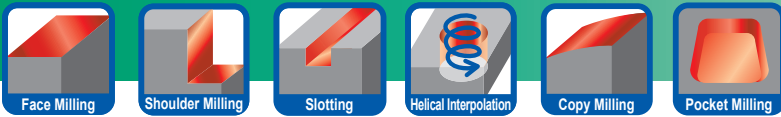
CATALOG NUMBER	STK	DIMENSIONS								Q	ARBOR BOLT	INSERT	PARTS Screw & Wrench
		D	Lf	Db	d	d1	a	b	l				
SSV-4040R-16	⊙	40	40	35	16	15	8.4	5.6	18	4	M8	ZOMT1605**ZER-PM ZOET160508ZER-PM ZOET160508ZFR-NL	DSW-4075H T-15
SSV-5050R-22	⊙	50	40	47	22	16	10.4	6.3	20	5	M10		
SSV-6063R-22	⊙	63	40	50	22	17	10.4	6.3	20	6	M10		
SSV-6063R-27	⊙	63	50	60	27	20	12.4	7	22	6	M12x1.75x30*		
SSV-7080R	⊙	80	50	60	25.4	20	9.5	6	24	7	M12x1.75x30*		
SSV-7080R-27	⊙	80	50	60	27	20	12.4	7	22	7	M12x1.75x30*		
SSV-8100R	⊙	100	63	85	31.75	26	12.7	8	32	8	M16x2x40*		
SSV-8100R-32	⊙	100	50	85	32	26	14.4	8	25	8	M16x2x30*		
SSV-8125R	⊙	125	70	100	38.1	32	15.9	10	38	8	M20x2.5x40*		
SSV-8125R-40	⊙	125	63	100	40	32	16.4	9	32	8	M20x2.5x40*		

⊙ - delivery may be longer

Note: All cutters supplied without inserts, wrench, & moly.

NOTE: Arbor bolt included on cutters marked with \* under arbor bolt column. All other cutters use bolt supplied with arbor.





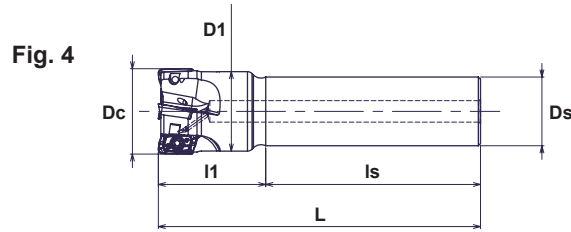
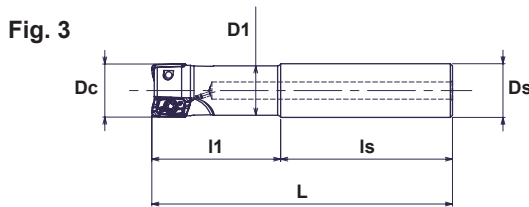
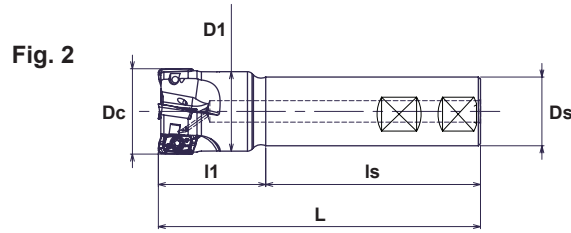
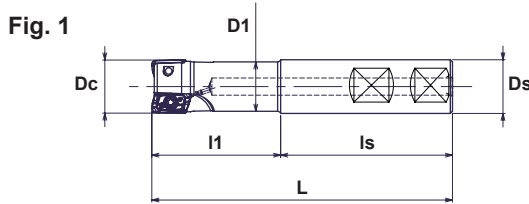
**INCH**

**METRIC**

# SIC-EVO

## END MILL SSV type

With coolant hole



### Specifications - Inch

CATALOG NUMBER	STK	DIMENSIONS						FIG.	Q	INSERT	PARTS
		D	l1	ls	L	D1	Ds				Screw & Wrench
SSV-2100-2.0-S100NP	•	1.00	2.00	5.00	7.00	.905	1.00	1	2	ZOMT1605**ZER-PM ZOET160508ZER-PM ZOET160508ZFR-NL	DSW-4075H T-15
SSV-2100-3.0-S100NP	•	1.00	3.00	5.00	8.00	.905	1.00	1	2		
SSV-3125-3.0-S125NP	•	1.25	3.00	2.50	5.50	1.14	1.25	1	3		
SSV-3125-4.75-S125NP	•	1.25	4.75	3.25	8.00	1.14	1.25	1	3		
SSV-4150-3.0-S125NP	•	1.50	3.00	2.50	5.50	1.37	1.25	2	4		
SSV-4150-4.75-S125NP	•	1.50	4.75	3.25	8.00	1.37	1.25	2	4		

Note: All cutters supplied without inserts, wrench, & moly.

### Specifications - Metric

CATALOG NUMBER	STK	DIMENSIONS						FIG.	Q	INSERT	PARTS
		D	l1	ls	L	D1	Ds				Screw & Wrench
SSV-2025-60-S25	⊙	25	60	80	140	23	25	3	2	ZOMT1605**ZER-PM ZOET160508ZER-PM ZOET160508ZFR-NL	DSW-4075H T-15
SSV-2025-100-S25	⊙	25	100	80	180	23	25	3	2		
SSV-3030-70-S32	⊙	30	70	80	150	28	32	3	3		
SSV-3030-120-S32	⊙	30	120	80	200	28	32	3	3		
SSV-3032-70-S32	⊙	32	70	80	150	29	32	3	3		
SSV-3032-120-S32	⊙	32	120	80	200	29	32	3	3		
SSV-4040-50-S32	⊙	40	50	100	150	37	32	4	4		
SSV-4040-50L-S32	⊙	40	50	150	200	37	32	4	4		
SSV-5050-40-S32	⊙	50	40	110	150	47	32	4	5		

⊙ - delivery may be longer

Note: All cutters supplied without inserts, wrench, & moly.



# SIC-EVO

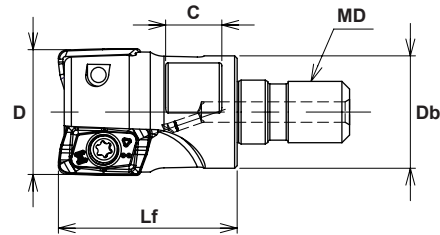
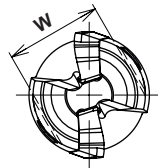
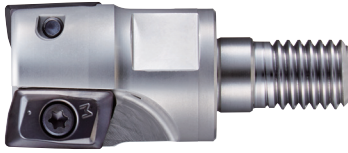
**INCH**

**METRIC**

## MODULAR HEADS

### SSV type

With coolant hole



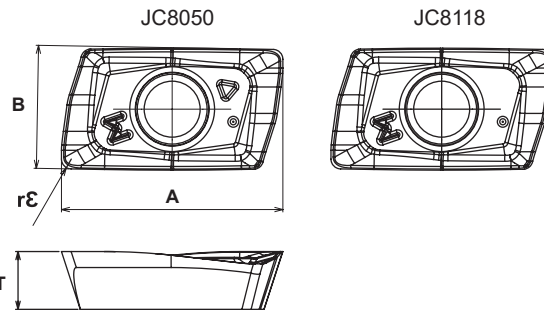
## Specifications

	CATALOG NUMBER	STK	DIMENSIONS						Q	INSERT	PARTS Screw & Wrench
			D	Lf	Db	MD	C	W			
INCH	SSV-2100-M12	•	1.00	1.38	0.95	M12	11	19	2	ZOMT1605**ZER-PM ZOET160508ZER-PM ZOET160508ZFR-NL	DSW-4075H T-15
	SSV-3125-M16	•	1.25	1.69	1.10	M16	12	22	3		
	SSV-4150-M16	•	1.50	1.69	1.10	M16	12	22	4		
METRIC	SSV-2025-M12	⊙	25	35	22	M12	11	19	2		
	SSV-2028-M12	⊙	28	35	22	M12	11	19	2		
	SSV-3030-M16	⊙	30	43	29	M16	12	22	3		
	SSV-3032-M16	⊙	32	43	29	M16	12	22	3		
	SSV-3035-M16	⊙	35	43	29	M16	12	22	3		
	SSV-4040-M16	⊙	40	43	29	M16	12	22	4		

⊙ - delivery may be longer

Note: All cutters supplied without inserts, wrench, & moly.

## INSERTS



CATALOG NUMBER	TOLERANCE	DIMENSIONS				PVD COATED		UNCOATED
		A	B	T	rE	JC8050	JC8118	FC18
ZOMT160504ZER-PM	M	.709	.394	.185	.015	★	★	
ZOMT160508ZER-PM		.709	.394	.185	.031	•	•	
ZOMT160516ZER-PM		.709	.394	.185	.062	•	•	
ZOMT160520ZER-PM		.709	.394	.185	.078	★	★	
ZOET160530ZER-PM		.709	.394	.185	.118	★	★	
ZOET160508ZER-PM	E	.709	.394	.185	.062	★	★	
ZOET160508ZFR-NL		.709	.394	.185	.062			★

★ Coming soon



**INCH**

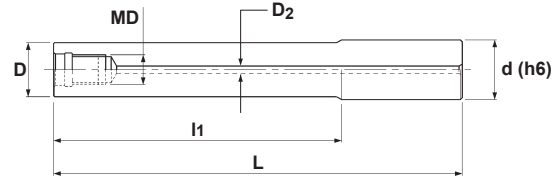
**METRIC**

# SIC-EVO

## MODULAR HEAD HOLDERS

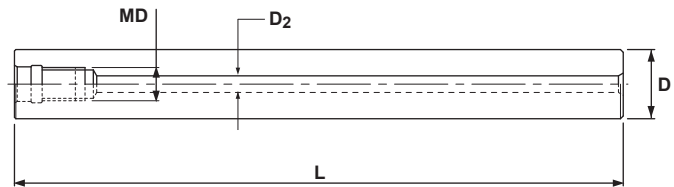
**MSN type**

**Solid Carbide with Coolant Thru**



### Specifications - Inch

CATALOG NUMBER	STK	DIMENSIONS					
		D	l1	L	d	MD	D2
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



### Specifications - Metric

CATALOG NUMBER	STK	DIMENSIONS			
		D	L	MD	D2
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

# SIC-EVO

METRIC

## MODULAR HEAD HOLDERS

MSN type

Solid Carbide with Coolant Thru

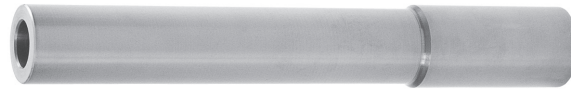


Fig. 1

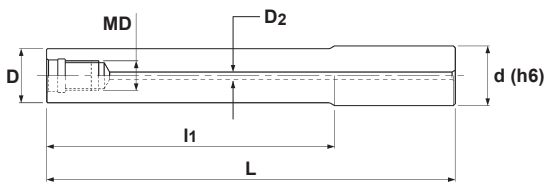
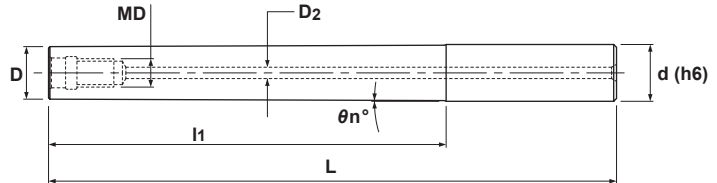


Fig. 2



### Specifications

CATALOG NUMBER	STK	DIMENSIONS							FIG.
		D	I1	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	2°	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	0°38'	M16	8	2
MSN-M16-127-S32C	•	29	127	207	32	-	M16	8	1
MSN-M16-127T-S32C	•	29	127	207	32	0°30'	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°23'	M16	8	2
MSN-M16-195-S32C	•	29	195	260	32	-	M16	8	1
MSN-M16-197T-S32C	•	29	197	277	32	0°23'	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





INCH

METRIC

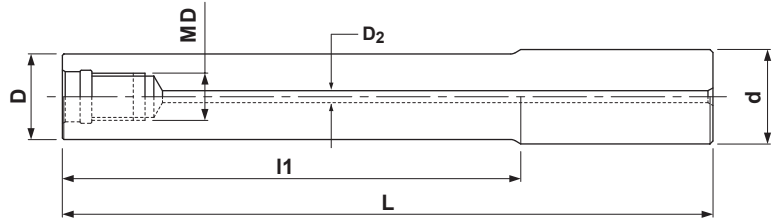
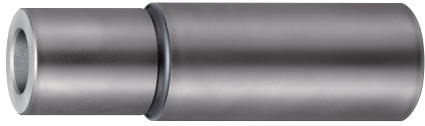
SIC-EVO

### MODULAR HEAD HOLDERS

MGN Type

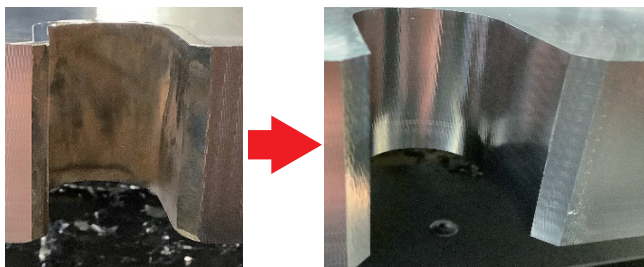
G-Body with Coolant Thru

G-Body



### Specifications

	CATALOG NUMBER	STK	DIMENSIONS					
			D	l1	L	d	MD	D2
INCH	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
METRIC	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



### Result

Both machining noise and surface are good.

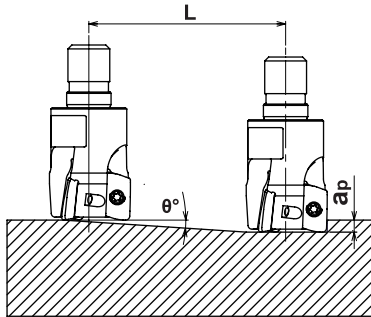
Work	Part Name	Die plate	
	Material	SS400 (JIS)	
	Hardness	--	
Tool	Tool no.	SSV-2025-M16	
	Insert No.	ZOMT160508ZER-PM (JC8118)	
Cutting conditions	Spindle Speed	$n$ 2500 (min <sup>-1</sup> )	
	Cutting Speed	$V_c$ 196 (m/min <sup>-1</sup> )	
	Feed Speed	$V_f$	2000 (mm/min)
		$f_z$	0.4 (mm/t)
	$a_p$ (mm)	3 (mm)	
	$a_e$ (mm)	5 (mm)	
	Coolant	Air blow (External)	
Machine	Double column type MC		



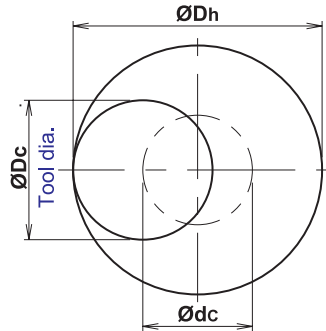
# SIC-EVO

## Recommended Data for Profile Milling

Ramping



Helical Interpolation



- Calculation of tool pass dia.

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

Tool pass dia.    Bore dia.    Tool Dia.

- Depth of cut per one circuit should not exceed max. doc ap.
- Down cutting is recommended, tool pass rotation should be counterclockwise.

- In case of ramping and helical interpolation, apply 80% or less feed speed from standard cutting condition table.
- In case of drilling, apply 50% or less Z axis feed speed from standard cutting condition.
- In case of helical interpolation, recommend wet cutting by coolant through the tool.
- Long consecutive chips may come out in case of drilling, confirm safe operating conditions.

	CATALOG NUMBER	TOOL DIAMETER (I)	EFFECTIVE CUTTING DIAMETER	MAX. DEPTH OF CUT: AP	RAMPING		HELICAL INTERPOLATION		MAX. DRILLING DEPTH
					MAX. RAMP ANGLE	TOTAL CUTTING LENGTH AT MAX AP: L	MIN. BORE DIAMETER: Dh min	MAX. BORE DIAMETER: Dh max	
INCH	SSV-2100-**	1.00"	.988"-2xR	.060"	6.2°	.552"	1.26"	1.968"-2xR	.055"
	SSV-3125-**	1.25"	1.238"-2xR	.060"	4.4°	.780"	1.76"	2.468"-2xR	.055"
	SSV-4150-**	1.50"	1.488"-2xR	.060"	3.8°	.903"	2.26"	2.968"-2xR	.055"
	SSV-4200R-075	2.00"	1.988"-2xR	.060"	2.4°	1.432"	3.26"	3.968"-2xR	.055"
	SSV-5200R-075	2.00"	1.988"-2xR	.060"	2.4°	1.432"	3.26"	3.968"-2xR	.055"
	SSV-6250R-100	2.50"	2.488"-2xR	.060"	1.7°	2.022"	4.26"	4.968"-2xR	.055"
	SSV-7300R-100	3.00"	2.988"-2xR	.060"	1.3°	2.644"	5.26"	5.968"-2xR	.055"
	SSV-8400R-150	4.00"	3.988"-2xR	.060"	0.85°	4.044"	7.26"	7.968"-2xR	.055"
METRIC	SSV-2025-**	25	24.7-2xR	1.5	6.2°	13.8	31	49.2-2xR	1.4
	SSV-2028-M12	28	27.7-2xR	1.5	5.3°	16.2	37	55.2-2xR	1.4
	SSV-3030-**	30	29.7-2xR	1.5	4.8°	17.9	41	59.2-2xR	1.4
	SSV-3032-**	32	31.7-2xR	1.5	4.4°	19.5	45	63.2-2xR	1.4
	SSV-3035-M16	35	34.7-2xR	1.5	4.3°	19.9	51	69.2-2xR	1.4
	SSV-4040-**	40	39.7-2xR	1.5	3.6°	23.8	61	79.2-2xR	1.4
	SSV-5050R-**	50	49.7-2xR	1.5	2.4°	35.8	81	99.2-2xR	1.4
	SSV-6063R-**	63	62.7-2xR	1.5	1.7°	50.5	107	125.2-2xR	1.4
	SSV-7080R-**	80	79.7-2xR	1.5	1.2°	71.6	141	159.2-2xR	1.4
	SSV-8100R-**	100	99.7-2xR	1.5	0.9°	95.5	181	199.2-2xR	1.4
	SSV-8125R-**	125	124.7-2xR	1.5	0.65°	132.2	231	249.2-2xR	1.4



# PROPER MOUNTING OF MODULAR HEADS

## ■ Cleaning

Remove dirt and chips with air from the connecting thread and face of modular head and MSN/MGN shank holder.

## ■ Initial Tightening

Tighten by hand until the head and the shank holder faces touch.

## ■ Final Tightening

Tighten slowly with torque control spanner wrench or DIJET DS type spanner wrench and confirm that there is no gap.

Attention: Final tightening without initial tightening cause connecting thread damage.



Thread	Tightening torque	Spanner size
M6	8N · m	8 ◆
M8	16N · m	10, 12 ◆
M10	16N · m	14, 15
M12	20N · m	17, 19
M16	25N · m	22, 26

### Modular heads are supplied without spanner wrench.

In case of choosing torque control spanner wrench, confirm that the wrench size is matched to the dimensions W & C of each modular head. (There are some cases that modifying the thickness of spanner wrench is necessary)

◆ = DIJET stocks DS-8 and DS-12 type spanner wrenches.

### Note:

1. Only use torque control spanner wrench or DIJET DS type spanner wrench.
2. Only apply gentle pressure on wrench.
3. Please confirm there is no gap between MSN/MGN shank holder and modular head

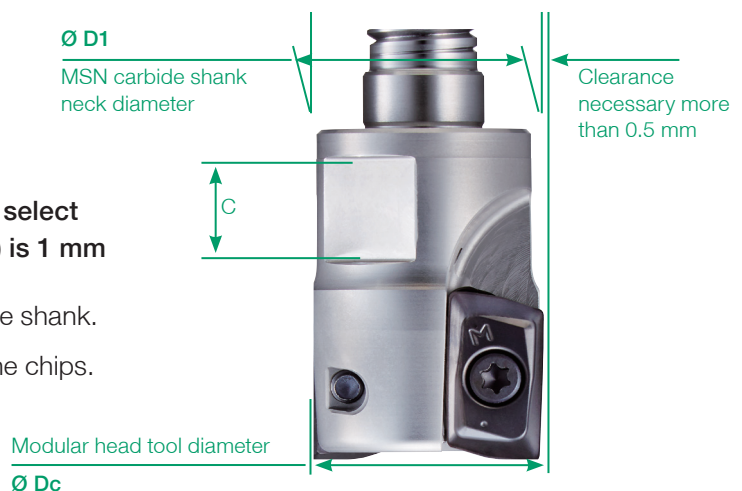
## SELECTION OF MSN CARBIDE SHANK HOLDER

$$\varnothing D_c - \varnothing D_1 \geq 1\text{mm}$$

When using modular head over  $\varnothing 16\text{mm}$ , please select MSN carbide shank which the diameter ( $\varnothing D_1$ ) is 1 mm or smaller than modular head ( $\varnothing D_c$ ).

Wrong selection can cause damage to the carbide shank.

Coolant or air blow is recommended to remove the chips.



### Caution for mounting in shrink fit holder.

When you use a carbide shank and a modular head on a shrink fit holder, please shrink fit only the carbide shank without mounting the modular head. Mount the modular head on the shank after shrink fit operation is complete.

In case of shrink fit MSN shank + modular head together, it will be difficult to loosen due to heat dissipation.

## Recommended Cutting Data

Material	Grade	SFM	Parameters	Face Milling		Side Milling	
				Low HP	High HP	Low HP	High HP
Gray Cast Iron	JC8118 JC8050	830	IPT	.010"	.014"	.010"	.014"
			DOC	.140"	.216"	.400"	.590"
			WOC	70%	70%	up to 6% of D	
Nodular Cast Iron	JC8118 JC8050	500	IPT	.010"	.014"	.010"	.014"
			DOC	.080"	.160"	.400"	.590"
			WOC	70%	70%	up to 6% of D	
Carbon Steel	JC8118 JC8050	660	IPT	.010"	.014"	.010"	.014"
			DOC	.080"	.160"	.400"	.590"
			WOC	70%	70%	up to 6% of D	
Low Alloy Steel	JC8118 JC8050	600	IPT	.010"	.014"	.010"	.014"
			DOC	.080"	.160"	.400"	.590"
			WOC	60%	60%	up to 6% of D	
Mold Steel	JC8118 JC8050	500	IPT	.010"	.014"	.010"	.014"
			DOC	.080"	.160"	.400"	.590"
			WOC	60%	60%	up to 6% of D	
Tool & Die Steel	JC8118	600	IPT	.008"	.012"	.008"	.012"
			DOC	.080"	.120"	.400"	.590"
			WOC	60%	60%	up to 5% of D	
Hardened Die Steel (40-50HRC)	JC8118	330	IPT	.006"	.010"	.006"	.010"
			DOC	.040"	.100"	.400"	.590"
			WOC	60%	60%	up to 3% of D	
Stainless Steel (Austenitic)	JC8050	400	IPT	.007"	.011"	.007"	.011"
			DOC	.080"	.160"	.400"	.590"
			WOC	60%	60%	up to 6% of D	
Stainless Steel (Martensitic)	JC8118	600	IPT	.008"	.012"	.010"	.014"
			DOC	.080"	.160"	.400"	.590"
			WOC	60%	60%	up to 6% of D	
Aluminum	FC18	990	IPT	.012"	.016"	.012"	.016"
			DOC	.080"	.160"	.400"	.590"
			WOC	70%	70%	up to 8% of D	

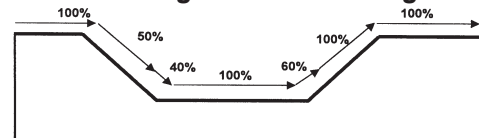
- NOTE:** 1. Above parameters should be adjusted according to the machine rigidity & work rigidity.  
 2. If chatter occurs, recommend to reduce DOC or spindle speed and maintain IPT.  
 3. If machine does not have enough power, recommend reducing DOC or spindle speed & feed.  
 4. Use air blow.  
 5. In case of slotting, reduce feed speed to 50%

### 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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