



Shouldering

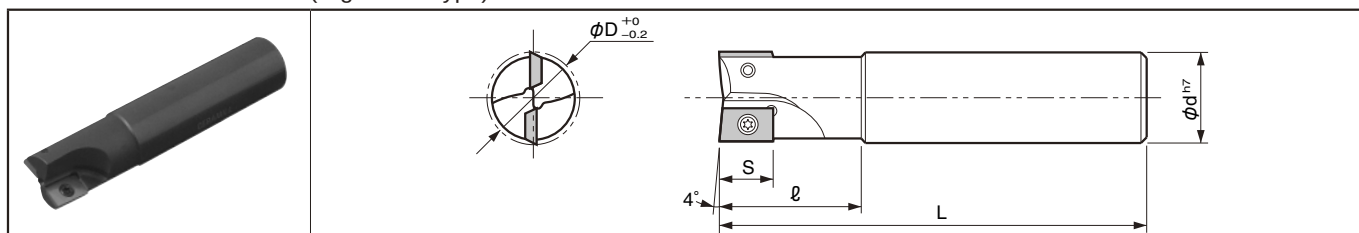


Slotting



Facing

DMC-H Endmill (High Rake type)



Toolholder Dimensions

Description	Std.	No. of Insert	Dimension (mm)						Rake Angle (°)		Drawing	Spare Parts		
			øD	ød	L	ℓ	S		A.R.	R.R.		Clamp Screw	Wrench	
														
DMC 316H	●	1	16	16	90	30	14.0		+5°	-3.5°	-	SB-4060TR	FT-15	
320H	●		20	20	110				+6°	-2°				
325H	●	2	25	25	120	+8°			-2°					
332H	●		32	32	130	+8°			0°					
340H	●		40		150	+8°			0°					

Applicable Inserts

Toolholder	Applicable Inserts M18, M19			Applicable Inserts M21	
DMC 316H 320H 325H 332H 340H	NDMM 150304ER-SP 150308ER-SP		NDCT 150308TRX	NDCW 150308TRX 150308FRX	NDCW 150302FRX 150302FRX-NE (PCD)

DMC-H type Recommended Cutting Conditions

Workpiece Material	fz (mm/t)	Recommended Insert Grade (Cutting Speed Vc: m/min)												Max. ap (mm)		
		Cermet		PVD Coated Carbide						Carbide		PCD				
		TN100M	TC60	PR630	PR730	PR830			PR660	PR905	PW30	KW10	KPD230 (KPD001)	KPD010	Cutting Dia. (øD)	Slotting (ap)
Stainless Steel	~0.15	☆ 120~200	☆ 120~200	☆ 100~200	★ 120~200									~ø20	3	6×2
Carbon Steel	~0.2	★ 120~200	☆ 120~200	☆ 100~200	★ 120~200									~ø20	4	8×4
Alloy Steel	~0.2	★ 100~180	☆ 100~180	☆ 100~180	★ 100~180									~ø20	4	8×4
Mold Steel	~0.15	★ 100~180	☆ 100~180	☆ 80~150	★ 80~150									~ø20	3	5×2
Cast Iron	~0.2										★ 80~150			~ø20	4	8×4
Non-ferrous Metals	~0.2										★ 100~300	★ 300~500	☆ 300~500	~ø20	4	8×4
														~ø25~	6	14×6

• Above inserts are also applicable to DMC 000 SX type, but the conventional NDCW1503 00 TR type insert is not applicable for this endmill.

★ : 1st Recommendation ☆ : 2nd Recommendation

Insert	Description	No interference of relief surface	Less relief (ap must be under 5mm.)	Insert	Description	No interference of relief surface	No interference of relief surface
DMC-H	NDCT ... TRX NDCW ... (T / F) RX NDCT ... (T / F) R			DMC-SX	NDCT ... TRX NDCW ... (T / F) RX NDCT ... (T / F) R		
		A direction	A direction			B direction	B direction

● : Std. Item ○ : Check Availability R : Std. Item (R-hand Only) L : Std. Item (L-hand Only)