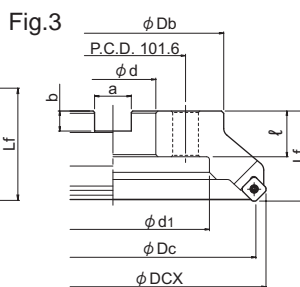
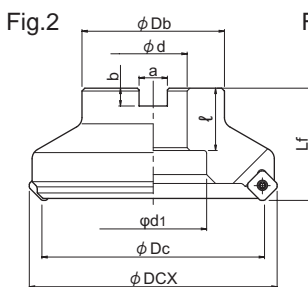
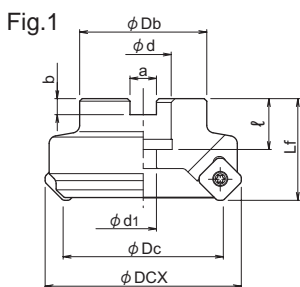
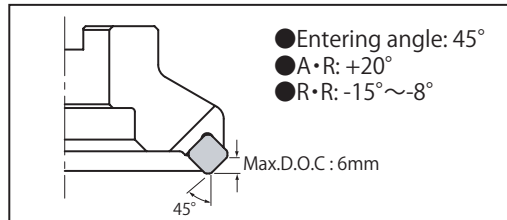


DIJET Mill 45 SSE45Type



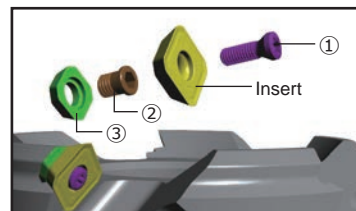
Bore	Cat. No.	Stock	No. of flutes	Dimensions(mm)								Weight kg	Applicable inserts	Fig.	
				ϕDc	ϕDCX	Lf	ϕDb	ϕd	ϕd1	a	b				ℓ
Metric Bore	SSE45-4050R-22	●	4	50	63	40	45	22	10.4	10.4	6.3	20	SE•T13T3AG•N••• XEHW13T3AGSN-W	1	
	SSE45-5063R-22	●	5	63	76.1		50							0.6	
	SSE45-6080R-27	●	6	80	93.1	50	56	27	13.5	12.4	7	22		1.1	
	SSE45-7100R-32	●	7	100	113.3		70							32	17.5
	SSE45-8125R-40	●	8	125	138.3	63	80	40	60	16.4	9	32		2.6	2
	SSE45-5050R-22	●	5	50	63	40	45	22	10.4	10.4	6.3	20		0.4	
	SSE45-6063R-22	●	6	63	76.1		50							0.6	
	SSE45-8080R-27	●	8	80	93.1	50	56	27	13.5	12.4	7	22		1.1	
	SSE45-10100R-32	●	10	100	113.3		70							32	17.5
	SSE45-12125R-40	●	12	125	138.3	63	80	40	60	16.4	9	32		2.6	2

Note) All cutters are supplied without inserts or wrenches.

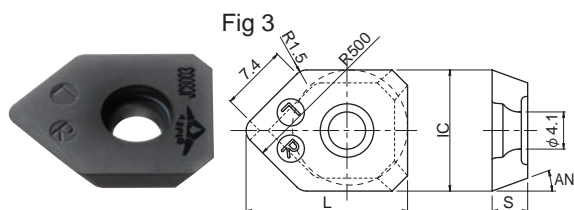
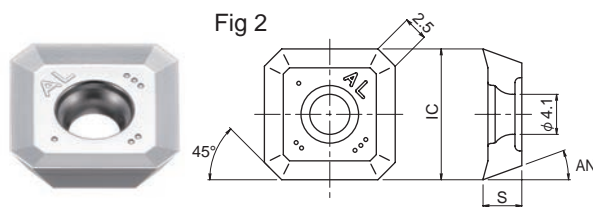
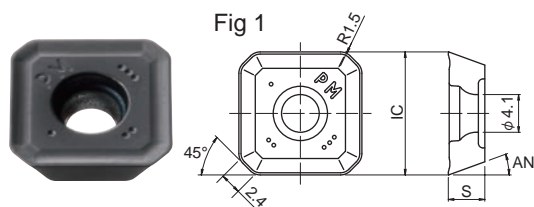
Clamp screw	Recommended torque (N•m)
TSW-3512H	3.0
SSW-535	6.5

■ PARTS

Clamp screw	Shim screw	Shim	Wrench	Wrench for Shim
①	②	③		
TSW-3512H	SSW-535	SM-SE13	A-15T	LW-035



DIJET Mill 45

SSE45_{Type}

■ ATTENTION TO USING WIPER INSERT



- In case of feed per rev $fz \geq 2$ mm/rev and surface roughness is required, we recommend to use wiper insert.
- Wiper insert for SSE45 has single cutting edge.
- Please put insert as "R" mark is shown to the front.

■ INSERTS

Cat. No.	Tolerance	PVD coated					Uncoated	Dimensions(mm)				Fig.
		DH103	DH111	JC5040	JC8015	JC8050		FZ05	IC	L	S	
SEMT1 3T3AGSN-PM	M			●	●	●		13.4	—	3.97	20°	1
SEMT13T3AGSN-KM			●									
SEGT13T3AGFN-AL	G						●	17.8				2
XEHW13T3AGSN-W	H	●										

Note) 10 inserts per case.

■ RECOMMENDED CUTTING CONDITIONS

ISO	Work Materials	Cutting speed Vc (m/min)	Feed per tooth fz (mm/t)	Insert Grades	Insert No.
P	Low carbon steel (SS400, S10C) ≤ 180HB	250 (200-300)	0.2 (0.1-0.3)	JC5040 (JC8050)	SEMT13T3AGSN-PM (SEMT13T3AGSN-PM)
	Carbon steel (S50C, S55C) ≤ 250HB	220 (170-250)	0.2 (0.1-0.3)	JC5040 (JC8050)	SEMT13T3AGSN-PM (SEMT13T3AGSN-PM)
	Tool & Die steel (SKD61, SKD11) ≤ 255HB	120 (100-150)	0.2 (0.1-0.3)	JC5040	SEMT13T3AGSN-PM
M	Stainless steel (SUS304) ≤ 250HB	220 (170-250)	0.2 (0.1-0.3)	JC8050 (JC8015)	SEMT13T3AGSN-PM (SEMT13T3AGSN-PM)
K	Gray cast iron (FC300) ≤ 300HB	200 (150-250)	0.2 (0.1-0.3)	DH111 (JC8015)	SEMT13T3AGSN-KM (SEMT13T3AGSN-PM)
	Nodular cast iron (FCD400) ≤ 300HB	150 (120-180)	0.2 (0.1-0.3)	JC8015	SEMT13T3AGSN-PM
H	Hardened steel 40-55HRC	80 (60-100)	0.15 (0.1-0.2)	JC8015	SEMT13T3AGSN-PM
N	Aluminium alloy (A5052) 50-110HB	300-	0.2 (0.1-0.3)	FZ05	SEGT13T3AGFN-AL

Note) In case of unfavourable conditions, insert grade JC8050 is recommended.

DIJET Mill 90

SSD90Type

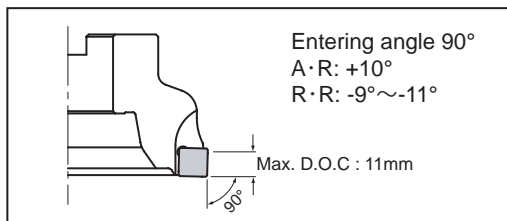


Fig 1

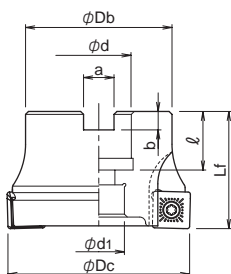
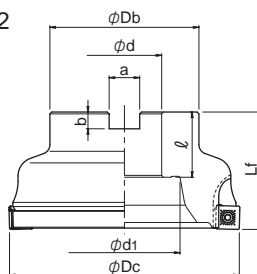


Fig 2



■BODY

Bore	Cat. No.	Stock	No. of flutes	Dimensions(mm)								Weight kg	Applicable inserts	Fig.
				ϕDc	Lf	ϕDb	ϕd	$\phi d1$	a	b	l			
Metric Bore	SSD90-4050R-22	●	4	50	40	41	22	17	10.4	6.3	20	0.3	SD**1204PD*R	1
	SSD90-5063R-22	●	5	63		50						0.5		
	SSD90-6080R-27	●	6	80	50	60	27	37	12.4	7	22	0.9		
	SSD90-8100R-32	●	8	100		70	32	43	14.4	8	32	1.5		
	SSD90-10125R-40	●	10	125		63	80	40	57	16.4	9	35		

Note) All cutters are supplied without inserts or wrenches.

Clamp screw	Recommended torque (N·m)
TSW-3512H	3.0
SSW-535	6.5

■PARTS

Clamp screw	Shim screw	Shim	Wrench	Wrench for shim
①	②	③		
TSW-3512H	SSW-535	SM-SD12	A-15T	LW-035

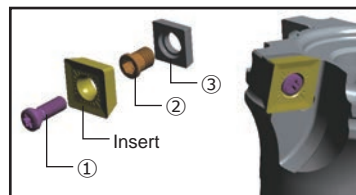
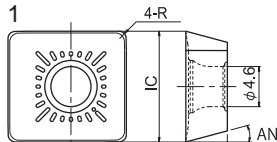
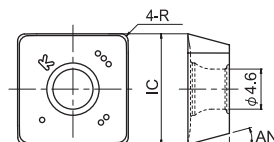




Fig 1



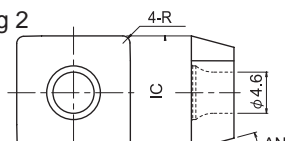
SDMT1204PDER
(With Chipbreaker)
(Grade: JC8050, JC5040)



SDMT1204PDER
(With Chipbreaker)
(Grade: JC8015)



Fig 2



SDHW1204PDTR
(Without Chipbreaker)
(Grade: JC8015)

■ INSERTS

Cat. No.	Tolerance	PVD coated				Dimensions mm			Fig.
		DH111	JC5040	JC8015	JC8050	IC	S	AN	
SDMT1204PDER	M	●	●	●	●	12.7	4.76	15	1
SDHW1204PDTR	H			●					2

Note) 10 inserts per case.

■ RECOMMENDED CUTTING CONDITIONS

ISO	Work Materials	Cutting speed Vc (m/min)	Feed per tooth fz (mm/t)	Insert Grades	Insert No.
P	Low carbon steel (SS400, S10C) ≤ 180HB	250 (200-300)	0.2 (0.1-0.3)	JC5040 (JC8050)	SDMT1204PDER (SDMT1204PDER)
	Carbon steel (S50C, S55C) ≤ 250HB	220 (170-250)	0.2 (0.1-0.3)	JC5040 (JC8050)	SDMT1204PDER (SDMT1204PDER)
	Tool & Die steel (SKD61, SKD11) ≤ 255HB	120 (100-150)	0.15 (0.1-0.25)	JC5040	SDMT1204PDER
M	Stainless steel (SUS304) ≤ 250HB	220 (170-250)	0.15 (0.1-0.25)	JC8050 (JC8015)	SDMT1204PDER (SDMT1204PDER) (SDHW1204PDTR)
K	Gray cast iron (FC300) ≤ 300HB	200 (150-250)	0.2 (0.1-0.3)	DH111 (JC8015)	SDMT1204PDER SDHW1204PDTR
	Nodular cast iron (FCD400) ≤ 300HB	150 (120-180)	0.2 (0.1-0.3)	JC8015	SDMT1204PDER SDHW1204PDTR
H	Hardened steel 40-55HRC	80 (60-100)	0.1 (0.05-0.15)	JC8015	SDMT1204PDER SDHW1204PDTR

Note) In case of unfavourable conditions, insert grade JC8050 is recommended.