



High feed SD Milling Insert

Iron chip harvester

$A_{pmax}=2.0mm$ $f_{max}=2.0mm$

Passionate pursuit of perfection



Insert Type

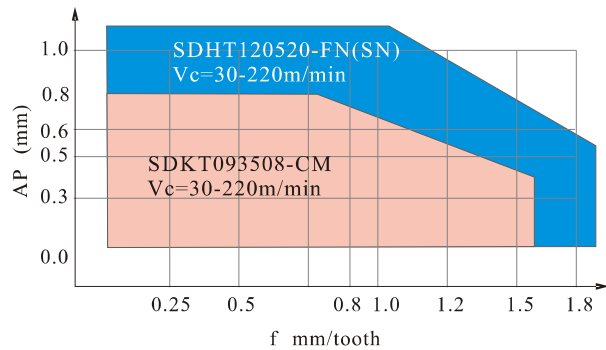
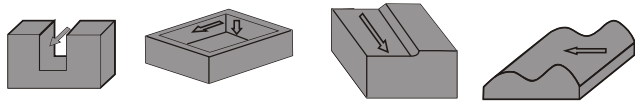
SDKT093508-CM

SDHT120520-FN,
SDHT120520-SN,
SDMT120520-SN





SDK(H,M)T high feed milling insert



Feature:

Strong edge, perfect abrasive resistance, high stability and efficiency.
Performance exceed famous brand.

Application:

Stainless steel, Heat resisting alloy, Die steel, Nodular cast iron.

		PVD Coating			parameters	
		CP2630TN CP2640TN	CP2430	CP6130MS	Vc (mm/min)	
Material group	P Steel	✳	✳		120-160-250	
	P P20,718,SKD11,S136H	✳	✳		100-130-160	
	P HRC40-63 Steel			●	50-80-120	
	M Stainless steel	✳	✳	●	60-110-150	
	K Cast iron	✳	✳	●	150-180-220	
	S Titanium alloy	✳	✳		40-60-80	
	S Superalloy	✳	✳	●	40-60-100	
Type	purpose				Ap(mm)	f (mm/t)
SDKT093508-CM	Ti-alloy, St-steel, Superalloy, steel	✳	✳	●	0.3-0.8	0.5-1.5
SDHT120520-FN		✳	✳	●	0.5-1.2	0.8-1.5
SDHT120520-SN	Cast iron, Steel	✳	✳	●	0.5-1.2	0.8-2.0
NEW SDMT120520-SN		✳	✳		0.5-1.2	0.8-2.0

SDKT093508 programming R angle is **R=2.0mm**; sharp cutting, the best choice for alloy processing.
SDH(M)T120520 programming R angle is **R=4.0mm**
SDMT120512 and SDMT150512 are installed with HITACHI



SDKT0935 SDHT1205 SDMT1205 SDMT1505

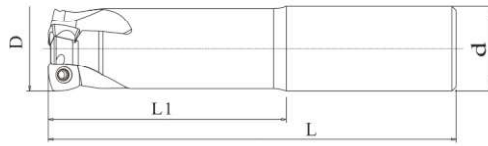


Material examples	Hardness	Grade	V _c m/ min	fz mm/t / Ap mm	
				SDKT093508	SDHT120520
S45C, S50C	~220HB	CP2630TN CP2430	100-250	fz=0. 5-1.5 Ap=0.5-0.8	fz=0. 5-1.8 Ap=0.5-1.0
20CrMoTi, 42CrMo	~200HB	CP2630TN CP2430	100-200	fz=0. 5-1.2 Ap=0.4-0.6	fz=0. 5-1.5 Ap=0.5-1.0
SKD61 (H13), SKD11	350HB	CP2630TN CP2430	100-150	fz=0. 5-0.7 Ap=0.3-0.6	fz=0. 5-1.2 Ap=0.5-1.0
P20, 718, 738	HRC28-32	CP2630TN CP2430	100-180	fz=0. 5-1.2 Ap=0.3-0.5	fz=0. 5-1.2 Ap=0.5-0.8
S136H, NAK80, 4Cr13	HRC30-40	CP2630TN CP2430	100-150	fz=0. 5-0.7 Ap=0.3-0.5	fz=0. 5-1.2 Ap=0.5-1.0
SKD61 (H13), S136H, NAK80	HRC40-50	CP2630TN CP6130MS	80-120	fz=0. 1-0.3 Ap=0.15-0.4	fz=0. 1-0.3 Ap=0.15-0.5
	HRC50-62	CP6130MS	50-80	fz=0. 1-0.2 Ap=0.10-0.4	fz=0. 1-0.2 Ap=0.15-0.5
304, 316	200HB	CP2630TN CP6130MS	100-150	fz=0. 3-0.7 Ap=0.3-0.6	fz=0. 3-0.8 Ap=0.3-0.8
718	HRC38-45	CP2630TN CP6130MS	60-120	fz=0. 3-0.6 Ap=0.3-0.5	fz=0. 3-0.6 Ap=0.3-0.6
Ti-6Al-4V (Tc4)	HRC40	CP6130MS CP2630TN	30-80	fz=0. 3-0.8 Ap=0.3-0.5	fz=0. 3-1.0 Ap=0.3-0.8
FC250, HT250	~200HB	CP2430 CP2630TN	120-220	fz=0.5-1.5 Ap=0.5-1.0	fz=0.5-1.8 Ap=0.5-1.2
FCD400, QT300, 400, 500, 600	~200HB	CP2630TN CP2430	120-200	fz=0.5-1.5 Ap=0.5-0.8	fz=0.5-1.8 Ap=0.5-1.2

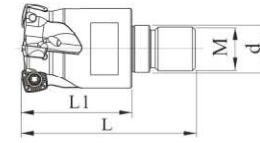
CP2430 Suitable For Dry Or Air-cooled Cutting



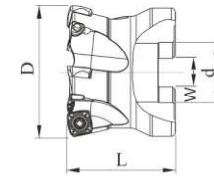
Cutter tool CSDR SD(K,H,M)T



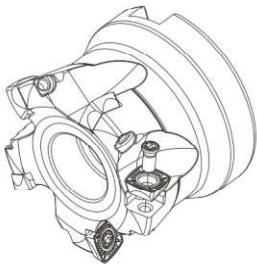
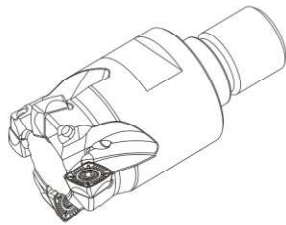
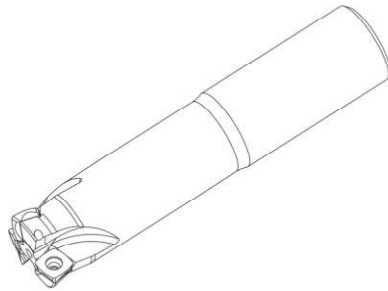
1. End mill (with internal cooling)



2. Screw coupling (with internal cooling)



3. Shell mill (with internal cooling)



Cutter Tool: SKD61 material, processed after heat treatment, good rigidity, strong seismic performance, high precision <0.03mm

Designation	Z	type	mm					MS3070	T10	BR-6	SDKT093508
			D	d	L	L1 W	M				
type 1	CSDR-25X110-SD09-3T-W	3	1	25	25	110	40	MS3070	T10	BR-6	SDKT093508
	CSDR-26X25X120-SD09-3T-W	3	1	26	25	110	-				
	CSDR-32X130-SD09-4T-W	4	1	32	32	130	50				
	CSDR-35X130-SD09-4T-W	4	1	35	32	130	-				
	CSDR-35X200-SD09-4T-W	4	1	35	32	200	-				
type 2	CSDRM-25-SD09-M12-3T-W	3	2	25	12.5	35	22.5	MS3070	T10	BR-6	SDKT093508
	CSDRM-32-SD09-M16-4T-W	4	2	32	17	43	25				
	CSDRM-35-SD09-M16-4T-W	4	2	35	17	43	25				
	CSDRM-40-SD09-M16-5T-W	5	2	40	17	43	25	MS4090	T15	BR-6	SDHT1205 SDMT1205
	CSDRM-35-SD12-M16-3T-W	3	2	35	17	43	25				
	CSDRM-40-SD12-M16-4T-W	4	2	40	17	43	25				
type 3	CSDR-40-SD09-5T-16-W	4	3	40	16	40	10.4	MS3070	T10	BR-6	SDKT093508
	CSDR-50-SD09-6T-22-W	5	3	50	22	40	10.4				
	CSDR-63-SD09-6T-22-W	6	3	63	22	40	10.4				
	CSDR-63-SD09-8T-22-W	8	3	63	22	40	10.4				
	CSDR-80-SD09-8T-27-W	8	3	80	27	40	12.4				
	CSDR-50-SD12-4T-22	4	3	50	22	50	10.4	MS4090	T15	BR-6	SDHT1205 SDMT1205
	CSDR-63-SD12-5T-22	5	3	63	22	50	10.4				
	CSDR-80-SD12-6T-27	6	3	80	27	50	12.4				
	CSDR-100-SD12-6T-32	6	3	100	32	63	14.4				
	CSDR-125-SD12-7T-40	7	3	125	40	63	16.4				

SDKT093508 programming R angle is **R=2.0mm**; SDHT120520 programming R angle is **R=4.0mm**