

PRODUCT NEWS

PN-E-021

SERIES EXPANSION



QM *Quick & Mini* Series

"QM MILL & QM MAX"
New generation high feed mill



QM MILL

Modular Type
 $\varnothing 10 \sim \varnothing 32$

Shank Type
 $\varnothing 10 \sim \varnothing 14$

MPM/PME/MPT type



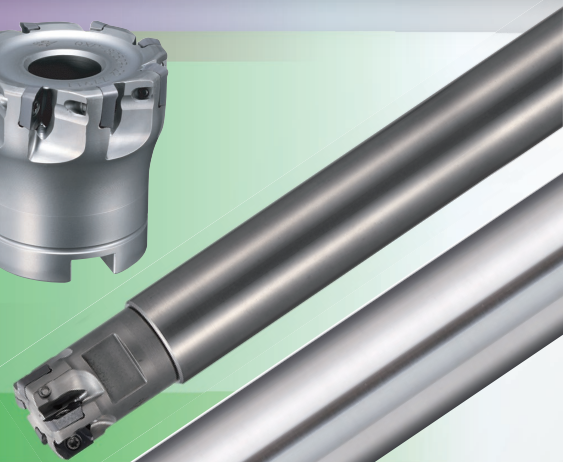
QM MAX

Bore Type
 $\varnothing 40 \sim \varnothing 66$

Modular Type
 $\varnothing 16 \sim \varnothing 42$

Shank Type
 $\varnothing 16 \sim \varnothing 25$

MQX/QXP/QXPS type



High precision

QM MAX

Modular Type
 $\varnothing 16 \sim \varnothing 35$

MQT type



DIJET GmbH

www.dijet.de

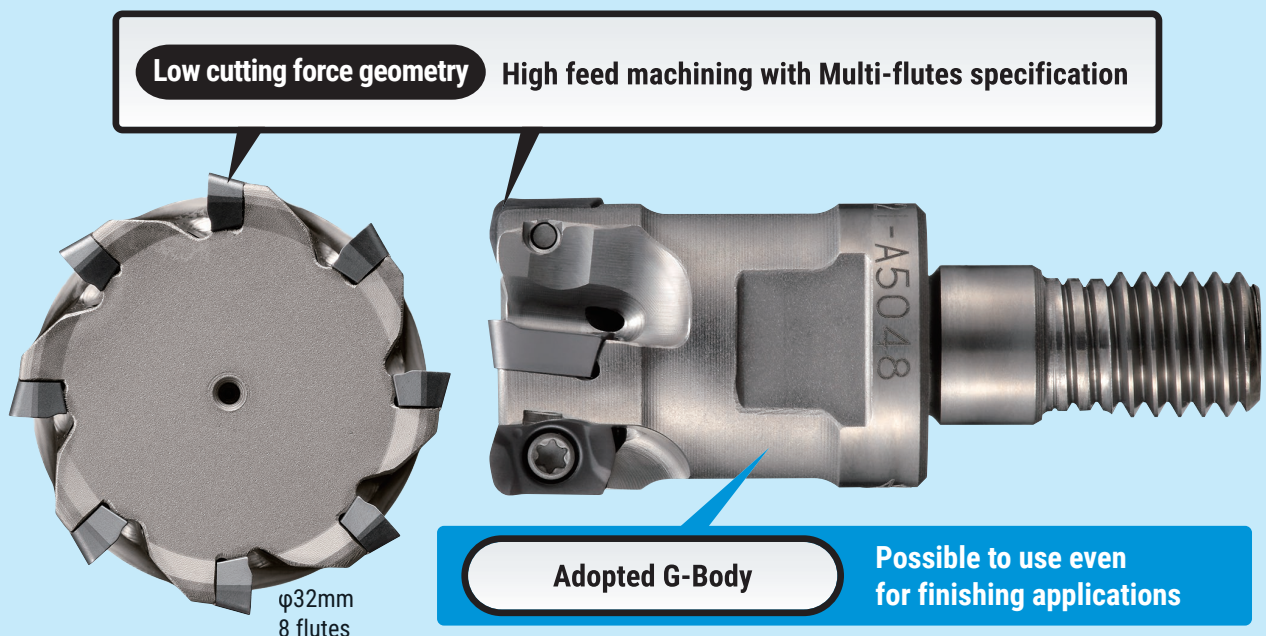
QM Quick & Mini MILL

Low cutting force geometry

Multi - flutes specification

Vibration free

- Unique 3D geometry insert provides stable cutting and less power consumption.
- BT30 Capable of running on low horse power & compact machines.
- High speed and high efficient machining.
- Control vibration with combination of MSN carbide shank holder for longer tool life.



Insert Line-Up

A variety of inserts all fit into the same body.

High feed insert



EOMT0602...ZER (R1.0, 2.0)

High feed insert for unfavorable conditions



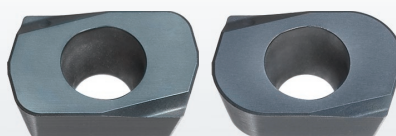
EOMW060210ZER

Shoulder insert



ZOMT0602...ZER-PL (R0.2,0.4,0.8)

For high hardened steel



EOHW0602...ZTR (R1.0, 2.0)

"Mirror Insert" for finishing side & bottom face



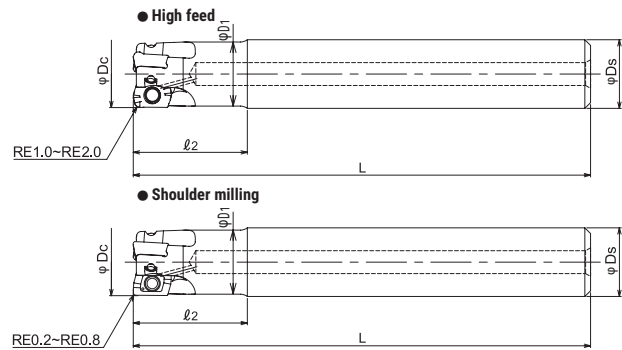
YOHW0602...ZER-12

PME
TYPE

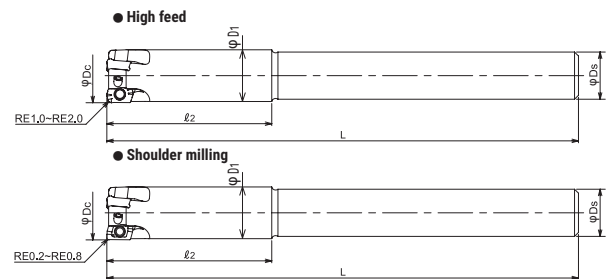
Shank Type



■ PME type (Through coolant hole)



■ PME-LS type (No coolant hole)



Type	Cat.No.	Stock	No. of inserts	Dimensions (mm)					Insert
				φD _C	ℓ ₂	L	φD ₁	φD _S	
Standard	PME2010S10	●	2	10	20	80	9.3	10	EO**0602**Z*R ZOMT0602**ZER YOHWO602**ZER-12
	PME3012S12	●	3	12			11.2	12	
	PME3014S12	●		14			13.15		
Long shank	PME2011S10-LS	●	2	11	33	120	10.3	10	
	PME3013S12-LS	●	3	13	39		12.2	12	
	PME3014S12-LS	●		14	42		13.15		

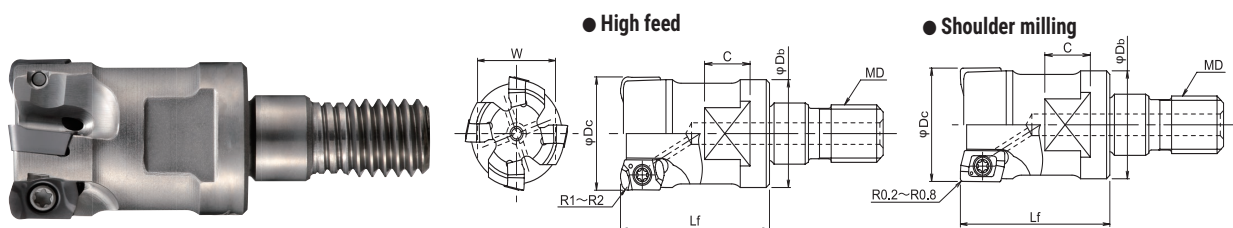
Note) All cutters are supplied without inserts or wrenches.

Screw	Torque(N.m)	Wrench
DSW-1840H	0.4	A-06



MPM
TYPE

Modular Type



Cat.No.	Stock	No. of inserts	Dimensions (mm)						Insert
			φDc	Lf	φDb	MD	C	W	
MPM-2010-M6	●	2	10	18	9.5	M6	6.5	8	EO**0602**Z*R ZOMT0602**ZER YOHW0602**ZER-12
MPM-2011-M6	●		11		9.7	M6			
MPM-3012-M6	●	3	12	20	11.2	M6	8		
MPM-3013-M6	●		13		11.5	M6			
MPM-3015-M8	○	4	15	23	14	M8	8	12	
MPM-4016-M8	●		16		15	M8			
MPM-4017-M8	●		17			M8			
MPM-4018-M8	○		18			M8			
MPM-5020-M10	●	5	20	30	19	M10	9	14	
MPM-5021-M10	●		21			M10			
MPM-6025-M12	●	6	25	35	23.6	M12	10	17	
MPM-7030-M16	●	7	30	43	29	M16	12	22	
MPM-8032-M16	●	8	32			M16			

Note) All cutters are supplied without inserts or wrenches.

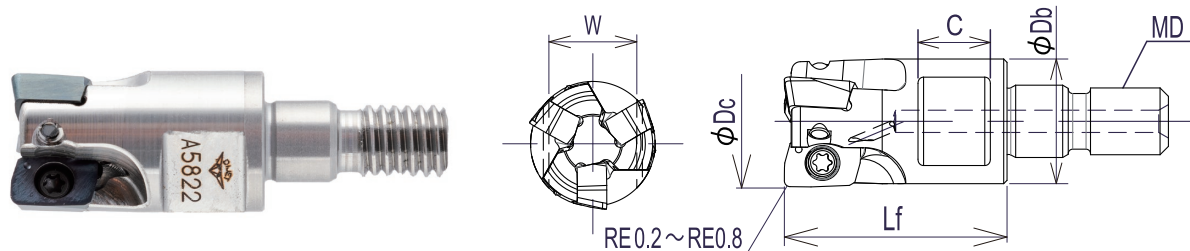
MPT
TYPE

High Precision "QM MILL"

High tolerance insert-pocket for the ground inserts

O.D. 0
Tolerance -0.03

NEW



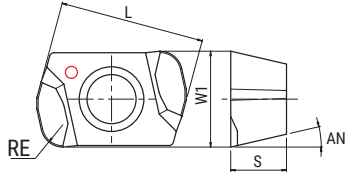
Cat.No.	Stock	No. of inserts	Dimensions (mm)						Insert
			φDc	Lf	φDb	MD	C	W	
MPT-2010A00-M6	●	2	10	18	9.5	M6	6.5	8	ZOMT0602**ZER YOHW0602**ZER-12
MPT-2011A00-M6	○		11		9.7				
MPT-3012A00-M6	●	3	12	20	11.2				
MPT-3013A00-M6	○		13		11.5				
MPT-4016A00-M8	●	4	16	23	15	M8	8	12	

Note) All cutters are supplied without inserts or wrenches.

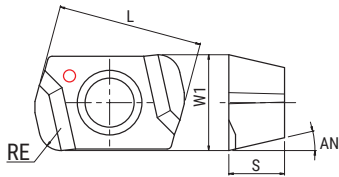
Screw	Torque(N.m)	Wrench
DSW-1840H	0.4	A-06

Insert

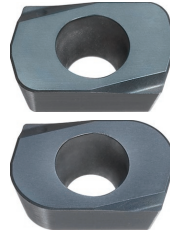
High feed insert



High feed insert for unfavorable conditions



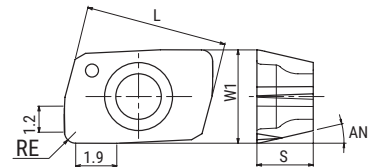
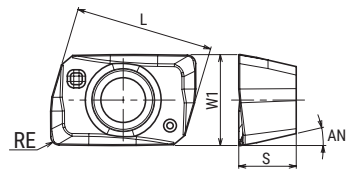
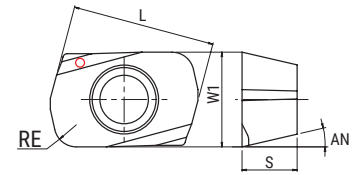
For high hardened steel



Shoulder insert



"Mirror Insert" for finishing side & bottom face



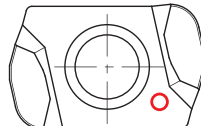
Type	Cat.No.	Tolerance	PVD Coating						Dimensions (mm)					
			DH102	DS118	DS150	JC7560	JC8015	JC8050	JC8118	RE	L	W1	S	AN
High feed insert	EOMT060210ZER	M		●	●	●		●	●	1	6.5	4.3	2.5	13°
	EOMT060220ZER			●	●			●	●	2				
High feed insert for unfavorable conditions	EOMW060210ZER				●		●	●	1					
For high hardened steel	EOHW060210ZTR	H	●						●	2				
	EOHW060220ZTR		●						●					
shoulder insert	ZOMT060202ZER-PL	M						●	●	0.2	6.62	2.7		
	ZOMT060204ZER-PL							●	●	0.4				
	ZOMT060208ZER-PL							●	●	0.8				
"Mirror Insert" for finishing side & bot- tom face	YOHW060203ZER-12	H	●				●			0.3	6.5	2.6		
	YOHW060205ZER-12		●				●			0.5				
	YOHW060208ZER-12		●					●					0.8	

Note) 10 inserts per case.

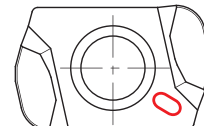
GRADE MARKINGS



JC8118/DS118



JC8050/JC7560/DS150



MAGNETIZER



- Magnetizing and demagnetizing a 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.

Cat.No.	Stock
MAGNETISER	●

● : Standard stock items

○ : Stock in Japan

■ Insert selection guide

Material	Carbon steel (S50C, S55C) below 250HB						Tool & die steel # (SKD61, SKD11) below 255HB					
Cat.No. / Grade	JC8118	JC8050	JC7560	DH102	DS118	DS150	JC8118	JC8050	JC7560	DH102	DS118	DS150
EOMT0602*0ZER	☆	☆	☆				☆	☆	☆			
EOMW060210ZER	○	○	◎				○	○	◎			
EOHW0602*0ZTR												

Material	Mold steel (HPM7, PX5, KPM30) 30-36HRC						Mold steel (NAK80, HPM1) 38-43HRC					
Cat.No. / Grade	JC8118	JC8050	JC7560	DH102	DS118	DS150	JC8118	JC8050	JC7560	DH102	DS118	DS150
EOMT0602*0ZER	☆	☆	☆				☆	☆				
EOMW060210ZER	○	○	◎				◎	○				
EOHW0602*0ZTR												

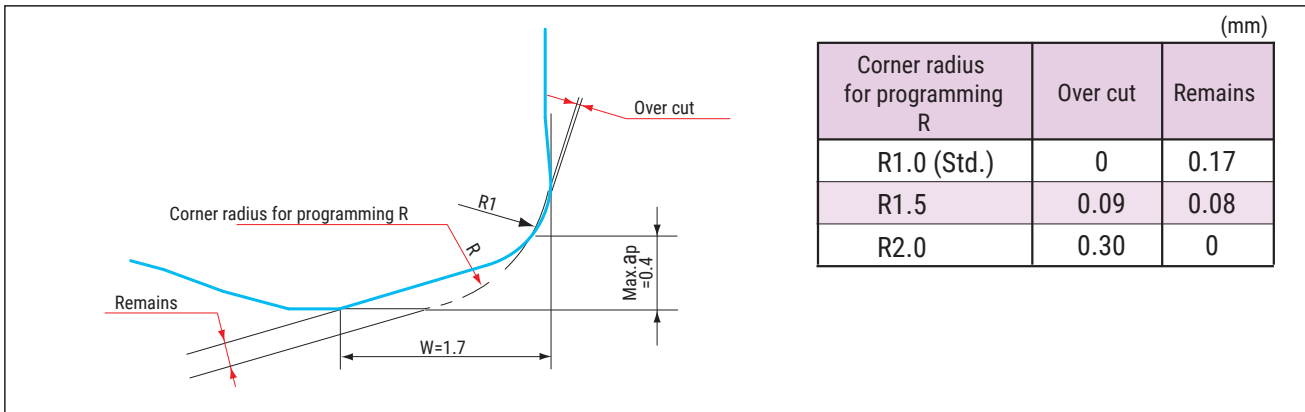
Material	Hardened die steel (SKD61, DAC, DHA) 42-52HRC						Hardened die steel (SKD11, SLD, DC11) 55-62HRC					
Cat.No. / Grade	JC8118	JC8050	JC7560	DH102	DS118	DS150	JC8118	JC8050	JC7560	DH102	DS118	DS150
EOMT0602*0ZER	☆						×	×				
EOMW060210ZER	○	●					○					
EOHW0602*0ZTR	◎						●			◎		

Material	Cast iron (FC, FCD) below 300HB						Stainless steel (SUS304) below 250HB					
Cat.No. / Grade	JC8118	JC8050	JC7560	DH102	DS118	DS150	JC8118	JC8050	JC7560	DH102	DS118	DS150
EOMT0602*0ZER	○							◎	○			
EOMW060210ZER	◎		●					●				
EOHW0602*0ZTR												

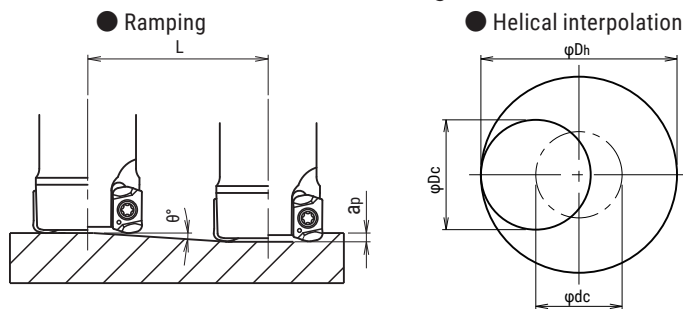
Material	Titanium alloy (Ti-6Al-4V)						Heat resistant alloy (INCO718)					
Cat.No. / Grade	JC8118	JC8050	JC7560	DH102	DS118	DS150	JC8118	JC8050	JC7560	DH102	DS118	DS150
EOMT0602*0ZER	○	○	◎		○	◎	◎	○	○		○	○
EOMW060210ZER			●					●				
EOHW0602*0ZTR												

◎: First choice ○: For general milling ●: For unstable milling ☆: For light cutting force ×: Not recommended

Definition of corner shape for programming



Recommended Data for Profile Milling



- Calculation of tool pass dia.

$$\phi_{dc} = \phi_{Dh} - \phi_{Dc}$$

Tool pass dia. Bore dia. Tool Dia.

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

- In case of ramping and helical interpolation, apply 70% or less feed (V_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

Cat.No.	Tool dia. (mm)	Effective cutting dia. (mm)	Max.depth of cut: a_p (mm)	Ramping		Helical interpolation	
				Max. ramping angle θ	Max. depth of cut (a_p) Total cutting length L(mm)	Min. Bore dia. (mm)	Max. Bore dia. (mm)
MPM-2010-M6	10	6.6	0.3	2°18'	7.5	15	18
MPM-2011-M6	11	7.6	0.3	1°54'	9	17	20
MPM-3012-M6	12	8.5	0.3	1°36'	10.7	19	22
MPM-3013-M6	13	9.5	0.3	1°24'	12.3	21	24
MPM-3015-M8	15	11.5	0.4	1°12'	19.1	25	28
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-4018-M8	18	14.5	0.4	0°51'	27.0	31	34
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
PME2010S10	10	6.6	0.3	2°18'	7.5	15	18
PME2011S10-LS	11	7.6	0.3	1°54'	9	17	20
PME3012S12	12	8.5	0.3	1°36'	10.7	19	22
PME3013S12-LS	13	9.5	0.3	1°24'	12.3	21	24
PME3014S12 (-LS)	14	10.5	0.3	1°18'	13.2	23	26

■ Recommended Cutting Conditions

Material		High Feed		Side Finishing	Bottom Finishing
		EOMT / EOMW	EOHW	YOHW	YOHW
Carbon Steel below 250HB	Grade	JC7560 (JC8050 JC8118)	-	JC8015 (DH102)	JC8015 (DH102)
	Vc	95 - 120	-	280 - 400	160 - 250
	fz	0.5 - 0.9	-	0.1 - 0.15	0.14 - 0.2
	ap	0.2 - 0.4	-	~1.2	~0.12
	ae	0.7 Dc	-	~0.1	0.6 Dc
Tool & Die Steel below 255HB	Grade	JC7560 (JC8050 JC8118)	-	JC8015 (DH102)	JC8015 (DH102)
	Vc	90 - 110	-	250 - 360	150 - 230
	fz	0.5 - 0.9	-	0.1 - 0.15	0.13 - 0.18
	ap	0.15 - 0.4	-	~1.0	~0.12
	ae	0.7 Dc	-	~0.1	0.6 Dc
Mold Steel 30-36HRC	Grade	JC8118 (JC7560 JC8050)	-	JC8015 (DH102)	JC8015 (DH102)
	Vc	90 - 110	-	250 - 360	150 - 230
	fz	0.5 - 0.9	-	0.1 - 0.15	0.13 - 0.18
	ap	0.2 - 0.4	-	~1.0	~0.12
	ae	0.7 Dc	-	~0.1	0.6 Dc
Mold Steel 38-43HRC	Grade	JC8118 (JC8050)	-	DH102 (JC8015)	DH102 (JC8015)
	Vc	70 - 90	-	200 - 280	130 - 200
	fz	0.5 - 0.7	-	0.08 - 0.12	0.08 - 0.12
	ap	0.2 - 0.3	-	~1.0	~0.12
	ae	0.6 Dc	-	~0.1	0.6 Dc
Hardened Die Steel 42-52HRC	Grade	JC8118	JC8118	DH102 (JC8015)	DH102 (JC8015)
	Vc	50 - 70	70 - 90	140 - 200	90 - 120
	fz	0.45 - 0.6	0.3 - 0.6	0.08 - 0.1	0.08 - 0.1
	ap	0.15 - 0.3	0.1 - 0.25	~0.8	~0.1
	ae	0.6 Dc	0.6 Dc	~0.1	0.4 Dc
Hardened Die Steel 55-62HRC	Grade	-	DH102	DH102	DH102
	Vc	-	70 - 80	100 - 150	50 - 70
	fz	-	0.27 - 0.3	0.08 - 0.1	0.06 - 0.08
	ap	-	0.1 - 0.15	~0.5	~0.1
	ae	-	0.4 Dc	~0.1	0.4 Dc
Grey & Nodular Cast Iron below 300HB	Grade	JC8118	-	JC8015 (DH102)	JC8015 (DH102)
	Vc	120 - 150	-	280 - 400	130 - 200
	fz	0.5 - 0.9	-	0.1 - 0.15	0.1 - 0.15
	ap	0.2 - 0.4	-	~1.2	~0.15
	ae	0.7 Dc	-	~0.12	0.6 Dc
Stainless Steel	Grade	JC8050 (JC7560)	-	JC8015 (DH102)	JC8015 (DH102)
	Vc	95 - 120	-	250 - 360	150 - 230
	fz	0.5 - 0.9	-	0.1 - 0.15	0.13 - 0.18
	ap	0.15 - 0.4	-	~1.0	~0.12
	ae	0.6 Dc	-	~0.1	0.6 Dc
Titanium Alloy	Grade	DS150 (JC7560 JC8050 DS118)	-	JC8015 (DH102)	JC8015 (DH102)
	Vc	50 - 60	-	55 - 80	30 - 50
	fz	0.4 - 0.5	-	0.08 - 0.12	0.09 - 0.12
	ap	0.15 - 0.3	-	~1.0	~0.12
	ae	0.6 Dc	-	~0.1	0.6 Dc
Heat Resistant Alloy	Grade	JC8118 (JC8050)	-	-	-
	Vc	25 - 30	-	-	-
	fz	0.3 - 0.4	-	-	-
	ap	0.15 - 0.3	-	-	-
	ae	0.6 Dc	-	-	-

Note

1. Please adjust cutting conditions according to machine rigidity or work rigidity.
2. In case of chatter occurring, recommended to reduce ap or rpm and keep feed per tooth.
3. ap should be reduced when using on low rigidity machine.
4. Use air blow.

■ Recommended Cutting Conditions

Material		Shoulder Milling	Side Finishing	Bottom Finishing
		ZOMT	ZOMT	ZOMT
Carbon Steel below 250HB	Grade	JC8050 (JC8118)	JC8050 (JC8118)	JC8050 (JC8118)
	Vc	128 - 160	145 - 240	90 - 180
	fz	0.06 - 0.08	0.07 - 0.13	0.1 - 0.15
	ap	~4.0	~4.0	~0.15
	ae	~0.15 Dc	~0.1	~0.6 Dc
Tool & Die Steel below 255HB	Grade	JC8050 (JC8118)	JC8050 (JC8118)	JC8050 (JC8118)
	Vc	120 - 150	130 - 215	80 - 160
	fz	0.04 - 0.06	0.07 - 0.13	0.1 - 0.15
	ap	~4.0	~4.0	~0.15
	ae	~0.15 Dc	~0.1	~0.6 Dc
Mold Steel 30-36HRC	Grade	JC8118 (JC8050)	JC8118 (JC8050)	JC8118 (JC8050)
	Vc	120 - 150	130 - 215	80 - 160
	fz	0.03 - 0.05	0.07 - 0.13	0.1 - 0.15
	ap	~4.0	~4.0	~0.15
	ae	~0.15 Dc	~0.1	~0.6 Dc
Mold Steel 38-43HRC	Grade	JC8118 (JC8050)	JC8118 (JC8050)	JC8118 (JC8050)
	Vc	90 - 120	110 - 185	70 - 140
	fz	0.03 - 0.05	0.05 - 0.1	0.1 - 0.15
	ap	~3.0	~3.0	~0.15
	ae	~0.13 Dc	~0.1	~0.6 Dc
Hardened Die Steel 42-52HRC	Grade	JC8118	JC8118	JC8118
	Vc	80 - 100	90 - 120	75 - 100
	fz	0.03 - 0.05	0.05 - 0.07	0.1 - 0.12
	ap	~2.5	~2.5	~0.1
	ae	~0.12 Dc	~0.1	~0.6 Dc
Grey & Nodular Cast Iron below 300HB	Grade	JC8118	JC8118	JC8118
	Vc	120 - 150	125 - 210	90 - 180
	fz	0.06 - 0.08	0.07 - 0.15	0.12 - 0.18
	ap	~4.0	~4.0	~0.15
	ae	~0.15 Dc	~0.1	~0.6 Dc
Stainless Steel	Grade	JC8050	JC8050	JC8050
	Vc	120 - 150	130 - 215	80 - 160
	fz	0.04 - 0.06	0.07 - 0.13	0.1 - 0.15
	ap	~4.0	~4.0	~0.15
	ae	~0.15 Dc	~0.1	~0.6 Dc

Note

1. Please adjust cutting conditions according to machine rigidity or work rigidity.
2. In case of chatter occurring, recommended to reduce ap or rpm and keep feed per tooth.
3. ap should be reduced when using on low rigidity machine.
4. Use air blow.

QM Quick & Mini MAX

New generation high feed mill "QM MAX"

Bore Type
φ40~φ66

Modular Type
φ16~φ42

Shank Type
φ16~φ25

G-Body



Low cutting force geometry

- Unique 3D geometry insert provides stable cutting and less power consumption.

Multi - flutes specification

- High speed and high efficient machining.

Vibration free

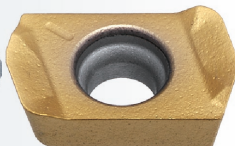
- Control vibration with combination of MSN carbide shank holder.

Insert Line-Up

High feed insert



EPMT100312ZER

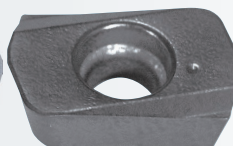


EPMW100312ZER

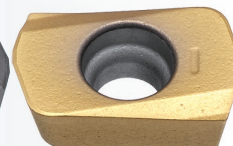
High feed insert for unfavorable conditions



EPMW100312ZER

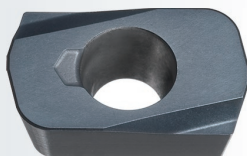


EPMW100312ZTR



EPMW100312ZTR

For high hardened steel



EPHW100316ZTR

Shoulder insert for aluminum



ZPMT1003...ZER-NL
(R0.4, 0.8, 2.0)

Shoulder insert for general steel



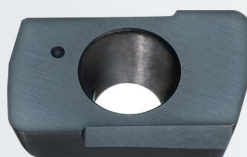
ZPMT1003...ZER-PL
(R0.4, 0.8, 2.0)

Shoulder insert for Ti alloy

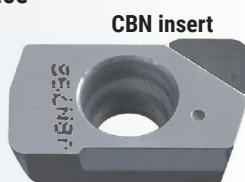


ZPMT1003...ZER-SL
(R0.4, 0.8, 2.0)

"Mirror Insert" for finishing side & bottom face



YPHW1003...ZER-...



YPHW100308ZTR-F1

A variety of inserts all fit into the same body.

Multi-purpose cutter that can high feed, square up and finish.

**QXP
TYPE**

Bore Type

Through
coolant
hole

**G-
Body**

Face Milling

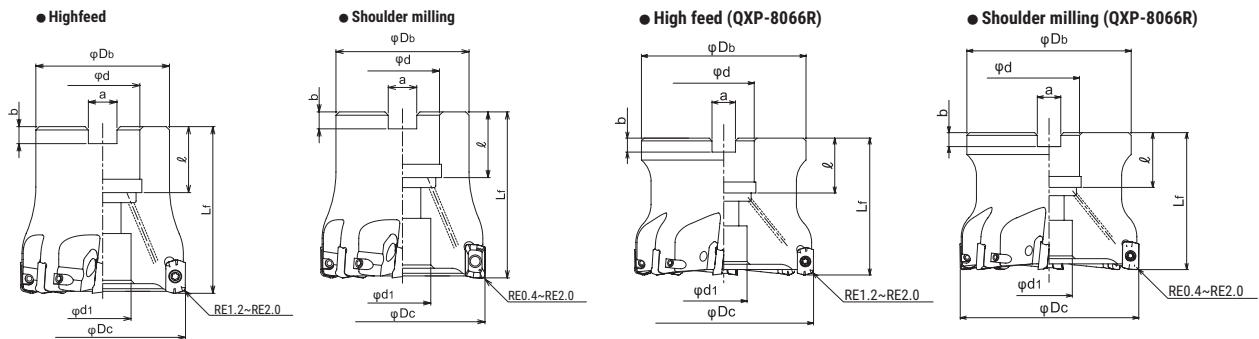
Shoulder Milling

Slotting

Copy Milling

Pocket Milling

Helical Interpolation



Cat.No.	Stock	No. of inserts	Dimensions (mm)								Insert
			φD _C	L _f	φD _b	φ _d	φ _d 1	a	b	ℓ	
QXP-6040R-16	●	6	40	45	35	16	14	8.4	5.6	18	EP**1003**Z*R ZPMT1003**ZER.** YPHW1003**Z*R.**
QXP-7040R-16	●	7									
QXP-7050R-22	●	8	50	50	40	22	17	10.4	6.3	20	
QXP-8050R-22	●										
QXP-8052R-22	●		52								
QXP-8063R-22	●		63		48						
QXP-8066R-27	●	66	27			20	12.4	7	22		

Note) All cutters are supplied without inserts or wrenches.

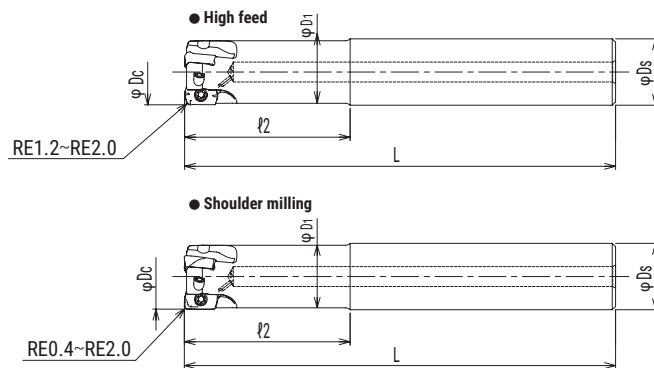
Screw	Torque(N.m)	Wrench
DSW-2563H	1.1	A-08

● : Standard stock items

○ : Stock in Japan

QXPS
TYPE

Shank Type



Cat.No	Stock	No. of inserts	Dimensions (mm)					Parts		Insert
			φDc	ℓ2	L	φD1	φDs	Screw	Wrench	
QXPS2016S16+A	●	2	16	30	100	15	16	TSW-2556H	A-08	EP**1003**Z*R
QXPS3020S20+A	●	3	20	50	130	18.85	20			ZPMT1003**ZER**
QXPS4025S25+A	●	4	25	60	140	23.6	25	DSW-2563H		YPHW1003**Z*R**

Note) All cutters are supplied without inserts or wrenches.

Screw	Torque(N.m)
TSW-2556H	1.1
DSW-2563H	

**MQX
TYPE**

Modular Type

Through
coolant
hole

**G-
Body**

Face Milling

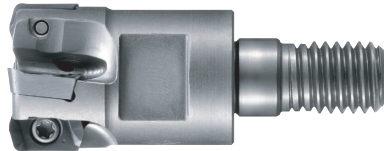
Shoulder Milling

Slotting

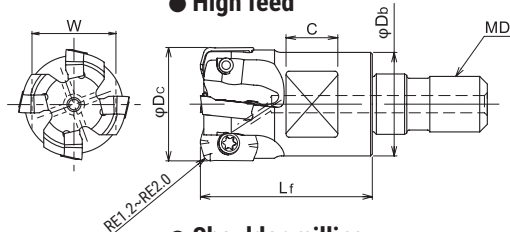
Copy Milling

Pocket Milling

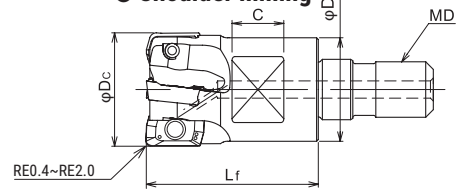
Helical Interpolation



● **High feed**



● **Shoulder milling**



Cat.No.	Stock	No. of inserts	Dimensions (mm)						Parts		Insert
			φDc	Lf	φDb	MD	C	W	Screw	Wrench	
MQX-2016-M8	●	2	16	23	14	M8	8	12	TSW-2556H	A-08	EP**1003**Z*R ZPMT1003**ZER-** YPHW1003**Z*R-**
MQX-2017-M8	●		17			M8					
MQX-3020-M10	●	3	20	30	18	M10	9	14			
MQX-4020-M10	●	4				M10					
MQX-4021-M10	●		21	M10							
MQX-4025-M12	●	5	25	35	22.5	M12	10	17	DSW-2563H		
MQX-5025-M12	●					M12					
MQX-4026-M12	○	4	26			M12					
MQX-5026-M12	●					M12					
MQX-5028-M12	○	5	28		23.6	M12					
MQX-5030-M16	○		30	27	M16	12	22				
MQX-5032-M16	●		32	29	M16						
MQX-6032-M16	●				6			M16			
MQX-5035-M16	●	5	35		M16						
MQX-6035-M16	●	6		M16							
MQX-6040-M16	●		40	32	M16	14	26				
MQX-7040-M16	●	7			M16						
MQX-6042-M16	●	6	42		M16						

Note) All cutters are supplied without inserts or wrenches.

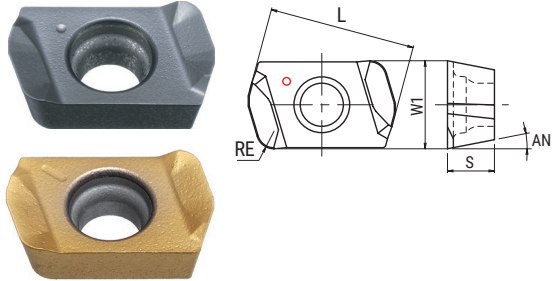
Screw	Torque(N.m)
TSW-2556H	1.1
DSW-2563H	

● : Standard stock items

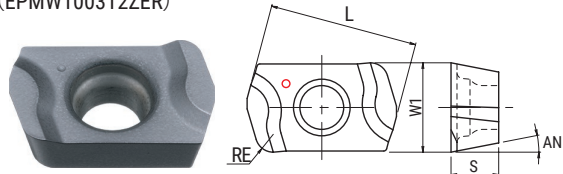
○ : Stock in Japan

Insert

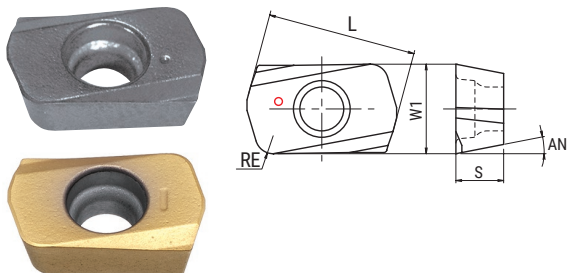
High feed insert
(EPMT1003 * * ZER)



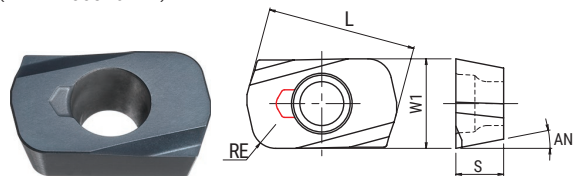
High feed insert for unfavorable conditions
(EPMW100312ZER)



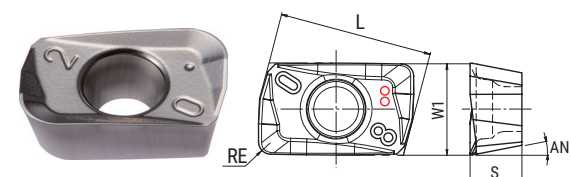
High feed insert for unfavorable conditions
(EPMW100312ZTR)



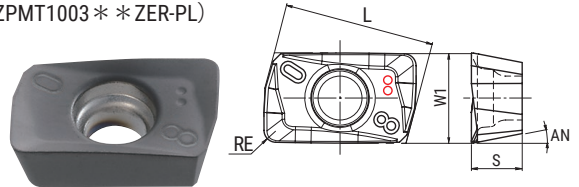
For high hardened steel
(EPHW100316ZTR)



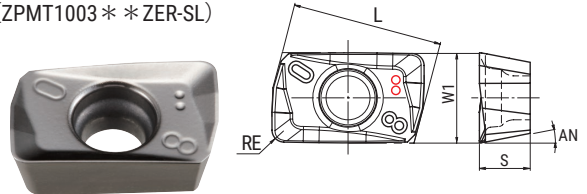
Shoulder insert for aluminum
(ZPMT1003 * * ZER-NL)



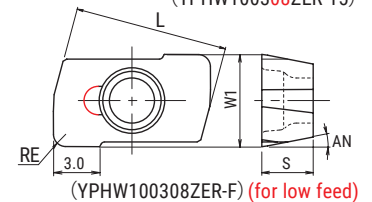
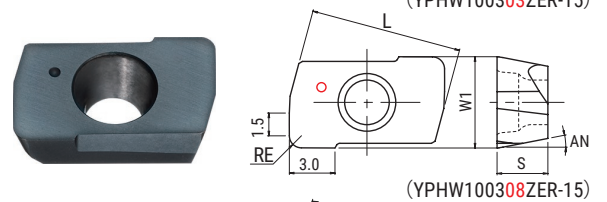
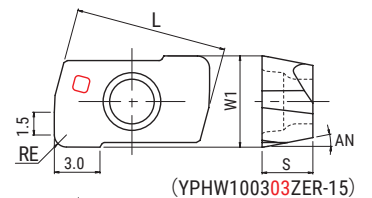
Shoulder insert for general steel
(ZPMT1003 * * ZER-PL)



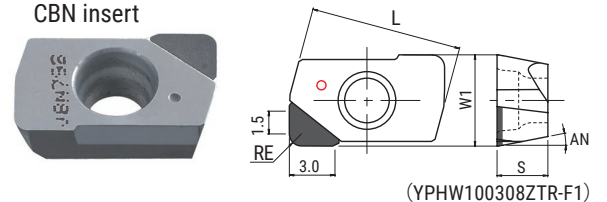
Shoulder insert for Ti alloy
(ZPMT1003 * * ZER-SL)



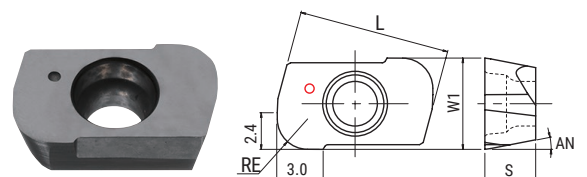
"Mirror Insert" for finishing side & bottom face
(YPHW1003 * * ZER-15) (YPHW100308ZTR-F1) (YPHW100308ZER-F)



CBN insert



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



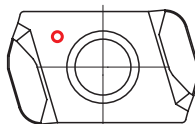
Type	Cat.No.	Tolerance	PVD coating								Uncoated	Cermet	CBN	Dimensions (mm)				
			JC8118	DH102	JC7518	JC7560	JC8015	JC8050	DS118	DS150	FC18	CX75	JBN795	L	S	W1	RE	AN
High feed insert	EPMT100312ZER	M	●			●		●	●	●				10	3.2	6	1.2	11°
	EPMT100320ZER	M	●											10	3.2	6	2.0	11°
High feed insert for unfavorable conditions	EPMW100312ZER	M	●					●						10	3.2	6	1.2	11°
	EPMW100312ZTR	M	●			●		●						10	3.2	6	1.2	11°
For high hardened steel	EPHW100316ZTR	H	●	●										10	3.2	6	1.6	11°
Shoulder insert for aluminum	ZPMT100304ZER-NL	M									●			10.08	3.4	6	0.4	11°
	ZPMT100308ZER-NL	M									●			10.08	3.4	6	0.8	11°
	ZPMT100320ZER-NL	M									●			10.08	3.4	6	2.0	11°
Shoulder insert for general steel	ZPMT100304ZER-PL	M	●	●				●				●		10.08	3.4	6	0.4	11°
	ZPMT100308ZER-PL	M	●	●				●				●		10.08	3.4	6	0.8	11°
	ZPMT100320ZER-PL	M	●	●				●				●		10.08	3.4	6	2.0	11°
Shoulder insert for Ti alloy	ZPMT100304ZER-SL	M			●			●						10.08	3.4	6	0.4	11°
	ZPMT100308ZER-SL	M			●			●						10.08	3.4	6	0.8	11°
	ZPMT100320ZER-SL	M			●			●						10.08	3.4	6	2.0	11°
"Mirror Insert" for finishing side & bottom face	YPHW100303ZER-15	H		●			●					●		10.06	3.35	6	0.3	11°
	YPHW100308ZER-15	H		●								●		10.06	3.35	6	0.8	11°
	YPHW100308ZER-F	H					●							10.06	3.35	6	0.8	11°
	YPHW100308ZTR-F1	H											●	10.06	3.35	6	0.8	11°
	YPHW100320ZER-24	H		●			●							10.06	3.35	6	2.0	11°

Note) 10 inserts per case, but grade JBN795 insert is packed in 1 piece per case.

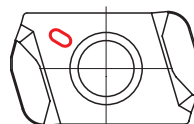
GRADE MARKING



JC8118 / DS118



JC8050 / JC7560 / DS150



■ Insert selection guide

Material	Carbon steel (S50C, S55C) below 250HB						Tool & die steel (SKD61, SKD11) below 255HB						Mold steel (HPM7, PX5, P20) 30-36HRC						Mold steel (NAK80, HPM1, P21) 38-43HRC					
Cat.No. Grade	JC8118	JC8050	JC7560	DH102	DS118	DS150	JC8118	JC8050	JC7560	DH102	DS118	DS150	JC8118	JC8050	JC7560	DH102	DS118	DS150	JC8118	JC8050	JC7560	DH102	DS118	DS150
EPMT1003 * * ZER	☆	☆	☆				☆	☆	☆				☆	☆	☆				☆	☆				
EPMW100312ZER																				○				
EPMW100312ZTR	○	○	◎				○	○	◎				○	○	◎				◎	○				
EPHW100316ZTR																								

Material	Hardened die steel (SKD61, DAC, DHA) 42-52 HRC						Hardened die steel (SKD11, SLD, DC11) 55-62HRC						Grey cast iron (FC, FCD) below 300HB						Stainless steel (SUS304) below 250HB					
Cat.No. Grade	JC8118	JC8050	JC7560	DH102	DS118	DS150	JC8118	JC8050	JC7560	DH102	DS118	DS150	JC8118	JC8050	JC7560	DH102	DS118	DS150	JC8118	JC8050	JC7560	DH102	DS118	DS150
EPMT1003 * * ZER	☆						×	×					○							◎	○			
EPMW100312ZER	○						○						◎							●				
EPMW100312ZTR	●						●						●		○									
EPHW100316ZTR	◎									◎														

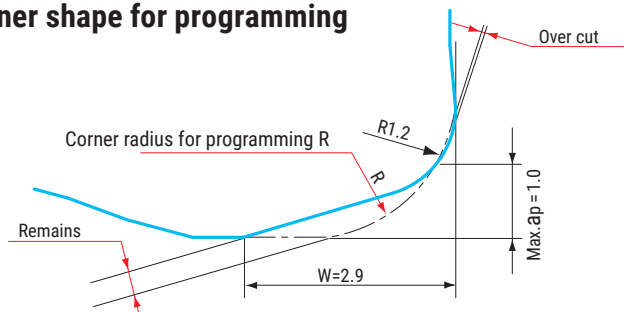
Material	Titanium alloy (Ti-6Al-4V)						Heat resistant alloy (INCO718)					
Cat.No. Grade	JC8118	JC8050	JC7560	DH102	DS118	DS150	JC8118	JC8050	JC7560	DH102	DS118	DS150
EPMT1003 * * ZER	○	○	●		○	◎	◎	○	○		○	○
EPMW100312ZER		●						●				
EPMW100312ZTR												
EPHW100316ZTR												

- EPMT Type : with chip breaker
- EPMW Type : without chip breaker
- EPMW Type : without chip breaker

- ◎ : First choice
- : For general milling
- : For unstable milling
- ☆ : For light cutting force
- ×

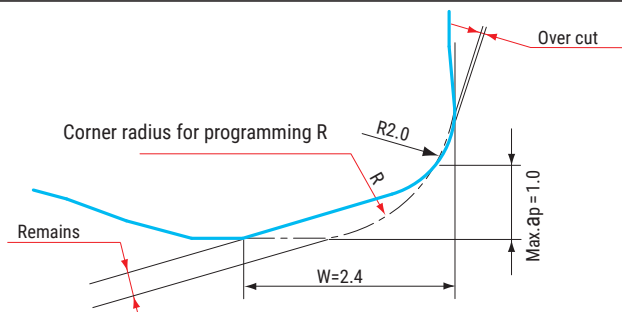
■ Definition of corner shape for programming

• EPMT/W Type
(RE=R1.2)



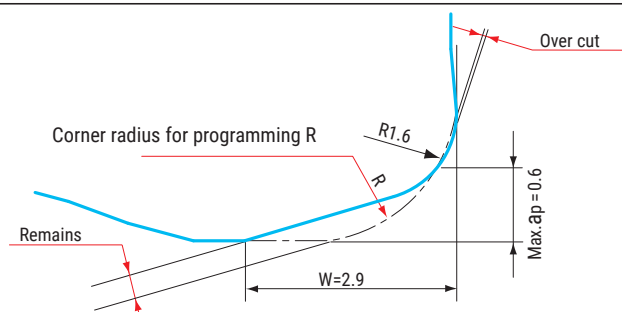
Corner radius for programming R	Over cut	Remains
R1.0	0	0.57
R1.5 (Std.)	0	0.45
R2.0	0.04	0.33
R2.5	0.21	0.21
R3.0	0.40	0.09

• EPMT Type
(RE=R2.0)



Corner radius for programming R	Over cut	Remains
R1.0	0	0.51
R1.5	0	0.31
R2.0 (Std.)	0	0.13
R2.5	0.12	0.04
R3.0	0.32	0

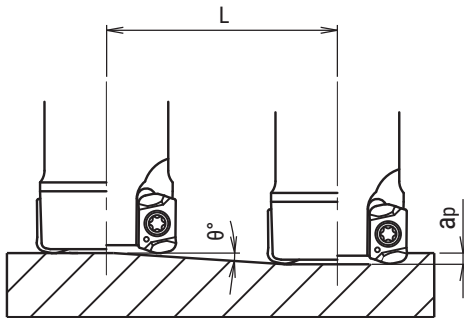
• EPHW Type



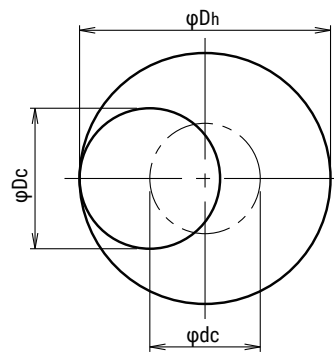
Corner radius for programming R	Over cut	Remains
R1.0	0	0.42
R1.5 (Std.)	0	0.33
R2.0	0.01	0.23
R2.5	0.17	0.14
R3.0	0.37	0.05

■ Recommended Data for Profile Milling

Ramping



Helical interpolation



- Calculation of tool pass dia.

$$\phi_{dc} = \phi_{Dh} - \phi_{Dc}$$

Tool pass dia. Bore dia. Tool Dia.

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

- In case of ramping and helical interpolation, apply 70% or less feed (Vf) 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

Cat.No.	Tool dia.	Effective Cutting dia.	Max.depth of cut : a_p	Ramping		Helical interpolation	
				Max.ramping angle θ°	Max.depth of cut (a_p) Total cutting length L(mm)	Min.Bore dia.	Max.Bore dia.
QXP-*040R-16	40	34.1	1	0.5	114.6	70	78
QXP-*050R-22	50	44.1	1	0.4	143.2	90	98
QXP-8052R-22	52	46.1	1	0.35	163.7	94	102
QXP-8063R-22	63	57.1	1	0.3	191	116	124
QXP-8066R-27	66	60.1	1	0.3	191	122	130
QXPS-2016-...	16	10.2	0.8	1.8	25.5	22	30
QXPS-3020-...	20	14.1	0.8	1.4	32.7	30	38
QXPS-4025-...	25	19.1	0.8	1	45.8	40	48
MQX-*016-M8	16	10.2	0.8	1.8	25.5	22	30
MQX-*017-M8	17	11.2	0.8	1.6	28.6	24	32
MQX-*020-M10	20	14.1	0.8	1.4	32.7	30	38
MQX-*021-M10	21	15.1	0.8	1.3	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	0.95	48.2	42	50
MQX-*028-M12	28	22.1	0.8	0.85	53.9	46	54
MQX-*030-M16	30	24.1	0.8	0.8	57.3	50	58
MQX-*032-M16	32	26.1	0.8	0.7	65.5	54	62
MQX-*035-M16	35	29.1	0.8	0.6	76.4	60	68
MQX-*040-M16	40	34.1	0.8	0.5	91.7	70	78
MQX-*042-M16	42	36.2	0.8	0.45	101.9	74	82

(EPM*100312ZER type inserts)

■ Recommended Cutting Conditions

Material		High Feed		Shoulder Milling	Side Finishing	Bottom Finishing
		EPMT / EPMW	EPHW	ZPMT		
Carbon Steel below 250HB	Grade	JC7560 (JC8050 JC8118)	-	JC8050 (JC8118)	JC8050 (JC8118)	JC8050 (JC8118)
	Vc	130 - 180	-	130 - 160	190 - 320	90 - 180
	fz	0.7 - 0.9	-	0.12 - 0.15	0.18 - 0.30	0.1 - 0.15
	ap	0.4 - 1.0	-	~5.0	~5.0	~0.2
	ae	0.7 Dc	-	~0.16 Dc	~0.2	0.4 - 1.0 Dc
Tool & Die Steel below 255HB	Grade	JC7560 (JC8050 JC8118)	-	JC8050 (JC8118)	JC8050 (JC8118)	JC8050 (JC8118)
	Vc	130 - 180	-	120 - 150	180 - 300	80 - 160
	fz	0.7 - 0.9	-	0.12 - 0.15	0.15 - 0.25	0.1 - 0.15
	ap	0.4 - 1.0	-	~5.0	~5.0	~0.2
	ae	0.7 Dc	-	~0.16 Dc	~0.2	0.4 - 1.0 Dc
Mold Steel 30-36HRC	Grade	JC8118 (JC7560 JC8050)	-	JC8118 (JC8050)	JC8118 (JC8050)	JC8118 (JC8050)
	Vc	130 - 180	-	120 - 150	180 - 300	80 - 160
	fz	0.7 - 1.0	-	0.12 - 0.15	0.15 - 0.25	0.1 - 0.15
	ap	0.4 - 1.0	-	~5.0	~5.0	~0.2
	ae	0.7 Dc	-	~0.16 Dc	~0.2	0.4 - 1.0 Dc
Mold Steel 38-43HRC	Grade	JC8118 (JC8050)	-	JC8118 (JC8050)	JC8118 (JC8050)	JC8118 (JC8050)
	Vc	70 - 100	-	100 - 120	150 - 250	70 - 140
	fz	0.6 - 0.7	-	0.1 - 0.12	0.15 - 0.25	0.1 - 0.15
	ap	0.3 - 0.8	-	~4.0	~4.0	~0.2
	ae	0.6 Dc	-	~0.15 Dc	~0.2	0.4 - 1.0 Dc
Hardened Die Steel 42-52HRC	Grade	JC8118	JC8118	JC8118 (DH102)	JC8118 (DH102)	JC8118 (DH102)
	Vc	60 - 70	70 - 90	80 - 100	120 - 210	75 - 100
	fz	0.5	0.5 - 0.8	0.09 - 0.12	0.12 - 0.20	0.1 - 0.12
	ap	0.2 - 0.6	0.1 - 0.3	~3.5	~3.5	~0.2
	ae	0.6 Dc	0.6 Dc	~0.14 Dc	~0.2	0.4 - 1.0 Dc
Hardened Die Steel 55-62HRC	Grade	-	DH102	DH102	DH102	DH102
	Vc	-	60 - 80	50 - 70	100 - 180	50 - 70
	fz	-	0.2 - 0.3	0.1	0.09 - 0.15	0.08 - 0.1
	ap	-	0.1 - 0.2	~2.5	~2.5	~0.15
	ae	-	0.4 Dc	~0.14 Dc	~0.15	0.4 - 1.0 Dc
Grey & Nodular Cast Iron below 300HB	Grade	JC8118	-	JC8118 (DH102)	JC8118 (DH102)	JC8118 (DH102)
	Vc	110 - 150	-	120 - 150	160 - 280	90 - 180
	fz	0.8 - 1.2	-	0.16 - 0.2	0.18 - 0.30	0.12 - 0.18
	ap	0.4 - 1.0	-	~5.0	~5.0	~0.2
	ae	0.7 Dc	-	~0.2 Dc	~0.2	0.4 - 1.0 Dc
Stainless Steel	Grade	JC8050 (JC7560)	-	JC8050 (JC8118 JC7518)	JC8050 (JC8118 JC7518)	JC8050 (JC8118 JC7518)
	Vc	130 - 150	-	120 - 150	180 - 300	80 - 160
	fz	0.6 - 0.8	-	0.12 - 0.15	0.15 - 0.25	0.1 - 0.15
	ap	0.3 - 0.8	-	~5.0	~5.0	~0.2
	ae	0.6 Dc	-	~0.16 Dc	~0.2	0.4 - 1.0 Dc
Titanium Alloy	Grade	DS150 (JC8050 DS118)	-	DS118 (JC7518)	DS118 (JC7518)	DS118 (JC7518)
	Vc	50 - 60	-	50 - 60	60 - 100	25 - 50
	fz	0.4	-	0.12 - 0.15	0.15 - 0.25	0.1 - 0.12
	ap	0.2 - 0.8	-	~5.0	~5.0	~0.2
	ae	0.6 Dc	-	~0.15 Dc	~0.2	0.4 - 1.0 Dc
Heat Resistant Alloy	Grade	JC8118 (JC8050)	-	JC7518	JC7518	JC7518
	Vc	20 - 30	-	25 - 30	30 - 50	15 - 30
	fz	0.3	-	0.11 - 0.15	0.15 - 0.25	0.1 - 0.12
	ap	0.2 - 0.8	-	~5.0	~5.0	~0.2
	ae	0.6 Dc	-	~0.15 Dc	~0.20	0.4 - 1.0 Dc
Aluminium	Grade	-	-	FC18	FC18	FC18
	Vc	-	-	300 - 600	420 - 700	300 - 600
	fz	-	-	0.16 - 0.2	0.18 - 0.30	0.1 - 0.15
	ap	-	-	~5.0	~5.0	~0.3
	ae	-	-	~0.4 Dc	~0.3	0.4 - 1.0 Dc

■ Recommended Cutting Conditions

Material		Contouring	Side Finishing	Bottom Finishing	Vertical Side Finishing	Side Finishing	Bottom Finishing	Vertical Side Finishing
		YPHW-24	YPHW-15			YPHW-F (CBN)		
Carbon Steel below 250HB	Grade	-	JC8015 (DH102)	DH102	JC8015 (DH102)	-	-	-
	Vc	-	450 - 650	170 - 260	350 - 450	-	-	-
	fz	-	0.1 - 0.15	0.18 - 0.25	0.08 - 0.18	-	-	-
	ap	-	0.7 - 2.0	~0.2	Pf 0.5 - 1.12	-	-	-
	ae	-	~0.2	~0.6 Dc	~0.2	-	-	-
Tool & Die Steel below 255HB	Grade	-	JC8015 (DH102)	DH102	JC8015 (DH102)	-	-	-
	Vc	-	350 - 450	150 - 240	300 - 400	-	-	-
	fz	-	0.1 - 0.15	0.18 - 0.25	0.08 - 0.18	-	-	-
	ap	-	0.7 - 2.0	~0.2	Pf 0.5 - 1.12	-	-	-
	ae	-	~0.2	~0.6 Dc	~0.2	-	-	-
Mold Steel 30-36HRC	Grade	-	JC8015 (DH102)	DH102	JC8015 (DH102)	-	-	-
	Vc	-	350 - 450	140 - 220	250 - 350	-	-	-
	fz	-	0.1 - 0.15	0.17 - 0.2	0.07 - 0.15	-	-	-
	ap	-	0.7 - 2.0	~0.2	Pf 0.5 - 1.12	-	-	-
	ae	-	~0.2	~0.6 Dc	~0.2	-	-	-
Mold Steel 38-43HRC	Grade	JC8015 (DH102)	JC8015 (DH102)	DH102	JC8015 (DH102)	-	-	-
	Vc	220	350 - 400	150 - 200	180 - 250	-	-	-
	fz	0.25	0.08 - 0.12	0.1 - 0.12	0.07 - 0.12	-	-	-
	ap	0.15 - 0.4	0.7 - 2.0	~0.2	Pf 0.5 - 1.12	-	-	-
	ae	~0.4 Dc	~0.2	~0.6 Dc	~0.2	-	-	-
Hardened Die Steel 42-52HRC	Grade	JC8015 (DH102)	JC8015 (DH102)	DH102	DH102 (JC8015)	JBN795	JBN795	JBN795
	Vc	160	170 - 200	60 - 100	120 - 170	400 - 450	300 - 350	400 - 450
	fz	0.25	0.08 - 0.1	0.1	0.06 - 0.1	0.07 - 0.08	0.06 - 0.08	0.07 - 0.08
	ap	0.1 - 0.25	~1.5	~0.2	Pf 0.5 - 1.12	~1.2	~0.08	Pf 0.5 - 1.12
	ae	~0.4 Dc	~0.2	~0.6 Dc	~0.15	~0.1	~0.6 Dc	~0.1
Hardened Die Steel 55-62HRC	Grade	DH102	DH102	DH102	-	JBN795	JBN795	-
	Vc	100	150 - 180	50 - 70	-	300 - 400	200	-
	fz	0.2	0.08 - 0.1	0.05 - 0.07	-	0.06 - 0.08	0.05 - 0.06	-
	ap	0.1 - 0.2	~1.0	~0.2	-	~1.2	~0.06	-
	ae	~0.3 Dc	~0.2	~0.4 Dc	-	~0.1	~0.6 Dc	-
Grey Cast Iron	Grade	-	JC8015 (DH102)	DH102	JC8015 (DH102)	JBN795	JBN795	JBN795
	Vc	-	450 - 550	130 - 200	450 - 550	750	700	750
	fz	-	0.1 - 0.15	0.1 - 0.2	0.1 - 0.15	0.1 - 0.135	0.1 - 0.12	0.1 - 0.135
	ap	-	0.7 - 2.0	~0.2	Pf 0.5 - 1.12	~1.5	~0.1	Pf 0.5 - 1.12
	ae	-	~0.2	~0.6 Dc	~0.2	~0.1	~0.6 Dc	~0.1
Nodular Cast Iron	Grade	-	JC8015 (DH102)	DH102	JC8015 (DH102)	JBN795	-	JBN795
	Vc	-	450 - 550	130 - 200	450 - 550	700	-	700
	fz	-	0.1 - 0.15	0.1 - 0.2	0.1 - 0.15	0.1 - 0.135	-	0.1 - 0.135
	ap	-	0.7 - 2.0	~0.2	Pf 0.5 - 1.12	~1.5	-	Pf 0.5
	ae	-	~0.2	~0.6 Dc	~0.2	~0.1	-	~0.1
Stainless Steel	Grade	-	JC8015 (DH102)	JC8015 (DH102)	-	-	-	-
	Vc	-	350 - 450	130 - 180	-	-	-	-
	fz	-	0.1 - 0.15	0.1 - 0.15	-	-	-	-
	ap	-	0.7 - 2.0	~0.2	-	-	-	-
	ae	-	~0.2	~0.6 Dc	-	-	-	-
Titanium Alloy	Grade	-	JC8015 (DH102)	DH102	-	-	-	-
	Vc	-	70 - 90	30 - 50	-	-	-	-
	fz	-	0.08 - 0.12	0.1 - 0.15	-	-	-	-
	ap	-	0.7 - 2.0	~0.2	-	-	-	-
	ae	-	~0.2	~0.6 Dc	-	-	-	-

Note

1. Please adjust cutting conditions according to machine rigidity or work rigidity.
2. In case of chatter occurring, recommended to reduce ap or rpm and keep feed per tooth.
3. ap should be reduced when using on low rigidity machine.
4. Use air blow.
5. When using Endmill type, reduce cutting conditions by 10-20%.

High precision
QMMAX
BARREL TOOL QM MAX

MQT type Modular type $\phi 16 \sim \phi 35$

High precision
BARREL TOOL
Tuff Modular Heads System



1. High precision QM Max MQT type improved balance of holder than conventional holders.
Possible to adapt multi-machining machines such as multi-tasking machines. Lined up high precision H grade inserts. High efficient machining is possible by adapting multi-blades specification.
→ Accuracy of tool dia. with master insert 0 ~ -0.03

2. Lineup holders with cutting edge angle 3°, 5°. Complex shape machining with inclination is possible by 3 axis machine.

3. Adopted 3 grades: PVD coated grade "JC8015" for general & mold steel, stainless steel and cast iron.
Cermet grade "CX75" for improving surface roughness.
And new PVD coated grade "DH102" for high speed machining in high hardened material.





MQT TYPE

High precision "QM MAX"



Fig 1

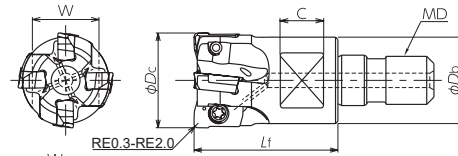
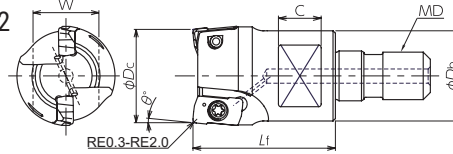


Fig 2



Inclination angle θ°	Cat.No.	Stock	No. of inserts	Dimensions (mm)						Parts		Inserts	Fig.	
				φD _C	L _f	φD _b	MD	C	W	Screws	Wrench			
0°	MQT-2016A00-M8	●	2	16	23	14	M8	8	12	TSW-2556H	A-08	XP**100308ZER-R; YPHW1003**Z*R-**, ZPMT1003**ZER-PL	1	
	MQT-4020A00-M10	●	4	20	30	18	M10	9	14					
	MQT-5025A00-M12	●	5	25	35	22.5	M12	10	17	DSW-2563H				
	MQT-6032A00-M16	●	6	32	43	29	M16	12	22					
	MQT-6035A00-M16	●		35		M16								
3°	MQT-2016A03-M8	●	2	16	23	14	M8	8	12	TSW-2556H	A-08	XP**100308ZER-R; YPHW1003**Z*R-**, ZPMT1003**ZER-PL	2	
	MQT-2020A03-M10	●		20	30	18	M10	9	14					
5°	MQT-2016A05-M8	●		16	23	14	M8	8	12					TSW-2556H
	MQT-2020A05-M10	●		20	30	18	M10	9	14					

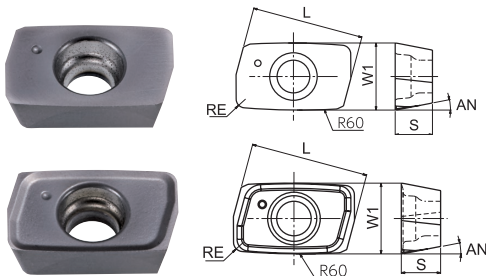
Note) All cutters are supplied without inserts or wrenches.

Clamp screw	Torque(N.m)
TSW-2556H	3.0
DSW-2563H	4.0

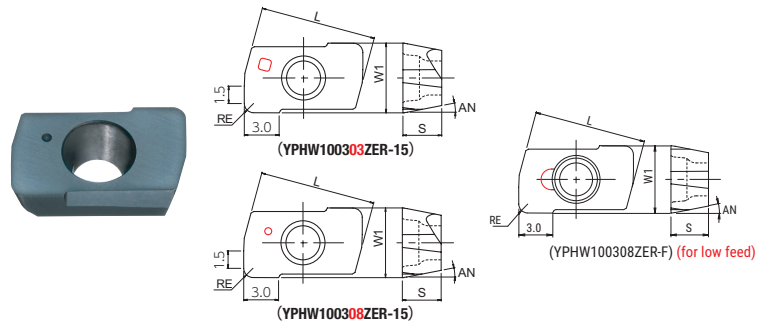
MQT TYPE

Insert

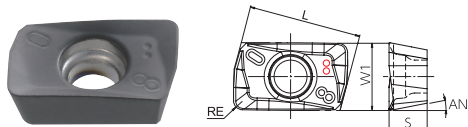
For tapered wall finishing
(XPHW100308ZER-R)(XPTH100308ZER-R)



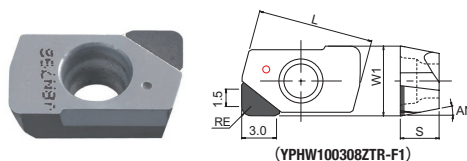
For finishing side face
(YPHW1003**ZER-15)(YPHW100308ZER-F)(YPHW100308ZTR-F1)



Shoulder milling insert (from semi-finishing to finishing)
ZPMT1003**ZER-PL*



CBN Insert



Type	Cat.No.	Tolerance	PVD Coating				Cermat	CBN	Dimensions (mm)				
			DH102	JC8015	JC8050	JC8118	CX75	JBN795	RE	L	W1	S	AN
For tapered wall finishing	XPHW100308ZER-R	H	●	●			●		0.8	10.06	6	3.35	11°
	XPTH100308ZER-R		●	●			●		0.3				
For finishing side face	YPHW100303ZER-15		●	●			●		0.8				
	YPHW100308ZER-15		●	●			●		0.8				
	YPHW100308ZER-F	M		●						10.08	3.4		
	YPHW100308ZTR-F1							●					
Shoulder milling insert (from semi-finishing to finishing)	ZPMT100304ZER-PL		●		●	●	●		0.4				
	ZPMT100308ZER-PL	M	●		●	●	●		0.8	10.08	3.4		
	ZPMT100320ZER-PL		●		●	●	●		2				

Note) 10 inserts per case.

● : Standard stock items

○ : Stock in Japan

■ Recommended cutting conditions

MQT type with XPHT/XPBW insert for finishing side wall + MSN shank

Material	Grade	Tool dia.(mm)														
		16					20					20				
		2N					2N					4N				
		r (mm)	ap (mm)	ae (mm)	n (min ⁻¹)	Vf (mm/min)	r (mm)	ap (mm)	ae (mm)	n (min ⁻¹)	Vf (mm/min)	r (mm)	ap (mm)	ae (mm)	n (min ⁻¹)	Vf (mm/min)
Carbon steel (S50C, S55C) below 250HB	JC8015 XPHT (XPBW) (CX75)	~55	≤1.5	<0.12	12,000	4,800	~70	≤1.5	<0.12	9,600	3,840	~70	≤1.5	<0.12	9,600	7,680
		55~80	≤1.2	<0.10	9,000	3,600	70~100	≤1.2	<0.10	7,200	2,880	70~100	≤1.2	<0.10	7,200	5,760
		80~105	≤1.0	<0.10	7,200	2,880	100~130	≤1.0	<0.10	5,760	2,300	100~130	≤1.0	<0.10	5,760	4,600
		105~160	≤1.0	<0.10	6,000	2,400	130~200	≤1.0	<0.10	4,800	1,920	130~200	≤1.0	<0.10	4,800	3,840
Tool & die steel (SKD61, SKD11) below 255HB	JC8015 XPHT (XPBW) (CX75)	~55	≤1.5	<0.12	10,000	4,000	~70	≤1.5	<0.12	8,000	3,200	~70	≤1.5	<0.12	8,000	6,400
		55~80	≤1.2	<0.10	7,500	3,000	70~100	≤1.2	<0.10	6,000	2,400	70~100	≤1.2	<0.10	6,000	4,800
		80~105	≤1.0	<0.10	6,000	2,400	100~130	≤1.0	<0.10	4,800	1,920	100~130	≤1.0	<0.10	4,800	3,840
		105~160	≤1.0	<0.10	5,000	2,000	130~200	≤1.0	<0.10	4,000	1,600	130~200	≤1.0	<0.10	4,000	3,200
Mold steel (HPM7, PX5, P20) 30-36 HRC	JC8015 XPHT (XPBW) (DH102)	~55	≤1.2	<0.12	9,000	3,600	~70	≤1.2	<0.12	7,200	2,880	~70	≤1.2	<0.12	7,200	5,760
		55~80	≤1.0	<0.10	6,800	2,720	70~100	≤1.0	<0.10	5,400	2,160	70~100	≤1.0	<0.10	5,400	4,320
		80~105	≤0.8	<0.10	5,400	2,160	100~130	≤0.8	<0.10	4,320	1,730	100~130	≤0.8	<0.10	4,320	3,460
		105~160	≤0.8	<0.10	4,500	1,800	130~200	≤0.8	<0.10	3,600	1,440	130~200	≤0.8	<0.10	3,600	2,880
Mold steel (NAK80, HPM1, P21) 38-43HRC	DH102 XPBW (JC8015)	~55	≤1.0	<0.12	8,000	3,200	~70	≤1.0	<0.12	6,400	2,560	~70	≤1.0	<0.12	6,400	5,120
		55~80	≤0.8	<0.10	6,000	2,400	70~100	≤0.8	<0.10	4,800	1,920	70~100	≤0.8	<0.10	4,800	3,840
		80~105	≤0.6	<0.10	4,800	1,920	100~130	≤0.6	<0.10	3,840	1,540	100~130	≤0.6	<0.10	3,840	3,080
		105~160	≤0.6	<0.10	4,000	1,600	130~200	≤0.6	<0.10	3,200	1,280	130~200	≤0.6	<0.10	3,200	2,560
Hardened die steel (SKD61, DAC, DHA) 42-52HRC	DH102 XPBW (JC8015)	~55	≤1.0	<0.10	5,000	1,500	~70	≤1.0	<0.10	4,000	1,200	~70	≤1.0	<0.10	4,000	2,400
		55~80	≤0.8	<0.08	3,750	1,130	70~100	≤0.8	<0.08	3,000	900	70~100	≤0.8	<0.08	3,000	1,800
		80~105	≤0.6	<0.08	3,000	900	100~130	≤0.6	<0.08	2,400	720	100~130	≤0.6	<0.08	2,400	1,440
		105~160	≤0.6	<0.08	2,500	750	130~200	≤0.6	<0.08	2,000	600	130~200	≤0.6	<0.08	2,000	1,200
Hardened die steel (SKD11, SLD, DC11) 55-62HRC	DH102 XPBW	~55	≤1.0	<0.10	3,600	720	~70	≤1.0	<0.10	2,860	570	~70	≤1.0	<0.10	2,860	1,140
		55~80	≤0.8	<0.08	2,700	540	70~100	≤0.8	<0.08	2,140	430	70~100	≤0.8	<0.08	2,140	860
		80~105	≤0.6	<0.08	2,160	430	100~130	≤0.6	<0.08	1,720	340	100~130	≤0.6	<0.08	1,720	680
		105~160	≤0.6	<0.08	1,800	360	130~200	≤0.6	<0.08	1,430	290	130~200	≤0.6	<0.08	1,430	580
Grey & Nodular cast iron (FC, FCD) below 300HB	JC8015 XPBW (XPHT) (DH102)	~55	≤1.5	<0.12	12,000	6,000	~70	≤1.5	<0.12	9,600	4,800	~70	≤1.5	<0.12	9,600	9,600
		55~80	≤1.2	<0.10	9,000	4,500	70~100	≤1.2	<0.10	7,200	3,600	70~100	≤1.2	<0.10	7,200	7,200
		80~105	≤1.0	<0.10	7,200	3,600	100~130	≤1.0	<0.10	5,760	2,880	100~130	≤1.0	<0.10	5,760	5,760
		105~160	≤1.0	<0.10	6,000	3,000	130~200	≤1.0	<0.10	4,800	2,400	130~200	≤1.0	<0.10	4,800	4,800
Stainless steel (SUS304) below 250HB	JC8015 XPHT (XPBW)	~55	≤1.2	<0.12	10,000	4,000	~70	≤1.2	<0.12	8,000	3,200	~70	≤1.2	<0.12	8,000	6,400
		55~80	≤1.0	<0.10	7,500	3,000	70~100	≤1.0	<0.10	6,000	2,400	70~100	≤1.0	<0.10	6,000	4,800
		80~105	≤0.8	<0.10	6,000	2,400	100~130	≤0.8	<0.10	4,800	1,920	100~130	≤0.8	<0.10	4,800	3,840
		105~160	≤0.8	<0.10	5,000	2,000	130~200	≤0.8	<0.10	4,000	1,600	130~200	≤0.8	<0.10	4,000	3,200

Cusp height: XPHT/W

Cusp Height (μm)	ap(mm)	Cusp Height (μm)	ap(mm)
0.50	0.5	3.35	1.3
0.71	0.6	3.89	1.4
0.97	0.7	4.46	1.5
1.27	0.8	5.08	1.6
1.61	0.9	5.73	1.7
1.98	1.0	6.43	1.8
2.40	1.1	7.16	1.9
2.86	1.2	7.94	2.0

Note

- Figures to be adjusted according to machine rigidity or work rigidity.
- If chattering occurs, recommended to reduce ap and ae.
- Use air blow.

■ Recommended cutting conditions

MQT type with XPHT/XPHW insert for finishing side wall + MSN shank

Material	Grade	Tool dia.(mm)									
		25					32/35				
		5N					6N				
		r (mm)	a_p (mm)	a_e (mm)	n (min ⁻¹)	V_f (mm/min)	r (mm)	a_p (mm)	a_e (mm)	n (min ⁻¹)	V_f (mm/min)
Carbon steel (S50C, S55C) below 250HB	JC8015 XPHT (XPHW) (CX75)	~90	≤1.5	<0.12	7,640	7,640	~120	≤1.5	<0.12	5,460	6,550
		90~125	≤1.2	<0.10	5,730	5,730	120~175	≤1.2	<0.10	4,100	4,920
		125~160	≤1.0	<0.10	4,580	4,580	175~225	≤1.0	<0.10	3,280	3,940
		160~250	≤1.0	<0.10	3,820	3,820	225~320	≤1.0	<0.10	2,730	3,280
Tool & die steel (SKD61, SKD11) below 255HB	JC8015 XPHT (XPHW) (CX75)	~90	≤1.5	<0.12	6,400	6,400	~120	≤1.5	<0.12	4,550	5,460
		90~125	≤1.2	<0.10	4,800	4,800	120~175	≤1.2	<0.10	3,410	4,090
		125~160	≤1.0	<0.10	3,840	3,840	175~225	≤1.0	<0.10	2,730	3,280
		160~250	≤1.0	<0.10	3,200	3,200	225~320	≤1.0	<0.10	2,280	2,740
Mold steel (HPM7, PX5, P20) 30-36 HRC	JC8015 XPHT (XPHW) (DH102)	~90	≤1.2	<0.12	5,730	5,730	~120	≤1.2	<0.12	4,090	4,910
		90~125	≤1.0	<0.10	4,300	4,300	120~175	≤1.0	<0.10	3,070	3,680
		125~160	≤0.8	<0.10	3,440	3,440	175~225	≤0.8	<0.10	2,450	2,940
		160~250	≤0.8	<0.10	2,870	2,870	225~320	≤0.8	<0.10	2,050	2,460
Mold steel (NAK80, HPM1, P21) 38-43HRC	DH102 XPHW (JC8015)	~90	≤1.0	<0.12	5,100	5,100	~120	≤1.0	<0.12	3,640	4,370
		90~125	≤0.8	<0.10	3,830	3,830	120~175	≤0.8	<0.10	2,730	3,280
		125~160	≤0.6	<0.10	3,060	3,060	175~225	≤0.6	<0.10	2,180	2,620
		160~250	≤0.6	<0.10	2,550	2,550	225~320	≤0.6	<0.10	1,820	2,180
Hardened die steel (SKD61, DAC, DHA) 42-52HRC	DH102 XPHW (JC8015)	~90	≤1.0	<0.10	3,180	2,380	~120	≤1.0	<0.10	2,280	2,050
		90~125	≤0.8	<0.08	2,380	1,780	120~175	≤0.8	<0.08	1,710	1,540
		125~160	≤0.6	<0.08	1,910	1,430	175~225	≤0.6	<0.08	1,370	1,230
		160~250	≤0.6	<0.08	1,590	1,190	225~320	≤0.6	<0.08	1,140	1,030
Hardened die steel (SKD11, SL, DC11) 55-62HRC	DH102 XPHW	~90	≤1.0	<0.10	2,300	1,150	~120	≤1.0	<0.10	1,640	980
		90~125	≤0.8	<0.08	1,720	860	120~175	≤0.8	<0.08	1,230	740
		125~160	≤0.6	<0.08	1,380	690	175~225	≤0.6	<0.08	980	590
		160~250	≤0.6	<0.08	1,150	580	225~320	≤0.6	<0.08	820	490
Grey & Nodular cast iron (FC, FCD) below 300HB	JC8015 XPHW (XPHT) (DH102)	~90	≤1.5	<0.12	7,640	9,550	~120	≤1.5	<0.12	5,460	8,190
		90~125	≤1.2	<0.10	5,730	7,160	120~175	≤1.2	<0.10	4,100	6,150
		125~160	≤1.0	<0.10	4,580	5,720	175~225	≤1.0	<0.10	3,280	4,920
		160~250	≤1.0	<0.10	3,820	4,780	225~320	≤1.0	<0.10	2,730	4,100
Stainless steel (SUS304) below 250HB	JC8015 XPHT (XPHW)	~90	≤1.2	<0.12	6,400	6,400	~120	≤1.2	<0.12	4,550	5,460
		90~125	≤1.0	<0.10	4,800	4,800	120~175	≤1.0	<0.10	3,410	4,090
		125~160	≤0.8	<0.10	3,840	3,840	175~225	≤0.8	<0.10	2,730	3,280
		160~250	≤0.8	<0.10	3,200	3,200	225~320	≤0.8	<0.10	2,280	2,740

Cusp height: XPHT/W

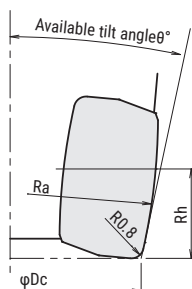
Cusp Height (μm)	a_p (mm)	Cusp Height (μm)	a_p (mm)
0.50	0.5	3.35	1.3
0.71	0.6	3.89	1.4
0.97	0.7	4.46	1.5
1.27	0.8	5.08	1.6
1.61	0.9	5.73	1.7
1.98	1.0	6.43	1.8
2.40	1.1	7.16	1.9
2.86	1.2	7.94	2.0

Note

- Figures to be adjusted according to machine rigidity or work rigidity.
- If chattering occurs, recommended to reduce a_p and a_e .
- Use air blow.

- Definition of edge shape for programming
- When using taper holder (MQT-***A03/05 type)

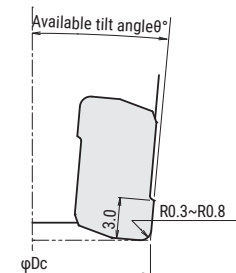
Fig.1 XPHW/T



- imensions when using XPHW / T insert

available tilt angle	Cat.No	Dimensions (mm)			Fig
		φDc	Ra	Rh	
1°~6°	MQT-2016A03-M8	15.5	R64.19	8.76	1
3°~8°	MQT-2016A05-M8	15.5	R64.34	10.98	1
1°~6°	MQT-2020A03-M10	19.5	R63.34	8.67	1
3°~8°	MQT-2020A05-M10	19.5	R63.46	10.85	1

Fig.2 YPHW

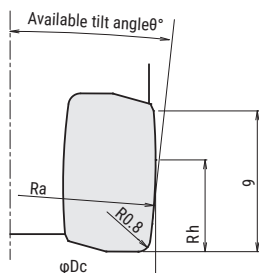


- imensions when using YPHW insert

available tilt angle	Cat.No	Dimensions (mm)	Fig
		φDc	
3°	MQT-2016A03-M8	16	2
5°	MQT-2016A05-M8	16	2
3°	MQT-2020A03-M10	20	2
5°	MQT-2020A05-M10	20	2

- When using straight holder (MQT-***A00 type)

Fig.3 XPHW/T



- Dimensions when using XPHW/T insert

available tilt angle	Cat.No	Dimensions (mm)			Fig
		φDc	Ra	Rh	
0°~3°	MQT-2016A00-M8	16	R63.27	5.48	3
0°~3°	MQT-4020A00-M10	20	R64.29	5.48	3
0°~3°	MQT-5025A00-M12	25	R63.26	5.48	3
0°~3°	MQT-6032A00-M16	32	R62.41	5.48	3
0°~3°	MQT-6035A00-M16	35	R62.16	5.48	3

- Dimensions when using YPHW insert

available tilt angle	Cat.No	Dimensions (mm)	Fig
		φDc	
0°	MQT-2016A00-M8	16	-
0°	MQT-4020A00-M10	20	-
0°	MQT-5025A00-M12	25	-
0°	MQT-6032A00-M16	32	-
0°	MQT-6035A00-M16	35	-

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