

DIJET®

DIE & MOLD SERIES

CATALOG NO. 10012

**HIGH PERFORMANCE DIE & MOLD
LIGHT CUTTING APPLICATIONS**

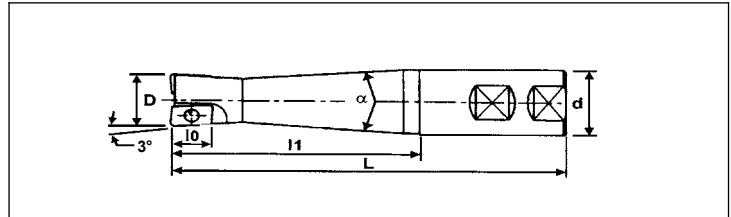
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DBD Type - Taper Style



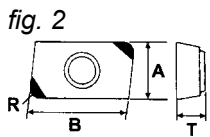
Specifications

CATALOG NUMBER	DIMENSIONS						PARTS		INSERTS	Q
	D	L	I0	I1	d	α	Screw	Wrench		
DBD-2100-1.5-S100	1.00	3.78	.656	1.50	1.00	60°	ESW-407	T-15	DBD-187...	2
DBD-2100-2.3-S100	1.00	4.58	.656	2.30	1.00	8°				
DBD-2100-3.1-S125	1.00	5.45	.656	3.17	1.25	12°				
DBD-2100-3.9-S125	1.00	6.25	.656	3.97	1.25	8°				
DBD-2100-4.7-S125	1.00	7.00	.656	4.72	1.25	6°				
DBD-2100-5.5-S125	1.00	7.78	.656	5.50	1.25	5°				
DBD-2100-6.3-S125	1.00	8.58	.656	6.30	1.25	4°30'				
DBD-2125-2.3-S125	1.25	4.58	.656	2.30	1.25	14°	ESW-408	T-15	DBD-187...	2
DBD-2125-3.1-S125	1.25	5.38	.656	3.10	1.25	6°				
DBD-2125-3.9-S150	1.25	6.62	.656	3.93	1.50	10°				
DBD-2125-4.7-S150	1.25	7.39	.656	4.70	1.50	7°				
DBD-2125-5.9-S150	1.25	8.60	.656	5.91	1.50	5°22'				
DBD-2125-6.5-S150	1.25	9.19	.656	6.50	1.50	4°30'				
DBD-2125-7.5-S150	1.25	10.19	.656	7.50	1.50	4°				
DBD-3150-2.3-S200	1.50	5.80	.656	2.30	2.00	72°	ESW-407	T-15	DBD-187...	3
DBD-3150-3.1-S200	1.50	6.00	.656	3.10	2.00	31°				
DBD-3150-3.9-S200	1.50	7.43	.656	3.93	2.00	19°				
DBD-3150-5.1-S200	1.50	8.65	.656	5.15	2.00	12°				
DBD-3150-6.3-S200	1.50	9.80	.656	6.30	2.00	9°				
DBD-3150-7.1-S200	1.50	10.60	.656	7.10	2.00	7°30'				
DBD-3150-8.1-S200	1.50	11.60	.656	8.10	2.00	6°30'				

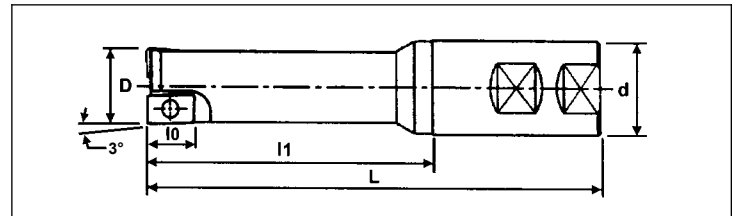
Note: All cutters are supplied without inserts.

Inserts

fig. 1 	CATALOG NUMBER	DIMENSIONS				FIG.	STOCK					
		A	B	T	R		C.B.N.		COATED		CERMET	
							JBN330	JC5015	JC5030	JC3552	CX90	
DBD-187-031	.375	.656	.187	.0312	1			•				
DBD-187-062	.375	.656	.187	.0625	1		•	•	•	•		
DBD-187-125	.375	.656	.187	.1260	1			•				
DBD-187-2	.375	.656	.187	.0625	2	•						



DBD Type - Straight Style

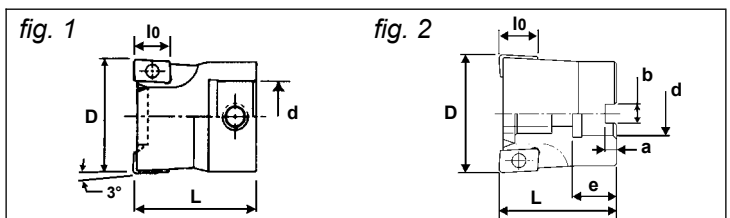


Specifications

CATALOG NUMBER	DIMENSIONS					PARTS		INSERTS	Q
	D	L	l ₀	l ₁	d	Screw	Wrench		
DBD-2100-S3.1-S125	1.00	5.45	.656	3.17	1.25	ESW-407	T-15	DBD-187...	2
DBD-2100-S3.9-S125	1.00	6.25	.656	3.97	1.25				
DBD-2100-S4.7-S125	1.00	7.00	.656	4.72	1.25				
DBD-2100-S5.5-S125	1.00	7.78	.656	5.50	1.25				
DBD-2100-S6.3-S125	1.00	8.58	.656	6.30	1.25				
DBD-2125-S3.9-S150	1.25	6.62	.656	3.93	1.50	ESW-408	T-15	DBD-187...	2
DBD-2125-S4.7-S150	1.25	7.39	.656	4.70	1.50				
DBD-2125-S5.9-S150	1.25	8.60	.656	5.91	1.50				
DBD-2125-S6.5-S150	1.25	9.19	.656	6.50	1.50				
DBD-2125-S7.5-S150	1.25	10.19	.656	7.50	1.50				
DBD-3150-S3.9-S200	1.50	7.43	.656	3.93	2.00	ESW-407	T-15	DBD-187...	3
DBD-3150-S5.1-S200	1.50	8.65	.656	5.15	2.00				
DBD-3150-S6.3-S200	1.50	9.80	.656	6.30	2.00				
DBD-3150-S7.1-S200	1.50	10.60	.656	7.10	2.00				
DBD-3150-S8.1-S200	1.50	11.60	.656	8.10	2.00				

Note: All cutters are supplied without inserts.

DBD-EC Type -Face Mill Type



Specifications

CATALOG NUMBER	DIMENSIONS							FIG.	PARTS		INSERTS	Q
	D	L	l ₀	d	a	b	e		Screw	Wrench		
DBD-4200-EC	2.00	2.25	.656	1.25	-	-	-	1	ESW-407	T-15	DBD-187...	4
DBD-4225-EC	2.25	2.25	.656	1.25	-	-	-	1	ECS-0030	A-316		4
DBD-5250-EC	2.50	2.25	.656	1.25	-	-	-	1				5
DBD-4200-75R	2.00	2.00	.656	.750	.196	.318	.750	2	ESW-407	T-15		4
DBD-5250-100R	2.50	2.00	.656	1.00	.236	.374	.945	2				5

Note: All cutters are supplied without inserts.

Table 1: Recommended Cutting Conditions for Carbide

WORK MATERIAL	INSERT GRADE	TOOL DIAMETER											
		1.00"		1.25"		1.50"		2.00"		2.25"		2.50"	
		N r.p.m.	F inch/min	N r.p.m.	F inch/min	N r.p.m.	F inch/min	N r.p.m.	F inch/min	N r.p.m.	F inch/min	N r.p.m.	F inch/min
Low Carbon Steel (HB 125 ~ 180)	JC5030, CX90 JC3552	3,100	80	2,450	65	2,050	80	1,500	80	1,350	70	1,200	80
Carbon Steel (HB 170 ~ 220)	JC5030, CX90 JC3552	2,700	75	2,200	60	1,850	75	1,350	70	1,200	65	1,100	75
Alloy Steel (HB 200 ~ 260)	JC5030, JC5015 CX90, JC3552	2,200	55	1,700	45	1,400	50	1,050	50	900	45	850	50
Tool & Die Steel (HB 280 ~ 370)	JC5030, JC5015 CX90, JC3552	1,900	50	1,500	40	1,250	45	900	45	800	40	750	45
Stainless Steel (HB 150 ~ 270)	JC5015, JC3552 CX90	2,200	55	1,700	45	1,400	50	1,050	50	900	45	850	50
Gray Cast Iron (HB 200 ~ 250)	JC5015, JC3552	2,400	80	1,900	60	1,600	75	1,150	70	1,050	65	950	70
Nodular Cast Iron (HB 180 ~ 250)	JC5015, JC3552	1,900	60	1,500	50	1,250	60	900	55	800	50	750	60

Note: Above data is relevant to tools with ratio (Reach/Dia.) of 4xs and below. For tools above 4xs, see Table 3.

Table 2: Recommended Cutting Conditions for CBN

WORK MATERIAL	INSERT GRADE	TOOL DIAMETER											
		1.00"		1.25"		1.50"		2.00"		2.25"		2.25"	
		N r.p.m.	F inch/min	N r.p.m.	F inch/min	N r.p.m.	F inch/min	N r.p.m.	F inch/min	N r.p.m.	F inch/min	N r.p.m.	F inch/min
Carbon Steel (HRC 55 ~ 65)	JBN330	1,350	18	1,050	14	900	18	650	18	600	16	550	18
Carbon Steel (HRC 45 ~ 55)	JBN330	2,150	30	1,700	24	1,400	28	1,050	28	950	26	850	30
Alloy Steel (HB 200 ~ 260)	JBN330	3,750	100	3,000	80	2,500	100	1,850	100	1,650	90	1,500	100
Gray Cast Iron (HB 200 ~ 250)	JBN330	5,000	135	4,000	110	3,300	135	2,500	135	2,200	120	2,000	135
Nodular Cast Iron (HB 180 ~ 250)	JBN330	3,750	100	3,000	80	2,500	100	1,850	100	1,650	90	1,500	100

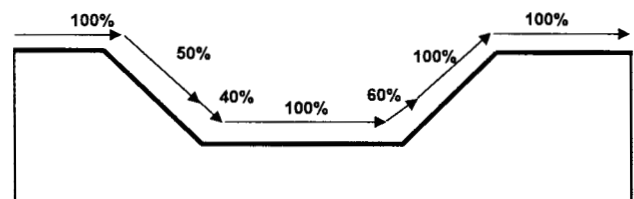
Note: Above data is relevant to tools with ratio (Reach/Dia.) of 4xs and below. For tools above 4xs, see Table 3.

Table 3: Additional Cutting Data for Longer Tools

REACH / DIA.	4.0 ~ 4.5	4.5 ~ 5.3	5.3 ~ 5.7	5.7 ~ 6.2	6.3 ~
rpm %	90	80	80	75	70
feed %	90	90	80	75	70

Note: The above percentages should be applied for longer tools.

Reduced Cutting Data for Cutting Pattern



Note: Feed should be reduced when cutting the above pattern.

