



DIE & MOLD SERIES

CATALOG NO. 10011

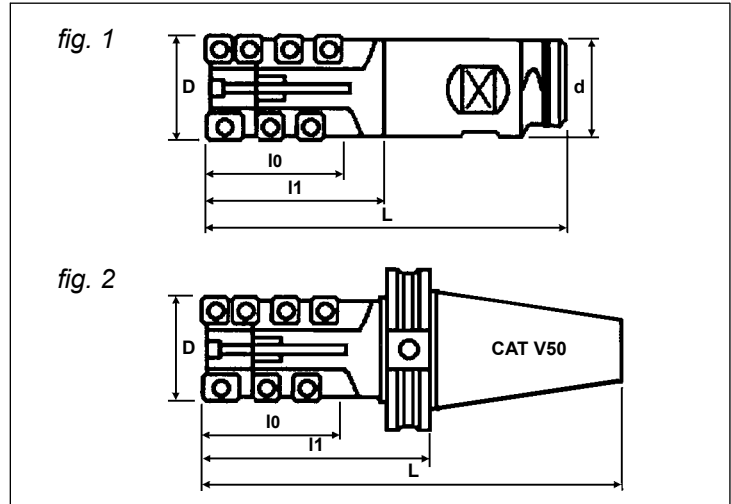
**HIGH PERFORMANCE DIE & MOLD
FOR SHOULDER & GROOVING
ROUGHING APPLICATIONS**

EXCITER MILL



DIJET INCORPORATED
www.dijetusa.com

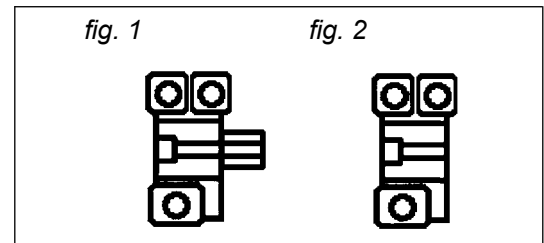
DXE Type End Cap Mounted Type



Specifications

CATALOG NUMBER	DIMENSIONS					FIG.	PARTS		INSERTS			
	D	L	I0	I1	d		Screw	Wrench	Nose	Q	PERIPHERY	Q
20DXE-040-N2NPN	2.00	8.50	4.00	5.25	2.00	1	EXW-510	T-20	IM-CP43N	2	IM-SP43GS	20
20DXE-050-N2NPN	2.00	9.00	5.00	6.25	2.00	1					IM-SP43GS	24
20DXE-060-N2NPN	2.00	10.50	6.00	7.25	2.00	1					IM-SP43GS	30
20DXE-050-NCV5	2.00	11.00	5.00	7.00	CV50	2					IM-SP43GS	24
25DXE-040-NCV5	2.50	10.00	4.00	6.00	CV50	2	EXW-510	T-20	IM-CP43N	2	IM-SP43GS	20
25DXE-060-NCV5	2.50	12.00	6.00	8.00	CV50						IM-SP43GS	30
30DXE-040-NCV5	3.00	10.00	4.00	6.00	CV50	2	EXW-510	T-20	IM-CP43N	2	IM-SP43GS	20
30DXE-060-NCV5	3.00	12.00	6.00	8.00	CV50						IM-SP43GS	30
30DXE-085-NCV5	3.00	14.50	8.50	10.50	CV50						IM-SP43GS	42

DXCP Type



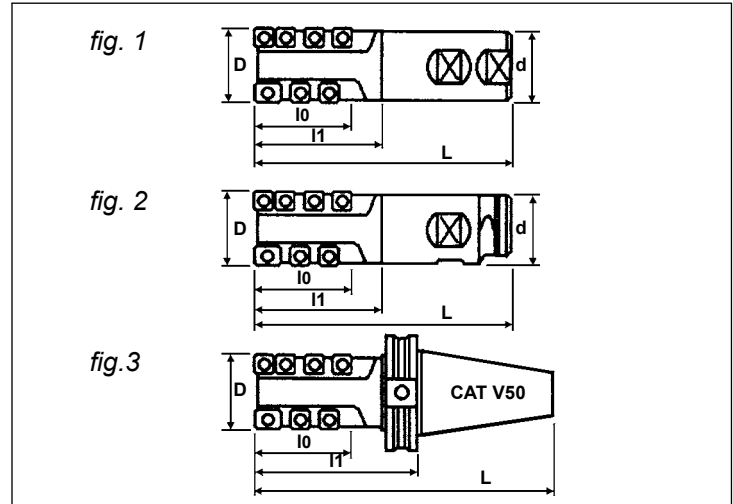
Specifications

APPLICABLE HOLDERS	CATALOG NUMBER	FIG.	PARTS				INSERTS			
			CLAMP BOLT	KEY	SCREW	WRENCH	NOSE	Q	PERIPHERY	Q
20DXE...	20DXCP-N	1	EES-1055		EXW-510	T-20	IM-CP43N	2	IM-SP43GS	4
25DXE...	25DXCP-N	2	EES-1250	EXK-2.5	EXW-510	T-20	IM-CP43N	2	IM-SP43GS	4
30DXE...	30DXCP-N	2	EES-1250	EXK-3.0	EXW-510	T-20	IM-CP43N	2	IM-SP43GS	4

Note: All cutters are supplied without inserts.



DXS Type Solid Cutter Body Type

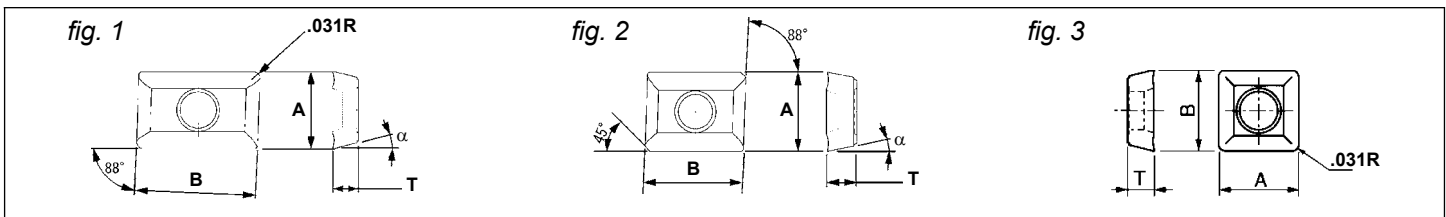


Specifications

CATALOG NUMBER	DIMENSIONS					FIG.	PARTS		INSERTS			
	D	L	l0	l1	d		Screw	Wrench	Nose	Q	PERIPHERY	Q
125DXS-020-NW125	1.25	5.00	2.00	2.72	1.25	1	CSW-407	T-15SD	IM-CP32N	2	IM-SP32GS	14
125DXS-040-NW125	1.25	7.00	4.00	4.72	1.25						IM-SP32GS	32
150DXS-020-NW150	1.50	5.50	2.00	2.80	1.50	1	CSW-407	T-15SD	IM-CP32N	2	IM-SP32GS	14
150DXS-040-NW150	1.50	7.50	4.00	4.80	1.50						IM-SP32GS	32
150DXS-060-NW150	1.50	9.50	6.00	6.80	1.50						IM-SP32GS	48
20DXS-030-N2NPN	2.00	7.08	3.00	3.80	2.00	2	EXW-510	T-20	IM-CP43N	2	IM-SP43GS	14
20DXS-030-NCV5	2.00	9.00	3.00	5.00	CV50	3					IM-SP43GS	14
25DXS-040-NCV5	2.50	10.00	4.00	6.00	CV50	3	EXW-510	T-20	IM-CP43N	2	IM-SP43GS	20
25DXS-060-NCV5	2.50	12.00	6.00	8.00	CV50						IM-SP43GS	30

Note: All cutters are supplied without inserts.

Inserts

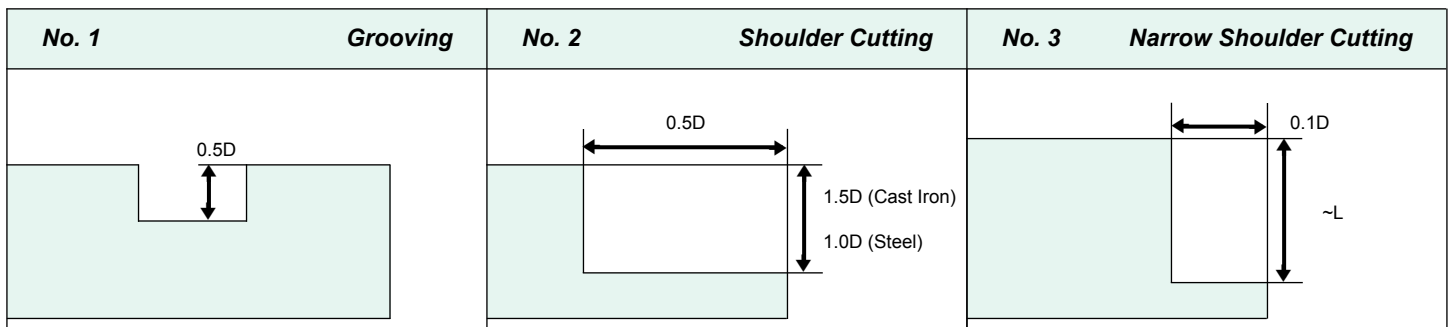


APPLICABLE HOLDERS	CATALOG NUMBER	DIMENSIONS				FIG.	STOCK							
		A	B	T	α		COATED							
							JC5030	JC5040	JC3562	JC5015	JC3521	UNCOATED		
125DXS...	IM-CP32N	.375	.500	.125	14°	1	•			•				
150DXS...	IM-SP32GS	.375	.375	.125	14°	3	•			•				
20DX...	IM-CP43N	.500	.625	.187	11°	2	•	•	•	•	•			
25DX...							•	•	•	•	•			
30DX...	IM-SP43GS	.500	.500	.187	11°	3	•	•	•	•	•			

Recommended Cutting Conditions

WORK MATERIAL	INSERT GRADE	TYPE	TOOL DIAMETER									
			1.25"		1.50"		2.00"		2.50"		3.00"	
			<i>N</i> r.p.m.	<i>F</i> inch/min	<i>N</i> r.p.m.	<i>F</i> inch/min	<i>N</i> r.p.m.	<i>F</i> inch/min	<i>N</i> r.p.m.	<i>F</i> inch/min	<i>N</i> r.p.m.	<i>F</i> inch/min
Cast Iron (HB 150)	JC5015	No. 1	800	14	650	12	500	9	400	7	340	6
	JC3562	No. 2	900	18	750	15	560	11	450	9	380	7
	JC3521	No. 3	900	29	750	24	560	18	450	15	380	12
Gray Cast Iron (~HB 220)	JC5015	No. 1	720	13	600	11	450	8	360	7	300	5
	JC3562	No. 2	800	16	650	13	500	10	400	8	340	6
	JC3521	No. 3	800	27	650	23	500	17	400	13	340	10
Carbon & Alloy Steel (~HB 250)	JC5040	No. 1	720	11	600	9	450	7	360	5	300	4
	JC5030	No. 2	800	16	650	13	500	10	400	8	340	6
	JC3562	No. 3	800	27	650	23	500	17	400	13	340	10
Alloy Tool Steel (~HB 255)	JC5040	No. 1	450	6	420	5	290	4	220	3	190	2
	JC5030	No. 2	500	8	420	7	310	5	250	4	210	3
	JC3562	No. 3	500	13	650	11	310	8	250	6	210	5
Low Carbon Steel (~HB 200)	JC5040	No. 1	800	13	650	11	500	8	400	6	340	5
	JC5030	No. 2	900	18	750	15	560	11	450	9	380	7
	JC3562	No. 3	900	29	750	24	580	18	450	15	380	12

Cutting Type

No. 1	Grooving	No. 2	Shoulder Cutting	No. 3	Narrow Shoulder Cutting
					


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