

DIJET[®]

FACE MILLING SERIES

CATALOG NO. 30002

FACE MILLING APPLICATIONS

MIGHTY BLADER & OCTOBLADER



DIJET INCORPORATED
www.dijetusa.com

Mighty Blader

MIG (Face Mill Style)

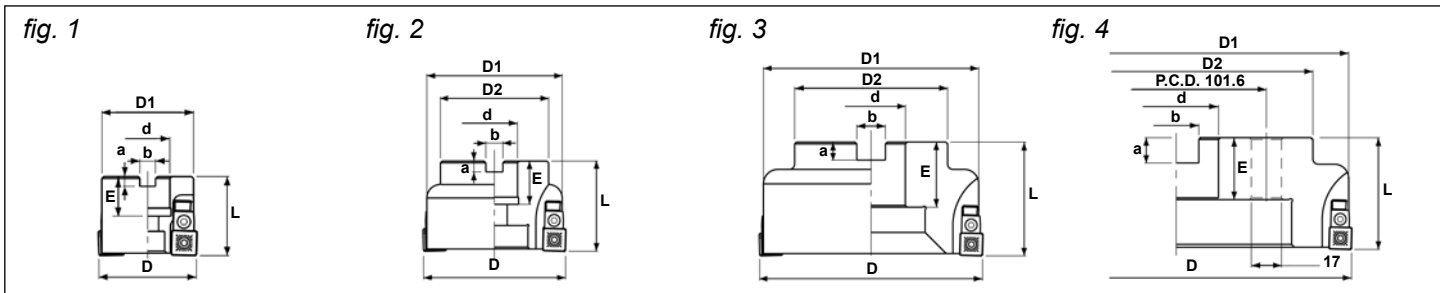


Multi-purpose 90° lead face mill for molds, dies, and other similar type work pieces.



Entering Angle	: 90°	A.R. : +10°
		R.R. : -10°
Max. D.O.C.		: .430"

Specifications



CATALOG NUMBER	DIMENSIONS									FIG.	INSERT NUMBER	Q
	D	D1	D2	L	d	a	b	E				
MIG-4200-75R	2.00	1.80	-	2.00	.750	.196	.315	.750	1	SDMT1204PDER	4	
MIG-5250-100R	2.50	2.32	1.73	2.00	1.00	.236	.375	.750	2	SDMT1204PDER	5	
MIG-6300-100R	3.00	2.82	2.17	2.00	1.00	.236	.375	.750	2	SDMT1204PDER	6	
MIG-8400-150R	4.00	3.80	2.76	2.48	1.50	.393	.625	1.00	2	SDMT1204PDER	8	
MIG-10125R	4.92	4.71	3.35	2.48	1.50	.393	.625	1.41	3	SDMT1204PDER	10	
MIG-12160R	6.30	6.08	4.72	2.48	2.00	.433	.748	1.45	3	SDMT1204PDER	12	
MIG-12200-250R	7.87	7.65	6.06	2.48	2.50	.562	1.00	1.50	4	SDMT1204PDER	12	

Note: All cutters are supplied without inserts.

Inserts

	CATALOG NUMBER	DIMENSIONS			STOCK					
		A	R	T	COATED			CERMET		UNCOATED
					JC5040					
SDMT1204PDER	.500	.031	.187	.						

Parts

INSERT SCREW	BODY SAVER	CLAMP SCREW	ADJUST BUTTON	ADJ. BUTTON SCREW	WRENCH
EXW-412	BSV43S-1	HCS4-10	RB-14	LS-113	T-15SD

Octoblader

OCT Type

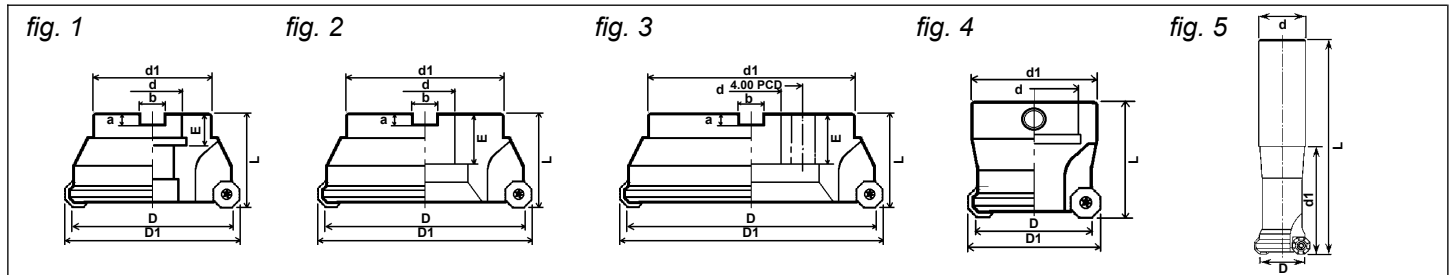


The multi-purpose milling cutter from general steel to die steel and stainless steel.



Entering Angle	:-	A.R. : +8°
		R.R. : -2°30'
Max. D.O.C.		: .400"

Specifications



CATALOG NUMBER	DIMENSIONS									FIG.	INSERT NUMBER	Q
	D	D1	L	d	d1	a	b	E				
OCT-4240-075R	2.00	2.40	2.00	.750	1.73	.169	.318	.750	1	ODMT0606AEN or ODMW0606AEN	4	
OCT-4250-100R	2.10	2.50	2.00	1.00	1.97	.236	.375	.750	1		4	
OCT-5290-100R	2.50	2.90	2.00	1.00	1.97	.236	.375	.750	1		5	
OCT-5300-100R	2.60	3.00	2.00	1.00	2.28	.236	.375	.750	1		5	
OCT-6340-100R	3.00	3.40	2.00	1.00	2.28	.236	.375	.750	1		6	
OCT-6400-150R	3.60	4.00	2.36	1.50	2.76	.393	.625	1.41	2		6	
OCT-06100R	3.94	4.33	2.36	1.25	2.76	.314	.500	1.25	2		6	
OCT-08125R	4.92	5.32	2.36	1.50	3.35	.393	.625	1.41	2		8	
OCT-10160R	6.30	6.69	2.36	2.00	4.72	.433	.750	1.45	2		10	
OCT-12200R	7.87	8.27	2.48	1.875	6.06	.562	1.00	1.37	3		12	
OCT-12200-250R	7.87	8.27	2.48	2.50	6.06	.562	1.00	1.37	3		12	
OCT-4200-EC	1.59	2.00	2.25	1.25	2.00	-	-	-	4		4	
OCT-2150-1.5-S100	1.09	1.50	4.50	1.00	1.50	-	-	-	5		2	
OCT-3200-1.5-S125	1.59	2.00	4.50	1.25	1.50	-	-	-	5		3	

Note: All cutters are supplied without inserts.

Inserts

	CATALOG NUMBER	DIMENSIONS			STOCK		
		A	B	T	COATED		
					JC5040	JC8015	
	ODMT0606AEN	.630	.630	.216	•	•	
	ODMW0606AEN*	.630	.630	.216		•	

* Use this insert for cast iron materials

Parts

SCREW	WRENCH
ESW-510	T-25SD

for EC Type

SCREW	WRENCH
ECS-0030	A-316

Recommended Cutting Conditions For Mighty Blader

WORK MATERIAL	INSERT GRADE	SFM IPT	TOOL DIAMETER													
			2.00" (4 teeth)		2.50" (5 teeth)		3.00" (6 teeth)		4.00" (8 teeth)		5.00" (10 teeth)		6.00" (12 teeth)		8.00" (12 teeth)	
			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	N r.p.m.	F inch/min
Low Carbon Steel (HB 180 ~ 280)	JC5040	800 .016	1,528	98	1,222	98	1,019	98	764	98	611	98	509	98	382	73
Carbon Steel (HB 180 ~ 280)	JC5040	650 .016	1,241	79	993	79	828	79	621	79	497	79	414	79	310	60
Alloy Steel (HB 180 ~ 280)	JC5040	550 .012	1,050	50	840	50	700	50	525	50	420	50	350	50	263	38
Tool & Die Steel (HRC30 ~ 40)	JC5040	400 .008	764	24	611	24	509	24	382	24	306	24	255	24	191	18
Stainless Steel (HB 150 ~ 270)	JC5040	500 .008	955	31	764	31	637	31	477	31	382	31	318	31	239	23
Gray Cast Iron (HB 200 ~ 250)	JC5040	800 .018	1,528	110	1,222	110	1,019	110	764	110	611	110	509	110	382	83
Nodular Cast Iron (HB 180 ~ 250)	JC5040	600 .014	1,146	64	917	64	764	64	573	64	458	64	382	64	286	48
Aluminum (HB 180 ~ 250)	JC5040	2,000 .010	3,820	153	3,056	153	2,547	153	1,910	153	1,528	153	1,273	153	955	115

Recommended Cutting Conditions For Octoblader

WORK MATERIAL	INSERT GRADE	SFM IPT	TOOL DIAMETER (teeth)															
			1.50" (2 teeth)		2.00" (3 / 4 teeth)		2.50" (4 / 5 teeth)		3.00" (5 / 6 teeth)		4.00" (6 teeth)		5.00" (8 teeth)		6.00" (10 teeth)		8.00" (12 teeth)	
			MAX D.O.C. = .400" (use 4 corners) / .160" (use 8 corners)															
			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	N r.p.m.	F inch/min	N r.p.m.	F inch/min
Low Carbon Steel (HB 180 ~ 280)	JC5040 JC8015	800 .016	2,038	65	1,528	73/98	1,222	78/98	1,019	82/98	784	73	611	78	509	81	382	73
Carbon Steel (HB 180 ~ 280)	JC5040 JC8015	650 .016	1,655	53	1,241	60/79	993	64/79	828	66/79	621	60	497	64	414	66	310	60
Alloy Steel (HB 180 ~ 280)	JC5040 JC8015	550 .012	1,401	34	1,050	38/50	840	40/50	700	42/50	525	38	420	40	350	42	263	38
Tool & Die Steel (HRC30 ~ 40)	JC5040 JC8015	400 .008	1,019	16	764	18/24	611	20/24	509	20/24	382	18	306	20	255	20	191	18
Stainless Steel (HB 150 ~ 270)	JC8015	500 .008	1,273	20	955	23/31	764	24/31	637	26/31	477	23	382	24	318	25	239	23
Gray Cast Iron (HB 200 ~ 250)	JC8015	800 .018	2,037	73	1,528	83/110	1,222	88/110	1,019	92/110	764	83	611	88	509	92	382	83
Nodular Cast Iron (HB 180 ~ 250)	JC8015	600 .014	1,528	43	1,146	48/64	917	51/64	764	53/64	573	48	458	51	382	53	286	48
Aluminum Alloy (HB 180 ~ 250)	JC5040	2,000 .010	5,093	102	3,820	115/153	3,056	122/153	2,547	128/153	1,910	115	1,528	122	1,273	127	955	115

Feed Rate should be reduced on the below cutting styles:

- Plunging 30%
- Ramping 50%
- Grooving 60%


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