



DIE & MOLD SERIES

CATALOG NO. 10014

**HIGH PERFORMANCE DIE & MOLD
SEMI-FINISHING TO
ROUGH APPLICATIONS**

SIDE CHIPPER



DIJET INCORPORATED
www.dijetusa.com

Side Chipper



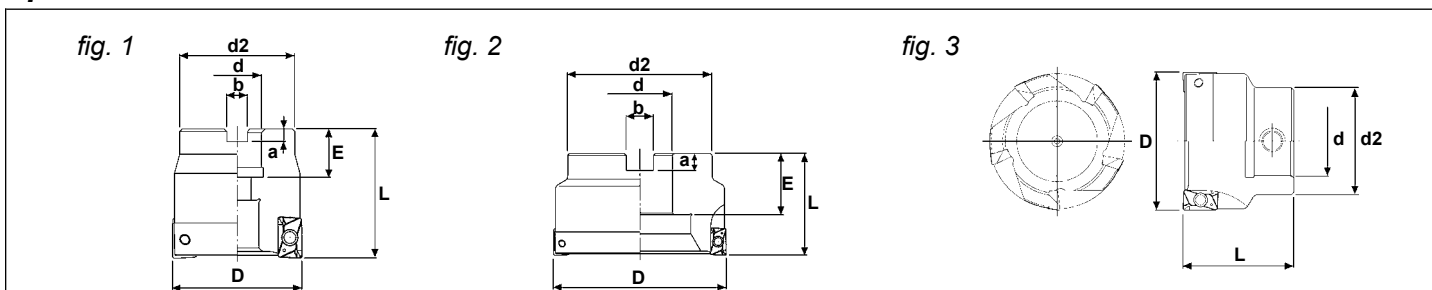
Face Mill Style



The 3D insert geometry provides lower cutting forces & excellent chip ejection.

Entering Angle	: 90°	A.R. : +4°
		R.R. : -1° - 4°
Max. D.O.C.		: .500"

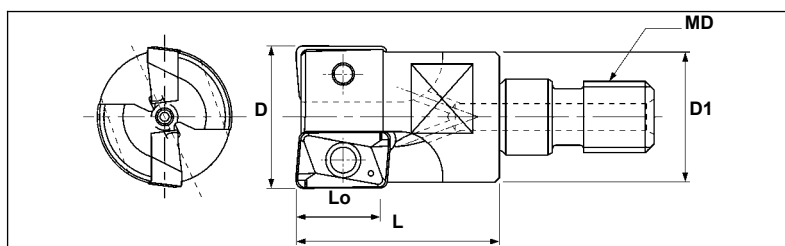
Specifications



CATALOG NUMBER	DIMENSIONS							PARTS		FIG.	INSERTS	Q
	D	L	d	d2	a	b	E	SCREW	WRENCH			
SIC-4200-075R	2.00	2.00	.750	1.77	.196	.318	.750	TSW-408	T-15SD	1	ZPMT1604..R	4
SIC-5250-100R	2.50	2.00	1.00	2.16	.236	.374	.945			1	ZPMT1604..R	5
SIC-6300-100R	3.00	2.00	1.00	2.36	.236	.374	.945			1	ZPMT1604..R	6
SIC-8400-150R	4.00	2.36	1.50	3.34	.393	.626	1.41			2	ZPMT1604..R	8
SIC-4200-EC	2.00	2.00	1.25	1.94	-	-	-	TSW-408	T-15SD	3	ZPMT1604..R	4
SIC-5250-EC	2.50	2.00	1.25	1.93	-	-	-	ECS-0030	A-316	3	ZPMT1604..R	5

Note: All cutters are supplied without inserts.

Modular Head Style

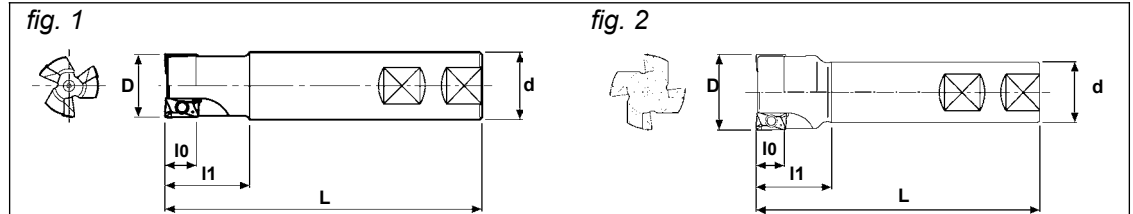


Specifications

CATALOG NUMBER	DIMENSIONS					HEAD TORQUE lbs./ft	PARTS		INSERT
	D	L	Lo	D1	MD		Screw	Wrench	
MIC-2062-M8	.625	.900	.400	.591	M8	16.9	ESW-206	T-08SD	ZCMT1003..R (2)
MIC-2075-M10	.750	1.18	.500	.728	M10	33.9	A2301-2364-1	T-10SD	ZPMT13T3..R (2)
MIC-3075-M10	.750	1.18	.400	.728	M10	33.9	ESW-206	T-08SD	ZCMT1003..R (3)
MIC-2100-M12	1.00	1.38	.600	.945	M12	59	TSW-408	T-15SD	ZPMT1604..R (2)
MIC-3100-M12	1.00	1.38	.500	.941	M12	59	DSW-0307	T-10SD	ZPMT13T3..R (3)
MIC-2125-M16	1.25	1.69	.600	1.14	M16	66.3	TSW-408	T-15SD	ZPMT1604..R (2)
MIC-3125-M16	1.25	1.69	.600	1.14	M16	66.3	TSW-408	T-15SD	ZPMT1604..R (3)

Note: All cutters are supplied without inserts.

End Mill Style




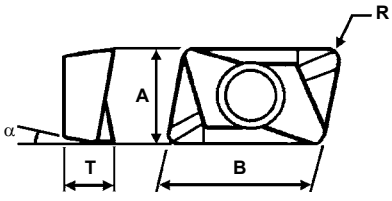
Specifications

CATALOG NUMBER	DIMENSIONS					PARTS		FIG	INSERTS	q
	D	L	l0	l1	d	Screw	Wrench			
SICS-2062-S062	.625	3.25	.400	1.12	.625	ESW-206	T-08SD	1	ZCMT1003..R	2
SICM-2062-S062	.625	4.00	.400	1.97	.625					2
SICS-2075-S075	.750	4.00	.500	1.25	.750	A2301-2364-1	T-10SD	1	ZPMT13T3..R	2
SICM-2075-S075	.750	5.00	.500	2.97	.750					2
SICL-2075-S100	.750	7.00	.500	4.00	1.00					2
SICS-3075-S075	.750	4.00	.400	1.25	.750	ESW-206	T-08SD	1	ZCMT1003..R	3
SICM-3075-S075	.750	5.00	.400	2.97	.750					3
SICL-3075-S100	.750	7.00	.400	4.00	1.00					3
SICS-2100-S100	1.00	4.00	.600	1.25	1.00	TSW-408	T-15SD	1	ZPMT1604..R	2
SICM-2100-S100	1.00	5.00	.600	2.72	1.00					2
SICL-2100-S125	1.00	6.00	.600	4.00	1.25					2
SICS-3100-S100	1.00	4.00	.500	1.25	1.00	DSW-0307	T-10SD	1	ZPMT13T3..R	3
SICM-3100-S100	1.00	5.00	.500	2.72	1.00					3
SICL-3100-S125	1.00	7.00	.500	4.00	1.25					3
SICS-2125-S125	1.25	5.50	.600	2.50	1.25	TSW-408	T-15SD	1	ZPMT1604..R	2
SICM-2125-S125	1.25	6.00	.600	4.00	1.25					2
SICS-3125-S125	1.25	4.00	.600	1.75	1.25	TSW-408	T-15SD	1	ZPMT1604..R	3
SICM-3125-S125	1.25	6.00	.600	3.72	1.25					3
SICL-3125-S125	1.25	8.00	.600	5.50	1.25					3
SICS-4150-S125	1.50	4.00	.600	1.75	1.25	TSW-408	T-15SD	2	ZPMT1604..R	4
SICM-4150-S125	1.50	6.00	.600	3.72	1.25					4
SICL-4150-S125	1.50	8.50	.600	5.75	1.25					4
SICS-4150-S150	1.50	4.00	.600	1.75	1.50	TSW-408	T-15SD	1	ZPMT1604..R	4
SICM-4150-S150	1.50	6.00	.600	3.72	1.50					4
SICL-4150-S150	1.50	8.50	.600	5.75	1.50					4

Note: All cutters are supplied without inserts.




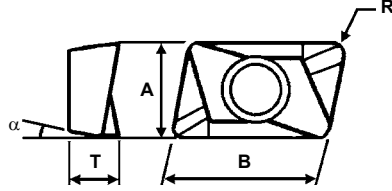
Inserts

 	CATALOG NUMBER	DIMENSIONS					STOCK		
		A	B	T	R	α	COATED		
							JC5015	JC5040	JC8015
ZCMT100304R	.250	.409	.134	.015	7°	★	★		
ZCMT100308R	.250	.409	.134	.031	7°	•	•	★	
ZPMT13T308R	.312	.500	.156	.031	11°	•	•	★	
ZPMT13T316R	.312	.500	.156	.063	11°	•	•	★	
ZPMT13T320R	.312	.500	.156	.078	11°	•	•	★	
ZPMT160404R	.375	.625	.187	.015	11°	★	★		
ZPMT160408R	.375	.625	.187	.031	11°	•	•	★	
ZPMT160416R	.375	.625	.187	.063	11°	•	•	★	
ZPMT160420R	.375	.625	.187	.078	11°	•	•	★	
**ZPMT160430R	.375	.625	.187	.118	11°	•	•	★	
**ZPMT160432R	.375	.625	.187	.126	11°	•	•	★	

**Note: Body must be modified to .059" radius or .047" chamfer at corner to use these inserts.

★ Coming Soon

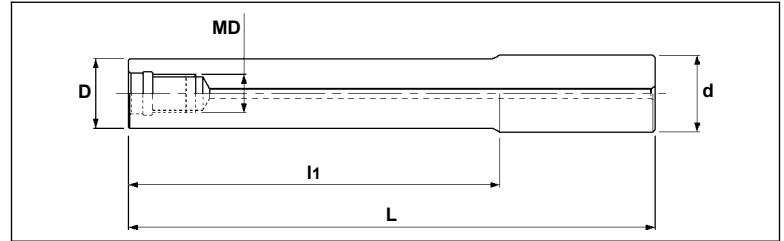
Polished Inserts for Aluminum

 	CATALOG NUMBER	DIMENSIONS					STOCK
		A	B	T	R	α	UNCOATED
							FZ15
ZCMT100308RP	.250	.409	.134	.031	7°	•	
ZPMT13T308RP	.312	.500	.156	.031	11°	•	
ZPMT13T316RP	.312	.500	.156	.063	11°	•	
ZPMT13T320RP	.312	.500	.156	.078	11°	•	
ZPMT160408RP	.375	.625	.187	.031	11°	•	
ZPMT160416RP	.375	.625	.187	.063	11°	•	
ZPMT160420RP	.375	.625	.187	.078	11°	•	
**ZPMT160430RP	.375	.625	.187	.118	11°	•	
**ZPMT160432RP	.375	.625	.187	.126	11°	•	

**Note: Body must be modified to .059" radius or .047" chamfer at corner to use these inserts.

Modular Head Holders

Carbide Holder with Coolant Hole



Specifications

CATALOG NUMBER	DIMENSIONS					APPLICABLE HOLDERS
	D	l1	L	d	MD	
MSN-M8-2.0-S062C	.591	2.00	5.00	.625	M8	MIC-2062-M8
MSN-M8-4.0-S062C	.591	4.00	7.00	.625	M8	
MSN-M8-6.0-S062C	.591	6.00	9.00	.625	M8	
MSN-M10-2.0-S075C	.728	2.00	5.00	.750	M10	MIC-2075-M10, MIC-3075-M10
MSN-M10-4.0-S075C	.728	4.00	7.00	.750	M10	
MSN-M10-6.0-S075C	.728	6.00	9.00	.750	M10	
MSN-M12-2.0-S100C	.945	2.00	5.00	1.00	M12	MIC-2100-M12, MIC-3100-M12
MSN-M12-4.0-S100C	.945	4.00	7.00	1.00	M12	
MSN-M12-6.0-S100C	.945	6.00	9.00	1.00	M12	
MSN-M12-8.0-S100C	.945	8.00	11.00	1.00	M12	
MSN-M16-2.0-S125C	1.14	2.00	5.00	1.25	M16	MIC-2125-M16, MIC-3125-M16
MSN-M16-4.0-S125C	1.14	4.00	7.00	1.25	M16	
MSN-M16-6.0-S125C	1.14	6.00	9.00	1.25	M16	
MSN-M16-8.0-S125C	1.14	8.00	11.00	1.25	M16	

Nominal Cutting Speed and Feed Values for MIC - with Carbide Holder

WORK MATERIAL	INSERT GRADE	MIC-2062-M8				MIC-2075-M10				MIC-3075-M10				MIC-2100-M12			
		L1 total*	DOC	N rpm	F ipm	L1 total*	DOC	N rpm	F ipm	L1 total*	DOC	N rpm	F ipm	L1 total*	DOC	N rpm	F ipm
Gray Cast Iron (HB200 ~ 250)	JC5015 JC5040	3.0"	.020	3,000	71	3.25"	.030	2,400	55	3.25"	.030	2,400	63	3.50"	.040	1,800	42
		5.0"	.020	3,000	65	5.25"	.020	2,400	55	5.25"	.020	2,400	62	5.50"	.020	1,800	42
		7.0"	.010	2,500	48	7.25"	.010	2,200	60	7.25"	.010	2,000	55	7.50"	.010	1,600	37
															9.50"	N/A	N/A
Nodular Cast Iron (HB180 ~ 250)	JC5015 JC5040	3.0"	.020	3,000	70	3.25"	.030	2,400	55	3.25"	.030	2,400	63	3.50"	.040	1,800	42
		5.0"	.020	3,000	65	5.25"	.020	2,400	55	5.25"	.030	2,400	63	5.50"	.020	1,800	42
		7.0"	.010	2,500	48	7.25"	.010	2,400	60	7.25"	.010	2,000	55	7.50"	.010	1,600	37
															9.50"	N/A	N/A
Carbon Steel (HB180 ~ 280)	JC5040 JC5015	3.0"	.020	3,500	86	3.25"	.030	2,900	55	3.25"	.030	2,900	75	3.50"	.040	2,100	42
		5.0"	.020	3,200	63	5.25"	.020	2,900	55	5.25"	.020	2,500	65	5.50"	.020	2,100	42
		7.0"	.010	2,900	55	7.25"	.010	2,500	45	7.25"	.010	2,400	61	7.50"	.010	1,800	35
															9.50"	.010	1,600
Alloy Steel (HB180 ~ 280)	JC5040 JC5015	3.0"	.020	2,500	50	3.25"	.030	2,500	45	3.25"	.030	2,500	60	3.50"	.040	1,900	33
		5.0"	.020	2,500	50	5.25"	.020	2,500	45	5.25"	.020	2,500	60	5.50"	.020	1,900	33
		7.0"	.010	2,500	35	7.25"	.010	2,500	50	7.25"	.010	2,400	60	7.50"	.010	1,800	31
															9.50"	.010	1,600
Pre-Hardened Steel (HB180 ~ 255)	JC5040 JC5015	3.0"	.020	1,400	14	3.25"	.020	1,000	11	3.25"	.020	1,100	16	3.50"	.030	825	10
		5.0"	.010	1,200	12	5.25"	.020	1,000	10	5.25"	.012	950	13	5.50"	.020	700	8
		7.0"	N/A	N/A	N/A	7.25"	N/A	N/A	N/A	7.25"	N/A	N/A	N/A	7.50"	N/A	N/A	N/A
															9.50"	N/A	N/A
Tool & Die Steel (HB180 ~ 255)	JC5040 JC5015	3.0"	.020	3,200	63	3.25"	.030	2,500	45	3.25"	.030	2,500	60	3.50"	.040	1,900	33
		5.0"	.020	3,200	63	5.25"	.020	2,500	45	5.25"	.020	2,500	60	5.50"	.020	1,900	33
		7.0"	.010	3,000	60	7.25"	.010	2,500	50	7.25"	.010	2,400	60	7.50"	.010	1,800	31
															9.50"	.010	1,600
Stainless Steel (HB150 ~ 250)	JC5015 JC5040	3.0"	.020	3,200	63	3.25"	.030	2,600	45	3.25"	.030	2,600	60	3.50"	.040	1,900	33
		5.0"	.020	3,200	62	5.25"	.020	2,600	45	5.25"	.020	2,400	55	5.50"	.020	1,800	31
		7.0"	.010	3,000	60	7.25"	.010	2,500	45	7.25"	.008	2,400	55	7.50"	.010	1,800	31
															9.50"	N/A	N/A
Aluminum Alloy (HB30 ~ 100)	FZ15	3.0"	.040	3,200	75	3.25"	.040	3,000	50	3.25"	.040	3,000	65	3.50"	.060	1,800	50
		5.0"	.040	3,200	75	5.25"	.040	3,000	50	5.25"	.040	3,000	65	5.50"	.040	1,800	50
		7.0"	.020	3,000	60	7.25"	.020	3,000	55	7.25"	.020	2,800	55	7.50"	.030	1,800	45
															9.50"	.020	1,600

* L1 Total (Overhang) = Modular Head length "L" + Modular Head Holder "L1"

Notes:

1. Speeds and Feeds should be adjusted according to the machine and work rigidity.
2. If chattering occurs, reduce the DOC or RPM by 30% and keep the feed per tooth the same.
3. In case of full slotting, it is recommended to reduce the RPM and IPM to 70% of the above.
4. Ramping up to 3 degrees is recommended.
5. Maximum width of cut not to exceed 60% of diameter.

Nominal Cutting Speed and Feed Values for MIC - with Carbide Holder

WORK MATERIAL	INSERT GRADE	MIC-3100-M12				MIC-2125-M16				MIC-3125-M16			
		L1 total*	DOC	N rpm	F ipm	L1 total*	DOC	N rpm	F ipm	L1 total*	DOC	N rpm	F ipm
Gray Cast Iron (HB200 ~ 250)	JC5015 JC5040	3.50"	.040	1,900	32	3.75"	.060	1,500	35	3.75"	.060	1,500	43
		5.50"	.020	1,900	30	5.75"	.040	1,500	35	5.75"	.040	1,500	43
		7.50"	.020	1,600	40	7.75"	.020	1,250	30	7.75"	.020	1,250	37
		9.50"	.020	1,400	35	9.75"	.010	1,250	35	9.75"	.010	1,200	40
Nodular Cast Iron (HB180 ~ 250)	JC5015 JC5040	3.50"	.040	1,900	32	3.75"	.060	1,500	35	3.75"	.060	1,500	43
		5.50"	.020	1,900	30	5.75"	.040	1,500	35	5.75"	.040	1,500	43
		7.50"	.020	1,600	40	7.75"	.020	1,250	30	7.75"	.020	1,250	37
		9.50"	.020	1,400	40	9.75"	.010	1,250	35	9.75"	.010	1,250	40
Carbon Steel (HB180 ~ 280)	JC5040 JC5015	3.50"	.040	2,300	60	3.75"	.060	1,800	35	3.75"	.060	1,800	42
		5.50"	.020	2,300	60	5.75"	.040	1,800	35	5.75"	.040	1,800	38
		7.50"	.010	1,900	48	7.75"	.020	1,500	30	7.75"	.020	1,500	38
		9.50"	.010	1,800	45	9.75"	.010	1,500	35	9.75"	.010	1,400	40
Alloy Steel (HB180 ~ 280)	JC5040 JC5015	3.50"	.040	2,000	48	3.75"	.060	1,600	28	3.75"	.060	1,600	34
		5.50"	.020	2,000	48	5.75"	.040	1,600	28	5.75"	.040	1,600	34
		7.50"	.010	1,900	45	7.75"	.020	1,500	26	7.75"	.020	1,500	35
		9.50"	.010	1,700	45	9.75"	.010	1,400	30	9.75"	.010	1,400	38
Pre-Hardened Steel (HB180 ~ 255)	JC5040 JC5015	3.50"	.030	890	13	3.75"	.030	700	8	3.75"	.040	700	10
		5.50"	.015	765	10	5.75"	.020	600	7	5.75"	.020	600	9
		7.50"	N/A	N/A	N/A	7.75"	.010	600	7	7.75"	.010	600	9
		9.50"	N/A	N/A	N/A	9.75"	.001	600	9	9.75"	N/A	N/A	N/A
Tool & Die Steel (HB180 ~ 255)	JC5040 JC5015	3.50"	.040	2,000	48	3.75"	.060	1,600	28	3.75"	.060	1,600	33
		5.50"	.020	2,000	48	5.75"	.040	1,600	28	5.75"	.040	1,600	33
		7.50"	.010	1,900	44	7.75"	.020	1,500	26	7.75"	.020	1,500	34
		9.50"	.010	1,700	35	9.75"	.010	1,400	30	9.75"	.010	1,400	35
Stainless Steel (HB150 ~ 250)	JC5015 JC5040	3.50"	.040	2,000	48	3.75"	.060	1,600	28	3.75"	.060	1,600	33
		5.50"	.020	1,900	44	5.75"	.040	1,500	26	5.75"	.040	1,500	33
		7.50"	.010	1,900	40	7.75"	.020	1,500	26	7.75"	.020	1,500	34
		9.50"	N/A	N/A	N/A	9.75"	.010	1,400	25	9.75"	N/A	N/A	N/A
Aluminum Alloy (HB30 ~ 100)	FZ15	3.50"	.060	2,200	45	3.75"	.060	1,500	40	3.75"	.060	1,600	50
		5.50"	.040	2,200	45	5.75"	.060	1,500	40	5.75"	.040	1,600	50
		7.50"	.020	1,900	40	7.75"	.040	1,250	30	7.75"	.020	1,600	45
		9.50"	.010	1,900	40	9.75"	.020	1,250	35	9.75"	.010	1,500	50

* L1 Total (Overhang) = Modular Head length "L" + Modular Head Holder "L1"

Notes:

1. Speeds and Feeds should be adjusted according to the machine and work rigidity.
2. If chattering occurs, reduce the DOC or RPM by 30% and keep the feed per tooth the same.
3. In case of full slotting, it is recommended to reduce the RPM and IPM to 70% of the above.
4. Ramping up to 3 degrees is recommended.
5. Maximum width of cut not to exceed 60% of diameter.

Nominal Cutting speed and feed values (Face Mill Style)

WORK MATERIAL	INSERT GRADE	CUTTING SPEED V (ft / min)	SIC-4200...		SIC-5250...		SIC-6300...		SIC-8400...	
			N (rpm)	F (ipm)	N (rpm)	F (ipm)	N (rpm)	F (ipm)	N (rpm)	F (ipm)
Gray Cast Iron (HB200 ~ 250)	JC5015, JC5040	590	1,150	78	900	73	750	69	560	65
Nodular Cast Iron (HB180 ~ 250)	JC5015, JC5040	530	1,000	59	800	55	680	52	500	49
Carbon Steel (HB180 ~ 280)	JC5040	490	950	51	750	48	620	46	470	43
Alloy Steel (HB180 ~ 280)	JC5040	470	900	41	720	38	600	36	450	34
Pre-Hardened Steel (HB180 ~ 255)	JC5015, JC5040	430	820	37	650	34	550	33	400	31
Tool & Die Steel (HB180 ~ 255)	JC5040	430	820	37	650	34	550	33	400	31
Stainless Steel (HB150 ~ 250)	JC5015, JC5040	400	760	29	600	27	500	26	380	24
Aluminum Alloy (HB30 ~ 100)	JC5015, JC5040	1200	2,300	172	1,850	160	1,500	150	1,150	143
Inconel, Titanium ~HRc 30	JC5015, JC5040	90	230	2.71	180	2.53	150	2.41	120	2.26
Max Depth O.C.			.500"		.500"		.500"		.500"	
Max Width O.C.			1.5"		1.875"		2.25"		3"	

- Note: 1. In case of occurring chatter, the revolution should be reduced by 30%.
 2. Recommended Max Width of Cut is 60% x diameter.

Nominal Cutting speed and feed values (End Mill Style)

WORK MATERIAL	INSERT GRADE	CUTTING SPEED V (ft / min)	TOOL DIAMETER									
			.625" (2 teeth)		.750" (2/3 teeth)		1.00" (2/3 teeth)		1.25" (2/3 teeth)		1.50" (4 teeth)	
			N (rpm)	F (ipm)	N (rpm)	F (ipm)	N (rpm)	F (ipm)	N (rpm)	F (ipm)	N (rpm)	F (ipm)
Gray Cast Iron (HB200 ~ 250)	JC5015, JC5040	590	3,600	83	3,000	73 / 104	2,250	55 / 78	1,800	44 / 63	1,500	69
Nodular Cast Iron (HB180 ~ 250)	JC5015, JC5040	530	3,200	63	2,700	55 / 78	2,000	41 / 59	1,600	33 / 47	1,350	52
Carbon Steel (HB180 ~ 280)	JC5040	490	3,000	55	2,500	48 / 69	1,850	36 / 51	1,500	29 / 41	1,250	46
Alloy Steel (HB180 ~ 280)	JC5040	470	2,900	44	2,400	38 / 54	1,800	29 / 41	1,450	23 / 33	1,200	36
Pre-Hardened Steel (HB180 ~ 255)	JC5015, JC5040	430	2,600	39	2,200	34 / 49	1,650	26 / 37	1,300	21 / 30	1,100	33
Tool & Die Steel (HB180 ~ 255)	JC5040	430	2,600	39	2,200	34 / 49	1,650	26 / 37	1,300	21 / 30	1,100	33
Stainless Steel (HB150 ~ 250)	JC5015, JC5040	400	2,500	32	2,050	27 / 39	1,500	20 / 29	1,200	16 / 23	1,000	26
Aluminum Alloy (HB30 ~ 100)	JC5015, JC5040	1200	7,350	183	6,000	161 / 230	4,500	120 / 172	3,600	97 / 138	3,000	153
Inconel, Titanium ~HRc 30	JC5015, JC5040	120	730	2.87	600	2.53 / 3.61	450	1.90 / 2.71	370	1.52 / 2.17	300	2.41
Max Depth O.C.			.120"		.350"		.500"		.500"		.500"	
Max Width O.C.			.625"		.750"		1.00"		1.25"		1.50"	

- Note: 1. Above data is relevant to tools with ratio (Reach/Dia.) of 4xs and below. For tools above 4xs, see table below.
 2. If chattering occurs, reduce RPM by 30%.

Additional Cutting Data For Longer Tools

Reach/Dia.	~4.0	4.0~4.5	4.5~5.3
rpm %	100	90	80
feed %	100	90	90



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