



MILLING - INDEXABLE

Cutter Series (Angle x Depth of Cut)

- DN5G DN6G (45° x 0.165")
- DG6G (20° x .070")
- DN5K DN6K (45° x 0.235")
- DG6K (20° x 0.100")

Insert Series

- SQGU11
- SQGU14

Diameter Range

1.50-8.00" (40-200 mm)

Lead Angles

- 45°
- 20° (hi-feed)

Materials

- Steel
- Iron

DIPOSQUADF™

45° and Hi-Feed Face Mills that share the same High-Strength, 8-Edge Insert

- » Extreme geometry enjoys heavy feed rates and promotes efficient chip evacuation.
- » Offered with 2 insert IC sizes for depth-of-cut and density diversity.
- » Integrated wiper flats produce 32-63 Ra finishes.



11 mm



14 mm



20°



45°



COMPLETE METALWORKING SOLUTIONS
(800) 991-4225 www.ahbinc.com
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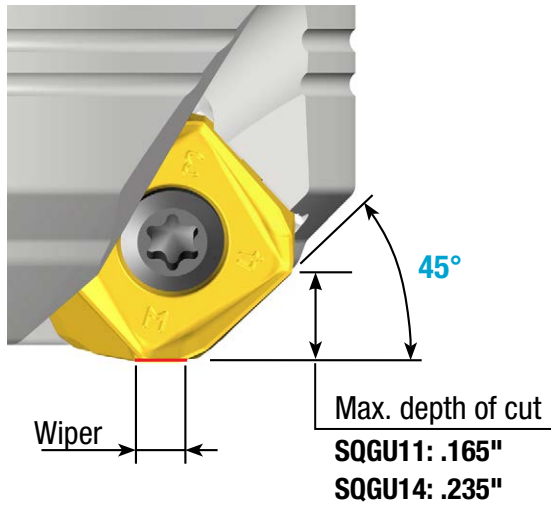
See it in
action! »



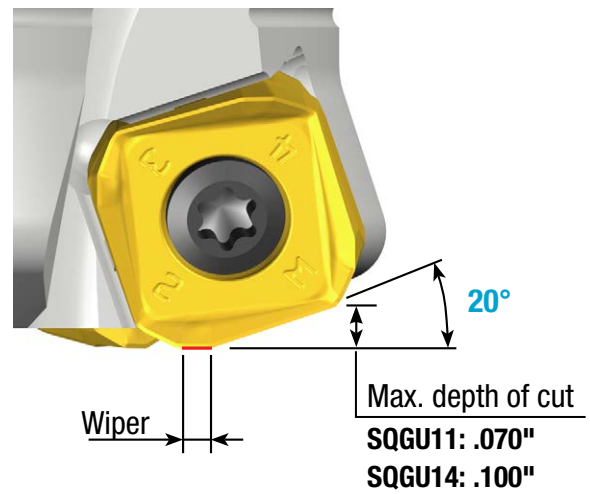
Features & Benefits

- Economical double-sided 8-corner insert
- Two lead angle cutters for roughing and high-feed machining

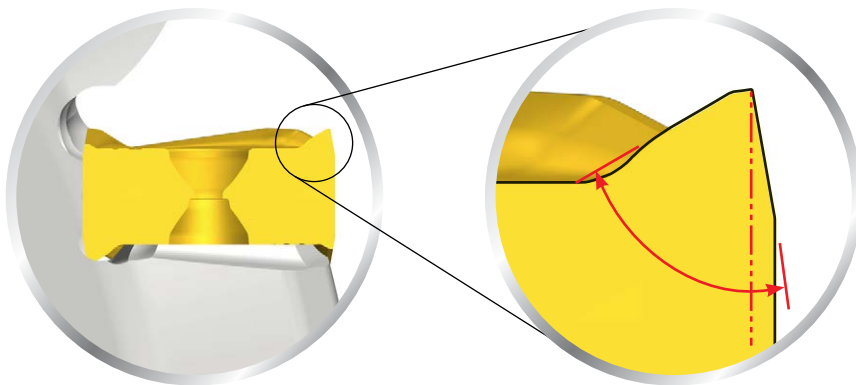
45° cutters: deep depth of cut for roughing



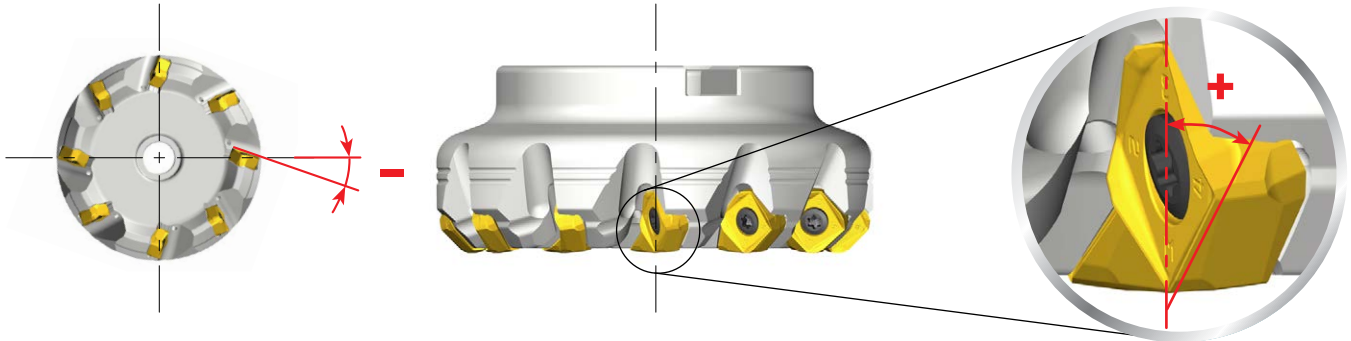
20° cutters: for high feed milling



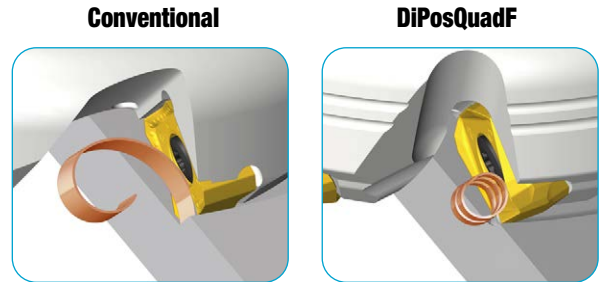
- Wiper edge for excellent surface roughness
Note: good visual roughness requires feed rate adjustment
- Reinforced edge optimized for high feed machining



- High negative radial rake angle and high positive axial rake angle

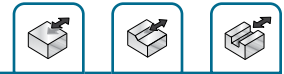


- Excellent chip evacuation due to reduced chip volume
- Enhanced body rigidity for excellent machining performance under harsh cutting conditions
- Fine pitch cutter maximizes productivity



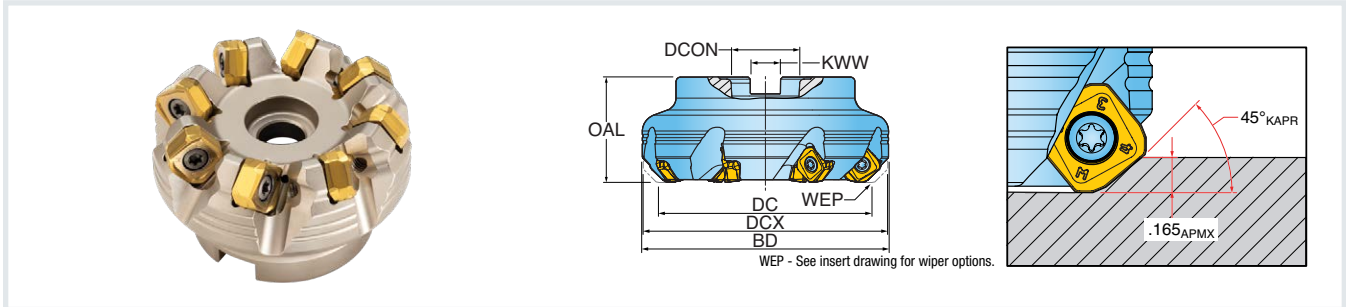
| Conventional cutter | DiPosQuadF cutter | |
|--|--|---|
| | Normal pitch | Fine pitch |
| <p>Reduced body rigidity</p> <p>Reduced body rigidity due to the wider space for insert clamping and chip evacuation</p> | <p>Improved body rigidity</p> <p>Improved body rigidity and ideal chip evacuation in the narrowest space</p> | <p>Larger number of teeth for higher productivity</p> |

Face Lead Angle Channel



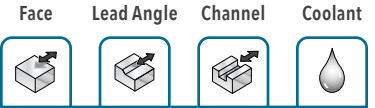
11 mm • Series DN5G, DN6G

45° FACE MILL

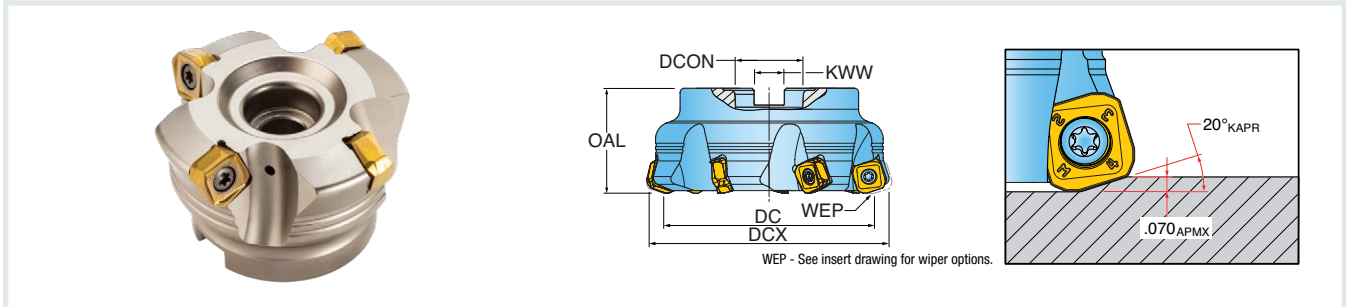


| Part Number | DC Cutting Diameter | DCX Cutting Diameter Max. | OAL Overall Length | ZEFF Eff. Teeth | BD Body Diameter | DCON Bore Diameter | KWW Keyway | CSP Coolant |
|---------------|---------------------|---------------------------|--------------------|-----------------|------------------|--------------------|------------|-------------|
| INCH | | | | | | | | |
| DN6G-15R01 | 1.500 | 1.93 | 1.570 | 4 | 1.97 | 0.5000 | 0.250 | Yes |
| DN5G-15R01 | 1.500 | 1.93 | 1.570 | 6 | 1.97 | 0.5000 | 0.250 | Yes |
| DN6G-20R01 | 2.000 | 2.43 | 1.750 | 6 | 2.47 | 0.7500 | 0.312 | Yes |
| DN5G-20R01 | 2.000 | 2.43 | 1.750 | 8 | 2.47 | 0.7500 | 0.312 | Yes |
| DN6G-25R01 | 2.500 | 2.93 | 1.750 | 7 | 2.97 | 1.0000 | 0.375 | Yes |
| DN5G-25R01 | 2.500 | 2.93 | 1.750 | 10 | 2.97 | 1.0000 | 0.375 | Yes |
| DN6G-30R01 | 3.000 | 3.43 | 1.750 | 8 | 3.47 | 1.0000 | 0.375 | Yes |
| DN5G-30R01 | 3.000 | 3.43 | 1.750 | 12 | 3.47 | 1.0000 | 0.375 | Yes |
| DN6G-40R01 | 4.000 | 4.43 | 2.375 | 9 | 4.47 | 1.5000 | 0.625 | Yes |
| DN5G-40R01 | 4.000 | 4.43 | 2.375 | 14 | 4.47 | 1.5000 | 0.625 | Yes |
| DN6G-50R01 | 5.000 | 5.43 | 2.375 | 12 | 5.47 | 1.5000 | 0.625 | Yes |
| DN5G-50R01 | 5.000 | 5.43 | 2.375 | 18 | 5.47 | 1.5000 | 0.625 | Yes |
| DN6G-60R01 | 6.000 | 6.43 | 2.375 | 16 | 6.47 | 1.5000 | 0.625 | No |
| DN5G-60R01 | 6.000 | 6.43 | 2.375 | 24 | 6.47 | 1.5000 | 0.625 | No |
| METRIC | | | | | | | | |
| DN5G040R00 | 40.00 mm | 51.0 mm | 40.00 mm | 6 | 52.0 mm | 16.000 mm | 8.40 mm | Yes |
| DN6G040R00 | 40.00 mm | 51.0 mm | 40.00 mm | 4 | 52.0 mm | 16.000 mm | 8.40 mm | Yes |
| DN5G050R00 | 50.00 mm | 61.0 mm | 40.00 mm | 8 | 62.0 mm | 22.000 mm | 10.40 mm | Yes |
| DN6G050R00 | 50.00 mm | 61.0 mm | 40.00 mm | 6 | 62.0 mm | 22.000 mm | 10.40 mm | Yes |
| DN5G063R00 | 63.00 mm | 74.0 mm | 50.00 mm | 10 | 75.0 mm | 22.000 mm | 10.40 mm | Yes |
| DN6G063R00 | 63.00 mm | 74.0 mm | 50.00 mm | 7 | 75.0 mm | 22.000 mm | 10.40 mm | Yes |
| DN5G080R00 | 80.00 mm | 91.0 mm | 50.00 mm | 12 | 92.0 mm | 27.000 mm | 12.40 mm | Yes |
| DN6G080R00 | 80.00 mm | 91.0 mm | 50.00 mm | 8 | 92.0 mm | 27.000 mm | 12.40 mm | Yes |
| DN5G100R00 | 100.00 mm | 111.0 mm | 50.00 mm | 14 | 112.0 mm | 32.000 mm | 14.40 mm | Yes |
| DN6G100R00 | 100.00 mm | 111.0 mm | 50.00 mm | 9 | 112.0 mm | 32.000 mm | 14.40 mm | Yes |
| DN5G125R00 | 125.00 mm | 136.0 mm | 63.00 mm | 18 | 137.0 mm | 40.000 mm | 16.40 mm | Yes |
| DN6G125R00 | 125.00 mm | 136.0 mm | 63.00 mm | 12 | 137.0 mm | 40.000 mm | 16.40 mm | Yes |
| DN5G160R00 | 160.00 mm | 171.0 mm | 63.00 mm | 24 | 172.0 mm | 40.000 mm | 16.40 mm | No |
| DN6G160R00 | 160.00 mm | 171.0 mm | 63.00 mm | 16 | 172.0 mm | 40.000 mm | 16.40 mm | No |

11 mm • Series DG6G



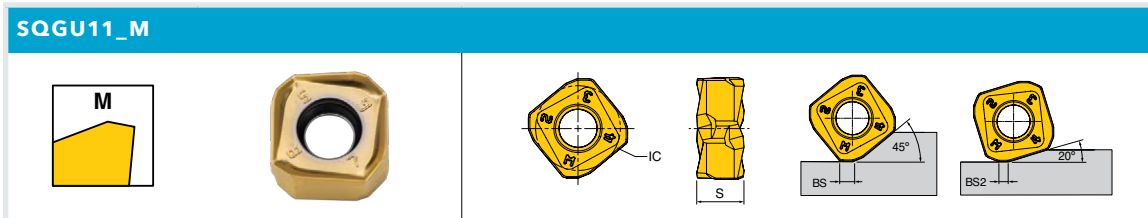
20° FACE MILL • HI-FEED



| Part Number | DC Cutting Diameter | DCX Cutting Diameter Max. | OAL Overall Length | ZEFF Eff. Teeth | DCON Bore Diameter | KWW Keyway | CSP Coolant |
|---------------|---------------------|---------------------------|--------------------|-----------------|--------------------|------------|-------------|
| INCH | | | | | | | |
| DG6G-20R01 | 2.000 | 2.53 | 1.570 | 4 | 0.7500 | 0.312 | Yes |
| DG6G-25R01 | 2.500 | 3.03 | 1.750 | 5 | 1.0000 | 0.375 | Yes |
| DG6G-30R01 | 3.000 | 3.53 | 1.750 | 6 | 1.0000 | 0.375 | Yes |
| DG6G-40R01 | 4.000 | 4.53 | 2.375 | 8 | 1.5000 | 0.625 | Yes |
| METRIC | | | | | | | |
| DG6G050R00 | 50.00 mm | 63.50 mm | 40.00 mm | 4 | 22.00 mm | 10.40 mm | Yes |
| DG6G063R00 | 63.00 mm | 76.50 mm | 50.00 mm | 5 | 22.00 mm | 10.40 mm | Yes |
| DG6G080R00 | 80.00 mm | 93.50 mm | 50.00 mm | 6 | 27.00 mm | 12.40 mm | Yes |
| DG6G100R00 | 100.00 mm | 113.50 mm | 50.00 mm | 8 | 32.00 mm | 14.40 mm | Yes |

11 mm • Inserts

FOR SERIES DN5G, DN6G, AND DG6G



| Part Number | Application | BS Wiper Length | BS2 Wiper Length | IC Inscribed Circle Dia. | S Thickness | NOI Number of Indexes | IH Insert Hand | Grade | | |
|---------------|---------------|-----------------|------------------|--------------------------|-------------|-----------------------|----------------|--------|--------|--------|
| | | | | | | | | IN2505 | IN2510 | IN6537 |
| SQGU1105ANR-M | Multi-Purpose | 0.075 | 0.039 | 0.44 | 0.248 | 8 | Right | • | • | • |

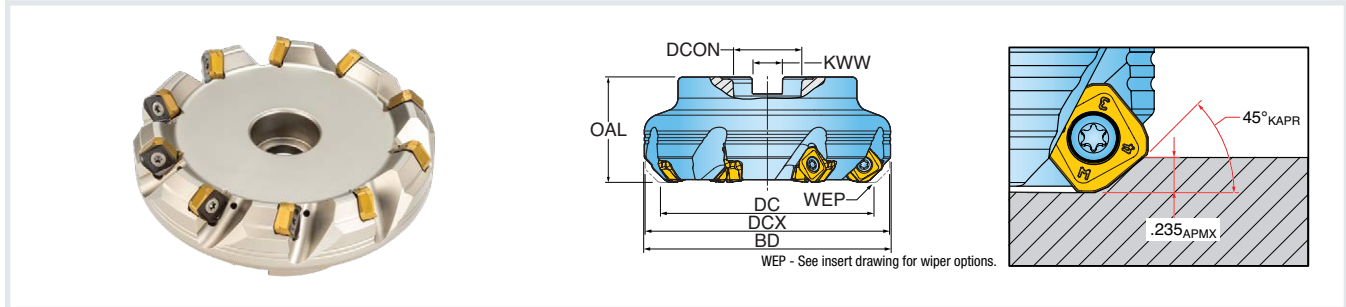
11 mm • Hardware

| Part Number | | | | | Optional | | | |
|---------------|-------------|---------------|-------------------|----------------|------------------------|----------------------|-----------------------|-------------------|
| | Screw | Driver Handle | Torx Driver Blade | Retention Bolt | Coolant Retention Bolt | Torque Driver Handle | Preset Torque Adapter | Torque Driver Bit |
| INCH | | | | | | | | |
| DN6G-15R01 | SM40-115-00 | DS-A00T | DS-T156B | SD-04-46 | - | DS-A00-.25-T | DT-35-.25 | DS-T15B1 |
| DN5G-15R01 | SM40-115-00 | DS-A00T | DS-T156B | SD-04-46 | - | DS-A00-.25-T | DT-35-.25 | DS-T15B1 |
| DN6G-20R01 | SM40-115-00 | DS-A00T | DS-T156B | SD-06-47 | SD-06-A6 | DS-A00-.25-T | DT-35-.25 | DS-T15B1 |
| DN5G-20R01 | SM40-115-00 | DS-A00T | DS-T156B | SD-06-47 | SD-06-A6 | DS-A00-.25-T | DT-35-.25 | DS-T15B1 |
| DN6G-25R01 | SM40-115-00 | DS-A00T | DS-T156B | SD-08-47 | SD-08-C9 | DS-A00-.25-T | DT-35-.25 | DS-T15B1 |
| DN5G-25R01 | SM40-115-00 | DS-A00T | DS-T156B | SD-08-47 | SD-08-C9 | DS-A00-.25-T | DT-35-.25 | DS-T15B1 |
| DN6G-30R01 | SM40-115-00 | DS-A00T | DS-T156B | SD-08-47 | SD-08-C9 | DS-A00-.25-T | DT-35-.25 | DS-T15B1 |
| DN5G-30R01 | SM40-115-00 | DS-A00T | DS-T156B | SD-08-47 | SD-08-C9 | DS-A00-.25-T | DT-35-.25 | DS-T15B1 |
| DN6G-40R01 | SM40-115-00 | DS-A00T | DS-T156B | SD-12-82 | SD-12-99 | DS-A00-.25-T | DT-35-.25 | DS-T15B1 |
| DN5G-40R01 | SM40-115-00 | DS-A00T | DS-T156B | SD-12-82 | SD-12-99 | DS-A00-.25-T | DT-35-.25 | DS-T15B1 |
| DN6G-50R01 | SM40-115-00 | DS-A00T | DS-T156B | SD-12-82 | SD-12-99 | DS-A00-.25-T | DT-35-.25 | DS-T15B1 |
| DN5G-50R01 | SM40-115-00 | DS-A00T | DS-T156B | SD-12-82 | SD-12-99 | DS-A00-.25-T | DT-35-.25 | DS-T15B1 |
| DN6G-60R01 | SM40-115-00 | DS-A00T | DS-T156B | - | - | DS-A00-.25-T | DT-35-.25 | DS-T15B1 |
| DN5G-60R01 | SM40-115-00 | DS-A00T | DS-T156B | - | - | DS-A00-.25-T | DT-35-.25 | DS-T15B1 |
| DG6G-20R01 | SM40-115-00 | DS-A00T | DS-T156B | SD-06-47 | SD-06-A6 | DS-A00-.25-T | DT-35-.25 | DS-T15B1 |
| DG6G-25R01 | SM40-115-00 | DS-A00T | DS-T156B | SD-08-47 | SD-08-C9 | DS-A00-.25-T | DT-35-.25 | DS-T15B1 |
| DG6G-30R01 | SM40-115-00 | DS-A00T | DS-T156B | SD-08-47 | SD-08-C9 | DS-A00-.25-T | DT-35-.25 | DS-T15B1 |
| DG6G-40R01 | SM40-115-00 | DS-A00T | DS-T156B | SD-12-82 | SD-12-99 | DS-A00-.25-T | DT-35-.25 | DS-T15B1 |
| METRIC | | | | | | | | |
| DN5G040R00 | SM40-115-00 | DS-A00T | DS-T156B | SHM8X1.25X25 | SHM8X1.25X25-C | DS-A00-.25-T | DT-35-.25 | DS-T15B1 |
| DN6G040R00 | SM40-115-00 | DS-A00T | DS-T156B | SHM8X1.25X25 | SHM8X1.25X25-C | DS-A00-.25-T | DT-35-.25 | DS-T15B1 |
| DN5G050R00 | SM40-115-00 | DS-A00T | DS-T156B | SHLM10X1.5X25 | SHLM10X1.5X25-C | DS-A00-.25-T | DT-35-.25 | DS-T15B1 |
| DN6G050R00 | SM40-115-00 | DS-A00T | DS-T156B | SHLM10X1.5X25 | SHLM10X1.5X25-C | DS-A00-.25-T | DT-35-.25 | DS-T15B1 |
| DN5G063R00 | SM40-115-00 | DS-A00T | DS-T156B | SHM10X1.5X30 | SHM10X1.5X30-C | DS-A00-.25-T | DT-35-.25 | DS-T15B1 |
| DN6G063R00 | SM40-115-00 | DS-A00T | DS-T156B | SHM10X1.5X30 | SHM10X1.5X30-C | DS-A00-.25-T | DT-35-.25 | DS-T15B1 |
| DN5G080R00 | SM40-115-00 | DS-A00T | DS-T156B | SHLM12X1.75X30 | SHLM12X1.75X30-C | DS-A00-.25-T | DT-35-.25 | DS-T15B1 |
| DN6G080R00 | SM40-115-00 | DS-A00T | DS-T156B | SHLM12X1.75X30 | SHLM12X1.75X30-C | DS-A00-.25-T | DT-35-.25 | DS-T15B1 |
| DN5G100R00 | SM40-115-00 | DS-A00T | DS-T156B | SHLM16X2X35 | SHLM16X2X35-C | DS-A00-.25-T | DT-35-.25 | DS-T15B1 |
| DN6G100R00 | SM40-115-00 | DS-A00T | DS-T156B | SHLM16X2X35 | SHLM16X2X35-C | DS-A00-.25-T | DT-35-.25 | DS-T15B1 |
| DN5G125R00 | SM40-115-00 | DS-A00T | DS-T156B | SHM20X2.5X40 | SHM20X2.5X40-C | DS-A00-.25-T | DT-35-.25 | DS-T15B1 |
| DN6G125R00 | SM40-115-00 | DS-A00T | DS-T156B | SHM20X2.5X40 | SHM20X2.5X40-C | DS-A00-.25-T | DT-35-.25 | DS-T15B1 |
| DN5G160R00 | SM40-115-00 | DS-A00T | DS-T156B | - | - | DS-A00-.25-T | DT-35-.25 | DS-T15B1 |
| DN6G160R00 | SM40-115-00 | DS-A00T | DS-T156B | - | - | DS-A00-.25-T | DT-35-.25 | DS-T15B1 |
| DG6G050R00 | SM40-115-00 | DS-A00T | DS-T156B | SHM10X1.5X30 | SHM10X1.5X30-C | DS-A00-.25-T | DT-35-.25 | DS-T15B1 |
| DG6G063R00 | SM40-115-00 | DS-A00T | DS-T156B | SHM10X1.5X30 | SHM10X1.5X30-C | DS-A00-.25-T | DT-35-.25 | DS-T15B1 |
| DG6G080R00 | SM40-115-00 | DS-A00T | DS-T156B | SHM12X1.75X35 | SHM12X1.75X35-C | DS-A00-.25-T | DT-35-.25 | DS-T15B1 |
| DG6G100R00 | SM40-115-00 | DS-A00T | DS-T156B | SHLM16X2X35 | SHLM16X2X35-C | DS-A00-.25-T | DT-35-.25 | DS-T15B1 |



14 mm • Series DN5K, DN6K

45° FACE MILL



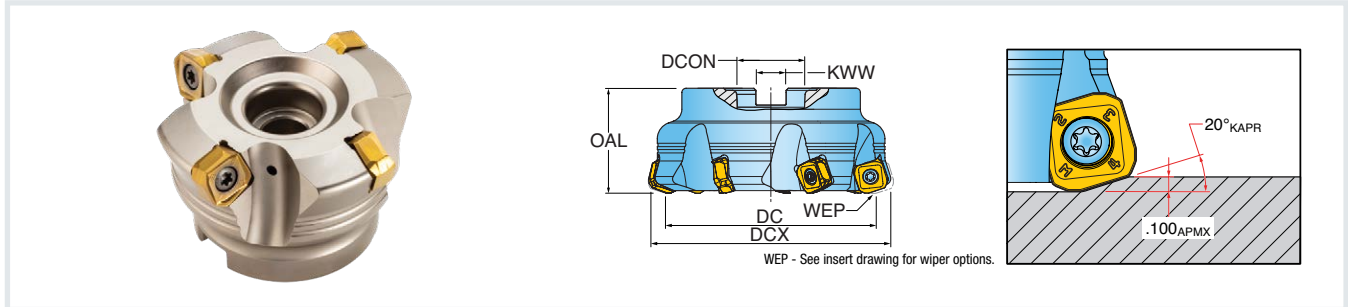
| Part Number | DC Cutting Dia. | DCX Cutting Dia. Max. | OAL Overall Length | ZEFF Eff. Teeth | BD Body Dia. | DCON Bore Dia. | KWW Keyway | DBC Bolt Circle Dia. | CSP Coolant |
|---------------|-----------------|-----------------------|--------------------|-----------------|--------------|----------------|------------|----------------------|-------------|
| INCH | | | | | | | | | |
| DN6K-20R01 | 2.000 | 2.61 | 1.750 | 4 | 2.67 | 0.7500 | 0.312 | - | Yes |
| DN5K-20R01 | 2.000 | 2.61 | 1.750 | 6 | 2.67 | 0.7500 | 0.312 | - | Yes |
| DN6K-25R01 | 2.500 | 3.11 | 1.750 | 6 | 3.17 | 1.0000 | 0.375 | - | Yes |
| DN5K-25R01 | 2.500 | 3.11 | 1.750 | 8 | 3.17 | 1.0000 | 0.375 | - | Yes |
| DN6K-30R01 | 3.000 | 3.61 | 1.750 | 7 | 3.67 | 1.0000 | 0.375 | - | Yes |
| DN5K-30R01 | 3.000 | 3.61 | 1.750 | 10 | 3.67 | 1.0000 | 0.375 | - | Yes |
| DN6K-40R01 | 4.000 | 4.61 | 2.375 | 8 | 4.67 | 1.5000 | 0.625 | - | Yes |
| DN5K-40R01 | 4.000 | 4.61 | 2.375 | 12 | 4.67 | 1.5000 | 0.625 | - | Yes |
| DN6K-50R01 | 5.000 | 5.61 | 2.375 | 10 | 5.67 | 1.5000 | 0.625 | - | Yes |
| DN5K-50R01 | 5.000 | 5.61 | 2.375 | 16 | 5.67 | 1.5000 | 0.625 | - | Yes |
| DN6K-60R01 | 6.000 | 6.61 | 2.375 | 12 | 6.67 | 1.5000 | 0.625 | - | No |
| DN5K-60R01 | 6.000 | 6.61 | 2.375 | 20 | 6.67 | 1.5000 | 0.625 | - | No |
| DN6K-80R01 | 8.000 | 8.61 | 2.375 | 18 | 8.67 | 2.5000 | 1.000 | 4.00 | No |
| DN5K-80R01 | 8.000 | 8.61 | 2.375 | 26 | 8.67 | 2.5000 | 1.000 | 4.00 | No |
| METRIC | | | | | | | | | |
| DN6K050R00 | 50.00 mm | 65.5 mm | 40.00 mm | 4 | 67.0 mm | 22.00 mm | 10.40 mm | - | Yes |
| DN5K050R00 | 50.00 mm | 65.5 mm | 40.00 mm | 6 | 67.0 mm | 22.00 mm | 10.40 mm | - | Yes |
| DN6K063R00 | 63.00 mm | 78.5 mm | 50.00 mm | 6 | 80.0 mm | 22.00 mm | 10.40 mm | - | Yes |
| DN5K063R00 | 63.00 mm | 78.5 mm | 50.00 mm | 8 | 80.0 mm | 22.00 mm | 10.40 mm | - | Yes |
| DN6K080R00 | 80.00 mm | 95.5 mm | 50.00 mm | 7 | 97.0 mm | 27.00 mm | 12.40 mm | - | Yes |
| DN5K080R00 | 80.00 mm | 95.5 mm | 50.00 mm | 10 | 97.0 mm | 27.00 mm | 12.40 mm | - | Yes |
| DN6K100R00 | 100.00 mm | 115.5 mm | 50.00 mm | 8 | 117.0 mm | 32.00 mm | 14.40 mm | - | Yes |
| DN5K100R00 | 100.00 mm | 115.5 mm | 50.00 mm | 12 | 117.0 mm | 32.00 mm | 14.40 mm | - | Yes |
| DN6K125R00 | 125.00 mm | 140.5 mm | 63.00 mm | 10 | 142.0 mm | 40.00 mm | 16.40 mm | - | Yes |
| DN5K125R00 | 125.00 mm | 140.5 mm | 63.00 mm | 16 | 142.0 mm | 40.00 mm | 16.40 mm | - | Yes |
| DN6K160R00 | 160.00 mm | 175.5 mm | 63.00 mm | 12 | 177.0 mm | 40.00 mm | 16.40 mm | - | No |
| DN5K160R00 | 160.00 mm | 175.5 mm | 63.00 mm | 20 | 177.0 mm | 40.00 mm | 16.40 mm | - | No |
| DN6K200R00 | 200.00 mm | 215.5 mm | 63.00 mm | 18 | 217.0 mm | 60.00 mm | 25.70 mm | 101.6 mm | No |
| DN5K200R00 | 200.00 mm | 215.5 mm | 63.00 mm | 26 | 217.0 mm | 60.00 mm | 25.70 mm | 101.6 mm | No |

Face Lead Angle Channel



14 mm • Series DG6K

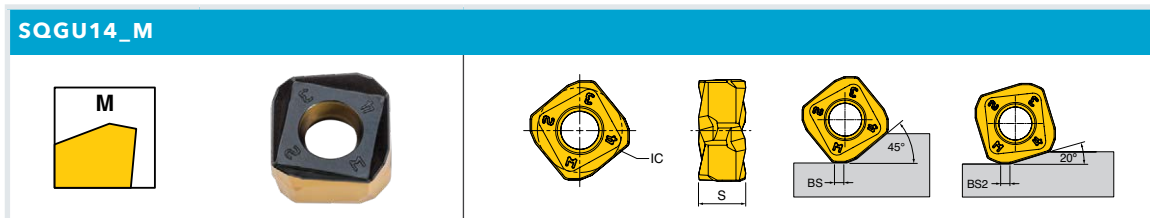
20° FACE MILL • HI-FEED



| Part Number | DC Cutting Diameter | DCX Cutting Diameter Max. | OAL Overall Length | ZEFF Eff. Teeth | DCON Bore Diameter | KWW Keyway | CSP Coolant |
|---------------|---------------------|---------------------------|--------------------|-----------------|--------------------|------------|-------------|
| INCH | | | | | | | |
| DG6K-25R01 | 2.500 | 3.19 | 1.750 | 5 | 1.00 | 0.375 | Yes |
| DG6K-30R01 | 3.000 | 3.69 | 1.750 | 6 | 1.00 | 0.375 | Yes |
| DG6K-40R01 | 4.000 | 4.69 | 2.375 | 7 | 1.50 | 0.625 | Yes |
| DG6K-60R01 | 6.000 | 6.69 | 2.375 | 8 | 1.50 | 0.625 | No |
| METRIC | | | | | | | |
| DG6K063R00 | 63.00 mm | 80.6 mm | 50.00 mm | 5 | 22.00 mm | 10.40 mm | Yes |
| DG6K080R00 | 80.00 mm | 97.6 mm | 50.00 mm | 6 | 27.00 mm | 12.40 mm | Yes |
| DG6K100R00 | 100.00 mm | 117.5 mm | 50.00 mm | 7 | 32.00 mm | 14.40 mm | Yes |
| DG6K125R00 | 125.00 mm | 142.5 mm | 63.00 mm | 8 | 40.00 mm | 16.40 mm | Yes |









14 mm • Inserts

FOR SERIES DN5K, DN6K, AND DG6K

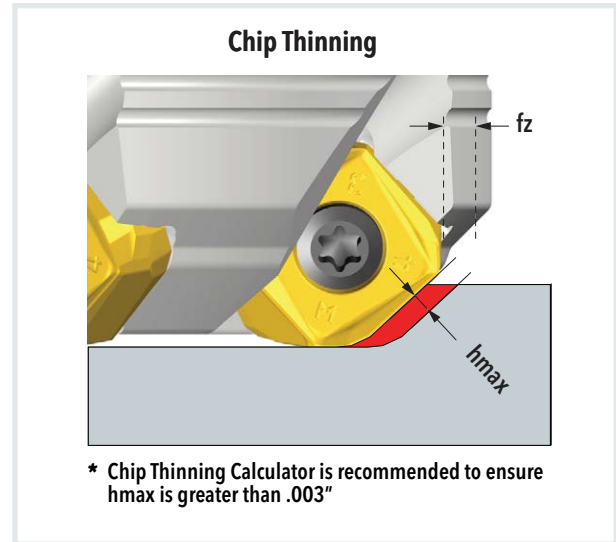


| Part Number | Application | BS Wiper Length | BS2 Wiper Length | IC Inscribed Circle Dia. | S Thickness | NOI Number of Indexes | IH Insert Hand | Grade | | |
|---------------|---------------|-----------------|------------------|--------------------------|-------------|-----------------------|----------------|--------|--------|--------|
| | | | | | | | | IN2505 | IN2510 | IN6537 |
| SQGU1406ANR-M | Multi-Purpose | 0.079 | 0.063 | 0.57 | 0.307 | 8 | Right | • | • | • |

14 mm • Hardware

| Part Number | | | | | Optional | | | |
|---------------|---|---|---|---|--|---|---|---|
| |  |  |  |  |  |  |  |  |
| | Screw | Driver Handle | Torx Driver Blade | Retention Bolt | Coolant Retention Bolt | Torque Driver Handle | Preset Torque Adapter | Torque Driver Bit |
| INCH | | | | | | | | |
| DN6K-20R01 | SM50-130-R0 | DS-A00T | DS-T206B | SD-06-47 | SD-06-A6 | DS-A00-.25-T | DT-44-.25 | DS-T20B1 |
| DN5K-20R01 | SM50-130-R0 | DS-A00T | DS-T206B | SD-06-47 | SD-06-A6 | DS-A00-.25-T | DT-44-.25 | DS-T20B1 |
| DN6K-25R01 | SM50-130-R0 | DS-A00T | DS-T206B | SD-08-47 | SD-08-C9 | DS-A00-.25-T | DT-44-.25 | DS-T20B1 |
| DN5K-25R01 | SM50-130-R0 | DS-A00T | DS-T206B | SD-08-47 | SD-08-C9 | DS-A00-.25-T | DT-44-.25 | DS-T20B1 |
| DN6K-30R01 | SM50-130-R0 | DS-A00T | DS-T206B | SD-08-47 | SD-08-C9 | DS-A00-.25-T | DT-44-.25 | DS-T20B1 |
| DN5K-30R01 | SM50-130-R0 | DS-A00T | DS-T206B | SD-08-47 | SD-08-C9 | DS-A00-.25-T | DT-44-.25 | DS-T20B1 |
| DN6K-40R01 | SM50-130-R0 | DS-A00T | DS-T206B | SD-12-82 | SD-12-99 | DS-A00-.25-T | DT-44-.25 | DS-T20B1 |
| DN5K-40R01 | SM50-130-R0 | DS-A00T | DS-T206B | SD-12-82 | SD-12-99 | DS-A00-.25-T | DT-44-.25 | DS-T20B1 |
| DN6K-50R01 | SM50-130-R0 | DS-A00T | DS-T206B | SD-12-82 | SD-12-99 | DS-A00-.25-T | DT-44-.25 | DS-T20B1 |
| DN5K-50R01 | SM50-130-R0 | DS-A00T | DS-T206B | SD-12-82 | SD-12-99 | DS-A00-.25-T | DT-44-.25 | DS-T20B1 |
| DN6K-60R01 | SM50-130-R0 | DS-A00T | DS-T206B | - | - | DS-A00-.25-T | DT-44-.25 | DS-T20B1 |
| DN5K-60R01 | SM50-130-R0 | DS-A00T | DS-T206B | - | - | DS-A00-.25-T | DT-44-.25 | DS-T20B1 |
| DN6K-80R01 | SM50-130-R0 | DS-A00T | DS-T206B | - | - | DS-A00-.25-T | DT-44-.25 | DS-T20B1 |
| DN5K-80R01 | SM50-130-R0 | DS-A00T | DS-T206B | - | - | DS-A00-.25-T | DT-44-.25 | DS-T20B1 |
| DG6K-25R01 | SM50-130-R0 | DS-A00T | DS-T206B | SD-08-47 | SD-08-C9 | DS-A00-.25-T | DT-44-.25 | DS-T20B1 |
| DG6K-30R01 | SM50-130-R0 | DS-A00T | DS-T206B | SD-08-47 | SD-08-C9 | DS-A00-.25-T | DT-44-.25 | DS-T20B1 |
| DG6K-40R01 | SM50-130-R0 | DS-A00T | DS-T206B | SD-12-82 | SD-12-99 | DS-A00-.25-T | DT-44-.25 | DS-T20B1 |
| DG6K-60R01 | SM50-130-R0 | DS-A00T | DS-T206B | - | - | DS-A00-.25-T | DT-44-.25 | DS-T20B1 |
| METRIC | | | | | | | | |
| DN6K050R00 | SM50-130-R0 | DS-A00T | DS-T206B | SHLM10X1.5X25 | SHLM10X1.5X25-C | DS-A00-.25-T | DT-44-.25 | DS-T20B1 |
| DN5K050R00 | SM50-130-R0 | DS-A00T | DS-T206B | SHLM10X1.5X25 | SHLM10X1.5X25-C | DS-A00-.25-T | DT-44-.25 | DS-T20B1 |
| DN6K063R00 | SM50-130-R0 | DS-A00T | DS-T206B | SHM10X1.5X30 | SHM10X1.5X30-C | DS-A00-.25-T | DT-44-.25 | DS-T20B1 |
| DN5K063R00 | SM50-130-R0 | DS-A00T | DS-T206B | SHM10X1.5X30 | SHM10X1.5X30-C | DS-A00-.25-T | DT-44-.25 | DS-T20B1 |
| DN6K080R00 | SM50-130-R0 | DS-A00T | DS-T206B | SHLM12X1.75X30 | SHLM12X1.75X30-C | DS-A00-.25-T | DT-44-.25 | DS-T20B1 |
| DN5K080R00 | SM50-130-R0 | DS-A00T | DS-T206B | SHLM12X1.75X30 | SHLM12X1.75X30-C | DS-A00-.25-T | DT-44-.25 | DS-T20B1 |
| DN6K100R00 | SM50-130-R0 | DS-A00T | DS-T206B | SHLM16X2X35 | SHLM16X2X35-C | DS-A00-.25-T | DT-44-.25 | DS-T20B1 |
| DN5K100R00 | SM50-130-R0 | DS-A00T | DS-T206B | SHLM16X2X35 | SHLM16X2X35-C | DS-A00-.25-T | DT-44-.25 | DS-T20B1 |
| DN6K125R00 | SM50-130-R0 | DS-A00T | DS-T206B | SHM20X2.5X40 | SHM20X2.5X40-C | DS-A00-.25-T | DT-44-.25 | DS-T20B1 |
| DN5K125R00 | SM50-130-R0 | DS-A00T | DS-T206B | SHM20X2.5X40 | SHM20X2.5X40-C | DS-A00-.25-T | DT-44-.25 | DS-T20B1 |
| DN6K160R00 | SM50-130-R0 | DS-A00T | DS-T206B | - | - | DS-A00-.25-T | DT-44-.25 | DS-T20B1 |
| DN5K160R00 | SM50-130-R0 | DS-A00T | DS-T206B | - | - | DS-A00-.25-T | DT-44-.25 | DS-T20B1 |
| DN6K200R00 | SM50-130-R0 | DS-A00T | DS-T206B | - | - | DS-A00-.25-T | DT-44-.25 | DS-T20B1 |
| DN5K200R00 | SM50-130-R0 | DS-A00T | DS-T206B | - | - | DS-A00-.25-T | DT-44-.25 | DS-T20B1 |
| DG6K063R00 | SM50-130-R0 | DS-A00T | DS-T206B | SHM10X1.5X30 | SHM10X1.5X30-C | DS-A00-.25-T | DT-44-.25 | DS-T20B1 |
| DG6K080R00 | SM50-130-R0 | DS-A00T | DS-T206B | SHM12X1.75X35 | SHM12X1.75X35-C | DS-A00-.25-T | DT-44-.25 | DS-T20B1 |
| DG6K100R00 | SM50-130-R0 | DS-A00T | DS-T206B | SHLM16X2X35 | SHLM16X2X35-C | DS-A00-.25-T | DT-44-.25 | DS-T20B1 |
| DG6K125R00 | SM50-130-R0 | DS-A00T | DS-T206B | SHM20X2.5X40 | SHM20X2.5X40-C | DS-A00-.25-T | DT-44-.25 | DS-T20B1 |

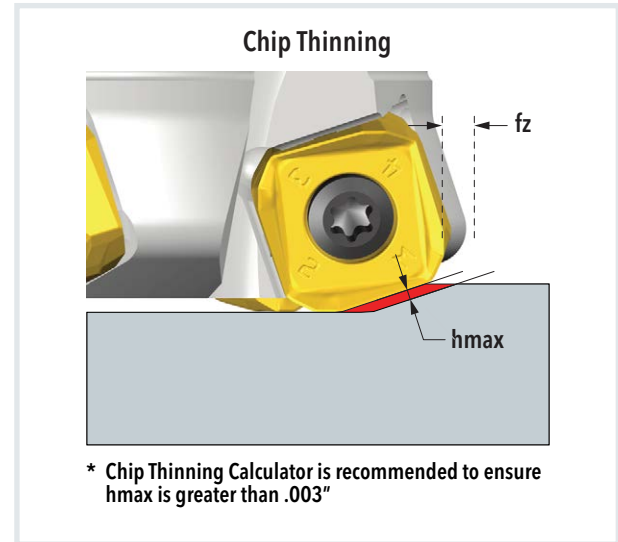
11 mm (45°) • Operating Guidelines



| ISO | Materials | | | Vc Cutting Speed SFM | fz* Feed/Tooth (inch) | Harder «-----» Tougher | | | Coolant |
|----------|--------------------------------|-------------------|-----------------------------|----------------------------|-----------------------------|------------------------|--------|--------|---------|
| | Material Group #VDI 3323 | Type | Examples | | | IN2510 | IN2505 | IN6537 | |
| P | 1-5 | Non-Alloy Steel | 1018, A36, 1045, A572, 1070 | 400-1000 | .005-.012 | | 2 | 1 | No |
| | 6-9 | Low-Alloy Steel | 4140, 4340, P20, 8620, 300M | 350-700 | | | | | |
| | 10-11 | High-Alloy Steel | H13, A2, D2, M2, T1 | 300-600 | | | | | |
| K | 15-16 | Gray Cast Iron | CLS. 20, 30, 45 | 500-1000 | .005-.013 | 1 | 2 | | No |
| | 17-20 | Nodular Cast Iron | 60-40-18, 100-70-03 | 400-800 | | | | | |

Note: Feed and speed recommendations are starting operating parameters. They are only guidelines from which further optimization should take place. Operating parameters are influenced by many machining variables. These variables may cause for reductions in feeds and speed or dramatic increases. Additionally, DOC and WOC may need to be revised to optimize the tools performance.

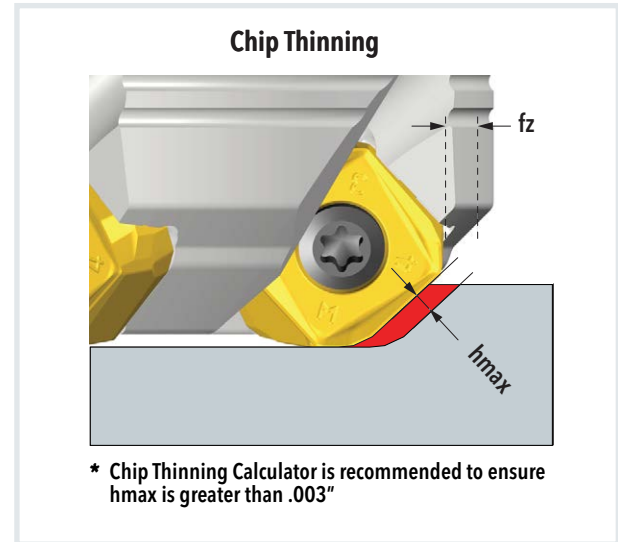
11 mm (20°) • Operating Guidelines



| ISO | Materials | | | Vc Cutting Speed SFM | fz* Feed/Tooth (inch) | Harder «-----» Tougher | | | Coolant |
|----------|--------------------------------|-------------------|-----------------------------|----------------------------|-----------------------------|------------------------|--------|--------|---------|
| | Material Group #VDI 3323 | Type | Examples | | | IN2510 | IN2505 | IN6537 | |
| P | 1-5 | Non-Alloy Steel | 1018, A36, 1045, A572, 1070 | 400-1000 | .012-.040 | | 2 | 1 | No |
| | 6-9 | Low-Alloy Steel | 4140, 4340, P20, 8620, 300M | 350-700 | | | | | |
| | 10-11 | High-Alloy Steel | H13, A2, D2, M2, T1 | 300-600 | | | | | |
| K | 15-16 | Gray Cast Iron | CLS. 20, 30, 45 | 500-1000 | .012-.060 | 1 | 2 | | No |
| | 17-20 | Nodular Cast Iron | 60-40-18, 100-70-03 | 400-800 | | | | | |

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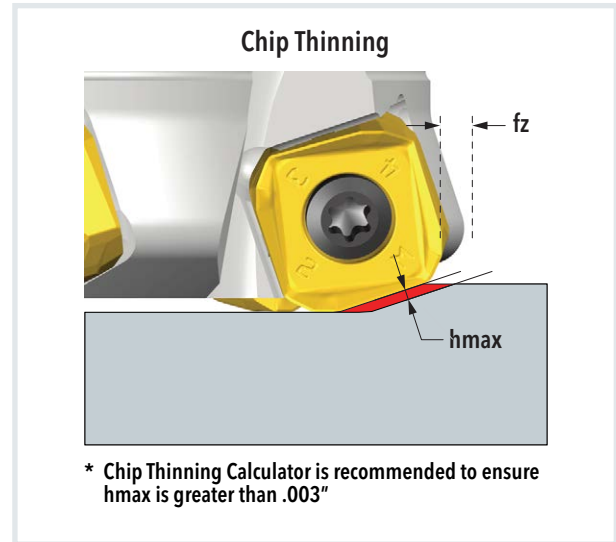
14 mm (45°) • Operating Guidelines



| ISO | Materials | | | Vc Cutting Speed SFM | fz* Feed/Tooth (inch) | Harder «-----» Tougher | | | Coolant |
|----------|--------------------------------|-------------------|-----------------------------|----------------------------|-----------------------------|------------------------|--------|--------|---------|
| | Material Group #VDI 3323 | Type | Examples | | | IN2510 | IN2505 | IN6537 | |
| P | 1-5 | Non-Alloy Steel | 1018, A36, 1045, A572, 1070 | 400-1000 | .003-.015 | | | | No |
| | 6-9 | Low-Alloy Steel | 4140, 4340, P20, 8620, 300M | 350-700 | | 2 | 1 | | |
| | 10-11 | High-Alloy Steel | H13, A2, D2, M2, T1 | 300-600 | | | | | |
| K | 15-16 | Gray Cast Iron | CLS. 20, 30, 45 | 500-1000 | .003-.016 | 1 | 2 | - | No |
| | 17-20 | Nodular Cast Iron | 60-40-18, 100-70-03 | 400-800 | | | | | |

Note: Feed and speed recommendations are starting operating parameters. They are only guidelines from which further optimization should take place. Operating parameters are influenced by many machining variables. These variables may cause for reductions in feeds and speed or dramatic increases. Additionally, DOC and WOC may need to be revised to optimize the tools performance.

14 mm (20°) • Operating Guidelines



| ISO | Materials | | | Vc Cutting Speed SFM | fz* Feed/Tooth (inch) | Harder «-----» Tougher | | | Coolant |
|----------|--------------------------------|-------------------|-----------------------------|----------------------------|-----------------------------|------------------------|--------|--------|---------|
| | Material Group #VDI 3323 | Type | Examples | | | IN2510 | IN2505 | IN6537 | |
| P | 1-5 | Non-Alloy Steel | 1018, A36, 1045, A572, 1070 | 400-1000 | .015-.075 | | 2 | 1 | No |
| | 6-9 | Low-Alloy Steel | 4140, 4340, P20, 8620, 300M | 350-700 | | | | | |
| | 10-11 | High-Alloy Steel | H13, A2, D2, M2, T1 | 300-600 | | | | | |
| K | 15-16 | Gray Cast Iron | CLS. 20, 30, 45 | 500-1000 | .015-.090 | 1 | 2 | - | No |
| | 17-20 | Nodular Cast Iron | 60-40-18, 100-70-03 | 400-800 | | | | | |

Note: Feed and speed recommendations are starting operating parameters. They are only guidelines from which further optimization should take place. Operating parameters are influenced by many machining variables. These variables may cause for reductions in feeds and speed or dramatic increases. Additionally, DOC and WOC may need to be revised to optimize the tools performance.