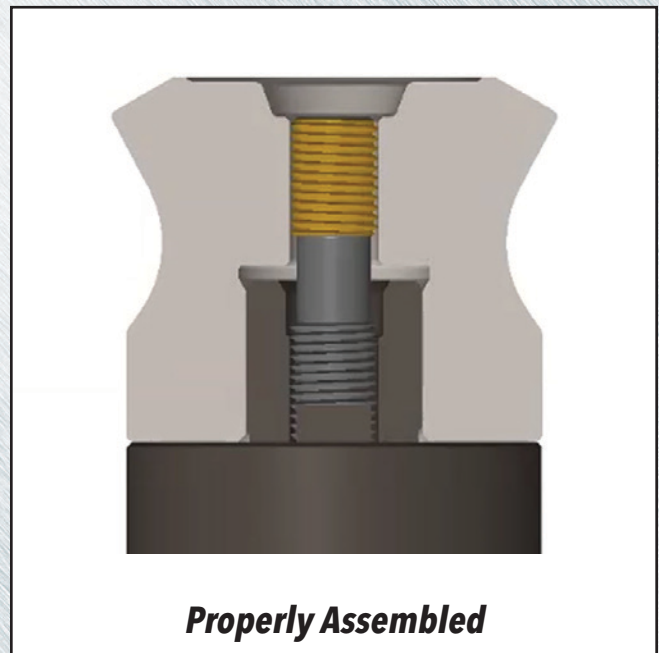
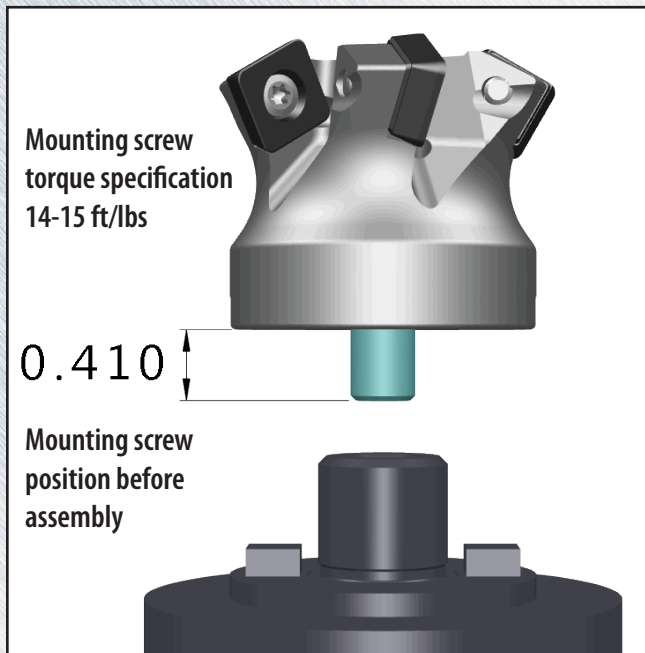
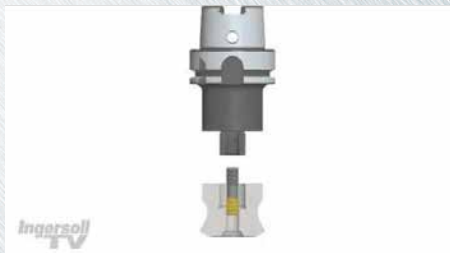


### MOUNTING SCREW ASSEMBLY (2.00" CUTTERS ONLY)



See link below for instructional video showing proper assembly method for 5M6P-20R30 & 5M5P-20R30



<http://www.youtube.com/watch?v=fYQ1smLdYjo>

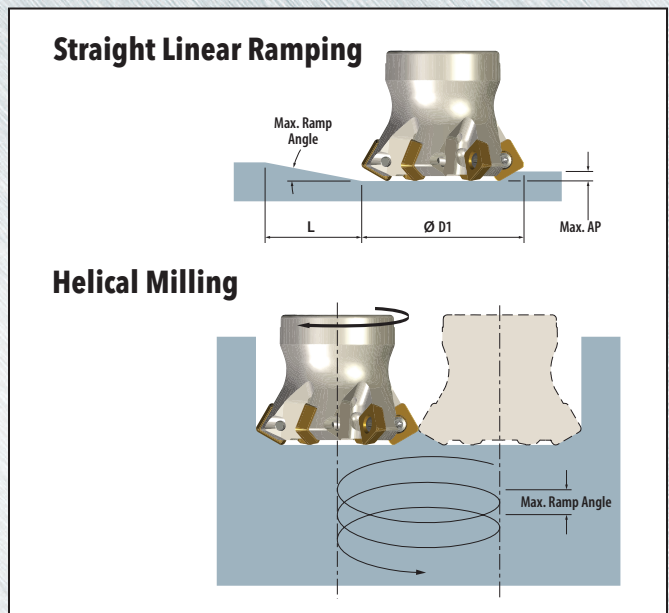
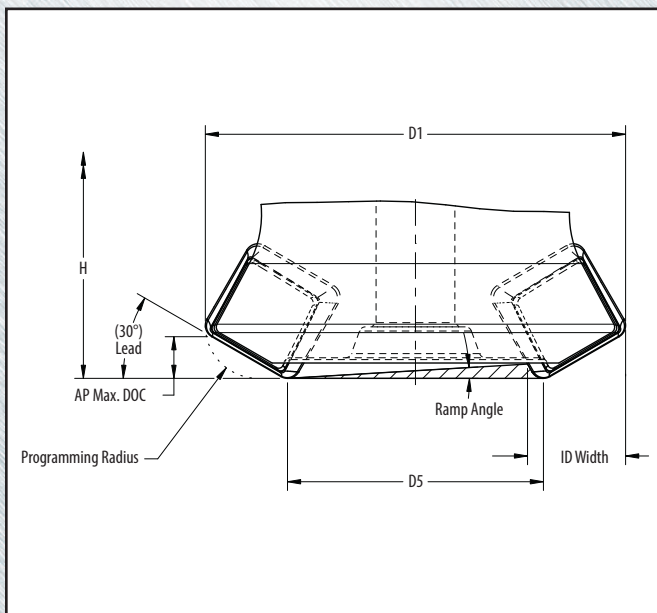
## Programming Tips

- Use a 2 times feed rate multiplier when programming to compensate and take advantage of the chip thinning
- As a general rule use 60% of the cutter diameter for determining the width of cut (WOC)
- Select a deeper depth of cut (DOC) when possible to leverage the material removal rate (MRR) to achieve maximum productivity
- Coolant or air blast, ensure optimal direction, flow and pressure
- Use high speed machining (HSM) programming features present in CAM system when programming
- Request a NX-sales drawing for additional programming information if needed

5M6P-20R30 5M5P-20R30	Insert Corner	D1 Max. Dia.	H Eff. Ext.	D5 Eff. Dia.	AP Max. DOC	Pgm Corner Radius	Max. Ramp Angle	L Min. Ramp Length	ID Width	Helical Milling (Min. & Max. Hole)			
										Max. Dia. w/Cusp	Max. Dia. w/o Cusp	Min. Dia. w/Cusp	Min. Dia. w/o Cusp
SDES130516N-PF	0.063	2.000	1.625	1.218	0.198	0.252	3.4	3.333	0.467	4.000	3.218	3.066	3.218
SDES130516N-PF1	0.063	2.000	1.625	1.218	0.198	0.251	3.4	3.333	0.467	4.000	3.218	3.066	3.218
SDMS130516R-PP	0.063	2.000	1.625	1.218	0.198	0.251	3.4	3.333	0.467	4.000	3.218	3.066	3.218
SDES1305MPR	-	1.961	1.606	1.237	0.202	0.242	2.4	4.820	0.436	3.922	3.198	3.050	3.198
SDES1305MPR-001	-	1.961	1.606	1.237	0.202	0.242	2.4	4.820	0.436	3.922	3.198	3.050	3.198

5M6P-25R30 5M5P-25R30	Insert Corner	D1 Max. Dia.	H Eff. Ext.	D5 Eff. Dia.	AP Max. DOC	Pgm Corner Radius	Max. Ramp Angle	L Min. Ramp Length	ID Width	Helical Milling (Min. & Max. Hole)			
										Max. Dia. w/Cusp	Max. Dia. w/o Cusp	Min. Dia. w/Cusp	Min. Dia. w/o Cusp
SDES130516N-PF	0.063	2.500	2.000	1.717	0.198	0.252	2.4	4.724	0.467	5.000	4.217	4.066	4.217
SDES130516N-PF1	0.063	2.500	2.000	1.717	0.196	0.252	2.4	4.724	0.467	5.000	4.217	4.066	4.217
SDMS130516R-PP	0.063	2.500	2.000	1.717	0.198	0.252	2.4	4.724	0.467	5.000	4.217	4.066	4.217
SDES1305MPR	-	2.461	1.981	1.737	0.202	0.243	1.7	6.806	0.436	4.922	4.198	4.050	4.198
SDES1305MPR-001	-	2.461	1.981	1.737	0.202	0.243	1.7	6.806	0.436	4.922	4.198	4.050	4.198

5M6P-30R30 5M5P-30R30	Insert Corner	D1 Max. Dia.	H Eff. Ext.	D5 Eff. Dia.	AP Max. DOC	Pgm Corner Radius	Max. Ramp Angle	L Min. Ramp Length	ID Width	Helical Milling (Min. & Max. Hole)			
										Max. Dia. w/Cusp	Max. Dia. w/o Cusp	Min. Dia. w/Cusp	Min. Dia. w/o Cusp
SDES130516N-PF	0.063	3.000	2.000	2.217	0.198	0.252	1.8	6.300	0.467	6.000	5.217	5.066	5.217
SDES130516N-PF1	0.063	3.000	2.000	2.217	0.196	0.252	1.8	6.300	0.467	6.000	5.217	5.066	5.217
SDMS130516R-PP	0.063	3.000	2.000	2.217	0.198	0.252	1.8	6.300	0.467	6.000	5.217	5.066	5.217
SDES1305MPR	-	2.962	2.237	2.237	0.202	0.243	1.3	8.970	0.436	5.924	5.199	5.052	5.199
SDES1305MPR-001	-	2.962	2.237	2.237	0.202	0.243	1.3	8.970	0.436	5.924	5.199	5.052	5.199



5M5M-40R30 5M6M-40R30	Insert Corner	D1 Max. Dia.	H Eff. Ext.	D5 Eff. Dia.	AP Max. DOC	Pgm Corner Radius	Max. Ramp Angle	L Min. Ramp Length	Wiper Flat	ID Width	Helical Milling (Min. & Max. Hole)			
											Max. Dia. w/Cusp	Max. Dia w/o Cusp	Min. Dia. w/Cusp	Min. Dia w/o Cusp
SDES1906ZPR-PF	Facet	4.000	2.500	2.89	0.31	0.333	2.0	8.762	0.053	0.686	8.000	6.885	6.628	6.779
SDMS1906ZPR-PP	Facet	4.000	2.500	2.89	0.31	0.333	2.0	8.762	0.053	0.686	8.000	6.885	6.628	6.779
SDMS190620R-PH	0.078	4.018	2.509	2.84	0.31	0.375	2.2	7.939	-	0.698	8.036	6.856	6.640	6.856
SDES190620N	0.078	4.018	2.509	2.84	0.31	0.375	2.2	7.939	-	0.698	8.036	6.856	6.640	6.856
SDES190620N-001	0.078	4.018	2.51	2.84	0.31	0.375	2.2	7.939	-	0.698	8.036	6.856	6.640	6.856
SDES1906MPR	-	3.949	2.475	2.89	0.31	0.364	1.0	17.989	-	0.637	7.898	6.842	6.620	6.842
SDES1906MPR-001	-	3.949	2.475	2.89	0.31	0.364	1.0	17.989	-	0.637	7.898	6.842	6.620	6.842

5M5M-50R30 5M6M-50R30	Insert Corner	D1 Max. Dia.	H Eff. Ext.	D5 Eff. Dia.	AP Max. DOC	Pgm Corner Radius	Max. Ramp Angle	L Min. Ramp Length	Wiper Flat	ID Width	Helical Milling (Min. & Max. Hole)			
											Max. Dia. w/Cusp	Max. Dia w/o Cusp	Min. Dia. w/Cusp	Min. Dia w/o Cusp
SDES1906ZPR-PF	Facet	5.000	2.500	3.89	0.31	0.333	1.3	13.484	0.053	0.686	10.000	8.885	8.628	8.779
SDMS1906ZPR-PP	Facet	5.000	2.500	3.89	0.31	0.333	1.3	13.484	0.053	0.686	10.000	8.885	8.628	8.779
SDMS190620R-PH	0.078	5.018	2.509	3.84	0.31	0.375	1.5	11.647	-	0.698	10.036	8.856	8.640	8.855
SDES190620N	0.078	5.018	2.509	3.84	0.31	0.375	1.5	11.647	-	0.698	10.036	8.856	8.640	8.855
SDES190620N-001	0.078	5.018	2.509	3.84	0.31	0.375	1.5	11.647	-	0.698	10.036	8.856	8.640	8.855
SDES1906MPR	-	4.949	2.475	3.89	0.31	0.364	0.7	25.700	-	0.612	9.898	8.842	8.674	8.842
SDES1906MPR-001	-	4.949	2.475	3.89	0.31	0.364	0.7	25.700	-	0.612	9.898	8.842	8.674	8.842

5M5M-60R30 5M6M-60R30	Insert Corner	D1 Max. Dia.	H Eff. Ext.	D5 Eff. Dia.	AP Max. DOC	Pgm Corner Radius	Max. Ramp Angle	L Min. Ramp Length	Wiper Flat	ID Width	Helical Milling (Min. & Max. Hole)			
											Max. Dia. w/Cusp	Max. Dia w/o Cusp	Min. Dia. w/Cusp	Min. Dia w/o Cusp
SDES1906ZPR-PF	Facet	6.000	2.500	4.89	0.31	0.333	1.0	17.530	0.053	0.686	12.000	10.885	10.628	10.779
SDMS1906ZPR-PP	Facet	6.000	2.500	4.89	0.31	0.333	1.0	17.530	0.053	0.686	12.000	10.885	10.628	10.779
SDMS190620R-PH	0.078	6.018	2.509	4.837	0.305	0.375	1.1	15.884	-	0.698	12.036	10.855	10.640	10.855
SDES190620N	0.078	6.018	2.509	4.837	0.305	0.375	1.1	15.884	-	0.698	12.036	10.855	10.640	10.855
SDES190620N-001	0.078	6.018	2.509	4.837	0.305	0.375	1.1	15.884	-	0.698	12.036	10.855	10.640	10.855
SDES1906MPR	-	5.949	2.475	4.89	0.31	0.364	0.6	29.938	-	0.612	11.898	10.842	10.674	8.842
SDES1906MPR-001	-	5.949	2.475	4.89	0.31	0.364	0.67	29.938	-	0.612	11.898	10.842	10.674	8.842

