

70° LEAD FACE MILL WITH 10 CUTTING EDGES



Fixed Pocket



Seat Pocket Protection



Cartridge Pocket Protection w/Axial Adjustment



Multi-Purpose



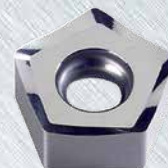
Flat Top



SiN



SS/Hi Temp/Ti



Non-Ferrous



Wiper



Diameter Range:
1.50-12.00

Depth of Cut:
Deka 08 - .23
Deka 17 - .47

Lead Angle:
70°

Cutter Series:
DM5G / DM6G / DM20 /
DM6Q / 4W2A

Insert Series:
PNCQ & PNCU

Materials:
Aluminum, Iron, Steel, Stainless
Steel, Hi-Temps & Titanium

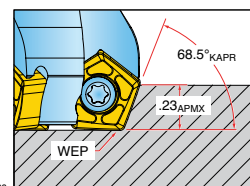
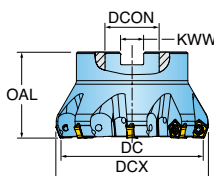
**PRODUCT
ANNOUNCEMENT
UPDATE
2018**

Features and Benefits

- 2-Side-Technology applied to penta shaped inserts for a cost-per-edge economy benefit
- Cutters offered with and without pocket protection
- Carbide and SiN insert grade options for iron applications
- 32-63 Ra surface finishes when using integrated wiper of multi-purpose inserts
- 20-40 Ra surface finishes when using wiper insert in one or two pockets
- Cutter bodies ported with coolant

SERIES DM5G, DM6G

**70° FACE MILL
.23 DEPTH OF CUT**

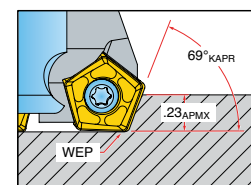
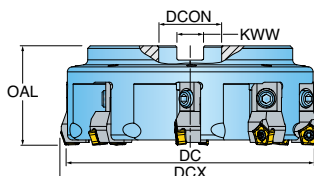


WEP - See insert drawing for wiper options.

Part Number	DC Cutting Dia.	DCX Cutting Dia. Max.	OAL Overall Length	ZEFF Effective Teeth	DCON Bore Diameter	KWW Keyway	DBC Bolt Circle	CSP Coolant
DM6G-15R01	1.500	1.71	1.570	4	0.500	0.250	NA	Yes
DM5G-20R01	2.000	2.21	1.570	6	0.750	0.312	NA	Yes
DM6G-20R01	2.000	2.21	1.570	4	0.750	0.312	NA	Yes
DM5G-25R01	2.500	2.71	1.570	8	0.750	0.312	NA	Yes
DM6G-25R01	2.500	2.71	1.570	6	0.750	0.312	NA	Yes
DM5G-30R01	3.000	3.21	1.750	10	1.000	0.375	NA	Yes
DM6G-30R01	3.000	3.21	1.750	7	1.000	0.375	NA	Yes
DM5G-40R01	4.000	4.21	2.375	12	1.500	0.625	NA	Yes
DM6G-40R01	4.000	4.21	2.375	8	1.500	0.625	NA	Yes
DM6G-50R01	5.000	5.21	2.375	10	1.500	0.625	NA	Yes
DM6G-60R01	6.000	6.21	2.375	12	1.500	0.625	NA	Yes
DM6G-80R10	8.000	8.21	2.375	16	2.500	1.000	4.00	No

SERIES 4W2A

**70° MULTI-CARTRIDGE FACE MILL
.23 DEPTH OF CUT**



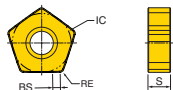
WEP - See insert drawing for wiper options.

** SERIES 4W2A ACCEPTS DIFFERENT CARTRIDGE AND INSERT STYLES. 55H-11R07 DEKA CARTRIDGES SOLD SEPARATELY.

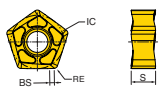
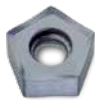
Part Number	DC Cutting Dia.	DCX Cutting Dia. Max.	OAL Overall Length	ZEFF Effective Teeth	DCON Bore Diameter	KWW Keyway	DBC Bolt Circle
4W2A-06R01	6.030	6.25	2.370	8	1.500	0.625	NA
4W2A-08R01	8.030	8.25	2.370	10	2.500	1.000	4.00
4W2A-10R01	10.030	10.25	2.370	12	2.500	1.000	4.00
4W2A-12R01	12.030	12.25	2.370	14	2.500	1.000	4.00, 7.00

8MM INSERTS

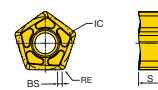
PNCQ08_GNTN



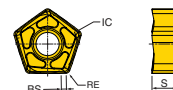
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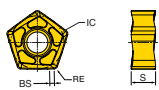
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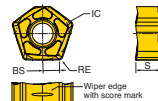
PNCU08_GNR



PNCU08_GNTR









PNCU08-W



Part Number	Application	RE/BCH Corner Radius/ Chamfer	BS Wiper Length	IC Inscribed Circle Dia.	S Thickness (To Cutting Edge)	NOI Number of Indexes	IH Insert Hand	Grade	IN055	IN2505	IN4005	IN4015	IN4030	IN4035	IN6515	IN70N
PNCQ0804GNTN	Flat Top	0.031 R	0.076	0.450	0.165	10	Right				•					
PNCU0805GNFR-HS	SS/Hi-Temp/Ti	0.030 R	0.062	0.450	0.217	10	Right			•					•	
PNCU0805GNFR-P	Sharp & Polished	0.030 R	0.062	0.450	0.217	10	Right	•								
PNCU0805GNR	SiN for Iron	0.031 R	0.076	0.450	0.190	10	Right									•
PNCU0805GNTR	Multi-Purpose	0.031 R	0.076	0.450	0.206	10	Right				•	•	•		•	
PNCU0805GNTR-W	Wiper	0.030 R	0.162	0.450	0.190	2	Right			•		•			•	

8MM HARDWARE

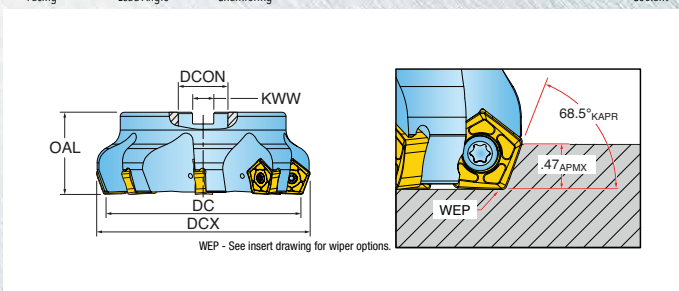
					
	Insert Screw	Driver Handle	Torx Driver Blade	Retention Bolt	Optional Coolant Bolt
DM6G-15R01	SM40-100-10	DS-A00T	DS-T156B	SD-04-86	
DM5G-20R01	SM40-100-10	DS-A00T	DS-T156B	SD-06-46	SD-06-89
DM6G-20R01	SM40-100-10	DS-A00T	DS-T156B	SD-06-46	SD-06-89
DM5G-25R01	SM40-100-10	DS-A00T	DS-T156B	SD-06-46	SD-06-89
DM6G-25R01	SM40-100-10	DS-A00T	DS-T156B	SD-06-46	SD-06-89
DM5G-30R01	SM40-100-10	DS-A00T	DS-T156B	SD-08-46	SD-08-92
DM6G-30R01	SM40-100-10	DS-A00T	DS-T156B	SD-08-46	SD-08-92
DM5G-40R01	SM40-100-10	DS-A00T	DS-T156B	SD-12-82	SD-12-99
DM6G-40R01	SM40-100-10	DS-A00T	DS-T156B	SD-12-82	SD-12-99
DM6G-50R01	SM40-100-10	DS-A00T	DS-T156B	SD-12-82	SD-12-99
DM6G-60R01	SM40-100-10	DS-A00T	DS-T156B	SD-12-82	SD-12-99
DM6G-80R10	SM40-100-10	DS-A00T	DS-T156B	-	-

	Face Mill Cartridge							
		Insert Screw	Driver Handle	Torx Driver Blade	Set Screw	3mm Hex Screw Driver	SHCS	5mm Hex Screw Driver
4W2A-06R01	55H-11R07*	SM40-100-10	DS-A00T	DS-T156B	SA060-01	DS-H03T	SD060-16	DS-H05T
4W2A-08R01	55H-11R07*	SM40-100-10	DS-A00T	DS-T156B	SA060-01	DS-H03T	SD060-16	DS-H05T
4W2A-10R01	55H-11R07*	SM40-100-10	DS-A00T	DS-T156B	SA060-01	DS-H03T	SD060-16	DS-H05T
4W2A-12R01	55H-11R07*	SM40-100-10	DS-A00T	DS-T156B	SA060-01	DS-H03T	SD060-16	DS-H05T

*55H-11R07 DEKA CARTRIDGES SOLD SEPARATELY.

SERIES DM6Q

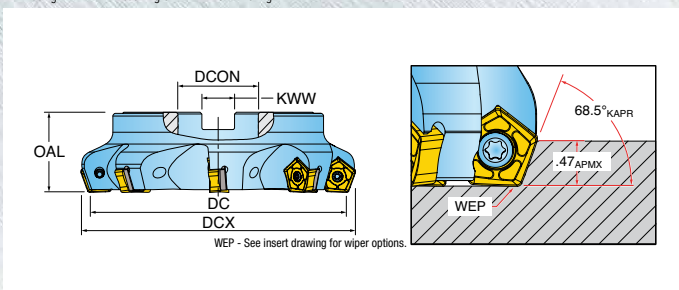
**70° HEAVY DUTY FACE MILL
.47 DEPTH OF CUT**



Part Number	DC Cutting Dia.	DCX Cutting Dia. Max.	OAL Overall Length	ZEFF Effective Teeth	DCON Bore Diameter	KWW Keyway	DBC Bolt Circle	CSP Coolant
DM6Q-03R01	3.000	3.44	2.375	4	1.000	0.375	NA	Yes
DM6Q-04R01	4.000	4.44	2.375	5	1.500	0.625	NA	Yes
DM6Q-05R01	5.000	5.44	2.375	6	1.500	0.625	NA	Yes
DM6Q-06R01	6.000	6.44	2.375	8	1.500	0.625	NA	Yes
DM6Q-08R01	8.000	8.44	2.375	10	2.500	1.000	4.00	No

SERIES DM2Q

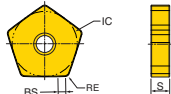
**70° HEAVY DUTY FACE MILL W/POCKET PROTECTION
.47 DEPTH OF CUT**



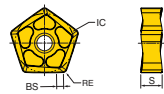
Part Number	DC Cutting Dia.	DCX Cutting Dia. Max.	OAL Overall Length	ZEFF Effective Teeth	DCON Bore Diameter	KWW Keyway	DBC Bolt Circle
DM2Q-06R01	6.000	6.44	2.375	7	1.500	0.625	NA
DM2Q-08R01	8.000	8.44	2.375	8	2.500	1.000	4.00
DM2Q-10R01	10.000	10.44	2.375	10	2.500	1.000	4.00
DM2Q-12R01	12.000	12.44	2.375	12	2.500	1.000	4.00, 7.00

17MM INSERTS

PNCQ17











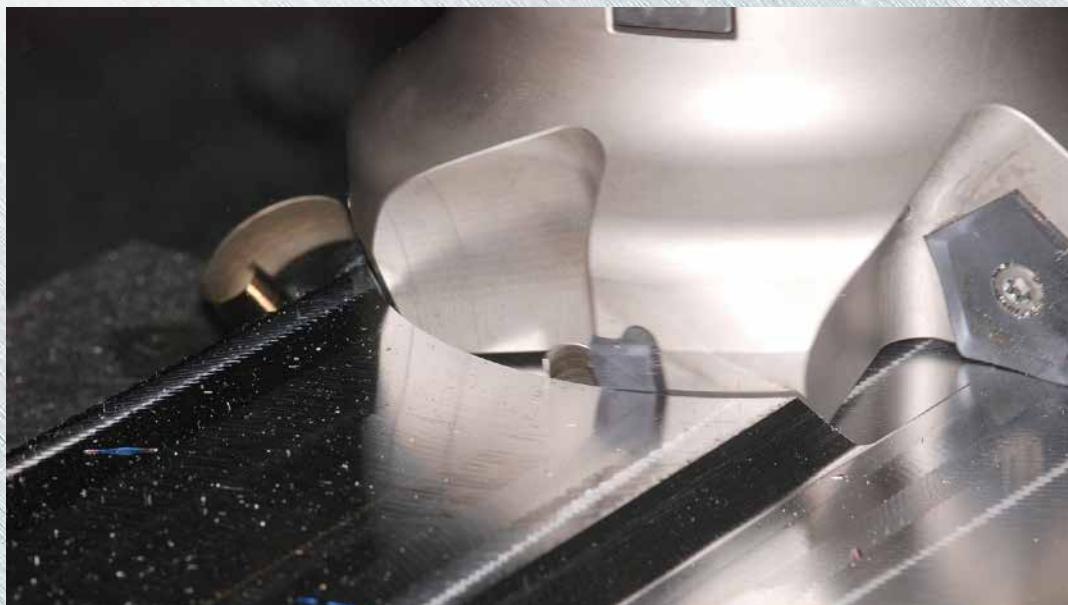
PNCU17



Part Number	Application	RE/BCH Corner Radius/ Chamfer	BS Wiper Length	IC Inscribed Circle Dia.	S Thickness (To Cutting Edge)	NOI Number of Indexes	IH Insert Hand	Grade	IN2005	IN2030	IN2040	IN2505	IN2530	IN4030	IN6515
PNCQ1706GNTN	Flat Top	0.060 R	0.157	0.925	0.256	10	Right					•	•		
PNCU1708GNTR	Multi-Purpose	0.060 R	0.157	0.925	0.328	10	Right	•	•	•				•	•

17MM HARDWARE

								
	Insert Screw	Driver Handle	Torx Driver Blade	Seat	Seat Screw	5mm Hex Screw Driver	Retention Bolt	Optional Coolant Bolt
DM6Q-03R01	SM50-130-R0	DS-A00T	DS-T206B	-	-	-	SD-08-48	SD08-C9
DM6Q-04R01	SM50-130-R0	DS-A00T	DS-T206B	-	-	-	SD-12-82	SD-12-99
DM6Q-05R01	SM50-130-R0	DS-A00T	DS-T206B	-	-	-	SD-12-82	SD-12-99
DM6Q-06R01	SM50-130-R0	DS-A00T	DS-T206B	-	-	-	SD-12-82	SD-12-99
DM6Q-08R01	SM50-130-R0	DS-A00T	DS-T206B	-	-	-	-	-
DM2Q-06R01	SM50-170-R0	DS-A00T	DS-T206B	SJ-5061	SF070R01	DS-H05T	SD-12-82	-
DM2Q-08R01	SM50-170-R0	DS-A00T	DS-T206B	SJ-5061	SF070R01	DS-H05T	-	-
DM2Q-10R01	SM50-170-R0	DS-A00T	DS-T206B	SJ-5062	SF070R01	DS-H05T	-	-
DM2Q-12R01	SM50-170-R0	DS-A00T	DS-T206B	SJ-5062	SF070R01	DS-H05T	-	-



OPERATING GUIDELINES - 8MM (SERIES DM5G, DM6G, 4W2A)

Material	Brinell Hardness	SFM	Feed per Insert (inch)	Grade						Coolant	
				IN055	IN2505 IN4005	IN4015 IN6515	IN4030	IN4035	IN70N		
Aluminum	7075-T6, 6061-T6, 2024	-	1650-2500	.005-.015	1		2				Yes
Cast Iron	Gray	150-250	300-1000	.008-.015		2	1				No
			1800+	.005-.008					1		
	Nodular		300-600	.005-.012		2	1				
			1500+	.004-.007						1	
Steel	Low Carbon 1018, 8620	150-250	400-800	.008-.018	2		1			No	
	High Carbon F-6180	250-400	350-500	.008-.015							
	Alloyed Steel 4140, 4340	150-300	300-600	.008-.015							
	Tool Steel A-6, D-1, D-2	Up to 300									
Stainless Steel	300 Series, 304, 316	-	300-600	.005-.012	3		2	1		May not be required at high speeds	
	400 Series 15-5 PH	Up to 320	400-600							Yes	
	13-8 PH	-	200-400								
Nickel Alloys	Inconel, Hastelloy, Waspalloy	-	75-120	.004-.010	2		3	1		Yes	
Titanium	6AL-4V	-	100-150	.005-.010	3		2	1		Yes	

OPERATING GUIDELINES - 17MM (SERIES DM6Q, DM2Q)

Material	Brinell Hardness	SFM	Feed per Insert (inch)	Grade						Coolant
				IN2005 IN2505	IN2030 IN2530 IN4030	IN2040	IN6515			
Cast Iron	Gray	150-250	300-1000	.007-.025	2				1	No
	Nodular		300-600	.007-.020	2				1	
Steel	Low Carbon 1018, 8620	150-250	400-800	.008-.025	2	1	3			No
	High Carbon F-6180	250-400	350-500	.008-.020						
	Alloyed Steel 4140, 4340	150-300	300-600	.008-.020						
	Tool Steel A-6, D-1, D-2	Up to 300								
Stainless Steel	400 Series 15-5 PH	Up to 320	350-600	-	2	1				Yes
	13-8 PH	-	200-400							

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 performance of the tool.