



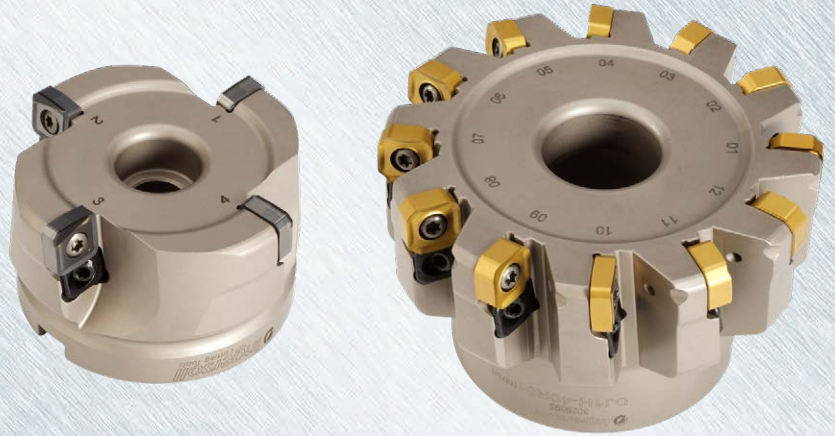
Diameters:
2.00" - 8.00"
50.00-250.00mm

Depth of Cut Max:
.040" Max; .020" Recommended
1.00mm Max; 0.50mm Recommended

Cutter Series:
DJ1H

Insert Series:
SNE_12

Materials:
Iron, Steel, Hardened Steel,
Stainless Steel, Hi-Temp Alloys
& Titanium



Finish-Milling cutters with easy set up and accurate adjustment

Features & Benefits:

- Fine adjustment within .0002" for runout and tolerance control
- 5-20 Ra surface finishes
- Carbide and CBN insert options
- Inserts with up to 8 indexes
- Inserts with Long, Medium & Short crowned wiper lengths for face pressure management
- Screw held inserts for secure mounting
- Cutter design accommodates milling up to a 90 degree shoulder
- Cutters with coarse and fine pitch densities for face pressure management



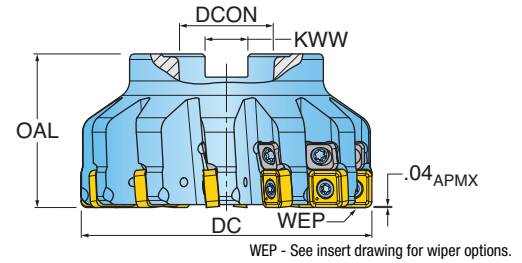
SERIES DJ1H

90° ADJUSTABLE FINISHING FACE MILL



Facing

Coolant



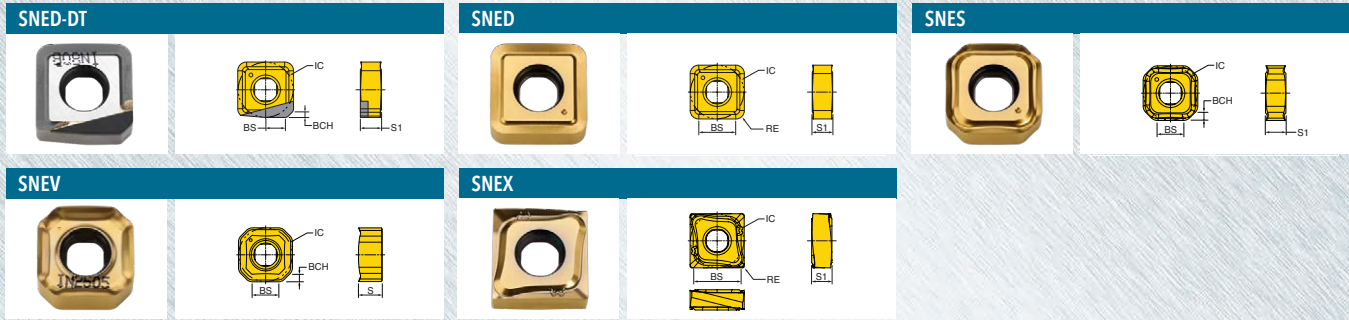
INCH

Part Number	DC Cutting Dia.	OAL Overall Length	ZEFF Effective Teeth	DCON Bore Dia.	KWW Keyway	DBC Bolt Circle	CSP Coolant
DJ1H-20R01	2.000	1.75	3	0.750	0.312	-	No
DJ1H-30R01	3.000	1.75	4	1.000	0.375	-	No
DJ1H-40R01	4.000	2.48	12	1.250	0.500	-	No
DJ1H-40R02	4.000	2.48	6	1.250	0.500	-	No
DJ1H-60R01	6.000	2.48	20	1.500	0.625	-	No
DJ1H-60R02	6.000	2.48	8	1.500	0.625	-	No
DJ1H-80R01	8.000	2.48	24	2.500	1.000	4.00	No
DJ1H-80R02	8.000	2.48	12	2.500	1.000	4.00	No

METRIC

Part Number	DC Cutting Dia.	OAL Overall Length	ZEFF Effective Teeth	DCON Bore Dia.	KWW Keyway	DBC Bolt Circle	CSP Coolant
DJ1H050R00	50.00 mm	50.00 mm	3	22.00 mm	10.40 mm	NA	Yes
DJ1H063R00	63.00 mm	50.00 mm	4	22.00 mm	10.40 mm	NA	Yes
DJ1H080R00	80.00 mm	50.00 mm	6	27.00 mm	12.40 mm	NA	Yes
DJ1H100R00	100.00 mm	63.00 mm	12	32.00 mm	14.40 mm	NA	Yes
DJ1H100R01	100.00 mm	63.00 mm	8	32.00 mm	14.40 mm	NA	Yes
DJ1H125R00	125.00 mm	63.00 mm	16	40.00 mm	16.40 mm	NA	No
DJ1H125R01	125.00 mm	63.00 mm	10	40.00 mm	16.40 mm	NA	No
DJ1H160R00	160.00 mm	63.00 mm	20	40.00 mm	16.40 mm	66.7 mm	No
DJ1H160R01	160.00 mm	63.00 mm	12	40.00 mm	16.40 mm	66.7 mm	No
DJ1H200R00	200.00 mm	63.00 mm	24	60.00 mm	25.70 mm	101.6 mm	No
DJ1H250R00	250.00 mm	63.00 mm	30	60.00 mm	25.70 mm	101.6 mm	No

INSERTS

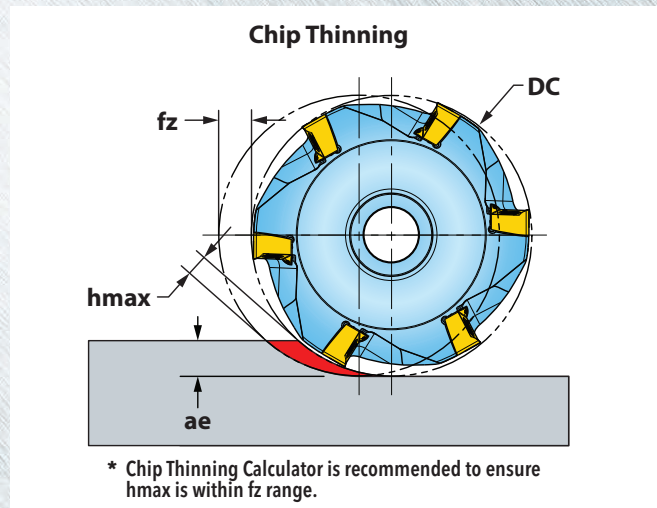


Part Number	RE/BCH Corner Radius/ Chamfer	BS Wiper Length	IC Inscribed Circle Dia.	S Thickness	NOI Number of Indexes	IH Insert Hand	Grade	IN80B	IN2504	IN2505	IN2510
SNED1204ANR-DT	0.060 Chamfer	0.190	0.500	0.187	1	Right	•				
SNED120420	0.078 R	0.340	0.500	0.187	8	Right		•		•	
SNES1204ANN	0.100 Chamfer	0.230	0.500	0.187	8	Right				•	
SNEV1204ANN-PH	0.100 Chamfer	0.230	0.500	0.218	4	Right			•		
SNEX120404R-W	0.015 R	0.470	0.500	0.187	4	Right					•

HARDWARE

									
	Insert Screw	Driver Handle	Driver Blade	Adjusting Screw	Adjusting Wedge	Retention Bolt	Torque Driver Handle	Preset Torque Bit	Torque Driver Bit
DJ1H-20R01	SM35-110-R0	DS-A00T	DS-T156B	SB060-10	2E-831-01	SD-06-46	DS-A00-.25-T	DT-30-.25	DS-T15B1
DJ1H-30R01	SM35-110-R0	DS-A00T	DS-T156B	SB060-10	2E-831-01	SD-08-47	DS-A00-.25-T	DT-30-.25	DS-T15B1
DJ1H-40R01	SM35-110-R0	DS-A00T	DS-T156B	SB060-10	2E-831-01	SD-10-47	DS-A00-.25-T	DT-30-.25	DS-T15B1
DJ1H-40R02	SM35-110-R0	DS-A00T	DS-T156B	SB060-10	2E-831-01	SD-10-47	DS-A00-.25-T	DT-30-.25	DS-T15B1
DJ1H-60R01	SM35-110-R0	DS-A00T	DS-T156B	SB060-10	2E-831-01	-	DS-A00-.25-T	DT-30-.25	DS-T15B1
DJ1H-60R02	SM35-110-R0	DS-A00T	DS-T156B	SB060-10	2E-831-01	-	DS-A00-.25-T	DT-30-.25	DS-T15B1
DJ1H-80R01	SM35-110-R0	DS-A00T	DS-T156B	SB060-10	2E-831-01	-	DS-A00-.25-T	DT-30-.25	DS-T15B1
DJ1H-80R02	SM35-110-R0	DS-A00T	DS-T156B	SB060-10	2E-831-01	-	DS-A00-.25-T	DT-30-.25	DS-T15B1
DJ1H050R00	SM35-110-R0	DS-A00T	DS-T156B	SB060-10	2E-831-01	ISO4762M10X25-12.9	DS-A00-.25-T	DT-30-.25	DS-T15B1
DJ1H063R00	SM35-110-R0	DS-A00T	DS-T156B	SB060-10	2E-831-01	ISO4762M10X25-12.9	DS-A00-.25-T	DT-30-.25	DS-T15B1
DJ1H080R00	SM35-110-R0	DS-A00T	DS-T156B	SB060-10	2E-831-01	ISO4762M12X35-12.9	DS-A00-.25-T	DT-30-.25	DS-T15B1
DJ1H100R00	SM35-110-R0	DS-A00T	DS-T156B	SB060-10	2E-831-01	ISO4762M16X30-12.9	DS-A00-.25-T	DT-30-.25	DS-T15B1
DJ1H100R01	SM35-110-R0	DS-A00T	DS-T156B	SB060-10	2E-831-01	ISO4762M16X30-12.9	DS-A00-.25-T	DT-30-.25	DS-T15B1
DJ1H125R00	SM35-110-R0	DS-A00T	DS-T156B	SB060-10	2E-831-01	ISO4762M20X40-12.9	DS-A00-.25-T	DT-30-.25	DS-T15B1
DJ1H125R01	SM35-110-R0	DS-A00T	DS-T156B	SB060-10	2E-831-01	ISO4762M20X40-12.9	DS-A00-.25-T	DT-30-.25	DS-T15B1
DJ1H160R00	SM35-110-R0	DS-A00T	DS-T156B	SB060-10	2E-831-01	-	DS-A00-.25-T	DT-30-.25	DS-T15B1
DJ1H160R01	SM35-110-R0	DS-A00T	DS-T156B	SB060-10	2E-831-01	-	DS-A00-.25-T	DT-30-.25	DS-T15B1
DJ1H200R00	SM35-110-R0	DS-A00T	DS-T156B	SB060-10	2E-831-01	-	DS-A00-.25-T	DT-30-.25	DS-T15B1
DJ1H250R00	SM35-110-R0	DS-A00T	DS-T156B	SB060-10	2E-831-01	-	DS-A00-.25-T	DT-30-.25	DS-T15B1

OPERATING GUIDELINES

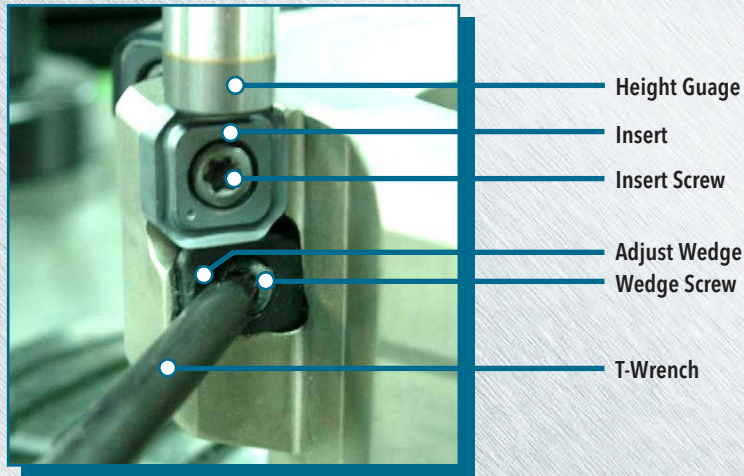


Materials				Vc Cutting Speed SFM	fz* Feed/Tooth (inch)	Harder <-----> Tougher				Coolant	
ISO	Mat'l Group #VDI 3323	Type	Examples			CBN	Carbide				
						IN80B	IN2504	IN2510	IN2505		
P	1-5	Non-alloy Steel	1018, A36, 1045, A572, 1070	500-1000	.004-.010		2		1	No	
	6-9	Low-alloy Steel	4140, 4340, P20, 8620, 300M	400-700							
	10-11	High-alloy Steel	H13, A2, D2, M2, T1	300-600							
M	12-13	"Stainless Steel (Ferritic & Martensitic)"	410, 416, 440	350-600	.004-.010				1	Yes	
	14	"Stainless Steel (Austenitic)"	303, 304, 316, 15-5, 17-4	300-550						May not be required at high speeds	
K	15-16	Gray Cast Iron	CLS. 20, 30, 45	500-1000	.003-.008	1	1	2	3	No	
				1400-2600	.003-.006						
	17-20	Nodular Cast Iron	"60-40-18, 100-70-03"	400-800	.003-.008	1	1	2	3	No	
				1300-2000	.003-.006						
		CGI	CGI	300-500	.003-.005		1	2	3		
S	31-35	High-Temp Alloys	Inconel, Hastelloy, Nimonic, Monel	65-120	.004-.010					1	Yes
		Co Based > 35 HRC	Stellite, Haynes	250-500	.002-.005					1	
		Ni Based > 35 HRC	Inconel, Hasteloy	200-450	.002-.005					1	
		Fe Based > 35 HRC		150-350	.002-.005					1	
	36-37	Titanium Alloys	"6Al-4V 5Al-5Mo-5V-3Cr"	85-130	.004-.010				1		
H	38-39	Hardened Steel >48	A2, O1, D2	250-600	.003-.006	1	2			No	

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.

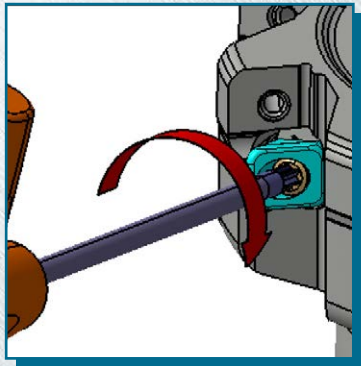
AXIAL ADJUSTMENT SET-UP

Component Identification:



1

Rotating the wedge screw clockwise, tighten the wedge to the utmost.



*Please note that you should tighten the wedge until it reaches the bottom of the pocket. Avoid using too much force.

2

Mount the insert.



*Tighten the insert screw completely (35in. lbs.)

3

Upon tightening of inserts, measure the cutter run-out, select the highest insert as a datum.



*Do not damage the insert edge on gauge setting.

Continue set-up on next page...

AXIAL ADJUSTMENT SET-UP (CONTINUED)

4

Set up the cutter height, raising one insert by turning the wedge screw counter-clockwise.



*Adjust 0.01mm (.0004") at least.

5

Adjust AXIAL RUNOUT of the remaining inserts the same way as the original insert.



*Note: The adjustable amount should not be over 0.1mm (.004").

*GAUGE user guide.



5.1

Adjust AXIAL RUNOUT by rotating the wrench gradually until it meets the 0.005mm (.0002") range.



5.2

When beyond the acceptable range. Please reset it with steps (1), (2), and (5).



6

RUNOUT adjustment is completed. (Do not clamp the insert screw any further once it is fixed.)



Continue set-up on next page...

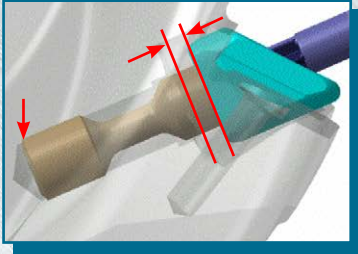
AXIAL ADJUSTMENT SET-UP (CONTINUED)

Note on Setting:

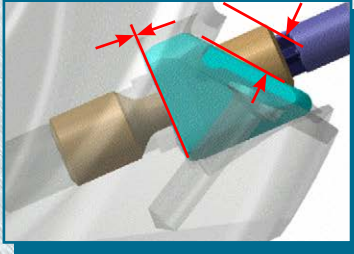
- When you change the insert corner, please start over from 1st step.
- You must remove dirt & debris on the surface of inserts or pockets before mounting inserts as this product requires high accuracy.
- When you reassemble the wedge after completely separating it, please put it together as in picture (3).

1**NO**

Gap between wedge and pocket bottom with screw bottomed out.

**2****NO**

Wedge bottomed out with screw excessively sticking out of top of wedge.

**3****YES**

Wedge bottomed out and screw is below wedge.

