MAJOR DREAM HOLDER

HSK MAJOR DREAM PRO-ENDMILL

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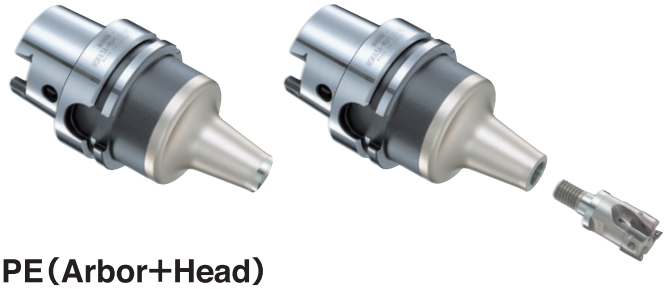

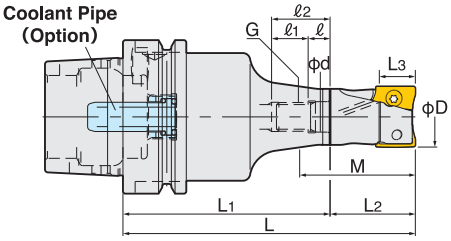

HSK-MDPE(Arbor+Head)

TAPER	Code No.	φD	L	L1	L2	MAX. Depth L3	M	Arbor Code No.	Head Code No.
HSK 63A	HSK 63A-MDPE16-100,120,135	16	100,120,135	70, 90,105	30	10	37.4	HSK 63A-MDPE-M 8- 70, 90,105	M 8-MDPE16-30
	-MDPE20-105,120,135	20	105,120,135	75, 90,105			40.0	-MDPE-M10- 75, 90,105	M10-MDPE20-30
	-MDPE25-105,120,135	25		70, 85,100	35	15	45.3,47.5,47.5	-MDPE-M12- 70, 85,100	M12-MDPE25-35
	-MDPE32-120,135,150	32	120,135,150	80, 95,110	40		52.5	-MDPE-M16- 80, 95,110	M16-MDPE32-40
HSK 100A	HSK100A-MDPE16-120,140,155	16	120,140,155	90,110,125	30	10	37.4	HSK100A-MDPE-M 8- 90,110,125	M 8-MDPE16-30
	-MDPE20-125,140,155	20	125,140,155	95,110,125			40.0	-MDPE-M10- 95,110,125	M10-MDPE20-30
	-MDPE25-125,140,155	25		90,105,120	35	15	45.3,47.5,47.5	-MDPE-M12- 90,105,120	M12-MDPE25-35
	-MDPE32-140,155,170	32	140,155,170	100,115,130	40		52.5	-MDPE-M16-100,115,130	M16-MDPE32-40

★2pcs of tip clamp bolt and tip clamp wrench are supplied as standard.
★Please refer ☞P.219 for cutting condition.
★Insert tip is available as an option . Please refer ☞P.171.
★Centre through tool coolant is available for all series.

HSK-MDPE-M(Arbor)

TAPER	Code No.	φD	L1	ID φd	Arbor Front Dia.	ℓ	ℓ1	ℓ2	Screw G
HSK 63A	HSK 63A-MDPE-M 8- 70, 90,105	16	70, 90,105	8.5	14.7	9	11	20	M 8
	-MDPE-M10- 75, 90,105	20	75, 90,105	10.5	18.7		12	21	M10
	-MDPE-M12- 70, 85,100	25	70, 85,100	12.5	23.0		15	24	M12
	-MDPE-M16- 80, 95,110	32	80, 95,110	17.0	30.0		16	25	M16
HSK 100A	HSK100A-MDPE-M 8- 90,110,125	16	90,110,125	8.5	14.7		11	20	M 8
	-MDPE-M10- 95,110,125	20	95,110,125	10.5	18.7		12	21	M10
	-MDPE-M12- 90,105,120	25	90,105,120	12.5	23.0		15	24	M12
	-MDPE-M16-100,115,130	32	100,115,130	17.0	30.0		16	25	M16

★Head is available as an option. ☞P.171 ★Centre through tool coolant is available for all series.
★This is interchangeable with DEPO. When the connection interface (Screw G and ID φd) is same, the cutter head of other carbide makers can be used.

CUTTING CONDITION of PRO-ENDMILL

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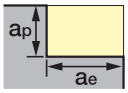
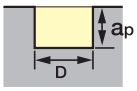
Side Milling



- The bold figures of cutting speed **V**(mm/min.) show the cutting speed when ae=0.5 X D. **V**(mm/min.) should be reduced to 80%, when ae=0.75 X D.
- Feed rate per 1 tooth/ 1 revolution **f**(mm/tooth) should be smaller, when ap is getting larger. The feed rate of **f**(mm/tooth) shows the feed rate when ae=0.5 X D & ap=MAX.

Material		Mild Steel (SS400, S10C)	Carbon Steel (S45C, SCM440)	Cast Iron (FC300)	Ductile Cast Iron (FCD450)	Hardened Steel HRC40~55 (SKD)
Cutting Speed V		**220**(140~270)	**170**(110~210)	**170**(110~210)	**120**(80~150)	**85**(50~100)
f	MDPE16	**0.1**(0.1~0.15)			**0.07**(0.07~0.1)	
	MDPE20	**0.1**(0.1~0.25)			**0.07**(0.07~0.2)	**0.07**(0.07~0.15)
	MDPE25	**0.1**(0.1~0.3)			**0.07**(0.07~0.25)	**0.07**(0.07~0.15)
	MDPE32					

Groove Milling



- Feed rate per 1 tooth/ 1 revolution **f**(mm/tooth) should be smaller, when ap is getting larger. The feed rate of **f**(mm/tooth) shows the feed rate when ae=0.5 X D & ap=MAX.
- MAX. ramping angle is **MDPE16: 15˚**, **MDPE20: 9˚**, **MDPE25: 11˚**, **MDPE32: 7˚**

Material		Mild Steel (SS400, S10C)	Carbon Steel (S45C, SCM440)	Cast Iron (FC300)	Ductile Cast Iron (FCD450)	Hardened Steel HRC40~55 (SKD)
Cutting Speed V		**180**(140~210)	**140**(110~160)	**100**(80~120)	**100**(80~120)	**70**(50~80)
f	MDPE16	**0.1**			**0.07**	
	MDPE20	**0.07**(0.07~0.1)				**0.07**
	MDPE25	**0.07**(0.07~0.15)				**0.07**
	MDPE32					

⚠ · Please clamp the insert tip with the suitable torque.
AOMT123608 : 1.0Nm , AOMT184808 : 4.0Nm
· For the guide line of insert tip life, the frank wear within 0.3mm under normal cutting will be recommended.