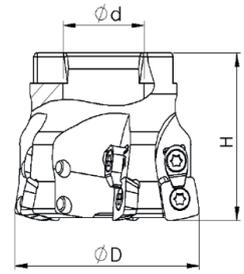




New Generation High Feed Milling Inserts



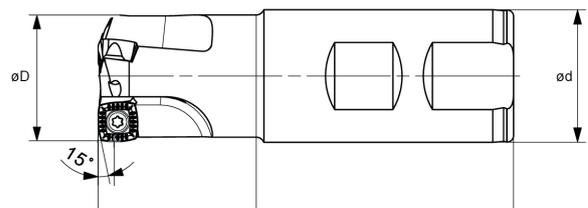
FACE MILLS



Order Code	Stock Availability	D (mm)		H (mm)	d (mm)	Insert	Screw	Torx Key
MCE040-03-SD09-C	○	40	3	32	16	SDMT0904...	M3.5X8.6	T10
MCE040-04-SD09-C	●	40	4	32	16			
MCE040-05-SD09-C	○	40	5	32	16			
MCE050-05-SD09-C	○	50	5	40	22			
MCE050-06-SD09-C	○	50	6	40	22			

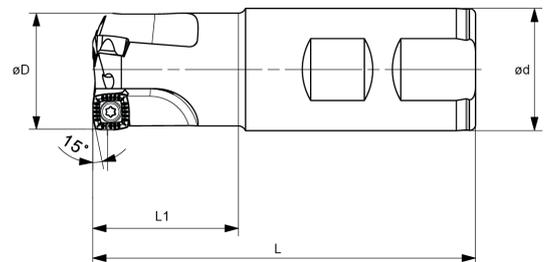
● Stock Item ○ Non Stock Item

INDEXABLE ENDMILLS



Order Code	Stock Availability	D (mm)		L1 (mm)	L (mm)	d (mm)	Insert	Screw	Torx Key
MSE025-02-SD09-200-C	●	25	2	48	200	25	SDMT0904...	M3.5X8.6	T10
MSE026-02-SD09-180-C	○	26	2	28	180	25			
MSE032-03-SD09-250-C	●	32	3	67	250	32			

● Stock Item ○ Non Stock Item

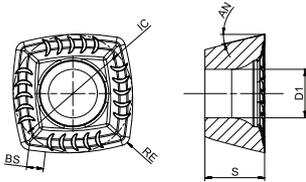


Order Code	Stock Availability	D (mm)		L1 (mm)	L (mm)	d (mm)	Insert	Screw	Torx Key
MSE025-02-SD09-96-C	○	25	2	37	96	25	SDMT0904...	M3.5X8.6	T10
MSE032-02-SD09-100-C	○	32	2	37	100	32			

● Stock Item ○ Non Stock Item

Cutter diameter (mm)	Spare parts		
	Screw	Wrench	Torque
Ø25-50	 SP035086	 DT-TP10	3.0Nm

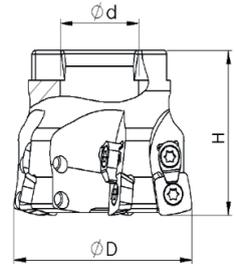
Compatible Inserts



Insert shape	Product code	Machining conditions									
		IC	S	RE	BS	D1	AN	TP2125	TP2135	TC0135	TC2225
	SDMT 090408-M3	9.525	4.76	0.8	1.3	3.9	15°	○	●		
	SDMT 120508-M3	12.7	5.56	0.8	2.2	4.4	15°	○	●		
	SDMT 120512-M3	12.7	5.56	1.2	2.2	4.4	15°	○	●		

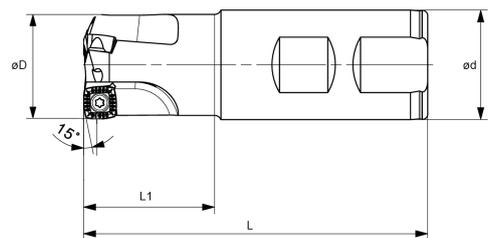
● Stock Item ○ Non Stock Item

ISO	Material classification	Tensile strength (N/mm ²)	Hardness (HB)	Cutting depth and feed							
				SDMT 090408							
				High feed milling				Plunging			
				ap		fz		ae		fz	
				(mm)							
				min	max	min	ma	min	max	min	ma
P	Unalloyed steel	<600	<180	0.20	1.20	0.30	1.50	0.00	7.00	0.05	0.15
		<950	<280								
	Alloyed steel	700-950	200-280								
		950-1200	280-355								
M	Duplex stainless steel	778	230	0.20	0.80	0.05	0.10				
	Austenitic stainless steel	675	200								
	Precipitation-hardening stainless	1013	300								
K	Grey cast iron	700	220	0.20	1.20	0.30	1.50	0.00	7.00	0.05	0.15
	Nodular cast iron	880	260								
	Malleable cast iron	800	250								
N	Aluminum	260	75	-	-	-	-				
	Aluminum alloy	447	130								
S	Fe-based alloy	943	280	0.10	0.50	0.05	0.10				
	Co-based alloy	1076	320								
	Ni-based alloy	1177	350								
	Ti-alloy	1262	370								
H	Hardened steel	-	50-60HRC	0.30	1.00	0.05	0.10				
	Chilled cast iron	-	55HRC								



Order Code	Stock Availability	D (mm)		H (mm)	d (mm)	Insert	Screw	Torx Key
MCE052-03-SD12-C	○	52	3	40	22	SDMT1205...	M4X11.2	DT-TP10
MCE052-04-SD12-C	○	52	4	40	22			
MCE052-05-SD12-C	○	52	5	40	22			
MCE063-04-SD12-C	●	63	4	40	22			
MCE063-05-SD12-C	●	63	5	40	22			
MCE066-04-SD12-C	○	66	4	45	27			
MCE066-05-SD12-C	○	66	5	45	27			
MCE080-05-SD12-C	○	80	5	50	27			
MCE080-08-SD12-C	○	80	8	50	27			
MCE100-06-SD12-C	○	100	6	50	32			
MCE100-09-SD12-C	○	100	9	50	32			
MCE125-08-SD12-C	○	125	8	63	40			
MCE125-11-SD12-C	○	125	11	63	40			

● Stock Item ○ Non Stock Item



Order Code	Stock Availability	D (mm)		L1 (mm)	L (mm)	d (mm)	Insert	Screw	Torx Key
MSE032-02-SD15-250-C	○	32	2	70	250	32	SDMT1205...	M4X11.2	T15

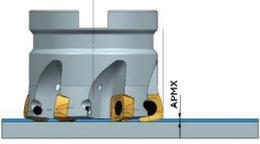
● Stock Item ○ Non Stock Item

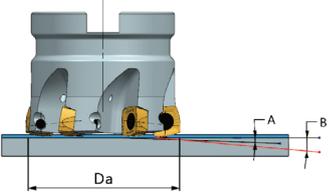
Cutter diameter (mm)	Spare parts		
	Screw	Wrench	Torque
ø32-125	 SP040112	 DT-TP15	3.5Nm

Recommended Cutting Parameters

Materials				Cutting depth and feed							
ISO	Material classification	Tensile strength (N/mm ²)	Hardness (HB)	SDMT 1205..							
				High feed milling				Plunging			
				ap		fz		ae		fz	
				(mm)							
min		max		min		max		min		max	
P	Unalloyed steel	<600	<180	0.50	1.60	0.30	2.00	0.0	10.0	0.06	0.18
		<950	<280								
	Alloyed steel	700-950	200-280								
		950-1200	280-355								
M	Duplex stainless steel	778	230	0.50	1.60	0.30	2.00	0.0	10.0	0.06	0.12
	Austenitic stainless steel	675	200								
	Precipitation-hardening	1013	300								
K	Grey cast iron	700	220	0.50	1.60	0.30	2.00	0.0	10.0	0.06	0.18
	Nodular cast iron	880	260								
	Malleable cast iron	800	250								
N	Aluminum	260	75	0.50	1.60	-	-	0.0	10.0	-	-
	Aluminum alloy	447	130								
S	Fe-based alloy	943	280	0.50	1.60	0.30	2.00	0.0	10.0	0.05	0.12
	Co-based alloy	1076	320								
	Ni-based alloy	1177	350								
	Ti-alloy	1262	370								
H	Hardened steel	-	50-60HRC	0.50	1.60	0.30	1.00	0.0	10.0	0.05	0.12
	Chilled cast iron	-	55HRC								

Application Data

Face milling	ap (mm)		
	APMX	SDMT 090408	SDMT 1205..
		1.2	1.6

Sloping	Da (mm)	Max. bevel			
		SDMT..0904..		SDMT..1205..	
		Max. bevel A	Max. bevel B	Max. bevel A	Max. bevel B
	25	2.80°	6.30°	-	-
	32	1.50°	5.00°	-	-
	40	0.80°	2.70°	-	-
	52	-	-	0.8°	2.7°
	63	-	-	0.6°	1.8°
	66	-	-	0.45°	1.8°
	100	-	-	0.32°	1.45°
	125	-	-	0.24°	1.06°

A = Max. bevel using full plane contact
 B = Max. bevel using full contact and corner radius

Plunging	Max. cutting depth a_r (mm)		
	Da (mm)	SDMT..0904..	SDMT..1205..
	25	6.0	-
	32	6.0	-
	40	6.0	-
	50	6.0	-
	52	-	9.0
	63	-	9.0
	66	-	9.0
	80	-	9.0
	100	-	9.0
	125	-	9.0

Helical interpolate milling on solid materials	Diameter range (mm) of holes milled in one feed				
	Da (mm)	SDMT..0904..		SDMT..1205..	
		D _o min (mm)	D _o max (mm)	D _o min (mm)	D _o max (mm)
	25	30	50	-	-
	32	51	64	-	-
	40	67	80	-	-
	50	87	100	-	-
	52	-	-	87.2	104
	63	-	-	109.2	126
	66	-	-	115.2	132
	80	-	-	143.2	160
	100	-	-	183.2	200
	125	-	-	233.2	250

Programming information

Helical interpolate milling on solid materials	Indexable insert						
	R	r (Insert radius)	rt (Approximate radius)	k	kr	x	
	SDMT..090408	17	0.8	2.0	6.5	1.9	1.47
	SDMT..120508	22.8	0.8	2.5	8.4	2.4	1.00
	SDMT..120512	20	1.2	3.0	8.3	2.8	0.86

Programming with the theoretical tool radius "rt" produces the maximum deviation from the final contour shown above.
The small deviations that occur only in the corners can be corrected by other tools in the subsequent process.

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