



DGC type insert line up includes double-sided SNMT and ONMT types.
Up to 16 corners can be used for improved economy.

General Features

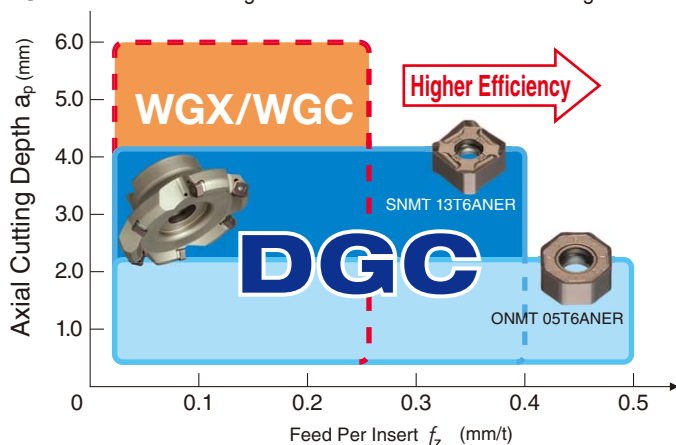
SEC-Sumi Dual Mill DGC type employs double-sided inserts with up to 16 corners for excellent economy. This is a general-purpose cutter featuring high cutting edge strength for high efficiency milling and a low-burr chipbreaker design that provides high quality machined surfaces.



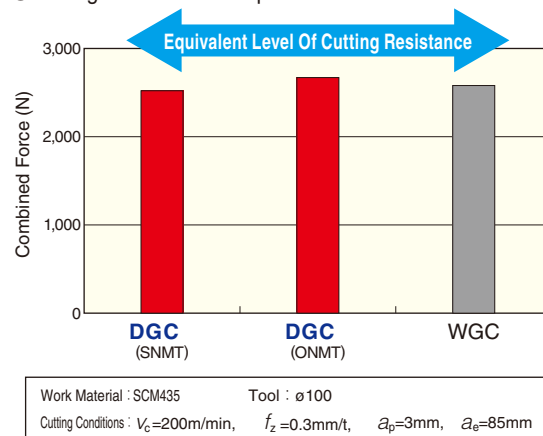
Characteristics

- Achieves level of cutting edge sharpness and machined surface quality equivalent to single-sided insert cutter at a maximum cutting depth of $a_p=3\text{mm}$ or shallower.

- Recommended Cutting Conditions For General Steel Milling



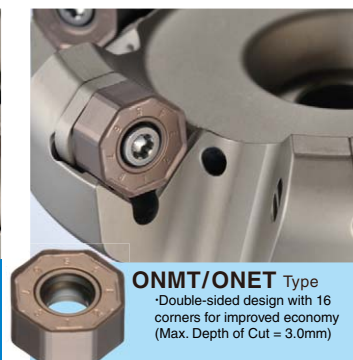
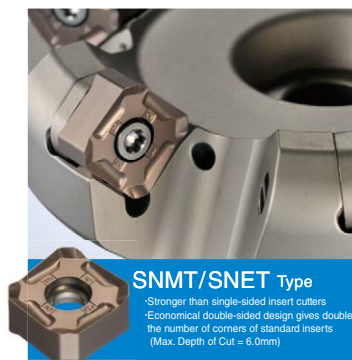
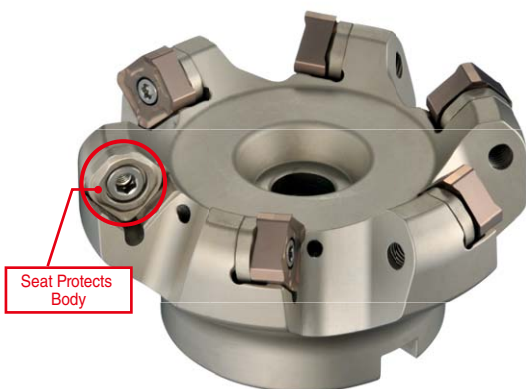
- Cutting Resistance Comparison



Dual-Purpose Body Characteristics

Two types of inserts can be used with a single body depending on milling application to help reduce tool costs.

Use Two Types Of Insert For Different Applications



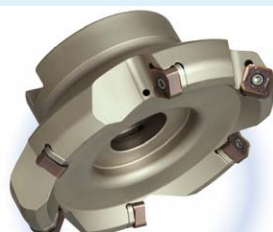
Choose A Tool To Suit Your Application From A Comprehensive Lineup

Cutter: $\phi 40\text{mm}$ to $\phi 250\text{mm}$
 Cutting Edges: **3 to 10**
 Mounting: Metric/Inch

Cutter: $\phi 50\text{mm}$ to $\phi 250\text{mm}$
 Cutting Edges: **4 to 14**
 Mounting: Metric/Inch

Cutter: $\phi 50\text{mm}$ to $\phi 250\text{mm}$
 Cutting Edges: **5 to 18**
 Mounting: Metric/Inch

Cutter: $\phi 40\text{mm}$ to $\phi 63\text{mm}$
 Cutting Edges: **3 to 4**
 Mounting: Metric/Inch



DGC 13000R(S)
Standard Pitch



DGC 13000R(S)
Fine Pitch



DGC 13000R(S)
Extra-Fine Pitch



DGC 13000EW
Endmill Type

Application Range

Work Material	Grade	Finishing to Light Cutting	Medium Cut	Rough to Heavy Cutting
P Steel	Coat	New ACP100	New ACP200	New ACP300
	Cermet		T4500A	
M Stainless Steel	Coat	New ACM200	New ACM300	

Work Material	Grade	Finishing to Light Cutting	Medium Cut	Rough to Heavy Cutting
K Cast Iron	Coat	New ACK200	New ACK300	
N Non-Ferrous Metal	Coat		DL1000	
	Carbide		EH520	

The letters "C" and "P" at either end of each grade indicate coating type. ▽ : CVD ▲ : PVD Blank: Non-coated

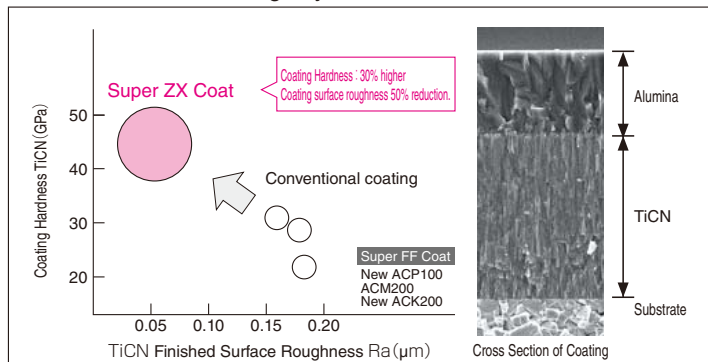
Features of Coating

C Super ZX Coat (CVD : Chemical Vapor Deposition)

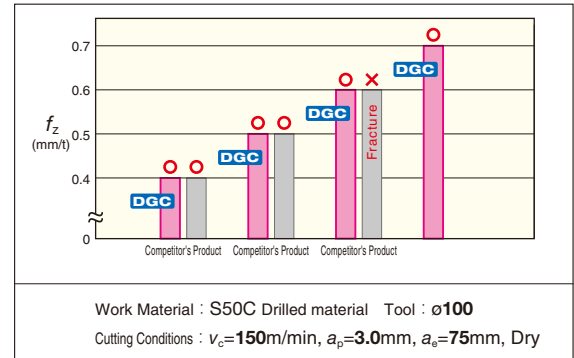
Our company's proprietary CVD process "Super FF Coat", with coating stress control technology and ultra-fine coating particles, exhibits excellent wear resistance and high reliability.

- ▶ Achieves excellent chipping resistance thanks to the smoothness of the coating and our coating stress control technology.
- ▶ High speed, high efficiency machining of more than 1.5 times that of conventional grades is possible by hardening the coating layer.
- ▶ Achieves over 2 times longer tool life compared to conventional grades under the same cutting conditions.

Characteristics of Coating Layer



Fracture Resistance

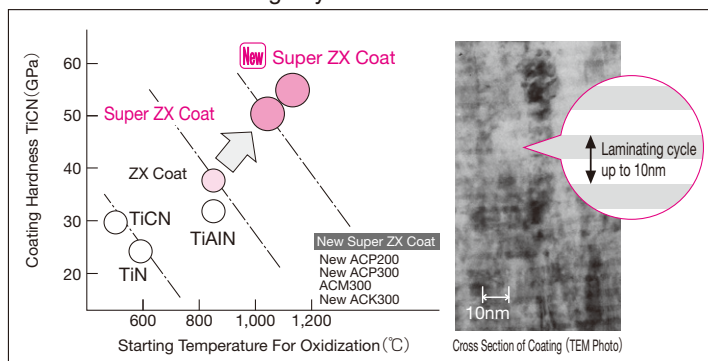


P NEW Super ZX Coat/Super ZX Coat (PVD : Physical Vapor Deposition)

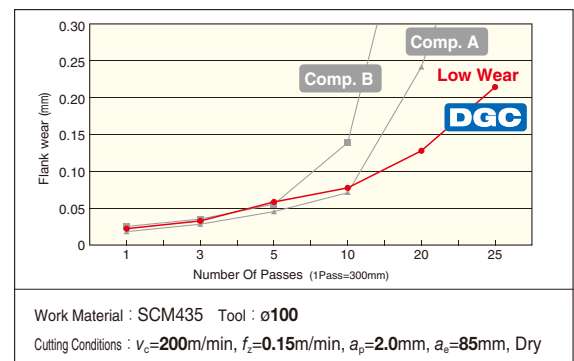
The New Super ZX Coat utilizes our proprietary thin-layer technology and advanced nanotechnology to create a coating that consists of a thousand layers of alternating, nanometer-thick coatings (1 nanometer is 1 billionth of a meter).

- ▶ Achieves excellent chipping resistance thanks to the smoothness of the coating and our coating stress control technology.
- ▶ High speed, high efficiency machining of more than 1.5 times that of conventional grades is possible by hardening the coating layer.
- ▶ Achieves over 2 times longer tool life compared to conventional grades under the same cutting conditions.

Characteristics of Coating Layer



Wear Resistance

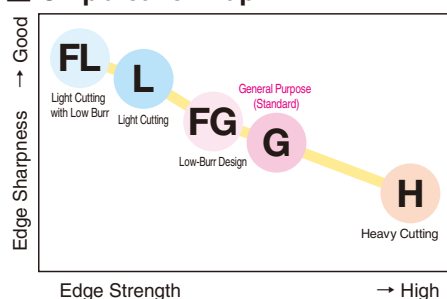


■ Chipbreaker Selection

Work Material	P M K S					N	P K
Breaker	FL	L	FG	G	H	S	W
Appearance							
Cutting Edge Insert Figure							
4 8	Not Available		Not Available		Not Available	Not Available	Double-Sided, 2 Corners (*)
Characteristics	Light Cut and with Wiper Flat	Light Cut	Standard and with Wiper Flat	Standard	High Strength	High Rake	Wiper
Application	Low Cutting Force and Low Burr	Low Cutting Force	General Purpose and Low Burr	General Purpose	Heavy Cut	Non-Ferrous Metal	Emphasis on Surface Finish

* Can be used only in combination with square inserts.

■ Chipbreaker Map



● Improved Milling Quality

- FG type chipbreakers feature chamfer to minimize burrs and provide excellent milling quality.

Low-Burr Design FG Type

With Chamfer

Chamfered Corners Reduce Burrs

● FG Type

No Burrs

Burr

FG type inserts with low-burr design enable high-quality milling with few burrs and little edge chipping.

Work Material : SCM435
Tool : $\phi 100$
Cutting Conditions : $v_c=200\text{m/min}$, $f_z=0.2\text{mm/t}$
 $a_p=3\text{mm}$, $a_e=85\text{mm}$

Cutter Diameter And Cutting Edge Height

Square Type : SNMT/SNET

Octagonal : ONMT/ONET

Attaching Octagonal Inserts

Press Down Firmly From Above

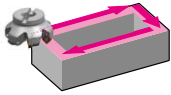
Align With Guide Faces

Note that while square inserts (SNMT) and octagonal inserts (ONMT) can be used interchangeably on the same body, they have different cutter diameters, cutting edge heights, and maximum cutting depths.

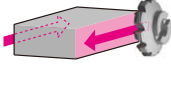
Body Shape (Example: With Cutter Diameter of 100mm)

Insert	Cutter ϕD_c (mm)	Cutting Edge Height L_f (mm)	Max. Depth of Cut a_p (mm)
SNMT/SNET	100.0	63.0	6.0
ONMT/ONET	102.9	61.4	3.0

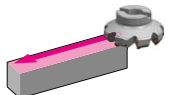
Application Examples

	Part/Work Material		Automotive Component / Cast Steel	
	Tool	Manufacturer	Sumitomo	Conventional Tool
		Body	DGCM13080R(φ80)	φ80
		Insert	SNMT13T6ANER-G (8 Corners)	Single-Sided (4 Corners)
		No. of Flutes	6	6
		Grade	ACP200	PVD Positive Type
	Cutting Conditions	Cutting Speed(m/min)	160	160
		Feed (mm/t)	0.31	0.31
		Feed Rate (mm/min)	1,184	1,184
		Axial Cutting Depth(mm)	3	3
		Cutting Width(mm)	60	60
		No. of Workpieces	2	2
		Dry/Wet	Wet	Wet

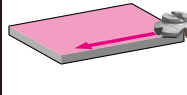
Can be used under the same conditions as the single-sided inserts. Improved tool economy with double the number of corners.

	Part/Work Material		Machine Component / S50C	
	Tool	Manufacturer	Sumitomo	Conventional Tool
		Body	DGCM13160R(φ160)	φ160
		Insert	SNMT13T6ANER-FG (8 Corners)	Single-Sided (8 Corners)
		No. of Flutes	10	10
		Grade	ACP200	PVD Positive Type
	Cutting Conditions	Cutting Speed(m/min)	133	133
		Feed (mm/t)	0.132	0.132
		Feed Rate (mm/min)	350	350
		Axial Cutting Depth(mm)	2.5	2.5
		Cutting Time	287分	287分
		Dry/Wet	Dry	Dry

Achieving higher machining quality with less burr as compared to the conventional tool.

	Part/Work Material		Machine Component / Cast Steel	
	Tool	Manufacturer	Sumitomo	Conventional Tool
		Body	DGCM13125(φ125)	φ125
		Insert	ONMT05T6ANER-G (16 Corners)	Double-Sided (8 Corners)
		No. of Flutes	8	8
		Grade	ACP200	PVD Positive Type
	Cutting Conditions	Cutting Speed(m/min)	160	160
		Feed (mm/t)	0.29	0.29
		Feed Rate (mm/min)	945	945
		Cutting Width(mm)	2.5	2.5
		Dry/Wet	Dry	Dry

Improved tool economy with double the number of corners.

	Part/Work Material		Automotive Component / Stainless Steel	
	Tool	Manufacturer	Sumitomo	Conventional Tool
		Body	DGC13100R(φ100)	φ100
		Insert	SNET13T6ANER-G (8 Corners)	Single-Sided (4 Corners)
		No. of Flutes	5	5
		Grade	ACM300	PVD Positive Type
	Cutting Conditions	Cutting Speed(m/min)	150	150
		Feed (mm/t)	0.15	0.15
		Feed Rate (mm/min)	360	360
		Axial Cutting Depth(mm)	2.0	2.0
		Dry/Wet	Wet	Wet

In addition to double the number of corners, each corner can achieve 3 times longer tool life than the conventional.

Recommended Cutting Conditions (SNMT / SNET)

ISO	Work Material	Hardness	Cutting Speed v_c (m/min) Min.-Optimum-Max.	Feed Rate f_z (mm/t) Min.-Optimum-Max.	Depth of Cut (mm)	Grade
P	General Steel	G	150-200-250	0.10-0.25-0.40	<4	ACP200 ACP300
	Soft Steel	G	180-250-350	0.10-0.30-0.45	<4	ACP200 ACP300
	Die Steel	G	100-150-200	0.15-0.25-0.35	<4	ACP200 ACP300
M	Stainless Steel	G	160-200-250	0.15-0.23-0.30	<3	ACM300
K	Cast Iron	G	100-200-250	0.10-0.25-0.40	<5	ACK200 ACK300
N	Non-Ferrous Metal	G	650-700-750	0.10-0.15-0.20	<3	DL1000

Note The cutting conditions above are a guide. Actual conditions will need to be adjusted according to machine rigidity, work clamp rigidity, cutting depth, and other factors.

Recommended Cutting Conditions (ONMT / ONET)

ISO	Work Material	Hardness	Cutting Speed v_c (m/min) Min.-Optimum-Max.	Feed Rate f_z (mm/t) Min.-Optimum-Max.	Depth of Cut (mm)	Grade
P	General Steel	G	150-200-250	0.10-0.30-0.50	<2	ACP200 ACP300
	Soft Steel	G	180-250-350	0.10-0.50-0.50	<2	ACP200 ACP300
	Die Steel	G	100-150-200	0.15-0.25-0.30	<2	ACP200 ACP300
M	Stainless Steel	G	160-200-250	0.15-0.23-0.30	<2	ACM300
K	Cast Iron	G	100-200-250	0.10-0.30-0.50	<2	ACK200 ACK300

Note The cutting conditions above are a guide. Actual conditions will need to be adjusted according to machine rigidity, work clamp rigidity, cutting depth, and other factors.

DGC13000R(S) Type

Rake Angle	Radial	-10°
	Axial	-5°

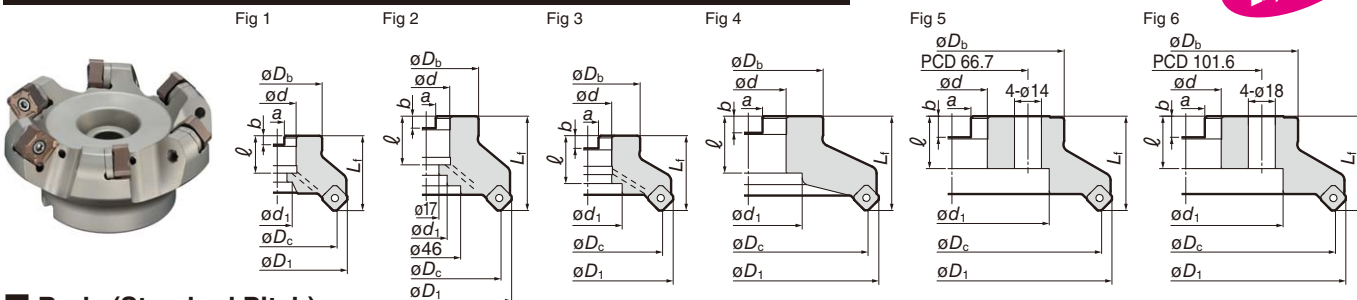


(SNMT/SNET)

(ONMT/ONET)

General Milling for Steel, Cast Iron, Exotic Alloy and Non-Ferrous Metal

Expansion



Body (Standard Pitch)

Cat. No.		Stock	Dimensions (mm)									No. of Teeth	Weight (kg)	Fig
			ϕD_c	ϕD_1	ϕD_b	L_f	ϕd	a	b	ℓ	ϕd_1			
Metric	DGC 13040RS	●	40 (42.9)	54	36	40 (38.44)	16	8.4	5.6	18	13.5	3	0.3	1
	13050RS	●	50 (52.9)	64	40	40 (38.44)	22	10.4	6.3	20	18	3	0.4	1
	13063RS	●	63 (65.9)	77	50	40 (38.44)	22	10.4	6.3	20	18	4	0.5	1
	13080RS	●	*80 (82.9)	94	60	50 (48.44)	27	12.4	7	25	20	4	1.2	1
	13100RS	●	100 (102.9)	114	70	50 (48.44)	32	14.4	8.5	32	46	5	1.6	3
	13125RS	●	125 (127.9)	139	80	63 (61.44)	40	16.4	9.5	29	52	6	2.8	1
	13160RS	●	160 (162.9)	174	130	63 (61.44)	40	16.4	9.5	29	88	7	4.5	5
	13200RS	●	200 (202.9)	214	150	63 (61.44)	60	25.7	14	35	130	8	7.1	6
13250RS	●	250 (252.9)	264	190	63 (61.44)	60	25.7	14	35	160	10	11.2	6	
Inch	DGC 13080R	●	*80 (82.9)	94	60	50 (48.44)	25.4	9.5	6	25	20	4	1.2	1
	13100R	●	*100 (102.9)	114	70	63 (61.44)	31.75	12.7	8	32.5	28	5	2.2	2
	13125R	●	125 (127.9)	139	80	63 (61.44)	38.1	15.9	10	35.5	55	6	2.8	1
	13160R	●	160 (162.9)	174	100	63 (61.44)	50.8	19.1	11	38	72	7	4.5	4
	13200R	●	200 (202.9)	214	150	63 (61.44)	47.625	25.4	14	35	130	8	7.1	6
	13250R	●	250 (252.9)	264	190	63 (61.44)	47.625	25.4	14	35	150	10	11.2	6

Figures in parentheses indicate values for ONMT/ONET type inserts.

Inserts are not included. Sizes $\phi 160$ mm or above do not have coolant holes. Figures in parentheses indicate values for ONMT type inserts.*Please use JIS B1176 hexagonal bolt ($\phi 80$: M12x30 to 35mm, $\phi 100$: M16x40 to 45mm) for securing $\phi 80/\phi 100$ cutter to the arbor.

Inserts

P Steel M Stainless Steel K Cast Iron N Non-Ferrous Metal S Exotic Alloy H Hardened Steel

Grade		Coated Carbide						Carbide		DLC	Cermet		
Application	High Speed/Light	P			K		MS		KN	N	PM		
	General Purpose		PM	PM	K		MS		KS	N	P		
	Roughing		PM	PM		K		MS					
Cat. No.		ACP100	ACP200	ACP300	ACK200	ACK300	ACM200	ACM300	H1	EH20	DL1000	T4500A	Fig
SNMT	13T6ANER-L	New	New	New	New	New							1
	13T6ANER-G												1
	13T6ANER-H												1
	13T6ANER-FL												2
	13T6ANER-FG												2
SNET	13T6ANER-L	New											1
	13T6ANER-G	New											1
	13T6ANER-FL	New											2
	13T6ANER-FG	New											2
	13T6ANFR-S	New											1
XNEU	13T6ANEN-W												3
ONMT	05T6ANER-L												4
	05T6ANER-G												4
ONET	05T6ANER-L	New											4
	05T6ANER-G	New											4

Fig 1

Fig 2

Wiper Insert

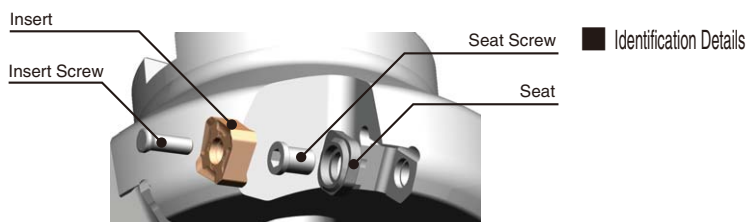
H9 (Be careful during installation.)

Fig 3

Fig 4

Wiper inserts can be used only in combination with square inserts.

* The new ACP100 and new ACK200 may vary in color or luster, but these variations do not affect the performance.



Parts

Seat	Seat Screw	L Type Wrench	Insert Screw	Spanner	Anti-seizure Cream
DGCS13R	BW06509F	LH040	BFTX0412IP	TRDR151P	SUMI-P

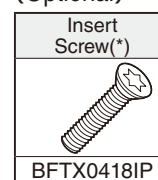
N.m Recommended Tightening Torque (N.m)

*Corners can be changed simply by loosening the screw. (Only applies to DGC / DGCM types with body size $\phi 80$ or above.

DGC 13 040 R S

(1) Cutter Series (2) Insert Size (3) Cutter (4) Direction (5) Metric Bore

(Optional)



Recommended Cutting Conditions

H31

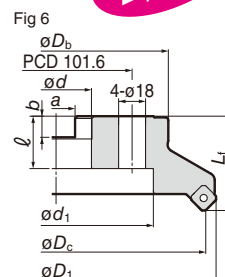
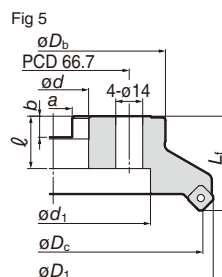
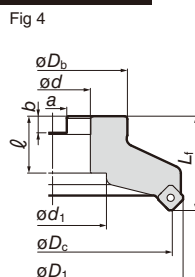
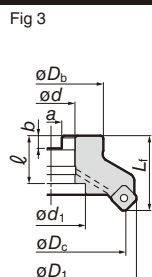
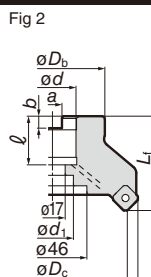
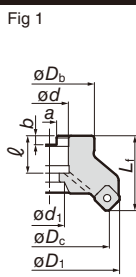
(SNMT/SNET) (ONMT/ONET)

P	M	K	N	N	S	H
Steel	Stainless Steel	Cast Iron	Non-Ferrous Metal	Aluminium	Exotic Alloy	Hardened Steel
						

DGCM13000R(S) Type

Expansion

Fig 1



Cat. No.		Stock	Dimensions (mm)									No. of Teeth	Weight (kg)	Fig
			$\varnothing D_c$	$\varnothing D_1$	$\varnothing D_b$	L_f	$\varnothing d$	a	b	ℓ	$\varnothing d_1$			
Metric	DGCM 13050RS	●	50 (52.9)	64	40	40 (38.44)	22	10.4	6.3	20	18	4	0.3	1
	13063RS	●	63 (65.9)	77	50	40 (38.44)	22	10.4	6.3	20	18	5	0.5	1
	13080RS	●	*80 (82.9)	94	60	50 (48.44)	27	12.4	7	25	20	6	1.1	1
	13100RS	●	100 (102.9)	114	70	50 (48.44)	32	14.4	8.5	32	46	7	1.5	3
	13125RS	●	125 (127.9)	139	80	63 (61.44)	40	16.4	9.5	29	52	8	2.8	1
	13160RS	●	160 (162.9)	174	130	63 (61.44)	40	16.4	9.5	29	88	10	4.6	5
	13200RS	●	200 (202.9)	214	150	63 (61.44)	60	25.7	14	35	130	12	7	6
	13250RS	●	250 (252.9)	264	190	63 (61.44)	60	25.7	14	35	160	14	11.1	6
Inch	DGCM 13080R	●	*80 (82.9)	94	60	50 (48.44)	25.4	9.5	6	25	20	6	1.1	1
	13100R	●	*100 (102.9)	114	70	63 (61.44)	31.75	12.7	8	32.5	28	7	2.2	2
	13125R	●	125 (127.9)	139	80	63 (61.44)	38.1	15.9	10	35.5	55	8	2.8	1
	13160R	●	160 (162.9)	174	100	63 (61.44)	50.8	19.1	11	38	72	10	4.6	4
	13200R	●	200 (202.9)	214	150	63 (61.44)	47.625	25.4	14	35	130	12	7	6
	13250R	●	250 (252.9)	264	190	63 (61.44)	47.625	25.4	14	35	150	14	11.1	6



Inserts are not included. Sizes $\varnothing 160$ mm or above do not have coolant holes. Figures in parentheses indicate values for ONMT type inserts.

*Please use JIS B1176 hexagonal bolt (ø80: M12x30 to 35mm, ø100: M16x40 to 45mm) for securing ø80/ø100 cutter to the arbor.

P Steel **M** Stainless Steel **K** Cast Iron **N** Non-Ferrous Metal **S** Exotic Alloy **H** Hardened Steel

Grade		Coated Carbide					Carbide		DLC	Cermet	
Application	High Speed/Light	P		K	M		K	N	P		
	General Purpose	P	P	K	M		K	N	P		
	Roughing	P	P	K	M						
Cat. No.		ACP100	ACP200	ACP300	AC/200	AC/300	H1	EH520	DL1000	T4500A	Fig
SNMT	13T6ANER-L	●	●	●	●	●					1
	13T6ANER-G	●	●	●	●	●		●		●	1
	13T6ANER-H	●	●	●	●	●					1
	13T6ANER-FL	●	●	●	●	●					2
	13T6ANER-FG	●	●	●	●	●					2
SNET	13T6ANER-L	●				●	●				1
	13T6ANER-G	●				●	●				1
	13T6ANER-FL	●				●	●				2
	13T6ANER-FG	●				●	●				2
	13T6ANFR-S	●						●	●		1
XNEU	13T6ANEN-W		●			●				●	3
ONMT	05T6ANER-L	●	●	●	●	●					4
	05T6ANER-G	●	●	●	●	●					4
ONET	05T6ANER-L	●				●	●				4
	05T6ANER-G	●				●	●				4

Fig 1

Fig 2

Wiper Insert

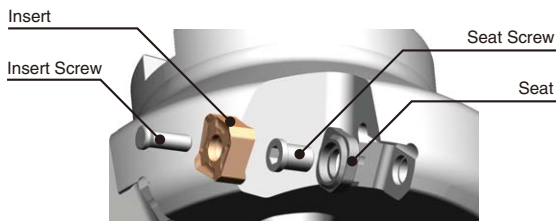
H9 (Be careful during installation.)

Fig 3

Fig 4

Wiper inserts can be used only in combination with square inserts.

* The new ACP100 and new ACK200 may vary in color or luster, but these variations do not affect the performance.



Seat	Seat Screw	L Type Wrench	Insert Screw	Spanner	Anti-seizure Cream
DGCS13R	BW06509F	LH040	BFTX0412IP 3.0	TRDR15IP	SUMI-P

(N·m) Recommended Tightening Torque (N·m)

*Corners can be changed simply by loosening the screw. (Only applies to DGC / DGCM types with body size $\phi 80$ or above.)

- mark: Standard stocked item (expanded item)

H33

H Milling Cutters

Face Milling

Radius

Multi.

Purpose

Milling

R/Copying

Groove/

Plot

Challenging

Aluminium/ Light Alloys

High-Speed

100

DGCF13000R(S) Type

Rake Angle	Radial	-10°
	Axial	-5°

6mm	45°
-----	-----

3mm	45°
-----	-----

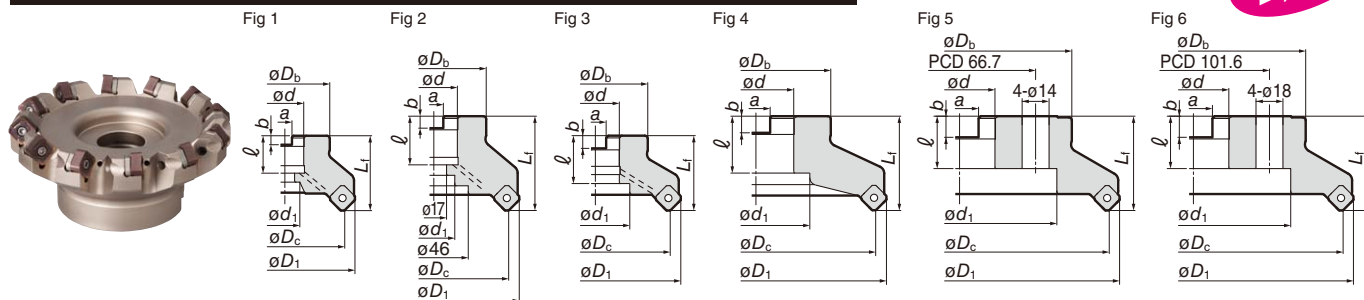
P	M	K	N	S	H
Steel	Cast Iron	Non-Ferrous Metal	Exotic Alloy	Hardened Steel	

(SNMT/SNET)

(ONMT/ONET)

General Milling for Steel, Cast Iron, Exotic Alloy and Non-Ferrous Metal

Expansion



Body (Extra-Fine Pitch)

Cat. No.		Stock	Dimensions (mm)									No. of Teeth	Weight (kg)	Fig
			ϕD_c	ϕD_1	ϕD_b	L_f	ϕd	a	b	ℓ	ϕd_1			
Metric	DGCF 13050RS	●	50 (52.9)	64	40	40 (38.44)	22	10.4	6.3	20	18	5	0.3	1
	13063RS	●	63 (65.9)	77	50	40 (38.44)	22	10.4	6.3	20	18	6	0.5	1
	13080RS	●	*80 (82.9)	94	60	50 (48.44)	27	12.4	7	25	20	8	1.1	1
	13100RS	●	100 (102.9)	114	70	50 (48.44)	32	14.4	8.5	32	46	10	1.4	3
	13125RS	●	125 (127.9)	139	80	63 (61.44)	40	16.4	9.5	29	52	12	2.7	1
	13160RS	●	160 (162.9)	174	130	63 (61.44)	40	16.4	9.5	29	88	14	4.4	5
	13200RS	●	200 (202.9)	214	150	63 (61.44)	60	25.7	14	35	130	16	6.9	6
	13250RS	●	250 (252.9)	264	190	63 (61.44)	60	25.7	14	35	160	18	11	6
Inch	DGCF 13080R	●	*80 (82.9)	94	60	50 (48.44)	25.4	9.5	6	25	20	8	1.1	1
	13100R	●	*100 (102.9)	114	70	63 (61.44)	31.75	12.7	8	32.5	28	10	2.1	2
	13125R	●	125 (127.9)	139	80	63 (61.44)	38.1	15.9	10	35.5	55	12	2.7	1
	13160R	●	160 (162.9)	174	100	63 (61.44)	50.8	19.1	11	38	72	14	4.4	4
	13200R	●	200 (202.9)	214	150	63 (61.44)	47.625	25.4	14	35	130	16	6.9	6
	13250R	●	250 (252.9)	264	190	63 (61.44)	47.625	25.4	14	35	150	18	11	6

Inserts are not included. Sizes $\phi 160$ mm or above do not have coolant holes. Figures in parentheses indicate values for ONMT/ONET type inserts.

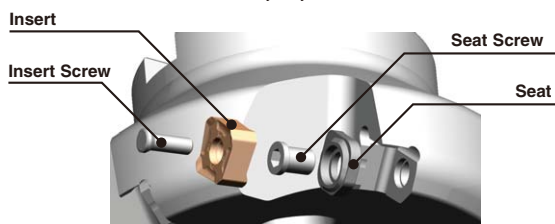
*Please use JIS B1176 hexagonal bolt ($\phi 80$: M12x30 to 35mm, $\phi 100$: M16x40 to 45mm) for securing $\phi 80/\phi 100$ cutter to the arbor.

Inserts

P Steel **M** Stainless Steel **K** Cast Iron **N** Non-Ferrous Metal **S** Exotic Alloy **H** Hardened Steel

Grade	Coated Carbide					Carbide	DLC	Cermet	Fig
Application	High Speed/Light	General Purpose	Roughing						
Cat. No.	ACP100	ACP200	ACP300	ACK200	ACK300	ACM200	ACM300	H1	
SNMT 13T6ANER-L	●	●	●	●	●				1
13T6ANER-G	●	●	●	●	●				1
13T6ANER-H	●	●	●	●	●				1
13T6ANER-FL	●	●	●	●	●				2
13T6ANER-FG	●	●	●	●	●				2
SNET 13T6ANER-L	●	●	●	●	●	●	●		1
13T6ANER-G	●	●	●	●	●	●	●		1
13T6ANER-FL	●	●	●	●	●	●	●		2
13T6ANER-FG	●	●	●	●	●	●	●		2
13T6ANFR-S	●	●	●	●	●	●	●		3
XNEU 13T6ANEN-W	●	●	●	●	●				1
ONMT 05T6ANER-L	●	●	●	●	●				4
05T6ANER-G	●	●	●	●	●				4
ONET 05T6ANER-L	●	●	●	●	●	●	●		4
05T6ANER-G	●	●	●	●	●	●	●		4

* The new ACP100 and new ACK200 may vary in color or luster, but these variations do not affect the performance.

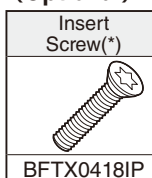


Identification Details

DGC F 13 050 R S

(1) Cutter Series (2) M: Fine Pitched F: Extra-Fine Pitched (3) Insert Size (4) Cutter (5) Direction (6) Metric Bore

(Optional)



Recommended Cutting Conditions

H31

Parts

Seat	Seat Screw	L Type Wrench	Insert Screw	Spanner	Anti-seizure Cream
DGCS13R	BW06509F	LH040	BFTX0412IP	TRDR15IP	SUMI-P

N·m Recommended Tightening Torque (N·m)

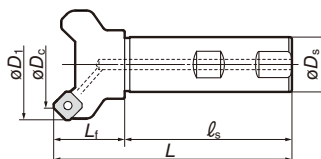
*Corners can be changed simply by loosening the screw. (Only applies to DGC / DGCM types with body size $\phi 80$ or above.)

Rake Angle	Radial	-10°	6mm	45°	3mm	45°	P	M	K	N	S	H
	Axial	-5°	(SNMT / SNET)	(ONMT / ONET)								

SEC-Sumi Dual Mill

DGC13000EW Type

General Milling for Steel, Cast Iron, Exotic Alloy and Non-Ferrous Metal



Expansion

Body (Shank Type)

Cat. No.	Stock	Dimensions (mm)						No. of Teeth	Weight (kg)
		ϕD_c	ϕD_1	ϕD_s	L_i	L_s	L		
DGC 13040EW	●	40(42.9)	54	32	40(38.44)	85	125	3	0.7
13050EW	●	50(52.9)	64	32	40(38.44)	85	125	3	0.9
13063EW	●	63(65.9)	77	32	40(38.44)	85	125	4	1.1

Figures in parentheses indicate values for ONMT/ONET type inserts.
Inserts are not included.

Inserts

P Steel M Stainless Steel K Cast Iron N Non-Ferrous Metal S Exotic Alloy H Hardened Steel

Grade		Coated Carbide					Carbide		DLC	Cermet			
Application	High Speed/Light	P		K		M	S	K	N	P			
	General Purpose		P	P	K	M	S	K	N	P			
	Roughing		P	P	K	M	S						
Cat. No.		ACP100	ACP200	ACP300	ACK200	ACK300	ACM200	ACM300	H1	EH620	DL1000	T4500A	Fig
SNMT 13T6ANER-L		●	●	●	●	●				●			1
13T6ANER-G		●	●	●	●	●			●			●	1
13T6ANER-H		●	●	●	●	●							1
13T6ANER-FL		●	●	●	●	●							2
13T6ANER-FG		●	●	●	●	●							2
SNET 13T6ANER-L		●	●	●	●	●	●	●					1
13T6ANER-G		●	●	●	●	●	●	●					1
13T6ANER-FL		●	●	●	●	●	●	●					2
13T6ANER-FG		●	●	●	●	●	●	●					2
13T6ANFR-S		●	●	●	●	●			●	●		●	1
XNEU 13T6ANEN-W		●	●	●	●	●						●	3
ONMT 05T6ANER-L		●	●	●	●	●							4
05T6ANER-G		●	●	●	●	●							4
ONET 05T6ANER-L		●	●	●	●	●	●	●					4
05T6ANER-G		●	●	●	●	●	●	●					4

Fig 1

Fig 2

Wiper Insert

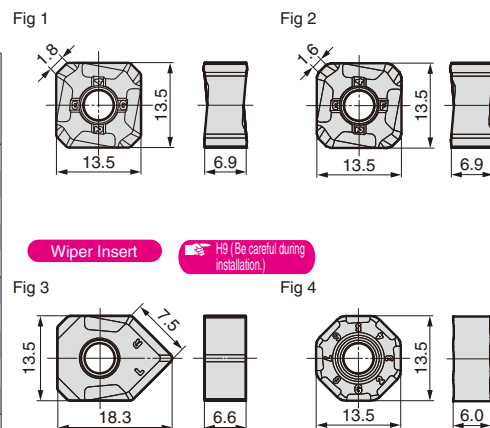
H0 (Be careful during installation.)

Fig 3

Fig 4

Wiper inserts can be used only in combination with square inserts.

* The new ACP100 and new ACK200 may vary in color or luster, but these variations do not affect the performance.



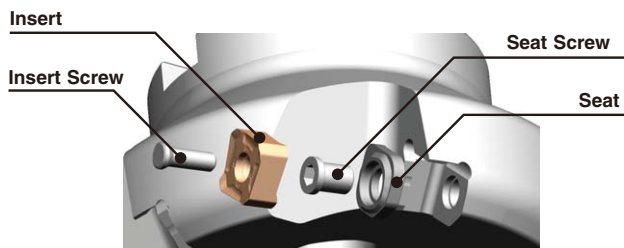
Wiper Insert

H9 (Be careful during installation.)

Wiper inserts can be used only in combination with square inserts.

H
Milling Cutters

Face Milling
Radius
Multi-Purpose
Shoulder Milling
R/Copying
Groove/T-Slot
Chamfering
Aluminum/Light Alloys
High-Speed Cast Iron



Identification Details

DGC 13 040 EW

(1) Cutter Series (2) Insert Size (3) Cutter (4) Endmill Type

Parts

Seat	Seat Screw	L Type Wrench	Insert Screw	Spanner	Anti-seizure Cream
DGCS13R	BW0609F	LH040	BFTX0412IP 3.0	TRDR15IP	SUMI-P

(Optional)

Insert Screw(*)
BFTX0418IP

Recommended Cutting Conditions

H31

Recommended Tightening Torque (N·m)

*Corners can be changed simply by loosening the screw. (Only applies to DGC / DGCM types with body size $\phi 80$ or above.)

● mark: Standard stocked item (expanded item)

H35