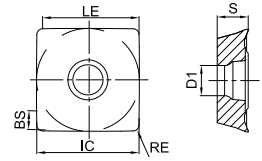





Shoulder Milling

SDKT







One Side Four Edge Shoulder Milling



Ordering Code	Dimension(mm)						Coating Grade										Uncoated	Cermet			
	LE	IC	S	BS	D1	RE	GA4225	GA4230	GA4325	GA4330	GP4225	GP2115	GM4135	GM2140	GK4125	GK2115			GS4130	GH4115	GN9125
 SDKT14T3PEER-GL	13.12	13.92	3.96	2.5	4.1	0.8	●	●			●	●	●	●	●	●	●				
 SDKT14T3PEER-GM	13.12	13.92	3.96	2.5	4.1	0.8	●	●			●	●	●	●	●	●	●				
 SDKT14T3PEER-GH	13.12	13.92	3.96	2.5	4.1	0.8			●		●				●	●					

● Stock ○ Available Upon Order

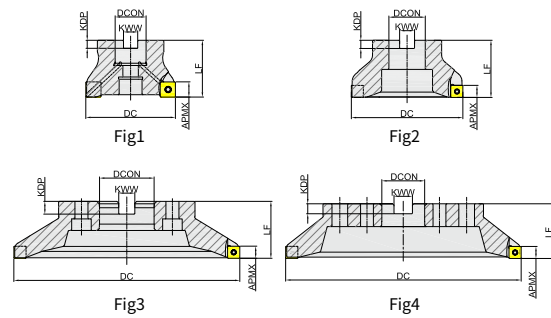
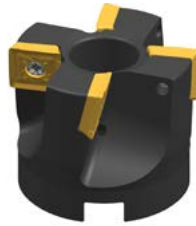
SDKT Series Geometry

Light Cutting for General Material	Medium Cutting for General Material	Heavy Cutting for General Material
		
GL	GM	GH
		
<p>Light cutting of low cutting force, good processing quality.</p>	<p>High stability in most cases.</p>	<p>Suitable on roughing, good edge strength.</p>

Shoulder Milling

MES190

Arbor



Sparse Pitch

Ordering Code	Dia-meter	Teeth	Dimension(mm)					APMX	Coolant	Suitable for	Shape	Stock
			DC	DCON	LF	KWW	KDP					
MES190050R04A22SD14	50	4	50	22	40	10.4	6.3	10	✓	SDKT14T3	Fig1	●
MES190063R05A22SD14	63	5	63	22	40	10.4	6.3	10	✓	SDKT14T3	Fig1	●
MES190080R06A27SD14	80	6	80	27	50	12.4	7	10	✓	SDKT14T3	Fig1	●
MES190100R07B32SD14	100	7	100	32	50	14.4	8	10	×	SDKT14T3	Fig2	●
MES190125R08B40SD14	125	8	125	40	63	16.4	9	10	×	SDKT14T3	Fig2	●
MES190160R08C40SD14	160	8	160	40	63	16.4	9	10	×	SDKT14T3	Fig3	○
MES190200R10C60SD14	200	10	200	60	63	25.7	14	10	×	SDKT14T3	Fig3	●
MES190250R12C60SD14	250	12	250	60	63	25.7	14	10	×	SDKT14T3	Fig3	○
MES190315R15D60SD14	315	15	315	60	80	25.7	14	10	×	SDKT14T3	Fig4	○

● Stock ○ Available Upon Order

Dense Pitch

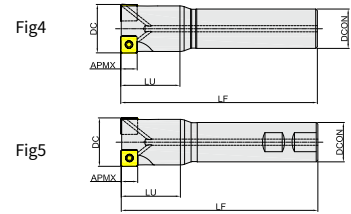
Ordering Code	Dia-meter	Teeth	Dimension(mm)					APMX	Coolant	Suitable for	Shape	Stock
			DC	DCON	LF	KWW	KDP					
MES190050R05A22SD14	50	5	50	22	40	10.4	6.3	10	✓	SDKT14T3	Fig1	●
MES190063R06A22SD14	63	6	63	22	40	10.4	6.3	10	✓	SDKT14T3	Fig1	●
MES190080R08A27SD14	80	8	80	27	50	12.4	7	10	✓	SDKT14T3	Fig1	●
MES190100R08B32SD14	100	8	100	32	50	14.4	8	10	×	SDKT14T3	Fig2	●
MES190125R10B40SD14	125	10	125	40	63	16.4	9	10	×	SDKT14T3	Fig2	●
MES190160R12C40SD14	160	12	160	40	63	16.4	9	10	×	SDKT14T3	Fig3	●
MES190200R16C60SD14	200	16	200	60	63	25.7	14	10	×	SDKT14T3	Fig3	●
MES190250R18C60SD14	250	18	250	60	63	25.7	14	10	×	SDKT14T3	Fig3	○
MES190315R24D60SD14	315	24	315	60	80	25.7	14	10	×	SDKT14T3	Fig4	○

● Stock ○ Available Upon Order

Shoulder Milling

MES190

Side Clamp Type/Cylindrical Straight Type



Ordering Code	Dia-meter	Teeth	Dimension(mm)				APMX	Suitable for	Coolant	Shape	Stock
			DC	DCON	LF	LU					
MES190040R03P20SD14	40	3	40	20	120	60	10	SDKT14T3	✓	Fig4	○
MES190040R03W32SD14	40	3	40	32	160	62	10	SDKT14T3	✓	Fig5	●
MES190040R04W32SD14	40	4	40	32	160	62	10	SDKT14T3	✓	Fig5	●
MES190050R04W32SD14	50	4	50	32	160	76	10	SDKT14T3	✓	Fig5	●
MES190050R05W32SD14	50	5	50	32	160	76	10	SDKT14T3	✓	Fig5	●

● Stock ○ Available Upon Order

Spare Parts

Part Name		Inserts Screw	Insert Screw Wrench	
Inserts	Shape			
	Specification	SI60M3.5X10-05018I	TI15P	TI15T
SDKT14T3	Ordering Code	SI60M035100-05018IS	TI15PB	TI15TB

Recommended Cutting Data

	Workpiece	Hardness	Grade	Specification	Ap (mm)	Cutting Speed Vc(m/min)	Feed Rate/Edges fz(mm)		
							Light Cutting(L)	Medium Cutting(M)	Heavy Cutting(H)
P	Soft Steel	≤ HB180	GA4225 GA4230	SDKT14T3	3	180 (140-220)	0.2 (0.1-0.3)	0.25 (0.15-0.35)	0.3 (0.2-0.4)
	Carbon Steel, Alloy Steel	HB180-350	GA4225 GA4230 GP2115	SDKT14T3	3	150 (110-190)	0.2 (0.1-0.3)	0.25 (0.15-0.35)	0.3 (0.2-0.4)
	Pre-harden Steel	HRC35-45	GA4230 GA4225 GP2115	SDKT14T3	3	150 (110-190)	0.1 (0.05-0.15)	0.15 (0.1-0.2)	0.2 (0.1-0.3)
M	Stainless (Ferrite, Martensite)	≤ HB270	GM2140 GM4135 GA4230	SDKT14T3	3	140 (100-180)	0.12 (0.1-0.2)	0.15 (0.1-0.2)	0.2 (0.1-0.3)
	Stainless (Austenite, Diphasic)	≤ HB270	GM2140 GM4135	SDKT14T3	3	120 (80-160)	0.1 (0.05-0.15)	0.15 (0.1-0.2)	0.2 (0.1-0.3)
K	Grey Cast Iron	≤ HB280	GK2115 GK4125	SDKT14T3	3	180 (140-220)	0.2 (0.1-0.3)	0.25 (0.1-0.4)	0.3 (0.2-0.5)
	Nodular Cast Iron, Vermicular Graphite Cast Iron	≤ HB350	GK4125 GK2115	SDKT14T3	3	140 (100-180)	0.1 (0.05-0.15)	0.15 (0.1-0.2)	0.2 (0.1-0.25)
S	Heat- resistant Alloy and Titanium Alloy	HRC30-45	GS4130	SDKT14T3	3	40 (30-60)	0.1 (0.05-0.15)	0.1 (0.05-0.15)	0.15 (0.1-0.2)