



MG

DLC
Coating

37.5

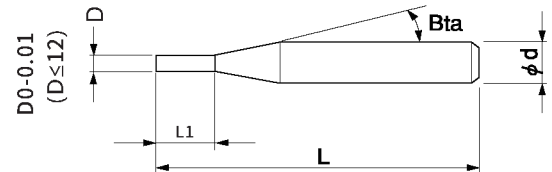
SD
0-0.003

Highly recommend ★ ○ ○
/Recommend/Suggest

DIE STEEL	Grade
Carbon steels (S45C/S55C)	
Alloy steels (SK/SCM/SUS)	
Prehardened steels (NAK/HPM)	
Hardened steels (~55/~60/~70HRC)	
SPECIAL MATERIAL	
Aluminum alloys	○
Graphite	
Copper	★
Plastics	○
Carbon fiber	
Titanium alloys	
Heat resistant alloys	
Cemented carbide	
Hard brittle (non-metallic) material	

Specialty

- * Special geometry design, sharp cutting edge, highly efficient milling and chip evacuation;
- * The coating, with good thermal stability, makes it maintain the hardness and mechanical properties under high temperature;
- * Lower coefficient of friction reduces wear during cutting and provides better surface quality;



Total 24 models

Unit (mm)

Model Number	D Outside Diameter	L1 Length Of Cut	Bta Shank Taper Angle	L Overall Length	T Number Of Flutes	d Shank Diameter	In Stock
SHDS4-0100250	1.0	2.5	12°	50	4	4	○
SHDS4-0150450	1.5	4.5	12°	50	4	4	○
SHDS4-0200600	2.0	6	12°	50	4	4	○
SHDS4-0250700	2.5	7	12°	50	4	4	○
SHDS4-0300800-3	3	8	-	50	4	3	○
SHDS4-0300800-4	3	8	12°	50	4	4	○
SHDS4-0300800-6	3	8	12°	50	4	6	○
SHDS4-0401000-4	4	10	-	50	4	4	○
SHDS4-0401000-6	4	10	12°	50	4	6	○
SHDS4-0401200-75	4	12	12°	75	4	4	○
SHDS4-0501300	5	13	12°	50	4	6	○
SHDS4-0601500	6	15	-	50	4	6	○
SHDS4-0601800-75	6	18	-	75	4	6	○
SHDS4-0601800-100	6	18	-	100	4	6	○
SHDS4-0802000	8	20	-	60	4	8	○
SHDS4-0802400-75	8	24	-	75	4	8	○

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Total 24 models

Unit (mm)

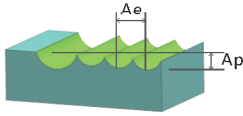
Model Number	D Outside Diameter	L1 Length Of Cut	Bta Shank Taper Angle	L Overall Length	T Number Of Flutes	d Shank Diameter	In Stock
SHDS4-0802400-100	8	24	-	100	4	8	○
SHDS4-0802400-150	8	24	-	150	4	8	○
SHDS4-1002500	10	25	-	75	4	10	○
SHDS4-1003000-100	10	30	-	100	4	10	○
SHDS4-1003000-150	10	30	-	150	4	10	○
SHDS4-1203000	12	30	-	75	4	12	○
SHDS4-1205000-100	12	50	-	100	4	12	○
SHDS4-1205000-150	12	50	-	150	4	12	○

*New size added from this series.

○ Stocked items.

4 Flutes

Square



Side Milling

Work Material	Oxygen-free & Copper	
	(min-1) Speed	(mm/min) Feed
(mm) Diameter		
D1.0	10000	220
D1.5	8000	240
D2.0	8000	300
D2.5	8000	300
D3	7000	400
D4	7000	500
D5	7000	500
D6	7000	500
D8	6500	600
D10	5500	600
D12	5000	600

Milling Amount for Side Milling(mm)

Work Material	Length of Cut	
	2.5D (Length of Cut=Diameter*2.5)	4D (Length of Cut=Diameter*4)
45HRC以下 Below 45HRC	$a_e=0.07D$ $a_p=2D$	$a_e=0.07D$ $a_p=2D$
45HRC以上 Above 45HRC	$a_e=0.03D$ $a_p=1.5D$	$a_e=0.03D$ $a_p=1.5D$

D: Diameter(mm)

 a_p : Axial Depth (mm) a_e : Radial Depth (mm)

Contour Milling

Work Material	Oxygen-free & Copper	
(mm) Diameter	(min-1) Speed	(mm/min) Feed
D1.0	18000	1600
D1.5	16000	1800
D2.0	16000	1800
D2.5	14000	2200
D3	12000	2200
D4	10000	2200
D5	9000	2500
D6	9000	2500
D8	8000	2500
D10	7000	2500
D12	6000	2500

Note:

*Decrease both spindle speed and feed rate proportionally when the milling parameters exceed the machine's maximum spindle speed;

*Recommend oil coolant for Stainless Steels and Heat Resistance Alloys;

*Recommend using a non-contact measuring device to avoid damaging the precision tip point;

*Decrease both spindle speed and feed rate proportionally in case of chattering.

4 Flutes

Square