

PRODUCT NEWS

PN-E-004
(Web-only version)

SERIES EXPANSION
New grade
"DS250", "DS217"

 **DIJET**[®]

For heat resistant alloy, titanium alloy and
hardened stainless steel

SKS-GIT Type 09

- Bore type : $\phi 40 \sim 80$
- Modular type : $\phi 20 \sim 42$
- Shank type : $\phi 25 \sim 35$



Specifically designed for high efficiency machining of difficult to cut materials

The optimized
cutting edge design provides
sharpness & low cutting resistance
that is ideal for
difficult-to-cut materials

Precise ground insert
provides
run out accuracy
and longer tool life

Multi-edge design
enables
high efficiency Machining

DIJET GmbH

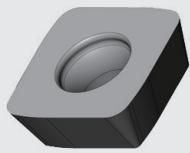
www.dijet.de

SKG09/MSG09 Type

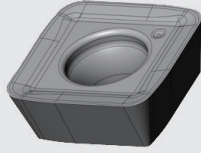
● Insert Lineup

Wear resistance

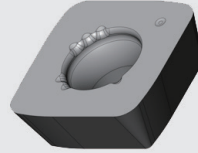
Fracture resistance



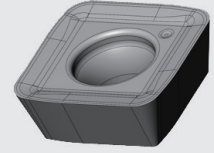
SDEW090312ZER
(JC7518/**DS217**/DS118)



SDET090312ZDER-SM
(DS118)



SDEW090312ZER
(JC7550/**DS250**/DS150)



SDET090312ZDER-SM
(JC7550/**DS250**/DS150)

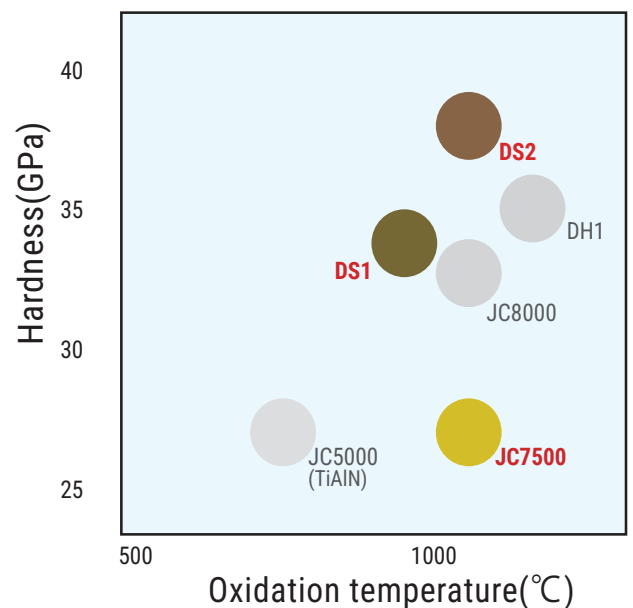
● Application

Insert	Titanium alloy	Inconel	SUS630	SUS316
SDEW090312ZER (DS217)		■	◎	
SDEW090312ZER (JC7518)		■	◎	
SDEW090312ZER (DS250)			●	◎
SDEW090312ZER (JC7550)			●	◎
SDEW090312ZER (DS118)	◎			
SDEW090312ZER (DS150)	●			
SDET090312ZDER-SM (DS250)		●	●	●
SDET090312ZDER-SM (JC7550)		●	●	●
SDET090312ZDER-SM (DS150)	●			
SDET090312ZDER-SM (DS118)	●			

◎: stable machining ●: unstable machining ■:light load machining

	DS2 Coating	DS1 Coating	JC7500 Coating
Composition	TiAlSiN	TiB ₂	AlTiCrN
Hardness (GPa)	36 - 38	33 - 35	27 - 28
Oxidation temperature (°C)	1100 - 1200	900 - 1000	1000 - 1100
Coefficient of friction	0.3	0.4	0.5

DIJET Coating MAP



SKG09
TYPE

Bore Type

Through coolant hole

G-Body

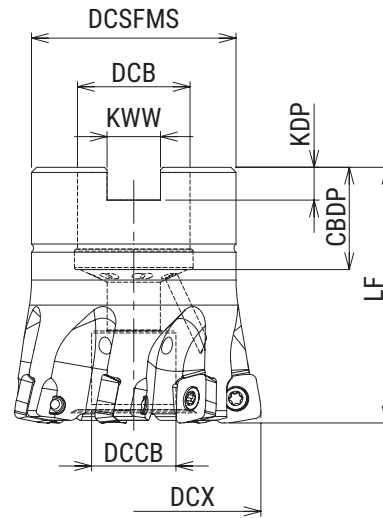
Face Milling

Copy Milling

Pocket Milling

Helical Interpolation

Plunge Milling



Cat.No.	Stock	No. of inserts	Dimensions (mm)								Arbor set bolt	Weight (kg)	Insert
			DCX	LF	DCSFMS	DCB	DCCB	KWW	KDP	CBDP			
SKG-5040R-09-16	●	5	40	40	37	16	13.5	8.4	5.6	18	M8	0.21	SDEW090312ZER SDET090312ZDER-SM
SKG-7050R-09-22	●	7	50	50	40	22	16.5	10.4	6.3	20	M10	0.35	
SKG-7052R-09-22	●		52		M10						0.37		
SKG-8063R-09-22	●	8	63	48	27	20	12.4	7	22	M12X1.75X30★	0.60		
SKG-8066R-09-27	●		66	M12X1.75X30★						0.60			
SKG-9080R-09-27	●	9	80	60						M12X1.75X30★	0.97		

All cutters are supplied without inserts or wrench.

Screw	Torque(N.m)	Wrench
DSW-307H	2.1	A-10

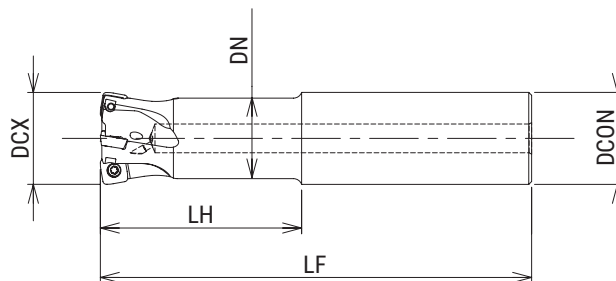
SKG09/MSG09 type

Through coolant hole



SKG09
TYPE

Shank Type



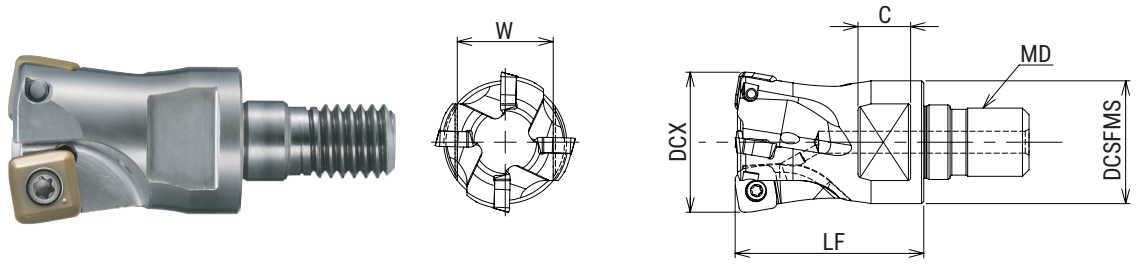
Cat.No.	Stock	No. of inserts	Dimensions (mm)					Insert
			DCX	LH	LF	DN	DCON	
SKG-3025-60-09-S25	○	3	25	60	140	23	25	SDEW090312ZER SDET090312ZDER-SM
SKG-3025-100-09-S25	○			100	180			
SKG-4032-70-09-S32	○	4	32	70	150	28	32	
SKG-4032-120-09-S32	○			120	200			
SKG-5035-70-09-S32	○	5	35	70	150	31	32	
SKG-5035-120-09-S32	○			120	200			

All cutters are supplied without inserts or wrench.

Screw	Torque(N.m)	Wrench
DSW-307H	2.1	A-10

MSG09
TYPE

Modular Type



Cat.No.	Stock	No. of inserts	Dimensions (mm)						Insert	Parts
			DCX	LF	DCSFMS	MD	C	W		
MSG-2020-09-M10	●	2	20	30	19	M10	9	14	SDEW090312ZER SDET090312ZDER-SM	DSW-306H
MSG-2022-09-M10	○		22			M10				
MSG-3025-09-M12	●	3	25	35	23	11	19	DSW-307H		
MSG-4028-09-M12	○		28		23.6					M12
MSG-4032-09-M16	●	4	32	43	28	12	22			
MSG-5035-09-M16	●		35		29			M16		
MSG-5040-09-M16	●	5	40		32	M16	14	26		
MSG-5042-09-M16	●		42			M16				

All cutters are supplied without inserts or wrench.

Screw	Torque(N.m)	Wrench
DSW-306H	1.8	A-10
DSW-307H	2.1	A-10

SKG/MSG09
TYPE

Insert

Fig. 1



Fig. 1

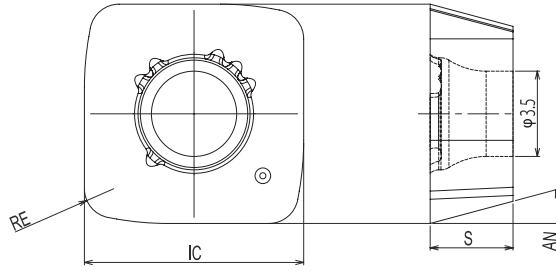
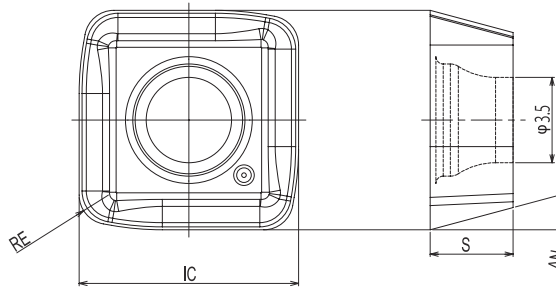


Fig. 2



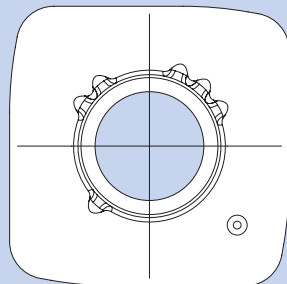
Fig. 2



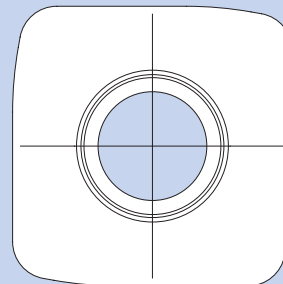
Cat.No.	Tolerance	PVD Coating						Dimensions (mm)				Fig.
		DS118	DS150	NEW DS217	JC7518	NEW DS250	JC7550	RE	IC	S	AN	
SDEW090312ZER	E	●	●	●	●	●	●	1.2	9	3.4	15°	1
SDET090312ZDER-SM		●	●			●	●					2

Note) 10 inserts per case.

GRADE MARKING



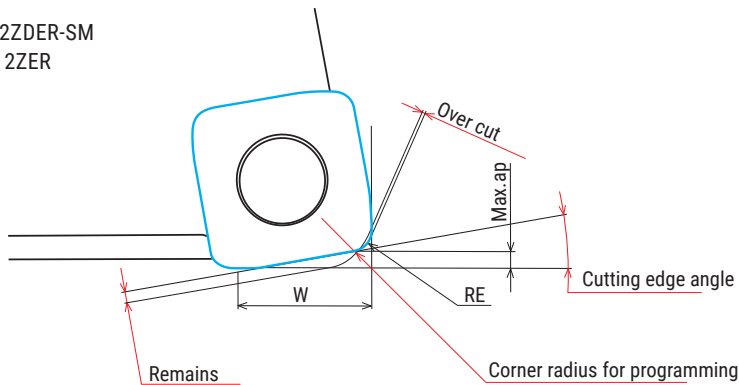
JC7550/DS250/DS150



JC7518/DS217/DS118

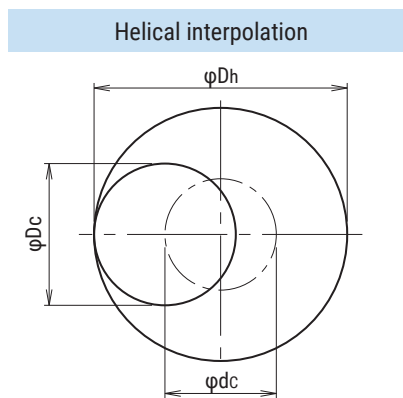
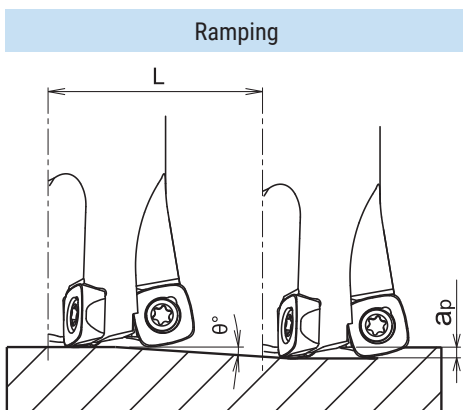
Definition of corner shape for programming

■ SDET090312ZDER-SM
SDEW090312ZER



Corner radius for programming	Remains	Over cut	Max.ap	W	Cutting edge angle
1.5	0.81	0	0.9	7.1	10°
2 (Standard)	0.73	0			
2.5	0.65	0.08			

Recommended Data for Profile Milling



- Calculation of tool pass dia.

$$\varphi_{dc} = \varphi_{Dh} - \varphi_{Dc}$$

Tool pass dia. Bore dia. Tool dia.

- Depth of cut per one circuit should not exceed max. depth of cut Ap

- Down cutting is recommended, tool pass rotation should be counterclockwise

- In case of ramping and helical interpolation, apply 70% or less feed (Vf) from standard cutting condition table

Cat.No.	Tool dia.	Effective cutting dia.	Max.depth of cut : ap	Ramping		Helical interpolation	
				Max.ramping angle θ	Total cutting length at Max.ap : L(mm)	Min.Bore dia. (mm)	Max.Bore dia. (mm)
MSG-2020-09-M10	20	5.6	0.9	1°	51.6	27	38
MSG-2022-09-M10	22	7.7	0.9	1°	51.6	31	42
MSG-3025-09-M12	25	10.7	0.9	1°	51.6	37	48
MSG-4028-09-M12	28	13.7	0.9	1°	51.6	43	54
MSG-4032-09-M16	32	17.6	0.9	1°	51.6	51	62
MSG-5035-09-M16	35	20.6	0.9	1°	51.6	57	68
MSG-5040-09-M16	40	25.7	0.9	1°	51.6	67	78
MSG-5042-09-M16	42	27.7	0.9	1°	51.6	71	82
SKG-3025-60-09-S25	25	10.7	0.9	1°	51.6	37	48
SKG-3025-100-09-S25	25	10.7	0.9	1°	51.6	37	48
SKG-4032-70-09-S32	32	17.6	0.9	1°	51.6	51	62
SKG-4032-120-09-S32	32	17.6	0.9	1°	51.6	51	62
SKG-5035-70-09-S32	35	20.6	0.9	1°	51.6	57	68
SKG-5035-120-09-S32	35	20.6	0.9	1°	51.6	57	68
SKG-5040R-09-16	40	25.7	0.9	1°	51.6	67	78
SKG-7050R-09-22	50	35.6	0.9	1°	51.6	87	98
SKG-7052R-09-22	52	37.6	0.9	1°	51.6	91	102
SKG-8063R-09-22	63	48.7	0.9	0°45'	68.8	113	124
SKG-8066R-09-27	66	51.7	0.9	0°45'	68.8	119	130
SKG-9080R-09-27	80	65.7	0.9	0°30'	103.1	147	158

Recommended Cutting Conditions - SKSG2-09 type -

Material	Insert	Grade	Vc	fz	ap	ae
Austenitic Stainless Steel	SDEW (SDET)	JC7550 (DS250)	125 - 150	0.8 - 1.0	0.3 - 0.8	0.6 Dc
Martensitic Stainless Steel	SDEW	JC7550 (DS250)	155 - 190	0.8 - 1.0	0.3 - 0.8	0.6 Dc
Duplex Stainless Steel	SDEW	DS217 JC7518 (JC7550) (DS250)	85 - 100	0.25 - 0.3	0.3 - 0.8	0.4~0.6 Dc
Titanium Alloy	SDEW	DS150 (DS118)	60	0.5 - 0.6	0.3 - 0.8	0.6 Dc
Heat Resistant Alloy	SDEW	DS217 (JC7518) (JC7550)	25 - 30	0.5 - 0.6	0.2 - 0.5	0.4~0.6 Dc

Note

1. Please adjust cutting conditions according to machine rigidity or work rigidity. (the above table is guide for cutting on a BT50 machine.)
2. In case of chatter occurring, recommended to reduce ap or rpm and keep feed per tooth.
3. ap should be reduced when using on low rigidity machine.
4. Use air blow.
5. Wet cutting is recommended for machining Super Duplex, Titanium Alloy, Heat Resistant Alloy.

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