PRODUCT NEWS

PN-E-020

SERIES EXPANSION

DIJET®

The Evolution of High Performance Shoulder Milling

SIC-EVO

NEW

SSVL type

- Bore type : ø50–ø80
- Shank type : ø32–ø40

SSV type

- Bore type : ø40–ø125
- Modular type : ø25–ø40
- Shank type : ø25–ø40

DIJET GmbH

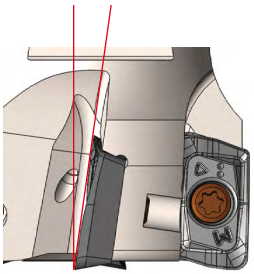
www.dijet.de

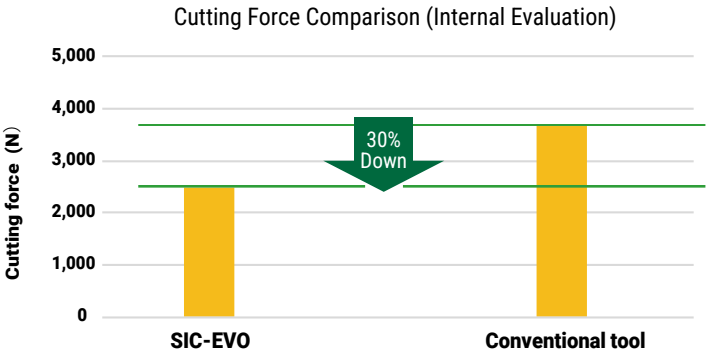
Feature 1 Arc Geometry on Peripheral Cutting Edge

The arc-shaped peripheral cutting edge
minimizes cusp height even at large depth of cut (ap),
enabling high-efficiency, high-precision machining of vertical walls.

Max. depth of cut (ap) =15mm is possible.

Feature 2 Low Cutting Force with High-Positive Geometry



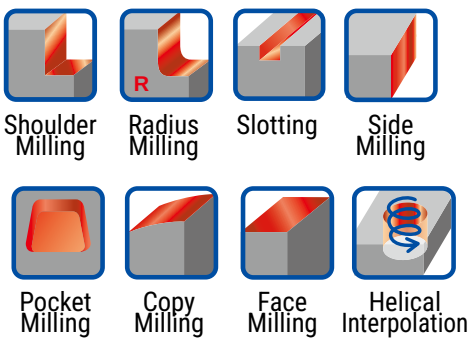


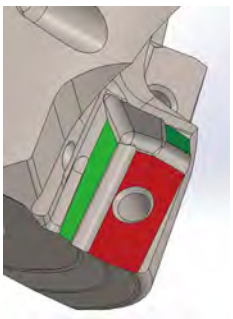
Work Material : 1.1213
Tool dia : ø25
Cutting Conditions : Vc=200m/min, fz=0.1mm/t, ap=15mm, ae=1mm

Optimized Cutting Edge Geometry

Feature 3 Multi-functional indexable cutter

Usable for a wide range of applications such as face milling, slotting,
pocket milling & side milling.





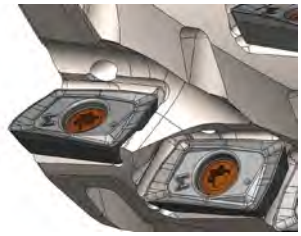
Three-face insert clamping ensures
stable ramping and helical interpolation.

Feature 4 Long Cutting Edge Cutter Body

New long-edge cutter body lineup enables deeper shoulder milling in both bore and shank type holders.

Long Cutting Edge Cutter Lineup

- Bore type
  - ø50 mm → Max. Depth of Cut(ap) : 57mm
  - ø63 mm → Max. Depth of Cut(ap) : 57mm
  - ø80 mm → Max. Depth of Cut(ap) : 71mm
- Shank type
  - ø32 mm → Max. Depth of Cut(ap) : 43mm
  - ø40 mm → Max. Depth of Cut(ap) : 57mm



- **Wide pocket geometry** enhances chip evacuation.
- **Coolant holes in every pocket** improve chip evacuation and prevent chip welding.

Feature 5 Insert Line-up

- For Steel

ZOMT1605...ZER-PM
(R0.4, R0.8, R1.6, R2.0, R3.0, R4.0, R5.0)

P M K H

- For Aluminium alloy
- High precision periphery ground insert.

ZOET1605...ZFR-NL
(R0.4, R0.8, R1.6, R2.0, R3.0, R3.2)

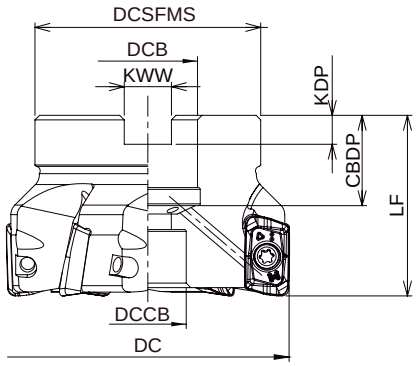
N

■ Application

ISO	P					M					K				H			N			
	P01	P10	P20	P30	P40	M01	M10	M20	M30	M40	K01	K10	K20	K30	H01	H10	H20	N01	N10	N20	N30
Range		JC8118						JC8118				JC8118				JC8118					
				JC8050					JC8050											FC18	

SSV TYPE Bore Type

Through coolant hole | Face Milling | Shoulder Milling | Slotting | Copy Milling | Pocket Milling | Helical Interpolation



Cat.No.	Stock	No. of inserts	Dimensions (mm)								Max. spindle speed (min⁻¹)	Arbor set bolt	Weight (kg)	Insert
			DC	LF	DCSFMS	DCB	DCCB	KWW	KDP	CBDP				
SSV-4040R-16	●	4	40	40	35	16	14	8.4	5.6	18	19,000	M8	0.20	ZOMT1605**ZER-PM ZOET1605**ZFR-NL
SSV-5050R-22	●	5	50	40	47	22	17	10.4	6.3	20	16,000	M10	0.33	
SSV-6063R-22	●	6	63	40	50	22	17	10.4	6.3	20	14,000	M10	0.52	
SSV-6063R-27	●	6	63	50	60	27	20	12.4	7	22	14,000	M12X1.75X30 ★	0.75	
SSV-7080R-27	●	7	80	50	60	27	20	12.4	7	22	12,000	M12X1.75X30 ★	1.08	
SSV-8100R-32	●	8	100	50	85	32	26	14.4	8	25	11,000	M16X2X30 ★	1.95	
SSV-8125R-40	●	8	125	63	100	40	32	16.4	9	32	9,600	M20X2.5X40 ★	3.73	

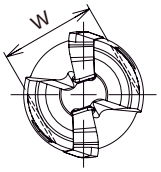
Note) When using inserts with corner radius RE4 or RE5, please machine the cutter body to R4 or C4.5.

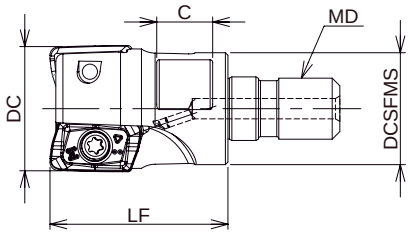
● : Stocked Items

Screw	Torque(N.m)	Wrench
DSW-4075H	3.6	A-15T

SSV TYPE Modular Type

Through coolant hole





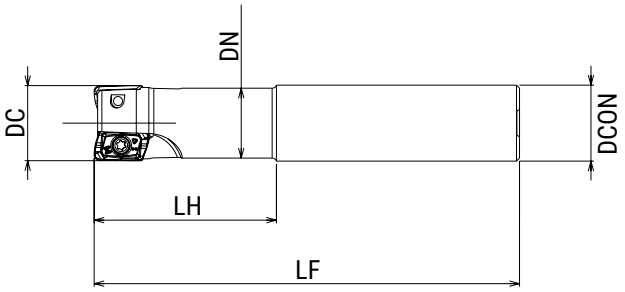
Cat.No.	Stock	No. of inserts	Dimensions (mm)						Max. spindle speed (min⁻¹)	Insert
			DC	LF	DCSFMS	MD	C	W		
SSV-2025-M12	●	2	25	35	22	M12	11	19	26,000	ZOMT1605**ZER-PM ZOET1605**ZFR-NL
SSV-2028-M12	○	2	28	35	22	M12	11	19	24,000	
SSV-3030-M16	○	3	30	43	29	M16	12	22	23,000	
SSV-3032-M16	●	3	32	43	29	M16	12	22	22,000	
SSV-3035-M16	●	3	35	43	29	M16	12	22	20,000	
SSV-4040-M16	●	4	40	43	29	M16	12	22	19,000	

Note) When using inserts with corner radius RE4 or RE5, please machine the cutter body to R4 or C4.5.

● : Stocked Items ○ : Stock in Japan

Screw	Torque(N.m)	Wrench
DSW-4075H	3.6	A-15

SSV TYPE Shank Type

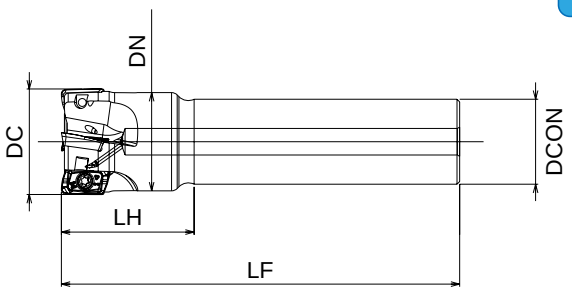


Cat.No.	Stock	No. of inserts	Dimensions (mm)					Insert
			DC	LH	LF	DN	DCON	
SSV-2025-60-S25+A	●	2	25	60	140	23	25	ZOMT1605**ZER-PM ZOET1605**ZFR-NL
SSV-2025-100-S25+A	●	2	25	100	180	23	25	
SSV-3032-70-S32+A	●	3	32	70	150	29	32	
SSV-3032-120-S32+A	●	3	32	120	200	29	32	
SSV-4040-50L-S32+A	●	4	40	50	200	37	32	

Note) When using inserts with corner radius RE4 or RE5, please machine the cutter body to R4 or C4.5.

● : Stocked Items

Through coolant hole



Cat.No.	Stock	No. of inserts	Dimensions (mm)					Insert
			DC	LH	LF	DN	DCON	
SSV-4040-50-S32	●	4	40	50	150	37	32	ZOMT1605**ZER-PM ZOET1605**ZFR-NL

Note) When using inserts with corner radius RE4 or RE5, please machine the cutter body to R4 or C4.5.

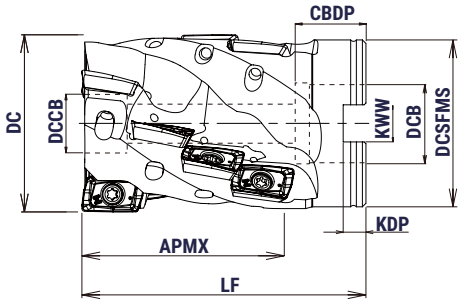
● : Stocked Items

Screw	Torque(N.m)	Wrench
DSW-4075H	3.6	A-15

SSVL TYPE Bore Type

LONG CUTTING EDGE

G-Body | Through coolant hole | Shoulder Milling



Cat.No.	Stock	No. of Flutes	No. of inserts	Dimensions (mm)									Arbor set bolt	Weight (kg)	Insert
				DC	LF	DCSFMS	DCB	DCCB	KWW	KDP	CBDP	APMX			
SSVL-3050R-57-22	●	3	12	50	80	47	22	16.5	10.4	6.3	20	57	ASB-M10065	0.75	ZOMT1605**ZER-PM
SSVL-4063R-57-27	●	4	16	63	80	60	27	20	12.4	7	22	57	ASB-M12065	1.27	
SSVL-5080R-71-32	●	5	25	80	95	70	32	26	14.4	8	25	71	ASB-M16070	2.47	

Note) 1.When using inserts with corner radius RE4 or RE5, please machine the cutter body to R4 or C4.5.
2.Corner radius RE0.8 is recommended for peripheral cutting edges, excluding the bottom cutting edge.
Inserts with corner radius RE0.4 can also be used.

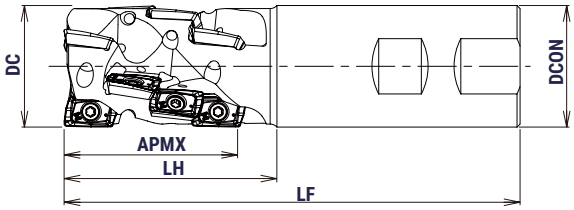
● : Stocked Items

Screw	Torque(N.m)	Wrench
DSW-4075H	3.6	A-15T

SSVL TYPE Shank Type

LONG CUTTING EDGE

G-Body | Through coolant hole



Cat.No.	Stock	No. of Flutes	No. of inserts	Dimensions (mm)					Insert
				DC	LF	DCON	LH	APMX	
SSVL-2032-43-S32	●	2	6	32	140	32	60	43	ZOMT1605**ZER-PM
SSVL-3040-57-S40	●	3	12	40	150	40	70	57	

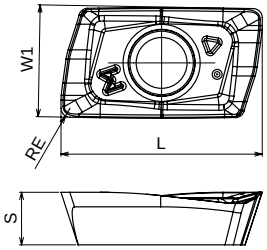
Note) 1.When using inserts with corner radius RE4 or RE5, please machine the cutter body to R4 or C4.5.
2.Corner radius RE0.8 is recommended for peripheral cutting edges, excluding the bottom cutting edge.
Inserts with corner radius RE0.4 can also be used.

● : Stocked Items

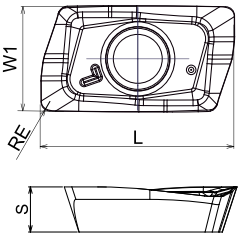
Screw	Torque(N.m)	Wrench
DSW-4075H	3.6	A-15T

Insert

For Steel



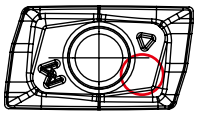
For Aluminium alloy



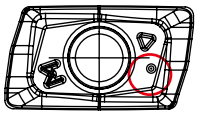
Cat.No.	Tolerance	PVD Coating		Uncoated	Dimensions (mm)			
		JC8050	JC8118	FC18	RE	L	W1	S
ZOMT160504ZER-PM	M	●	●		0.4	18	10	4.7
ZOMT160508ZER-PM	M	●	●		0.8	18	10	4.7
ZOMT160516ZER-PM	M	●	●		1.6	18	10	4.7
ZOMT160520ZER-PM	M	●	●		2.0	18	10	4.7
ZOMT160530ZER-PM	M	●	●		3.0	18	10	4.7
ZOMT160540ZER-PM	M	●	●		4.0	17	10	4.7
ZOMT160550ZER-PM	M	●	●		5.0	17	9.9	4.7
ZOET160504ZFR-NL	E			●	0.4	18	10	4.7
ZOET160508ZFR-NL	E			●	0.8	18	10	4.7
ZOET160516ZFR-NL	E			●	1.6	18	10	4.7
ZOET160520ZFR-NL	E			●	2.0	18	10	4.7
ZOET160530ZFR-NL	E			●	3.0	18	10	4.7
ZOET160532ZFR-NL	E			○	3.2	18	10	4.7

● : Stocked Items ○ : Stock in Japan

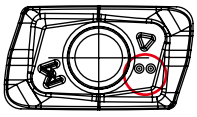
GRADE MARKINGS



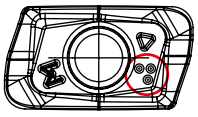
ZO*T160504Z*R-**



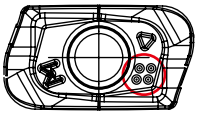
ZO*T160508Z*R-**



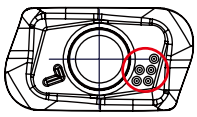
ZO*T160516Z*R-**



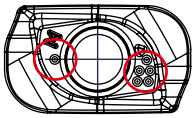
ZO*T160520Z*R-**



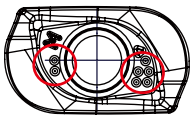
ZO*T160530Z*R-**



ZOET160532ZFR-NL

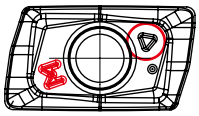


ZOMT160540ZER-PM

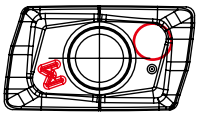


ZOMT160550ZER-PM

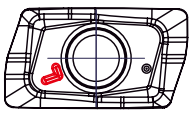
JC8050



JC8118



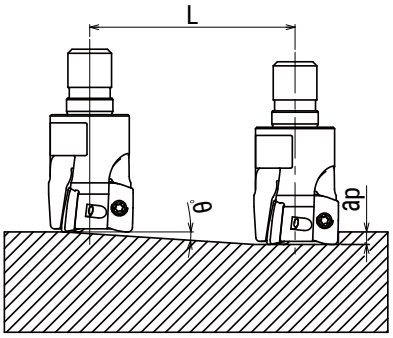
FC18



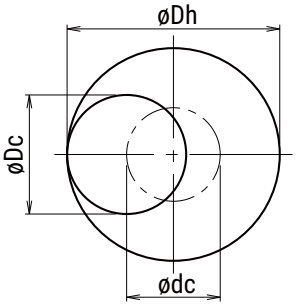
SSV TYPE

■ Recommended Data for Profile Milling

Ramping



Helical interpolation



- Calculation of tool pass dia.

$$ødc = øDh - øDc$$

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 80% or less feed (Vf) from standard cutting condition table.
- In case of drilling , apply 50% or less feed (Vf) from standard cutting condition table.
- In case of helical interpolation, recommend wet cutting by coolant through the tool.
- Long chips may come out in case of drilling, confirm safe operating conditions.

Tool dia. (mm)	Effective Cutting dia. (mm)	Ramping					Helical Interpolation		Max. Drilling Depth: Z (mm)
		Max. ramping angle θ	Max Depth of Cut : ap (mm)		Total Cutting Length at Max ap : L(mm)		Min. Bore dia. Dh min (mm)	Max. Bore dia. Dh max (mm)	
			STEELS	ALUMINIUM	STEELS	ALUMINIUM			
25	24.7−2×R	6.2	1.5	7	13.8	64.5	31	49.2−2×R	1.4
28	27.7−2×R	5.3	1.5	7	16.2	75.5	37	55.2−2×R	1.4
30	29.7−2×R	4.8	1.5	7	17.9	83.4	41	59.2−2×R	1.4
32	31.7−2×R	4.4	1.5	7	19.5	91.0	45	63.2−2×R	1.4
35	34.7−2×R	4.3	1.5	7	19.9	93.1	51	69.2−2×R	1.4
40	39.7−2×R	3.6	1.5	7	23.8	111.3	61	79.2−2×R	1.4
50	49.7−2×R	2.4	1.5	7	35.8	167.1	81	99.2−2×R	1.4
63	62.7−2×R	1.7	1.5	7	50.5	235.9	107	125.2−2×R	1.4
80	79.7−2×R	1.2	1.5	7	71.6	334.2	141	159.2−2×R	1.4
100	99.7−2×R	0.9	1.5	7	95.5	445.6	181	199.2−2×R	1.4
125	124.7−2×R	0.65	1.5	7	132.2	617.0	231	249.2−2×R	1.4

■Recommended Cutting Conditions | Shoulder Milling | SSV type

Material	Grade	*Vc* (m/min)	*fz* (mm/t)		Tool dia. (mm)							
					25	32	40	50	63	80	100	125
Carbon Steel below 250HB	JC8050	200 (160–200)	0.35 (0.20–0.35)	ap ap x ae	≤ 10.0 ≤ 15	≤ 12.0 ≤ 24	≤ 15.0 ≤ 30	≤ 15.0 ≤ 40	≤ 15.0 ≤ 45	≤ 15.0 ≤ 45	≤ 15.0 ≤ 45	≤ 15.0 ≤ 45
Cast Steel below 285HB	JC8050	180 (140–180)	0.3 (0.20–0.30)	ap ap x ae	≤ 10.0 ≤ 15	≤ 12.0 ≤ 24	≤ 15.0 ≤ 30	≤ 15.0 ≤ 40	≤ 15.0 ≤ 45	≤ 15.0 ≤ 45	≤ 15.0 ≤ 45	≤ 15.0 ≤ 45
Tool & Die Steel below 255HB	JC8050	200 (160–200)	0.35 (0.20–0.35)	ap ap x ae	≤ 10.0 ≤ 15	≤ 12.0 ≤ 24	≤ 15.0 ≤ 30	≤ 15.0 ≤ 40	≤ 15.0 ≤ 45	≤ 15.0 ≤ 45	≤ 15.0 ≤ 45	≤ 15.0 ≤ 45
Mold Steel 30-36HRC	JC8118	150 (120–150)	0.35 (0.20 -0.35)	ap ap x ae	≤ 10.0 ≤ 15	≤ 12.0 ≤ 24	≤ 15.0 ≤ 30	≤ 15.0 ≤ 40	≤ 15.0 ≤ 45	≤ 15.0 ≤ 45	≤ 15.0 ≤ 45	≤ 15.0 ≤ 45
Mold Steel 38-43HRC	JC8118	120 (90–120)	0.25 (0.15–0.25)	ap ap x ae	≤ 10.0 ≤ 12	≤ 12.0 ≤ 18	≤ 15.0 ≤ 20	≤ 15.0 ≤ 30	≤ 15.0 ≤ 30	≤ 15.0 ≤ 45	≤ 15.0 ≤ 45	≤ 15.0 ≤ 45
Hardened Die Steel 42-52HRC	JC8118	100 (80–100)	0.2 (0.10–0.20)	ap ap x ae	≤ 10.0 ≤ 8	≤ 12.0 ≤ 12	≤ 12.0 ≤ 12	≤ 15.0 ≤ 18	≤ 15.0 ≤ 25	≤ 15.0 ≤ 45	≤ 15.0 ≤ 45	≤ 15.0 ≤ 45
Grey Cast Iron below 160-260HB	JC8118	210 (210–250)	0.35 (0.20–0.35)	ap ap x ae	≤ 10.0 ≤ 15	≤ 12.0 ≤ 24	≤ 15.0 ≤ 30	≤ 15.0 ≤ 40	≤ 15.0 ≤ 45	≤ 15.0 ≤ 45	≤ 15.0 ≤ 45	≤ 15.0 ≤ 45
Nodular Cast Iron below 170-300HB	JC8118	150 (110–150)	0.3 (0.15–0.30)	ap ap x ae	≤ 10.0 ≤ 15	≤ 12.0 ≤ 24	≤ 15.0 ≤ 30	≤ 15.0 ≤ 40	≤ 15.0 ≤ 45	≤ 15.0 ≤ 45	≤ 15.0 ≤ 45	≤ 15.0 ≤ 45
Austenitic Stainless Steel	JC8050	120 (100–120)	0.2 (0.10–0.20)	ap ap x ae	≤ 10.0 ≤ 15	≤ 12.0 ≤ 24	≤ 15.0 ≤ 30	≤ 15.0 ≤ 40	≤ 15.0 ≤ 45	≤ 15.0 ≤ 45	≤ 15.0 ≤ 45	≤ 15.0 ≤ 45
Martensitic Stainless Steel	JC8118	180 (140–180)	0.3 (0.15–0.30)	ap ap x ae	≤ 10.0 ≤ 15	≤ 12.0 ≤ 24	≤ 15.0 ≤ 30	≤ 15.0 ≤ 40	≤ 15.0 ≤ 45	≤ 15.0 ≤ 45	≤ 15.0 ≤ 45	≤ 15.0 ≤ 45
Aluminium	FC18	900 (700–900)	0.2 (0.07–0.20)	ap ap x ae	≤ 15.0 ≤ 75	≤ 15.0 ≤ 75	≤ 15.0 ≤ 75	≤ 15.0 ≤ 75	≤ 15.0 ≤ 75	≤ 15.0 ≤ 75	≤ 15.0 ≤ 75	≤ 15.0 ≤ 75

Note
1. Please adjust cutting conditions according to machine rigidity or work rigidity.
2. In case of chatter occuring, recommended to reduce ap or rpm and keep feed per tooth.
3. ap should be reduced when using on low rigidity machine.
4. Use airblow. (For Aluminium machining Wet cutting is recommended.)

■Recommended Cutting Conditions | Face Milling | SSV type

Material	Grade	*Vc* (m/min)	*fz* (mm/t)		Tool dia. (mm)							
					25	32	40	50	63	80	100	125
Carbon Steel below 250HB	JC8050	150 (110–150)	0.35 (0.20–0.35)	ap	≤ 3.0	≤ 3.5	≤ 3.5	≤ 4.0	≤ 4.0	≤ 4.0	≤ 4.0	≤ 4.0
				ae	≤ 25	≤ 32	≤ 40	≤ 50	≤ 63	≤ 80	≤ 100	≤ 125
Cast Steel below 285HB	JC8050	150 (110–150)	0.35 (0.20–0.35)	ap	≤ 3.0	≤ 3.5	≤ 3.5	≤ 4.0	≤ 4.0	≤ 4.0	≤ 4.0	≤ 4.0
				ae	≤ 25	≤ 32	≤ 40	≤ 50	≤ 63	≤ 80	≤ 100	≤ 125
Tool & Die Steel below 255HB	JC8050	150 (110–150)	0.30 (0.15–0.30)	ap	≤ 3.0	≤ 3.5	≤ 3.5	≤ 4.0	≤ 4.0	≤ 4.0	≤ 4.0	≤ 4.0
				ae	≤ 25	≤ 32	≤ 40	≤ 50	≤ 63	≤ 80	≤ 100	≤ 125
Mold Steel 30–36HRC	JC8118	130 (110–130)	0.30 (0.15–0.30)	ap	≤ 3.0	≤ 3.5	≤ 3.5	≤ 4.0	≤ 4.0	≤ 4.0	≤ 4.0	≤ 4.0
				ae	≤ 25	≤ 32	≤ 40	≤ 50	≤ 63	≤ 80	≤ 100	≤ 125
Mold Steel 38–43HRC	JC8118	110 (90–110)	0.25 (0.15–0.25)	ap	≤ 2.0	≤ 2.5	≤ 2.5	≤ 3.0	≤ 3.0	≤ 3.0	≤ 3.0	≤ 3.0
				ae	≤ 25	≤ 32	≤ 40	≤ 50	≤ 63	≤ 80	≤ 100	≤ 125
Hardened Die Steel 42–52HRC	JC8118	90 (70–90)	0.20 (0.10–0.20)	ap	≤ 1.5	≤ 2.0	≤ 2.0	≤ 2.5	≤ 2.5	≤ 2.5	≤ 2.5	≤ 2.5
				ae	≤ 20	≤ 26	≤ 32	≤ 40	≤ 55	≤ 65	≤ 80	≤ 100
Grey Cast Iron below 160–260HB	JC8118	200 (130–200)	0.35 (0.20–0.35)	ap	≤ 5.0	≤ 5.5	≤ 5.5	≤ 6.0	≤ 6.0	≤ 6.0	≤ 6.0	≤ 6.0
				ae	≤ 25	≤ 32	≤ 40	≤ 50	≤ 63	≤ 80	≤ 100	≤ 125
Nodular Cast Iron below 170–300HB	JC8118	130 (110–130)	0.30 (0.15–0.30)	ap	≤ 3.0	≤ 3.5	≤ 3.5	≤ 4.0	≤ 4.0	≤ 4.0	≤ 4.0	≤ 4.0
				ae	≤ 25	≤ 32	≤ 40	≤ 50	≤ 63	≤ 80	≤ 100	≤ 125
Austenitic Stainless Steel	JC8050	110 (90–110)	0.20 (0.10–0.20)	ap	≤ 3.0	≤ 3.5	≤ 3.5	≤ 4.0	≤ 4.0	≤ 4.0	≤ 4.0	≤ 4.0
				ae	≤ 20	≤ 26	≤ 32	≤ 40	≤ 55	≤ 65	≤ 80	≤ 100
Martenstic Stainless Steel	JC8118	150 (110–150)	0.30 (0.15–0.30)	ap	≤ 3.0	≤ 3.5	≤ 3.5	≤ 4.0	≤ 4.0	≤ 4.0	≤ 4.0	≤ 4.0
				ae	≤ 25	≤ 32	≤ 40	≤ 50	≤ 63	≤ 80	≤ 100	≤ 125
Aluminium	FC18	900 (700–900)	0.20 (0.07–0.20)	ap	≤ 7.0	≤ 7.0	≤ 7.0	≤ 7.0	≤ 7.0	≤ 7.0	≤ 7.0	≤ 7.0
				ae	≤ 18	≤ 22	≤ 28	≤ 35	≤ 44	≤ 56	≤ 70	≤ 87

Note
1. Please adjust cutting conditions according to machine rigidity or work rigidity.
2. In case of chatter occuring, recommended to reduce ap or rpm and keep feed per tooth.
3. ap should be reduced when using on low rigidity machine.
4. Use airblow. (For Aluminium machining Wet cutting is recommended.)

■Recommended Cutting Conditions | Shoulder Milling | SSVL type

Material	Grade	*Vc* (m/min)	Tool dia. (mm)					
			32			40		
			ap(mm)	ap x ae(mm²)	*fz* (mm/t)	ap(mm)	ap x ae(mm²)	*fz* (mm/t)
Carbon Steel below 250HB	JC8050	160	≤ 43	≤ 86	0.23–0.27	≤ 57	≤ 171	0.23–0.27
Cast Steel below 285HB	JC8050	140	≤ 43	≤ 86	0.23–0.27	≤ 57	≤ 171	0.23–0.27
Tool & Die Steel below 255HB	JC8050	160	≤ 43	≤ 86	0.23–0.27	≤ 57	≤ 171	0.23–0.27
Mold Steel 30—36HRC	JC8118	120	≤ 43	≤ 86	0.18–0.23	≤ 57	≤ 171	0.18–0.23
Mold Steel 38—43HRC	JC8118	90	≤ 43	≤ 65	0.18–0.23	≤ 57	≤ 85	0.18–0.23
Hardened Die Steel 42—52HRC	JC8118	90	≤ 43	≤ 43	0.14–0.18	≤ 57	≤ 57	0.14–0.18
Grey Cast Iron below 160—260HB	JC8118	210	≤ 43	≤ 129	0.23–0.27	≤ 57	≤ 228	0.23–0.27
Nodular Cast Iron below 170—300HB	JC8118	130	≤ 43	≤ 129	0.18–0.23	≤ 57	≤ 228	0.18–0.23
Austenitic Stainless Steel	JC8050	100	≤ 43	≤ 86	0.14–0.18	≤ 57	≤ 171	0.14–0.18
Martensitic Stainless Steel	JC8118	150	≤ 43	≤ 86	0.18–0.23	≤ 57	≤ 171	0.18–0.23

Material	Grade	*Vc* (m/min)	Tool dia. (mm)					
			50			63		
			ap(mm)	ap x ae(mm²)	*fz* (mm/t)	ap(mm)	ap x ae(mm²)	*fz* (mm/t)
Carbon Steel below 250HB	JC8050	160	≤ 57	≤ 342	0.20–0.30	≤ 57	≤ 433	0.25–0.35
Cast Steel below 285HB	JC8050	140	≤ 57	≤ 342	0.20–0.30	≤ 57	≤ 433	0.25–0.35
Tool & Die Steel below 255HB	JC8050	160	≤ 57	≤ 239	0.20–0.30	≤ 57	≤ 302	0.25–0.35
Mold Steel 30—36HRC	JC8118	120	≤ 57	≤ 239	0.20–0.30	≤ 57	≤ 302	0.25–0.35
Mold Steel 38—43HRC	JC8118	90	≤ 57	≤ 199	0.15–0.25	≤ 57	≤ 256	0.15–0.25
Hardened Die Steel 42—52HRC	JC8118	90	≤ 57	≤ 68	0.10–0.20	≤ 57	≤ 85	0.10–0.20
Grey Cast Iron below 160—260HB	JC8118	210	≤ 57	≤ 342	0.20–0.30	≤ 57	≤ 433	0.25–0.35
Nodular Cast Iron below 170—300HB	JC8118	130	≤ 57	≤ 342	0.15–0.25	≤ 57	≤ 433	0.20–0.30
Austenitic Stainless Steel	JC8050	100	≤ 57	≤ 239	0.10–0.20	≤ 57	≤ 302	0.10–0.20
Martensitic Stainless Steel	JC8118	150	≤ 57	≤ 342	0.15–0.25	≤ 57	≤ 433	0.20–0.30

Note) 1. Please adjust cutting conditions according to machine rigidity or work rigidity.
2. In case of chatter occuring, recommended to reduce ap or rpm and keep feed per tooth.
3. ap should be reduced when using on low rigidity machine.
4. Use airblow.

HEADQUARTERS
DIJET Industrial Co.Ltd.
2-1-18, Kami-Higashi,
Hirano-ku, Osaka 547-0002, Japan
www.dijet.co.jp

DIJET GmbH (EUROPE)
Immermannstraße 9
40210 Düsseldorf, Germany
PHONE +49-211-50088820

YouTube | DIJET EUROPE

Official website | www.dijet.de

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