

HEPTA MILL

HEP Type

HEP
TYPE

High Feed Mill with 7 Cutting-Edge



- Max. Depth of cut 5mm at fz=1mm/tooth is possible.
- Insert with thickness 6.35mm is durable for heavy roughing.
- Heptagonal insert with unique geometry for lower cutting force.
- Multi functional cutter for ramping , pocket milling , plunging.



Fig.1

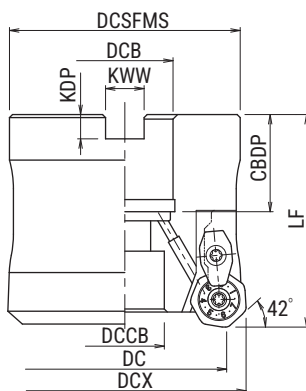


Fig.2

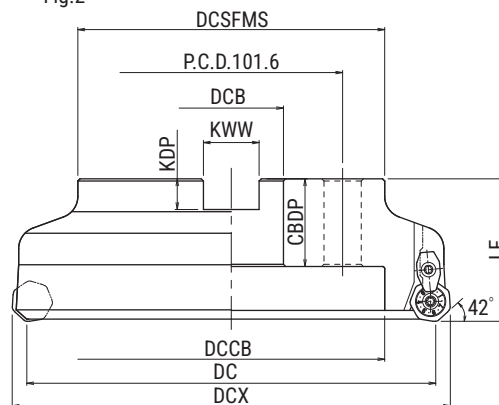
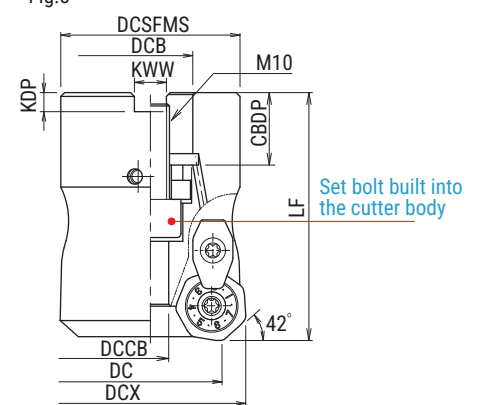


Fig.3



Cat.No.	Stock	No. of inserts	Dimensions (mm)									Arbor set bolt	Parts		Weight (kg)	Inserts	Fig.
			DC	DCX	LF	DCSFMS	DCB	DCCB	KWW	KDP	CBDB		Screw	Wrench			
HEP-3050R-08-22	●	3	36.7	50	65	47	22	9.6	10.4	6.3	19	M10X1.5X25	DSW-4512H	A-20	0.9	XD**080 ...	3
HEP-4063R-08-22	●	4	49.5	63	50	60	22	17	10.4	6.3	20	M10			1.1		1
HEP-4063R-08-27	●	4	49.5	63	50	60	27	20	12.4	7	22	M12X1.75X30			1.1		
HEP-5080R-08-27	●	5	66.6	80	55	76	27	20	12.4	7	22	M12X1.75X40			1.9		
HEP-6100R-08-32	●	6	86.6	100	70	96	32	26	14.4	8	32	M16X2X45			3.6		
HEP-7125R-08-40	●	7	111.6	125	70	100	40	32	16.4	9	35	M20X2.5X45			5.5		
HEP-8160R-08-40	●	8	146.6	160	70	100	40	32	16.4	9	35	M20X2.5X45	A-20L		8.4		2
HEP-9200R-08-60	●	9	186.6	200	65	140	60	140	25.4	14.3	40	M16			10.2		

Screw	Torque(N.m)
DSW-4512H	6

Insert

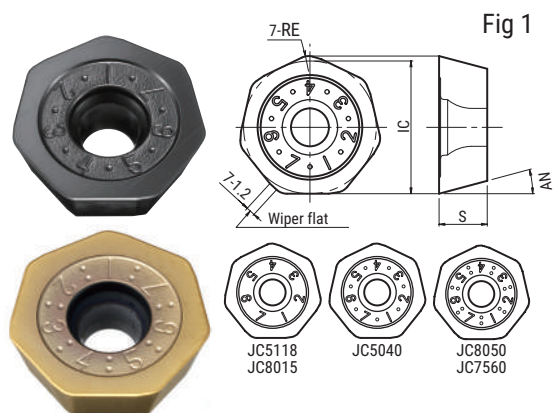


Fig 1

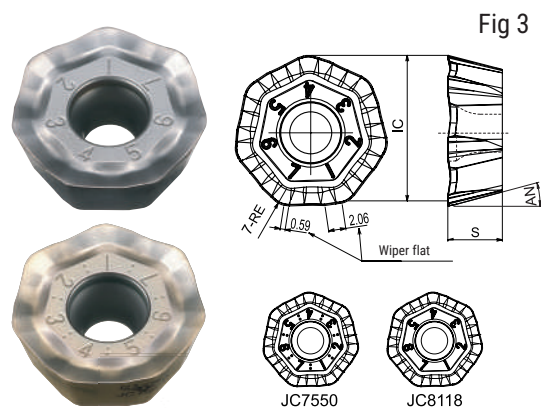


Fig 3

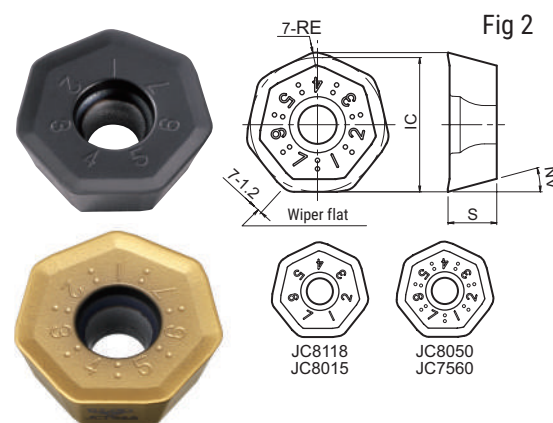


Fig 2

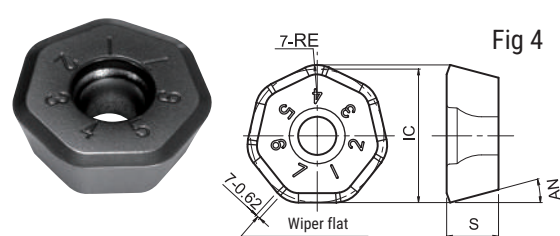


Fig 4

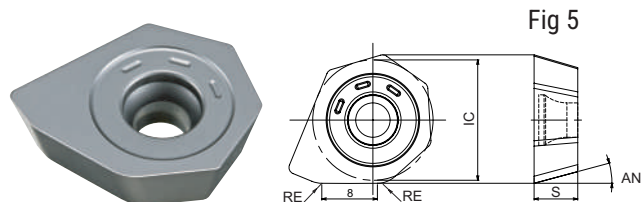


Fig 5

Cat.No.	Tolerance	PVD Coating							Dimensions(mm)				Fig.
		JC5040	JC7550	JC7560	JC8011	JC8015	JC8050	JC8118	RE	IC	S	AN	
XDMW080620ZTR	M	●		●			●	●	2	17.5	6.35	15°	1
XDMW080635ZTR-S						●			3.5				4
XDMT080620ZER				●			●	●	2	17.341	6.5		2
XDMT080620ZER-ML			●					●					3
XDHW080610ZER-W	H				●				4	17.5	6.35		5

■ Recommended Cutting Conditions

Material	Insert	Grade	General Cutting			Unstable Cutting			ae
			Vc	fz	ap	Vc	fz	ap	
Carbon Steel below 250HB	XDMT080620ZER (XDMW080620ZTR) [XDMW080620ZTR]	JC7560 (JC5040) [JC7560]	140	~0.8	~4	120	~0.8	~4	0.7 Dc
Tool & Die Steel below 255HB	XDMT080620ZER (XDMW080620ZTR) [XDMW080620ZTR]	JC7560 (JC5040) [JC7560]	140	~0.7	~3	120	~0.7	~3	0.7 Dc
Mold Steel 30-36 HRC	XDMT080620ZER (XDMT080620ZER) [XDMW080620ZTR]	JC8118 (JC7560) [JC5040]	140	~0.7	~3	120	~0.7	~3	0.7 Dc
Mold Steel 38-43 HRC	XDMT080620ZER (XDMT080620ZER) [XDMW080620ZTR]	JC8118 (JC8015) [JC8118]	100	~0.7	~3	90	~0.7	~3	0.7 Dc
Hardened Die Steel 42-52 HRC	XDMT080620ZER (XDMT080620ZER) [XDMW080620ZTR]	JC8118 (JC8015) [JC8118]	70	~0.4	~2	70	~0.3	~2	0.4 Dc
Grey Cast Iron	XDMT080620ZTR (XDMT080620ZTR) [XDMW080635ZTR-S]	JC8015 (JC8118) [JC8015]	140	~1.0	~5	120	~1.0	~5	0.7 Dc
Nodular Cast Iron	XDMT080620ZTR (XDMT080620ZTR) [XDMW080635ZTR-S]	JC8015 (JC8118) [JC8015]	120	~0.8	~4	100	~0.7	~4	0.7 Dc
Austenitic Stainless Steel	XDMT080620ZER (XDMT080620ZER) [XDMT080620ZER-ML]	JC8050 (JC7560) [JC7550]	120	~0.5	~4	100	~0.5	~4	0.7 Dc
Titanium Alloy	XDMT080620ZER-ML (XDMT080620ZER) [XDMT080620ZER]	JC7550 JC5040 [JC8118]	60	~0.3	~3	50	~0.2	~3	0.6 Dc
Heat Resistant Alloy	XDMT080620ZER-ML (XDMT080620ZER) [XDMT080620ZER]	JC8118 (JC8118) [JC8015]	30	~0.2	~2	25	~0.2	~2	0.5 Dc

Note

1. Please adjust cutting conditions according to machine rigidity or work rigidity.
2. In case of chatter occurring, recommended to reduce ap or Vf.
3. Use airblow.
4. XDMW080635ZTR-S is recommended to cut cast steel with crusty and nonuniform surface.