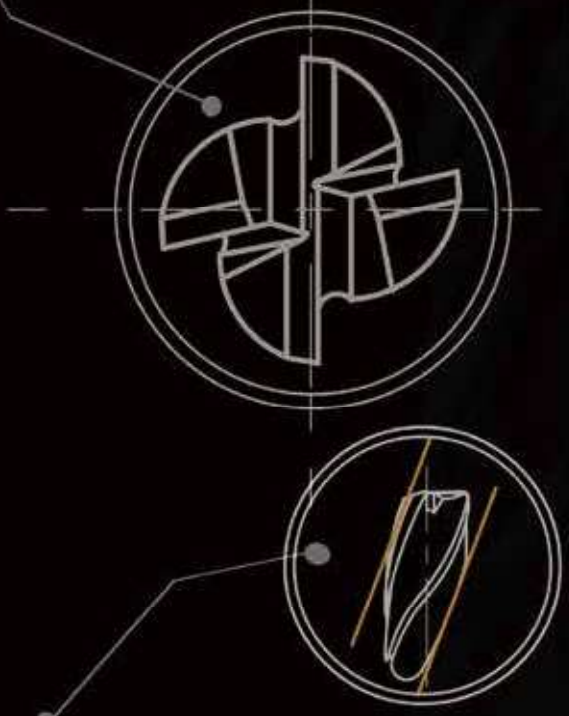
SPEED TIGER

UNEQUAL FLUTE



UNEQUAL HELIX ANGLE

DH+

Milling in any way

HSC HPC

ENDMILL

DH+ SERIES

INDEX

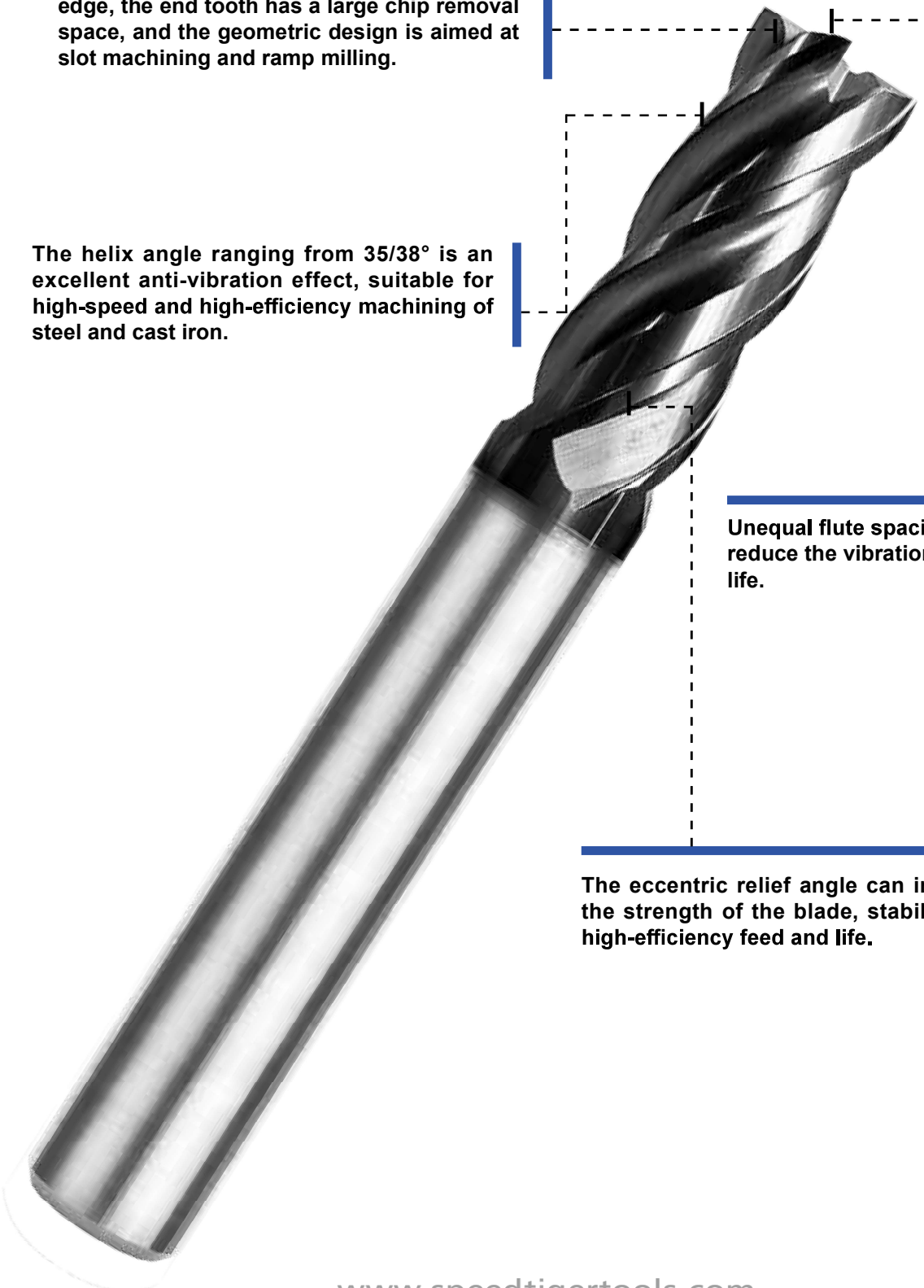
Shape	Flute	Type	Mode	Pho	Coating	Spec.	Cutting Condition
Square	4	d x 1.5	DHS+		nACRo	48	147
Square	4	d x 2~2.5	DH+		ZrN-A	49	147

DH+ SERIES

CHARACTERISTICS

The long edge passes through the center edge, the end tooth has a large chip removal space, and the geometric design is aimed at slot machining and ramp milling.

The helix angle ranging from 35/38° is an excellent anti-vibration effect, suitable for high-speed and high-efficiency machining of steel and cast iron.

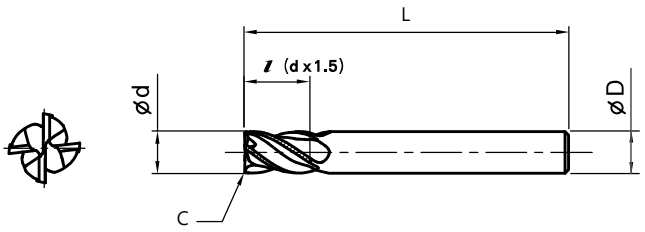


Unequal flute spacing design can reduce the vibration and prolong life.

The eccentric relief angle can increase the strength of the blade, stabilize and high-efficiency feed and life.

DHS+ d x 1.5

Cutting Condition P147





MODE	Diameter	Flute Length	Full Length	Shank Diameter	Chamfer	Flute	Coating	
	d	ℓ	L	D	C	Z	ZrN-A	nACRo
DHS+0304	3	4.5	50	4	0.05	4	.03	.08
DHS+0404	4	6.0	50	4	0.06	4	.03	.08
DHS+0504	5	7.5	50	6	0.08	4	.03	.08
DHS+0604	6	9.0	50	6	0.09	4	.03	.08
DHS+0804	8	12.0	60	8	0.12	4	.03	.08
DHS+1004	10	15.0	75	10	0.15	4	.03	.08
DHS+1204	12	18.0	75	12	0.18	4	.03	.08
DHS+1604	16	24.0	100	16	0.24	4	.03	.08
DHS+2004	20	30.0	100	20	0.30	4	.03	.08

Application :

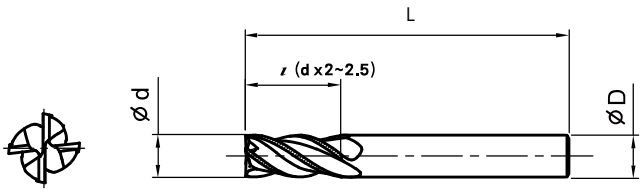
★ Perfect ◎ Excellent ○ Good

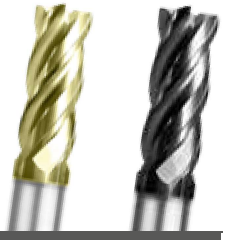
Coating	Carbon steel, Alloy steel	Pre-harden steel	High-hardened				Stainless steel	Titanium alloy	Nickel/Inconel alloy	Copper alloy	Aluminum alloy	Cast iron
		~45HRC	~50HRC	~55HRC	~60HRC	~65HRC						
nACRo	◎	◎	◎	○			○		○			◎
ZrN-A	◎	◎	○	○			○					◎

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DH+ d x 2~2.5

Cutting Condition P147





MODE	Diameter	Flute Length	Full Length	Shank Diameter	Flute		
	d	ℓ	L	D	Z	ZrN-A	nACRo
DH+0404	4	10.0	50	4	4	.03	.08
DH+0604	6	13.0	50	6	4	.03	.08
DH+0804	8	19.0	60	8	4	.03	.08
DH+1004	10	22.0	75	10	4	.03	.08
DH+1204	12	26.0	75	12	4	.03	.08
DH+1604	16	32.0	100	16	4	.03	.08
DH+2004	20	40.0	100	20	4	.03	.08

Application :

★ Perfect ◎ Excellent ○ Good

Coating	Carbon steel, Alloy steel	Pre-harden steel	High-hardened				Stainless steel	Titanium alloy	Nickel/Inconel alloy	Copper alloy	Aluminum alloy	Cast iron
		~45HRC	~50HRC	~55HRC	~60HRC	~65HRC						
nACRo	◎	◎	◎	○			○		○			◎
ZrN-A	◎	◎	○	○			○					◎