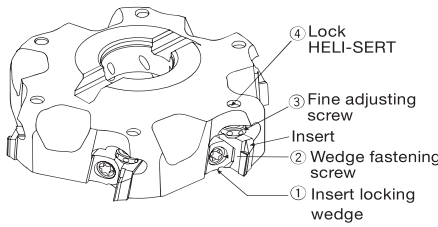


Replacement parts

No.	Description	Part Cat. No.		
		EDPD09063R EDPD09063RB	EDPD09080R EDPD09080RB	DPD09100R~ DPD09160R DPD09100RB~ DPD09160RB
①	Insert locking wedge	FW-304R-T	FW-304R-T	FW-304R-T
②	Wedge fastening screw	FDS-8SST	FDS-8ST-18	FDS-8ST-18
③	Fine adjusting screws	AJM5	AJM5	AJM5
④	Lock HELI-SERT	LM5-0.8 × 1DNS	LM5-0.8 × 1DNS	LM5-0.8 × 1DNS
	Cutter mounting screw	-	CM12 × 30H	TMBA-M12H
	Wrench for locking insert	T-27T	T-27T	T-27T
	Wrench for fine adjusting	T-7F	T-7F	T-7F



Standard Cutting Conditions

Work materials	Insert grade	Figure	Cutting speed v_c (SFM)	Feed per tooth f_z (in/t)
Aluminum alloy castings & die castings (Si < 13%)	DX140	Fig.1	1640 ~ 13,120	.002 ~ .008
Aluminum alloy castings & die castings (Si ≥ 13%)			650 ~ 1640	
Rolled aluminum alloys			1640 ~ 13,120	
Copper alloys			650 ~ 1640	

Notes:

- When requiring improved surface finish, use the wiper insert together with regular inserts (Fig.2).
- When requiring reduced burr occurrence, use the deburring inserts together with regular inserts (Fig.3).
- When using the cutter at speeds over 4920 SFM, use an arbor or toolholder well balanced to within G16.
- Wet cutting, using a water soluble cutting fluid, is recommended.
- When the length to diameter overhang ratio of the tool (L/D) exceeds 3, reduce cutting speed and feed to 70 to 80% of the values given in the table.

How to put insert together

		For general	Accuracy of machining surface priority	Burr reduction priority
Applicable insert	General insert YDEN0905PDFR-D	◎	◎	◎
	Wiper insert YDEN0905PDFR-WD	-	◎	-
	Deburring Wiper Insert YDEN0905PDFR-BD	-	-	◎
Number of Inserts by type		All general	1 or 2 wiper inserts in cutter body	General insert: Deburring wiper insert = 1 : 1
Specification of insert setting				
Accuracy of machining surface (roughness and undulation)		△	◎	○
Burr of machining surface		△	○	◎

Note: ◎: First choice ○: Second choice
△: Not Applicable