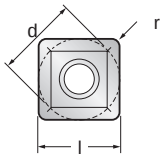
STELLRAM


SDHT09-422


SDHT09-423


SDMT09-41


SDMW09-TN



Shoulder Mills

Product			Application & Material			Dimensions (mm)				
			Roughing ▼	Semi-Finishing ▼▼	Finishing ▼▼▼					
EDP	Item Description	Grade	Depth of Cut (mm)			d (IC)	l	s	r	h_m min
			a_p max* or a_e max.*	a_p max. and a_e max. 15% D**	a_p min. - max.					
031261	SDHT09T308EN-422	X500	♦ ■	● ● ●	-	9,52	9,52	3,97	0,80	0,03
033075	SDHT09T308EN-422	SP6519	♦ ●	♦ ♦ ■	-	9,52	9,52	3,97	0,80	0,03
031260	SDHT09T308EN-423	X500	□ ♦	-	-	9,52	9,52	3,97	0,80	0,04
033074	SDHT09T308EN-423	SP6519	■ ●	■ □ ♦	-	9,52	9,52	3,97	0,80	0,04
014410	SDMT09T308EN-41	X500	●	■ ■ ●	-	9,52	9,52	3,97	0,80	0,04
031479	SDMT09T308EN-41	SP6519	■ ■ ●	■	-	9,52	9,52	3,97	0,80	0,04
017325	SDMT09T308EN-41	MP91M	■	● ● ♦	-	9,52	9,52	3,97	0,80	0,04
015232	SDMW09T308TN	X500	● ●	-	-	9,52	9,52	3,97	0,80	0,15
031482	SDMW09T308TN	SP6519	♦ ♦	-	-	9,52	9,52	3,97	0,80	0,15
017327	SDMW09T308TN	MP91M	♦	-	-	9,52	9,52	3,97	0,80	0,15

Machining Choice: ♦ 1st Choice ■ 2nd Choice ● 3rd Choice | Material Guide Key descriptions found on page A5.



* Note: Please do not surpass the recommended max. a_p for slotting as shown on the steel body page A172.

* Note: a_p max. for profiling is only possible when a_e < 75% of the Diameter.

** Note: For semi finishing, axial engagement $\mathbf{a_p}$ for slotting and radial engagement $\mathbf{a_e}$ for profiling should be max. 15% of the Diameter. SDHT09T308EN-423 to be used in unstable conditions.

Note: Feed recommendations can be found on page A174. Speed recommendations can be found on page A175.