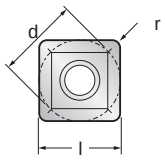
STELLRAM


SDHT12-422


SDHT12-423


SDMT12-41


SDMW12



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.					
030717	SDHT120412EN-422	X500	♦●	●●●	-	12,70	12,70	4,76	1,20	0,05
030728	SDHT120412EN-422	SP6519	♦●	♦♦●	-	12,70	12,70	4,76	1,20	0,05
031218	SDHT120412EN-423	X500	■■	-	-	12,70	12,70	4,76	1,20	0,06
031321	SDHT120412EN-423	SP6519	■●	■■■	-	12,70	12,70	4,76	1,20	0,06
014411	SDMT120412EN-41	X500	●	■■●	-	12,70	12,70	4,76	1,20	0,05
031480	SDMT120412EN-41	SP6519	■■●	♦♦■	-	12,70	12,70	4,76	1,20	0,05
017326	SDMT120412EN-41	MP91M	■	●●♦	-	12,70	12,70	4,76	1,20	0,05
015233	SDMW120412TN	X500	●●	-	-	12,70	12,70	4,76	1,20	0,15
034518	SDMW120412TN	SP6519	♦♦	-	-	12,70	12,70	4,76	1,20	0,15
017328	SDMW120412TN	MP91M	♦	-	-	12,70	12,70	4,76	1,20	0,15

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



Shoulder Mills

* Note: Please do not surpass the recommended max. a_p for slotting as shown on the steel body page A176.

* 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. SDHT120412EN-423 to be used in unstable conditions.

Note: Feed recommendations can be found on page A178. Speed recommendations can be found on page A179.