

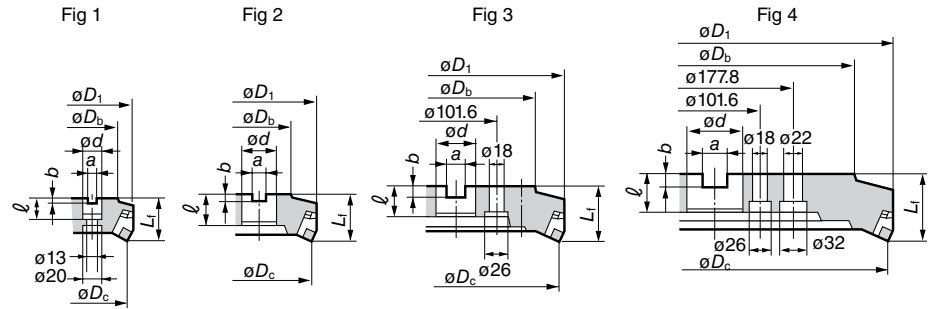
# DNF4000 Type

Rake Angle	Radial	-6°
	Axial	-5°

6.5mm / 65°

<b>P</b>	<b>M</b>	<b>K</b>	<b>N</b>	<b>S</b>	<b>H</b>
Steel	Stainless Steel	Cast Iron	Non-Ferrous Metal	Exotic Alloy	Hardened Steel
○	○	○	○	○	○

## General Milling for Steel & Cast Iron



### Body Imperial

Cat. No. (R)	Stock	Cat. No. (L)	Stock	Dimensions (mm)								No. of Teeth	Weight (kg)	Fig
				$\phi D_c$	$\phi D_1$	$\phi D_b$	$L_f$	$\phi d$	$a$	$b$	$\ell$			
<b>DNF 4080R</b>	●	<b>DNF 4080L</b>		*80	96	60	50	<b>25.4</b>	9.5	6	25	6	1.8	1
<b>4100R</b>	●	<b>4100L</b>	●	<b>100</b>	116	75	60	<b>31.75</b>	12.7	8	32	8	3.0	2
<b>4125R</b>	●	<b>4125L</b>		<b>125</b>	141	75	60	<b>38.1</b>	15.9	10	38	10	4.3	2
<b>4160R</b>	●	<b>4160L</b>		<b>160</b>	176	100	60	<b>50.8</b>	19.1	11	38	12	6.8	2
<b>4200R</b>	●	<b>4200L</b>		<b>200</b>	216	130	60	<b>47.625</b>	25.4	13.5	38	16	9.8	3
<b>DNF 4250R</b>		<b>DNF 4250L</b>		<b>250</b>	266	200	70	<b>47.625</b>	25.4	13.5	40	20	18.1	3
<b>4315R</b>		<b>4315L</b>		<b>315</b>	331	240	70	<b>47.625</b>	25.4	13.5	40	24	27.4	3
<b>4400R</b>		<b>4400L</b>		<b>400</b>	416	300	80	<b>63.5</b>	25.4	13.5	45	32	49.6	4
<b>4500R</b>		<b>4500L</b>		<b>500</b>	516	400	80	<b>63.5</b>	25.4	13.5	45	40	76.3	4

Inserts are not included.



\*Please use hexagonal bolt (JIS B1176) M12x30 to 35 mm for securing  $\phi 80$  cutter to the arbour.

### Inserts

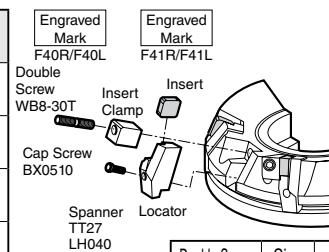
**P** Steel **M** Stainless Steel **K** Cast Iron **N** Non-Ferrous Metal **S** Exotic Alloy **H** Hardened Steel

Application	Grade	Coated Carbide					Carbide				Cermet		Ceramic	SUB90	Fig		
		ACP100	ACP200	ACP300	ACK200	ACK300	EH20Z	A30N	A30	H10E	G10E	T1500A	T1200A	T250A		NB90M	BN250
High Speed/Light	<b>P</b>				<b>K</b>											<b>H</b>	Fig 5
General Purpose		<b>M</b>			<b>K</b>			<b>P</b>	<b>P</b>	<b>K</b>	<b>K</b>						Fig 6
Roughing		<b>M</b>			<b>K</b>												Fig 7
Cat. No.																	Fig 8
<b>CSNH 43M</b>																	Fig 9
<b>43MT</b>																	
<b>CSN 43M</b>																	
<b>43MT</b>																	
<b>CSNB 43M</b>																	
<b>43MT</b>																	
<b>SNC 433</b>																	
<b>434</b>																	
<b>SNMN 432</b>																	
<b>433</b>																	
<b>434</b>																	
<b>SNMN 432TN-S</b>																	
<b>433TN-S</b>																	
<b>434TN-S</b>																	
<b>NW 100</b>																	

### Spare Parts

(\*1: To use wiper inserts, please change locators to LNF40R (L). Spanner and cap screw remain unchanged.)

Applicable Cutters	Locator (*1)	Insert Clamp
DNF4080R DNF4100R	LNF40R	FTW40R
DNF4125R to DNF4500R	LNF40R	FTW41R
DNF4080L to DNF4100L	LNF40L	FTW40L
DNF4125L to DNF4500L	LNF40L	FTW41L



Double Screw	Size	(N·m)
WB8-30T	M8	8.0

(N·m) Recommended Tightening Torque (N·m)

### Recommended Cutting Conditions

ISO	Work Material	Hardness	Cutting Speed $v_c$ (m/min) Min. - Optimum - Max.	Feed Rate $f_z$ (mm/t) Min. - Optimum - Max.	Grade
<b>P</b>	General Steel	180 to 280HB	80-100-120	0.10-0.13-0.15	T250A
	Soft Steel	$\leq 180$	100-130-160	0.10-0.18-0.25	T250A
<b>K</b>	Cast Iron	250HB	150-200-250	0.10-0.15-0.20	ACK200

Note The cutting conditions above are a guide. Actual conditions will need to be adjusted according to machine rigidity, work clamp rigidity, cutting depth, and other factors.