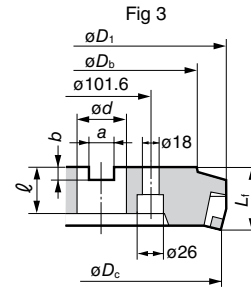
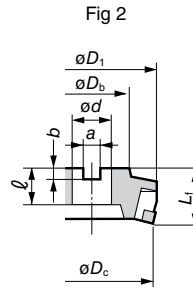
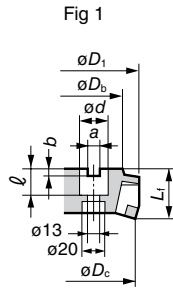


# DPG4000/DPGF4000 Type

Rake Angle	Radial	0°
	Axial	+8°



## General Milling for Steel, Stainless 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>DPG 4080R</b>	●	<b>DPG 4080L</b>		*80	90	60	50	<b>25.4</b>	9.5	6	25	4	1.5	1
<b>4100R</b>	●	<b>4100L</b>		<b>105</b>	115	75	60	<b>31.75</b>	12.7	8	32	5	3.0	2
<b>4125R</b>	●	<b>4125L</b>		<b>125</b>	135	75	60	<b>38.1</b>	15.9	10	38	6	4.0	2
<b>4160R</b>	●	<b>4160L</b>		<b>157</b>	167	100	60	<b>50.8</b>	19.1	11	38	8	6.1	2
<b>4200R</b>	●	<b>4200L</b>		<b>200</b>	210	130	60	<b>47.625</b>	25.4	13.5	38	10	10.0	3
<b>DPGF 4080R</b>	●	<b>DPGF 4080L</b>		*80	90	60	50	<b>25.4</b>	9.5	6	25	6	1.5	1
<b>4100R</b>	●	<b>4100L</b>		<b>105</b>	115	75	60	<b>31.75</b>	12.7	8	32	8	3.0	2
<b>4125R</b>	●	<b>4125L</b>		<b>125</b>	135	75	60	<b>38.1</b>	15.9	10	38	10	4.0	2
<b>4160R</b>	●	<b>4160L</b>		<b>157</b>	167	100	60	<b>50.8</b>	19.1	11	38	12	6.1	2

Inserts are not included.



\*Please use JIS B1176 hexagonal bolt ( $\phi 80$ : M12x30 to 35mm) 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			Fig		
		High Speed/Light	General Purpose	Roughing											
		P	M, K	K	M		P, K	K, K	P, P	P					
	Cat. No.	ACP100	ACP200	ACP300	ACK200	ACK300	EH20Z	A30N	A30	H10E	G10E	T1500A	T1200A	T250A	
Face Milling	SPCH 42R				●	●	●				●				5(6)
	42L				●	●	▲				●				6
Radius	42TR	●	●	●				●		●					5(6)
Multi-Purpose	42TL		●												6
Shoulder Milling	42TR-R											●	▲	●	6
	42TL-R													●	6
R/Copying	SPMN 422								●		●	●	▲	●	7
	423				●	●			●		●	●	▲		7
Groove/T-Slot	SPG 422								●		●	●	▲		—
	423										●		▲		—
Chamfering	DPW 500R									●		●	▲		8
Aluminium/Light Alloys	500L									●		●	▲		8

Fig 5 (ACP/ACK Series Grades)

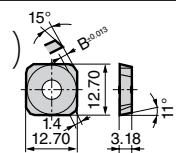


Fig 6

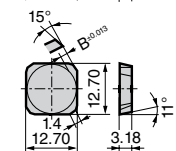


Fig 7

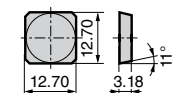
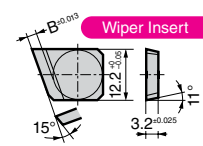
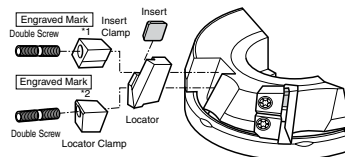


Fig 8



Double Screw (Common)	Size	<b>M8</b>
	Torque	<b>8.0</b>

Recommended Tightening Torque (N·m)



<sup>1</sup> Engraved Mark  
T40R, T40L, T41R, T41L, T42R, T42L, TF80R, TF80L, TF41R, TF41L

<sup>2</sup> Engraved Mark  
L40R, L40L, L41R, L41L, L42R, L42L, LF80R, LF80L, LF41R, LF41L

### Spare Parts

Applicable Cutters	Locator	Locator Clamp For DPG	Locator Clamp For DPGF	Insert Clamp For DPG	Locator Clamp For DPGF	Double Screw	Spanner
DPG(F)4080R	GL40R	GLW40R	GLWF80R	GTW40R	GTWF80R	WB8-22T	TT27
DPG(F)4100R to DPG(F)4160R		GLW41R	GLWF41R	GTW41R	GTWF41R	WB8-30T	
DPG4200R		GLW42R	—	GTW42R	—	WB8-30T	
DPG(F)4080L		GLW40L	GLWF80L	GTW40L	GTWF80L	WB8-22T	
DPG(F)4100L to DPG(F)4160L	GL40L	GLW41L	GLWF41L	GTW41L	GTWF41L	WB8-30T	TT27
DPG4200L		GLW42L	—	GTW42L	—	WB8-30T	

### 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	100-125-150	0.10-0.15-0.20	ACP200
	Soft Steel	≤180HB	100-175-250	0.10-0.18-0.25	ACP200
	Die Steel	200 to 220HB	80-120-160	0.10-0.15-0.20	ACP200
<b>M</b>	Stainless Steel	—	80-120-160	0.10-0.15-0.20	ACP300
<b>K</b>	Cast Iron	250HB	80-140-200	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.