

NEW!

**UNLIMITED
SPEED!!!**

*The power of **SCMAX** and the
productivity of High-Feed*

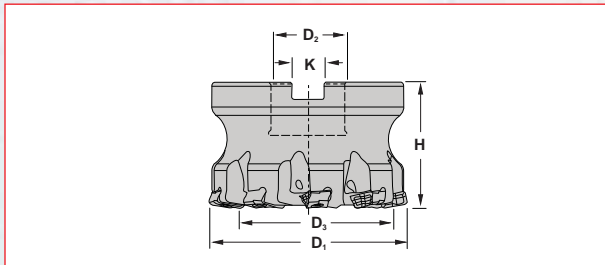


Features & Benefits:

- "On-Edge" design combines robust edge strength and high feed geometry.
- 80° lead angle provides extreme (5X) chip thinning for smooth, stable cut.
- Ramping capability with an aggressive depth of cut of up to .120".
- Economy of 4 indexes in two insert sizes.
- Medium density cutters for steel applications.
- High density cutters with coolant/air through the tool for Titanium/Hi Temp alloys.
- Diameters from Ø2.00" to Ø8.00"

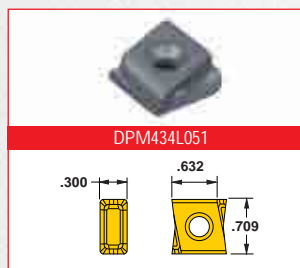
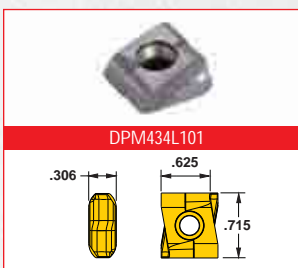
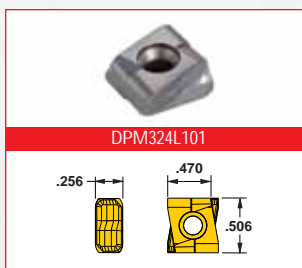
■ **MAX** HIGH FEED MILLS SERIES SP6H, SP6N

Diameters
2.000" - 8.000"



D ₁ Nominal Diameter	Cutter Number	Effective Inserts	D ₂ Bore Size	D ₃ Effective Diameter	Max DOC	EQ UNEQ	Bolt Circle	K Keyway	H Height	Retention Bolt	Coolant Thru
2.000	SP6H-02R02	4	0.750	1.151	0.08	U	-	0.32	1.750	SD-06-46	Yes
3.000	SP6H-03R02	7	1.000	2.139	0.08	E	-	0.38	1.750	SD-08-48	Yes
4.000	SP6H-04R02	9	1.500	3.178	0.08	U	-	0.63	2.500	SD-12-82	Yes
4.000	SP6N-04R01	6	1.500	2.929	0.12	U	-	0.63	2.500	SD-12-82	No
4.000	SP6N-04R02	7	1.500	2.929	0.12	E	-	0.63	2.500	SD-12-82	Yes
6.000	SP6N-06R01	8	1.500	4.922	0.12	U	-	0.63	2.500	SD-12-82	No
6.000	SP6N-06R02	9	1.500	4.922	0.12	E	-	0.63	2.500	SD-12-82	Yes
8.000	SP6N-08R01	10	2.500	6.922	0.12	E	4.00	1.00	2.500	SD-10-70	No
8.000	SP6N-08R02	10	2.500	6.922	0.12	E	4.00	1.00	2.500	SD-10-70	Yes

INSERTS



Cutter Series	Insert Number	Application	Corner	Grades		
				IN	2005	1530
SP6H	DPM324L101	Multi-Purpose/Ramping	4 x .125"	■	■	
SP6H	DPM324L051	Multi-Purpose	4 x .062"	■	■	
SP6N	DPM434L101	Multi-Purpose/Ramping	4 x .200"	■	■	
SP6N	DPM434L051	Multi-Purpose	4 x .062"	■	■	

HARDWARE

Cutter Series	Insert Screw		Wrench Part No.
	Part No.	Torque	
SP6H	SM40-120-20	30-35 in lbs	DS-T15T
SP6N	SM50-160-10	35-40 in lbs	DS-T20B

TECHNICAL INFORMATION

Series SP6H/SP6N		Brinell Hardness	SFM	Feed per Insert	DOC		Grades		Coolant
Material					DPM324L	DPM434L	IN2005	IN1330	
Steel	Low Carbon 1018, 8620	100-250	500-800	.035-.100	.040-.080	.060-.120	1	2	No
	High Carbon F-6180	250-400	400-700						
	Alloyed Steel 4140, 4340	150-300	300-600						
	Tool Steel A-6, D-1, D-2	Up to 300							
Stainless Steel	300 Series, 304, 316	-	300-600	.030-.080	.030-.080	.050-.100	1	2	May not be required at high speeds.
	400 Series 15-5 PH	Up to 320	300-500						
	13-8 PH	-	200-400						
Titanium	6AL-4V	-	100-200	.030-.060	.030-.070	.040-.100	2	1	Yes

ADDITIONAL PROGRAMMING INFORMATION

Feeds & Speeds Note:

Feed and speed recommendations are starting operating parameters. They are only guidelines from which further optimization should take place. Operating guidelines are influenced by many machining variables. These variables may call for reductions in feeds and speeds or dramatic increases. Additionally, DOC and WOC may need to be revised to optimize the tools performance.

Programming Note:

Program all SP6H series S-Max High Feed cutters as though they are bullnose cutters with a .118"/3.0mm corner radius. Program all SP6N series S-Max High Feed cutters as though they are bullnose cutters with a .158"/4.0mm corner radius. This method will both ensure and minimize remaining stock for secondary passes.

