

sumiMill Series Indexable Shell Mills

Double Negative Face Mill



DNF Milling Cutter

Features and Benefits

- Double negative rake angles provide high cutting edge strength
- Up to eight indexes per cutter load
- NS260 ceramic inserts are an economical option for the high speed milling of gray cast iron

DNF Face Mill Series

Lead Angle: 25° Axial Rake Angle: -5° Radial Rake Angle: -6°	Fig. 1 Fig. 2 Fig. 3			Fig. 4								
Catalog Number	Dimensions								No. of Teeth	Max. D.O.C.	Weight (kg)	Fig.
	D	D ₁	D ₂	F	d	a	b	E				
DNF 4080R	3.150	3.780	2.362	1.969	1.000	0.375	0.236	0.985	6	.250	1.8	1
DNF 4100R	3.937	4.567	2.953	2.362	1.250	0.500	0.315	1.260	8		3.0	2
DNF 4125R*	4.921	5.551	2.953	2.362	1.500	0.625	0.394	1.496	10		4.3	3
DNF 4160R**	6.300	6.930	3.937	2.362	2.000	0.750	0.433	1.496	12		6.8	4

*Requires BFX3/4x16 arbor screw

**Requires BFX1x14 arbor screw

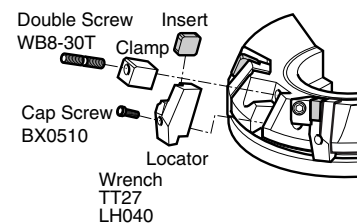
Inserts

	Figure 1		Figure 2		Figure 3				
	Coated	Cermet	Uncoated	Ceramic	Dimensions (Inches)				
Sumitomo Cat. No.	ACZ310 AC325	T250A	H10E	NS30 NS260	I.C.	T	R	Facet Width	Figure
CSNH43M	•				0.500	0.189	-	0.500	1
SNG432	•						0.0312		
SNG433					0.500	0.1875		0.0469	2
SNG434								0.0625	
SNG438								0.1250	
SNMN432								0.0312	
SNMN433	•	•			0.500	0.1875		0.0469	2
SNMN434								0.0625	
NW100			•		-	0.197	-	-	3

**See pages 92-93
For recommended
running parameters**

Hardware

Catalog Number	Locator	Insert Clamp	Locator Clamp	Insert Screw*	Wrench
DNF □□□□ R	LNF40R	FTW40R	BX0510	WB830T	TT27 LH040



Torque specifications for locator clamp (WB830T)= 71-75 in/lbs.
Torque specifications for insert clamp (WB830T)= 57-62 in/lbs.

MILLING