

# PRODUCT NEWS

No. 335



## Rhombic Diemaster

### MXD/XDF



NEW PRODUCT

## "G-Body"

- Modular Heads type:  $\phi 16 \sim \phi 42 \dots 5$  items.
- Face mill type:  $\phi 52 \sim \phi 66 \dots 2$  items.

### From semi-finishing to finishing on all mold shapes.

Through coolant holes in the bodies for  
safe operations and longer tool life.

**G-Body**



MXD Heads type

**G-Body**  
carbide shank

**G-Body**



XDF Face mill type



DIJET INDUSTRIAL CO., LTD.

## Feature of product

# High efficient and multi purpose machining t

## Multi purpose tool

Different grade of insert for machining different kind of materials. This tool can make all kind of operations, from semi-finishing to finishing, in any kind of mold. The through coolant holes in the all bodies give longer tool life and safe operations in cavities .

## Double clamp system

Adopted double clamp system for deep cut applications.

## Adopted positive axial rake

- 02 & 03 inserts type → A.R.; +6°  
on Modular Heads type.
- 03 inserts type → A.R.; +8°  
on Face mill type.

## Variation

Many kinds of modular heads are available with combination of carbide shanks.

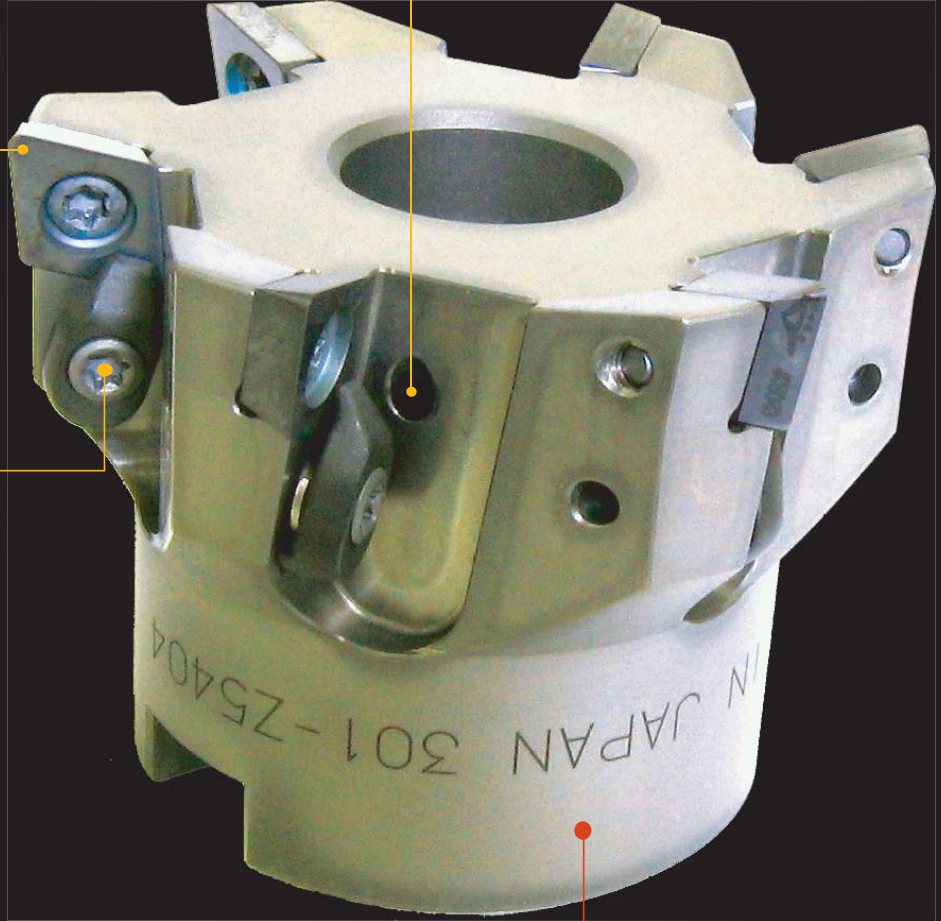


## G-Body

Adopted GN surface-hardening treatment on thermal resistant high strength steel gives high hardness over 65HRC and secure insert pocket and holder against thermal deformation, improved body durability and insert life by 30% or more. Make it difficult to be damaged even under severe cutting conditions. Also rust-proof and anti-welding effect is much improved.

# ool for Die and mold.

All tool has coolant holes from each pockets



**G-Body**

## ● MXD heads type

● Through coolant hole



Fig.1

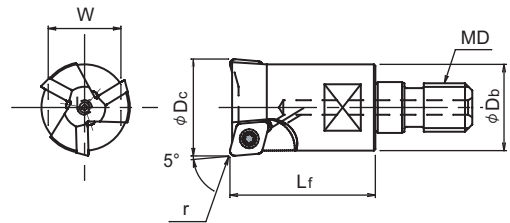
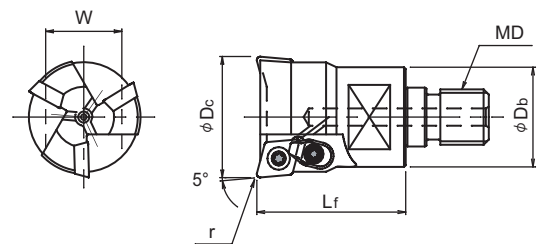


Fig.2



## ● Body

| Cat. No.     | Stock | No. of inserts | Dimensions (mm) |         |    |      |     |    | Inserts         | Parts       |           |        | Fig. |
|--------------|-------|----------------|-----------------|---------|----|------|-----|----|-----------------|-------------|-----------|--------|------|
|              |       |                | φDc             | r       | Lf | φDb  | MD  | W  |                 | Clamp screw | Clamp set | Wrench |      |
| MXD-2016-M8  | ●     | 2              | 16              | 0.5,1.0 | 23 | 15.4 | M8  | 12 | XDHW-0206-05,10 | CSW-2547    | —         | A-07   | 1    |
| MXD-3020-M10 | ●     | 3              | 20              | 0.5,1.0 | 30 | 17.8 | M10 | 14 | XDHW-0206-05,10 | CSW-2547    | —         | A-07   | 1    |
| MXD-3025-M12 | ●     | 3              | 25              | 0.5,1.0 | 35 | 20.8 | M12 | 17 | XDHW-0206-05,10 | CSW-2547    | —         | A-07   | 1    |
| MXD-3035-M16 | ●     | 3              | 35              | 1.0     | 43 | 28.8 | M16 | 22 | XDHW-0310-10    | CSW-3575    | DCM-18    | A-15   | 2    |
| MXD-4042-M16 | ●     | 4              | 42              | 1.0     | 43 | 28.8 | M16 | 22 | XDHW-0310-10    | CSW-3575    | DCM-18    | A-15   | 2    |

● Standard stock items

Note) 1. All cutters are supplied without inserts.

2. Please see page 7-8 for cutting conditions.

## ● Recommended tightening torque for modular head

| Thread | Tightening Torque | Wrench size |
|--------|-------------------|-------------|
| M8     | 23 N·m            | 10, 12      |
| M10    | 46 N·m            | 14, 15      |
| M12    | 80 N·m            | 17          |
| M16    | 90 N·m            | 22, 26      |

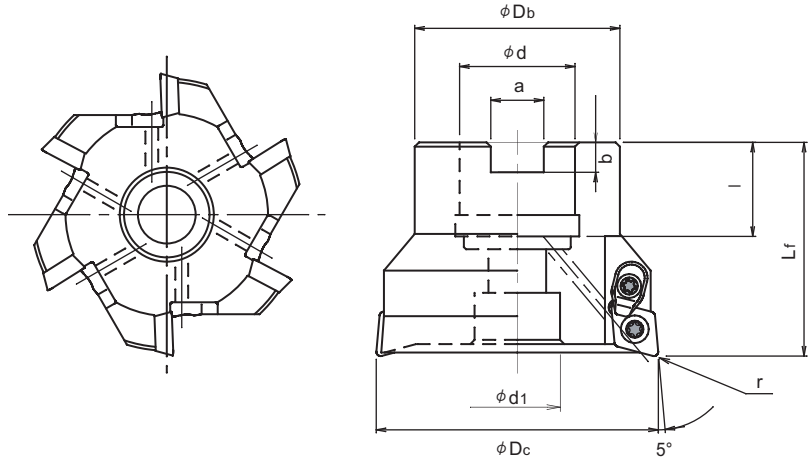
### ★ Attention to mounting head

Clean the contact surface of head and carbide holder, and also confirm there is no gap between head and holder after tightening. Please check even run-out.



## ● XDF Face mill type

● Through coolant hole



## ● Body

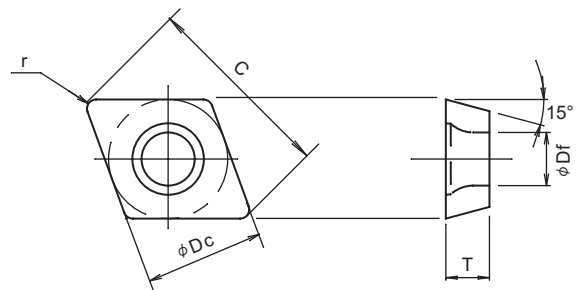
| Cat. No.     | Stock | No. of inserts | Dimensions (mm) |     |       |            |          |            |      |     |     | Inserts | Parts       |           |        |
|--------------|-------|----------------|-----------------|-----|-------|------------|----------|------------|------|-----|-----|---------|-------------|-----------|--------|
|              |       |                | $\phi D_c$      | $r$ | $L_f$ | $\phi D_b$ | $\phi d$ | $\phi d_1$ | $a$  | $b$ | $l$ |         | Clamp screw | Clamp set | Wrench |
| XDF-5052R-22 | ●     | 5              | 52              | 1.0 | 50    | 40         | 22       | 17         | 10.4 | 6   | 20  |         |             |           |        |
| XDF-6066R-27 | ●     | 6              | 66              | 1.0 | 50    | 48         | 27       | 20         | 12.4 | 7   | 22  |         |             |           |        |
|              |       |                |                 |     |       |            |          |            |      |     |     |         |             |           |        |

● Standard stock items

Note) 1. All cutters are supplied without inserts.

2. Please see page 9 for cutting conditions.

## ● Inserts



| Cat. No.     | Coated |        |        |        | Dimensions (mm) |      |        |     |            |
|--------------|--------|--------|--------|--------|-----------------|------|--------|-----|------------|
|              | JC8003 | JC8015 | JC5015 | JC5040 | $\phi D_c$      | T    | C      | $r$ | $\phi D_f$ |
| XDHW 0206-05 | ●      | ●      |        | ⊙      | 6.5             | 2.38 | 10.589 | 0.5 | 2.9        |
| XDHW 0206-10 | ●      | ●      |        | ●      | 6.5             | 2.38 | 9.846  | 1.0 | 2.9        |
| XDHW 0310-10 | ●      | ●      | ⊙      | ●      | 10              | 3.97 | 15.948 | 1.0 | 4          |

● Standard stock items ⊙ On request.

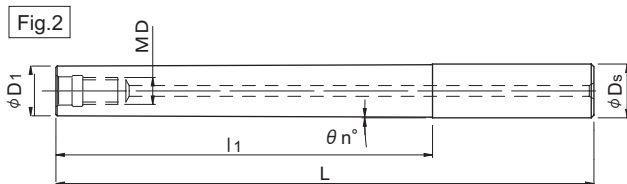
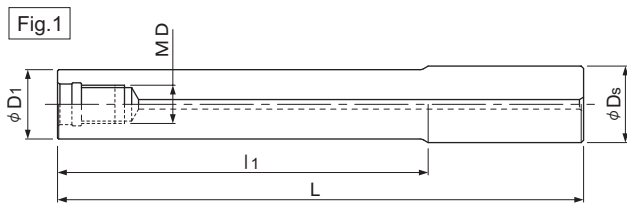
## MSN Carbide shank holder (Through coolant hole)

# 頑固一徹

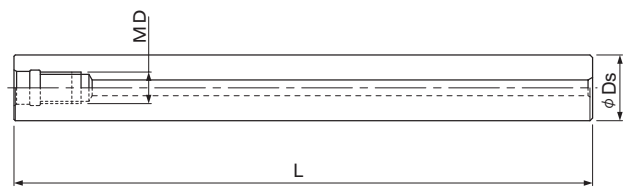
- For high productivity
- Through coolant hole



### ■ End mill shank type



### ■ Straight arbor type



## Body

| Cat. No.                     | Stock | Dimensions (mm) |     |     |      |     | Fig. |      |       |   |
|------------------------------|-------|-----------------|-----|-----|------|-----|------|------|-------|---|
|                              |       | φDs             | l1  | L   | φD1  | MD  |      |      |       |   |
| <b>NEW</b> MSN-M8-20-S16C    | ●     | 16              | 20  | 75  | 15.5 | M8  | 1    |      |       |   |
| MSN-M8-40-S16C               | ●     |                 | 40  | 95  |      |     |      |      |       |   |
| MSN-M8-80-S16C               | ●     |                 | 80  | 135 |      |     |      |      |       |   |
| MSN-M8-120-S16C              | ●     |                 | 120 | 175 |      |     |      |      |       |   |
| MSN-M10-20-S20C※2            | ●     | 20              | 20  | 80  | 19.5 | —   | 1    |      |       |   |
| MSN-M10-40-S20C※2            | ●     |                 | 40  | 100 |      |     |      |      |       |   |
| <b>NEW</b> MSN-M10-40T-S20C  | ●     |                 | 40  | 100 |      |     |      | 18.5 | 0°43' | 2 |
| MSN-M10-90-S20C※2            | ●     |                 | 90  | 150 |      |     |      | 19.5 | M10   | — |
| <b>NEW</b> MSN-M10-90T-S20C  | ●     | 25              | 90  | 150 | 18.5 | —   | 2    |      |       |   |
| MSN-M10-140-S20C※2           | ●     |                 | 140 | 200 |      |     |      | 19.5 | —     | 1 |
| <b>NEW</b> MSN-M10-140T-S20C | ●     |                 | 140 | 200 |      |     |      | 18.5 | 0°12' | 2 |
| MSN-M12-25-S25C              | ●     |                 | 25  | 90  |      |     |      | 24   | M12   | — |
| MSN-M12-55-S25C              | ●     | 55              | 120 |     |      |     |      |      |       |   |
| MSN-M12-105-S25C             | ●     | 105             | 170 |     |      |     |      |      |       |   |
| MSN-M12-155-S25C             | ●     | 155             | 220 |     |      |     |      |      |       |   |
| MSN-M16-25-S32C              | ●     | 32              | 25  | 90  | 29   | M16 | —    | 1    |       |   |
| MSN-M16-55-S32C              | ●     |                 | 55  | 120 |      |     |      |      |       |   |
| MSN-M16-105-S32C             | ●     |                 | 105 | 170 |      |     |      |      |       |   |
| MSN-M16-155-S32C             | ●     |                 | 155 | 220 |      |     |      |      |       |   |
| MSN-M16-195-S32C             | ●     | 195             | 260 |     |      |     |      |      |       |   |

● : Standard stock items

| Cat. No.          | Stock | Dimensions (mm) |     |     |
|-------------------|-------|-----------------|-----|-----|
|                   |       | φDs             | L   | MD  |
| MSN-M8-97S-S15C   | ●     | 15              | 97  | M8  |
| MSN-M8-147S-S15C  | ●     |                 | 147 |     |
| MSN-M8-107S-S16C  | ●     | 16              | 107 | M8  |
| MSN-M8-157S-S16C  | ●     |                 | 157 |     |
| MSN-M10-130S-S18C | ●     | 18              | 130 | M10 |
| MSN-M10-190S-S18C | ●     |                 | 190 |     |
| MSN-M10-130S-S20C | ●     | 20              | 130 | M10 |
| MSN-M10-190S-S20C | ●     |                 | 190 |     |
| MSN-M10-250S-S20C | ●     | 250             |     |     |
| MSN-M12-185S-S23C | ●     | 23              | 185 | M12 |
| MSN-M12-265S-S23C | ●     |                 | 265 |     |
| MSN-M12-145S-S25C | ●     | 25              | 145 | M12 |
| MSN-M12-215S-S25C | ●     |                 | 215 |     |
| MSN-M12-285S-S25C | ●     | 285             |     |     |
| MSN-M16-160S-S28C | ●     | 28              | 160 | M16 |
| MSN-M16-230S-S28C | ●     |                 | 230 |     |
| MSN-M16-310S-S28C | ●     | 310             |     |     |
| MSN-M16-157S-S32C | ●     | 32              | 157 | M16 |
| MSN-M16-217S-S32C | ●     |                 | 217 |     |
| MSN-M16-287S-S32C | ●     | 287             |     |     |
| MSN-M16-357S-S32C | ●     | 357             |     |     |

● : Standard stock items