

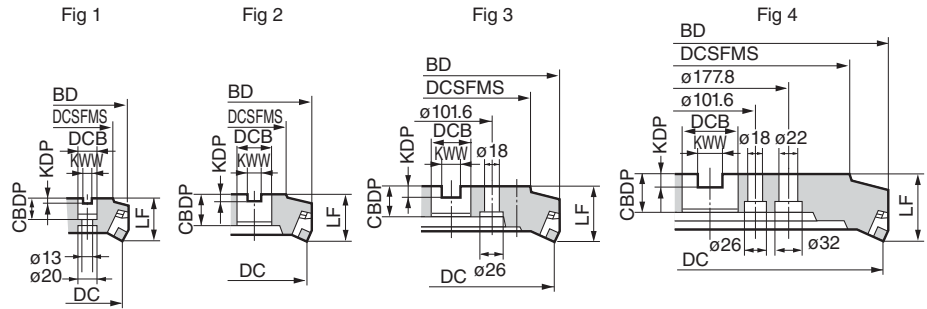
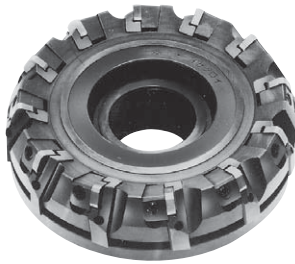
DNF 4000 Type

Rake Angle	Radial	-6°
	Axial	-5°



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

General Milling for Steel & Cast Iron



Body

Inch

Dimensions (mm)

Cat. No. (R)	Stock	Cat. No. (L)	Stock	Diameter	External Diameter	Boss	Height	Hole Size	Grooving Width	Grooving Depth	Mounting Depth	No. of Teeth	Weight (kg)	Fig
				DC	BD	DCSFMS	LF	DCB	KWW	KDP	CBDP			
DNF 4080R	●	DNF 4080L		*80	96	60	50	25.4	9.5	6	25	6	1.8	1
4100R	●	4100L	●	100	116	75	60	31.75	12.7	8	32	8	3.0	2
4125R	●	4125L		125	141	75	60	38.1	15.9	10	38	10	4.3	2
4160R	●	4160L		160	176	100	60	50.8	19.1	11	38	12	6.8	2
4200R	●	4200L		200	216	130	60	47.625	25.4	13.5	38	16	9.8	3
DNF 4250R		DNF 4250L		250	266	200	70	47.625	25.4	13.5	40	20	18.1	3
4315R		4315L		315	331	240	70	47.625	25.4	13.5	40	24	27.4	3
4400R		4400L		400	416	300	80	63.5	25.4	13.5	45	32	49.6	4
4500R		4500L		500	516	400	80	63.5	25.4	13.5	45	40	76.3	4

Inserts are not included.

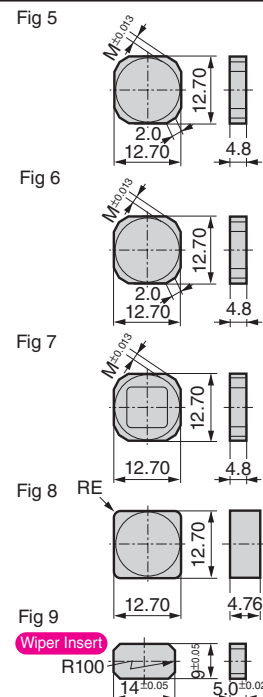


*Please use JIS B1176 hexagonal bolt (M12x30 to 35mm) for securing ø80 cutter to the arbor.

Insert

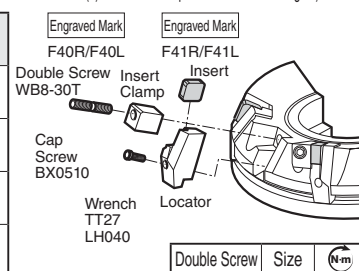
P Steel **M** Stainless Steel **K** Cast Iron **N** Non-Ferrous Metal **S** Exotic Alloy **H** Hardened Steel

Application	Grade	Coated Carbide						Carbide				Cermets		CBN			
		High Speed/Light	General Purpose	Roughing	ACP100	ACP200	ACP300	ACK200	ACK300	EH20Z	A30N	A30	H10E	G10E	T1500A	T250A	BN250
Cat. No.																	Fig
CSNH 43M							●										5
43MT							●										5
CSN 43M																	6
43MT																	6
CSNB 43M																	7
43MT																	7
SNC 433																	
434																	
SNMN 432																	8
433																	8
434																	8
SNMN 432TN-S																	
433TN-S																	
434TN-S																	
NW 100																	9



Parts (*1: To use wiper inserts, please change locators to LNF40R (L). Wrench 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



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
P	General Steel	180 to 280HB	80-100-120	0.10-0.13-0.15	T250A
	Soft Steel	≤180	100-130-160	0.10-0.18-0.25	T250A
K	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.

Double Screw	Size	Torque
WB8-30T	M8	8.0

Recommended Tightening Torque (N·m)