



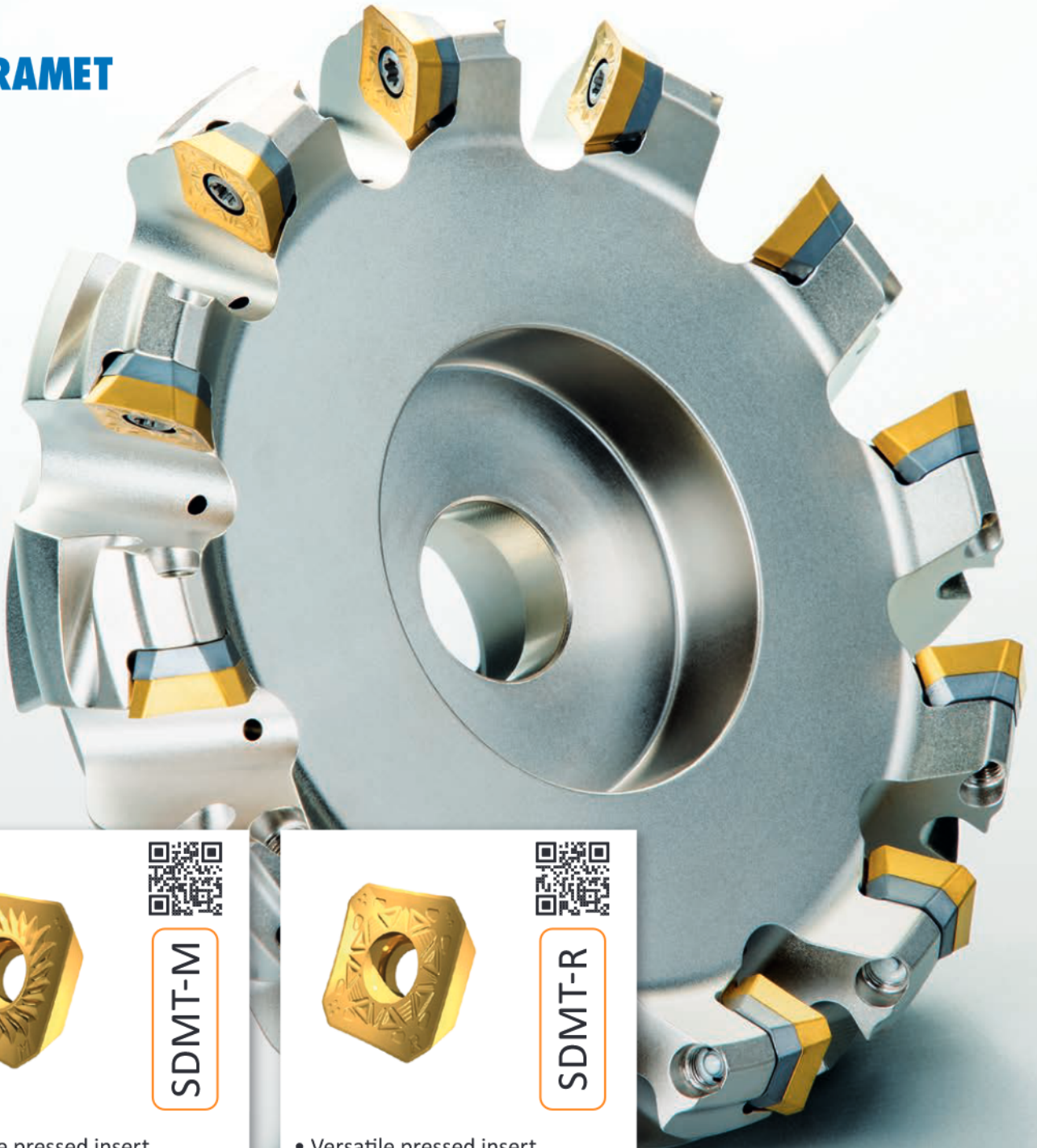
SSD13F

VERSATILE FACE MILLING

INTRODUCTION



A new face milling assortment for general engineering and maintenance, repair and operations has been launched. The latest Pramet range includes two economical and precise inserts (SDMT and SDET) for depths of cut up to 6.4 mm. Several geometries and cutters are available for machining a wide range of materials.



SDMT-M

- Versatile pressed insert
- Steels, cast irons and hard steels
- Medium cuts



SDMT-R

- Versatile pressed insert
- Steels, cast irons and hard steels
- Rough cuts

MILLING CUTTERS AND INSERTS

INSERTS FEATURES & BENEFITS

Application-specific geometries and grades.

EASY TO SELECT AND USE
for a wide range of workpiece materials.

Geometries M and R on economical pressed insert (SDMT 13).

LIGHT, MEDIUM AND ROUGH CUTS
in steels, cast irons and hard steels.

Sharp geometry F on precision ground insert (SDET 13).

SECURE AND SAFE
machining in stainless steels and heat resistant super alloys (HRSA).

Polished and extra sharp geometry FA on specific ground insert (SDET 13).

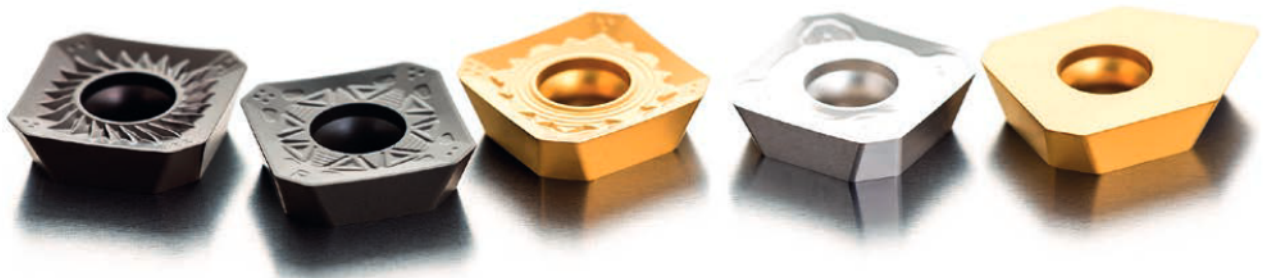
PRODUCTIVE MILLING
in non-ferrous materials.

Wide wiper edge design on all geometries.

HIGH SURFACE QUALITY
across multiple applications, from heavy roughing to finishing.

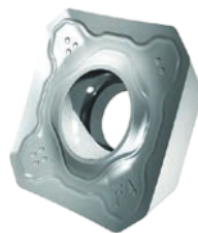
Additional wiper insert XDET 13 available.

PRODUCTIVE AND HIGH SURFACE QUALITY
in larger diameter cutters.



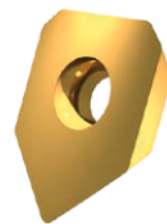
SDET-F

- Precision ground insert
- Stainless steels & HRSA
- Light to medium cuts



SDET-FA

- Precision ground insert
- Non-ferrous materials
- Light to rough cuts



XDET

- Wiper insert
- Steels, cast irons, stainless steels
- High quality surface finish

SSD13F

VERSATILE FACE MILLING

CUTTERS SSD13F – FEATURES & BENEFITS

Weldon and shell-style cutters in diameters 32 – 250 mm (1.25 – 10.00 inch).

▶ **MULTIPLE CHOICES**
for a wide range of machine sizes.

Carbide shim on cutter seating place.

▶ **EXTRA PROTECTION FOR HIGH DURABILITY**
of cutter body, while providing insert stability and process security.

Internal coolant on entire assortment, including large-sized diameters.

▶ **IMPROVED TOOL LIFE**
and better chip evacuation, providing high surface quality and reliability.

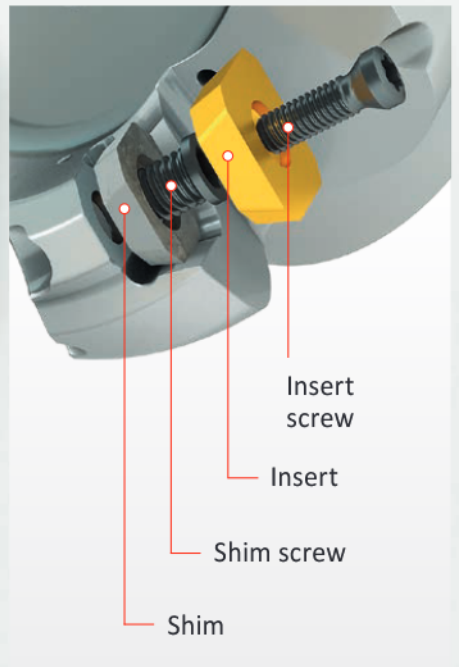


SSD13F

- Weldon shank
- DC range
32 – 40 mm
1.25 – 1.50 inch

SSD13F

- Shell body
- DC range
40 – 250 mm
1.50 – 10.00 inch





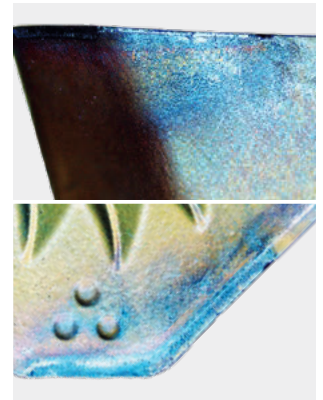
MILLING CUTTERS AND INSERTS

FACE MILLING EXAMPLES

Workpiece: Carbon steel plate (215 HB)
 Material: 1.1191 / C45
 Cutter: 63A05R-S45SD13F-C
 Coolant: Compressed air

| Cutting conditions | | | |
|-----------------------|------------|------------|-----------------|
| v_c (m/min) | f_z (mm) | a_p (mm) | a_e (mm) |
| 250 | 0.25 | 2 | 50 |
| Insert geometry | | | Tool life (min) |
| SDMT 13T3AFSN-M:M8330 | | | 97 |

SDMT 13T3AFSN-M:M8330, 97 min

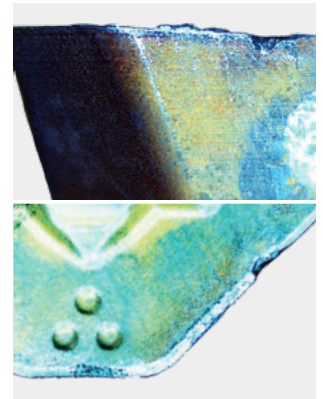


WMG P2.2

Workpiece: Stainless steel plate (145 HB)
 Material: 1.4404 / 316L
 Cutter: 63A05R-S45SD13F-C
 Coolant: Compressed air

| Cutting conditions | | | |
|-----------------------|------------|------------|-----------------|
| v_c (m/min) | f_z (mm) | a_p (mm) | a_e (mm) |
| 120 | 0.15 | 2 | 50 |
| Insert geometry | | | Tool life (min) |
| SDET 13T3AFSN-F:M6330 | | | 42 |

SDET 13T3AFSN-F:M6330, 42 min

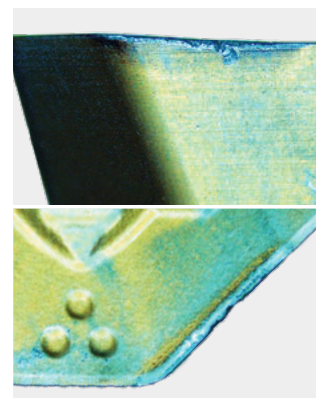


WMG M3.1

Workpiece: Stainless steel plate (145 HB)
 Material: 1.4404 / 316L
 Cutter: 63A05R-S45SD13F-C
 Coolant: Soluble oil emulsion (~ 10%)

| Cutting conditions | | | |
|-----------------------|------------|------------|-----------------|
| v_c (m/min) | f_z (mm) | a_p (mm) | a_e (mm) |
| 80 | 0.15 | 2 | 50 |
| Insert geometry | | | Tool life (min) |
| SDET 13T3AFSN-F:M6330 | | | 100 |

SDET 13T3AFSN-F:M6330, 100 min

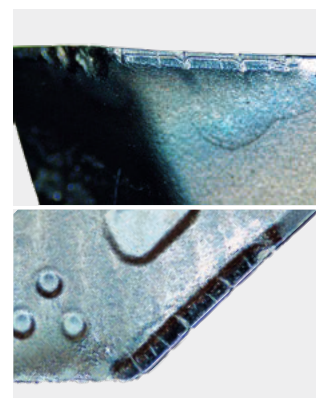


WMG M3.1

Workpiece: Cast iron plate (205 HB)
 Material: GG25 / FC250
 Cutter: 63A05R-S45SD13F-C
 Coolant: Compressed air

| Cutting conditions | | | |
|-----------------------|------------|------------|-----------------|
| v_c (m/min) | f_z (mm) | a_p (mm) | a_e (mm) |
| 300 | 0.4 | 2 | 50 |
| Insert geometry | | | Tool life (min) |
| SDMT 13T3AFSN-R:M5315 | | | 42 |

SDMT 13T3AFSN-R:M5315, 42 min



WMG K1.2