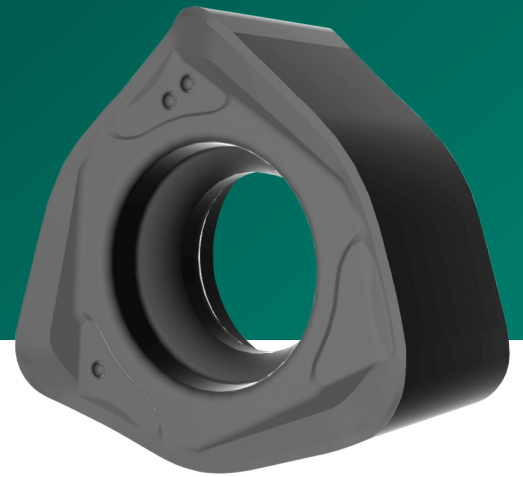


DAPRA

VAPOR™

INDEXABLE HIGH-FEED MILLING



New grades deliver breakthrough performance across all materials.

WHY VAPOR WINS



Increased Tool Life

› 2X over previous grades



Advanced Grades

› Leverage the most advanced substrate and coating combinations



Refined Geometries

› Allow for a 25% increase in machining parameters



Improved Cost per Edge

› 6 edges per double-sided insert to reduce cost per part

COMPETITIVE ANALYSIS

Material **330 Stainless Steel**
(Austenitic Ni Cr)

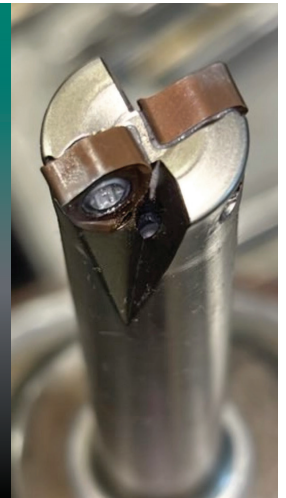
**TIME
IN THE
CUT**

**120
MINUTES**

**50
MINUTES**

COMPETITOR

**DAPRA
DTM-D-DMF530**



140% increase in tool life while improving DOC from 0.010" to 0.020"

WHAT'S NEW

THE GRADES

DMP920 P10-P35 K10-K30

For general machining of cast iron and steel

› Tough substrate with high cracking resistance

DMP930 P20-P40 K20-K40

For the toughest steel milling applications

› Excellent combination of toughness and wear resistance

DMH930 M20-M40 S20-S30

For general machining of stainless and titanium

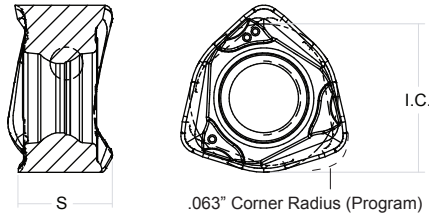
› Tough fine-grain substrate and ultra-smooth coating resists cracking and built-up edge

DMF530 M25-M40 S25-S35




For difficult stainless steels and titanium alloys





› Optimized coating for both high hardness and unmatched heat resistance

DAPRA VAPOR™ 6MM SERIES



6MM SERIES INSERTS

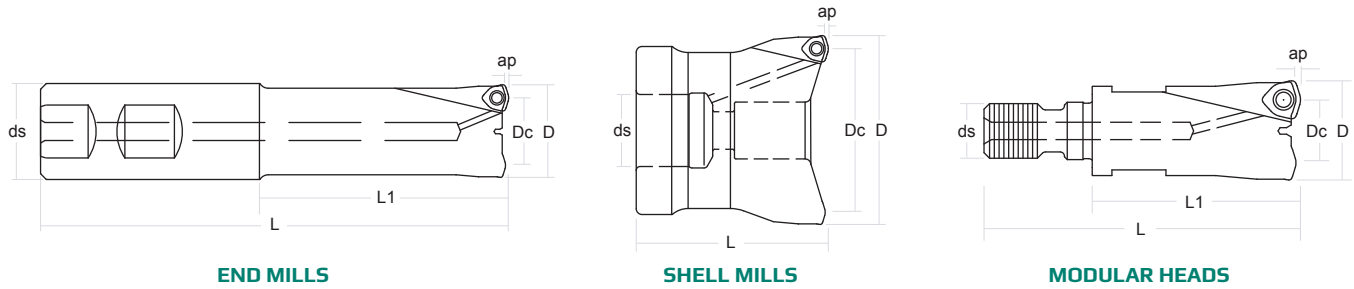
-  STOCK, STANDARD (PREFERRED)
-  STOCK, STANDARD (ALTERNATIVE)
-  NON-STOCK (ALTERNATIVE)

DTM-06 Inserts				Dimensions (Inch)			Application Details	Grade Selection			
EDP #	Catalog ID	Grade	# of Edges	I.C.	Re	S	Cutting Condition	P	M	K	S
110000210	DTM-06-T-DMP920	DMP920	6	0.244	0.031	0.160	Moderate				
110000211	DTM-06-T-DMP930	DMP930	6	0.244	0.031	0.160	Moderate				
110000212	DTM-06-D-DMP930	DMP930	6	0.244	0.031	0.160	Moderate				
110000213	DTM-06-D-DMH930	DMH930	6	0.244	0.031	0.160	Moderate				
110000214	DTM-06-D-DMF530	DMF530	6	0.244	0.031	0.160	Moderate/Severe				

6MM SERIES MACHINING PARAMETERS

Geometry	Grade	Speed / Feed	P (ISO 10-40)	M (ISO 20-40)	K (ISO 10-30)	S (ISO 20-35)
DTM-06-T	DMP920	SFM (feet/min.)	460-820		460-885	
		FPT (inch/tooth)	.020-.040		.020-.040	
		DOC (ap)	.010-.035		.010-.035	
	DMP930	SFM (feet/min.)	395-755			
		FPT (inch/tooth)	.020-.040			
		DOC (ap)	.010-.035			
DTM-06-D	DMP930	SFM (feet/min.)	395-755			
		FPT (inch/tooth)	.020-.040			
		DOC (ap)	.010-.035			
	DMH930	SFM (feet/min.)		330-690		100-360
		FPT (inch/tooth)		.015-.035		.007-.025
		DOC (ap)		.010-.035		.010-.025
	DMF530	SFM (feet/min.)		395-820		100-490
		FPT (inch/tooth)		.015-.035		.007-.025
		DOC (ap)		.010-.035		.010-.025





END MILLS (WELDON)

● STOCK, STANDARD // ● STOCK, LIMITED // ○ NON-STOCK

EDP #	Catalog ID	# of Inserts	Dimensions (Inch)					ap (max./in.)	Insert Type	Insert Screw (EDP #)	Stock
			D	Dc	ds	L	L1				
72000	DTMEM050-150-R2-1C	1	0.500	0.230	0.750	3.720	1.500	0.040	DTM-06	22600L	●
72005	DTMEM050-250-R2-1C	1	0.500	0.230	0.750	4.720	2.500	0.040	DTM-06	22600L	●
72010	DTMEM063-200-R2-2C	2	0.625	0.355	0.750	4.180	2.000	0.040	DTM-06	22600L	●
72015	DTMEM063-300-R2-2C	2	0.625	0.355	0.750	5.180	3.000	0.040	DTM-06	22600L	●
72020	DTMEM075-200-R2-3C	3	0.750	0.480	0.750	4.180	2.000	0.040	DTM-06	22600L	●
72025	DTMEM075-300-R2-3C	3	0.750	0.480	0.750	6.180	3.000	0.040	DTM-06	22600L	●
72030	DTMEM100-250-R2-4C	4	1.000	0.730	1.000	4.875	2.500	0.040	DTM-06	22600L	●
72040	DTMEM100-250-R2-5C	5	1.000	0.730	1.000	4.875	2.500	0.040	DTM-06	22600L	●
72045	DTMEM100-450-R2-5C	5	1.000	0.730	1.000	6.875	4.500	0.040	DTM-06	22600L	●
72050	DTMEM125-300-R2-5C	5	1.250	0.980	1.250	5.400	3.000	0.040	DTM-06	22600L	●
72060	DTMEM150-350-R2-6C	6	1.500	1.230	1.250	5.780	3.500	0.040	DTM-06	22600L	●
72065	DTMEM150-550-R2-6C	6	1.500	1.230	1.250	7.780	5.500	0.040	DTM-06	22600L	●

SHELL MILLS (ARBOR)

EDP #	Catalog ID	# of Inserts	Dimensions (Inch)				ap (max./in.)	Insert Type	Insert Screw (EDP #)	Stock
			D	Dc	ds	L				
72100	DTMSM150-050-R2-6C	6	1.500	1.230	0.500	2.000	0.040	DTM-06	22600L	●
72099	DTMSM150-075-R2-6C	6	1.500	1.230	0.750	2.000	0.040	DTM-06	22600L	●
72105	DTMSM200-075-R2-7C	7	2.000	1.730	0.750	2.000	0.040	DTM-06	22600L	●

MODULAR HEADS

EDP #	Catalog ID	# of Inserts	Dimensions (Inch)					ap (max./in.)	Insert Type	Insert Screw (EDP #)	Stock
			D	Dc	ds	L	L1				
72200	DTMEM075-MOD-R2-3C	3	0.750	0.480	0.413	2.275	1.500	0.040	DTM-06	22600L	●
72205	DTMEM100-MOD-R2-4C	4	1.000	0.730	0.492	2.375	1.500	0.040	DTM-06	22600L	●
72206	DTMEM100-MOD-R2-5C	5	1.000	0.730	0.490	2.375	1.500	0.040	DTM-06	22600L	●
72210	DTMEM125-MOD-R2-5C	5	1.250	0.980	0.669	2.750	1.750	0.040	DTM-06	22600L	●