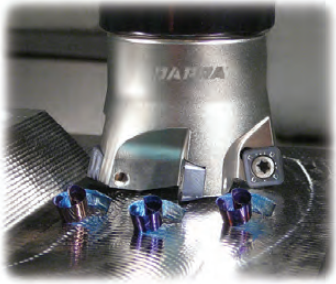




Dapra's **NEW**  
**RHINO-FEED**  
cutters and  
inserts allow  
for feed rates  
up to **5x** faster  
than normal!



See inside...

## NEW!! DAPRA **RHINO-FEED**

**Common Sense Feed Milling – Made in the USA**

**Purchase NEW RHINO-FEED inserts and get cutters for FREE!**



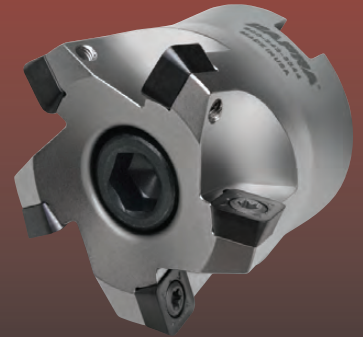
**FREE**

Buy 40 NEW  
inserts and get  
a RHINO-FEED  
End Mill

**OR**

**FREE**

Buy 60 NEW  
inserts and get  
a RHINO-FEED  
Shell Mill



This promotional offer good through 10/31/2011

## What is **RHINO-FEED**

The ultra-aggressive geometry of RHINO-FEED, DAPRA's High-Feed line, takes advantage of chip thinning to allow feed rates up to 5x faster than normal!



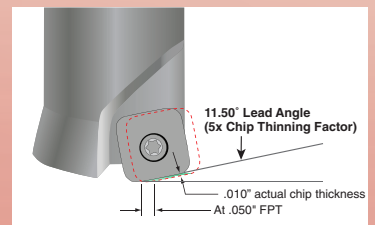
### Use RHINO-FEED high-feed inserts for:

- Mold cavity and core roughing
- Roughing of complex part contours
- Slotting
- 2D contouring
- Pocketing
- Helical interpolation
- Face milling
- Step milling

**NOTE:** High-feed milling does a tremendous amount of work in a short period of time. This line's high production rate can create more heat than typical milling tools. Strong air blast is recommended (multiple lines if possible).

## How Does it Work?

High-feed milling creates significant chip thinning due to an extreme lead angle. Feed rates must compensate for this to maximize productivity. The figure at right shows an example of this condition. Adjusting feed rates to account for chip thinning creates cutting conditions that provide very high feeds (IPM), but at lighter depths of cut (DOC).





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**High-Feed Cutter Bodies**

- Through-hardened, extra-tough tool steel for optimum strength
- Surface hardened for extra wear and chip-welding resistance
- Machined after hardening for excellent runout
- Standard and long-reach bodies available

**High-Feed Inserts**

- Strong design allows high feed rates in all materials
- Positive clearance provides excellent ramping and helixing capabilities
- Multiple geometries for either smooth cutting or strong edge conditions
- Simple but effective grade variety provides strong performance in all materials

**Mini-Feed Cutters**



- 0.500" - 1.000" OD
- 8mm IC
- 3 usable edges
- 1, 2 & 3 flutes



**Inserts**

Insert Part Number	IC	Thick-ness	# of Us-able Edges	Corner Radius (Actual)	Corner Radius (Program)	DOC (Max.)	DOC (Recommended)	FPT (Compensated)
RF08-D	8MM	.125"	3	.062	.088	.030	.010 - .025	.012 - .032

**Mid-Feed Cutters**



- 1.000" - 2.000" OD
- 10mm IC
- 4 usable edges
- 2, 3 & 5 flutes



**Inserts**

Insert Part Number	IC	Thick-ness	# of Us-able Edges	Corner Radius (Actual)	Corner Radius (Program)	DOC (Max.)	DOC (Recommended)	FPT (Compensated)
RF10-T	10MM	.190"	4	.075	.105	.045	.015 - .040	.020 - .060
RF10-D	10MM	.190"	4	.075	.105	.045	.015 - .040	.015 - .050

**Heavy-Feed Cutters**



- 1.25" - 4.00" OD
- 12mm IC
- 4 usable edges
- 2, 3, 4 & 5 flutes
- Extra-strong top clamping



**Inserts**

Insert Part Number	IC	Thick-ness	# of Us-able Edges	Corner Radius (Actual)	Corner Radius (Program)	DOC (Max.)	DOC (Recommended)	FPT (Compensated)
RF12-T	12MM	.220"	4	.094	.135	.060	.020 - .050	.025 - .070
RF12-D	12MM	.220"	4	.094	.135	.060	.020 - .050	.020 - .055

**Insert Edges**



"D" inserts have a positive cutting geometry, designed to reduce cutting forces and heat. This edge is suitable for all materials.



"T" inserts have a reinforced cutting edge for steels, irons and hard milling

**Uncoated**

DMK30 DMK25 DMP25

**With Coating**

DMK30-HP DMK25-HP DMP25-HP  
DMK30-GLH DMK25-GLH DMP25-GLH

	DMK30	DMK25	DMP25	DMK30-HP	DMK25-HP	DMP25-HP
Mini-Feed: RF08	D	D	D	D	D	D
Mid-Feed: RF10	T, D	D	T, D	T, D	D	T, D
Heavy-Feed: RF12	T, D	N/A	T, D	T, D	N/A	T, D

**Terms and Conditions:**

- Cutters must be for the inserts purchased.
- Cutter selection must be indicated at the time of the order.
- Insert styles can be mixed and matched to qualify for the discount, provided they are within the same product size range (mini, mid, heavy).
- Cutters and inserts purchased through this promotion are not eligible for return or exchange. Previous purchases are excluded.
- Product must be drop shipped to end user only.
- Promotional orders cannot be used as replacement orders.
- **Promotion ends October 31, 2011.**

Your Dapra distributor is:



Contact your local Dapra distributor, or call us directly:

**DAPRA**<sup>®</sup>  
**CORPORATION**  
**1-800-243-3344**  
**www.dapra.com**