



**If You Missed It
 The First Time...**

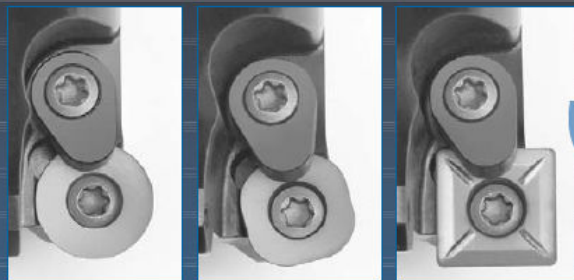


**You Can Still Mix & Match
 Toroid Inserts and Receive
 50% Off Toroid Cutters!**



3 Insert Options!

The Power of



3

Back By Popular Demand!!!!

**Buy 30 Toroid Inserts
 and receive 50% off of
 a cutter body.**

**For a Limited Time
 Only, So Stock Up Today!**



Mix & Match for Savings on Toroid Cutters and Inserts!

Special Offer Ends December 31, 2006 – See Inside for Details

Visit www.dapra.com for available sizes and grades.

1 Button Inserts

Precision-ground round inserts have a strong cutting edge, making them an excellent choice for many applications, including:

- Mold cavity and core roughing
- Roughing of complex part contours
- Helical interpolation (larger diameter hole making)
- Pocketing
- Semifinishing
- Face milling



2 High-Feed Inserts

Ultra-aggressive geometry takes advantage of chip thinning to allow feed rates up to 6x faster than normal! Use high-feed inserts for:

- Mold cavity and core roughing
- Roughing of complex part contours
- Pocketing
- Helical interpolation
- Face milling (roughing only)



3 Square Inserts

Your Toroid cutter can now be used for the most common applications involving 90° milling. Utilize the more economical 4-sided inserts for:

- Profiling
- Step milling
- Face milling
- Slotting
- Helical interpolation (cored holes only)
- Plunge milling

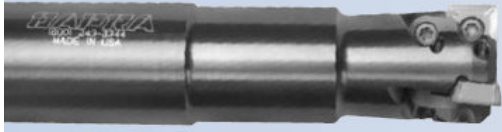


Buy 30 Inserts, Get a Toroid Cutter at 50% Off!

Button Inserts



High-Feed Inserts



Square Inserts



Mix and Match the 3 insert styles to qualify for this special offer!

Please see our Web site for features and dimensions of available Toroid Cutters and inserts

www.dapra.com

Speeds and Feeds for Dapra Toroid Cutters

			1018, 12L14, 1041, 1045	4140, 4150 4340, H13, P20, A2, D2	4140, 4150 4340, H13, P20, A2, D2	303, 304 LOW 400 SERIES	316, 347, PH STAINLESS	GRAY, MALLEABLE, DUCTILE	6061, 7075	AMPCO, WEARITE	INCONEL, WASPALOY, MONEL		
			LOW-TO-MEDIUM CARBON STEELS	TOOL STEELS, HIGH-ALLOY STEELS (SOFT)	TOOL STEELS, HIGH-ALLOY STEELS (HARDENED)	FREE MACHINING STAINLESS	TOUGHER STAINLESS	CAST IRONS	ALUMINUM ALLOYS	COPPER ALLOYS	HIGH-TEMP. ALLOYS/ TITANIUM	PLASTICS, NON-FERROUS	
TOUGHEST Shock Resistance	▲ LOWER TEMPS ▼ HIGHER TEMPS	DMK30	300-450	250-400		150-300	125-250	300-450	1000+	200-600	50-150 ROUGHING	1000+	
		DMK303	400-700	300-600		300-600	150-400					1000+	
		DMK30-HP	500-800	400-700		500-800	250-500	500-800			400-1200		1000+
		DMK307	600-900	500-800		600-900	300-600	600-900				75-300 ROUGHING	1000+
		DMK30-GLH	700-1000	500-900		600-1100	300-800	600-1200				75-450 ROUGHING	1000+
MEDIUM Shock & Wear	▲ LOWER TEMPS ▼ HIGHER TEMPS	DMP25	450-800	375-700		250-400		350-550 DUCTILE	1000+	200-600		1000+	
		DMP253	500-850	400-800		400-700				400-1200		1000+	
		DMP25-HP	600-1000	500-900		500-900		500-900	500-900 DUCTILE			50-150 FINISHING	1000+
		DMP257	700-1200	600-1000	250-500	600-1000		500-1100 DUCTILE				50-200 FINISHING	1000+
		DMP25-GLH	800-1600	600-1200	250-700	600-1200		500-1300 DUCTILE				50-250 FINISHING	1000+
HARDEST Wear Resistance	▲ LOWER TEMPS ▼ HIGHER TEMPS	DMK15				250-400	125-250 FINISHING	350-600 GRAY	1000+	200-600	50-150 FINISHING	1000+	
		DMK153				400-700	150-400 FINISHING		1000+	400-800	50-250 FINISHING	1000+	
		DMK15-HP	600-1000	500-900		500-900	250-500 FINISHING	600-900 GRAY			400-900	50-250 FINISHING	1000+
		DMK157	700-1200	600-1000	250-700	600-1000	300-600 FINISHING	700-1100 GRAY				75-250 FINISHING	1000+
		DMK15-GLH	800-1600	600-1200	300-800	600-1200	300-800 FINISHING	800-1300 GRAY			400-1200	75-350 FINISHING	1000+
1 st CHOICE GEOMETRY		T-Land	T-Land	T-Land	Dished	Dished	T-Land	Dished	Dished	Dished	Dished	Dished	
RECOMMENDED IPT		.006-.015	.006-.012	.003-.008	.004-.012	.003-.010	.006-.015	.005-.030	.005-.020	.003-.007	.005-.030		

The parameters provided are suggested operating parameters. Actual speeds and feeds will depend on many variables, such as rigidity, workpiece hardness, tool extension, machine accuracy, Depth of Cut, etc. Start at the middle of the SFM range and the low end of the FPT range. Next, increase FPT to optimize productivity and tool life. Higher SFM will provide higher output but may reduce tool life. Try different combinations to find the parameters that best suit your needs.

Terms and Conditions:

- Cutters must be for the inserts purchased.
- Offer only applies to Button, High-Feed, and Square Toroid inserts. Insert styles can be mixed and matched to qualify for the 30-piece discount.
- Cutters and inserts purchased through this promotion are not eligible for return.
- Offer is open to distributors.
- **Offer ends December 31, 2006!**

Your Dapra distributor is:

Fleetwood Industrial Supply Corp
 1410 W. Fullerton Ave.
 Addison, IL 60101
 (630) 543-0190 phone
 (630) 543-8488 fax

Contact your local Dapra distributor, or call us directly:

DAPRA[®]
CORPORATION
 1-800-243-3344
 www.dapra.com