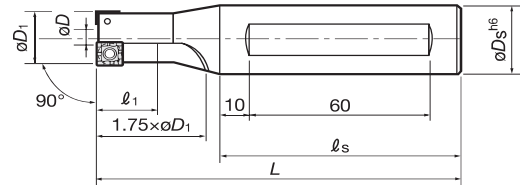




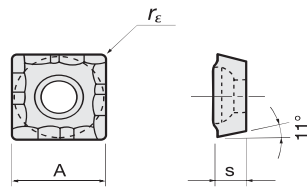
For counter milling of general steels, cast irons and stainless steels

Rake angle: A.R. Positive R.R. Negative



Cat. No.	Stock	No. of inserts	Dimensions (mm)					Applicable screw size	Applicable inserts	Clamping screw	Wrench	
			ϕD_1	ϕD_s	ϕD	l_1	l_s					L
TCB-140	○	1	14	25	4.0	18	80	117	M8	SPMP831DS	CSTB-2.2S CSTB-2.2	T-7D
TCB-175	○		17.5		7.1	22		115	M10			
TCB-200	○		20		8.2	25		120	M12			
TCB-230	○		23		11.0	29		126	M14			
TCB-260	○	2	32	32	14.0	33	85	132	M16	SPMP042ERD	CSTA-NO3	T-9D
TCB-290	○				29	30		138	M18			
TCB-320	○				32	—		144	M20			
TCB-350	○				35	—		150	M22			
TCB-390	○			14.0	—	158	M24	SPMM432ERD	CSTA-4	T-15D		
TCB-430	○	43	—	171	M27							
TCB-480	○	48	42	21.7	—	181	M30					

Inserts



Cat. No.	Accuracy	Coated	Dimensions (mm)			Application
		T313W	A	s	r_ϵ	
SPMP831DS	M	●	6.35	2.38	0.4	Steel · Cast irons
SPMP042ERD		●	7.938	3.18	0.8	
SPMM322ERD		●	9.525			
SPMM432ERD		●	12.7	4.76		

Note: No dimples on SPMP831DS.

Standard cutting conditions (for TCB-200)

Work materials	Grade	Cutting speed v_c (m/min)	Feed f (mm/rev)	Cutting fluid
Carbon steels	T313W	80 ~ 150	0.12 ~ 0.24	Water soluble type
Stainless steels, Mild steels	T313W	150 ~ 200	0.05 ~ 0.12	Water soluble type
Cast irons	T313W	70 ~ 130	0.20 ~ 0.40	Water soluble type or dry cutting

Notes : ● For cutters under 20 mm diameter, be sure to use a cutting fluid and select lower cutting speeds than shown above.
 ● For TCB-140 type, reduce the feeds to 1/2 of the values shown in the table.

● : Stocked items
 ○ : Stocked in Japan