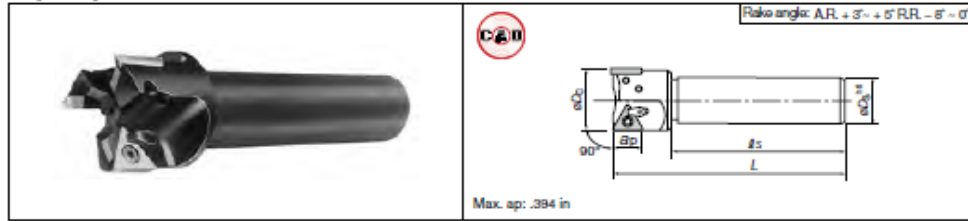


PES1500



For square shoulder milling of steels, cast irons and non-ferrous metals



Max. ap: .394 in

Cat. No.	Stock	No. of inserts	Dimensions (in)				
			ϕD_c	ϕD_s	A_p	f_s	L
PES1535R			1.38				
PES1540R		2	1.57	1.26	.748	4.72	160
PES1550R		3	1.97				

Inserts

Cat. No.	Accuracy	Honing	Grades			Application
			Cermet		Uncoated	
			NS740	TH10	UX30	
TPCA43ZTRW1	C	With				Steels, cast irons
TPCA43ZTRW2						
TPMA432TNW1	M					

Replacement parts

Clamp-set	Insert clamping screw	Wrench
CSG-5T	CSTA-4	T-15D

Standard cutting conditions

Work materials	Grades	Cutting speed vc (SFM)	Feed per tooth fz
Mild steels	UX30	330 ~ 500	.004 ~ .012
Carbon steels	UX30	330 ~ 400	.004 ~ .010
Alloy steels	UX30	260 ~ 330	.004 ~ .008
Die steels (20 ~ 30HRC)	UX30	160 ~ 230	.004 ~ .008
Cast irons	TH10	230 ~ 300	.004 ~ .012
Non-ferrous metals	TH10	650 ~ 1650	.002 ~ .008