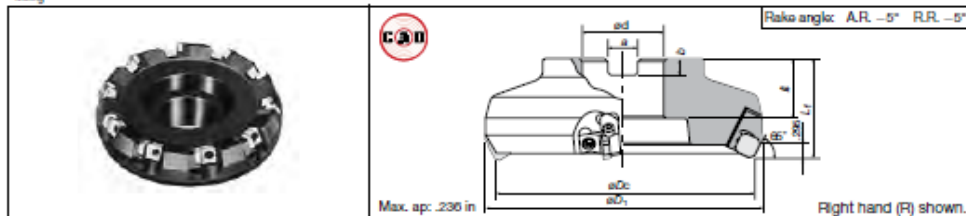


Economy type TAC Mills TGN4200-A



For general purpose milling of cast irons and steels



Cat. No.	Stock	No. of Inserts	Dimensions (in)							Weight (kg)	Mounting Details
			aDc	aD1	ed	l	Lf	b	a		
TGN4203R-A		5	3.15	3.62	1.00	1.02	1.97	.236	.375	1.5	9-162(A)
TGN4204R-A		6	3.94	4.41	1.25	1.25		.315	.500	2.4	
TGN4205R-A		8	4.92	5.35	1.50	1.50	2.48	.394	.625	3.9	9-162(B)
TGN4206R-A		10	6.30	6.73	2.00	2.00		.433	.750	6.1	

Inserts

Cat. No.	ISO Cat. No. (Metric)	Accuracy	Honing	Grades							Figure			
				Coated			Cermet		Uncoated			Ceramics		
				T3130	T1115	T1015	NS740	N308	X407	UX30		TH10	FX105	CX710
SNCN43ZTN	SNCN1204ZNTN	C	With										Fig. 1	
SNCN43ZFN	SNCN1204ZNFN		Without											
SNKN43ZTN	SNKN1204ZNTN		With	●	●		●					●		
SNKN43ZFN	SNKN1204ZNFN	K	Without										Fig. 3	
SNKF43ZTN	SNKF1204ZNTN	With		●										
SNKF43ZFN	SNKF1204ZNFN	Without												
SNMN 432 TN		M	With									●	Fig. 2	
SNMN 433 TN														●
SNMN 434 TN														●
SNMN 435 TN														●
SNMN 436 TN														●

Notes: Inserts can be used for former PS-series TAC mills.

Replacement parts

No.	Part	Part Cat. No.
①	Locator	LN423R/L
②	Locator fixing screw	CM4×0.7×14
③	Insert locking wedge	WP440R/L
④	Wedge fixing screw	FDS-8S
-	T-handle wrench	TP-4

Standard cutting conditions

Work materials	Grades	Roughing (Depth of cut: 1.5 - 4 in)			
		Cutting speed v _c (SFM)	Feed per tooth f _z (ipt)	Cutting speed v _c (SFM)	Feed per tooth f _z (ipt)
Cast irons	TH10*UX30	260 ~ 425	.004 ~ .010	260 ~ 425	.004 ~ .012
Ductile cast irons	T1115	325 ~ 660	.004 ~ .008	325 ~ 660	.004 ~ .010
	FX105	650 ~ 1640	.004 ~ .014	650 ~ 1968	.004 ~ .016
Mild steels	T3130	490 ~ 820	.004 ~ .012	490 ~ 820	.004 ~ .012
Unhardened steels (< 180 HB)	NS740	325 ~ 660	.004 ~ .008	490 ~ 820	.004 ~ .010
	UX30	325 ~ 590	.004 ~ .012	425 ~ 650	.004 ~ .012
Carbon steels	T3130	425 ~ 820	.004 ~ .012	490 ~ 820	.004 ~ .012
Alloy steels (< 300 HB)	NS740	325 ~ 590	.004 ~ .008	490 ~ 820	.004 ~ .010
	UX30	260 ~ 425	.004 ~ .012	325 ~ 490	.004 ~ .012

Notes: ● Dry cutting is recommended for above materials.
● When wet machining mild steels, carbon steels and alloy steels, use T3130 at lower cutting conditions.

● : Stocked items.

Most unmarked items are available on a RFQ basis, contact your sales rep for more information.