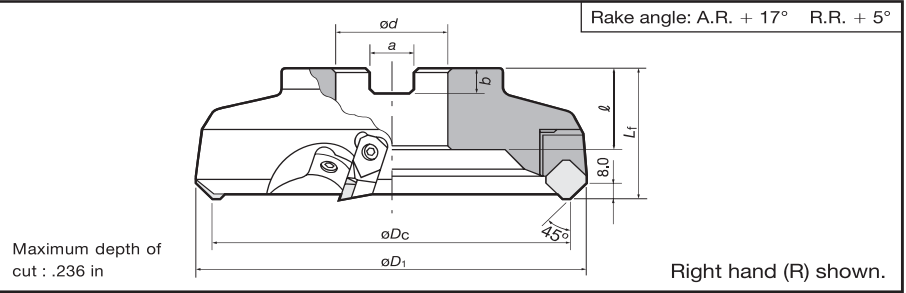


TAC Mills for large depth of cut

THF5400IA

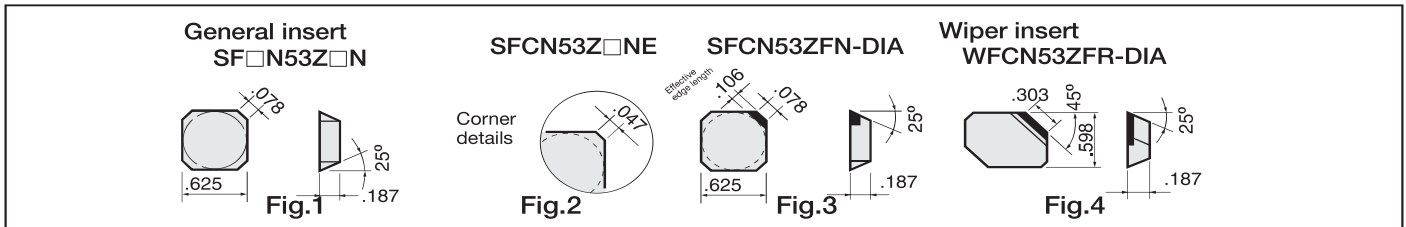


For large depth milling of aluminum alloys and non-ferrous metals



Cat. No.	Stock		No. of inserts	Dimensions (mm)							Weight (kg)	Mounting details	
	R	L		øD _c	øD ₁	od	l	L _f	b	a			
THF5403R/LIA	○		3	80	98	25.4	26	50	6	9.5	1.2	9-148B	
THF5404R/LIA	○		4	100	117	31.75	32	38	63	8	.500		.098
THF5405R/LIA	○		5	125	141	38.1	47.625			14	25.4		10
THF5406R/LIA	○		6	160	175	50.8		11	19				5.5
THF5408R/LIA			8	200	215	16.0		8.8					
THF5410R/LIA			10	250	264		16.0		8.8				
THF5412R/LIA			12	315	329	24.9	8.8						

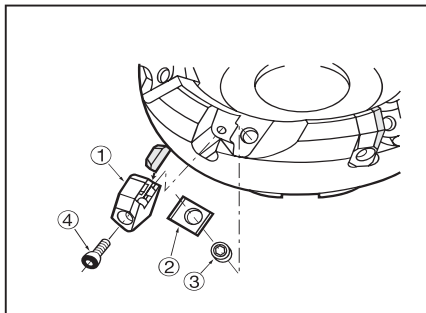
Inserts



Type	Cat. No. (Inch System)	ISO Cat. No. (Metric System)	Accuracy	Honing	Grades			Figure
					Uncoated	T-DIA	DX140	
General	SFCN53ZTNE	SFCN53ZTNE	C	With	TH10	TU40	DX140	Fig.2
	SFCN53ZFN	SFCN53ZFN		Without	○			Fig.1
	SFCN53ZFN-DIA	SFCN53ZFN-DIA					○	Fig.3
	SFCN53ZFN	SFCN53ZFN	E		○			Fig.1
Wiper	WFCN53ZFR-DIA	WFCN53ZFR-DIA	C				○	Fig.4

Notes: • T-DIA is Tungaloy's trade name for polycrystalline sintered diamond. The insert is one-corner type. "DX140": Packing Quantity = 1 pcs.
• Inserts can be used for former PS-series TAC mills.

Replacement parts



No.	Description	Cat. No.
①	Locator	LF540R/L
②	Insert locking wedge	WF500R/L
③	Wedge fixing screw	FDS-8S
④	Locator fixing screw	CM4×0.7×20
-	T-handle wrench	TP-4

• No. of revolutions n (min^{-1}) = SFM X 3.82 ÷ Cutter diameter ϕ
• Table feed F (in/min) = No. of revolutions n × Feed per tooth f_z × No. of inserts

Standard cutting conditions

Work materials	Insert grades	Depth of cut: .004 ~ .236 in	
		Cutting speed v_c (SFM)	Feed per tooth f_z (in/t)
Aluminum alloys (Si < 12%)	TH10	650 ~ 3300	.002 ~ .008
	DX140		
Aluminum alloys (Si > 13%)	TH10	650 ~ 1300	0.1 ~ .008
	DX140		
Duralumin	TH10	650 ~ 3300	.002 ~ .008
	DX140		
Copper alloys	TH10	650 ~ 1640	.002 ~ .008

Notes: • Use of water-soluble cutting fluid is recommended.
• Maximum depth of cut for SFCN53ZFN-DIA is .078 in.

● : Stocked items.
○ : Stocked in Japan

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