TAC Mills for large depth of cut

TMD5400IU

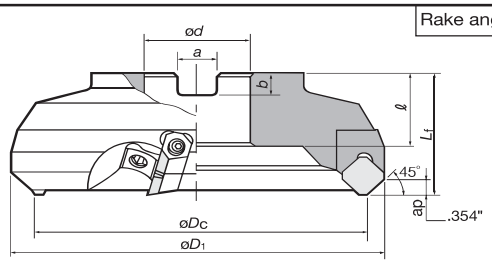
45° 6mm

P Steel M Stainless K Cast Iron N Non-ferrous

Face Milling Chamfering

For general purpose, large depth milling of general steels, stainless steels, cast irons, and non-ferrous metals

Rake angle: A.R. +15° R.R. −3°



Max. ap: .236 in

Right hand (R) shown.

Cat. No.	Stock	No. of inserts	Dimensions (in)							Weight (kg)	Mounting details
			øDc	øD1	ød	ℓ	Lf	b	a		
TMD5404RIU	●	4	3.94	4.65	1.50	1.26	2.48	.394	.625	2.5	9-148
TMD5405RIU	●	5	4.92	5.59	1.50	1.50		.394	.625	3.7	
TMD5406RIU	●		6.30	6.93	2.00			.433	.750	5.8	
TMD5408RIU	●	8	7.87	8.50	2.50			.551	1.00	9.0	
TMD5410RIU	●	10	9.84	10.43						16.3	
TMD5412RIU		12	12.40	12.99						25.2	

Inserts

SD□N53Z□N

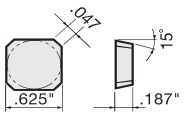


Fig. 1

SDEN53ZTN20 SDKN53ZTN16

Corner details

Fig. 2

Fig. 3

SDKR53ZSR-MJ

(With 3-dimensional chipbreaker)

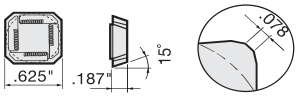


Fig. 4

SDEN53ZTNCR SDKN53ZTNCR

Corner details

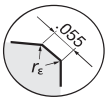


Fig. 5

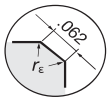


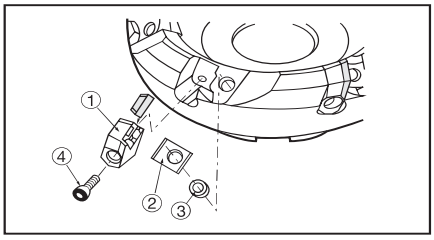
Fig. 6

Right hand (R) shown.

Cat. No. (Inch)	ISO Cat. No. (Metric)	Accuracy	Honing	Grades									Figure
				Coated						Cermet	Uncoated		
				T3130	AH330	AH120	AH130	AH140	GH330	NS740	UX30	TH10	
SDCN53ZTN	SDCN1504AETN	C	With										Fig. 1
SDEN53ZTN	SDEN1504AETN	E			●				●				
SDEN53ZTNCR	SDEN1504AETNCR												Fig. 5
SDEN53ZTN20	SDEN1504AETN-20			●									Fig. 2
SDEN53ZFN	SDEN1504AEFN		Without										Fig. 1
SDKN53ZTN	SDKN1504AETN	K	With			●	●	●	●	●	●		
SDKN53ZTNCR	SDKN1504AETNCR												Fig. 6
SDKN53ZTN16	SDKN1504AETN-16			●									Fig. 3
SDKN53ZFN	SDKN1504AEFN		Without									●	Fig. 1
SDKR53ZSR-MJ	SDKR1504AESR-MJ		With	●									Fig. 4

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

Replacement parts



No.	Part	Part Cat. No.
①	Locator	LD540R/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

Notes: • Dry cutting is recommended for all materials except for aluminum alloys.
• When wet machining mild steels, carbon steels and alloy steels, use T3130 at lower cutting conditions.

Standard cutting conditions

Work materials	Grades	Roughing (Depth of cut: ap .060 ~ .236 in)		Finishing (Depth of cut: ap .012 ~ .028 in)	
		Cutting speed v_c (SFM)	Feed per tooth f_z (ipt)	Cutting speed v_c (SFM)	Feed per tooth f_z (ipt)
Mild steels Unhardened steels (< 180 HB)	**NS740 • N308**	490 ~ 820	.004 ~ .010	490 ~ 820	.004 ~ .012
	AH120 • GH330		.004 ~ .014		.004 ~ .014
	T3130	490 ~ 990		590 ~ 980	
	UX30• AH130	325 ~ 590		425 ~ 650	
Carbon steels Alloy steels (< 300 HB)	**T3130**	490 ~ 920	.004 ~ .014	590 ~ 920	.004 ~ .014
	NS740 • N308	325 ~ 590	.004 ~ .010	490 ~ 820	.004 ~ .012
	AH120 • GH330	325 ~ 660	.004 ~ .012		.004 ~ .014
	UX30	260 ~ 425		325 ~ 490	
Die steels (< 30 HRC)	**T3130 • AH120**	325 ~ 490	.004 ~ .008	325 ~ 490	.004 ~ .008
	UX30	260 ~ 425		260 ~ 425	
Stainless steels (< 9.84 HB)	**AH130 • AH140**	260 ~ 590	.006 ~ .012	325 ~ 660	.006 ~ .013
	AH120 • GH330	490 ~ 760	.006 ~ .012	650 ~ 820	.006 ~ .012
	UX30	490 ~ 590		590 ~ 660	
Cast irons, Ductile cast irons	**TH10 • UX30**	260 ~ 425	.004 ~ .012	260 ~ 425	.004 ~ .012
Aluminum alloys (Si < 13%)	**TH10**	650 ~ 3280	.002 ~ .012	1148 ~ 3280	.004 ~ .012
Copper alloys	**TH10**	650 ~ 1650	.004 ~ .008	650 ~ 1650	.004 ~ .010

● : Stocked items.

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